



XD 9007E
SWGHE
04/08/2019

Simple. Smart.



XLT Electric Oven & AVI Hood Parts & Service Manual



Read This Manual Before Using This Appliance.

Current versions of this manual, Rough-In Specifications, Installation & Operation Manual, Architectural Drawings, & a list of International Authorized Distributors are available at: www.xltovens.com

For use with the following XLT Electric Oven Versions:

Standard (S) G
World (W) G

For use with the following AVI Electric Hood Versions:

Standard (S) E
World (W) E



XLT Ovens
PO Box 9090
Wichita, Kansas 67277

US: 888-443-2751 FAX: 316-943-2769 INTL: 316-943-2751 WEB: www.xltovens.com

**SAFETY DEPENDS ON YOU****CAUTION**

This appliance is for professional use by qualified personnel. This appliance must be installed by qualified persons in accordance with the regulations in force. This appliance must be installed with sufficient ventilation to prevent the occurrence of unacceptable concentrations of substances harmful to health in the room in which it is installed. This appliance needs an unobstructed flow of fresh air for satisfactory operation & must be installed in a suitably ventilated room in accordance with current regulations. This appliance should be serviced by qualified personnel at least every 12 months or sooner if heavy use is expected.

**DANGER**

Improper installation, adjustment, alteration, service or maintenance can cause property damage, injury, or death. Read the installation, operating and maintenance instructions thoroughly before installing, using, or servicing this equipment.

**DANGER****FOR YOUR SAFETY**

Do not store or use gasoline or other flammable liquids or vapors in the vicinity of this or any other appliance.

- Do not restrict the flow of ventilation air to the unit. Provide adequate clearance for operating, cleaning, and maintaining the unit when in the installed position.
- Keep the area free and clear of combustible material. DO NOT SPRAY AEROSOLS IN THE VICINITY OF THIS APPLIANCE WHILE IT IS IN OPERATION.
- Ovens are certified for installation on combustible floors.
- Electrical schematics are located inside the control box of the oven and in this manual. Disconnect input power to the unit before performing any maintenance.
- This unit requires a ventilation hood. The installation must conform to local codes.
- This unit must be operated by the same voltage, phase, & frequency of electrical power as designated on the nameplate label located on the side of the unit.
- Minimum clearances must be maintained from combustible & non-combustible construction materials.
- Follow all local codes when installing this unit.
- Follow all local codes to electrically ground the unit.
- Appliance is not to be cleaned with high pressure water.
- XLT ovens are certified for use in stacks of up to three (3) units of XLT products. Integration of other manufacturer's products into an oven stack is not recommended, & will void any warranties. XLT Ovens assumes no liability for mixed product applications.
- Failure to call XLT Customer Service at 1-888-443-2751 prior to contacting a repair company voids any & all warranties.
- PLEASE RETAIN THIS MANUAL FOR FUTURE REFERENCE.
- This appliance operates below 70 dBA.

XLT Ovens has spent millions of dollars designing and testing our products as well as developing Parts & Service Manuals. These manuals are the most complete and easiest to understand in the industry. However, they are worthless if they are not followed.

We have witnessed store operators and building owners lose many thousands of dollars in lost revenue due to incorrect installations. We highly recommend you follow all instructions given in this manual as well as follow best practices in plumbing, electrical, and HVAC building codes.

Definitions & Symbols

A safety instruction (message) includes a “Safety Alert Symbol” & a signal word or phrase such as **DANGER**, **WARNING** or **CAUTION**. Each signal word has the following meaning:

 DANGER	ISO 7000-0434: Indicates a potentially hazardous situation that, if not avoided, can result in serious injury or death.
 HIGH VOLTAGE	IEC 60417-5036: This symbol indicates high voltage. It calls your attention to items or operations that could be dangerous to you & other persons operating this equipment. Read the message & follow the instructions carefully.
 WARNING	ISO 7000-0434: Indicates a potentially hazardous situation, that if not avoided, can result in minor to moderate injury or serious damage to the product. The situation described in the CAUTION may, if not avoided, lead to serious results. Important safety measures are described in CAUTION (as well as WARNING), so be sure to observe them.
 CAUTION	ISO 7000-0434: Indicates a potentially hazardous situation, that if not avoided, can result in minor to moderate injury or serious damage to the product. The situation described in the CAUTION may, if not avoided, lead to serious results. Important safety measures are described in CAUTION (as well as WARNING), so be sure to observe them.
 READ MANUAL	 CLASS II EQUIPMENT
 PROTECTIVE EARTH	 EQUIPOTENTIALITY
 FUSE-LINK	



Warranty - US and Canada

Rev H

Approval Date: 09/28/2017

XLT warrants Version G ovens manufactured after October 16, 2017 to be free from any defect in material and workmanship under normal use for seven (7) years from the date of original purchase by the end user, and further warrants main fan blades, conveyor shafts, and conveyor bearings for ten (10) years. XLT further warrants all ovens/hoods to be free from rust for ten (10) years from the date the equipment is originally purchased. XLT warrants Version E hoods manufactured after October 16, 2017 to be free from any defect in material and workmanship under normal use for seven (7) years from the date of original purchase by the end user purchaser. If the purchase includes a pre-piped Ansul system hood and the ovens both the warranty will be increased to ten (10) years on both pieces of equipment. In the event of a part failure, XLT will furnish a replacement part and pay for all labor associated with the replacement of the part. If upon inspection XLT determines that the part is not defective, all incurred costs will be the responsibility of the end user purchaser. This warranty is extended to the original end user purchaser and is not transferable without prior written consent of XLT. Damages are limited to the original purchase price.

DUTIES OF THE OWNER:

- The owner must inspect the equipment and crates at time of receipt. Damage during shipment is to be immediately reported to the carrier and also to XLT
- The equipment must be installed and operated in accordance with the I&O Manual furnished with the unit
- This warranty shall not excuse the owner from properly maintaining the equipment in accordance with the I&O Manual furnished with the unit
- A copy of the "Initial Start-Up Checklist" must be filled out and returned to XLT when the unit is initially installed, and/or when the unit is removed and installed in another location
- The gas, electric, and HVAC utilities must be connected to the oven and installed by locally licensed contractors
- Failure to contact XLT Ovens prior to contacting a repair company for warranty work voids any and all warranties

WHAT IS NOT COVERED:

- Freight damage
- Overtime charges
- Any part that becomes defective because of utility services (power surges, high or low voltages, high or low gas pressure or volume, contaminated fuel, or improper utility connections)
- Any part that becomes defective because of moisture and/or other contaminants
- Conveyor belts
- Filters
- Exhaust Fans
- Light Bulbs
- Painted or Powder Coated surfaces
- Normal maintenance or adjustments
- This warranty shall not apply if the equipment or any part is damaged as a result of accident, casualty, alteration, misuse, abuse, improper cleaning, improper installation, improper operation, natural disasters, or man-made disasters

CLAIMS HANDLED AS FOLLOWS:

Should any such defect be discovered, XLT must be notified. Upon notification, XLT will arrange for necessary repairs to be made by an authorized service agent. Denial of services upon the arrival of an authorized service agent will release XLT of any and all warranty obligations.





Warranty - International

Rev K

Approval Date: 09/28/2017

XLT warrants Version G ovens manufactured after October 16, 2017 to be free from any defect in material and workmanship under normal use for five (5) years from the date of original purchase by the end user, and further warrants main fan blades, conveyor shafts, and conveyor bearings for ten (10) years. XLT further warrants all ovens/hoods to be free from rust for ten (10) years from the date the equipment is originally purchased. XLT warrants Version E hoods manufactured after October 16, 2017 to be free from any defect in material and workmanship under normal use for five (5) years from the date of original purchase by the end user purchaser. If the purchase includes a hood and the ovens both the warranty will be increased to seven (7) years on both pieces of equipment. In the event of a part failure, XLT will furnish a replacement part and pay for all labor associated with the replacement of the part. If upon inspection XLT determines that the part is not defective, all incurred costs will be the responsibility of the end user purchaser. This warranty is extended to the original end user purchaser and is not transferable without prior written consent of XLT. Damages are limited to the original purchase price.

DUTIES OF THE OWNER:

- The owner must inspect the equipment and crates at time of receipt. Damage during shipment is to be immediately reported to the carrier and also to the Distributor/Service Provider
- The equipment must be installed and operated in accordance with the I&O Manual furnished with the unit
- This warranty shall not excuse the owner from properly maintaining the equipment in accordance with the I&O Manual furnished with the unit
- A copy of the "Initial Start-Up Checklist" must be filled out and returned to Distributor/Service Provider when the unit is initially installed, and/or when the unit is removed and installed in another location
- The gas, electric, and HVAC utilities must be connected to the oven and installed by locally licensed contractors
- Failure to contact the Distributor/Service Provider prior to contacting a repair company for warranty work voids any and all warranties

WHAT IS NOT COVERED:

- Freight damage
- Overtime charges
- Any part that becomes defective because of utility services (power surges, high or low voltages, high or low gas pressure or volume, contaminated fuel, or improper utility connections)
- Any part that becomes defective because of moisture and/or other contaminants
- Conveyor belts
- Filters
- Exhaust Fans
- Light Bulbs
- Painted or Powder Coated surfaces
- Normal maintenance or adjustments
- This warranty shall not apply if the equipment or any part is damaged as a result of accident, casualty, alteration, misuse, abuse, improper cleaning, improper installation, improper operation, natural disasters, or man-made disasters

CLAIMS HANDLED AS FOLLOWS:

Should any such defect be discovered, the Distributor/Service Provider must be notified. Upon notification, Distributor/Service Provider will arrange for necessary repairs to be made by an authorized service agent. Denial of services upon the arrival of an authorized service agent will release XLT and Distributor/Service Provider of any and all warranty obligations.



Sockets	QTY.
1/4" Drive	
3/16	1
7/32	1
1/4	1
9/32	1
5/16	1
3/8	1
7/16	1
1/2	1
3/8" Drive	
7/16	1
1/2	1
9/16	1
5/8	1
3/4	1
11/16	1
13/16	1
7/8	1
15/16	1
1"	1
3/8" Drive Allen	
1/8	1
3/16	1
7/32	1
1/4	1
5/16	1
3/8	1

T-Handle Allen	QTY.
3/32	1
7/64	1
1/8	1
3/16	1
1/4	1
7/32	1

Ratchets	QTY.
7" 1/4" Drive	1
12" 3/8" Drive	1

Extensions	QTY.
1/4" Drive	
3"	1
6"	1
10"	1
3/8" Drive	
1-1/2"	1
3"	1
6"	1
10"	1

Gearwrench	QTY.
5/16	1
3/8	1
7/16	1
1/2	1
9/16	1
5/8	1
11/16	1
3/4	1

Wrenches	QTY.
10" Crescent	1
14" Pipe	2

Screw Drivers	QTY.
#2 Phillips	1
#1 Phillips	1
1/4" Flat Blade	1
1/8" Flat Blade	1

Nut Driver	QTY.
5 MM	1
8 MM	1

Pliers	QTY.
Diagonal SM	1
Diagonal Std	1
Slip Joint Std	1
Needle Nose	1
Wire Strippers	1
Wire Crimpers	1

Hammer	QTY.
8 oz. Ball Peen	1

Drills	QTY.
Cordless Micro	1
Cordless Std	1

Bits	QTY.
6" #2 Phillips	1
3/16" Drill Bit	1
5/32" Drill Bit	1
#10-24 Tap	1
#8-32 Tap	1

Miscellaneous	QTY.
Dwyer Manometer	1
Dwyer A-110 Fluid	1
Volt/Amp Meter	1
Heat Probe	1
Molex Extractor	1
Molex Crimper	1
Straight Pick 6"	1
90 Degree Pick 6"	1
7" Zip Ties	20
Flashlight	1
25' Tape Measure	1
Electrical Tape	1
Pipe Dope	1
White Lithium Grease	1
Stainless Steel Cleaner	1

Responsibility	XLT/Service Company	Owner/ Contractor
Site Survey: Verify electric and gas meter/regulator sizes	X	
Supply wiring from TS1 #R3, R4, R5 to exhaust fan		X
Supply (1) single phase 230 volt 10 amp circuit from breaker panel to XLT Hood		X
Assembly of new hood per XLT Installation & Operation Manual		X
Suspend XLT Hood from ceiling		X
Install new exhaust fan on roof		X
Supply power to XLT Hood		X
Install Duct Cover or Valance above XLT Hood		X
Assembly of new ovens per XLT Installation & Operation Manual		
Stands assembled and set in place	X	
Ovens moved and stacked with proper lifting equipment	X	
Assemble shrouds & brackets to XLT Oven/Hood	X	
Connecting fuel to XLT products		
Install piping and drip legs		X
Weld ducting to XLT Hood		X
Check for leaks		X
Install flexible gas hoses	X	
Connect electrical supply	X	
Connection may require Permit and Code Inspections		X
Relocate Make-Up-Air to enter the room at the ends of the ovens		X
Start-up per XLT Installation & Operation Manual:	X	
Gas pressure/leak testing, hood/oven functions, adjust as necessary	X	
Start-Up Checklist must be submitted to XLT to validate Warranty		X

This manual, which contains an illustrated parts breakdown, has been prepared as an aid in understanding how the unit operates, how to diagnose problems, and order parts for the equipment. All of the parts, listed in the parts breakdown, are manufactured with the same precision as the original equipment.

XLT parts and service providers are available worldwide. There are authorized service providers located in the principle cities of the United States. There are also authorized Distributors located throughout the world.

The Theory of Operation section describes how the unit operates. An understanding of normal operation will greatly aid diagnosis and troubleshooting. The Troubleshooting section asks simple yes or no questions. The next question or statement entirely depends upon the previous answer. It will lead to the solution of a problem in the most efficient way. The illustrated parts section identifies the various sub-assemblies and detailed parts which make up the equipment, as well as the part number. An explanation of how to order parts is included.

This manual is designed to supplement the Installation & Operation Manual provided with the unit when new. Please refer to it for descriptions, dimensions, weights, electrical requirements, maintenance schedules, and certifications.

XLT Ovens wants you to be totally satisfied with every aspect of owning & using your oven & hood. Your feedback, both positive & negative, is very important to us as it helps us understand how to improve our products & our company. Our goal is to provide you with equipment that we can be proud to build & you can be proud to own.

To receive technical support for the oven or hood you purchased, XLT has qualified customer service personnel that can provide assistance on any type of XLT oven or hood equipment problem you may experience. Customer Service is available 24/7/365 at 888-443-2751 or visit www.xltovens.com.

**DANGER**

Repairs of all appliances & ventilation exhaust hoods should only be performed by a qualified professional who has read & understands these instructions & is familiar with proper safety precautions. Read this manual thoroughly before installing or servicing this equipment.

**NOTE**

Notes indicates an area or subject of special merit, emphasizing either the product's capability or common errors in operation or maintenance.

**TIP**

Tips give a special instruction that can save time or provide other benefits while installing or using the product. The tip calls attention to an idea that may not be obvious to first-time users of the product.

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For maintenance procedures, please refer to the XLT Installation & Operation Manual.

Save this Manual

This document is the property of the owner of this equipment.

XLT Ovens reserves the right to make changes in design & specifications, and/or make additions to or improvements to its product without imposing any obligations upon itself to install them in products previously manufactured.

All Right Hand & Left Hand designations in this manual are from the point of view as if standing directly in front of the glass sandwich door.

Revision History Table		
Revision	Comments	Date
D	Added Recommended Tool List To Pg. 6, Added LUI Service Error Codes To Pg. 21, Added "Do Not Exceed 65 Hz On VFD Settings" To Pg. 24, And Updated Carrier Frequency From 2.1 To 9.5 On Pg. 24.	01/04/2019
E	Updated Door Retainer Right (XM-6704E) On Pg. 32.	04/08/2019

When the main power on the Large User Interface (LUI) is turned on:

1. The Oven Fan Motor (M1) located in the Back Wall will run.
2. The Fan (M3) located on the Control Panel will run.
3. The LUI will display actual temperature until set point is reached.
4. The LUI will display belt time.
5. The conveyor belt will move.

The first part of the Theory of Operation explains how electrical power is delivered to the oven and initial sequences when the main power on the LUI is turned on. The remainder of the Theory of Operation section explains the function of components in alphabetical order. These components are also listed on the schematic.

- Line voltage for Standard Ovens is assumed to be 208/240 VAC, 3 Φ , 60 Hz.
- Line voltage for World Ovens is assumed to be 380 VAC, 3 Φ , 50 Hz.

Power originates at the electrical connection on the wall. Line voltage is then carried into the oven through the power cord to the Power Block (PB). 3 wires come off the power block. One wire goes to the Circuit Breaker (CB) and then continues on to the Power Supply (PS). The other leg acts as a neutral for the PS and The Main Motor (M1). After the PS, 24 VDC is delivered to the Terminal Strip (TS2). From the other side of the TS2, power is then supplied to the Oven Control (OMC).

When the main power button is turned on, line voltage will be carried through the Main OMC the TS2 #6L after a 30 second delay.

- The OMC sends power to the Oven Fan Motor Relay (R1) or the Oven Fan Motor Frequency Drive (VFD World and Australia Only). Which then delivers power to the Oven Fan Motor (M1). Once the Main Motor Centrifugal Switch (S2) closes it provides power to the coil of the Contactors (C1 and C2), which opens the contactor sending power to the SSRs (SSR1-4) and Heating Elements (H1-H6). The SSRs are elements controlled by the OMC.

C1 & C2 - A contactor is an electrically controlled switch used for switching a power circuit. A contactor is controlled by a control circuit that has a much lower power level than the switched circuit. They consist of a small coil and a set of three SPST contacts. When the LUI is turned on and the S2 is closed, 24 VDC voltage is applied to the coil, which closes the contacts. Then power is allowed to flow to the SSR's. If the temperature at S3 exceeds 600° F, or if M1 does not rotate, then voltage is interrupted to the coil, and will open the contactors.

CAP - The Capacitor is physically mounted inside the Control Box but wired to the externally mounted M1. The M1 is a Permanent Split Capacitor (PSC) motor. PSC means a capacitor motor in which the starting capacitor and the auxiliary winding remain in the circuit for both starting and running. The CAP is a 30.0 μ F +/- 6% 370VAC/B 50/60 Hz.

CB - Circuit Breakers are used to protect electrical components. The current value is printed on the front of all breakers. If a CB is tripped, eliminate the cause and press the front to reset.

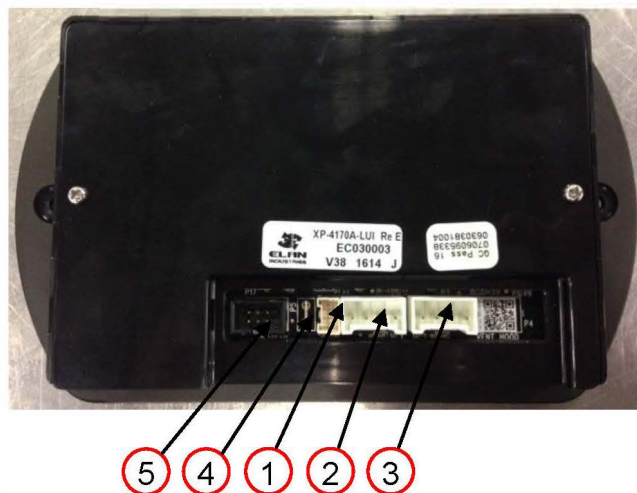
FLT 1 - Is an inline filter used in world ovens. The filter is placed in series with the Line voltage being supplied to the oven. The filter is used to reduce Electromagnetic Interference created by our equipment and back-feeding it into other appliances. EMI filters use capacitors to inhibit direct current while permitting alternating current. EMI filters also use inductors which redirect high voltages and high frequencies by dissipating them to ground.

H1-H6 - The Heating Elements convert electricity into heat through the process of joule heating. Electric current through the element encounters resistance, resulting in heating the element. The resistance values of the four (4) different part numbers used are:

- XP-5201-208-4.5 4500 Watt 9.61 Ohms
- XP-5201-240-4.5 4500 Watt 12.80 Ohms
- XP-5202-208-5.3 5300 Watt 8.16 Ohms
- XP-5202-240-5.3 5300 Watt 10.87 Ohms

Please refer to the Parts section for the proper application.

LR– The Line Reactor is used in all world ovens. It is an inductor wire between the incoming AC power source and the VFD. It is used to filter out spikes of current and reduce harmonics.



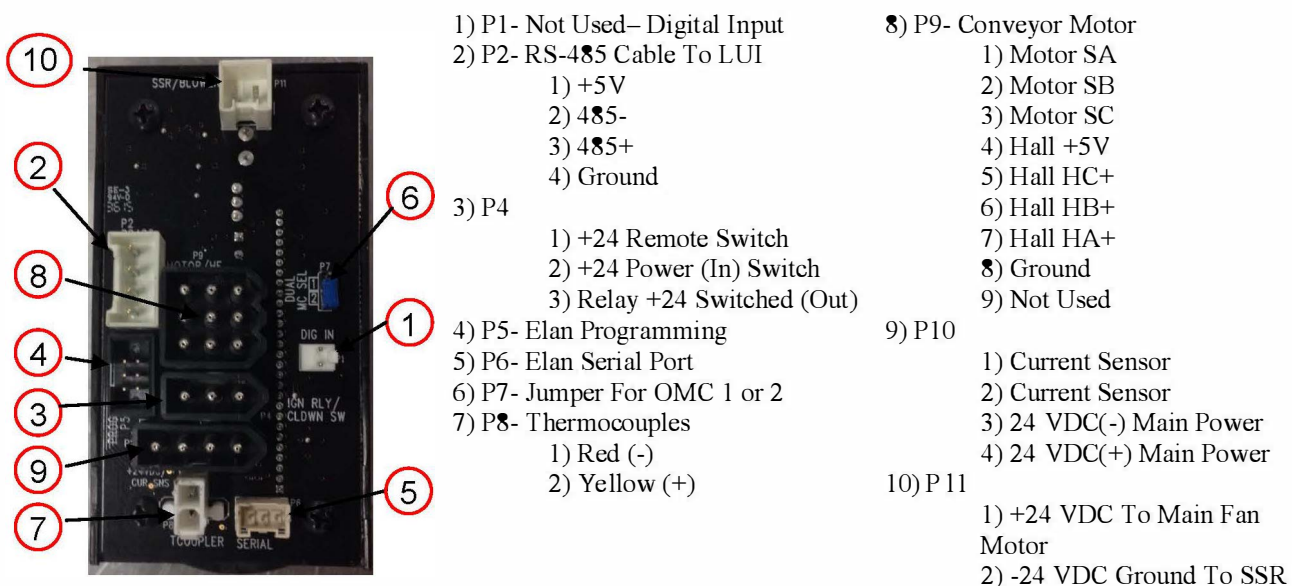
- 1) P1- Not Used
- 2) P2- RS-485 Cable To OMC1
 - 1) +5V
 - 2) 485-
 - 3) 485+
 - 4) Ground
- 3) P3- RS-485 Cable To OMC2
 - 1) +5V
 - 2) 485-
 - 3) 485+
 - 4) Ground
- 4) P5- Ground
- 5) P17- Not Used

LUI - The Large User Interface is powered by the OMC by the RS 485 cable. The main power button is located on the front face of the LUI. The conveyor(s) and temperature of the oven is controlled through the LUI. You can change the factory settings for the oven size, VFD/No VFD, cool down mode, and Gas/Electric, etc. For a Standard Oven it will also display the main fan amps. The LUI will display error messages and maintenance alarms. There are 12 menu presets for predetermined time and temperature settings. The screen can be locked to prevent unwanted mischief.

M1 – The Main Motor for standard ovens is a PSC, single phase, capacitor run motor and has an internal S2. The motor is dual voltage and reversible. The voltage to power the motor comes from the R1 terminal #2. For world ovens M1 is a 3 phase inverter rated motor with an internal S2. It gets power from a variable frequency drive which is then turned on by the OMC. The main motor will continue to operate for approximately 30 minutes or until the oven temperature is less than 225 degrees Fahrenheit after the oven is turned off. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

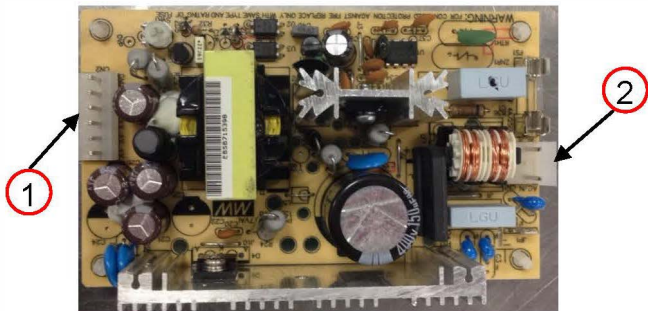
M2 - The Conveyor Motor is a brushless 24 VDC gear motor. The motor receives current from the OMC through three (3) wires; 1) A black or “W” phase, 2) a white or “V” phase, and 3) a red or “U” phase. They carry between 18 to 24 VDC. Each wire is energized by the OMC in sequence to provide power to the individual stator coils which, in turn, provide motor rotation. To determine the rotor position and send this position to the controller, three (3) Hall Effect switches are utilized. They read the rotational information from a disc mounted on the rotor assembly. This information is transmitted to the OMC by three (3) wires; 1) an orange “U” phase pole signal output, 2) a green “V” phase pole signal output, and 3) a green/white “W” phase pole signal output. These are located in a plug that inserts into the OMC1 or OMC2. There are two (2) additional wires in this plug; 1) a purple wire which is supply voltage for the pole sensor, and 2) a gray wire that is ground. The OMC, using an internal logic circuit, energizes the stator coils to provide proper rotation and sets the energization (phase) timing to obtain the desired belt speed set on the controller. The motor drives an integral gear box that reduces the motor output speed to give the correct travel time to the conveyor belt. The integral gear box is sealed and permanently lubricated with grease. The ratio is 1/200. This motor contains no serviceable parts. The OMC will detect if the conveyor belt has a jam by monitoring the rotor signal. If the signal falls more than 25% below the expected rate a jam is detected. This action will stop the conveyor and display an alarm on the LUI. To reset the alarm press and hold “Time” key for 10 seconds.

M3 - The Flow Path Pressure Generating fan supplies combustion air for the Burner. It is controlled by turning on and off the main power button. A filter is provided to ensure clean air.



OMC - The Oven Control reads selections or parameters from the LUI. It holds the logic for the conveyor controls and the temperature controls. The OMC will turn on or off SSR's, start and stop M1, send the call for heat signal, reads the thermocouple and monitor the current sensor.

PB - The Power Block is a connection point for multiple wires of different gauges.



- 1) CN2- 24VDC
 - 1) +24 VDC Main Power To OMC
 - 2) +24 VDC
 - 3) +24 VDC
 - 4) -24 VDC
 - 5) -24 VDC
 - 6) -24 VDC Ground To TS2
- 2) CN1- Line Voltage
 - 1) Neutral
 - 2) Not Used
 - 3) Line Voltage

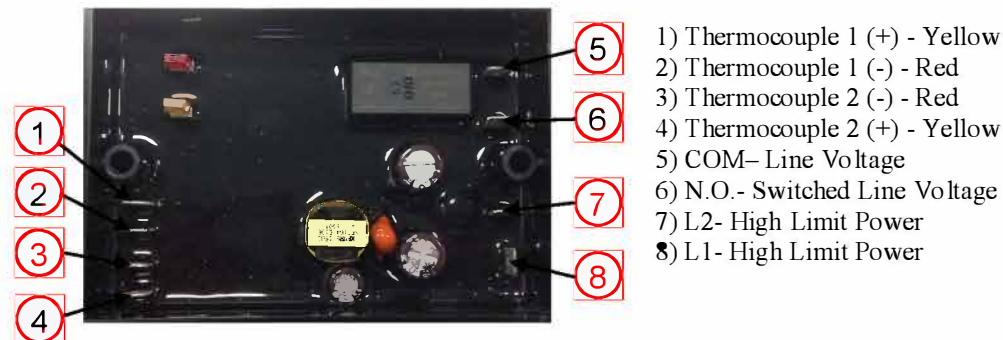
PS - The Power Supply rectifies line voltage to 24 VDC, and supplies power to the OMC and S2. A 4 amp fuse is used to provide over current protection, which is mounted on the PS itself. There are no other fuses used anywhere else.

PU - The Pick-Up is physically mounted within M2 and utilizes hall effect technology integral to the M2 to monitor the rotation speed. The hall effect signal is transmitted to the OMC, which converts it into linear travel speed of the conveyor.

R1 - The Oven Fan Motor Relay is used as a remote switch to handle the higher amp load of M1.

S2 - The Centrifugal Switch is a SPDT switch physically mounted inside M1. When M1 comes up to full speed, S2 closes and sends a 24 VDC signal to the contactors. It functions as a safety feature to prevent burner operation if the M1 fails to rotate.

S3 - Standard Ovens- The High Limit Switch for standard ovens is a bi-metal, NC, SPST switch physically mounted in the side panel of the Bake Chamber. Its purpose is to provide fail safe operation. If the temperature of S3 exceeds 600°F, it opens and interrupts line voltage to all components.

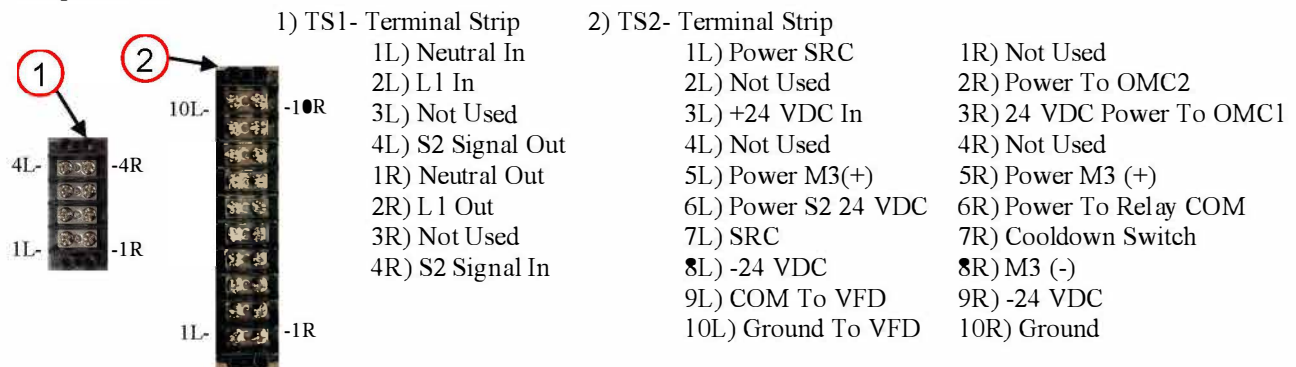


- 1) Thermocouple 1 (+) - Yellow
- 2) Thermocouple 1 (-) - Red
- 3) Thermocouple 2 (-) - Red
- 4) Thermocouple 2 (+) - Yellow
- 5) COM- Line Voltage
- 6) N.O.- Switched Line Voltage
- 7) L2- High Limit Power
- 8) L1- High Limit Power

S3 - World Ovens- The High Limit Switch for world ovens is an electronic, SPST switch physically mounted on the side panel of the Bake Chamber. Its purpose is to provide fail safe operation. When the oven receives power, S3 closes. If the actual oven temperature exceeds 650°F the yellow LED will not illuminate. A red LED will flash and S3 opens to interrupt line voltage to all components. There are two (2) thermocouple inputs to this device. If the delta exceeds 20° C between the thermocouples, the yellow and red LED will alternate flashing and S3 opens.

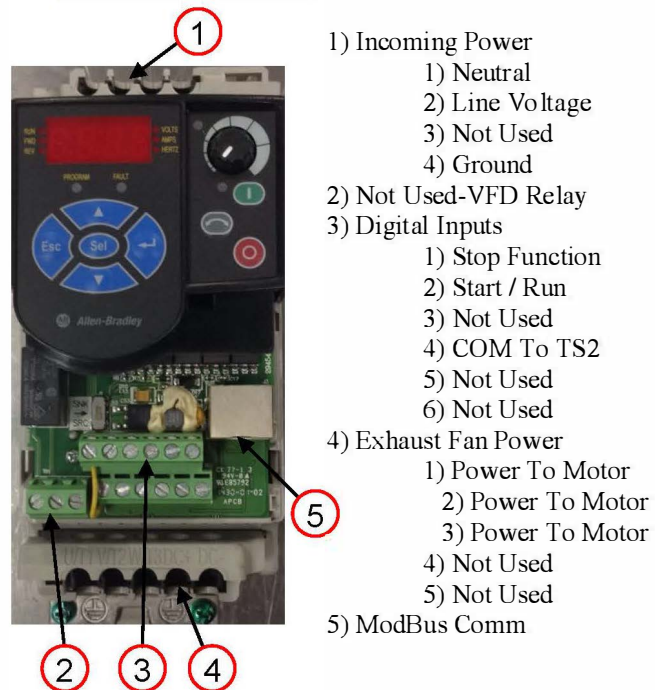
SSR 1-4 - A Solid State Relay is an electronic switching device in which a small control signal from the OMC a larger load current and voltage. It comprises a voltage sensor which responds to the TC, a solid state switching device which switches power to the Heating Elements (H1-6) either on or off, and does this without mechanical parts.

T/C - The thermocouple is a type K. It consists of two different conductors that produce a voltage proportional to a temperature difference between either end of the pair of conductors. The T/C is connected to P8 Terminals 1 & 2 on the OMC. The millivolt signal is used to display the actual temperature.



TS 1 & 2- These are terminal strips, that serve as a connection point for wires.

VFD -The Variable Frequency Drive converts 50 Hz power into 60 Hz power so the ovens fan can run at the proper RPM's. The VFD converts the AC supply voltage to DC and then converts the DC to a suitable three-phase frequency source for M1. The VFD is turned on via the OMC P11 terminal #1. A complete manual can be found at www.xltovens.com.



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When any one of the three oven switches on the Hood User Interface (HUI) are touched (capacitive touch);

1. The Exhaust Fan Motor (M1) located on the roof will run.
2. The ovens associated with the corresponding switches will turn on.

The first part of the Theory of Operation explains how electrical power is delivered to the hood and initial sequences when the HUI switch is turned on. The remainder of the Theory of Operation section explains the function of components in alphabetical order. These components are also listed on the schematic.

Power for the hood originates at the building's electrical service panel. Two (2) circuit are required, one is a single phase high voltage circuit for VFD/Fan circuit that connects to TS 1 terminals 1 & 2. The other circuit is a low voltage circuit for the lights. The line connects to P3 terminal 9 on HMC and the neutral connects to TS 1 terminal 5.

HUI mounted on the hood controls lighting, VFD activation, Make Up Air (MUA) activation and oven function. When HUI Light Switch is touched a relay is closed and voltage will go to lights. When ovens are installed with a hood, the Switch Relocation Cord (SRC) effectively eliminates the main switch located on the oven and transfers control to HUI switches on the hood. When HUI switches are touched a communication signal is sent to the VFD via ModBus signaling it to turn on to a set frequency, at the same time when HUI2 is activated a relay will allow line voltage to be carried through the Switch Relocation Cord (SRC) to the oven activating it. When HUI2-4 are activated the MUA will turn on. The VFD has a built in power supply that is wired to terminal 01 this puts the VFD in run mode so whenever a power loss is sensed the VFD will start back up in run mode once power is restored. The NO switch in the fire alarm system in the building needs to be connected to TS 1 terminals 9 & 10. When the alarm is activated 24 VDC from TS1 9 will return from the fire alarm system to TS1 10 then to HMC P8 to turn off lights, cooling fans, HUI, MUA, and making both relays R1 & R2 switch from NC to NO, causing the VFD to run at 60 Hz.

CB - Circuit Breakers are used to protect electrical components. If a CB is tripped, eliminate the cause and press the front to reset.

HUI – Hood User Interface contains the factory settings so that the hood will operate with the correct hertz when the correct oven size and number of ovens are selected. The factory settings also contain a selection for a VFD, Non VFD, type of MUA activation, and for a World installation. A beeping sound and the display will flash if an alarm occurs. An error message will display at top of screen on HUI. Touching the “I” button will give a brief description of how to correct the error (see Figure 1). Touching the “Light Bulb” button will turn the light on and off inside the hood. Touching the “Silver Square” buttons will turn each oven on or off and sequence the operation of the VFD and the MUA circuits. RS485 cable supplies power and communication between the HUI and HMC.

HMC – The Hood Machine Control is a printed circuit board that has all the relays to control these functions; oven activation SRC, MUA activation, VFD activation, monitors the air proving switches, and lighting activation. The HMC receives a continuous 24 VDC power source provided the CB1 breaker is on. This component also has independent relays to control oven power for fire suppression. If a signal from the fire system is received the oven(s) and lighting power is discontinued and the VFD will run at full speed. For a World installation, sail switch monitoring is available just by answering some questions through factory mode programming. The HMC will also program the PowerFlex 4M VFD each time the CB1 breaker is turned on. ModBus communication is used to change the frequency the VFD runs at depending on the number of ovens used. Error messages will appear on the screen to help with troubleshooting. The screen will flash and beep indicating a error has occurred, the alarm button can cancel this for 2 hours. If error has not been fixed beeping will return. The HMC has filter cleaning reminders available.

LT1 & LT2 - These are light bulbs at each end of the hood, and should illuminate when the HUI light button is touched, touch it again and the light turns off.

M1 – The Exhaust Fan Motor is a 3-phase, direct drive motor. In normal operation, it is powered by the VFD and its RPM will vary as the frequency from the VFD varies. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

M2 & M3 – The Cooling Fan Motor is a 24 VDC, direct drive motor. In normal operation, it is powered through HMC. These fans are used to keep the control box for the hood cool. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

PLUG 1, 2, & 3 – These are circular electrical plugs on one end of the Switch Relocation Cord (SRC). The plugs connect to Receptacles 4, 5, & 6 on the back of the hood. The other end of the SRC plugs into the oven wire harness, and eliminates the operator switch supplied in the oven. Conversely, when the HUI on the hood is turned off, the corresponding oven is turned off as well.

PS –The Power Supply rectifies line voltage to 24 VDC, and supplies power to the HMC, cooling fans, and fire suppression

R1 – Is a SPDT relay, which is an electrically operated switch. It uses an electromagnet to operate a switching mechanism. Voltage is supplied from TS1-9 to Ansul agent box. Once the fire alarm is activated voltage returns to TS1-10 over to HMC P8. That same voltage continues to R1-1 activating the coil in the relay, causing the contacts in the relay to switch from NC to NO. This will switch 24 VDC from terminal 6 to terminal 5 on the VFD causing the M1 to operate at 60 Hz.

R2 – Is a SPDT time delay relay, which is an electrically operated switch. It uses an electromagnet to operate a switching mechanism. Voltage continues from R1-6 to R2 via the red wire activating the coil in the relay, causing the contacts in the relay to switch from NC to NO after one second has expired. This action delays the application of the voltage on terminal (5) on the VFD.

REC 4, 5, & 6– These are circular electrical receptacles mounted on the back of the hood. The

Switch Relocation Cord (SRC) connects into these. This deactivates the main oven switch located on the oven and relocates the operation of it to the HUI. This capacitive touch (NO) switch is located on the front of the hood and controls the lights.

TS 1 & 2- These are terminal strips, that serve as a connection point for wires.

VFD - The Variable Frequency Drive (VFD) converts the AC supply voltage to DC and then converts the DC to a suitable three-phase frequency source for M1. Incoming power connects to terminals L1 & L2. M1 connects to terminals T1, T2, & T3 through TS1. The HMC sends the command to the ModBus to set the frequency for the combination of ovens selected. The VFD can receive a signal from the fire suppression system to command the drive to run at 60 Hz. A complete manual can be found at www.xltovens.com.

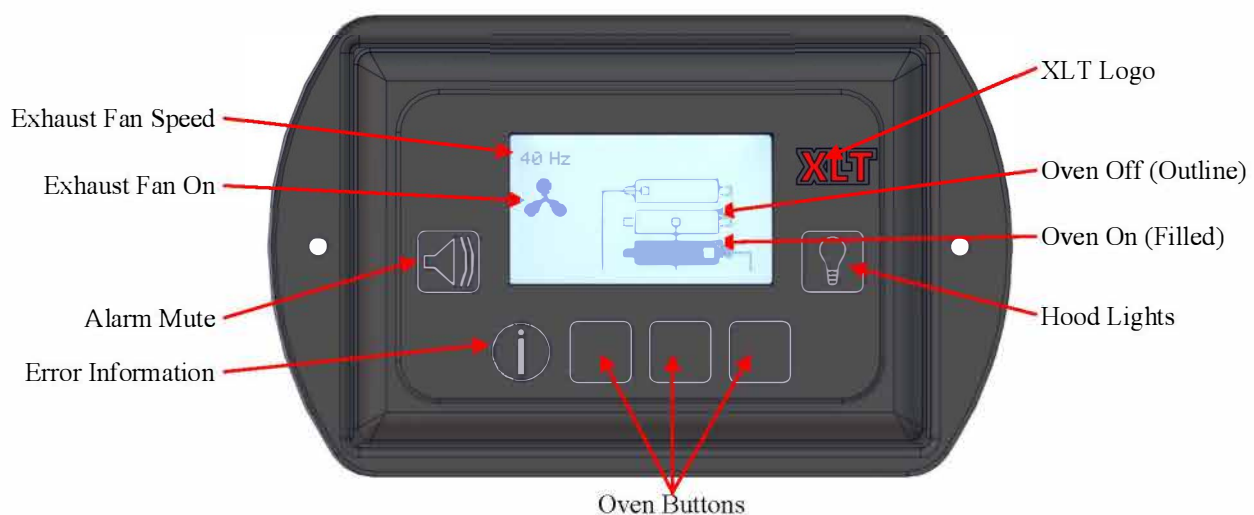


Figure 1

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Mechanical Function

If your oven does not function properly, please verify the following conditions:

1. Verify that the power cord to the oven is connected and/or plugged in if equipped with a plug and receptacle.
2. Check to see that the circuit breakers in the building electrical service panel have not been tripped or turned off.
3. Check all circuit breakers on the oven control panel to ensure they have not been tripped.
4. Ensure proper voltage, amperage, and wire size.



**HIGH
VOLTAGE**

Proceed with caution and read the following instructions carefully when unplugging the units.

Hard Reset

If your oven still does not function properly, perform a hard reset. First, power down the units then unplug the units from all electrical power. Leave the units unplugged for 1 minute. Once this is done, plug the units back in and turn on the power.

If your oven still does not function properly, XLT has qualified customer service personnel that can provide assistance on any type of XLT oven problem you may experience. Customer Service is available 24/7/365 at 888-443-2751, or visit www.xltovens.com.

LUI Service Error Codes

Display Alarm	MC LED	Error Determination	Troubleshooting
Oven Probe	Alarm LED on. Flash HEAT LED. All other LED's operate as normal.	Temp Sensor Error, Open or Short. Temp <40°F (4C) or >700°F (371C)	Perform A Hard Reset. If Error Still Exists, Contact XLT.
PCB Temp Probe	Alarm LED on. Flash HEAT LED. All other LED's operate as normal.	Temp Sensor Error, Open or Short.	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Over Temp	Alarm LED on. Flash HEAT LED. All other LED's operate as normal.	Temp is 50°F (10C) over set point for period > 1 min. If user adjusts set point lower, inhibit alarm until new set point is reached.	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Under Temp	Alarm LED on. Flash HEAT LED. All other LED's operate as normal.	Once set point is reached, the Actual is 15°F (-9C) under set point for more than 30 min. If user adjusts set point, reset timer.	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Over Speed	Alarm LED on. Flash CONVEYOR LED. All other LED's operate as normal.	Speed > 30 sec. fast Duration vs. Set Point	Perform A Hard Reset. If Error Still Exists, Check LUI Settings. If Settings Are Correct, Perform A Pan Test Too Confirm Settings. If Error Still Exists, Contact XLT.
Under Speed	Alarm LED on. Flash CONVEYOR LED. All other LED's operate as normal.	Speed > 30 sec. slow Duration vs. Set Point	Check Drive Chain and Sprocket To Verify Proper Working Condition. Perform A Hard Reset. If Error Still Exists, Check LUI Settings. If Settings Are Correct, Perform A Pan Test Too Confirm Settings. If Error Still Exists, Contact XLT.
Software Error	Alarm LED flash. All other LEDs off.	Internal Software Error	Perform A Hard Reset. If Error Still Exists, Contact XLT.
EEPROM Error	Alarm LED flash. All other LEDs off.	Bad Checksum	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Key Short	Alarm LED flash. All other LEDs off.	Any Key Shorted > 1 min.	Clean LUI Screen. Perform A Hard Reset. If Error Still Exists, Contact XLT.
Comm Error	Alarm LED flash. All other LEDs off.	Internal Software Error	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Hi Alarm	Alarm LED on. Flash HEAT LED. All other LED's operate as normal.	Hi Alarm set point exceeded.	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Main Fan Low Amps	Alarm LED on. Flash FAN LED. All other LED's operate as normal.	Amps below min level per Main Fan Amp level table for 10 sec.	Perform A Hard Reset. If Error Still Exists, Contact XLT.
Main Fan High Amps	Alarm LED on. Flash FAN LED. All other LED's operate as normal.	Amps above max level per Main Fan Amp level table for 10 sec.	Check CB1 To See If It Has Tripped. If Yes, Reset CB1. If No, Perform A Hard Reset. If Error Still Exists, Contact XLT.
Belt Jam	Conveyor LED flash. All other LED's operate as normal.	If the current motor speed is less than 25% of the most recent minimum motor speed.	Check For Obstructions. If No Obstructions Are Found, Check Drive Chain and Sprocket To Verify Proper Working Condition. Perform A Hard Reset. If Error Still Exists, Contact XLT.

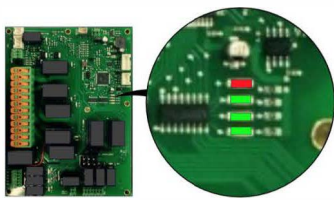


**HIGH
VOLTAGE**

Removing the hood VFD cover panel exposes high voltage. Proceed with caution and read the following the instructions carefully.

Initial troubleshooting of the hood:

1. Remove panel covering VFD to check and see if the circuit breaker is tripped.
2. Check the actual frequency of the VFD controller. To access the actual frequency, press <ESC> button until the Display Mode shows D001.
3. Check to see that the breaker in the service panel is not tripped.
4. Make sure the Switch Relocation Cords (SRC) are properly installed to the oven(s).
5. Check to see that the grease filters are clean & installed properly.
6. Check to see if the exhaust fan is rotating in the correct rotation. To verify fan rotation, remove the lid on the exhaust fan. Visually inspect rotation in accordance with label on fan housing.



Hood Machine Control LED Lights:

1. When the Red LED is lit it indicates an MC error.
2. When the first Green LED is lit it indicates power to MC.
3. When the second Green LED is lit it indicates that the exhaust fan on.
4. When the third Green LED is lit it indicates the MC communication to the VFD.

The VFD has internal diagnostics, and may show the following ERROR codes:

- F004 DC bus voltage fell below min value.
- F005 DC bus voltage fell below max value.
- F007 Motor Overload.
- F008 Heat sink Over Temp.
- F013 Ground Fault.
- F081 Comm Loss- RS485 port stopped communicating.

If any of the above error codes are displayed, then follow these steps to clear them.

1. Record error code on HUI.
2. Take the cover off the hood.
3. Cycle power with circuit breaker

If the corrective actions listed above do not correct the problem, then XLT has qualified customer service personnel that can provide assistance on any type of XLT Oven or AVI Hood problem you may experience. Customer Service is available at 888-443-2751 24/7/365, or visit www.xltovens.com.

For repairs or maintenance of the fire suppression system and components, contact the local Ansul dealer or XLT for assistance.

Large User Interface Programming Procedure



Read the entire instruction before programming.

TIP

Configuration Key Functions

ENTER = Used to select and save parameters.

HIDDEN = Behind the XLT is a hidden button. This is used along with the up and down button to access the programming mode.

UP = Increases the setting of the selected parameter.

DOWN = Decrease the setting of the selected parameter.

To enter factory tech mode press both UP and DOWN button simultaneously for 10 seconds and the following parameters will be displayed:

1. Software Version
2. Serial Number Entry
3. Elapsed Time:
 - Total Hours.
 - Hours Since Filter has been Cleaned.
4. Belt Length: 32 = 1832 36 = 2336 40 = 2440 or 3240 55 = 3255 or 3855 70 = 3270 or 3870
5. Belt Width: 18 = 1832 23 = 2336 24 = 2440 32 = 3240, 3255, or 3270 38 = 3855 or 3870
6. Main Fan Type:
 - Defaults to On/Off.
7. Split Belt:
 - Defaults to No.
8. Dual Burner:
 - Available on oven sizes 3270 and 3870.
9. Fuel Type:
 - Gas Oven or Electric Oven.
10. Remote Hood Switch Installed:
 - Defaults to No.
11. Temperature Offset Adjustments:
 - Offset shown in degrees F.
12. High Temperature range from 590°F (310°C) to Low Temperature.
13. Low Temperature range from 350°F (177°C) to High Temperature.
14. Main Fan (Amps):
 - Press <Enter> to see isolated Amp load.
15. Belt Direction:
 - Defaults to right to left.
 - Can be switched from left to right without physically changing the wire belt direction.
16. Main Fan Off Delay:
 - Defaults to auto 225°F (107°C)
17. Beeper Button Test

VFD (World) Programming Procedure



Read the entire instruction before programming.

TIP

Configuration Key Functions

ENTER = Used to select and save parameters.

ESCAPE = Used to return to previous menu.

UP = Increases the setting of the selected parameter.

DOWN = Decrease the setting of the selected parameter.



With the Oven Control switched off and power connected to the oven, the VFD should show 0.0 on the display.

Do Not Exceed 65 Hz On VFD Settings.

Programming Instructions For Factory Parameters

1. Press ESCAPE to show (d001) with (1) flashing.
2. Press ESCAPE again, now (d) is flashing.
3. Press DOWN Arrow until (P) is flashing and press ENTER.
4. (P101) is displayed with (1) flashing.
5. Press UP Arrow until (P106) is displayed and press ENTER.
6. Press UP Arrow until (2) is displayed and press ENTER.
7. Press ESCAPE and (P106) should be shown with (6) flashing.
8. Press UP Arrow until (P108) is displayed and press ENTER.
9. Press UP Arrow until (1) is displayed and press ENTER.
10. Press ESCAPE to show (P108) displayed.
11. Press ESCAPE again to have (P) flash, and press UP Arrow until (A) is displayed.
12. Press ENTER to have (1) flash.
13. Press UP Arrow until (A446) is displayed and press ENTER.
14. Press ESCAPE then press DOWN Arrow until (9.5) is shown and press ENTER.
15. Press UP Arrow until (A451) is displayed and press ENTER.
16. Press UP Arrow until (9) is shown and press ENTER.
17. Press ESCAPE then press UP Arrow until (A458) is displayed and press ENTER.
18. Press UP Arrow until (1) is displayed and press ENTER.
19. Press ESCAPE two times and the display should read (A458) with (A) flashing.
20. Press the DOWN Arrow until (d001) is displayed and press ENTER.
21. Press ENTER two more times for the display to show (0.0)

**TIP**

Read the entire instruction before programming.

Programming Instructions For Lower Than 60 Hz

1. Press ESCAPE to show (d001) with (1) flashing.
2. Press ESCAPE again, now (d) is flashing.
3. Press DOWN Arrow until (A) is flashing and press ENTER.
4. Press UP Arrow until (A458) is displayed and press ENTER.
5. Press UP Arrow until (0) is displayed and press ENTER.
6. Press ESCAPE and (A458) is shown with (8) flashing.
7. Press DOWN Arrow until (A409) is displayed and press ENTER.
8. Press DOWN Arrow until desired Hz is displayed and press ENTER.
9. Press ESCAPE until (A409) is displayed.
10. Press DOWN Arrow until (d001) is displayed and press ENTER.
11. Press ENTER two more times for the display to show (0.0)

Programming Instructions For Up To 65 Hz Max

1. Press ESCAPE to show (d001) with (1) flashing.
2. Press ESCAPE again, now (d) is flashing.
3. Press DOWN Arrow until (P) is flashing and press ENTER.
4. Press UP Arrow until (P105) is displayed and press ENTER.
5. Press UP Arrow until desired Hz is displayed and press ENTER.
6. Press ESCAPE until (P) is flashing on display showing (P105).
7. Press UP Arrow until (A) is flashing and press ENTER.
8. Press UP Arrow until (A409) is displayed and press ENTER.
9. Press UP Arrow until desired Hz is displayed and press ENTER.
10. Press ESCAPE once and UP Arrow until (A458) is displayed and press ENTER.
11. Press the UP Arrow until (1) is displayed and press ENTER.
12. Press ESCAPE until (A458) is displayed.
13. Press DOWN Arrow until (d001) is displayed and press ENTER.
14. Press ENTER two more times for the display to show (0.0)

Conveyor Speed Settings



Read the entire instruction before programming.

TIP

Configuration Key Functions

ENTER = Used to select and save parameters.

HIDDEN = Behind the XLT is a hidden button. This is used along with the up and down button to access the programming mode.

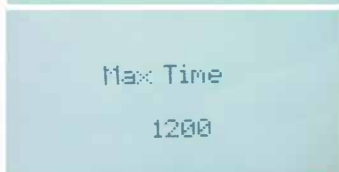
UP = Increases the setting of the selected parameter.

DOWN = Decrease the setting of the selected parameter.

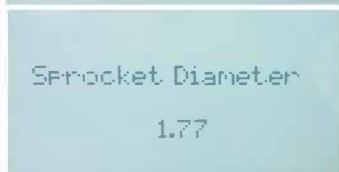
1. To enter conveyor settings press and hold 3 buttons (HIDDEN, UP, and DOWN) for 10 seconds to enter.
2. Displays will show programming screens before auto-exiting after 5 seconds of no activity.

**Min Time**

Factory default is 90. To change, press ENTER. Use Up/Down arrows to change time which is shown in seconds. Press ENTER to accept and advance.

**Max Time**

Factory default is 1200. To change, press ENTER. For 1832 use 1020 and all other models will be 1200. Use Up/Down arrows to change time which is shown in seconds. Press ENTER to accept and advance.

**Sprocket Diameter**

Factory default is 1.77. To change, press ENTER. Use Up/Down arrows to change diameter. Press ENTER to accept and advance.

**Final Gear Ratio**

Factory default is 300. To change, press ENTER. Use Up/Down arrows to change gear ratio. Press ENTER to accept and advance.

**Trim Speed**

Factory default is 100. To change, press ENTER. Use Up/Down arrows to change trim speed. Press ENTER to accept and advance.

Directional Change of the Conveyor Belt

The conveyor belt is non-directional. This means there is NO physical change of the belt when wanting to change direction; it is now as easy as a programming change. To change the direction:

1. Enter Factory Tech Mode by pressing and holding the 2 arrow buttons for 10 seconds.
2. Press Down arrow to cycle through screens.
3. On Belt Direction, press ENTER and use Up/Down arrows to change.
4. Press ENTER to accept and advance.

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Allen Bradley Power Flex 4M Restoring XLT Defaults

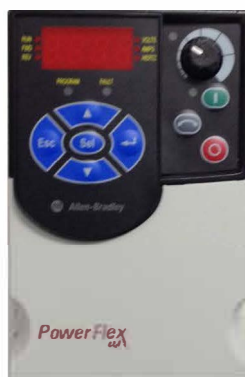
**TIP**

Read the entire instruction before programming.

To reset VFD settings change P112 to 1. The VFD will reset to factory default settings. To cycle power, turn circuit breaker off and on and the HMC will load the factory parameters into the VFD.

P105=65	Maximum Frequency
P106=2	Start Source
P108=4	Speed Reference
P110=2	Decel Time
A451=9	Auto Reset Tries
A452=60	Auto Reset Delay
T201=2	Terminal Block Group (I/O) Terminal 5
T202=6	Terminal Block Group (I/O) Terminal 6
A404=60	Jog Frequency

Test run the motor by turning on one of the oven/hood buttons located on the HUI.



Complete VFD manual available at www.xltovens.com.

VFD Controller Settings						
	Switches On			1832 & 2440	3240 & 3255	3855
	Top	Middle	Bottom			
Single	X			20 Hz	25 Hz	30Hz
Double	X			20 Hz	25 Hz	30Hz
			X	35 Hz	40 Hz	45 Hz
	X		X	35 Hz	40 Hz	45 Hz
Triple	X			20 Hz	25 Hz	30Hz
		X		30 Hz	35 Hz	40 Hz
			X	40 Hz	45 Hz	50 Hz
	X	X		30 Hz	35 Hz	40 Hz
	X		X	40 Hz	45 Hz	50 Hz
		X	X	40 Hz	45 Hz	50 Hz
	X	X	X	45 Hz	50 Hz	55 Hz
Fire Suppression				60 Hz-DO NOT CHANGE		

How to order Parts

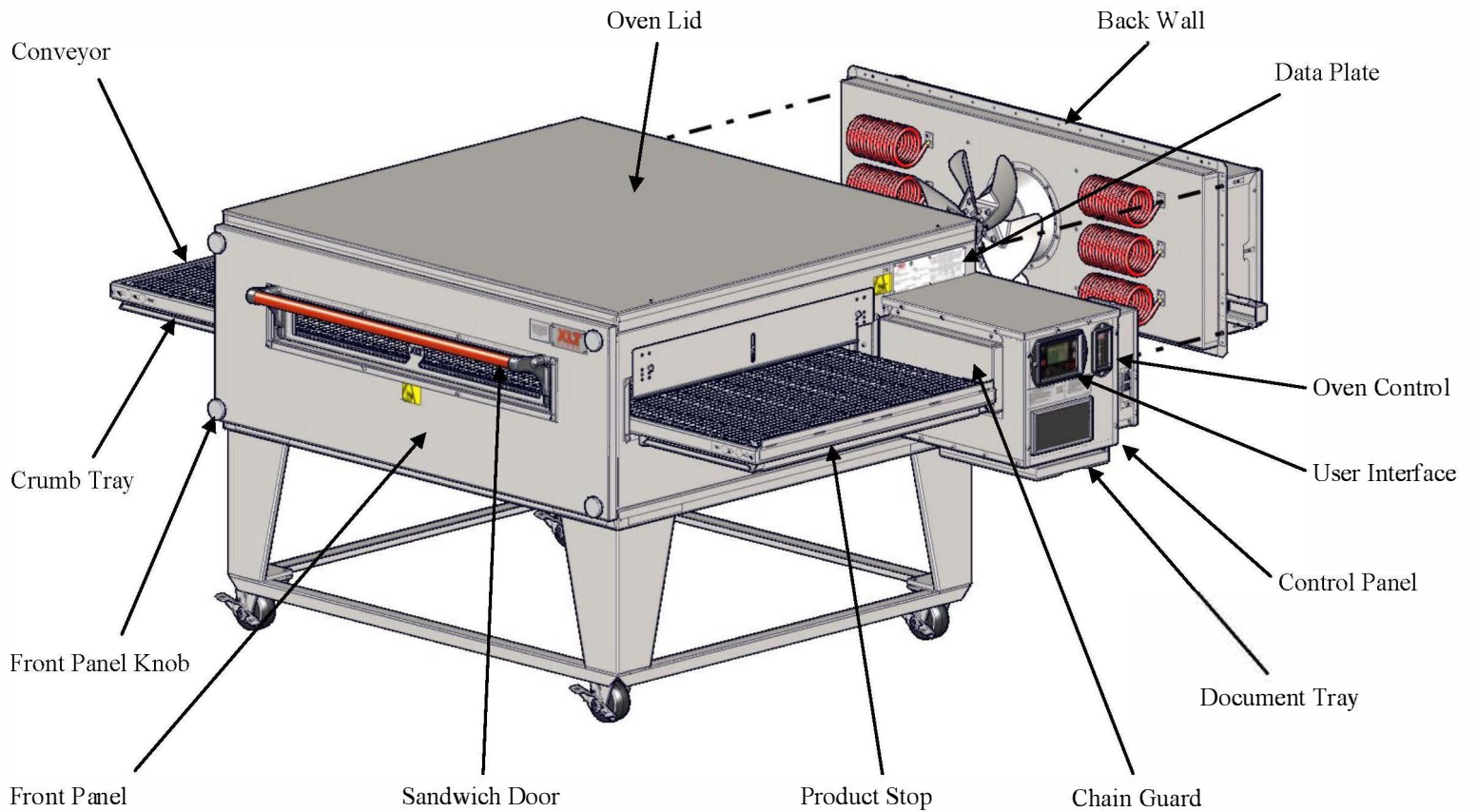
Have all information ready when calling XLT. Below is a list of information that is required for all orders. At the bottom of the Bill of Materials (BOM) on the following parts overview pages are additional requirements needed depending on your parts order.

Oven/Hood information required:

- Model #
- Serial #
- Manufacture Date
- Phone #
- Contact name
- Bill to
- Ship to
- Credit card information

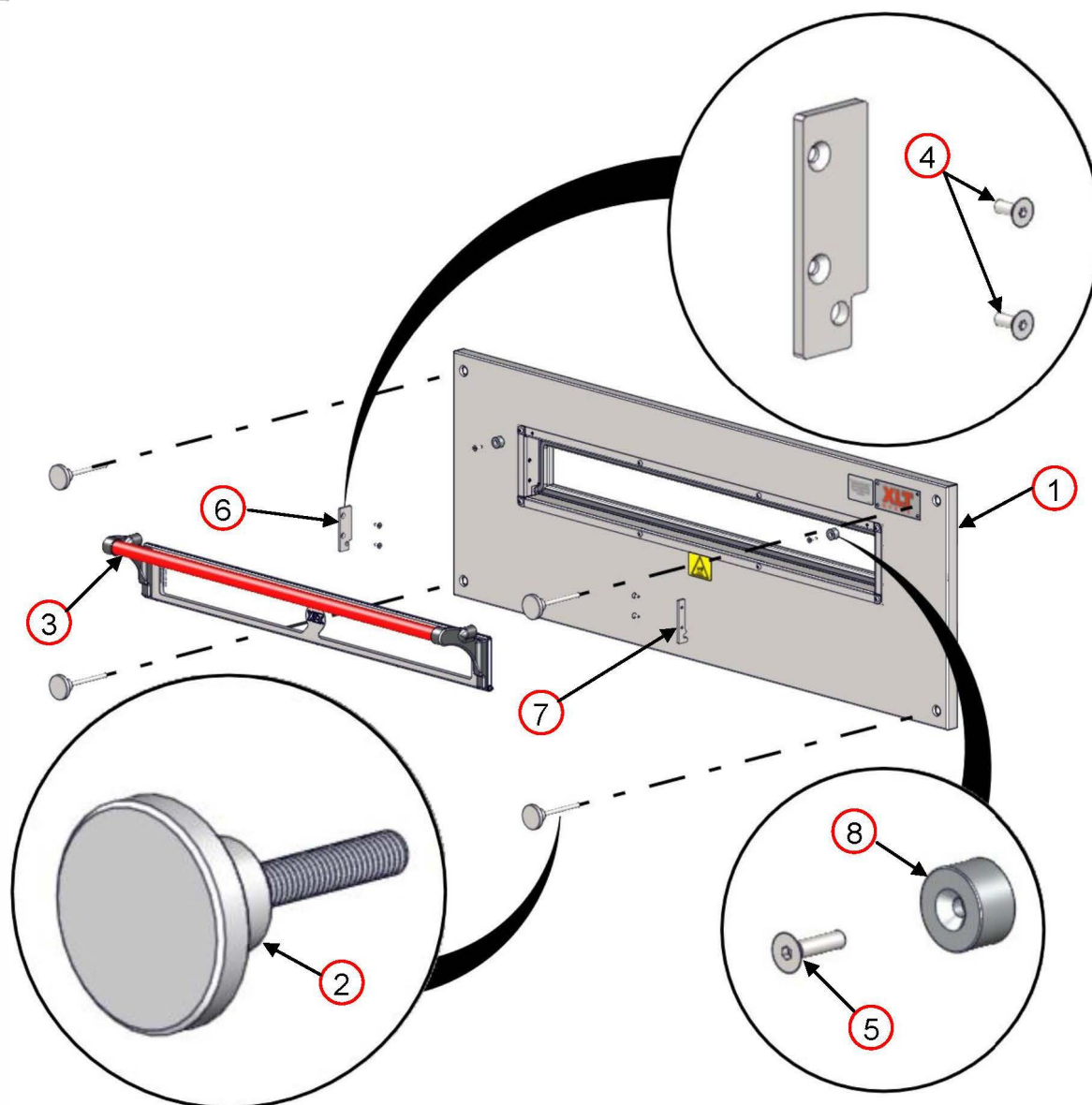
P.O.R = Price On Request

All prices are subject to change, contact XLT for current prices.

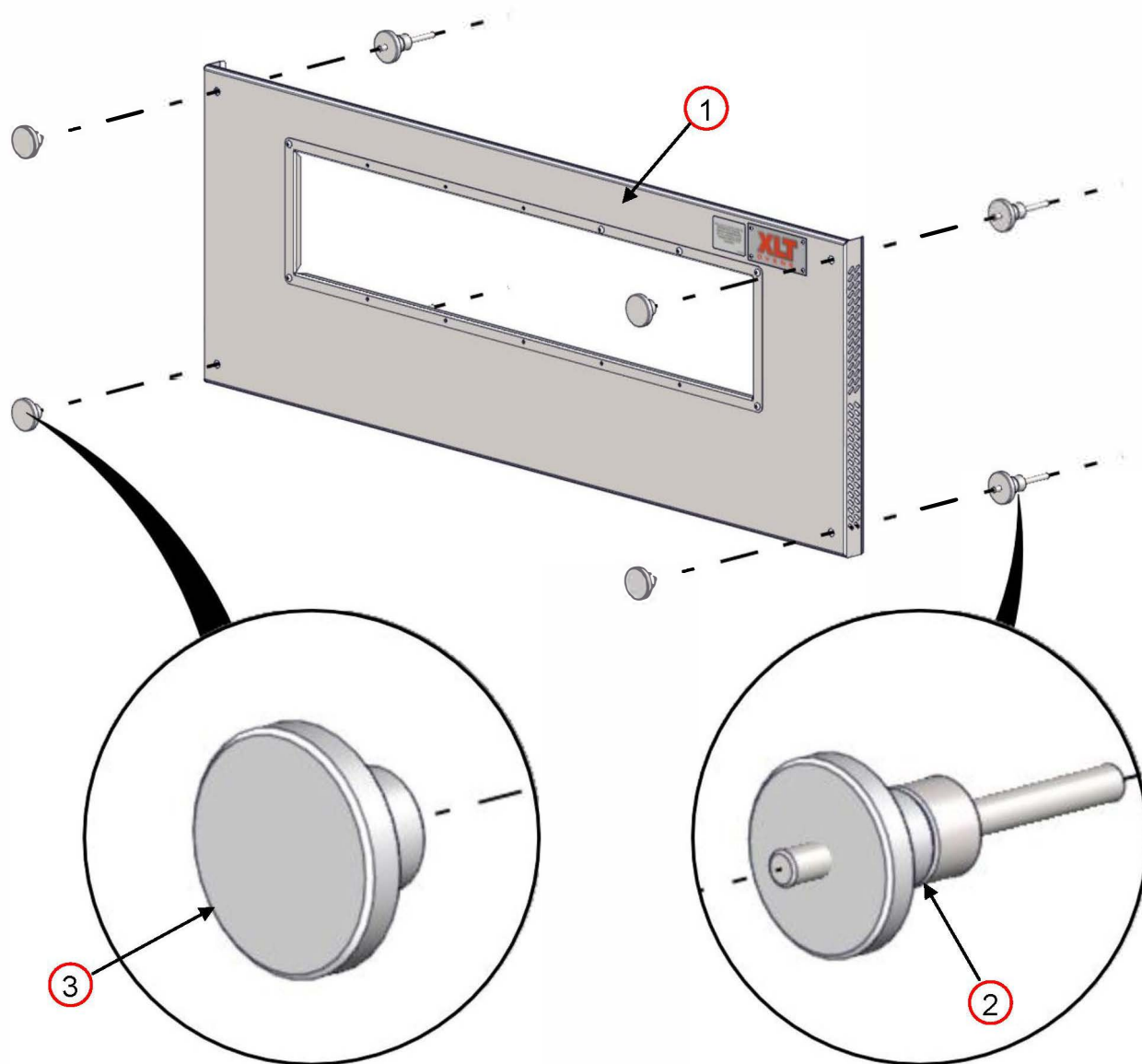


**WARNING**

Individuals with pacemakers or internal medical devices should not handle strong rare-earth magnets.



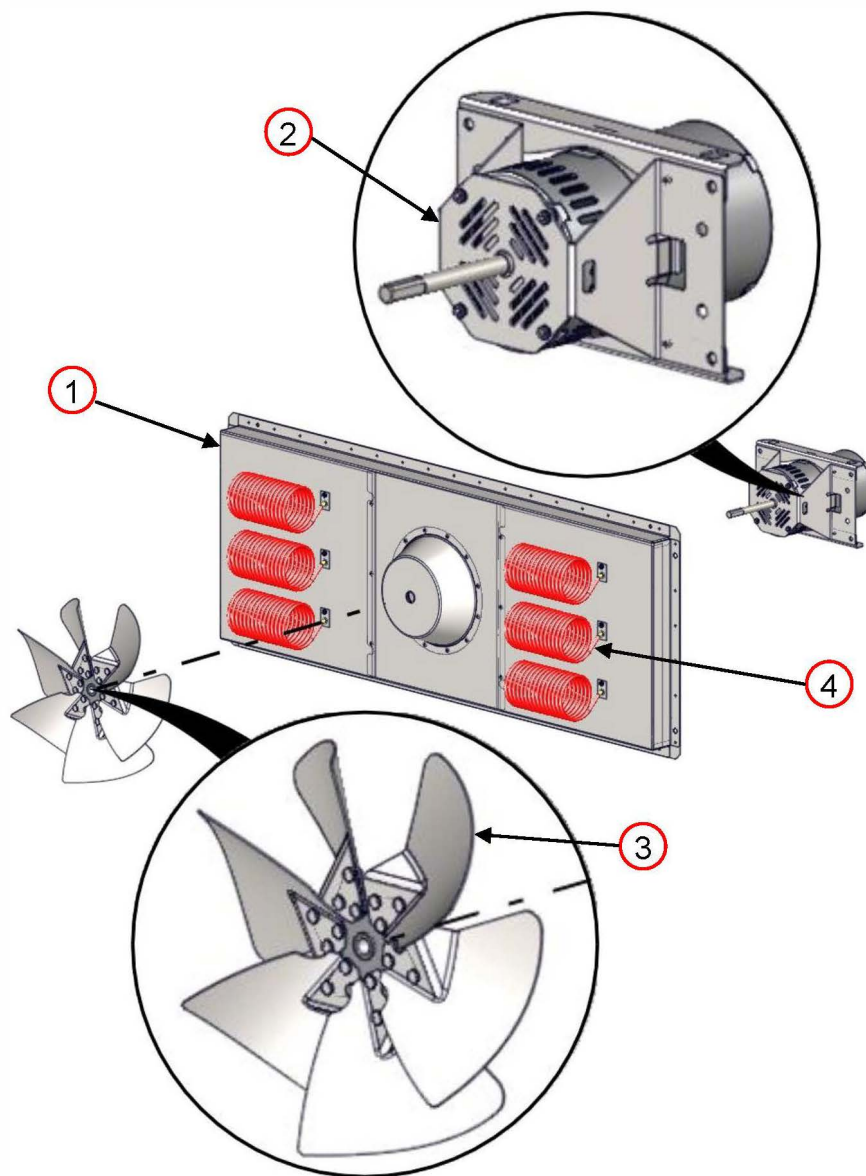
FRONT PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 6500E	Front Panel Assembly	P.O.R
2	XA 6505	Front Panel Knob	\$15.90
3	XA 6600E	Sandwich Door	P.O.R
4	XF 126-2	Screw 10-24 x 1/2	\$0.20
5	XF 129	Screw 10-24 x 3/4	P.O.R
6	XM 6703D	Door Retainer Left	\$8.70
7	XM 6704E	Door Retainer Right	\$8.70
8	XP 6519A	Window Steel Slug	P.O.R



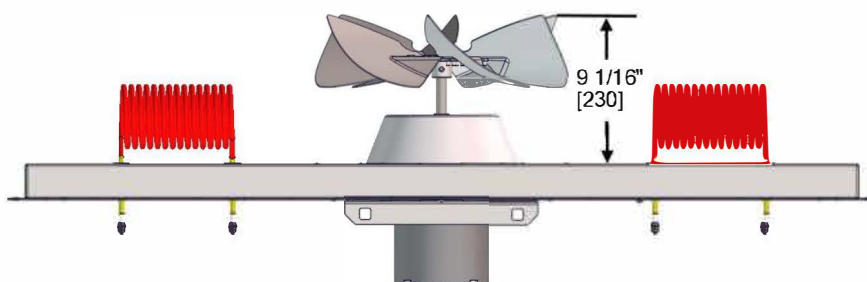
EXTENDED FRONT PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 6700B	Extended Front Panel	P.O.R
2	XA 6504	Front Panel Knob Assy Ext Frt	\$33.09
3	XP 6505	Front Panel Knob	\$14.49

Front Panel information required:

- Size of Oven
- Short or Long Window
- Stainless or Wood Handle
- 3" or 5" Window Opening



Installed Fan Height



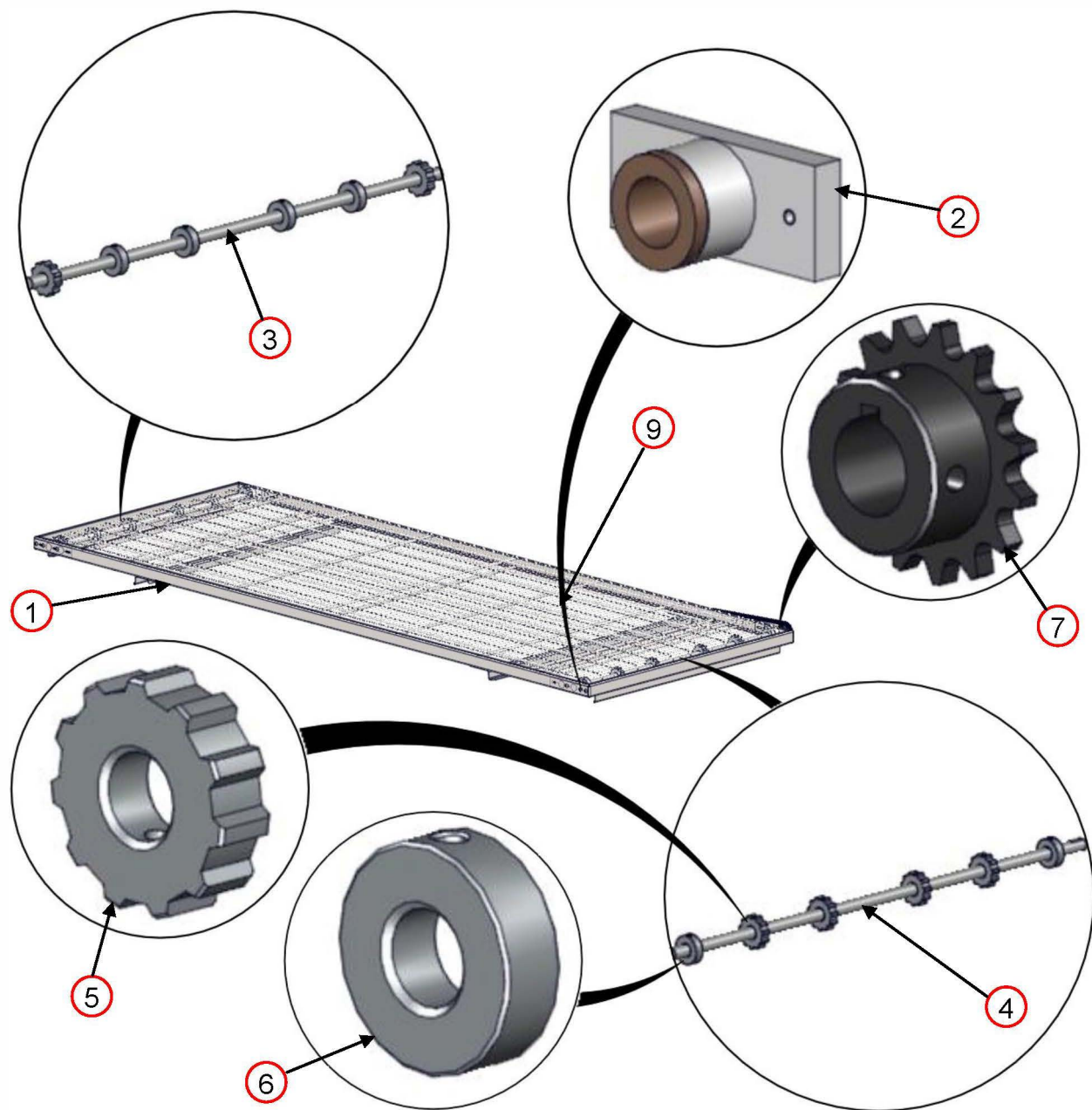
Electric Oven Elements								
Oven Size	208V-4500W	Qty	240V-4500W	Qty	208V-5300W	Qty	240V-5300W	Qty
1832-208 V					x	3		
1832-240 V							x	3
1832-380 V							x	3
2336-208 V					x	3		
2336-240 V							x	3
2336-380 V							x	3
2440-208 V	x	6						
2440-240 V			x	6				
2440-380 V			x	6				
3240-208 V	x	6						
3240-240 V			x	6				
3240-380 V			x	6				
3255-208 V					x	6		
3255-240 V							x	6
3255-380 V							x	6
3855-208 V					x	6		
3855-240 V							x	6
3855-380 V							x	6

BACK WALL - STANDARD			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 5001D	Back Wall Assembly	P.O.R
2	SP 5009B-75	Fan Motor w/ Mount 3/4 HP	\$283.20
3	XA 5200B	Fan Blade	P.O.R
4	XP 5201A/5202A	Heating Element	P.O.R

BACK WALL - WORLD			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 5001D	Back Wall Assembly	P.O.R
2	SP 5009B-75-3PH	Fan Motor w/ Mount 3/4 HP	\$283.20
3	XA 5200B	Fan Blade	P.O.R
4	XP 5201A/5202A	Heating Element	P.O.R

Back Wall information required:

- Size of Oven
- Voltage

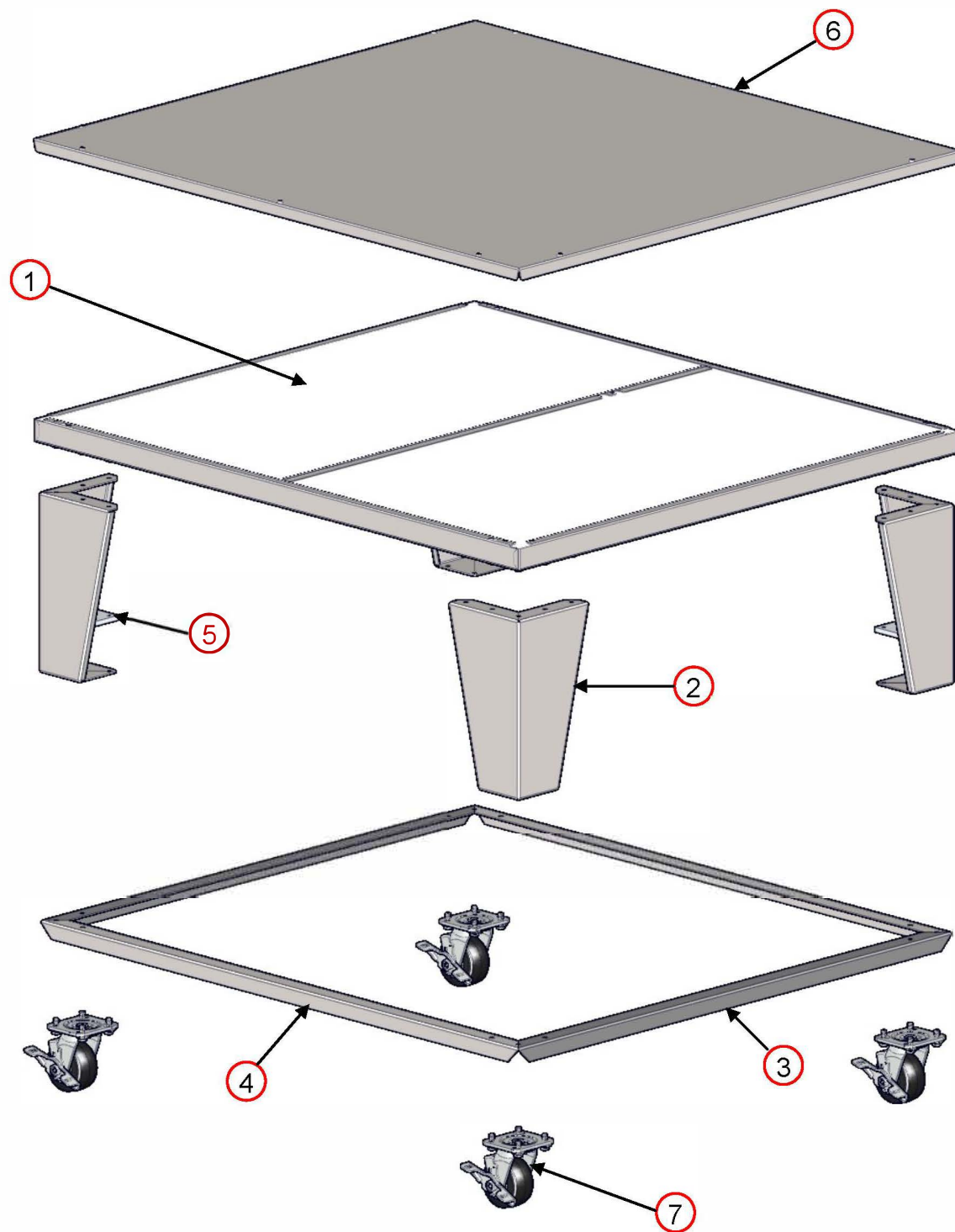


Conveyor Drive Chain not shown

CONVEYOR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 7000D	Conveyor Assembly	P.O.R
2	XA 7200	Conveyor Bearing Assembly	P.O.R
3	XM 7301A	Conveyor Shaft Idle	P.O.R
4	XM 7302A	Conveyor Shaft Drive	P.O.R
5	XP 7403	Conveyor Roll Notched	\$12.20
6	XP 7404	Conveyor Roll Plain	\$11.00
7	XP 9503	Conveyor Sprocket Driven 15	P.O.R
8	XP 9504	Conveyor Drive Chain	P.O.R
9	XP 9506A	Conveyor Belt	P.O.R

Conveyor information required:

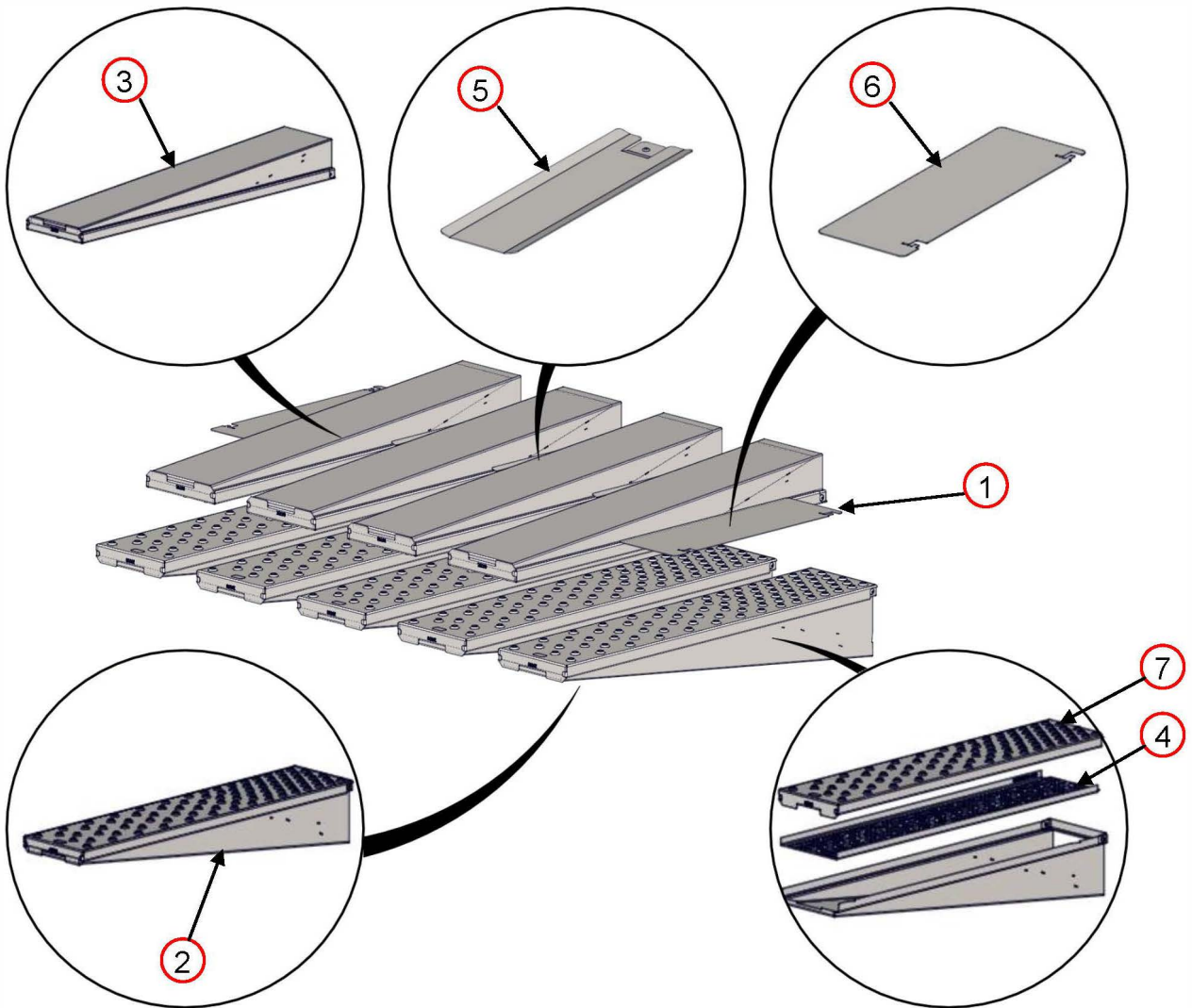
- Oven Size
- Split Belt or Standard Belt



BASE			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 1001A	Base Assembly	P.O.R
2	XM 1003-15	Base Leg	\$65.40
3	XM 1006	Side Leg Angle	P.O.R
4	XM 1007	Front/Back Leg Angle	P.O.R
5	XM 1008	Bolster Plate	\$11.50
6	XM 1010A	Oven Lid	P.O.R
7	XP 1004	Caster	\$21.60

Base information required:

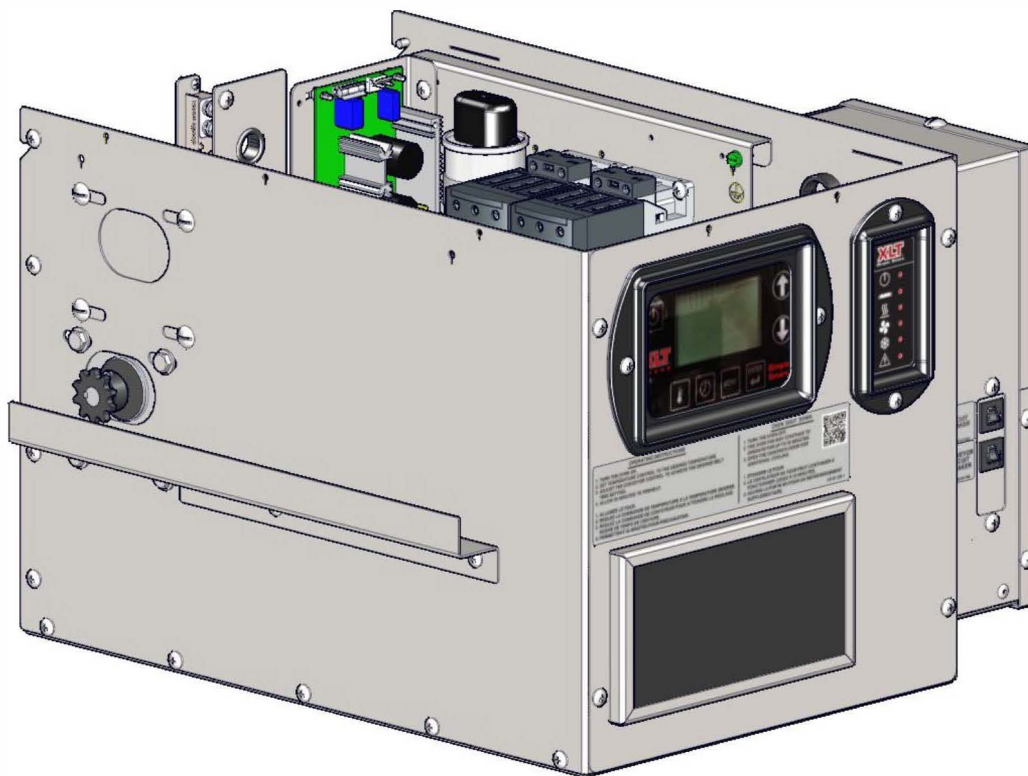
- Size of Oven
- Single, Double, or Triple Stack



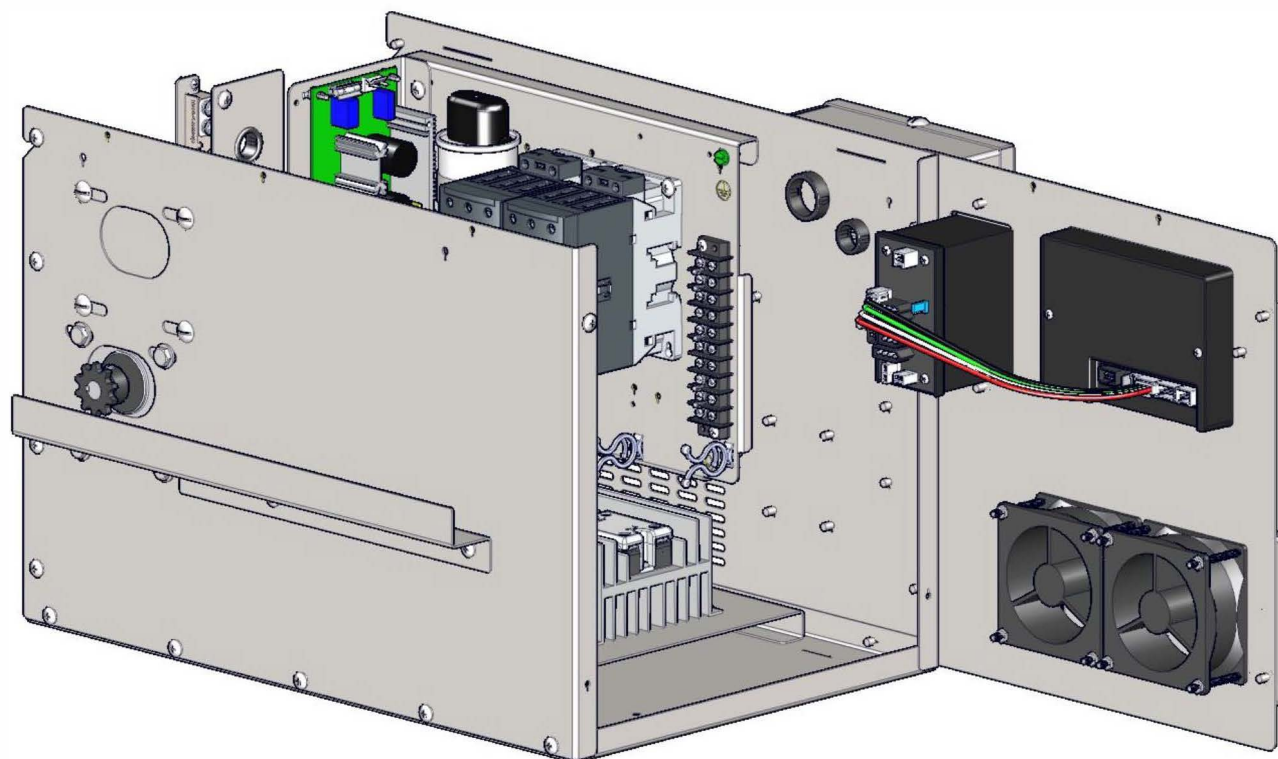
FINGERS			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 8Gxxxx	Finger Group Assembly	P.O.R
2	XA 8001C-B	Finger Body Bottom	P.O.R
3	XA 8001C-T	Finger Body Top	P.O.R
4	XM 8004	Finger Inner Plate Perforated	P.O.R
5	XM 8024B	Return Air Plate	P.O.R
6	XM 8025B	EndLoss Plate	P.O.R
7	XM 8xxxE	Finger Outer Plate	P.O.R

Finger information required:

- Size of Oven
- Customer name
- Part number on front of finger outer



Operating Position (shown with lid removed)



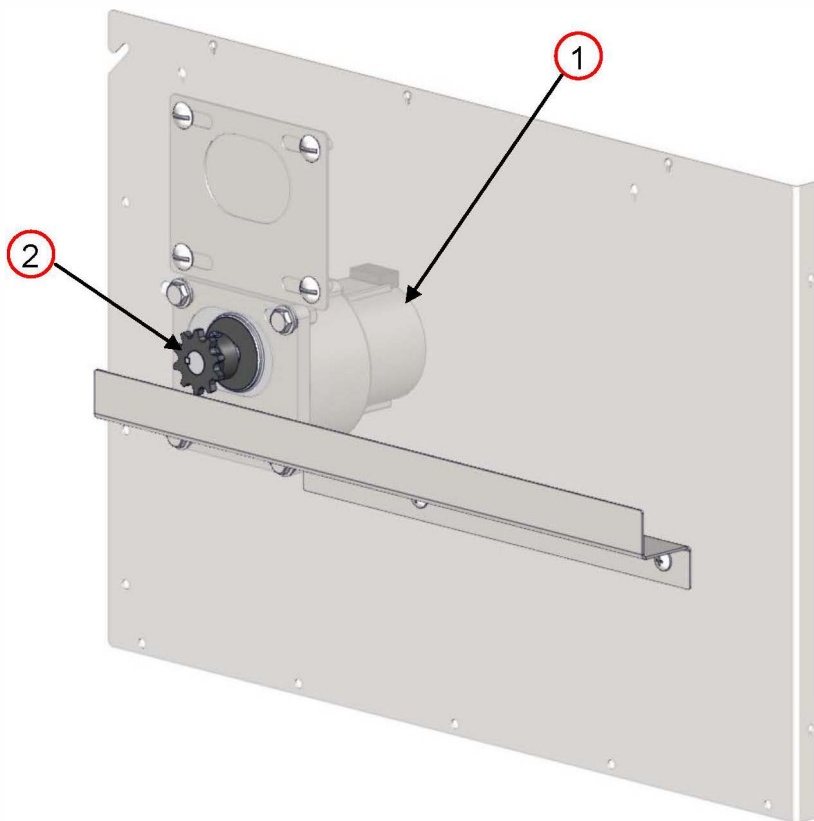
Service Position



CONTROL PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	SP 4520-EL	Fan Guard / Filter Holder	\$9.30
2	XP 4170A-LUI	Large User Interface	\$171.00
3	XP 4175A-MC	Oven Control	\$213.80
4	XP 4501C-EL	FPPG Fan EL M3	P.O.R.
5	XP 4520B-EL	Fan Filter	P.O.R.

Control Panel information required:

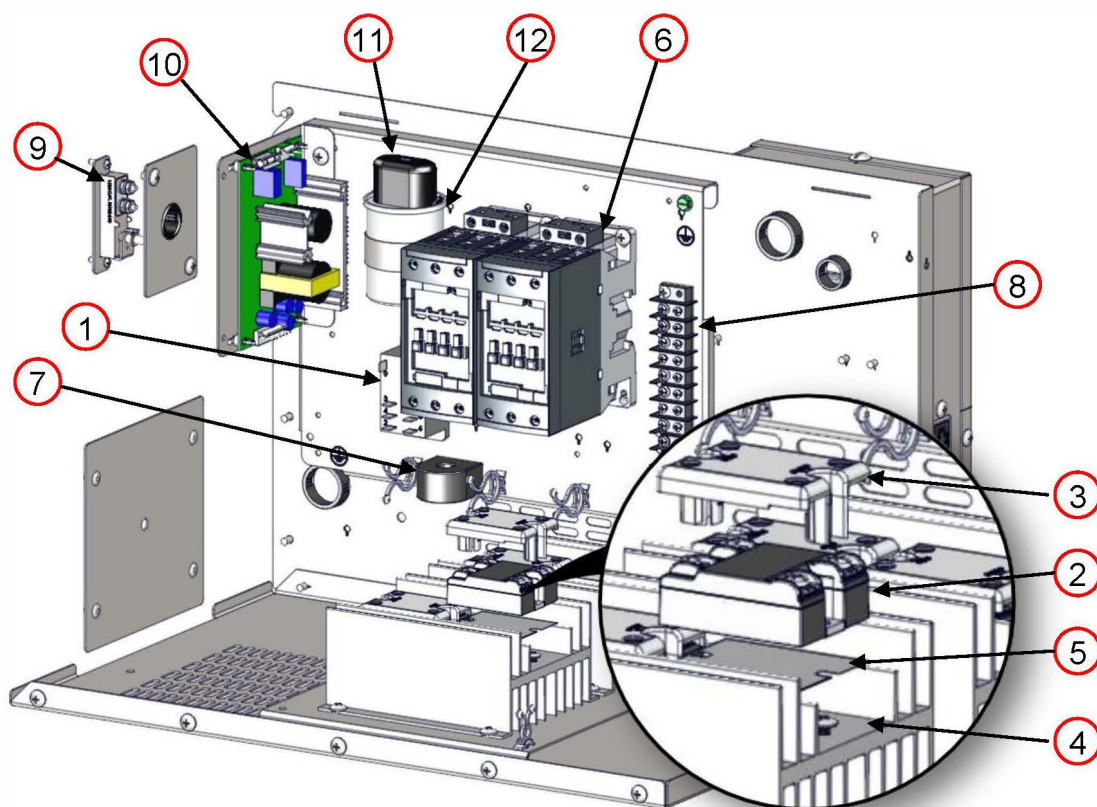
- Size of Oven
- Voltage
- Circuit Breaker amp rating
- Conveyor Belt direction



CONTROL BOX FRONT			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 4117A-12.5 RPM STD	Conv Motor Assy 12.5 RPM STD	\$305.30
2	XP 4155	Sprocket Conveyor Drive 10T	\$15.70

Control Box Front information required:

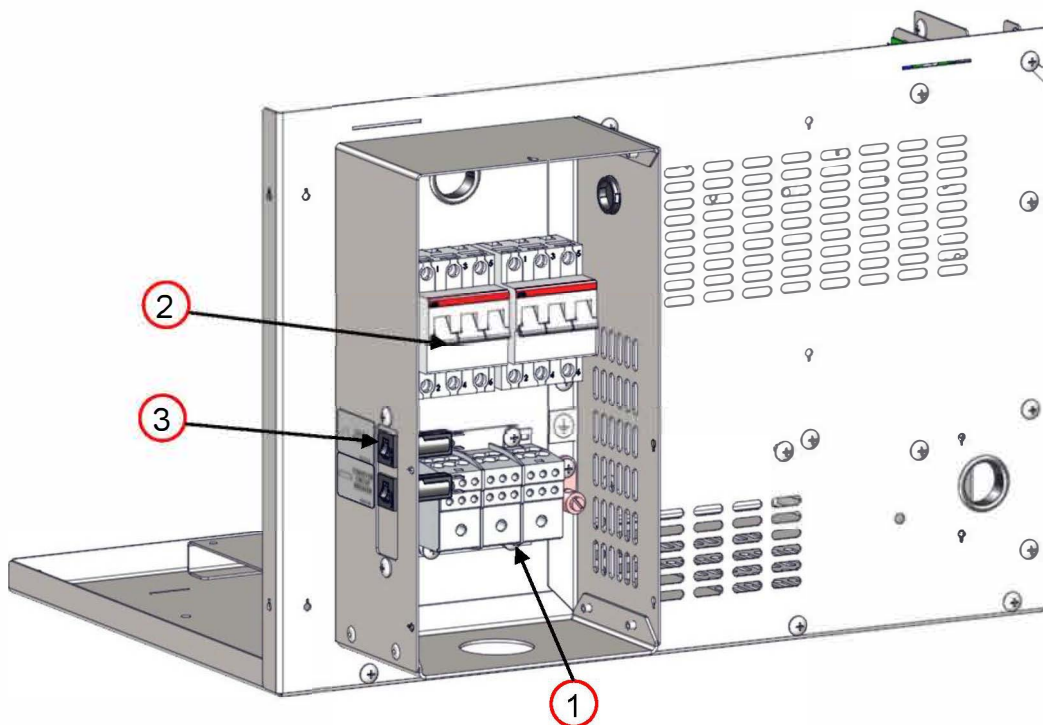
- Size of Oven
- Split Belt or Standard Belt



CONTROL BOX BACK			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	HP 2067A-24VDC	Relay 8 Pin 30A 24VDC	\$19.50
2	XP 4305A-90	Relay 90A Solid State	\$96.90
3	XP 4305A-90-COV	Relay 90A Cover	P.O.R
4	XP 4305A-90-HS	Relay 90A Heat Sink	P.O.R
5	XP 4305A-90-PAD	Relay 90A Thermal Pad	P.O.R
6	XP 4306A-70	70 Amp 3 Phase Contactor	\$124.50
7	XP 4310A	Current Sensor	\$27.80
8	XP 4701A-10	Terminal Strip 10 Place	\$7.00
9	XP 4713A	High Temp Limit Switch S3	\$34.10
10	XP 4716	Power Supply PS	\$32.40
11	XP 5012	Capacitor Boot	\$2.30
12	XP 5014-30	Capacitor Baldor 3/4 HP 30uF	\$18.60

Control Box Back information required:

- Size of Oven
- Voltage

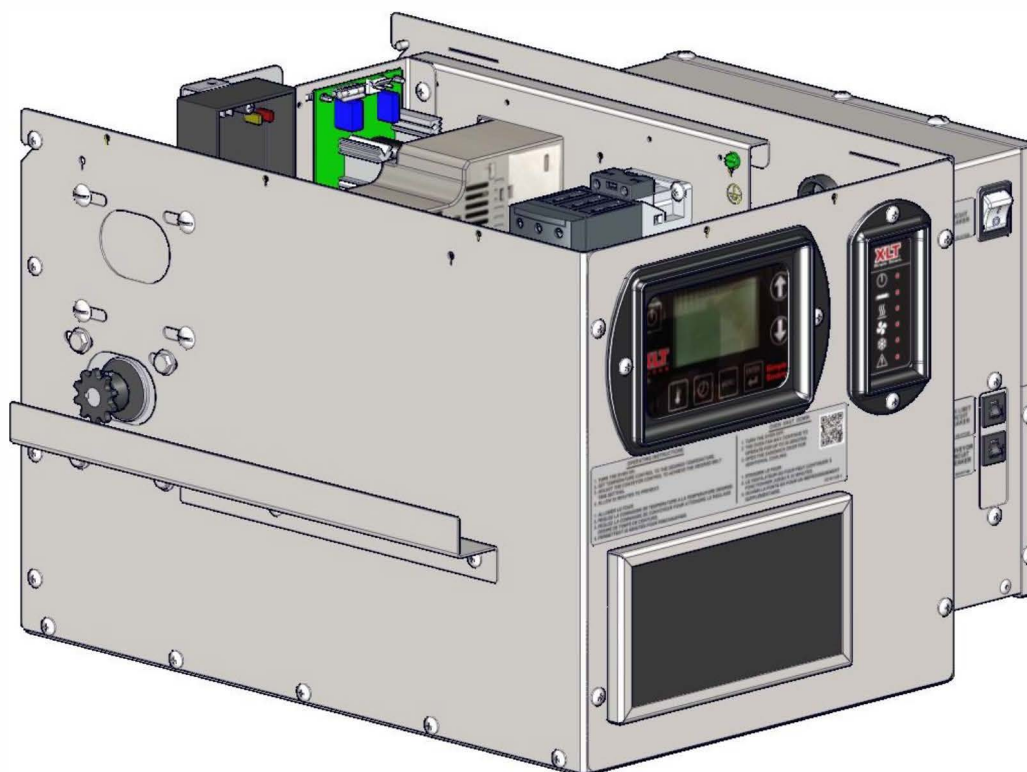


CONTROL BOX REAR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4302B	1 Pole Power Block Electric	\$75.20
2	XP 4303A	3 Pole Circuit Breaker EL	\$83.90
3	XP 4515-CB-0.5A	1/2 Amp Circuit Breaker	P.O.R

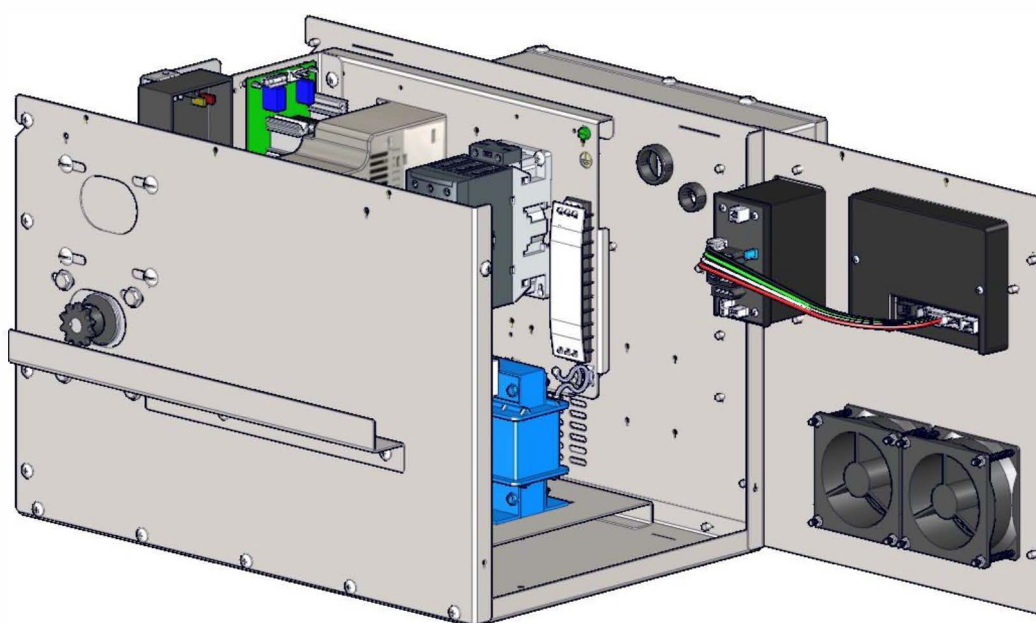
Control Box Rear information required:

- Size of Oven
- Voltage

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Operating Position (shown with lid removed)



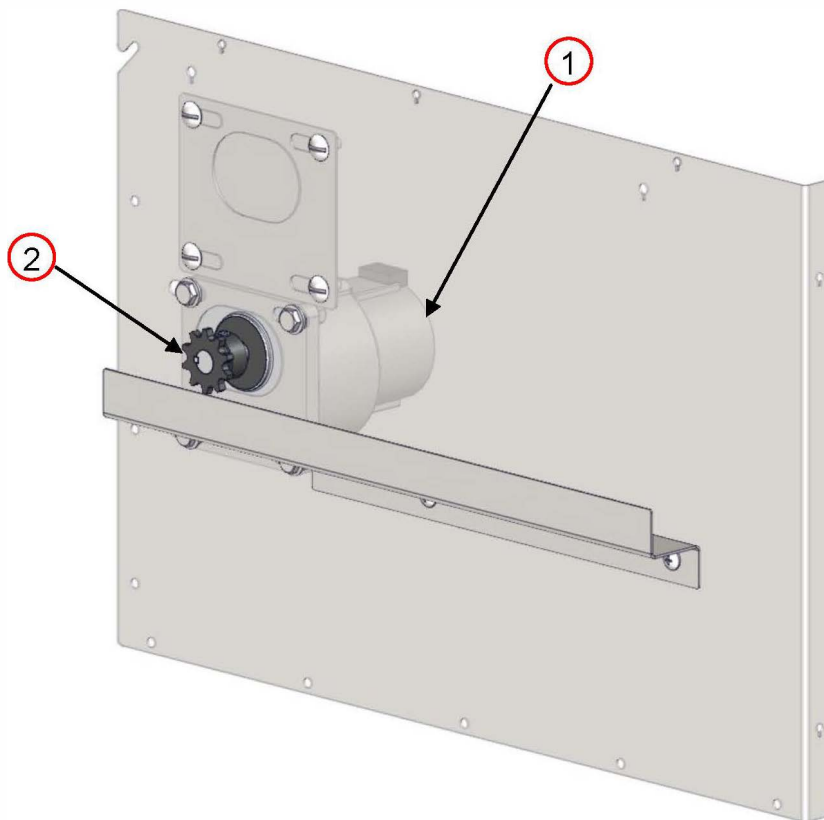
Service Position



CONTROL PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	SP 4520-EL	Fan Guard / Filter Holder	\$9.30
2	XP 4170A-LUI	Large User Interface	\$171.00
3	XP 4175A-MC	Oven Control	\$213.80
4	XP 4501C-EL	FPPG Fan EL M3	P.O.R.
5	XP 4520B-EL	Fan Filter	P.O.R.

Control Panel information required:

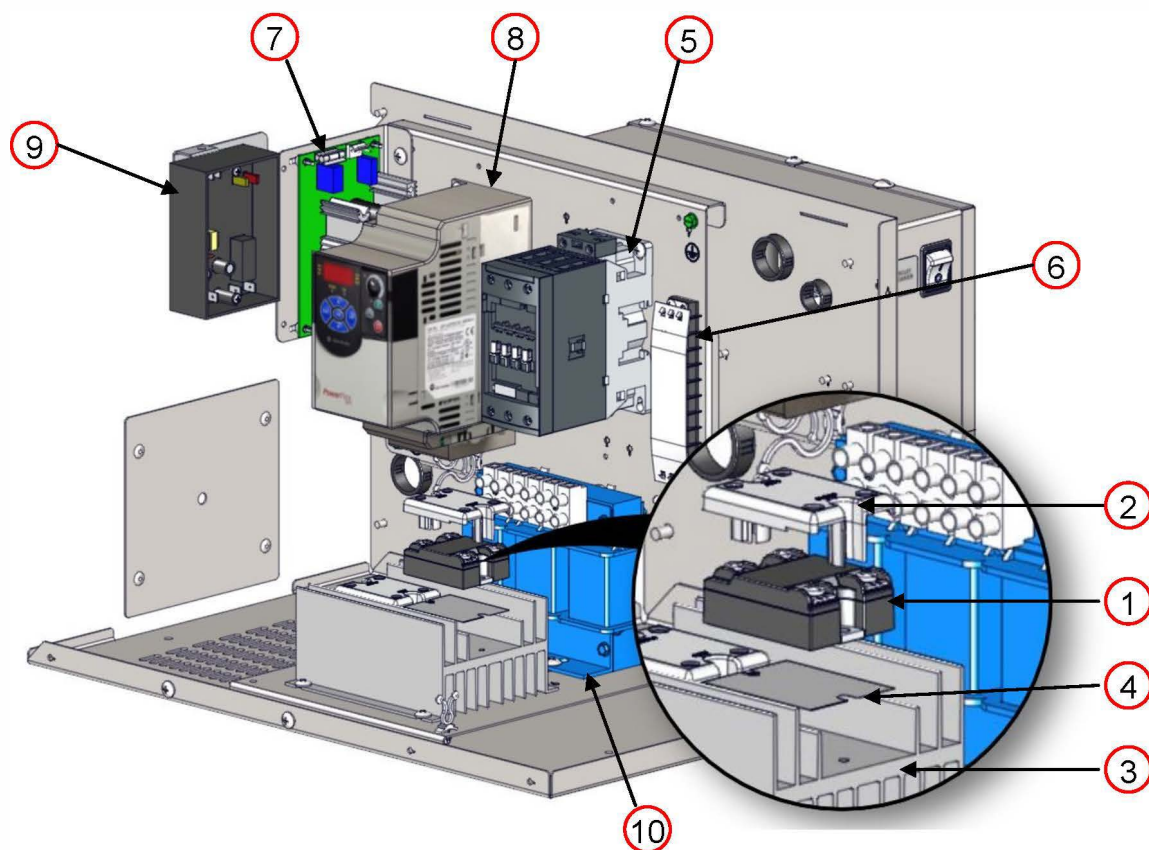
- Size of Oven
- Voltage
- Circuit Breaker amp rating
- Conveyor Belt direction



CONTROL BOX FRONT			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 4117-12.5 RPM STD	Conv Motor Assy 12.5 RPM STD	\$305.30
2	XP 4155	Sprocket Conveyor Drive 10T	\$15.70

Control Box Front information required:

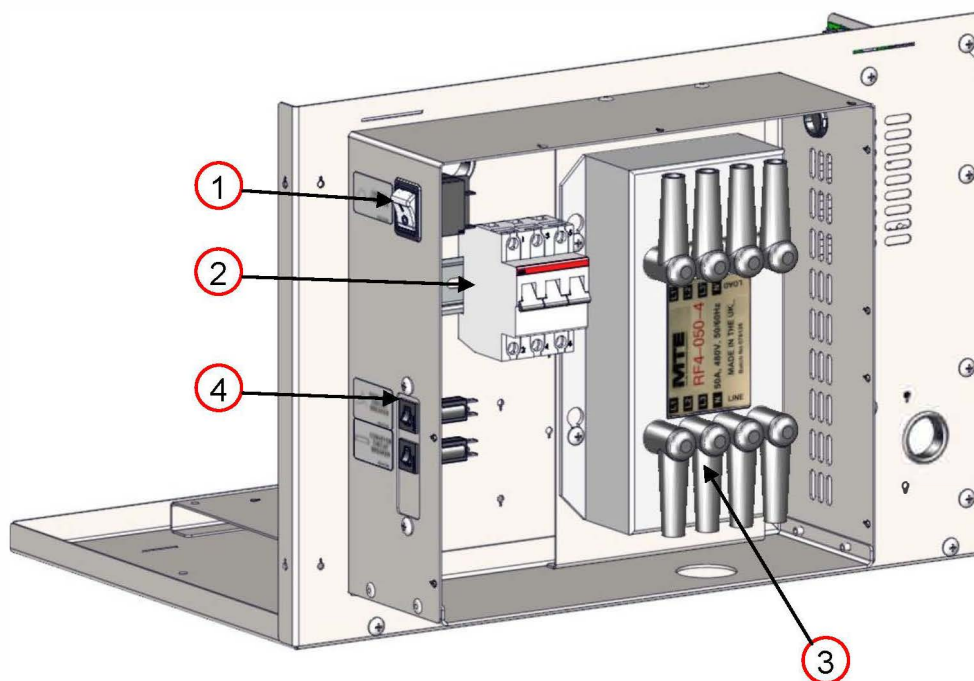
- Size of Oven
- Split Belt or Standard Belt



CONTROL BOX BACK			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4305A-90	Relay 30A Solid State	\$96.90
2	XP 4305A-90-COV	Relay 90A Cover	P.O.R
3	XP 4305A-90-HS	Relay 90A Heat Sink	P.O.R
4	XP 4305A-90-PAD	Relay 90A Thermal Pad	P.O.R
5	XP 4306A-70	70 Amp 3 Phase Contactor	\$124.50
6	XP 4701A-10	Terminal Strip 10 Place	\$7.00
7	XP 4716	Power Supply PS	\$32.40
8	XP 4718A-4.2	VFD Allen Bradley Power Flex 4M	\$185.40
9	XP 4720A-LS	Watlow LS High Temp Cont	\$204.80
10	XP 4722A	3 PH 5% Line Reactor	\$190.80

Control Box Back information required:

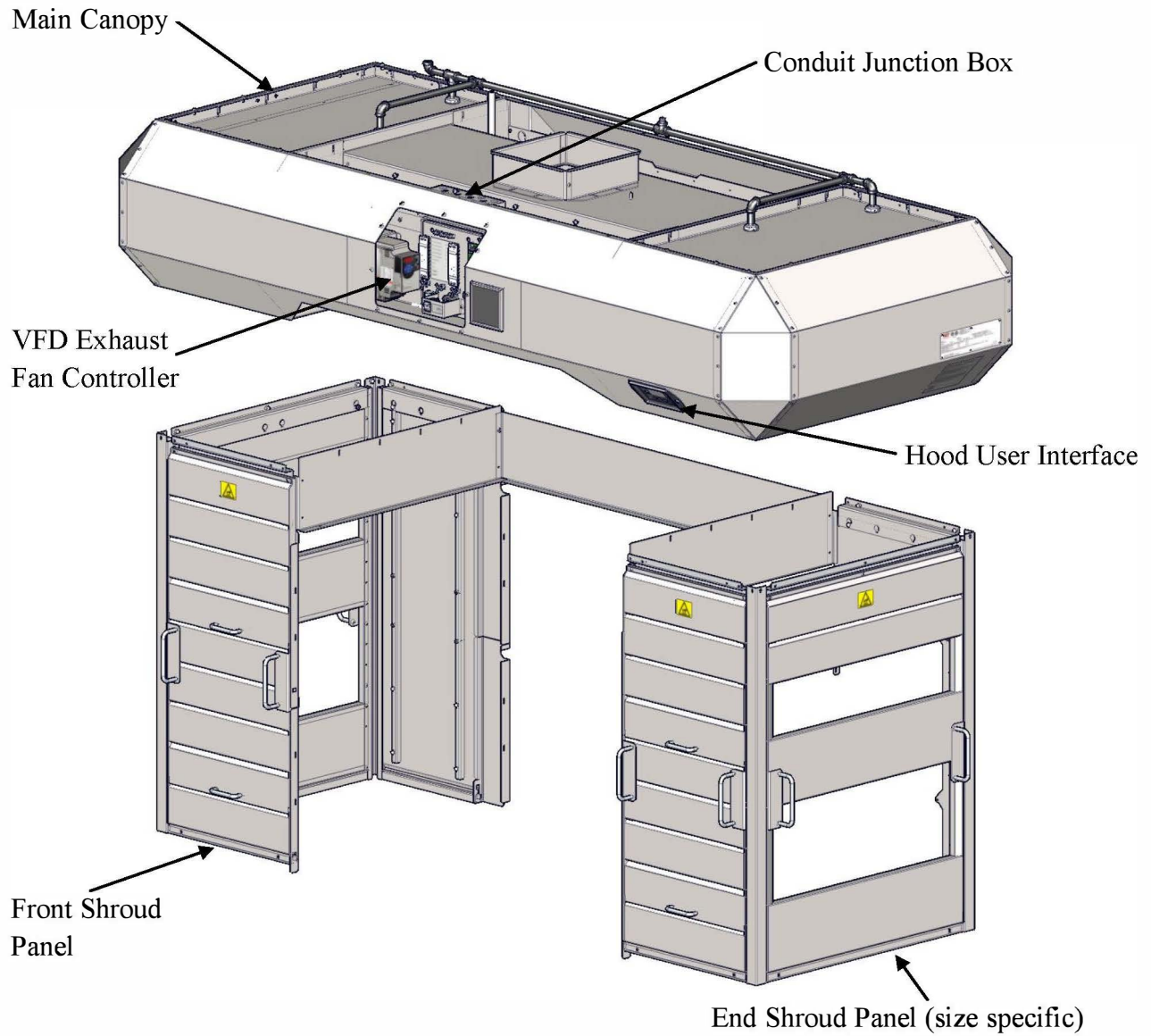
- Size of Oven
- Voltage



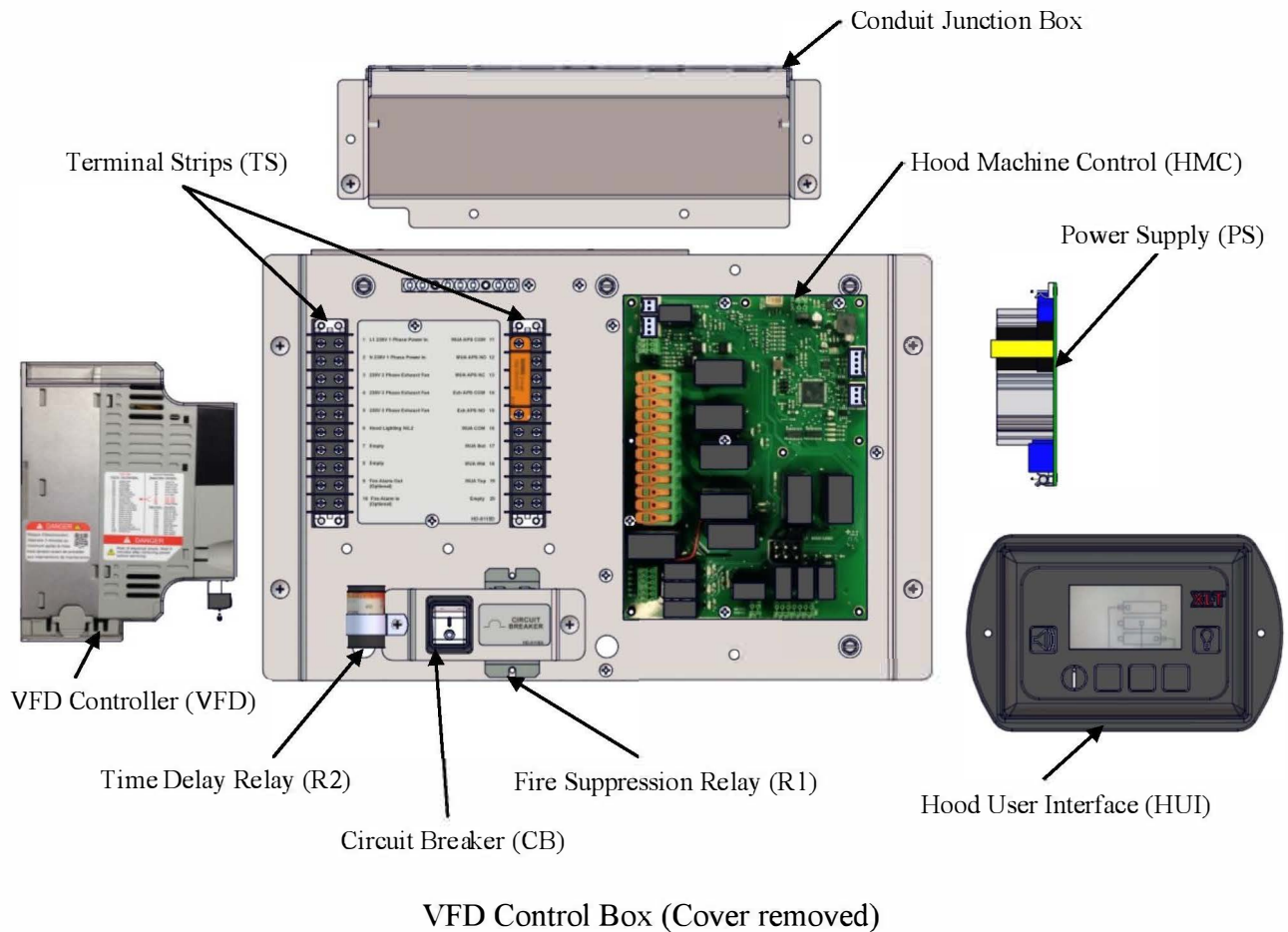
CONTROL BOX REAR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	HP 2060A	Circuit Breaker Exh Fan	\$52.30
2	XP 4303A	3 Pole Circuit Breaker EL	\$83.90
3	XP 4304A	Filter EMI 4 Wire	\$301.00
4	XP 4515-CB-0.5A	1/2 Amp Circuit Breaker	P.O.R

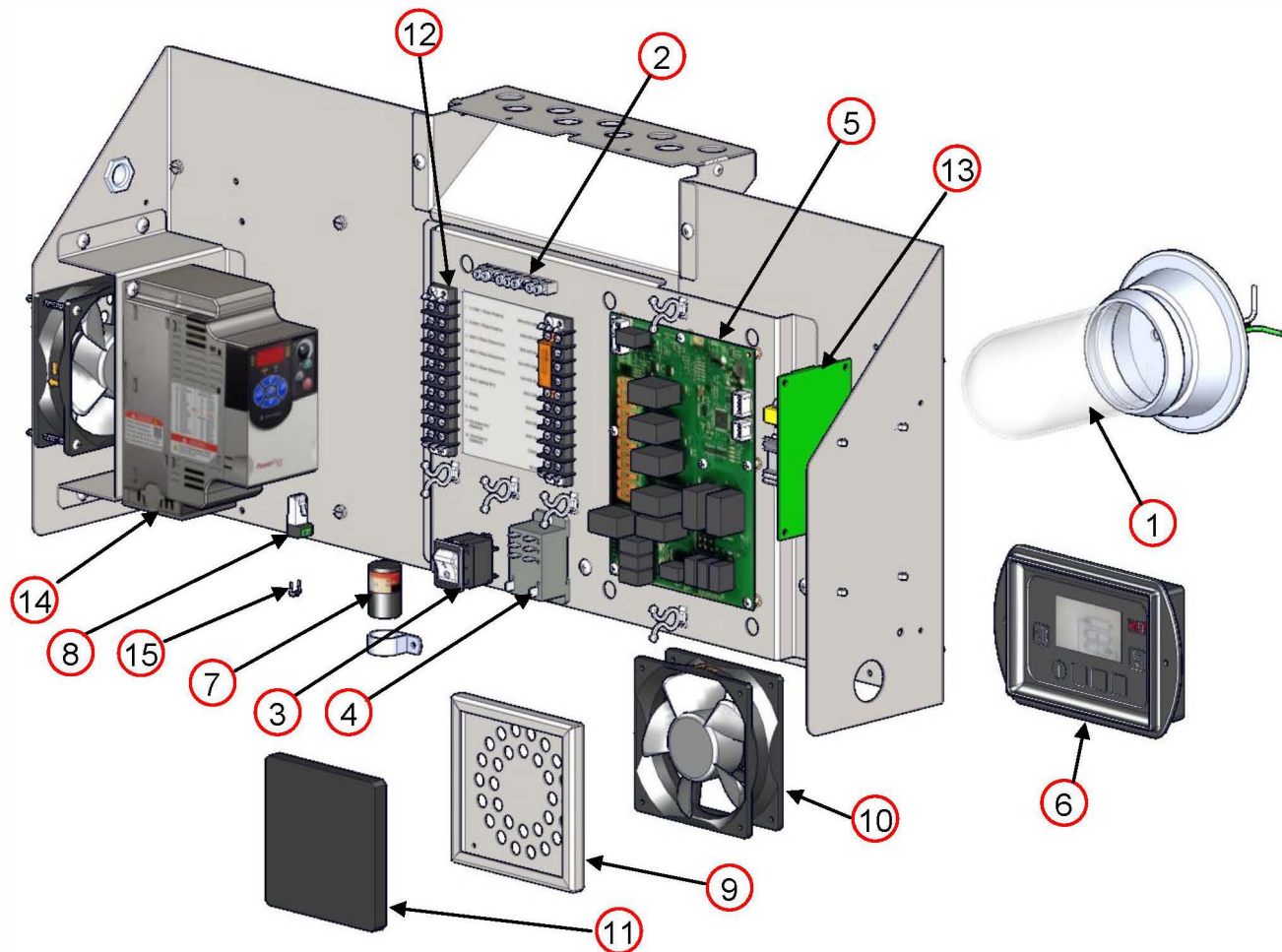
Control Box Rear information required:

- Size of Oven
- Voltage

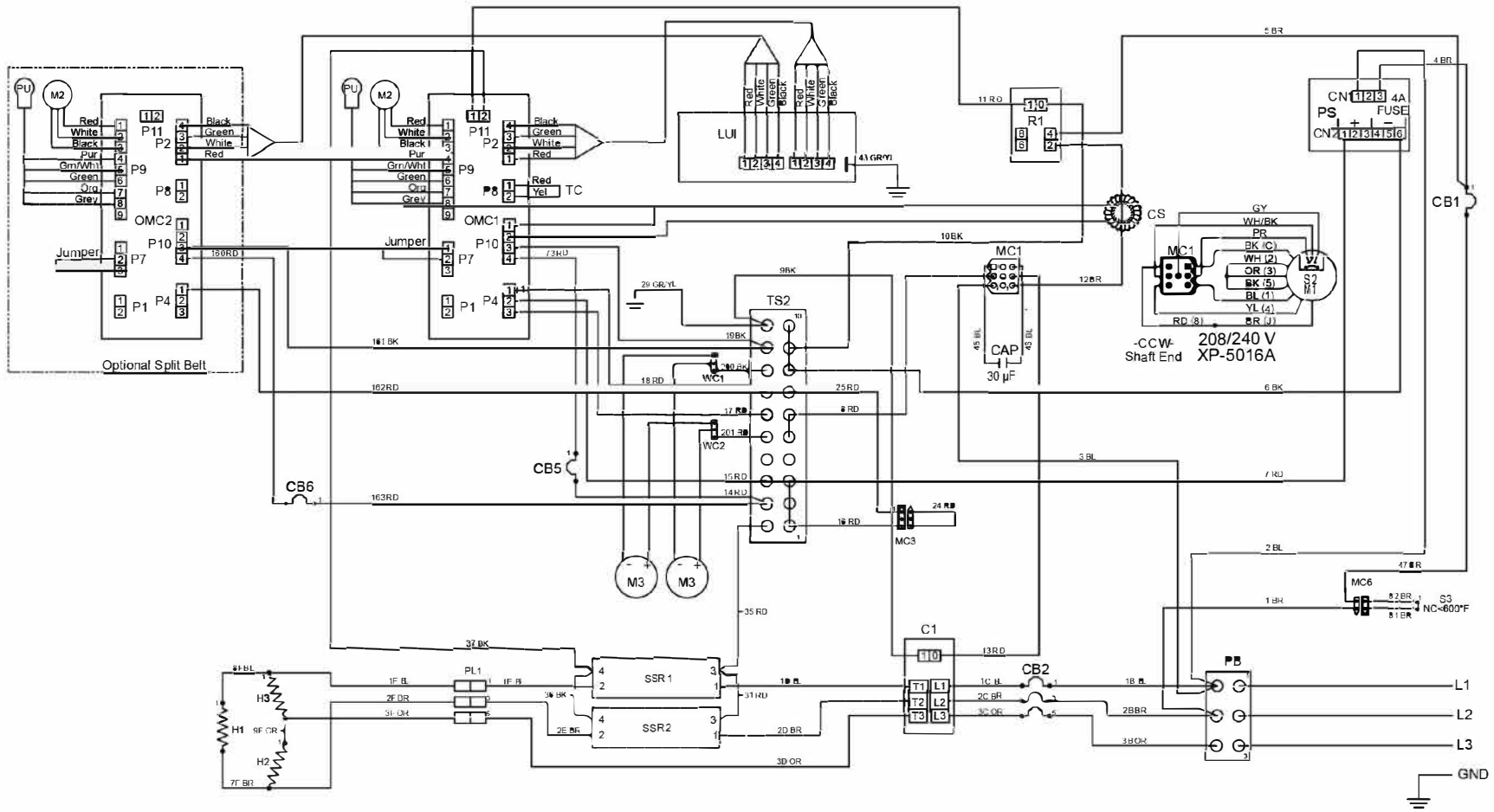


VFD Control Box w/Fire Suppression





VFD W/ FIRE SUPPRESSION			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	HP-1251	Light Assembly	\$57.80
2	HP-2058	Ground Bar 7 POS	\$55.70
3	HP-2060	Circuit Breaker Exhaust Fan	\$52.30
4	HP-2067A-24VDC	Relay 8 Pin 30A 24 VDC	\$19.50
5	HP-2070A-MC	Hood Machine Control	\$372.00
6	HP-2071A-UI	Hood User Interface	\$228.00
7	HP-2072B	Time Delay Relay R2	\$24.00
8	HP-4718A-RJ45	RJ45 Terminal Block	\$62.40
9	SP-4520-GA	Fan Guard / Filter Repl Kit GA	\$9.30
10	XP-4501A-GA	FPPG Fan Gas M2	P.O.R
11	XP-4520-GA	Fan Filter	\$1.95
12	XP-4701A-10	Terminal Strip 10 Place	\$7.00
13	XP-4716	Power Supply	\$32.40
14	XP-4718A-4.2	VFD Allen Bradley Power Flex 4M	\$185.40
15	XW-2900	120 Ohm Terminating Resistor	\$0.20



C1 Contactor, 70 Amp
 CAP Capacitor 30μF
 CB1 Circuit Breaker, 10 Amp, Main
 CB2 Circuit Breaker, 63 Amp, Heating Elements
 CB5 Circuit Breaker, 1/2 Amp, Conveyor Motor
 CB6 Circuit Breaker, 1/2 Amp, Conveyor Motor
 CS Current Sensor
 H1-H3 Heating Element, 208 or 240 VAC, 5300 W
 LUI Large User Interface

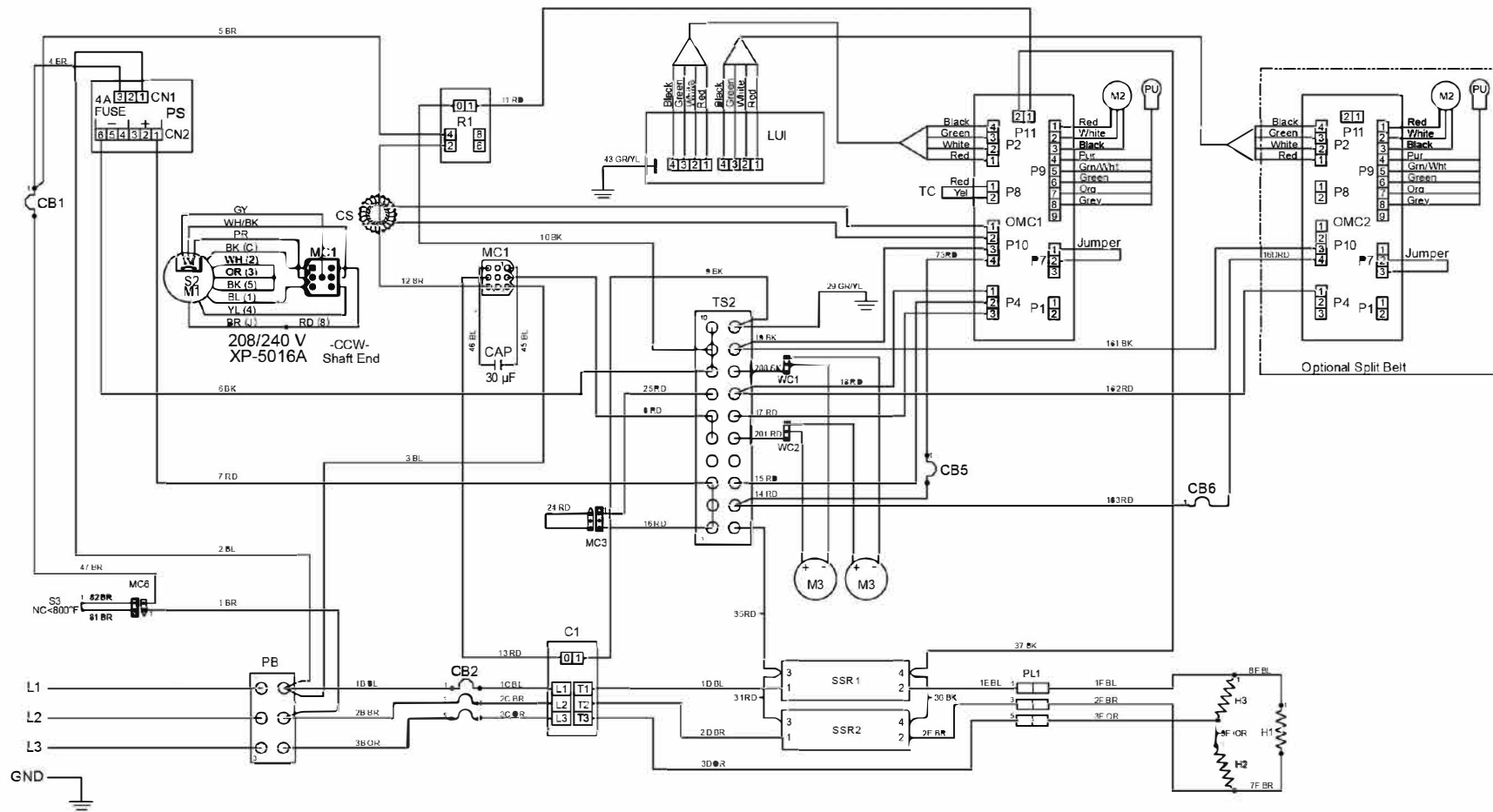
M1 Motor, Oven Fan
 M2 Motor, Conveyor
 M3 Motor, Cooling Fan
 OMC1 Oven Control, Main
 OMC2 Oven Control, Split Belt
 PB Power Block
 PL1 Push Lock, 1-3 Elements
 PS Power Supply
 PU Pick-Up

R1 Oven Fan Motor Relay
 S2 Switch, Centrifugal
 S3 Switch, High Limit
 SSR1 Solid State Relay, 90 Amp
 SSR2 Solid State Relay, 90 Amp
 TC Thermocouple
 TS2 Terminal Strip
 WC1 Wago Connector
 WC2 Wago Connector

RD-Red BK-Black BL-Blue BR-Brown GR/YL-Green Yellow OR-Orange WH-White GY-Gray

X3G-1832
 X3G-2336

208/240 VAC 3 PH 60 Hz
 XD-9130G-208/240-5300-3 LH
 LH Controls Left Side
 10/16/2017



- | | | | | | | | |
|--------|---|---------|--------------------------|--------------------|---------------------------|----------|---------|
| C1 | Contactor, 70 Amp | M1 | Motor, Oven Fan | R1 | Oven Fan Motor Relay | | |
| CAP | Capacitor 30µF | M2 | Motor, Conveyor | S2 | Switch, Centrifugal | | |
| CB1 | Circuit Breaker, 10 Amp, Main | M3 | Motor, Cooling Fan | S3 | Switch, High Limit | | |
| CB2 | Circuit Breaker, 63 Amp, Heating Elements | OMC1 | Oven Control, Main | SSR1 | Solid State Relay, 90 Amp | | |
| CB5 | Circuit Breaker, 1/2 Amp, Conveyor Motor | OMC2 | Oven Control, Split Belt | SSR2 | Solid State Relay, 90 Amp | | |
| CB6 | Circuit Breaker, 1/2 Amp, Conveyor Motor | PB | Power Block | TC | Thermocouple | | |
| CS | Current Sensor | PL1 | Push Lock, 1-3 Elements | TS2 | Terminal Strip | | |
| H1-H3 | Heating Element, 208 or 240 VAC, 5300 W | PS | Power Supply | WC1 | Wago Connector | | |
| LUI | Large User Interface | PU | Pick-Up | WC2 | Wago Connector | | |
| RD-Red | BK-Black | BL-Blue | BR-Brown | GR/YL-Green Yellow | OR-Orange | WH-White | GY-Gray |

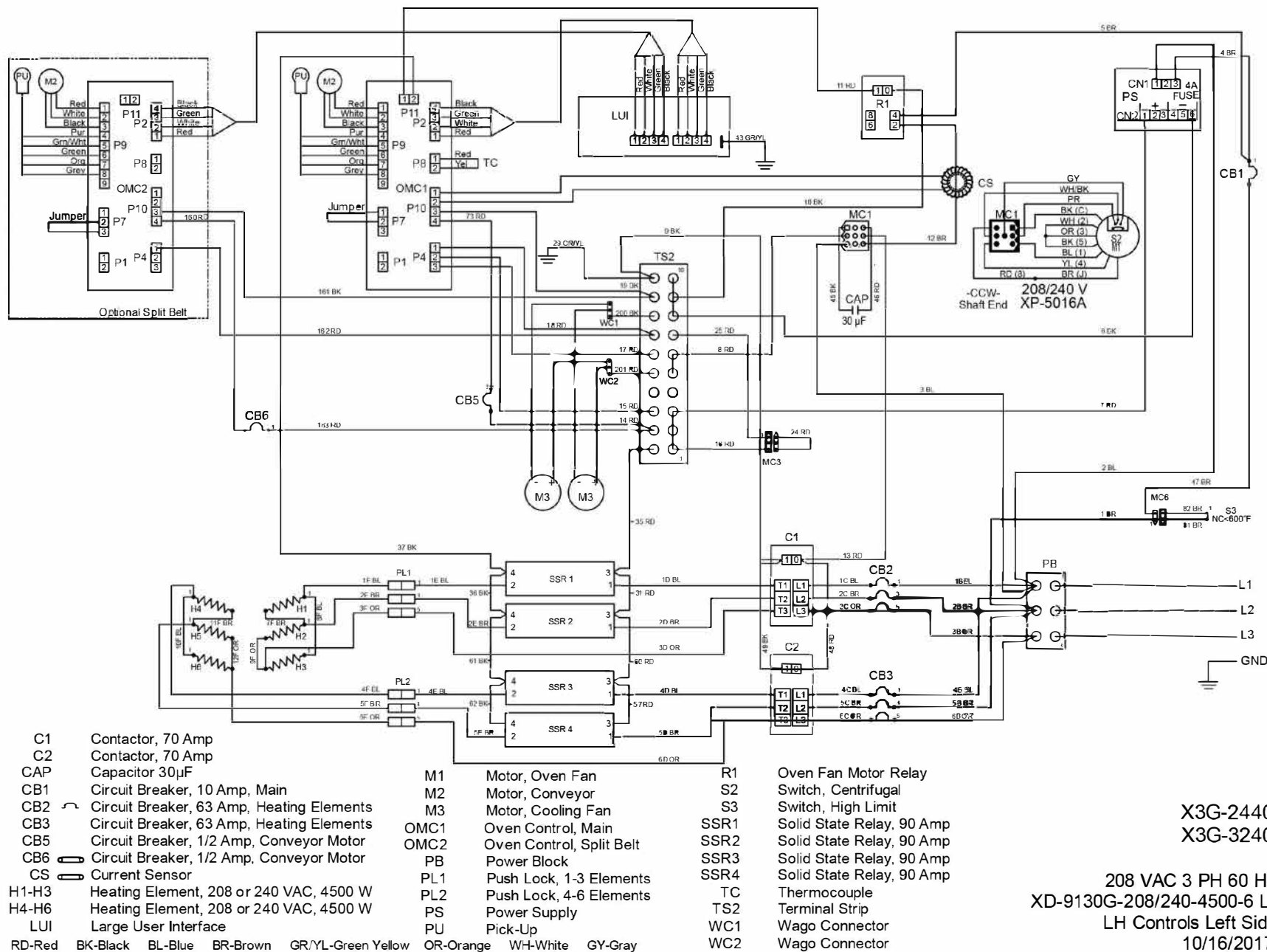
X3G-1832

X3G-2336

208/240 VAC 3 PH 60 Hz
XD-9130G-208/240-5300-3 RH

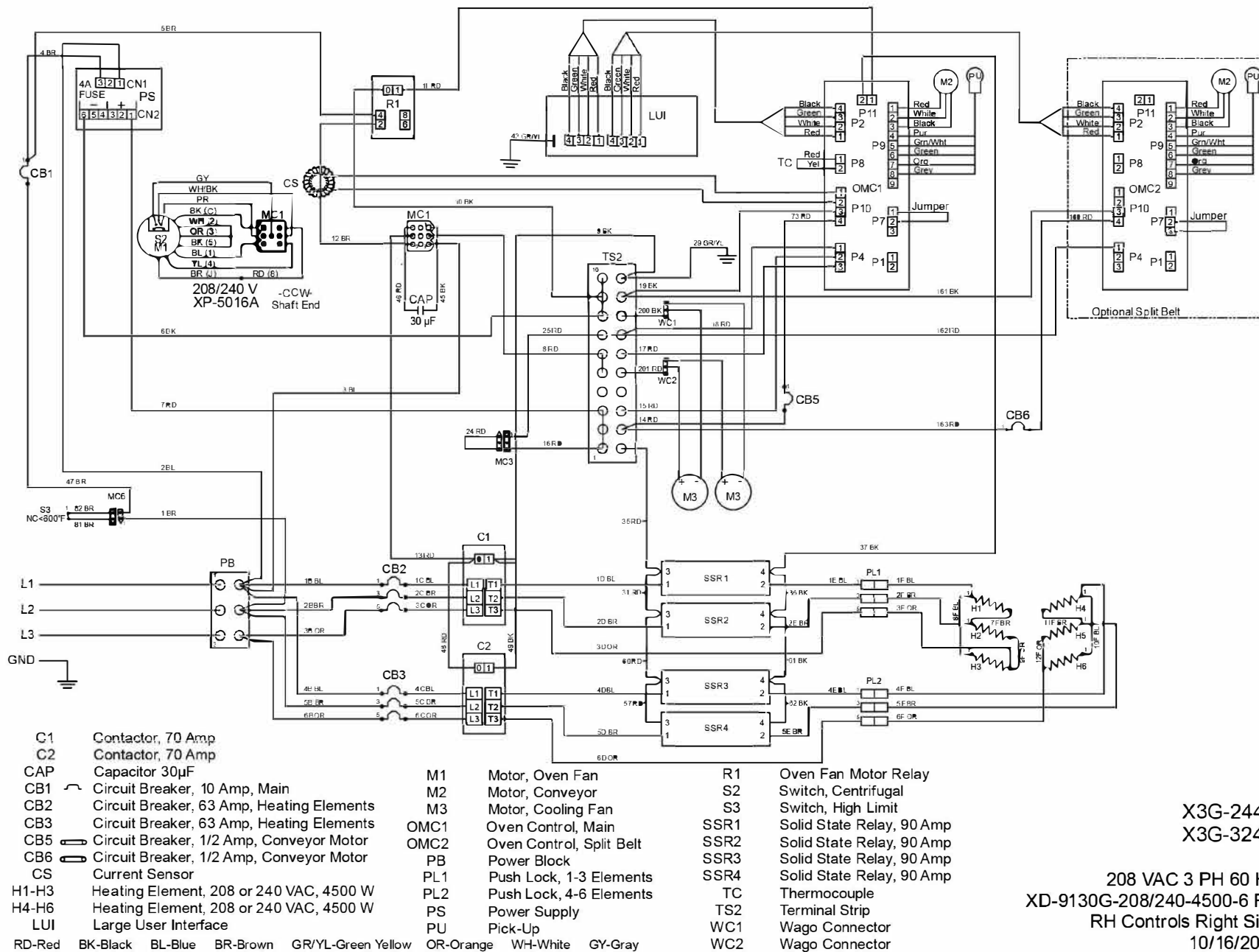
RH Controls Right Side

10/16/2017



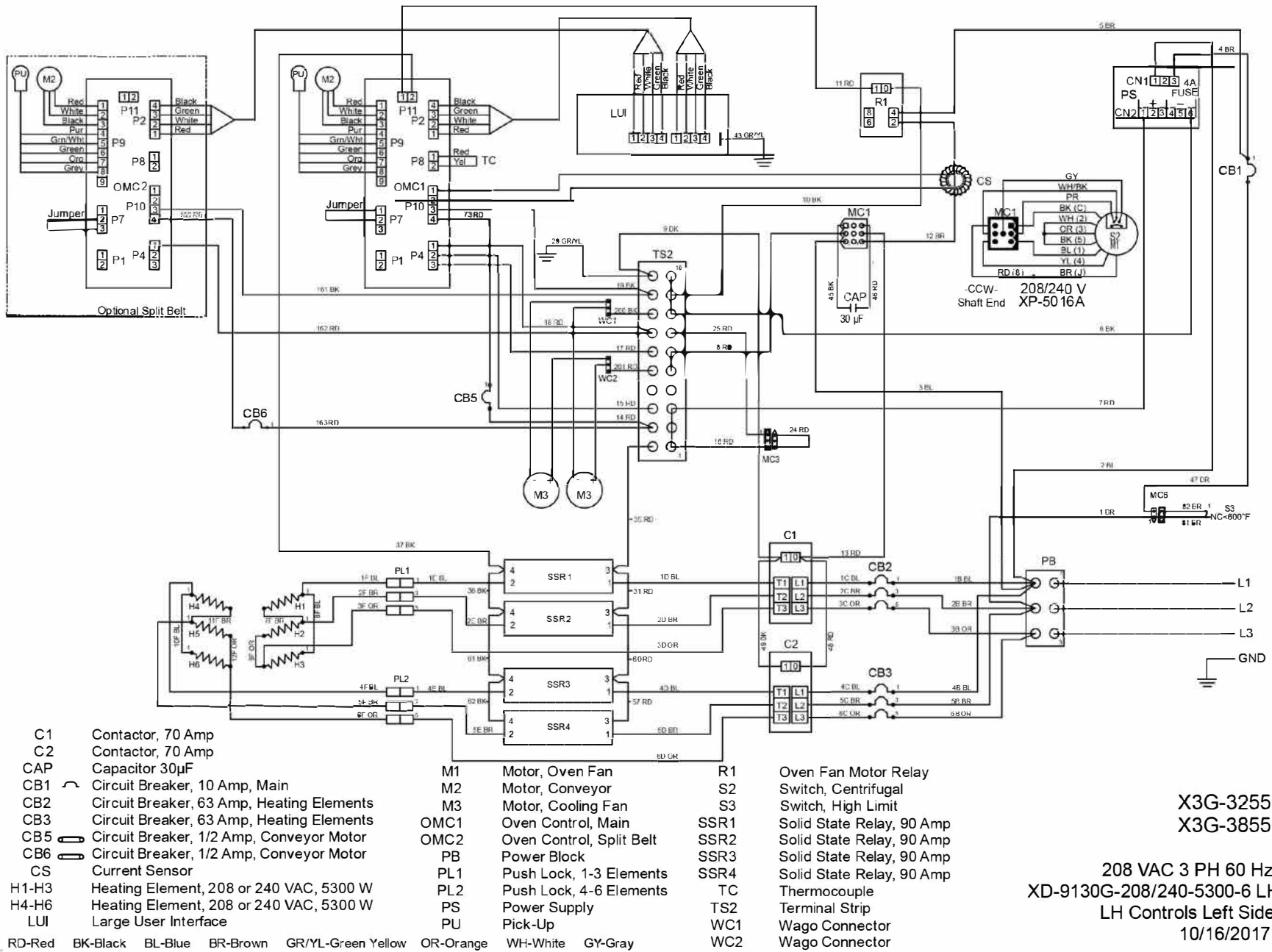
X3G-2440
X3G-3240

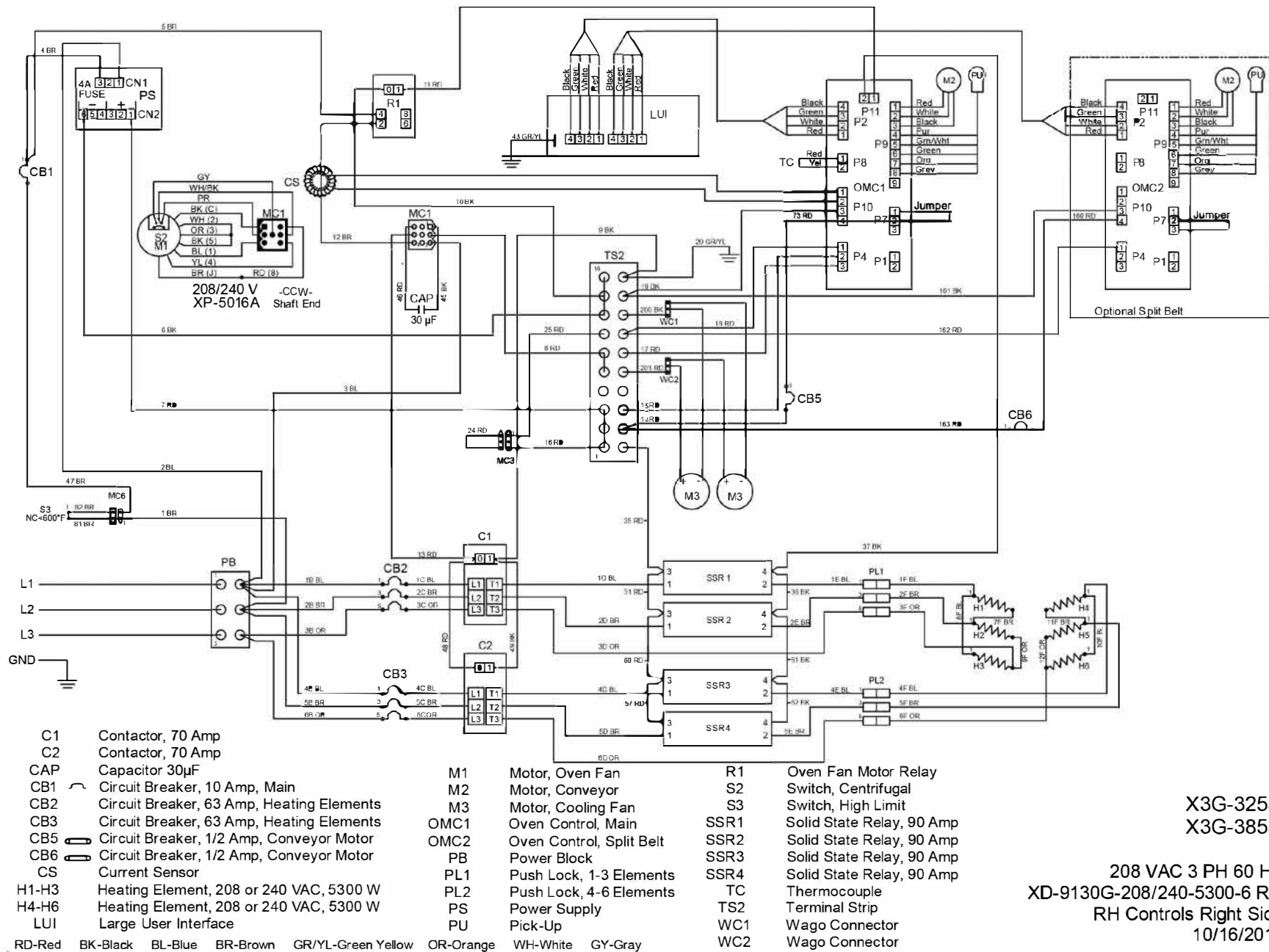
208 VAC 3 PH 60 Hz
XD-9130G-208/240-4500-6 LH
LH Controls Left Side
10/16/2017



X3G-2440
X3G-3240

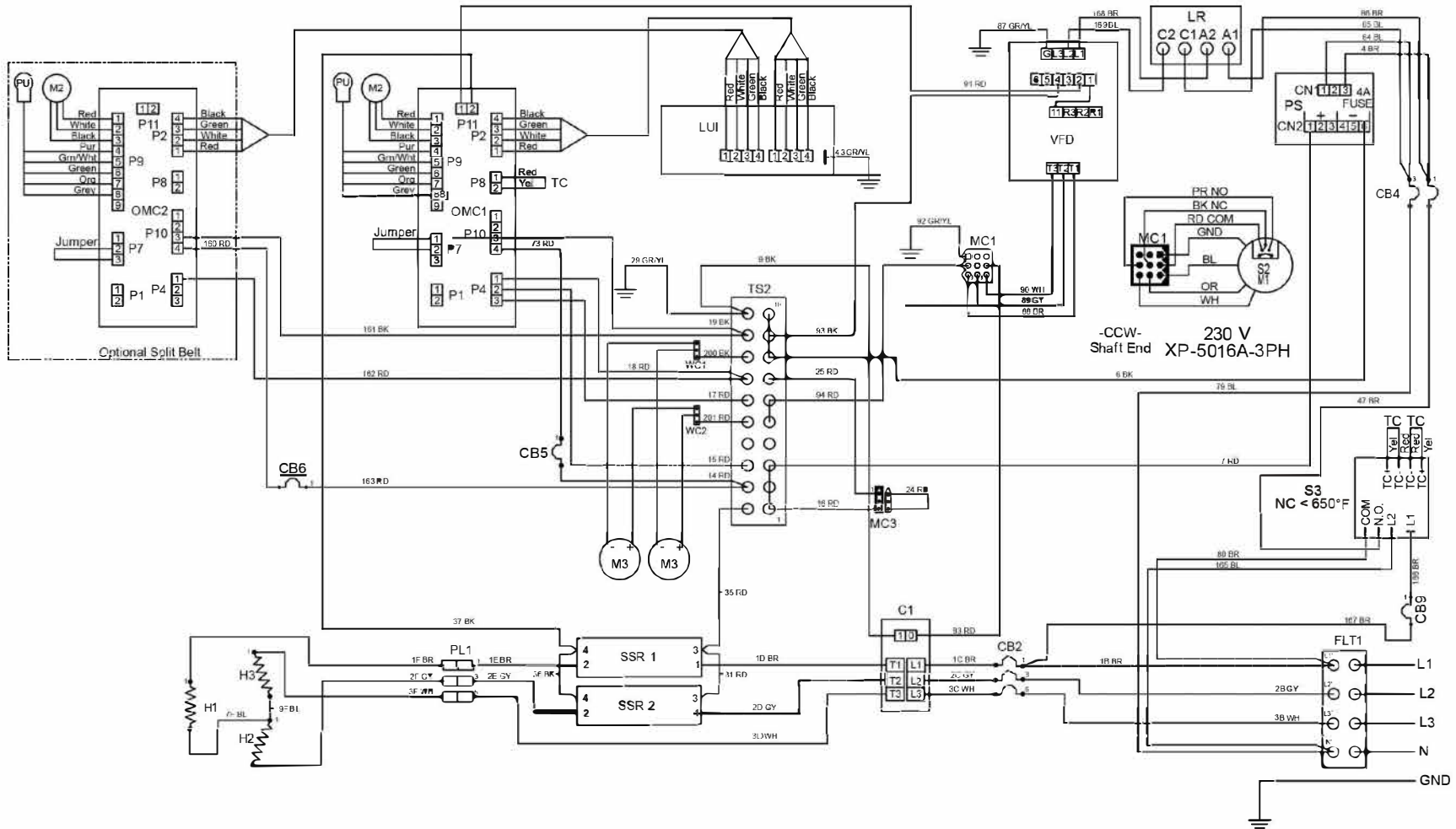
208 VAC 3 PH 60 Hz
XD-9130G-208/240-4500-6 RH
RH Controls Right Side
10/16/2017





X3G-3255
X3G-3855

208 VAC 3 PH 60 Hz
XD-9130G-208/240-5300-6 RH
RH Controls Right Side
10/16/2017

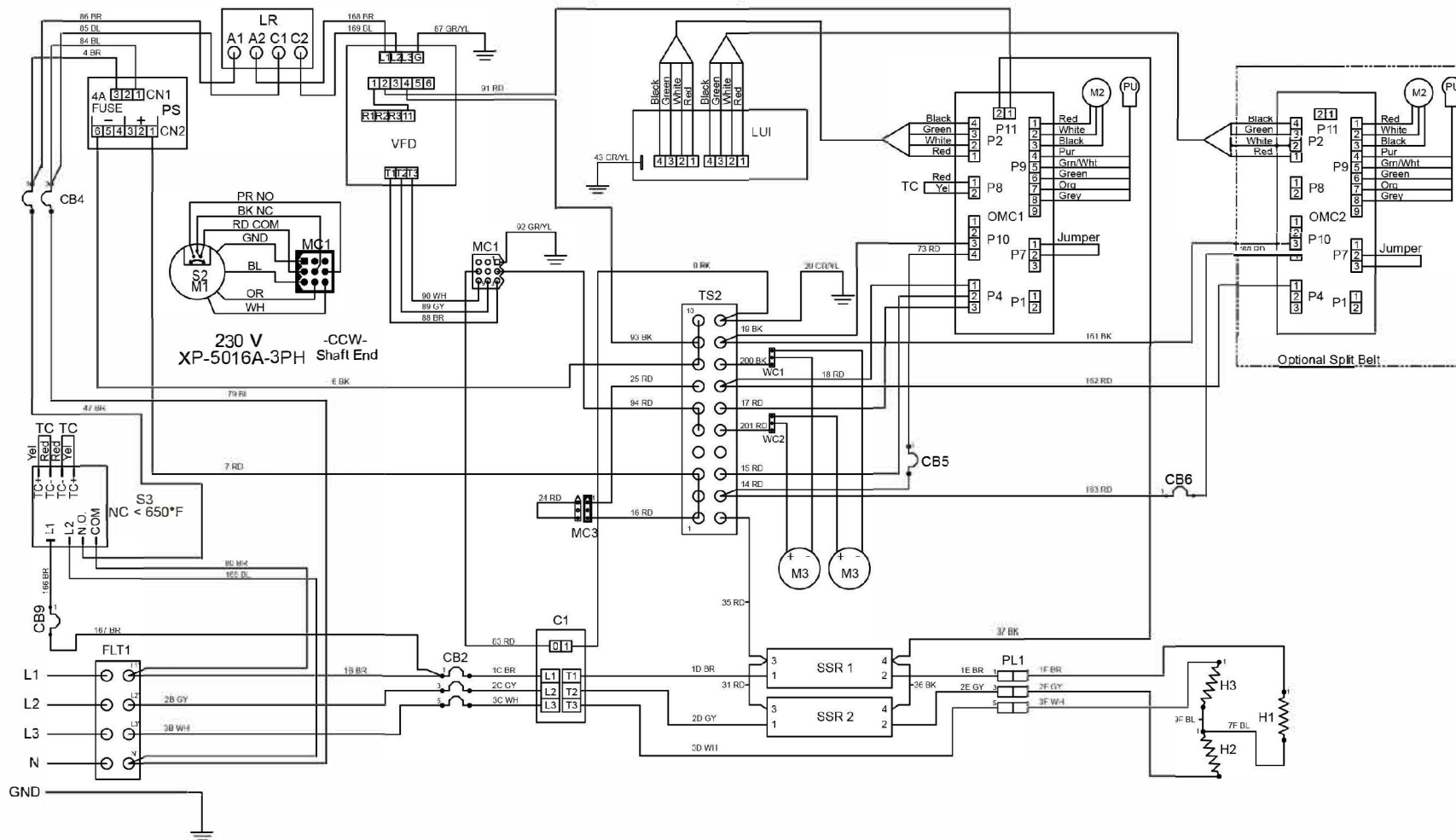


C1	Contactor, 70 Amp	LR	Line Reactor, 5% Impedance	S2	Switch, Centrifugal
CB2	Circuit Breaker, 63 Amp, Heating Elements	M1	Motor, Oven Fan	S3	Switch, High Limit
CB4	Circuit Breaker, 10 Amp, Main	M2	Motor, Conveyor	SSR1	Solid State Relay, 90 Amp
CB5	Circuit Breaker, 1/2 Amp, Conveyor Motor	M3	Motor, Cooling Fan	SSR2	Solid State Relay, 90 Amp
CB6	Circuit Breaker, 1/2 Amp, Conveyor Motor	OMC1	Oven Control, Main	TC	Thermocouple
CB9	Circuit Breaker, 1/2 Amp, High Limit	OMC2	Oven Control, Split Belt	TS2	Terminal Strip
FLT1	Filter, Control Voltage	PL1	Push Lock, 1-3 Elements	VFD	Variable Frequency Drive
H1-H3	Heating Element, 240 VAC, 5300 W	PS	Power Supply	WC1	Wago Connector
LUI	Large User Interface	PU	Pick-Up	WC2	Wago Connector

X3G-1832

X3G-2336

380 VAC 3 PH 50 Hz
 XD-9130G-380-5300-3 LH
 LH Controls Left Side
 10/16/2017

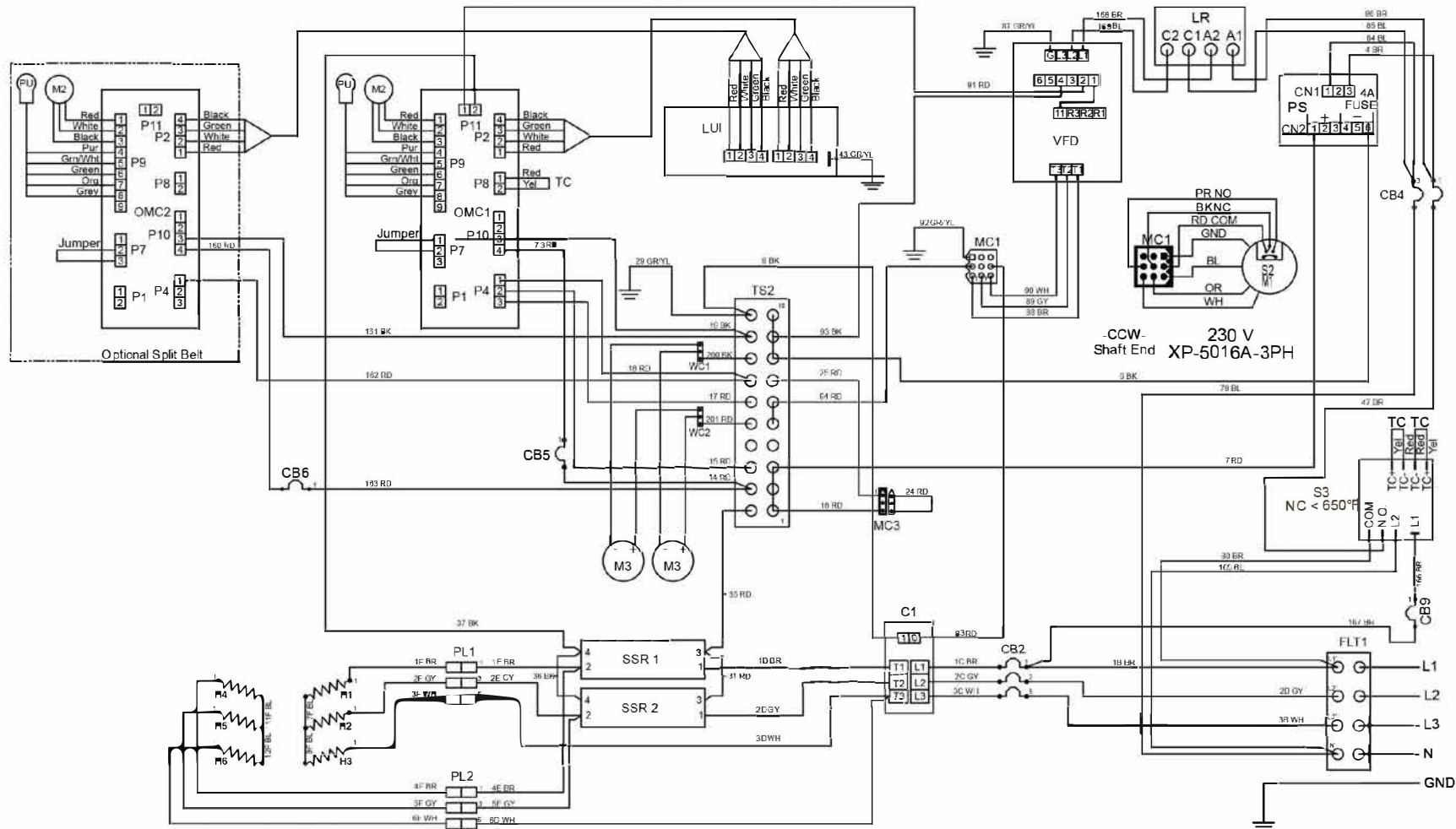


C1	Contactor, 70 Amp	LR	Line Reactor, 5% Impedance	S2	Switch, Centrifugal
CB2	Circuit Breaker, 63 Amp, Heating Elements	M1	Motor, Oven Fan	S3	Switch, High Limit
CB4	Circuit Breaker, 10 Amp, Main	M2	Motor, Conveyor	SSR1	Solid State Relay, 90 Amp
CB5	Circuit Breaker, 1/2 Amp, Conveyor Motor	M3	Motor, Cooling Fan	SSR2	Solid State Relay, 90 Amp
CB6	Circuit Breaker, 1/2 Amp, Conveyor Motor	OMC1	Oven Control, Main	TC	Thermocouple
CB9	Circuit Breaker, 1/2 Amp, High Limit	OMC2	Oven Control, Split Belt	TS2	Terminal Strip
FLT1	Filter, Control Voltage	PL1	Push Lock, 1-3 Elements	VFD	Variable Frequency Drive
H1-H3	Heating Element, 240 VAC, 5300 W	PS	Power Supply	WC1	Wago Connector
LUI	Large User Interface	PU	Pick-Up	WC2	Wago Connector

X3G-1832

X3G-2336

380 VAC 3 PH 50 Hz
XD-9130G-380-5300-3 RH
RH Controls Right Side
10/16/2017

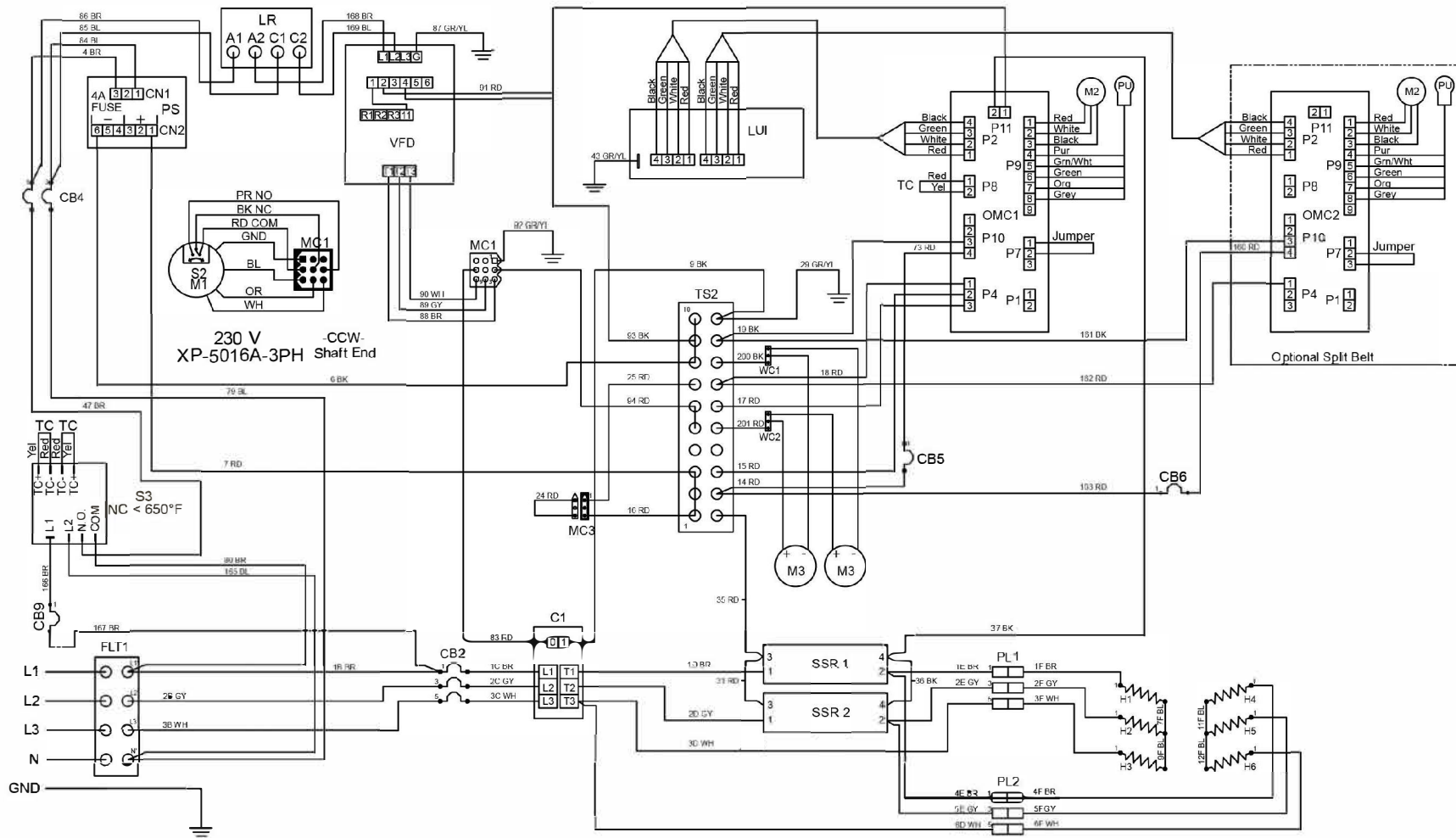


C1	Contactor 70 Amp	LR	Line Reactor, 5% Impedance	S2	Switch, Centrifugal
CB2	Circuit Breaker, 63 Amp, Heating Elements	M1	Motor, Oven Fan	S3	Switch, High Limit
CB4	Circuit Breaker, 10 Amp, Main	M2	Motor, Conveyor	SSR1	Solid State Relay, 90 Amp
CB5	Circuit Breaker, 1/2 Amp, Conveyor Motor	M3	Motor, Cooling Fan	SSR2	Solid State Relay, 90 Amp
CB6	Circuit Breaker, 1/2 Amp, Conveyor Motor	OMC1	Oven Control, Main	TC	Thermocouple
CB9	Circuit Breaker, 1/2 Amp, High Limit	OMC2	Oven Control, Split Belt	TS2	Terminal Strip
FLT1	Filter, Control Voltage	PL1	Push Lock, 1-3 Elements	VFD	Variable Frequency Drive
H1-H3	Heating Element, 240 VAC, 4500 W	PL2	Push Lock, 4-6 Elements	WC1	Wago Connector
H4-H6	Heating Element, 240 VAC, 4500 W	PS	Power Supply	WC2	Wago Connector
LUI	Large User Interface	PU	Pick-Up		
RD-Red	BK-Black	BL-Blue	BR-Brown	GR/YL-Green Yellow	OR-Orange
	WH-White	GY-Gray			

X3G-2440

X3G-3240

380 VAC 3 PH 50 Hz
 XD-9130G-380-4500-6 LH
 LH Controls Left Side
 10/16/2017

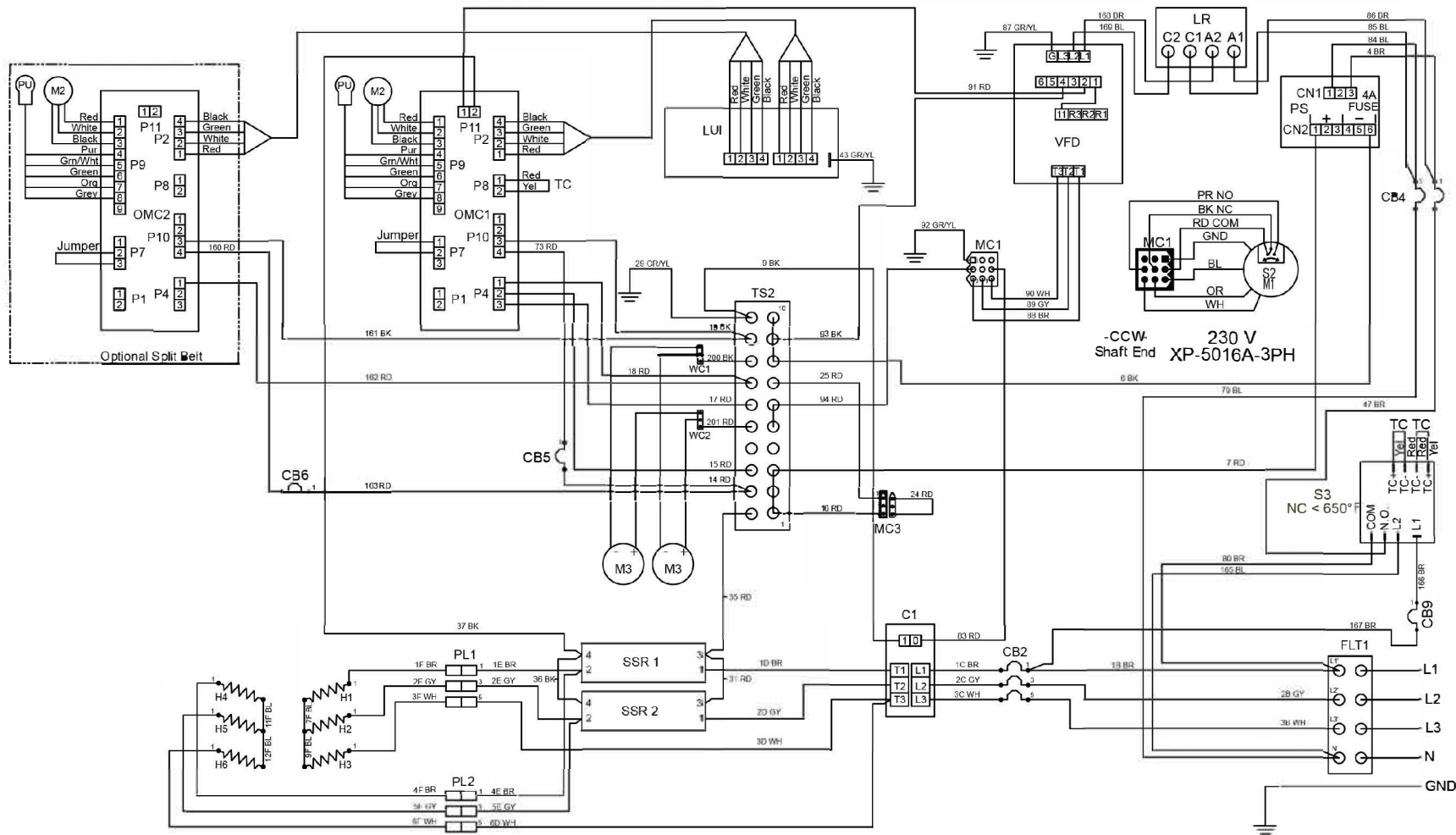


- | | | | |
|--------------------|---|------|----------------------------|
| C1 | Contactor 70 Amp | LR | Line Reactor, 5% Impedance |
| CB2 | Circuit Breaker, 63 Amp, Heating Elements | M1 | Motor, Oven Fan |
| CB4 | Circuit Breaker, 10 Amp, Main | M2 | Motor, Conveyor |
| CB5 | Circuit Breaker, 1/2 Amp, Conveyor Motor | M3 | Motor, Cooling Fan |
| CB6 | Circuit Breaker, 1/2 Amp, Conveyor Motor | OMC1 | Oven Control, Main |
| CB9 | Circuit Breaker, 1/2 Amp, High Limit | OMC2 | Oven Control, Split Belt |
| FLT1 | Filter, Control Voltage | PL1 | Push Lock, 1-3 Elements |
| H1-H3 | Heating Element, 240 VAC, 4500 W | PL2 | Push Lock, 4-6 Elements |
| H4-H6 | Heating Element, 240 VAC, 4500 W | PS | Power Supply |
| LUI | Large User Interface | PU | Pick-Up |
| RD-Red | | | |
| BK-Black | | | |
| BL-Blue | | | |
| BR-Brown | | | |
| GR/YL-Green Yellow | | | |
| OR-Orange | | | |
| WH-White | | | |
| GY-Gray | | | |

- | | |
|------|---------------------------|
| S2 | Switch, Centrifugal |
| S3 | Switch, High Limit |
| SSR1 | Solid State Relay, 90 Amp |
| SSR2 | Solid State Relay, 90 Amp |
| TC | Thermocouple |
| TS2 | Terminal Strip |
| VFD | Variable Frequency Drive |
| WC1 | Wago Connector |
| WC2 | Wago Connector |

380 VAC 3 PH 50 Hz
 XD-9130G-380-4500-6 RH
 RH Controls Right Side
 10/16/2017

X3G-2440
 X3G-3240



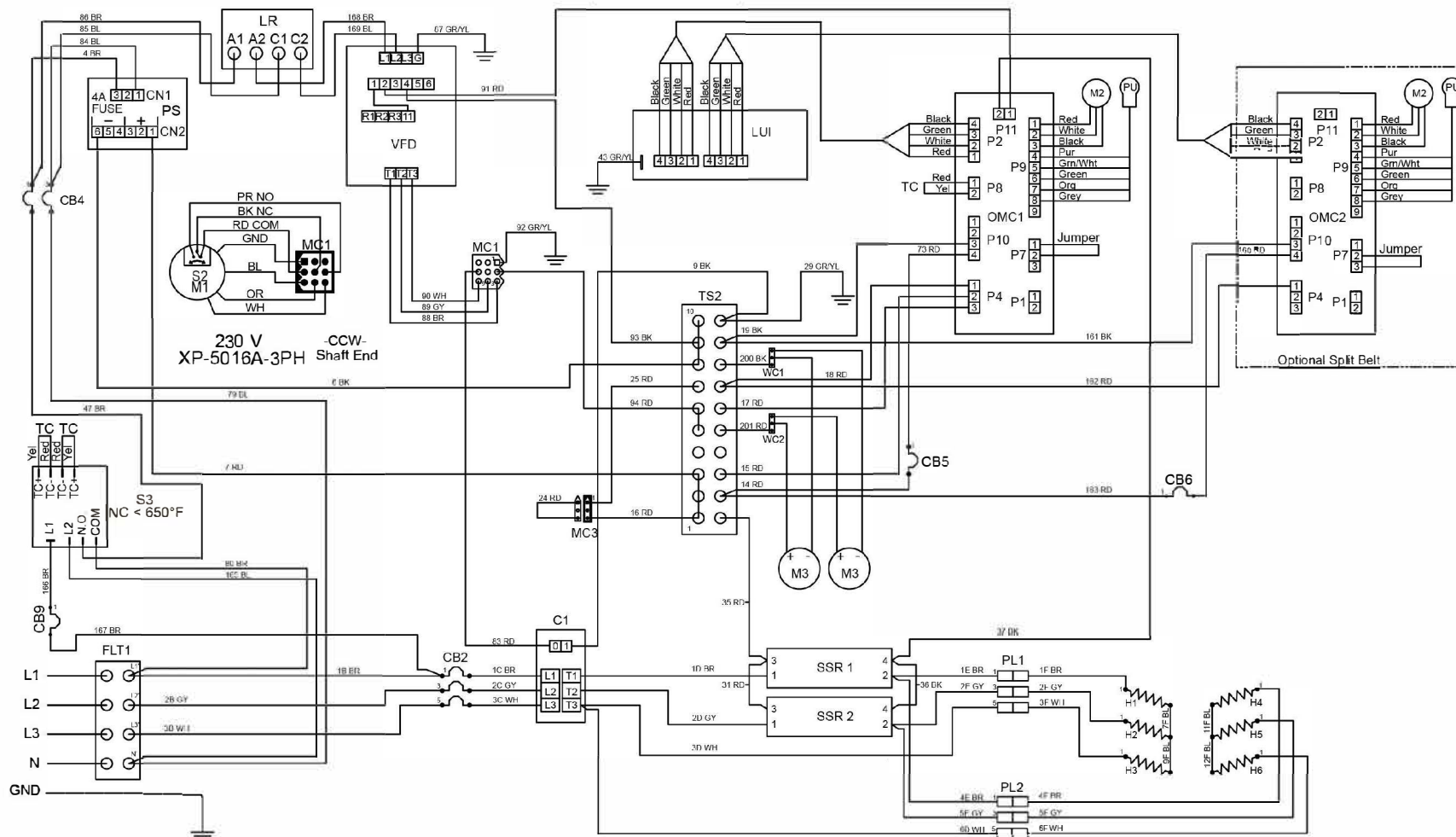
- | | | | | | |
|-------|---|------|----------------------------|------|---------------------------|
| C1 | Contactor, 70 Amp | LR | Line Reactor, 5% Impedance | S2 | Switch, Centrifugal |
| CB2 | Circuit Breaker, 63 Amp, Heating Elements | M1 | Motor, Oven Fan | S3 | Switch, High Limit |
| CB4 | Circuit Breaker, 10 Amp, Main | M2 | Motor, Conveyor | SSR1 | Solid State Relay, 90 Amp |
| CB5 | Circuit Breaker, 1/2 Amp, Conveyor Motor | M3 | Motor, Cooling Fan | SSR2 | Solid State Relay, 90 Amp |
| CB6 | Circuit Breaker, 1/2 Amp, Conveyor Motor | OMC1 | Oven Control, Main | TC | Thermocouple |
| CB9 | Circuit Breaker, 1/2 Amp, High Limit | OMC2 | Oven Control, Split Belt | TS2 | Terminal Strip |
| FLT1 | Filter, Control Voltage | PL1 | Push Lock, 1-3 Elements | VFD | Variable Frequency Drive |
| H1-H3 | Heating Element, 240 VAC, 5300 W | PL2 | Push Lock, 4-6 Elements | WC1 | Wago Connector |
| H4-H6 | Heating Element, 240 VAC, 5300 W | PS | Power Supply | WC2 | Wago Connector |
| LUI | Large User Interface | PU | Pick-Up | | |

RD-Red BK-Black BL-Blue BR-Brown GR/YL-Green Yellow OR-Orange WH-White GY-Gray

X3G-3255

X3G-3855

380 VAC 3 PH 50 Hz
 XD-9130G-380-5300-6 LH
 LH Controls Left Side
 10/16/2017

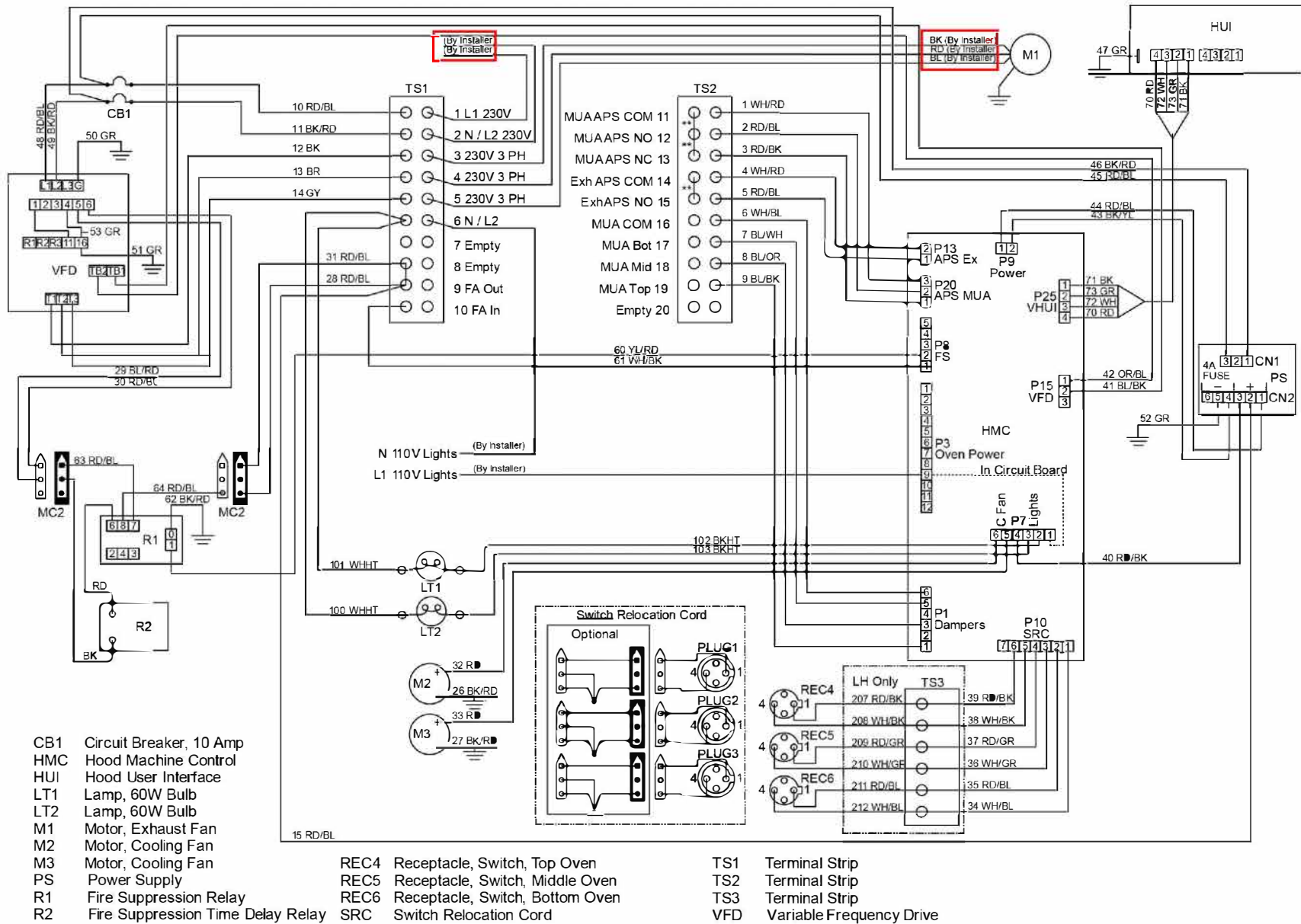


C1	Contactor, 70 Amp	LR	Line Reactor, 5% Impedance	S2	Switch, Centrifugal
CB2	Circuit Breaker, 63 Amp, Heating Elements	M1	Motor, Oven Fan	S3	Switch, High Limit
CB4	Circuit Breaker, 10 Amp, Main	M2	Motor, Conveyor	SSR1	Solid State Relay, 90 Amp
CB5	Circuit Breaker, 1/2 Amp, Conveyor Motor	M3	Motor, Cooling Fan	SSR2	Solid State Relay, 90 Amp
CB6	Circuit Breaker, 1/2 Amp, Conveyor Motor	OMC1	Oven Control, Main	TC	Thermocouple
CB9	Circuit Breaker, 1/2 Amp, High Limit	OMC2	Oven Control, Split Belt	TS2	Terminal Strip
FLT1	Filter, Control Voltage	PL1	Push Lock, 1-3 Elements	VFD	Variable Frequency Drive
H1-H3	Heating Element, 240 VAC, 5300 W	PL2	Push Lock, 4-6 Elements	WC1	Wago Connector
H4-H6	Heating Element, 240 VAC, 5300 W	PS	Power Supply	WC2	Wago Connector
LUI	Large User Interface	PU	Pick-Up		

RD-Red BK-Black BL-Blue BR-Brown GR/YL-Green Yellow OR-Orange WH-White GY-Gray

X3G-3255
X3G-3855

380 VAC 3 PH 50 Hz
XD-9130G-380-5300-6 RH
RH Controls Right Side
10/16/2017



Technical Support US: 888-443-2751

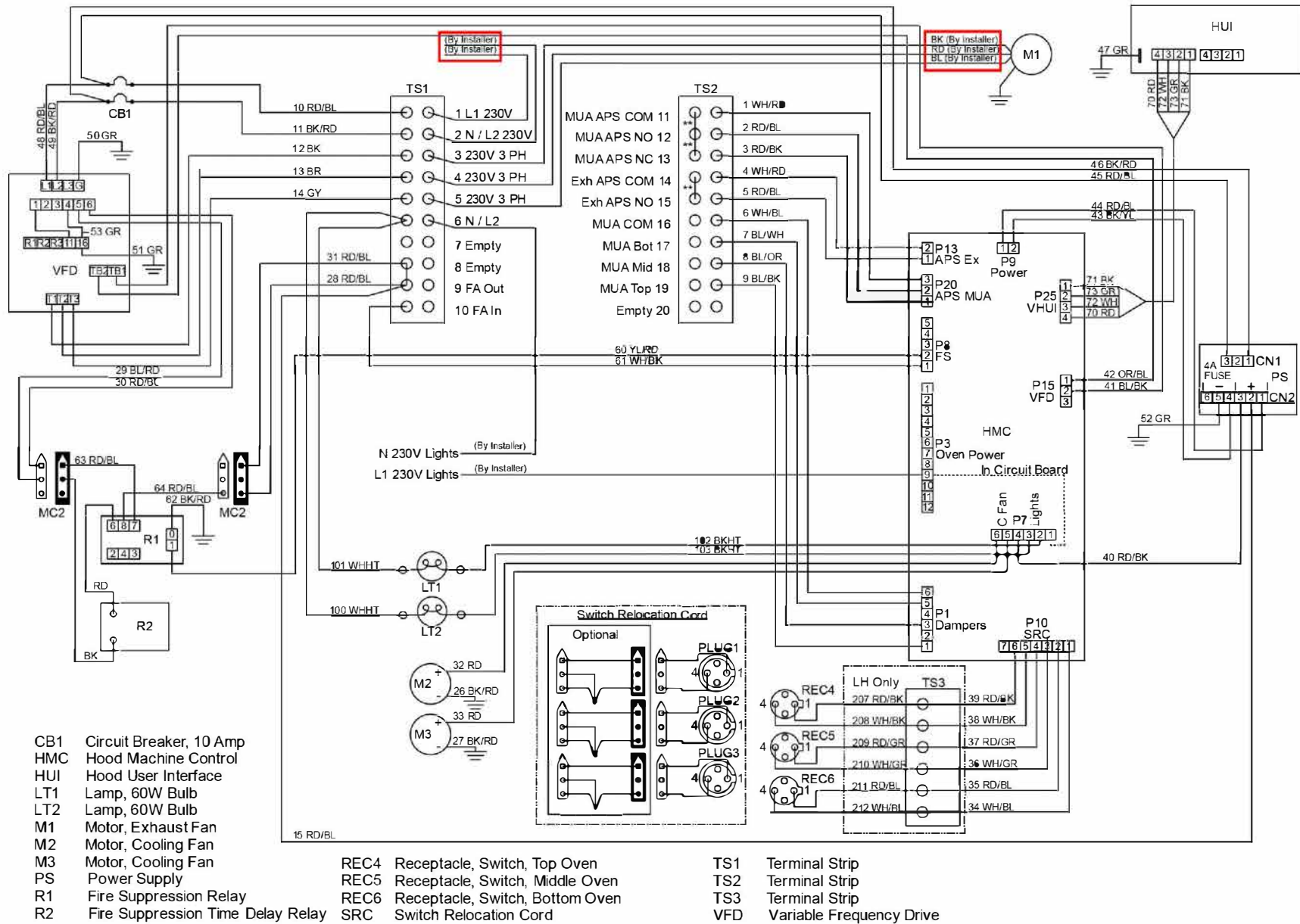
Simple. Smart.

Technical Support INTL: 316-943-2751

RD-Red BK-Black BL-Blue BR-Brown GR-Green YL-Yellow PR-Purple HT-High Temp OR-Orange WH-White GY-Gray ** - Remove Jumpers for APS

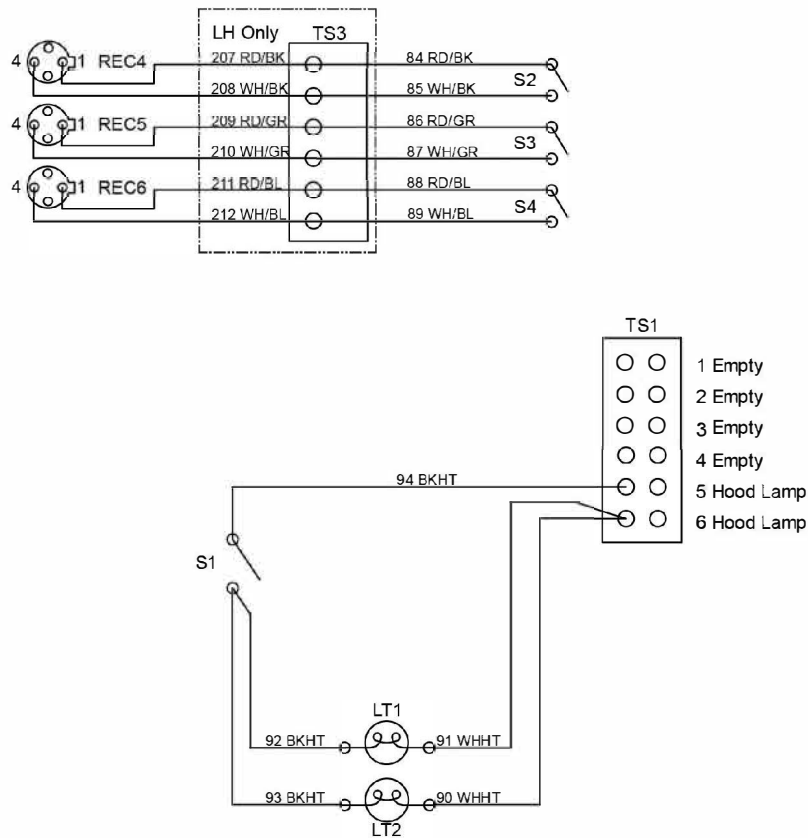
HD-9130E-ELE-VFD-S

03/16/2017



HD-9130E-ELE-VFD-W

03/16/2017



LT1 Lamp, 60W Bulb
 LT2 Lamp, 60W Bulb
 REC4 Receptacle, Top Oven
 REC5 Receptacle, Middle Oven
 REC6 Receptacle, Bottom Oven
 S1 Switch, Light
 S2 Switch, Top Oven
 S3 Switch, Middle Oven
 S4 Switch, Bottom Oven
 TS1 Terminal Strip
 TS3 Terminal Strip

RD-Red BK-Black BL-Blue GR-Green HT-High Temp WH-White

HD-9130E-NV
03/16/2017

XLT Ovens
PO Box 9090

Wichita, Kansas 67277

US: 888-443-2751 FAX: 316-943-2769 INTL: 316-943-2751 WEB: www.xltovens.com