SERVICE MANUAL



OV450 SERIES DECK OVENS INSTALLATION INSTRUCTIONS

OV450W
OV450N
OV452N

- NOTICE -

This Manual is prepared for the use of trained Baxter Service Technicians and should not be used by those not properly qualified.

This manual is not intended to be all encompassing. If you have not attended a Baxter Service School for this product, you should read, in its entirety, the repair procedure you wish to perform to determine if you have the necessary tools, instruments and skills required to perform the procedure. Procedures for which you do not have the necessary tools, instruments and skills should be performed by a trained Baxter Service Technician.

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SERVICE UPDATES

SERVICE UPDATES

March 2018

- Updated ELECTRICAL CONNECTIONS.
- Updated VENT HOOD.

February 2017

1. Incoming Power Connection
   A. POWER CONNECT
2. Baking Stone "Bake In"
   A. INITIAL START UP

GENERAL

INTRODUCTION

These instructions are for Baxter OV450 and OV452 Deck Ovens. When more than one OV450 and/or OV452 Deck Ovens are shipped partially assembled and require some field assembly. They will be in one or more crates, depending on configuration. Unstacking of the units will be required in order to fully assemble on an approved base.

All utility connections are the responsibility of the customer. All information, illustrations and specifications contained in this manual are based on the latest product information available at the date indicated on the cover of the manual. Retain these instructions for future reference.

INSTALLATION CODES AND STANDARDS

In the United States, the Deck Oven must be installed in accordance with:

1. State and local codes.
2. National Electrical Code (ANSI/NFPA No.70, latest edition) available from the:

   National Fire Protection Association

   Batterymarch Park

   Quincy, MA 02269.

In Canada, the Deck Oven must be installed in accordance with:

1. Local codes.
2. Canadian Electrical Code (CSA C22.2 No.3, latest edition) available from the:

   Canadian Standards Association

   5060 Spectrum Way

   Mississauga, Ontario

   Canada L4W 5N6.

WATER REQUIREMENTS

NOTICE

As with all steam related products, water filtration and regular filter replacements, coupled with routine deliming, are required. Your local Service office can recommend a water treatment system to meet the needs of your local water conditions. Contact your local Service representative for water treatment offerings.

Proper water quality can improve the taste of the food prepared in the deck oven, reduce liming and extend equipment life. Local water conditions vary from one location to another. The recommended proper water treatment for effective and efficient use of this equipment will also vary depending on the local water conditions. Ask your municipal water supplier for details about your local water supply prior to installation.

Dynamic Water Pressure	30-80 PIG
Hardness	2-4 grains
Silica	< 13ppm
Total Chloride	< 30 p.m.
pH Range	7-8
Chlorine & Chloramine	0 p.m.
Alkalinity	< 20 p.m.
TDS	< 60 p.m.
Undissolved Solids	< 5 microns

Water hardness above 4.0 grains per gallon should be treated by a water conditioner (water softener and/ or in-line water treatment). Water hardness below 2.0 grains per gallon may also require a water treatment system to reduce potential corrosion. Water treatment has been shown to reduce costs associated with machine cleaning, reduce deliming and reduce corrosion of metallic surfaces.

LOCATION

Allow space for operating deck oven. The deck oven requires approximately 3" from back of the deck oven for electrical and plumbing connections. Do not obstruct ventilation ports on the sides or back of deck oven. To prevent heat accumulation, 1" clearance is required from any wall. Deck ovens must be installed on an approved stand. Minimum clearance of 60"

must be provided in the front so deck oven can be pulled forward for servicing.

PLUMBING CONNECTIONS

Water and waste piping and connections shall comply with the International Plumbing Code 2003, International Code Council (ICC), or to the Uniform Plumbing Code 2003, International Association of Plumbing and Mechanical Officials (IAPMO).

⚠ WARNING

Plumbing connections must comply with applicable sanitary, safety and plumbing codes and provide adequate backflow protection to comply with applicable federal, state and local codes.

Connect cold water supply to 3/4" NPT connection located at the rear of deck oven. Water supply should have a pressure of 30 to 80 psi. Deck oven is supplied with a flow regulator which must be installed.

DRAIN CONNECTIONS

NOTICE

In order to avoid any back pressure in deck oven, do not connect solidly to any drain. Drain connections from each deck to the collector box must be high temperature hose.

Connect the ½" drain connection from each deck to the collector box on the deck oven stand. Route the drain line from the collector box to a floor drain. An air gap is provided by the collector box. No air gap required at floor drain.

ELECTRICAL CONNECTIONS



⚠ WARNING

Disconnect the electrical power to the machine and follow lockout / tagout procedures.

⚠ WARNING

Electrical and grounding connections must comply with the applicable portions of the National Electrical Code and/or other local electrical codes.

NOTE: Deck oven must be installed with the provided lanyard securely attached to one deck and to wall. Verify that all connections are long enough so that deck oven can be pulled forward to the extent of the lanyard without straining any connections.

NOTE: OV452N requires one electrical service for each deck, 208, 220, or 240VAC

Electrical Data (per deck)					
MODEL	**VOLTAGE**	**TOTAL KW**	**Maximum Operating kW**	**Amperage**	**Maximum Circuit Breaker**
OV452N	208	5.65	4.1	11.4	20
OV452N	220	6.3	4.6	12	20
OV452N	230	6.9	5	12.6	20
OV450N	208	5.75	4.2	11.6	20
OV450N	220	6.4	4.7	12.3	20
OV450N	230	7	5.1	12.8	20
OV450W	208	9.72	7.4	20.4	30
OV450W	220	10.9	8.2	21.6	30
OV450W	230	11.9	8.9	22.3	30

Electrical Data (per deck)					
MODEL	**VOLTAGE**	**TOTAL KW**	**Maximum Operating kW**	**Amperage**	**Maximum Circuit Breaker**
OV450W	480	9.72	7.4	9.4	20

VENT HOOD

Some local codes may require deck oven to be located under an exhaust hood. Information on construction and installation of ventilating hoods may be obtained from Vapor Removal from Cooking Equipment, NFPA Standard No. 96 (latest edition). Power is supplied through building.

Optional hood vent motor accessory to be powered by customer external power source, as there is no provision for power inside the oven for the hood vent fan motor.

UNPACKING

Use forklift only on side labeled (Fork this side) when moving crate. Remove crating from oven exterior, check for possible shipping damage. If deck oven is found to be damaged after unpacking, save packaging material and contact the carrier within 15 days of delivery.

Remove packaging from inside deck ovens & check baking stones for cracks. Cracked baking stones will need to be replaced before putting oven into operation.

Remove packaging from stand assembly & verify contents for stand installation. Check inside individual deck ovens for contents required for oven installation.

Leave as much protective plastic sheeting as possible on oven surfaces until installation is complete.

STAND PACKAGING CONTENTS

Stand to Bottom Deck Mounting Hardware

- Qty 2 M6 x 70 hex head bolts
- Qty 2 M6 x 16 hex head bolts
- Qty 4 M6 flat washers
- Qty 4 M6 hex nuts
- Restraining cable.
- 2 slide panel assemblies.
- Caster shim kit.
- Qty 2 #10-32 x ½" stainless thumb screws (for Drain Bottle)

Additional contents for adjustable height stands

- One shelf and 2 shelf supports. Wide adjustable stand only.
- Qty 6 1/4-20 x 3.5" hex head cap screws. Wide adjustable stand only.
- Qty (6) 1/4-20 lock nuts. Wide adjustable stand only.
- One peel support plate. Narrow adjustable stand only.

OVEN PACKAGING CONTENTS

NOTE: Each stack of deck ovens is supplied with a parts kit that contain parts packages which are required for each individual deck oven, and a parts packages required for the entire stack of decks no matter the quantity of deck ovens configured.

PARTS FOR ENTIRE STACK

- (1)Top Mounting Hardware Package 01-1M6878-00101
- (1)Top Assemble
- (1) Vent End Cap

Contents of Top Mounting Hardware Package 01-1M6878-00101

- (2) M6 hex nuts
- (2) M6 flat washers
- (4) M8 flat washers
- (4) M8 fender washers
- (2) M6 x 70 hex head bolts
- (2) M6 x 16 hex head bolts

Contents of Deck to Deck Mounting Hardware Package 01-1M6878-00102

- (2) M8 hex nuts
- (2) M6 hex nuts
- (4) M8 fender washers
- (6) M6 flat washers
- (2) M6 x 120 hex head bolts
- (4) M6 x 16 hex head bolts

OV450W per Deck Parts Package

- (1) Deck to Deck Mounting Hardware Package 01-1M6878-00102

- (1) Steam Duct Adaptor
- (1) Loading Door Glass
- (1) 6ft High Temp Drain Hose
- (1) Street Elbow, ½"
- (1) Adjustable Hose Clamp
- (1) Vent Tube, 250mm
- (1) Water Supply Assembly, 1.0GPM

OV450N per Deck Parts Package

- (1) Deck to Deck Mounting Hardware Package 01-1M6878-00102
- (1) Steam Duct Adaptor
- (1) Loading Door Glass
- (1) 6ft High Temp Drain Hose
- (1) Street Elbow, ½"
- (1) Adjustable Hose Clamp
- (1) Vent Tube, 250mm
- (1) Water Supply Assembly, .5GPM

OV452N per Deck Parts Package

- (1) Deck to Deck Mounting Hardware Package 01-1M6878-00102
- (2) Steam Duct Adaptor
- (1) Loading Door Glass
- (2) 6ft High Temp Drain Hose
- (2) Street Elbow, ½"
- (2) Adjustable Hose Clamps
- (1) Vent Tube, 189mm
- (2) Water Supply Assembly, .5GPM

POWER SUPPLY KIT

Secondary Power Supply Kit

- (1) Ground wire
- (2) Red wires
- (1) 9 pin serial cable, Reworked
- (1) AC-DC 12V power supply
- (2) Self adhesive pads
- (6) Wire ties

INSTALLING OVEN

NOTE: If the secondary power supply, used to power the control panels, is not installed, then follow the Control Panel Power Supply procedure per instructions.

STAND SETUP

NOTE: Prior to installing deck oven, check facilities floor for being level within a maximum of 1/8" per foot up to 3/4" in all directions. The laser level technique should be used as the preferred method to determine if stand will need to be leveled.

OV450N		
DECK CONFIGURATION	**STAND**	**HEIGHT SETTING**
SINGLE DECK OVEN	STAND-450NADJ	40"
TWO DECK OVENS	STAND-450NADJ	40"
THREE DECK OVENS	STAND-450NADJ	31"
FOUR DECK OVENS	STAND-450N18	18"

OV452N		
DECK CONFIGURATION	**STAND**	**HEIGHT SETTING**
SINGLE OVEN	STAND-450NADJ	40"
TWO OVENS	STAND-450NADJ	31"
THREE OVENS	STAND-450N18	18"

OV450N/OV452N COMBINATIONS		
DECK CONFIGURATION	**STAND**	**HEIGHT SETTING**
ONE OV450N on ONE OV452N	STAND-450NADJ	31"
TWO OV450N on ONE OV452N	STAND-450N18	18"

OV450W		
DECK CONFIGURATION	**STAND**	**HEIGHT SETTING**
SINGLE DECK OVEN	STAND-450WADJ	40"
TWO DECK OVENS	STAND-450WADJ	40"
THREE DECK OVENS	STAND-450WADJ	31"
FOUR DECK OVENS	STAND-450W18	18"

1. Refer to stand height tables to obtain the suggested height the stand should be set to for the number and type of decks supplied.
   - OV450N
   - OV452N
   - OV450N/OV452N COMBINATIONS
   - OV450W

NOTE: All mounting hardware should be installed such that the retaining nuts are to the inside of each leg or behind the slide panel assemblies.

2. Remove all the ¼-20 x 3.50” bolts and nuts from each leg of the stand (12 places on narrow stand, 18 places on wide stand), and slide the upper and lower sections of the stand apart until the suggested height is reached.

3. Place one bolt through each leg using the lowest mounting hole which allows access through both the inner and outer legs. Loosely secure bolt with ¼-20 nuts provided.

NOTE: Do not fully tighten hardware at this time.

4. Position the left hand slide panel assembly into rectangular notches in the base channels, and press mounting arm against inner side of stand legs.

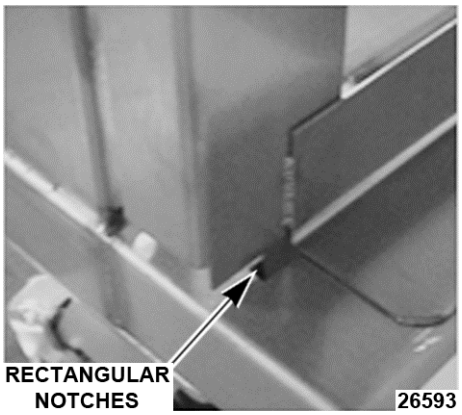

Fig. 1

5. Insert ¼-20 bolts through the holes in both the front and center legs that align with the holes in the slide panel mounting arms and loosely secure with nuts provided.

6. Position right hand slide panel assembly into rectangular notches in base channels next to the right front leg on narrow stands, and the center leg on wide stands. Press slide panel mounting arm against inner side of stand legs.

7. Insert ¼-20 bolt through the hole in both the front and center legs that aligns with the holes in the slide panel mounting arms and loosely secure with a nuts provided.



Fig. 2

NOTE: Do not fully tighten hardware at this time.

8. Place ¼-20 bolts through all other legs at a matching height to that of the bolts retaining the slide panel assemblies, and loosely secure with nuts.

9. **WIDE STANDS ONLY:**

   A. Using the key ways in the shelf support, position one shelf support over the heads of the two slide assembly retaining bolts as well as the third bolt head in the rear center leg. Mount the second shelf support over the three hex nuts on the right legs of the stand. If this shelf location is not optimal 6 additional leg bolts and nut have been supplied for mounting the shelf supports at any other available height. Visually confirm that both shelf slides are equally spaced from the bottom of the stand.

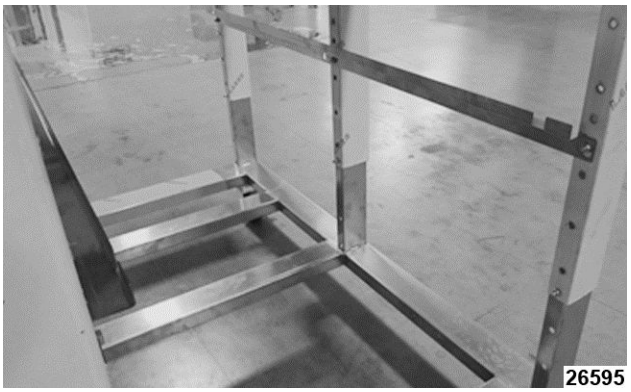

Fig. 3

   B. Tighten all leg mounting bolts.

C. Place shelf over shelf slides and slide to the rear until rear edge of shelf drops into the notches in the supports. Pull shelf forward until shelf is positioned against rear notch.

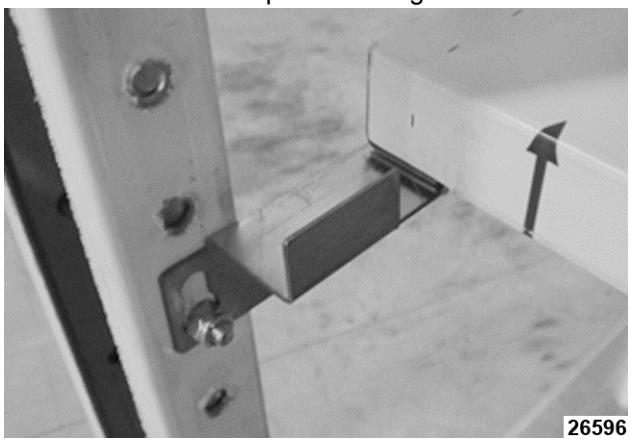

Fig. 4

10. **NARROW STAND ONLY:** Place peel support plate between right hand slide panel and front and middle right hand legs. When positioning, all bends in part should be up with square notch positioned at the center of the stand.
11. Verify stand is level from front to back and side to side. Shim the casters as required to level stand.

DRAIN BOTTLE

- Cut the protruding section off so that it is flush with top of drain bottle

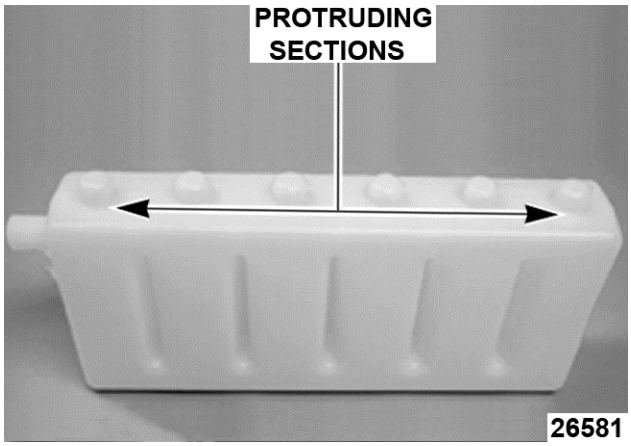

Fig. 5

- Verify that new hole is 1-1/8" diameter so that drain line fits into drain bottle.

NOTE: Repeat process for each drain line required.

12. Secure drain bottle to the two drain bottle mounting arms at the back of stand using two stainless thumb screws.
13. Install supplied lanyard eye hook with washers and nut to top right rear of stand.

UNSTACKING OVEN SECTIONS

1. Remove left, right, and rear covers from all deck ovens.
2. Carefully remove two layers of insulation from the right hand side and rear of each deck, to gain access to interdeck and top mounting screw locations as well as venting locations.

NOTE: Insulation will be reinstalled and needs to kept in good shape.

3. Open oven doors and slide glass panels out of door.



Fig. 6

4. Remove mounting hardware from baking stone retainer.
5. Remove baking stone retainer.

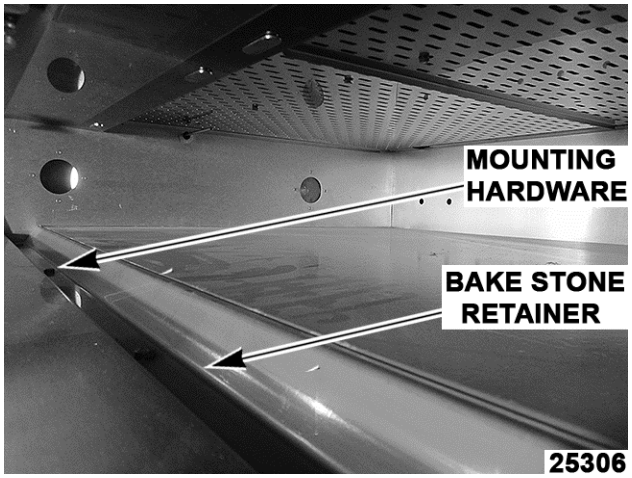

Fig. 7

6. Carefully remove baking stone from deck oven.

NOTICE

The baking stone material is a **VERY** fragile material. Handle Carefully. **DO NOT** hit the stone on any of its edges or it may crack.

7. Remove thumb screws which secure each control panel cover.

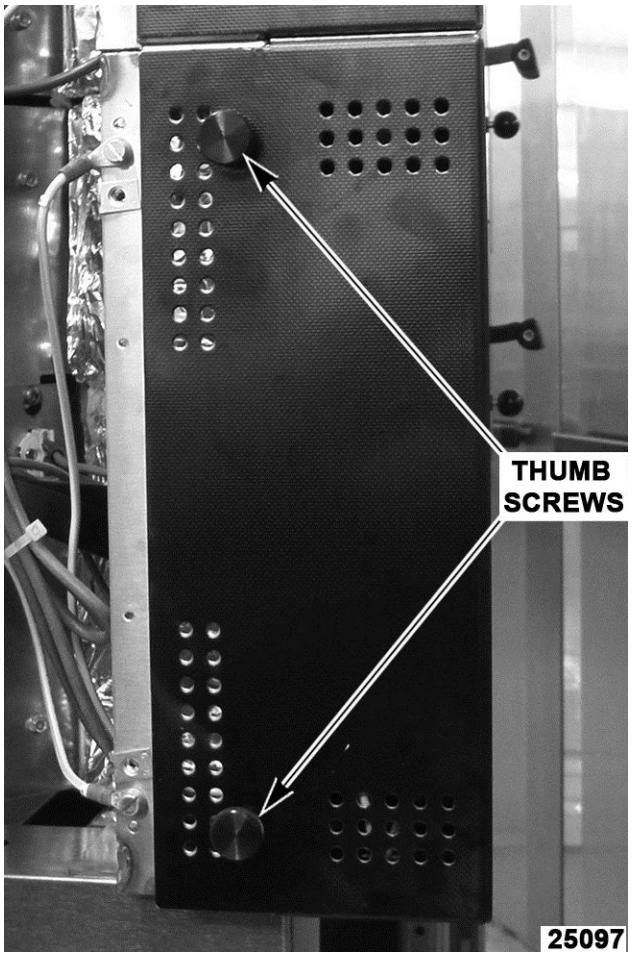

Fig. 8

8. Open control panel cover(s) and disconnect lower grey 9 pin serial cable that connects this oven controller with the one below it.

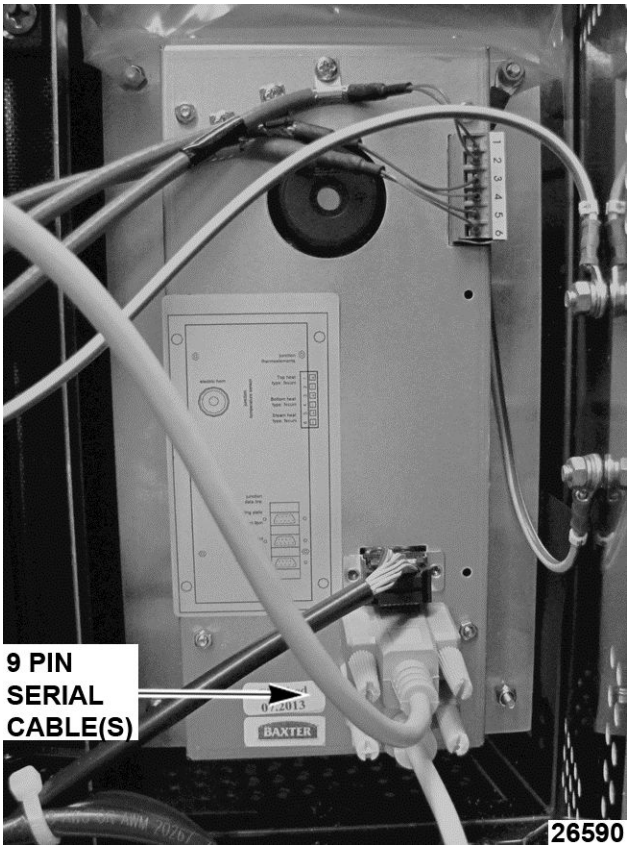

Fig. 9

9. Remove two bolts and washers in bottom of the control compartment connecting this oven to the one below it.

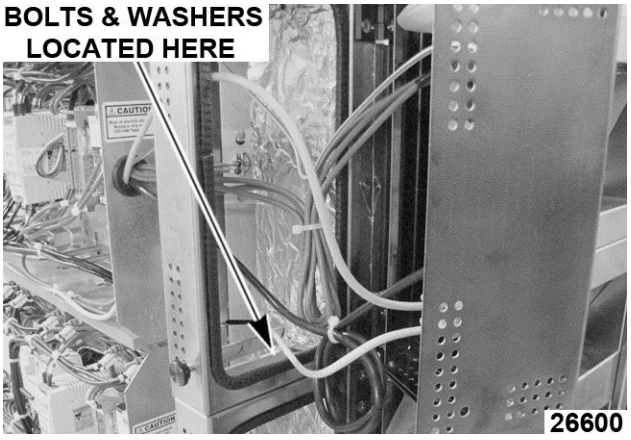

Fig. 10

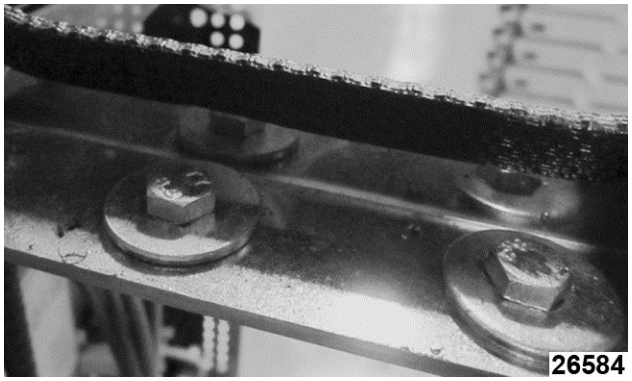

Fig. 11

10. Remove two bolts and washers located on right side of oven behind loading door handle and spring mechanism.

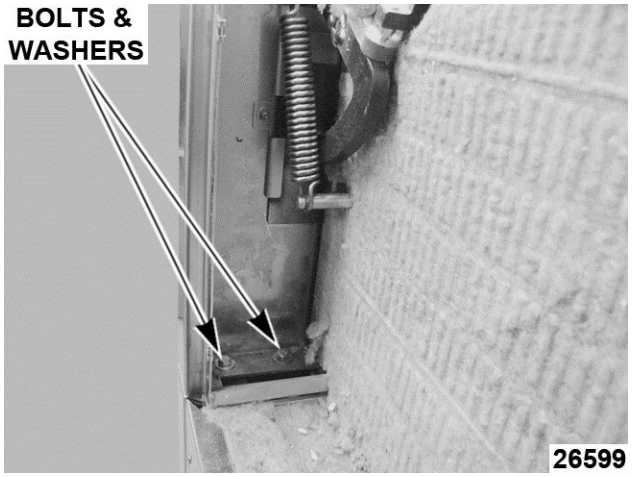

Fig. 12

11. Remove hardware holding decks together in the rear of the oven.

NOTE: When removing hardware, there will be two M8 hex nuts and M8 washers between deck ovens acting as spacers. These parts must be installed when stacking deck ovens.

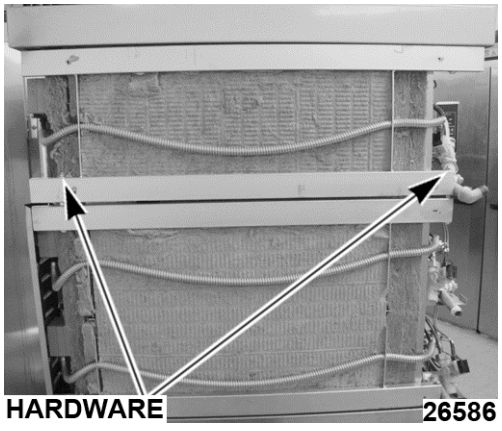

Fig. 13

12. Using an appropriate lifting device, chains, and spreader bar secure one end of each chain to each of the four welded lifting points in each corner on top of oven deck.

NOTE: Only lift one deck oven at a time.

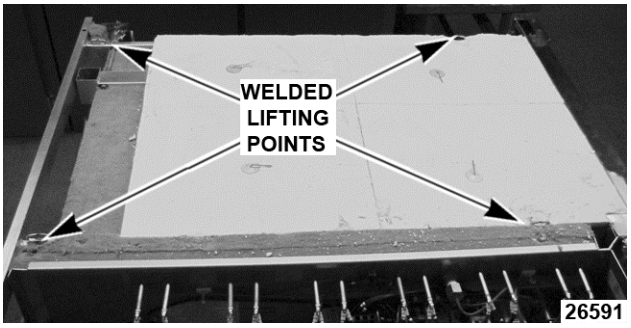

Fig. 14

13. Lift oven deck off of other oven decks.
14. After lifting oven deck, place deck on its back and move it to install location.

NOTICE

Support rear of each deck oven with blocks of wood to protect drain line and solenoid valve where they extend out from the rear of unit.

15. Repeat previous steps for each oven deck.

STACKING OVEN SECTIONS

NOTE: The deck with two 12V power supply modules must be the top deck in the stack. If not, refer to CONTROL PANEL POWER SUPPLY for repositioning secondary 12V power supply.

NOTE: The OV452N should always be placed as the lowest unit in a configuration.

1. Using an appropriate lifting device, chains, and spreader bar secure one end of each chain to each of the four welded lifting points in each corner on top of oven deck.

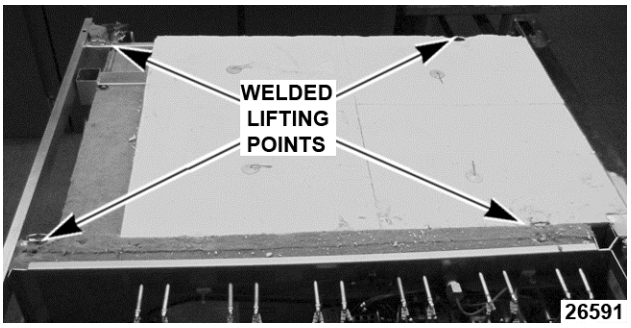

Fig. 15

NOTICE

Do not lift more than deck oven at one time.

2. Lift first oven deck and set on top of stand.
3. Align holes in bottom of oven deck to match up with holes in the stand.

NOTE: If all 4 holes do not align, then verify front of deck oven is flush with front of stand and drill new holes in stand.

NOTE: Washers are to be installed between oven deck and stand to act as a spacer so side and rear panels can be installed later.

4. Secure front of deck oven to stand using M6X16 hex head bolts, nuts, and washers. Secure rear of deck oven to stand using M6X70 hex head bolts, nuts, and washers.
5. Before additional deck ovens are stacked on top of this deck oven install steam vent interconnecting duct. Steam vent interconnecting duct must be installed from the vent collar to the deck oven above it on all deck ovens.

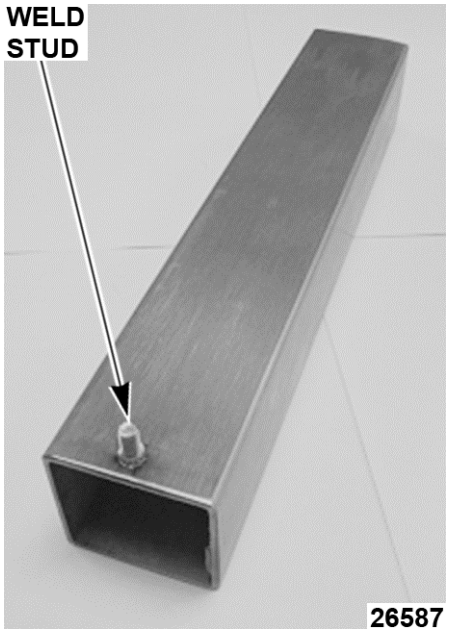

Fig. 16

NOTE: There are two steam duct interconnect tubes used in each OV452N deck. The upper most tube is pre installed and does not need to be removed or modified in any way. The lower tube will need to be installed as the decks are stacked. For all deck ovens the end of the interconnect tube with the welded stud is the end to be inserted through the insulation and into the lower deck until the weld stud makes contact with the coupler tube.

6. Apply hi-temp silicone caulking (included with oven) to seal both upper and lower connections between all interconnect ducts.

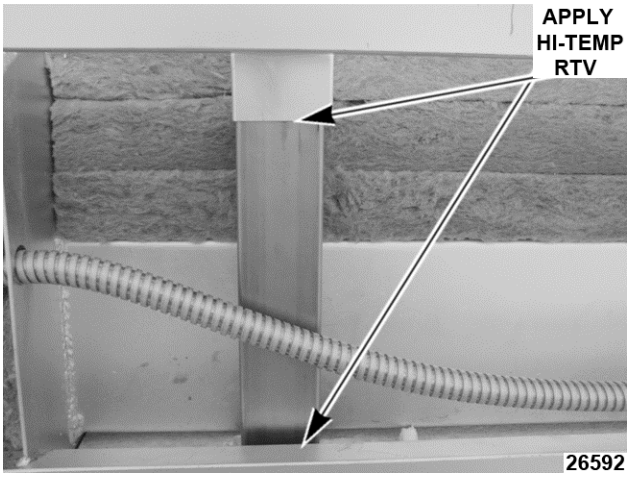

Fig. 17

7. Continue stacking deck ovens on top of one another.

NOTE: Be sure to place M8 hex nuts and washers in the rear between each deck oven.

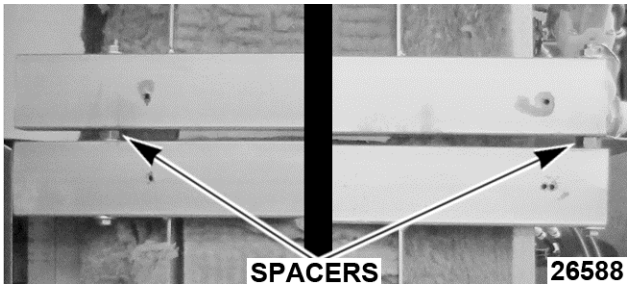

Fig. 18

8. Secure top deck oven to lower deck oven by inserting hardware shown in picture below.

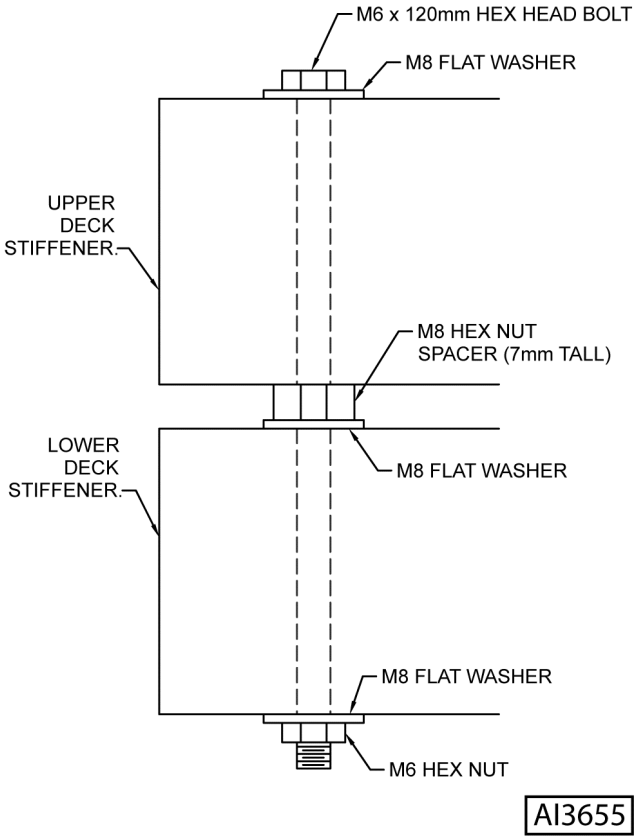

Fig. 19

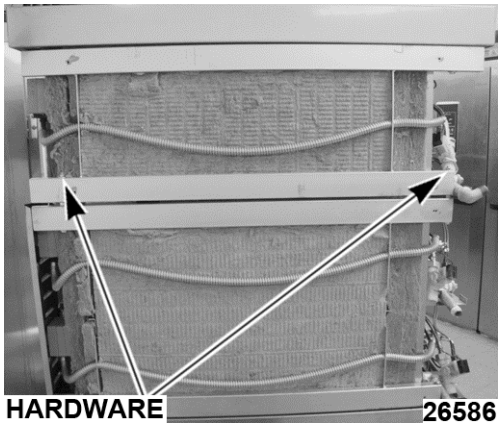

Fig. 20

9. Install bolts and washers in bottom of control compartment.

NOTE: Verify that sides and corners are flush before tightening hardware.

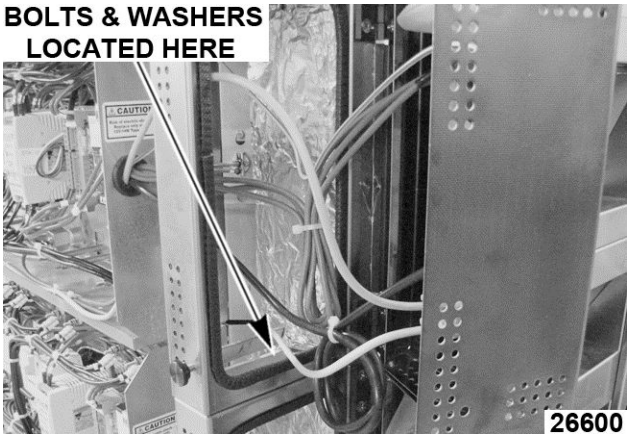

Fig. 21

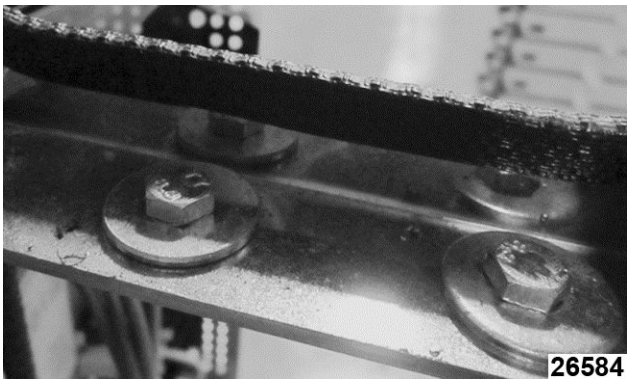

Fig. 22

10. Install bolts and washers located on right side of deck oven.

NOTE: Verify that sides and corners are flush before tightening hardware.

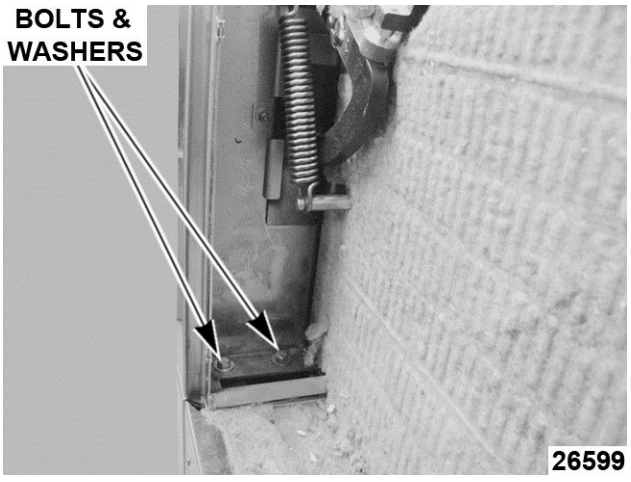

Fig. 23

11. After all units are stacked and secured to one another. Install and seal steam duct end cap with hi-temp RTV, onto the bottom opening of the vent collar on the bottom most deck oven.

12. Insulation previously removed from the rear and right hand side of the deck oven can now be replaced. It will be necessary to cut and modify the rear insulation pieces where the steam ducts were installed.

13. Position deck oven top on deck oven taking note to align steam duct with cut out in ceiling.

NOTE: M8 flat washer spacers placed between deck and top are there to allow outer panels to be installed. These must all be installed.

14. Place M8 washers above two outer most threaded inserts at each front corner as spacers. Loosely secure top to front of oven using 2 M6X16 hex head bolts and M6 washers, one at each front corner.

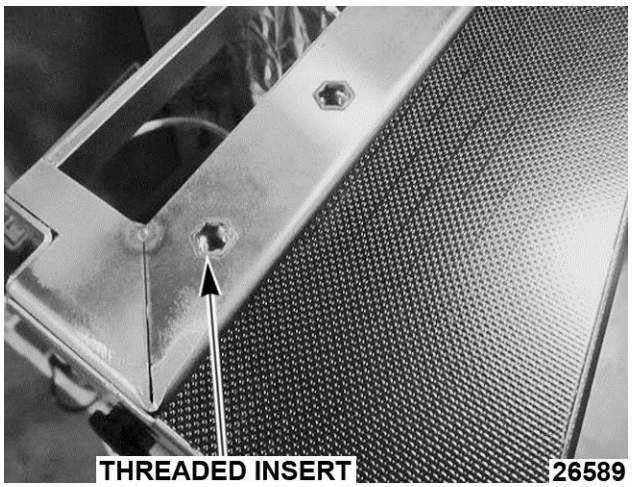

Fig. 24

15. Place M8 washers above each of the two rear mounting points in the rear support beam.

16. Insert M6X70 hex head bolts and M6 flat washer through bottom of support beam and into top cover, loosely securing with a M6 hex nut and M6 washer.

NOTE: It may be necessary to disconnect power vent motor to install the top right rear corner mounting bolt. If removal of power vent motor is required, take special note of vent shaft orientation.



Fig. 25

17. Secure top to deck oven by tightening all mounting bolts.

NOTE: Verify that all sides and corners are flush before tightening mounting bolts.

18. Install power vent motor if previously removed.

NOTE: Make sure that vent shaft position is identical to when the motor was removed. Incorrect vent positioning can affect steam venting from the deck.

19. Carefully install baking stones inside deck ovens.

NOTICE

The baking stone material is a **VERY** fragile material. Handle Carefully. **DO NOT** hit the stone on any of its edges or it may crack.

20. Secure baking stone retainers using retaining bolts.

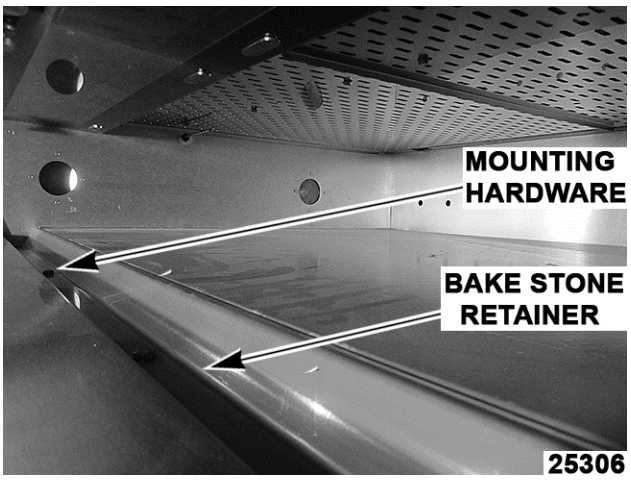

Fig. 26

21. Open deck oven door(s) and carefully slide glass panels into door(s).



Fig. 27

22. Install right, and rear panels.

CONTROL PANEL POWER SUPPLY

A secondary 12 volt power supply is used in all configurations of decks. For multiple deck configurations, it must be installed in the top deck.



⚠ WARNING

Disconnect the electrical power to the machine and follow lockout / tagout procedures.

1. Remove outer most green and yellow grounding terminal block with green and yellow ground wire attached to it from the din rail it is mounted to. It is not necessary to remove the ground wire from the terminal block.

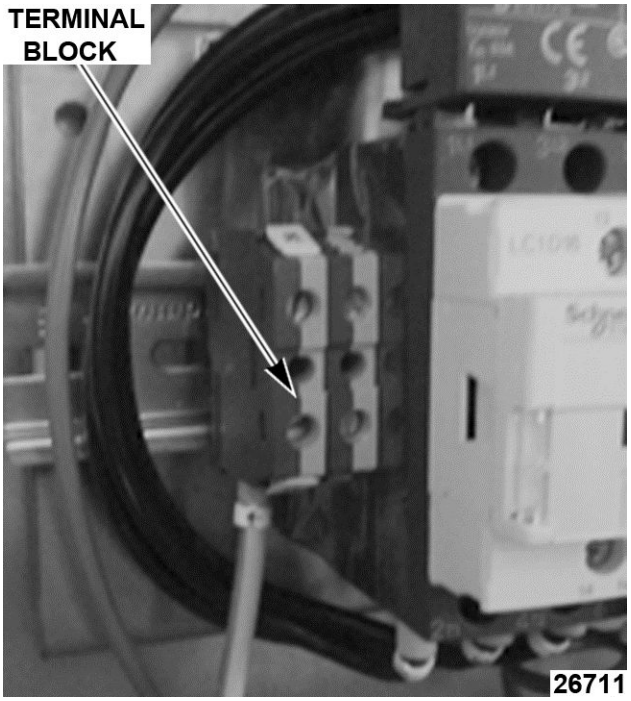

Fig. 28

2. Gently pull the red and black wires which looped around the grounding blocks, forward until they are positioned in front of the remaining grounding terminal and against the side of the contactor.

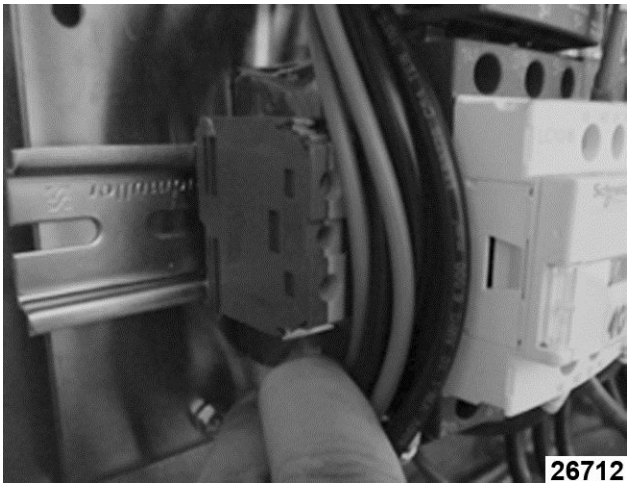

Fig. 29

3. Slide new 12V power supply over din rail and position flush up against the remaining ground terminal.

NOTE: No wires should be between the grounding terminal and the power supply.



Fig. 30

4. Holding 12V power supply tight against grounding terminal, reattach previously removed ground terminal and ground wire to din rail. Position ground terminal flush against side of power supply.



Fig. 31

5. Remove the two thumb screws in each of the deck control panels.
6. Route the end of the 6 foot 9 pin serial cable with the two mounting pins through the grommet at the rear of the control compartment. Route wire below lower elements along the blue thermocouple wires to the left side of the previously installed power supply.

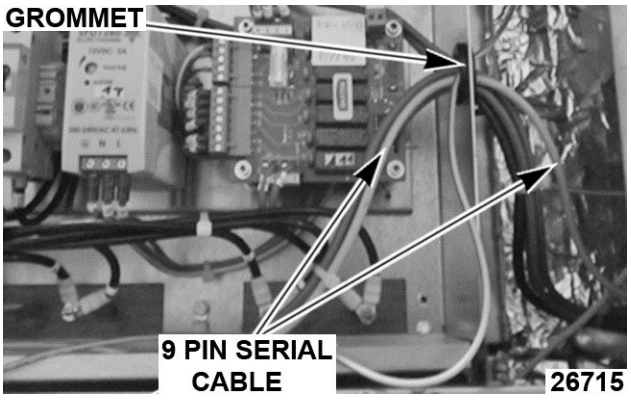

Fig. 32

7. Connect positive and negatively marked pins on 9 pin cable to the top of the power supply.



Fig. 33

8. Attach self adhesive mounting pad to the wiring tray, below and to the left of the previously installed power supply. Secure new 9 pin cable and existing blue thermocouple wire from steamer elements to mounting pad with plastic tie provided.

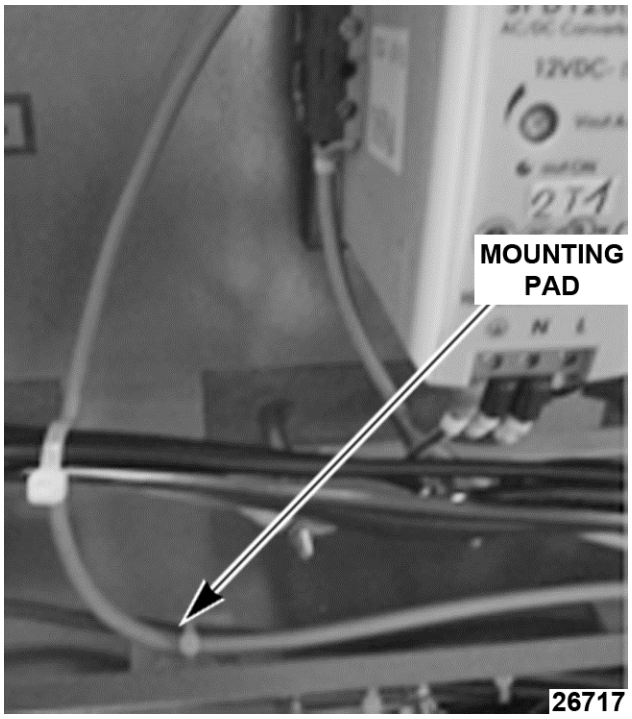

Fig. 34

9. Cut and remove wire tie securing the two blue thermocouple wires to the mounting pad at the middle of the deck base. Re secure the two blue cables as well as the new 9 pin cable to the mounting pad with wire tie.

10. Attach new mounting pad to rear side of control compartment rear wall. Secure the two blue wires, the green and yellow ground wire and the 9 pin cable to the new pad using a wire tie.

NOTICE

Make sure control wires do not contact high voltage components.

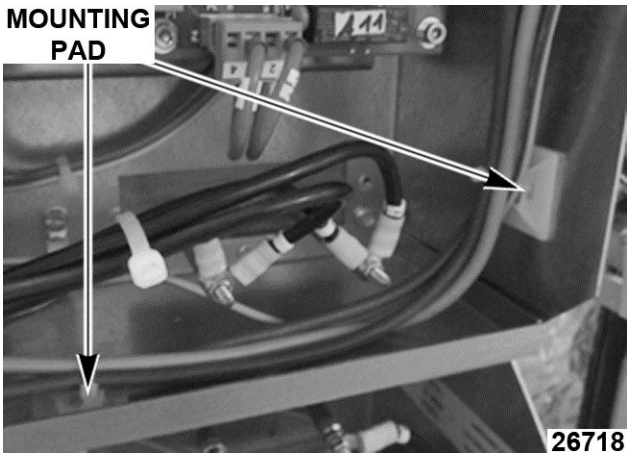

Fig. 35

11. Secure the 9 pin end of serial cable to the socket immediately below the black cable in the rear of the control panel. With the control panel fully open, bundle any excess wire and secure with a wire tie.

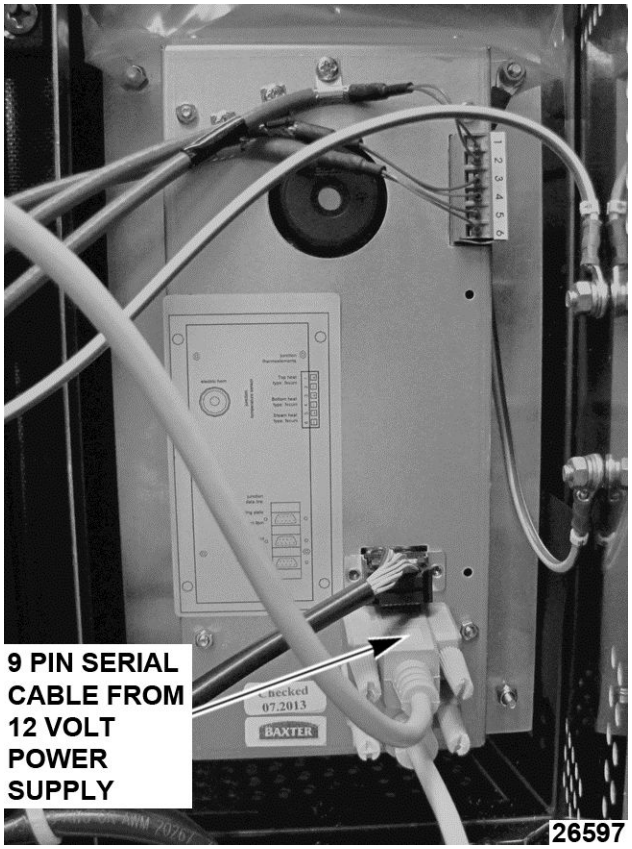

Fig. 36

12. Connect one end of a 3 foot 9 pin serial cable provided to the lowest mounting position on the rear of the control panel.

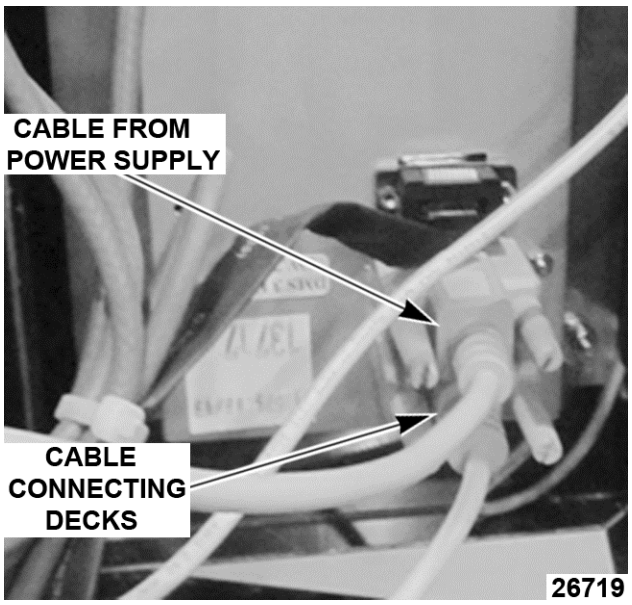

Fig. 37

13. Route remaining end of 3 foot cable out through the rear of the control compartment and either up or down one deck, depending on where the 12V power supply was mounted at the top or bottom of the stack of decks, and into the control compartment of the next deck.

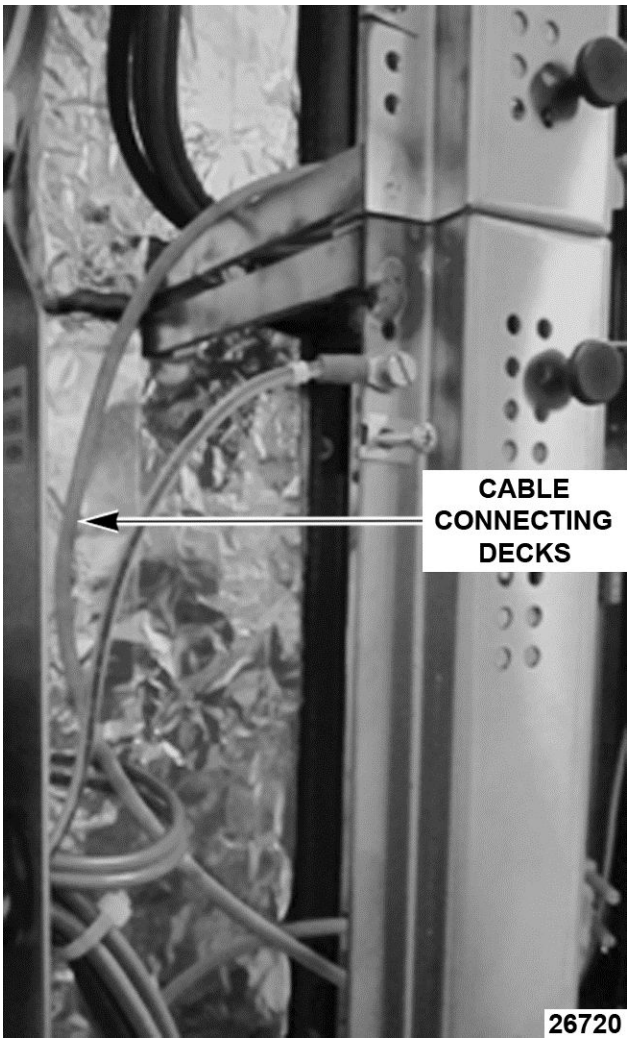

Fig. 38

14. The remaining end of the 9 pin cable connects to the next deck in the mounting position immediately below the black cable, just as the power supply cable previously did.
15. Continue using 3 foot cables, as required, to interconnect all decks.
16. Tighten thumb screws to secure each control panel cover.

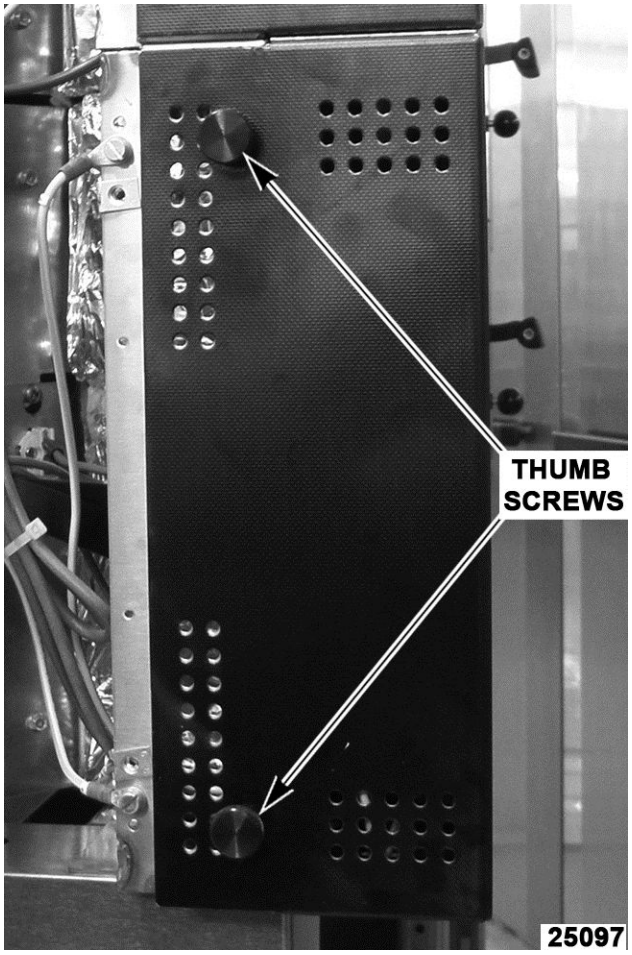

Fig. 39

17. Secure green and yellow ground wire, wire #47 and wire #48 to bottom of 12V power supply.

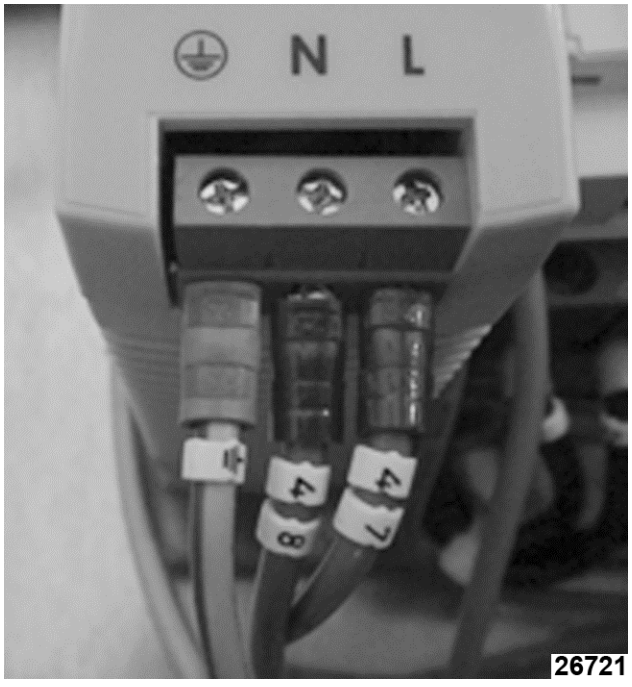

Fig. 40

18. Route green and yellow ground wire, wire #47 and wire #48 behind the hi-limit wires (numbered 21 and 22) and along the red wires beneath all the contactors.

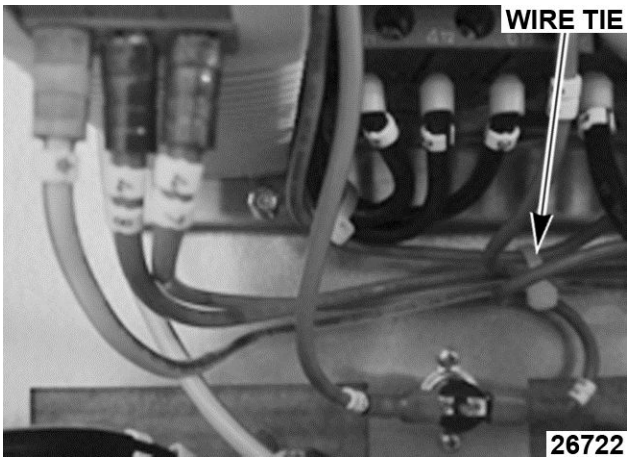

Fig. 41

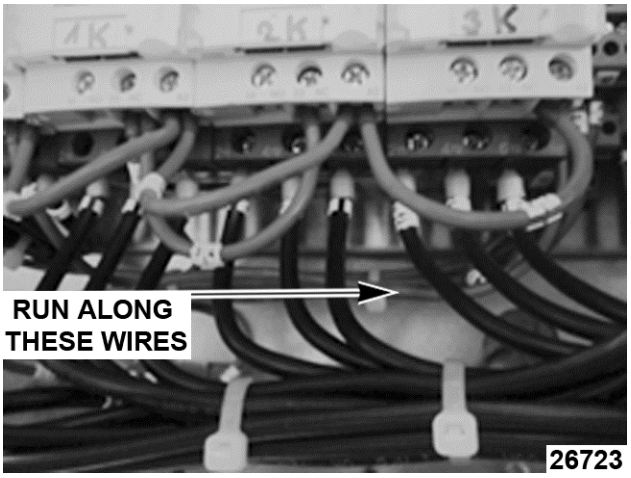

Fig. 42

19. Connect ground wire to middle position of green and yellow grounding terminal block.
20. Connect wire #47 into middle position of the terminal block immediately to the right of wire #18.
21. Connect wire #48 into middle position of the terminal block immediately to the right of wire #24.

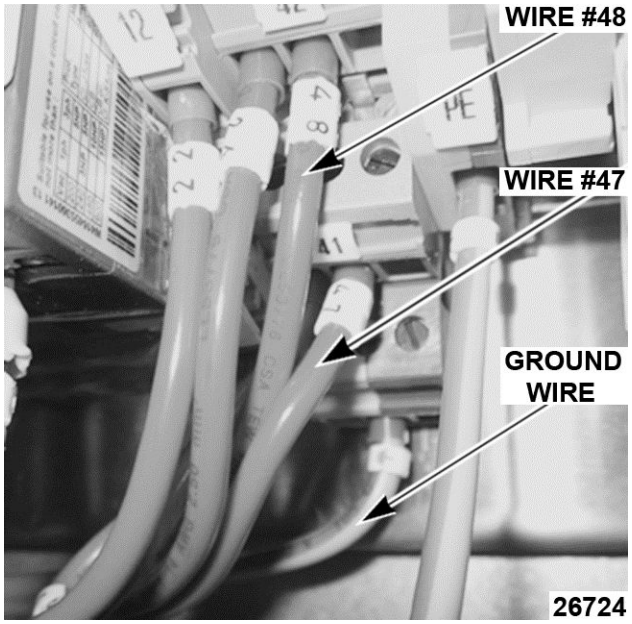

Fig. 43

22. Cut and remove wire ties and replace with ties provided securing new wires to existing wires in the same locations as previously secured.

POWER CONNECT



⚠ WARNING

Disconnect the electrical power to the machine and follow lockout / tagout procedures. There may be multiple circuits. Be sure all circuits are disconnected.

A design change was instituted in January 2015 for the incoming power connection method. This change affects all OV450N, OV450W and OV452N Baxter deck ovens.

Prior to Jan 1 2015

- Original deck oven design included a manual starter terminal block (01-1000V6-00357) preinstalled on the first contactor on each deck supplied.

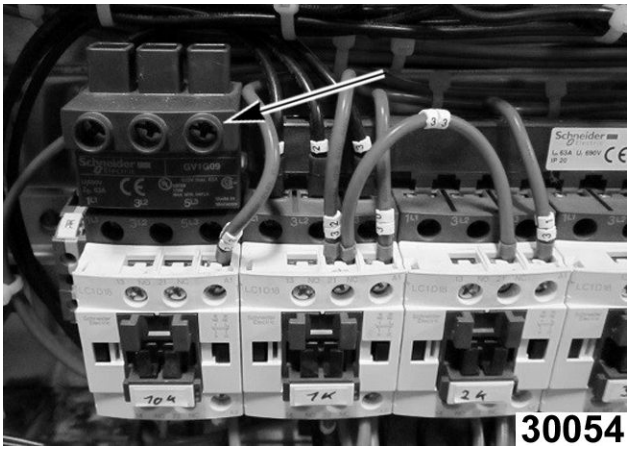

Fig. 44

- Power connections with the manual starter terminal block are done by stripping the ends of the incoming power lines and securing through the access ports on the top of the terminal block.

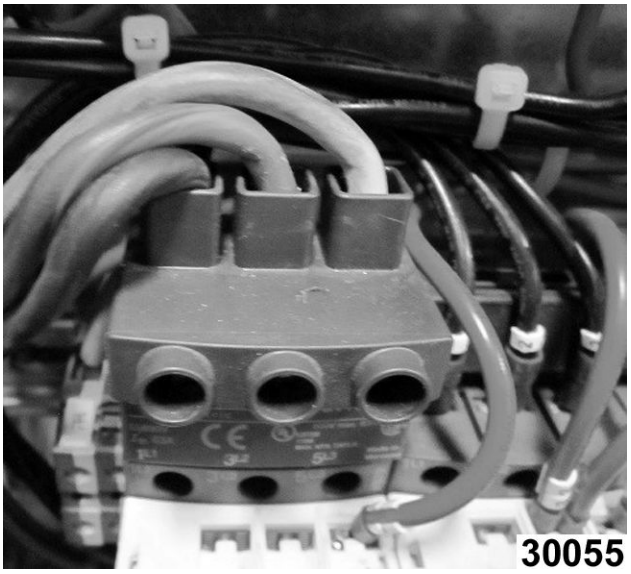

Fig. 45

After Jan 1 2015

- All deck ovens will be supplied without the manual starter terminal block.

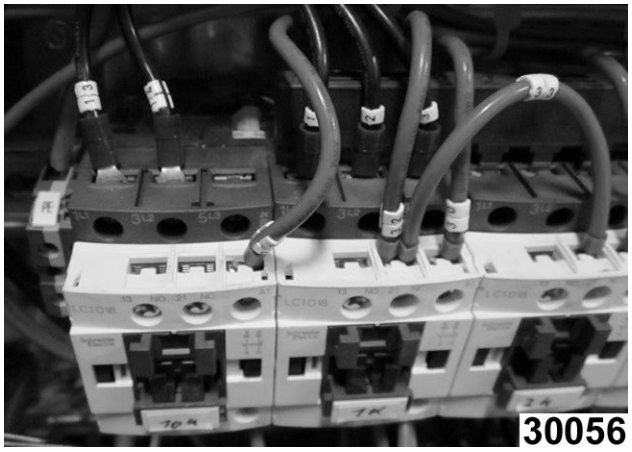

Fig. 46

- Yellow forked Terminals (01-1000V5-00127) are supplied with each stack of decks. They are to be installed on the ends of the incoming power lines for power connection to each deck. Power connection should continue to be made at the first contactor containing wires #13 and #14.

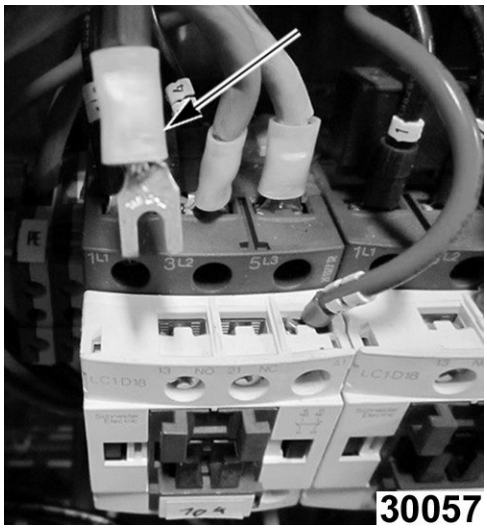

Fig. 47



Fig. 48

NOTE: Verify all power connection clamps are torqued to 1.7 n.m. using a torque wrench and a Phillips NO 2 2mm bit, prior to supplying power to unit. Failure to verify all torque settings may cause the unit to operate improperly or for damage to occur to the unit or its sub components.

INITIAL START UP

NOTE: Remove all protective plastic sheeting from oven surfaces and wipe down to remove all fingerprints, prior to heating deck oven(s).

NOTE: Refer to oven installation checklist and complete during initial start-up.

NOTE: Loosen hardware securing bake stone retainer, to allow for expansion of bake stones during the seasoning process.

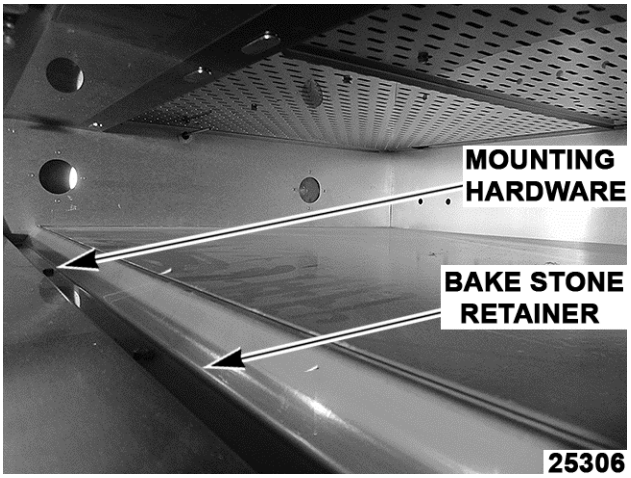

Fig. 49

1. The baking stones need to be slowly "baked in" prior to heating the deck oven to operating temperatures. Use the table and chart below, as a guide to properly season the baking stones.
2. After baking stones have been properly seasoned, check calibration of deck oven.

CONTROLS						
Parameter	**Step 1**	**Step 2**	**Step 3**	**Step 4**	**Step 5**	**Step 6**
Top Heat	158°F	248°F	338°F	446°F	482°F	482°F
Bottom Heat	86°F	86°F	86°F	86°F	428°F	464°F
Baking Time	45 Minutes	80 Minutes	45 Minutes	45 Minutes	45 Minutes	20 Minutes
Steam	None	None	None	None	None	Steam ON
Steam Vent	Open	Open	Open	Open	Open	Closed

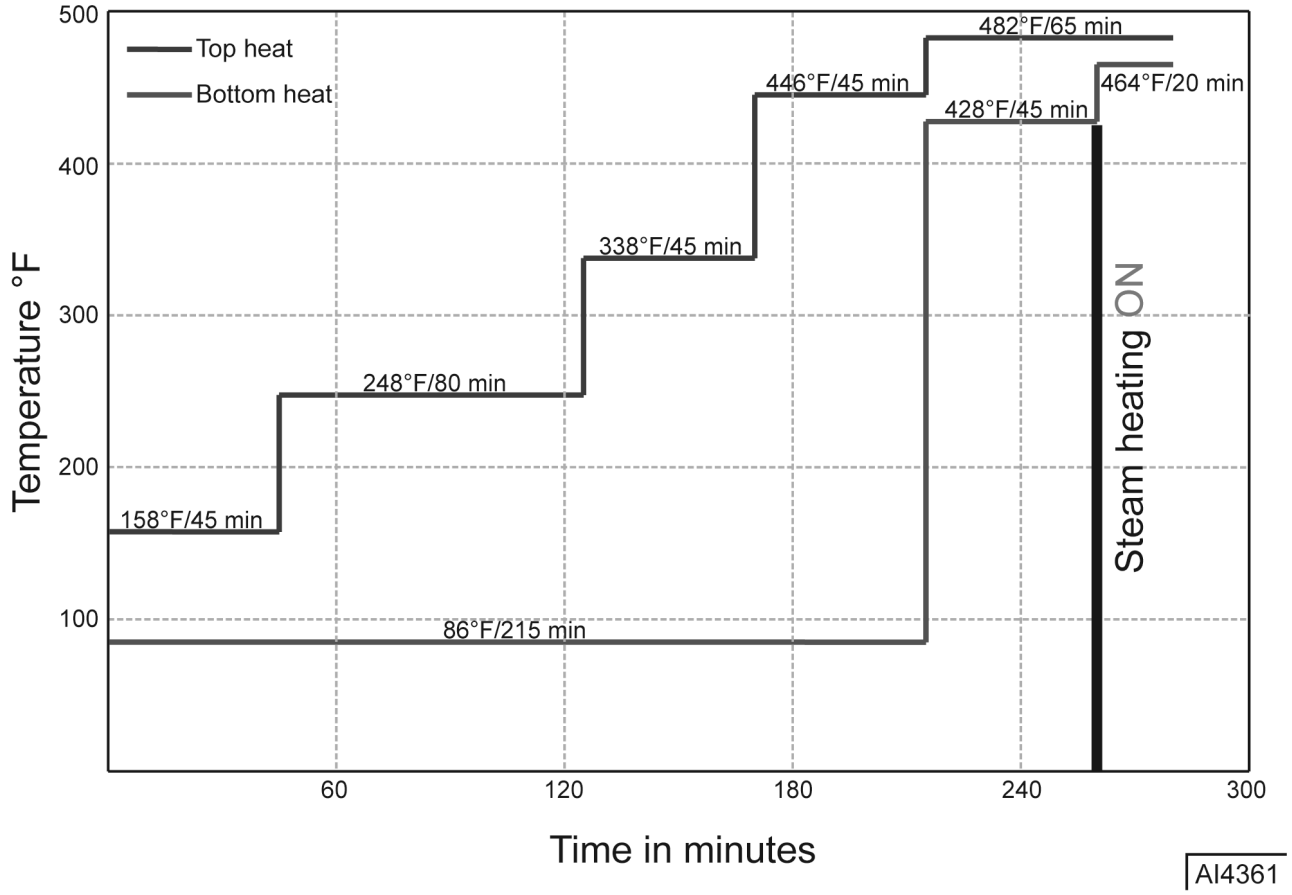

Fig. 50