



Simple. Smart.



XLT Oven & AVI Hood Installation & Operation Manual



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 combustion and 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.

An electronic copy of this manual & warranty policy is available at: www.xltovens.com

For use with the following XLT GAS Oven Versions:

Australian (AE) B
Standard (S) B
World (W) B

For use with the following AVI Hood Versions:

Standard (S) A
World (W) A



2000887

XLT Ovens
PO Box 9090
Wichita, Kansas 67277
TEL: 888-443-2751 FAX: 316-943-2769 WEB SITE: www.xltovens.com

WARNING & SAFETY INFORMATION



SAFETY DEPENDS ON YOU



WARNING

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.

- Post in a prominent location instructions to be followed in the event you smell gas. This information can be obtained by consulting your local gas supplier.



WARNING

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

- In the event a gas odor is detected, shut off the gas at the main shutoff valve immediately. Contact your local Gas Company or supplier.
- Do not restrict the flow of combustion and/or ventilation air to the unit. Provide adequate clearance for operating, cleaning, and maintaining the unit and adequate clearance for operating the gas shutoff valve when the unit is 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 at the end of this manual. Disconnect input power to the unit before performing any maintenance.
- This unit requires a Type I ventilation hood, which requires make-up and exhaust air to ensure adequate air supply. The installation should conform to local codes.
- This unit may be operated with either natural gas or LP fuel as designated on the nameplate label located on the side of the unit.
- This unit must be operated by the same voltage, phase, and frequency of electrical power as designated on the nameplate label located on the side of the unit.
- Minimum clearances must be maintained from combustible and 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.
- 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, and will void any warranties. XLT Ovens assumes no liability for mixed product applications.
- PLEASE RETAIN THIS MANUAL FOR FUTURE REFERENCE.

For the best results with the XLT Oven and AVI Hood, carefully read this manual and all of the warning labels attached to the products before installing and operating them, and follow the instructions exactly. Keep this manual handy for quick reference.

Definitions and Symbols

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



**HIGH
VOLTAGE**

This symbol indicates high voltage. It calls your attention to items or operations that could be dangerous to you and other persons operating this equipment. Read the message and follow the instructions carefully.



WARNING

Indicates a potentially hazardous situation that, if not avoided, can result in serious injury or death.



CAUTION

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.



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.

Purchaser’s Responsibility

It is the responsibility of the purchaser:

- To unload, uncrate, assemble, and move the ovens to their intended location.
- To ensure that the gas and electric utilities are installed on site in accordance with local building codes and with the specifications in this manual.
- To see that the gas and electric utilities are connected properly by a qualified installer using the proper hardware.
- To ensure a qualified installer has performed an initial start-up procedure.
- In Australia, install oven in accordance with the latest version of AS5601 Gas Installation.

Your new oven and hood system is the result of our dedication to help you produce the finest quality baked goods. XLT Ovens has made a substantial and growing investment in capital equipment and facilities, including state of the art CAD/CAM designing and fabricating software and machine tools. The company has also developed ways to build quality into its products at each stage of the manufacturing process, both through extensive use of automation and, most importantly, through an awareness that people are the central element in quality control.

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

To receive technical support for the oven or hood you purchased, contact the designated representative from whom you purchased the unit, or XLT Ovens at 888-443-2751 anytime day or night, 365 days per year. Please be prepared to provide the Model and Serial Number.

Receiving and Inspection

NOTIFY CARRIER OF DAMAGE AT ONCE

Upon receiving of all goods shipped by a Common Carrier, check for any exterior damage that may indicate interior damage. If conditions permit, open all crates and do a full inspection for any damage while the delivery driver is still there. If there is damage please note on the delivery receipt and call the carrier to make a freight damage claim within 24 hours of receipt. Failure to make a damage claim within the first 24 hours may void the opportunity to have the claim resolved.



WARNING

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

Save this Manual

This document is the property of the owner of this equipment. Please make sure to leave this copy with the store owner or “on site” manager, so it can be incorporated in the owners “on site” book of manuals for future use.

XLT Ovens reserves the right to make changes in design and 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 and Left Hand designations in this manual are from the point of view as if standing directly in front of the ovens.

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Revision History Table		
Revision	Comments	Date
01	Initial Release	1/19/2011
02	Updated Hood Installation Dimensions page 45	3/8/2011
03	Revised MJ/hr	04/07/2011

Oven Description

This manual covers the following XLT Series Ovens and AVI Hood models:

1832-AE-B	1832B-S	1832B-W	AVI-1832A-S	AVI-1832A-W
2440-AE-B	2440B-S	2440B-W	AVI-2440A-S	AVI-2440A-W
3240-AE-B	3240B-S	3240B-W	AVI-3240A-S	AVI-3240A-W
3255-AE-B	3255B-S	3255B-W	AVI-3255A-S	AVI-3255A-W
3270-AE-B	3270B-S	3270B-W	AVI-3270A-S	AVI-3270A-W
3270S-AE-B	3270SB-S	3270SB-W		
3855-AE-B	3855B-S	3855B-W	AVI-3855A-S	AVI-3855A-W
3870-AE-B	3870B-S	3870B-W	AVI-3870A-S	AVI-3870A-W

XLT Ovens are certified to the following Standards:

“-AE” indicates Australian Export configuration, certified to AGA AS 4563.

“-S” indicates Standard configuration, certified to ANSI Z83.11/CSA 1.8 & ANSI/NSF 4.

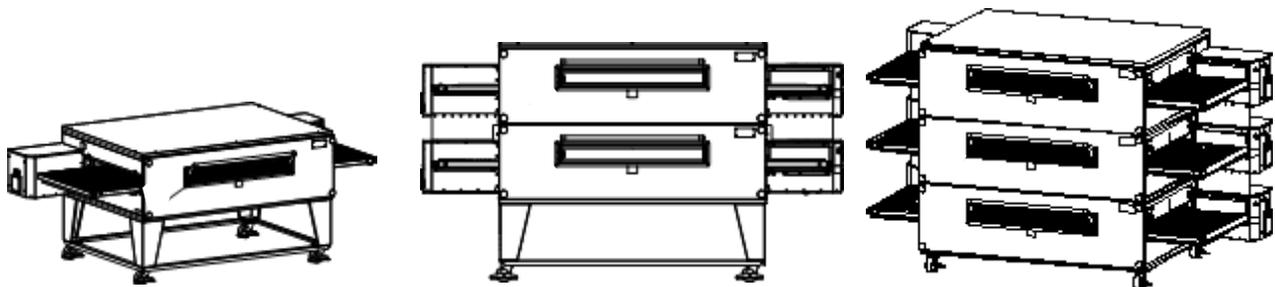
“-W” indicates World configuration, certified to CE GAD 90/396/EEC & BS EN 203-1.

AVI Hoods are certified to the following Standards:

“-S” indicates Standard configuration, certified to UL 710, ULC-S646, NFPA 96, and ANSI/NSF 2.

“-W” indicates World configuration, certified to UL 710, ULC-S646, NFPA 96, and ANSI/NSF 2.

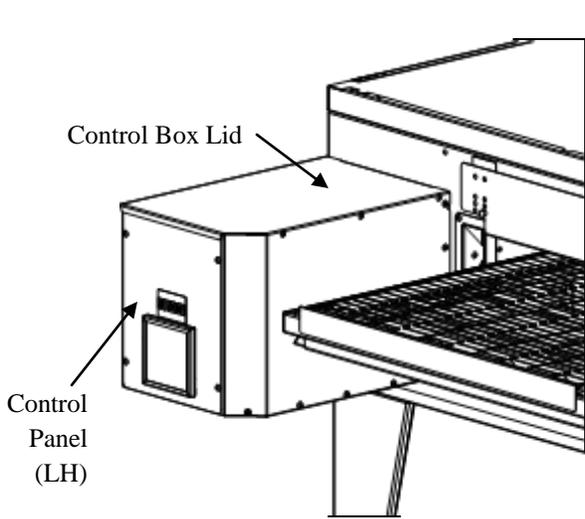
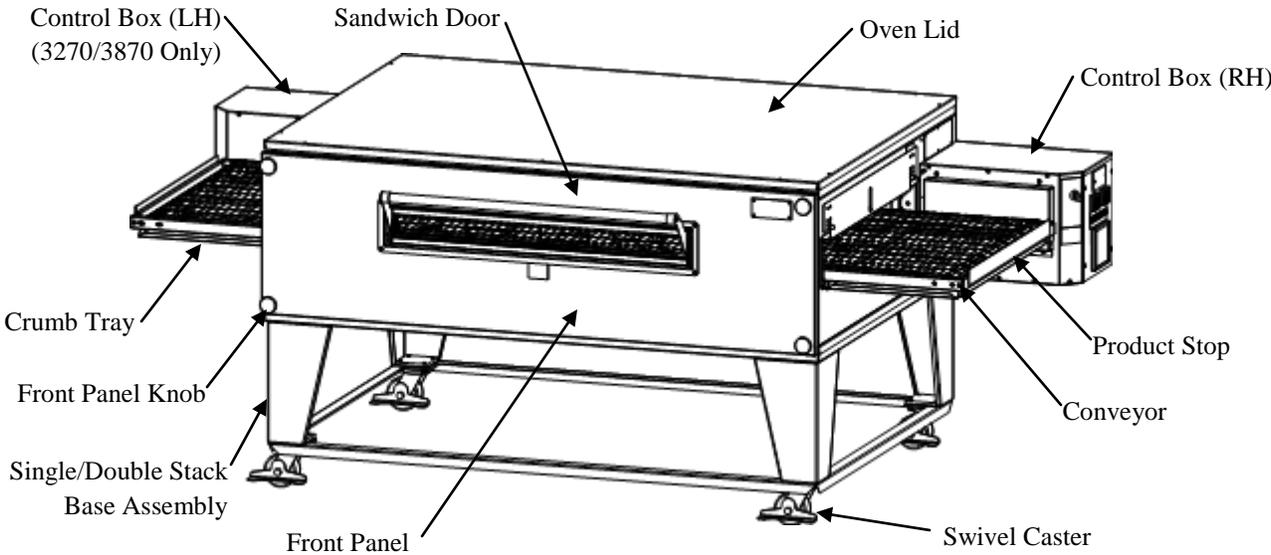
The first 2 digits of the model number represent the conveyor width and the last two digits indicate the bake chamber length. The ovens may be used in a single, double, or triple oven stack configuration. A single or double configuration can be upgraded by adding additional decks up to the maximum of three. All ovens are gas-fired and are available in Natural gas or LP gas models (Electric ovens are also available). The 3270 and 3870 models have two burners, one on each side, and have two control boxes. All other models have only a single burner with a single control box that can be supplied on either end. All models can be configured for a split belt conveyor.



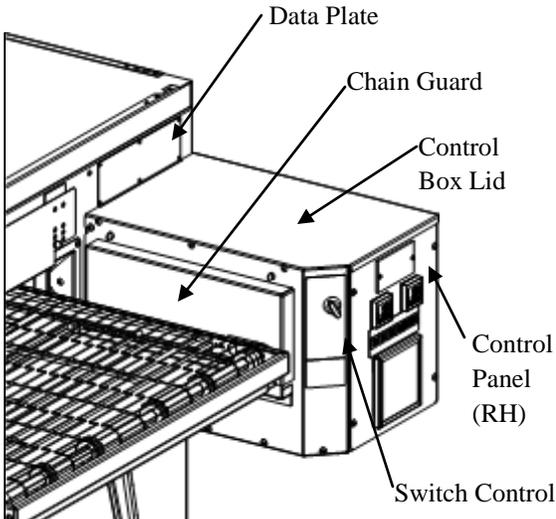
Food product is placed on the stainless steel wire conveyor belt on one side of the oven. The conveyor then transports the food through the bake chamber at a user-controlled speed. This provides repeatable and uniform food cooking. The conveyors can be easily configured to move either left-to-right or right-to-left. A large center sandwich door allows the introduction or removal of food items for cooking at shorter times. Temperatures up to 550° F or 288° C inside the oven are achieved by means of a user-adjustable digital control.

An easily removable front panel allows the full cleaning of the oven interior. All exposed oven surfaces both exterior and interior are stainless steel. The conveyor is a one piece design and is removed from the side which has the control box. No tools are required for disassembly and cleaning of the conveyor or oven interior. The oven itself is mounted on lockable swivel casters for easy moving and maintenance.

Accessories such as extended conveyor shelves and perforated crumb trays are available from XLT. In addition, moving equipment such as carts and lifting jacks are available to help install and move ovens and hoods. Please contact XLT or your designated representative for more information.

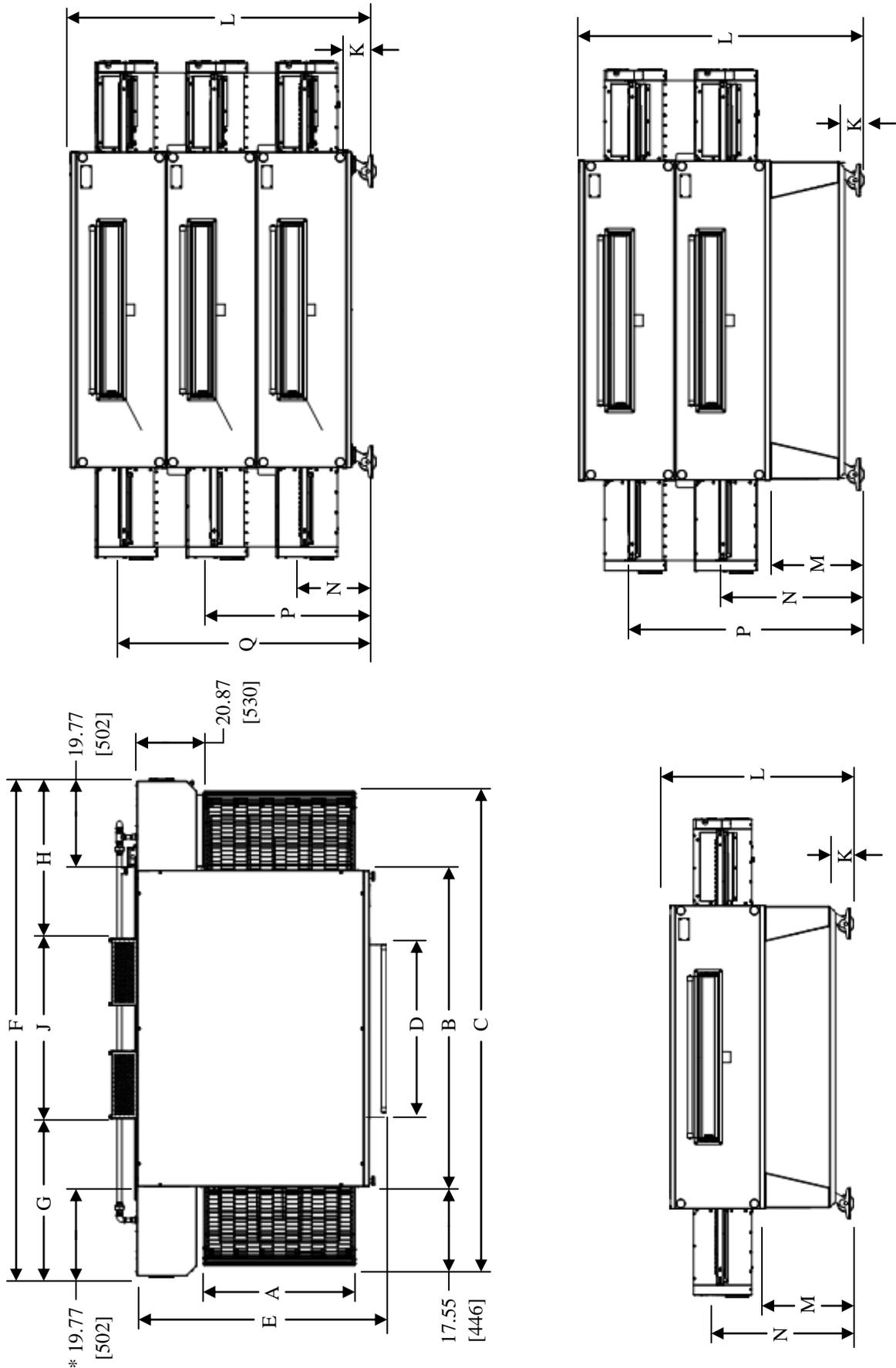


Models 3270 & 3870



All Models

Oven Dimensions



NOTE: All dimensions in inches [mm].

Oven Dimensions

SINGLE STACK	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	WEIGHT
1832	19.41 [493]	32.13 [816]	67.25 [1708]	19.72 [501]	47.23 [1200]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	500 [227]
2440	25.41 [645]	40.13 [1019]	75.25 [1911]	19.72 [501]	53.23 [1352]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	600 [272]
3240	33.41 [849]	40.13 [1019]	75.25 [1911]	19.72 [501]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	720 [327]
3255	33.41 [849]	55.13 [1400]	90.25 [2292]	37.72 [958]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	850 [386]
3270	33.41 [849]	70.13 [1781]	105.25 [2673]	37.72 [958]	61.23 [1555]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	1100 [500]
3855	39.41 [1001]	55.13 [1400]	90.25 [2292]	37.72 [958]	67.23 [1708]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	1050 [476]
3870	39.41 [1001]	70.13 [1781]	105.25 [2673]	37.72 [958]	67.23 [1708]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.70 [145]	42.73 [1085]	20.66 [525]	31.78 [807]	N/A	N/A	1300 [590]

DOUBLE STACK	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	WEIGHT
1832	19.41 [493]	32.13 [816]	67.25 [1708]	19.72 [501]	47.23 [1200]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	890 [404]
2440	25.41 [645]	40.13 [1019]	75.25 [1911]	19.72 [501]	53.23 [1352]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	1060 [481]
3240	33.41 [849]	40.13 [1019]	75.25 [1911]	19.72 [501]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	1300 [590]
3255	33.41 [849]	55.13 [1400]	90.25 [2292]	37.72 [958]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	1500 [680]
3270	33.41 [849]	70.13 [1781]	105.25 [2673]	37.72 [958]	61.23 [1555]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	2000 [907]
3855	39.41 [1001]	55.13 [1400]	90.25 [2292]	37.72 [958]	67.23 [1708]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	1800 [816]
3870	39.41 [1001]	70.13 [1781]	105.25 [2673]	37.72 [958]	67.23 [1708]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.70 [145]	62.72 [1593]	20.66 [525]	31.78 [807]	51.77 [1315]	N/A	2300 [1043]

TRIPLE STACK	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	WEIGHT
1832	19.41 [493]	32.13 [816]	67.25 [1708]	19.72 [501]	47.23 [1200]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	1240 [562]
2440	25.41 [645]	40.13 [1019]	75.25 [1911]	19.72 [501]	53.23 [1352]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	1500 [680]
3240	33.41 [849]	40.13 [1019]	75.25 [1911]	19.72 [501]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	1830 [830]
3255	33.41 [849]	55.13 [1400]	90.25 [2292]	37.72 [958]	61.23 [1555]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	2100 [953]
3270	33.41 [849]	70.13 [1781]	105.25 [2673]	37.72 [958]	61.23 [1555]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	2850 [1293]
3855	39.41 [1001]	55.13 [1400]	90.25 [2292]	37.72 [958]	67.23 [1708]	N/A*	N/A*	39.92 [1014]	14.85 [377]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	2550 [1157]
3870	39.41 [1001]	70.13 [1781]	105.25 [2673]	37.72 [958]	67.23 [1708]	109.72 [2787]	34.94 [887]	34.94 [887]	39.85 [1012]	5.63 [143]	67.69 [1726]	20.66 [525]	16.75 [425]	36.73 [933]	56.72 [1441]	3300 [1497]

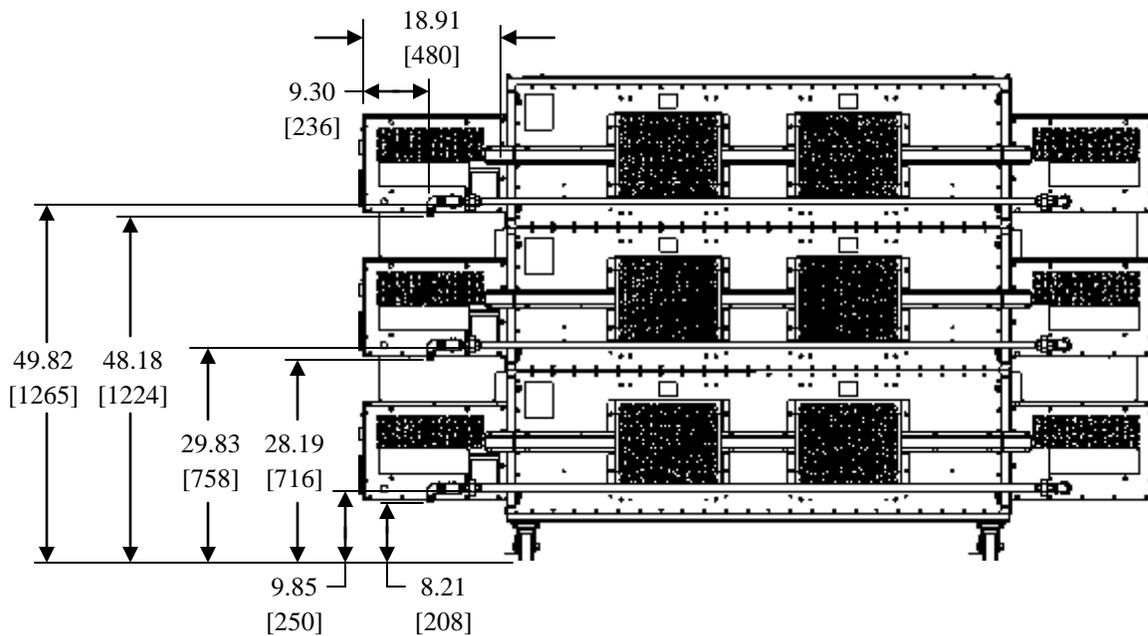
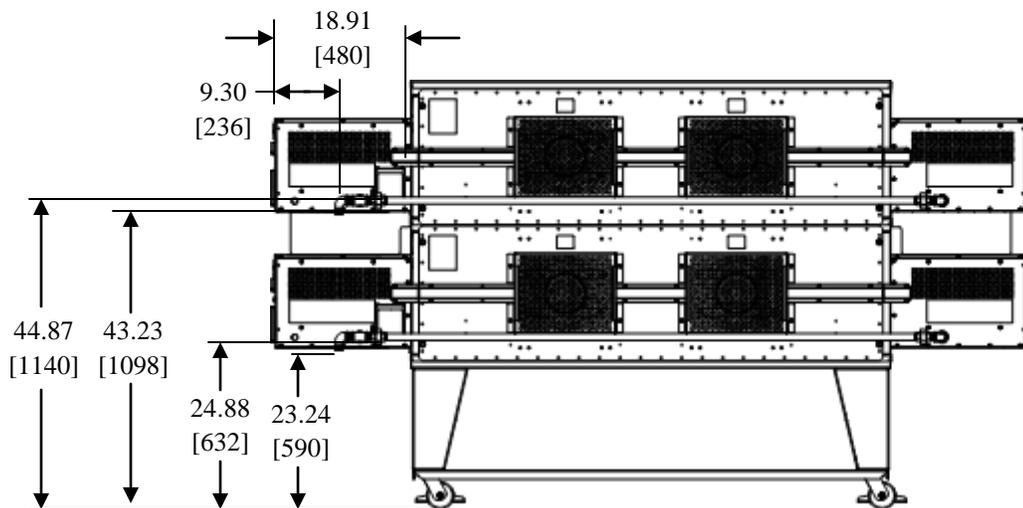
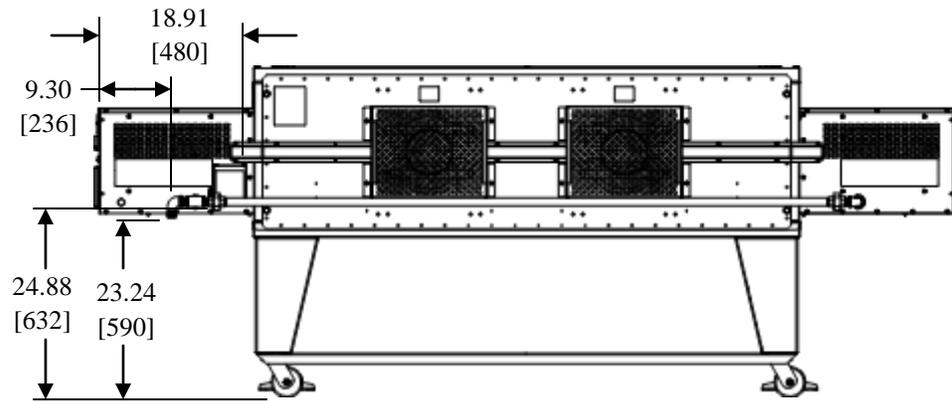
* Oven does not have left hand control box.

NOTE: All dimensions in inches [mm]. All weights in pounds [kg].



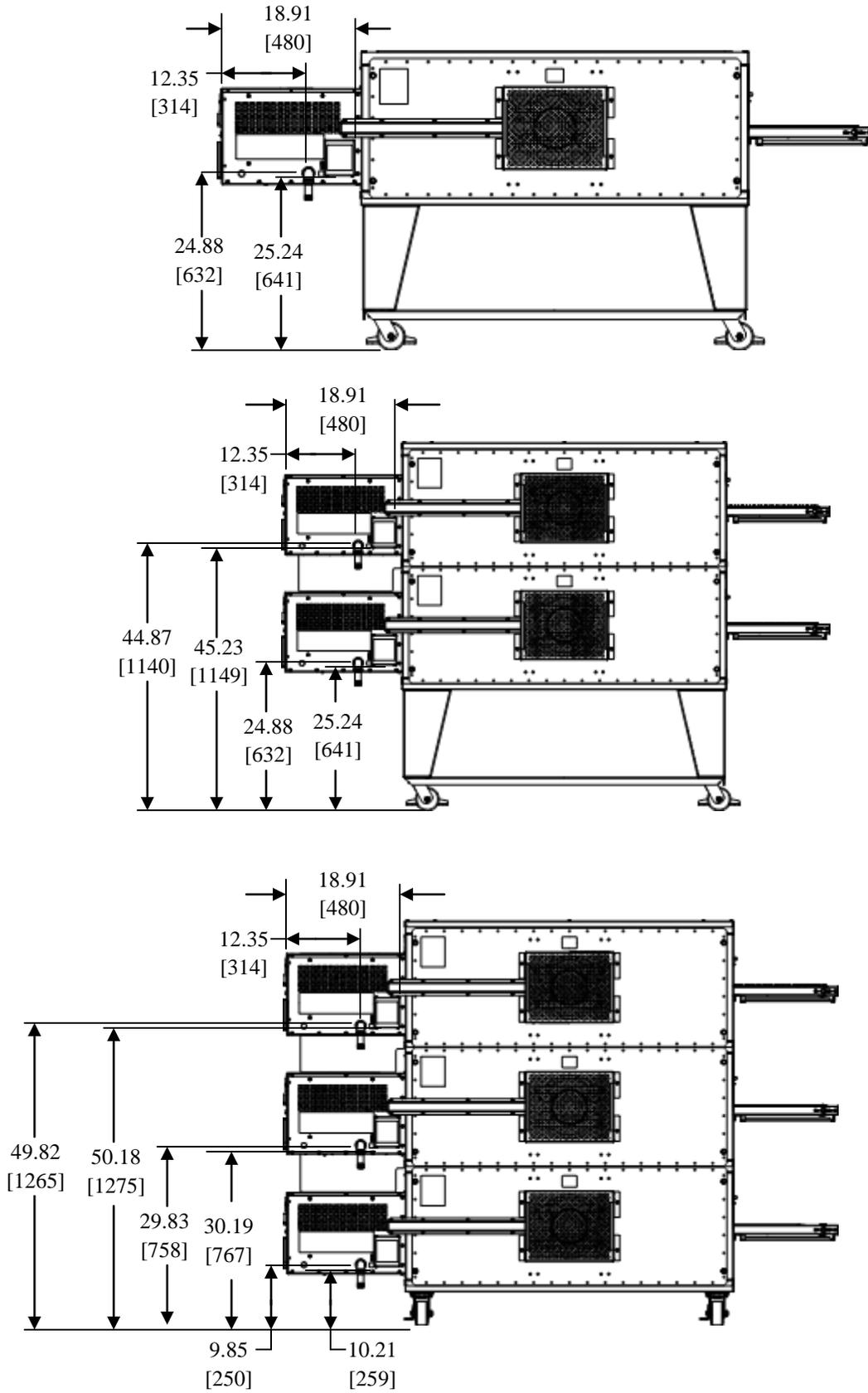
10 Gas & Electrical Connection Dimensions - Australian & World Ovens

For Models 3270 & 3870



NOTE: All dimensions in inches [mm].

For Models 1832, 2440, 3240, 3255 & 3855



NOTE: All dimensions in inches [mm].



Australian Ovens

OVEN	VOLTS	AMPS			FREQUENCY
Size	220/230/240 VAC	Single	Double	Triple	50 Hz
1832		3	6	9	
2440		3	6	9	
3240		3	6	9	
3255		3	6	9	
3270		6	12	18	
3855		3	6	9	
3870		6	12	18	

Standard Ovens

OVEN	VOLTS	AMPS			FREQUENCY
Size	120 VAC	Single	Double	Triple	60 Hz
1832		6	12	18	
2440		6	12	18	
3240		6	12	18	
3255		6	12	18	
3270		12	24	36	
3855		6	12	18	
3870		12	24	36	

World Ovens

OVEN	VOLTS	AMPS			FREQUENCY
Size	220/230/240 VAC	Single	Double	Triple	50 / 60 Hz
1832		3	6	9	
2440		3	6	9	
3240		3	6	9	
3255		3	6	9	
3270		6	12	18	
3855		3	6	9	
3870		6	12	18	

Oven	Burner Max. Capacity			Inlet Pressure					
				NAT Gas			LP Gas		
				W/C	mbar	kPa	W/C	mbar	kPa
Size	BTU/HR	KW/HR	MJ/HR	W/C	mbar	kPa	W/C	mbar	kPa
1832	52,000	15.24	63	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
2440	65,000	19.05	79	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
3240	90,000	26.37	105	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
3255	150,000	43.95	169	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
3270	160,000	46.88	190	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
3855	150,000	43.95	169	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5
3870	160,000	46.88	190	6-14	15-35	1.5-3.5	11.5-14	27.5-35	2.75-3.5

Oven	Manifold Pressure						Orifice Sizes Standard & World				Orifice Size Australia	
	Natural Gas			LP Gas			Natural Gas		LP Gas		Natural Gas	LP Gas
	W/C	mbar	kPa	W/C	mbar	kPa	Inches	MM	Inches	MM	MM	MM
Size	W/C	mbar	kPa	W/C	mbar	kPa	Inches	MM	Inches	MM	MM	MM
1832	3.5	8.75	.875	10	25	2.5	.1285	3.26	.0820	2.08	3.56	2.24
2440	3.5	8.75	.875	10	25	2.5	.144	3.66	.0890	2.26	3.96	2.44
3240	3.5	8.75	.875	10	25	2.5	.1695	4.3	.1040	2.64	4.62	2.79
3255	3.5	8.75	.875	10	25	2.5	.219	5.56	.1285	3.26	5.94	3.66
3270	3.5	8.75	.875	10	25	2.5	.147	3.73	.0980	2.49	4.39	2.64
3855	3.5	8.75	.875	10	25	2.5	.219	5.56	.1285	3.26	5.94	3.66
3870	3.5	8.75	.875	10	25	2.5	.147	3.73	.0980	2.49	4.39	2.64

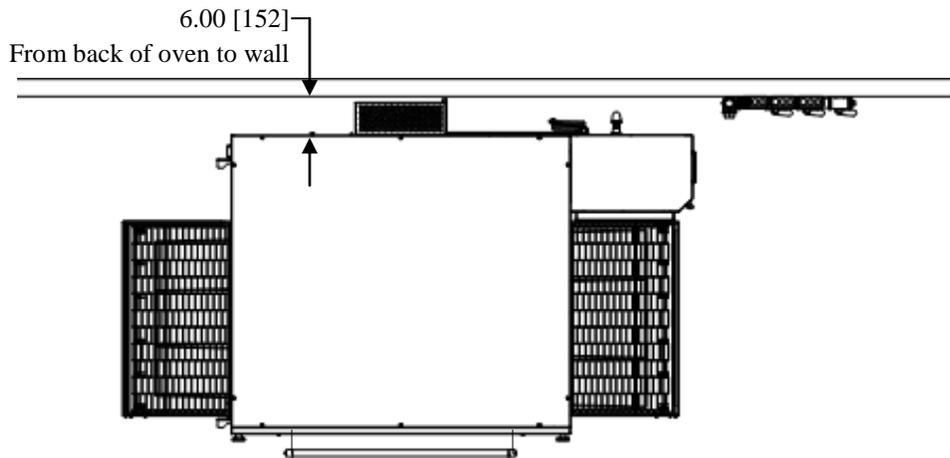
All values shown this page are per each oven

Gas Group	Natural Gas				Propane Gas			
	I _{2H}	I _{2E}	I _{2E+}	I _{2L}	I ₃₊	I _{3B/P} (30)	I _{3P} (30/37/50)	I _{3B} (37)
Inlet pressure (mbar)	20	20	20/25	25	28/30/37/50	28-30/37/50	30/37/50	37
Number of injectors	(1) per burner							
Main burner opening size	Fixed							
Ignition	Electric Direct Spark Igniter							
Inlet connection	BSP 3/4" male thread							

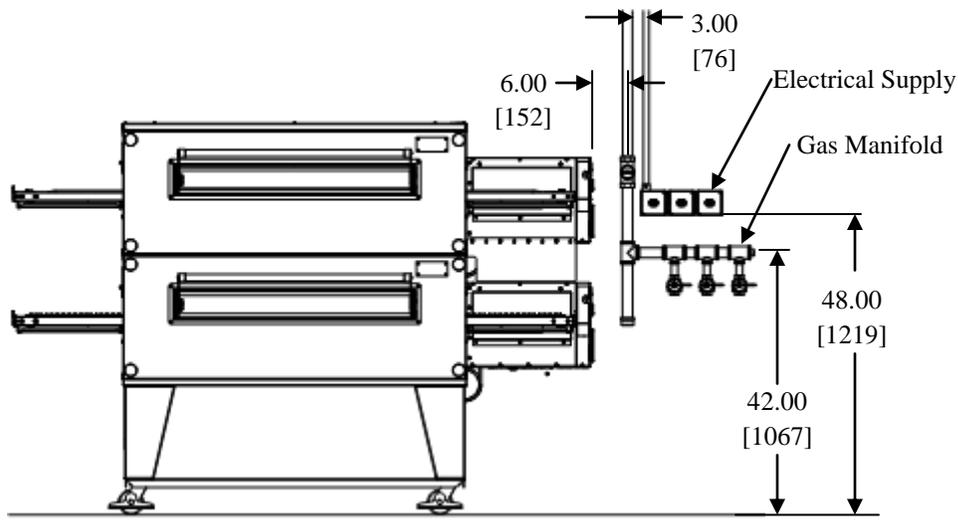
Gas Matrix by Country

Country	Symbol	Natural Gas (8.75 mbar manifold)				LP Gas (25 mbar manifold)		
		I _{2H}	I _{2L}	I _{2E}	I _{2E+}	I _{3B/P}	I ₃₊	I _{3P}
Germany	DE			X		X		X
Austria	AT	X				X		
Belgium	BE				X		X	
Denmark	DK	X				X		
Spain	ES	X					X	X
Finland	FI	X				X		
France	FR				X	X	X	X
Greece	GR	X						
Ireland	IE	X					X	X
Iceland	IS							
Italy	IT	X					X	
Luxembourg	LU							
Norway	NO					X		
Netherlands	NL		X			X		X
Portugal	PT	X					X	X
United Kingdom	GB	X					X	X
Sweden	SE	X				X		
Switzerland	CH	X				X	X	X
Slovenia	SI	X						
Slovakia	SK					X		
Cyprus	CY					X	X	X
Estonia	EE	X						
Latvia	LT					X		
Lithuania	LV							
Malta	MT					X		X
Hungary	HU					X		X
Poland	PL			X				
Czech Republic	CZ	X				X		

The gas supply and the electrical supply are to be provided by the customer prior to installation. The picture shows a typical utility rough-in for a triple stack oven. Preparing the utilities this way allows for an easy third deck addition if a double stack oven is initially installed.



NOTE Utilities must be easily accessible when the ovens are in the installed position. Do not install utilities behind the ovens.



NOTE

1. All dimensions in inches [mm].
2. All dimensions on this page are recommended.

All installations must conform to local building and mechanical codes. It is required that the ovens be placed under a ventilation hood. The gas supply should have a gas meter and regulator large enough to handle all of the gas appliances, such as the furnace, hot water heater, and ovens, in operation at the same time. Add up all of the BTU / kw / MJ ratings to determine the total load. (See Oven Specifications page for supply requirements).

FOR EACH OVEN:

Electrical service for Standard Ovens must be 120VAC, 20 A, 60 Hz single phase circuits with ground.

Electrical service for World Ovens must be 220/230/240VAC, 10 A, 50/60 Hz single phase circuits with ground.

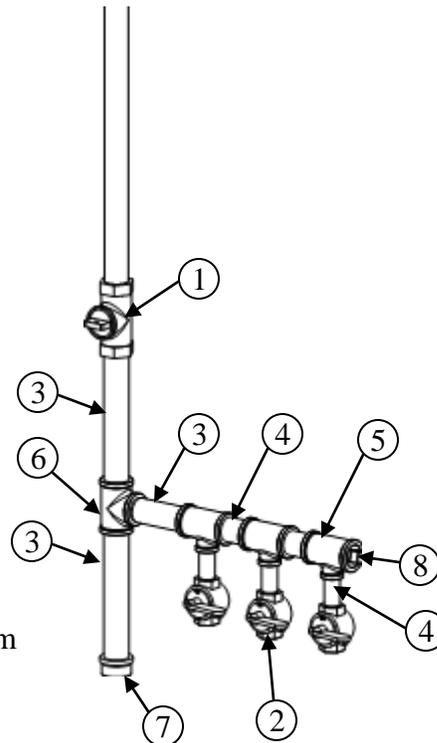
Electrical service for Australian Ovens must be 220/230/240 VAC, 10 A, 50Hz single phase and installed in accordance with the latest version of AS/NZS 3000 wiring rules.

- A separate circuit breaker must be provided for each oven deck.
- Gas and electric connections must be accessible when the ovens are in the installed position.
- Electrical plugs and cords must meet all local code requirements.

**CAUTION**

Do not use Teflon tape on gas line connections as this can possibly cause gas valve malfunction or plugging of orifices from shreds of tape. Use of Teflon tape may affect warranty.

Item #	Description
1	1-½ [40] Shut-Off Valve
2	¾ [20] Shut-Off Valve
3	6 [150] Nipple
4	¾ [20] Nipple
5	Reducing Tee
6	Tee
7	Cap
8	Plug



 All pipe fittings to be 1-½ [40] minimum unless noted. NPT & BSP

NOTE

Gas hose assemblies with quick disconnects for each oven deck will be installed at each valve.

NOTE: All dimensions in inches [mm].

WARNING & SAFETY INFORMATION

XLT ovens can easily be moved and stacked with the proper lifting equipment. The use of lifting equipment is highly recommended.



WARNING

- These ovens are heavy and can tip or fall causing bodily injury.
- NEVER place any part of your body beneath any oven that is suspended by the lifting jacks. A crush hazard exists if the oven falls or slips.
- DO NOT place your hands on the lifting jack vertical pole beneath the jack's winch. As the jack's winch descends when you turn the jack handle, a pinch point is created between the winch and the pole.

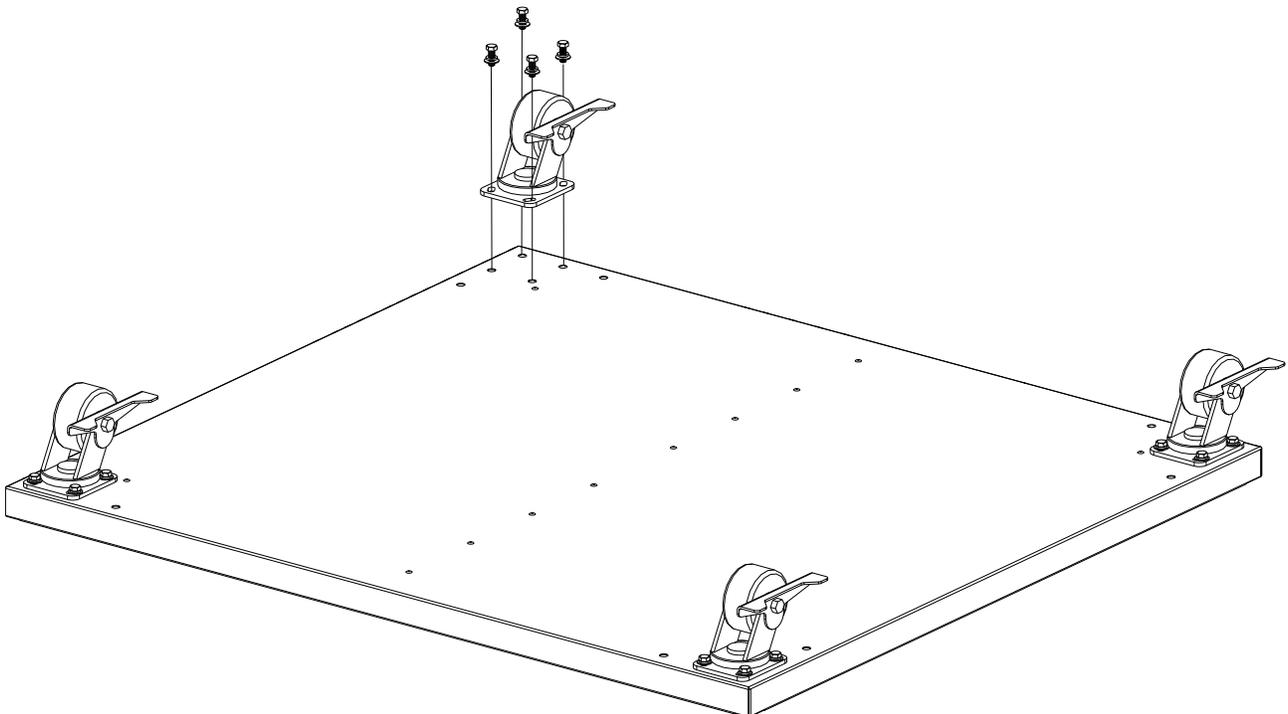


CAUTION

BE CAREFUL when rolling the oven on the cart, especially when going up or down ramps and over bumps. Leave the straps/banding on until the oven is near the assembly area.

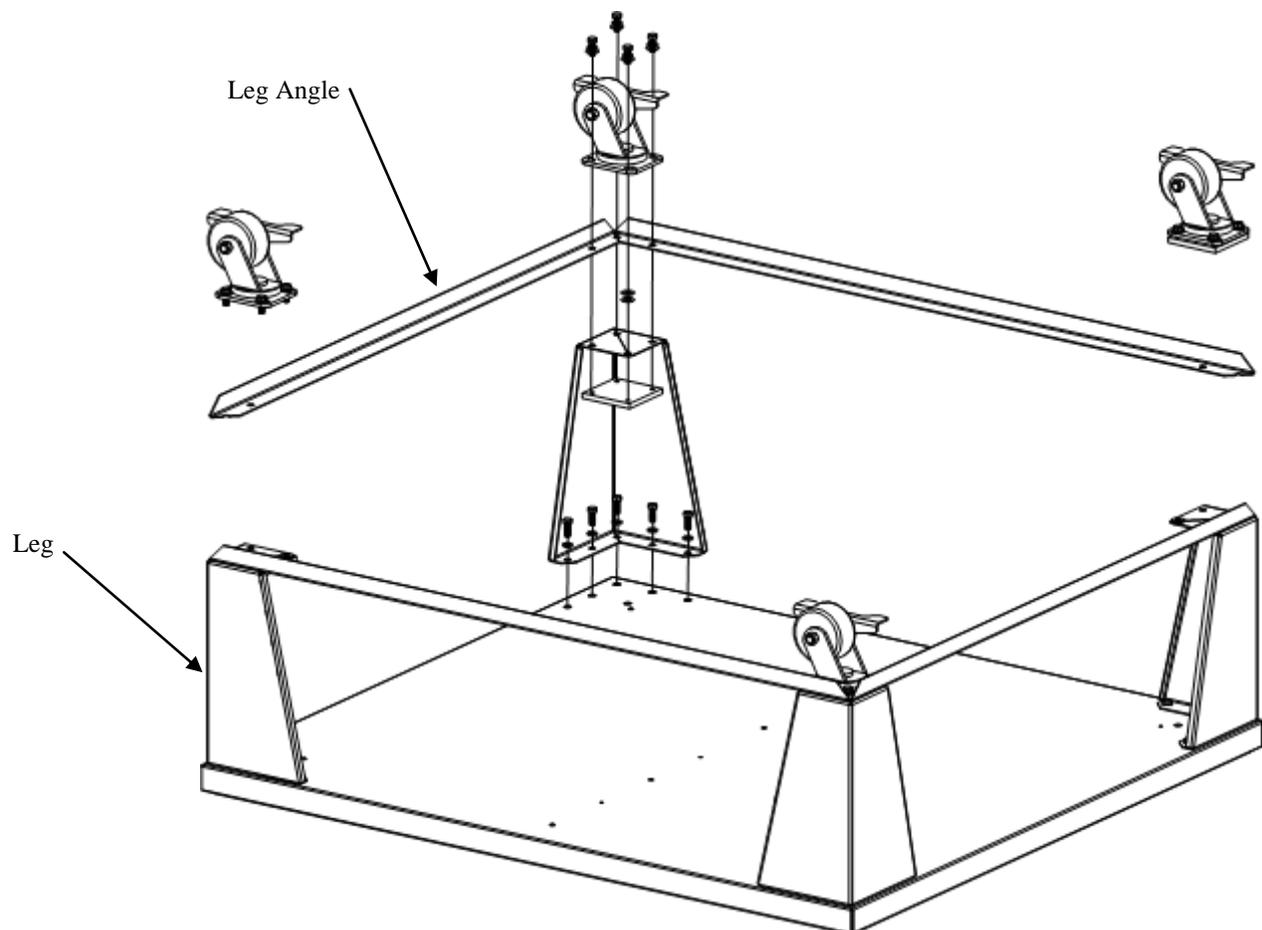
Base Assembly - Triple Stack

1. Flip the oven base upside down on the floor.
2. For triple-stack configurations, attach the four casters directly to the base with the supplied 3/8" x 1" hex bolts, washers, and lock-washers.
3. Flip the base assembly over and ensure the insulation is placed properly.



Base Assembly - Single & Double Stack

1. Flip the oven base upside down on the floor.
2. For single and double-stack configurations, attach the four legs to the bottom of the base with the supplied 3/8" x 1" hex bolts, washers, and lock-washers. Do not fully tighten them at this time. Leave them slightly loose so that the rest of the components can be more easily assembled.
3. Place the four leg angles on top of the legs as shown. All of the leg angle holes should line up with the holes in the bottom of the legs. Place two (2) washers on each leg at the inner corner holes. These 2 washers are approximately the same thickness as the leg angles, and will keep the caster level.
4. Attach the four casters to the legs as shown. The leg angles and washers are sandwiched between the casters and the leg base plates.
5. Tighten all fasteners.
6. Flip the base assembly over and ensure the insulation is placed properly.

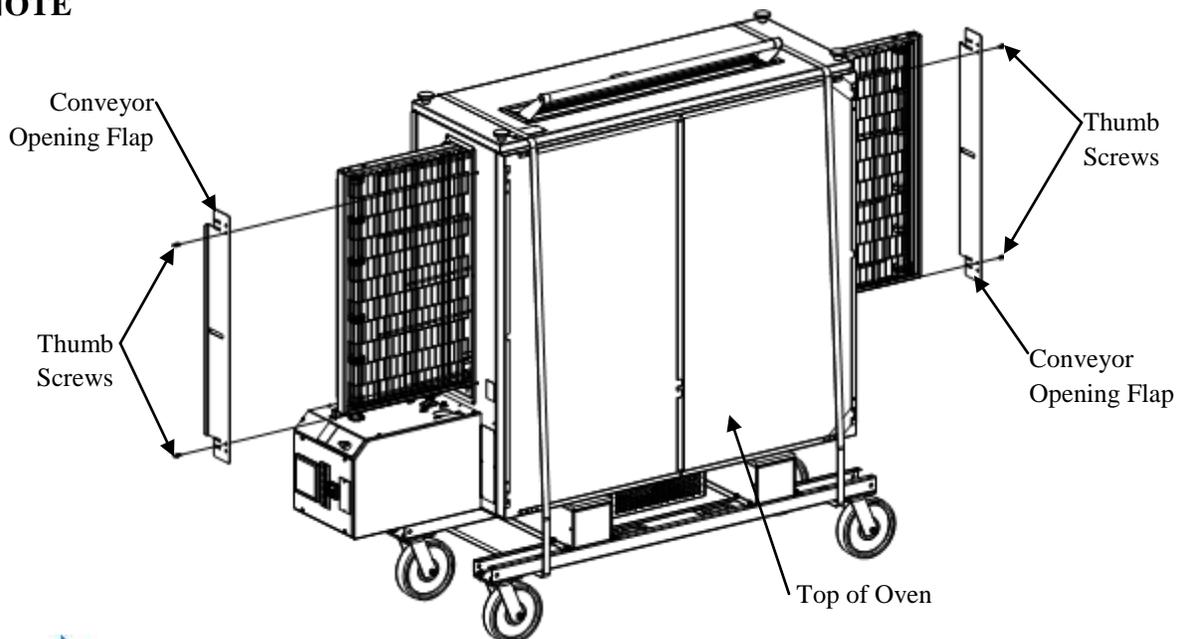


Prepare the Oven for Lifting

1. Remove the two conveyor opening flaps and thumbscrews from the oven. Set them aside for reinstallation later.
2. Install the lifting plates in place of the conveyor opening flaps using the same thumbscrews.

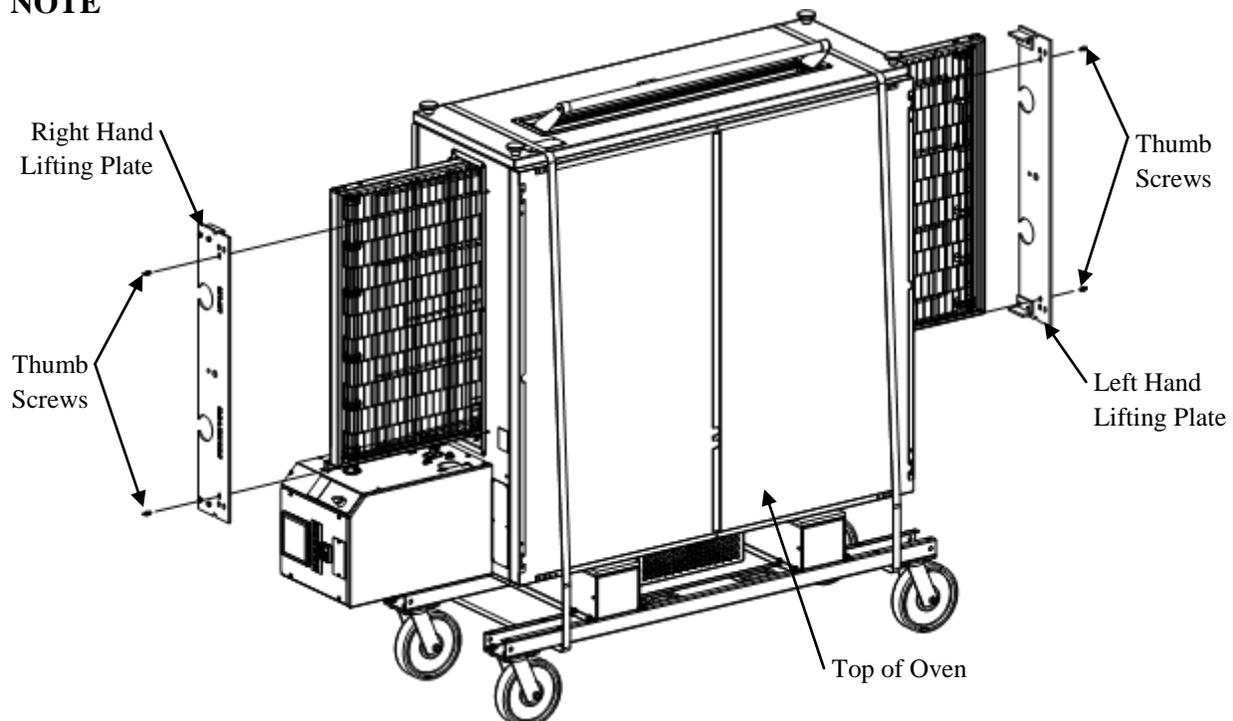
 If using an AVI Hood System, conveyor flaps are not needed.

NOTE



 The Lifting Pipe hole, marked for the appropriate oven size, must be installed closest to the control box.

NOTE



Lifting Jack Setup

Each lifting jack consists of two (2) parts; the pole/winch assembly, and the tripod base.

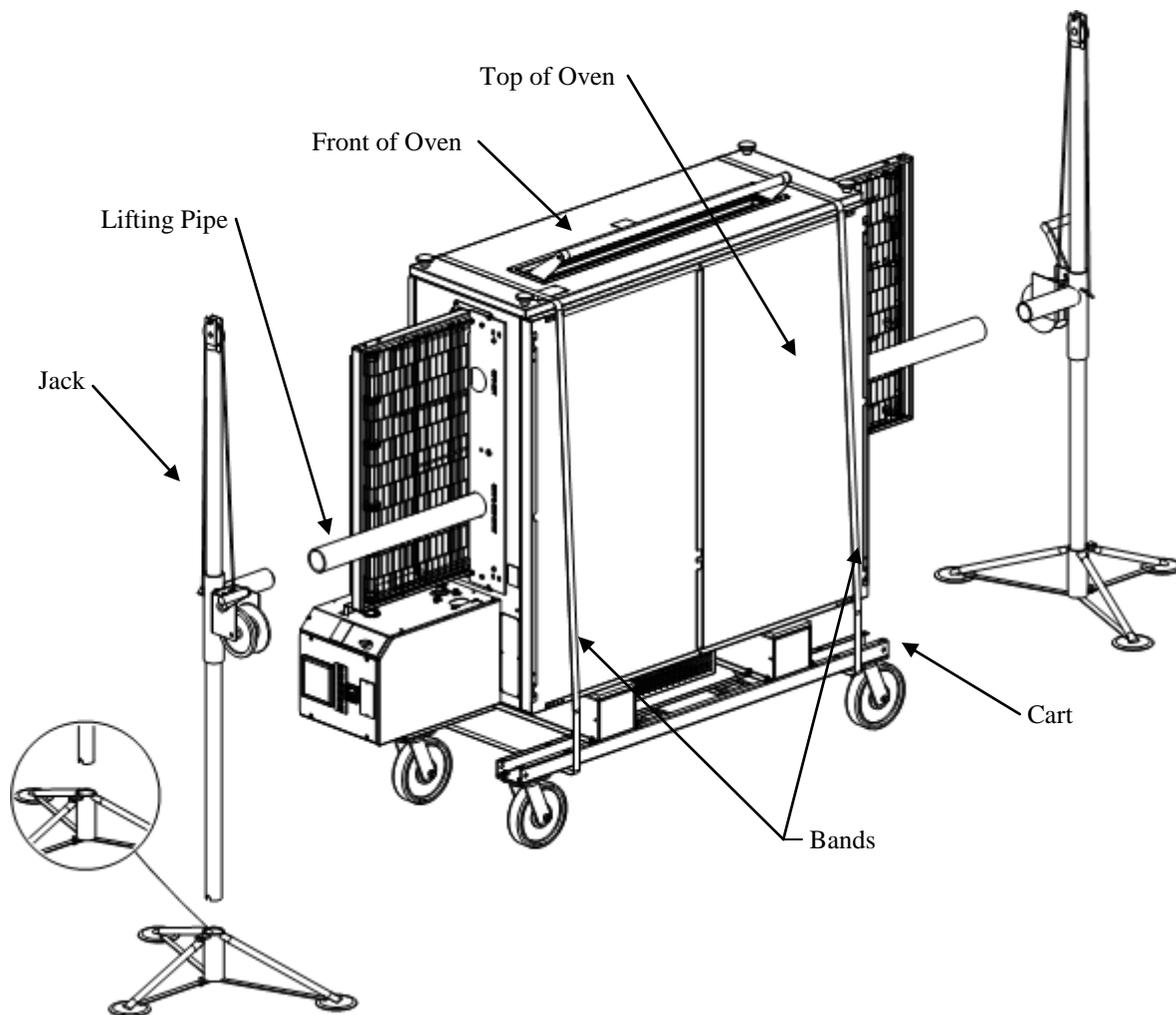
1. Place the bottom of the pole into the socket of the tripod base.



WARNING

- Make sure that the notch on tube of the winch assembly is aligned with the pin in the tripod base as shown. These alignments are important and keep the jack aligned properly.
- Check for smooth operation. The cable should not be pinched and should pass smoothly over the pulley on top of the pole assembly.
- Inspect cable prior to each use.
- If cable is frayed or shows signs of excessive wear and tear, DO NO USE until cable is replaced.
- At a minimum replace the cable annually with wire rope that meets or exceeds the jack manufacturer's specifications.
- Do not exceed the stated capacity of the jack.

2. Insert the lifting pipe through the oven bake chamber. Make sure the pipe is centered.



Illustrations shown with XLT Oven on Cart, instructions also apply when oven is crate shipped.

Stacking the Ovens

1. Fully insert the lifting jacks into the lifting pipe.

**WARNING**

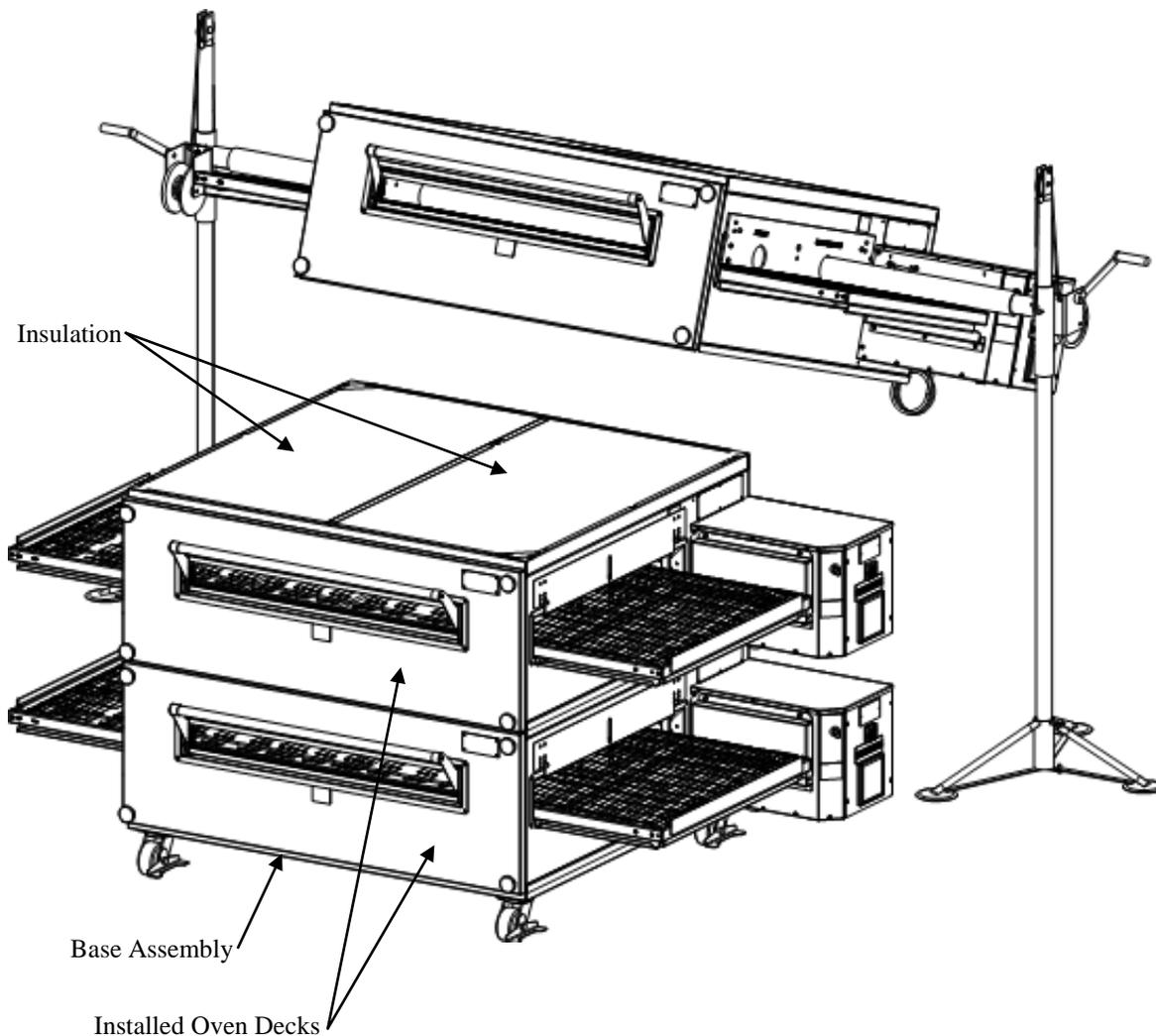
- Failure to engage properly can result in damage, injury, or death from a falling oven.

2. Raise the oven high enough to clear the cart or the skid.

**WARNING**

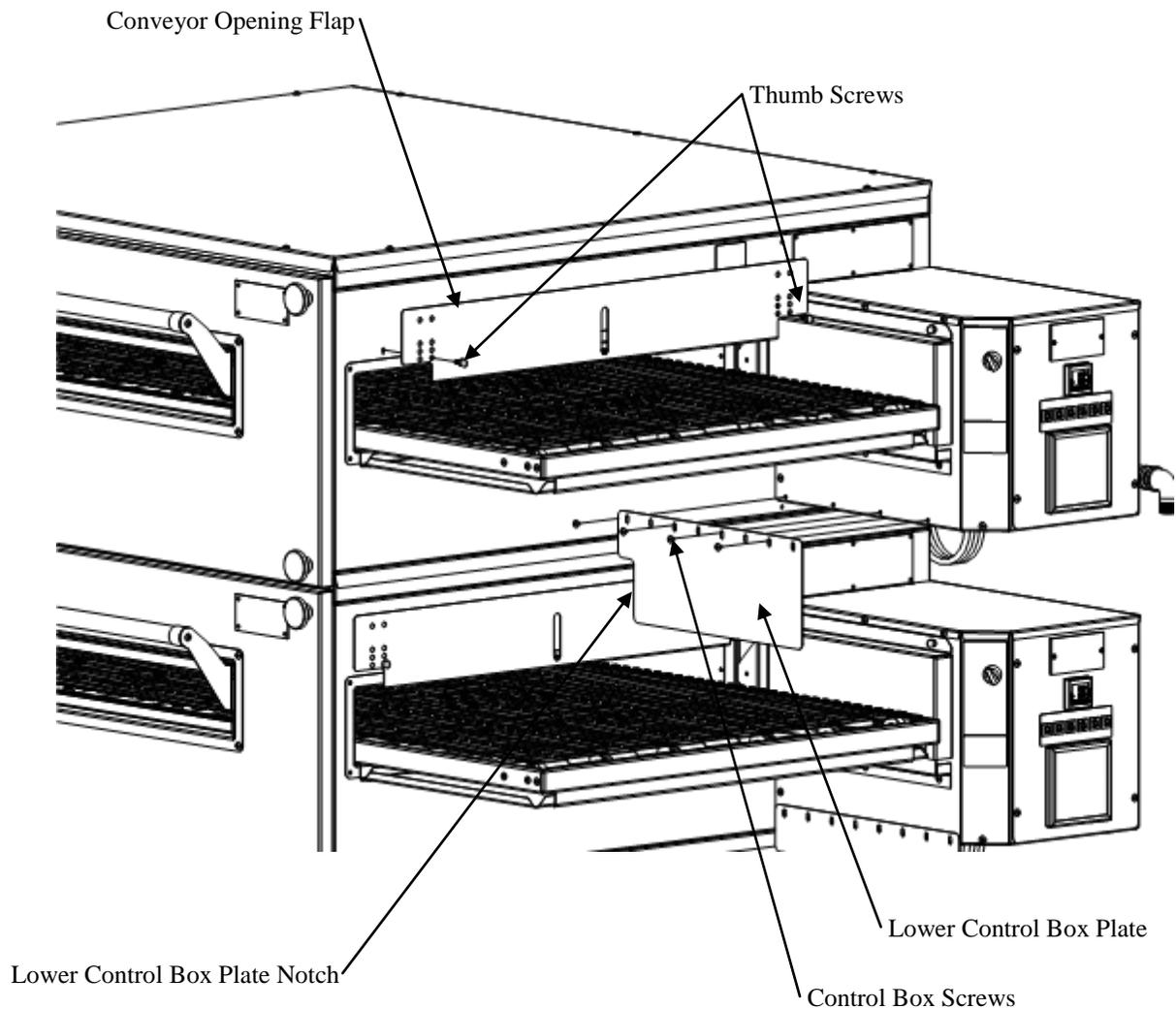
- Both jacks should be raised in unison, otherwise they may bind and a dangerous situation may develop.
- Do not put any part of yourself under the oven at any time.
- The oven is top heavy. Be careful!

3. Remove the cart or skid.
4. Rotate the oven as shown.
5. Roll the appropriate oven base underneath the oven.
6. Lower the oven onto the base.
7. Repeat as necessary



Stacking the Ovens

8. Reinstall the conveyor opening flaps in each oven deck. A series of holes in the flaps allow adjustment for different heights of food product.
9. Control box heat shields need to be installed on any multi-deck installation. For xx70 models, they are required on both ends. To install, remove the four (4) control box screws under the conveyor. Place the panel with the notch towards the bake chamber. Line up the slots with the existing holes and replace the screws.



Electric Supply Requirements for Australian, Standard. & World Ovens



CAUTION

Australian Ovens

- In Australia, the electrical service must be installed in accordance with the latest version of AS/NZS 3000 wiring rules.



**HIGH
VOLTAGE**

Standard Ovens

Electrical Grounding Instructions

This appliance is equipped with a three-prong (grounding) plug for your protection against shock hazard and should be plugged into a properly grounded three-prong receptacle. Do not cut or remove the grounding prong from this plug.

- When installed, the appliance must be electrically grounded in accordance with local codes, or in the absence of local codes, with the National Electrical Code, ANSI/NFPA 70, or the Canadian Electrical Code, CSA C22.2, as applicable.

World Ovens

- This appliance is equipped with a ground lug for your protection against shock hazard and must be properly grounded.
- When installed, the appliance must be electrically grounded in accordance with local codes.

Physical Location & Spacing Requirements

XLT Ovens are suitable for installation on either combustible or non-combustible floors, and adjacent to either combustible or non-combustible walls. The motor cover is designed to provide the proper clearance to the back of the oven. The minimum side clearances are 6in. / 150mm, measured from the end of the conveyor.



All installations must conform to local building and mechanical codes.

NOTE

Gas Supply Requirements for Australian, Standard. & World Ovens

The gas supply shall have a gas meter and regulator large enough to handle all of the gas appliances, such as the furnace, water heater, and ovens in operation at the same time. Add up all of the Btu/kw/MJ ratings to determine the total load. The installation must conform to local building codes.

1. The appliance and its individual shutoff valve must be **disconnected** from the gas supply piping system during any pressure testing of that system at test pressures in **excess** of 3.5 kPa or ½-psi.
2. The appliance must be **isolated** from the gas supply piping system by closing its individual manual shutoff valve during any pressure testing of the gas supply piping system at test pressures **equal to or less than** 3.45 kPa or ½-psi.

Minimum and maximum inlet pressures are as follows:

Gas Type	Min kPa	Max kPa	Min "WC	Max "WC
Natural	1.5	3.5	6.0	14
LP	2.75	3.5	11.5	14

- For Australia, if installing with a flexible hose assembly, the assembly must be certified to AS/NZS 1869, and be Class B or D.
- For Standard Ovens, if installing with a flexible gas hose, the installation must comply with either ANSI Z21.69 or CAN/CGA-6.16 and a disconnect device complying with either ANSI Z21.41 or CAN-6.9.
- The installation must conform with local building codes, or in the absence of local codes, with the National Fuel Gas Code, ANSI Z223.1, latest version, Natural Gas Installation Code, CAN/CGA-B149.1, or the Propane Installation Code, CAN/CGA-B149.2, as applicable.



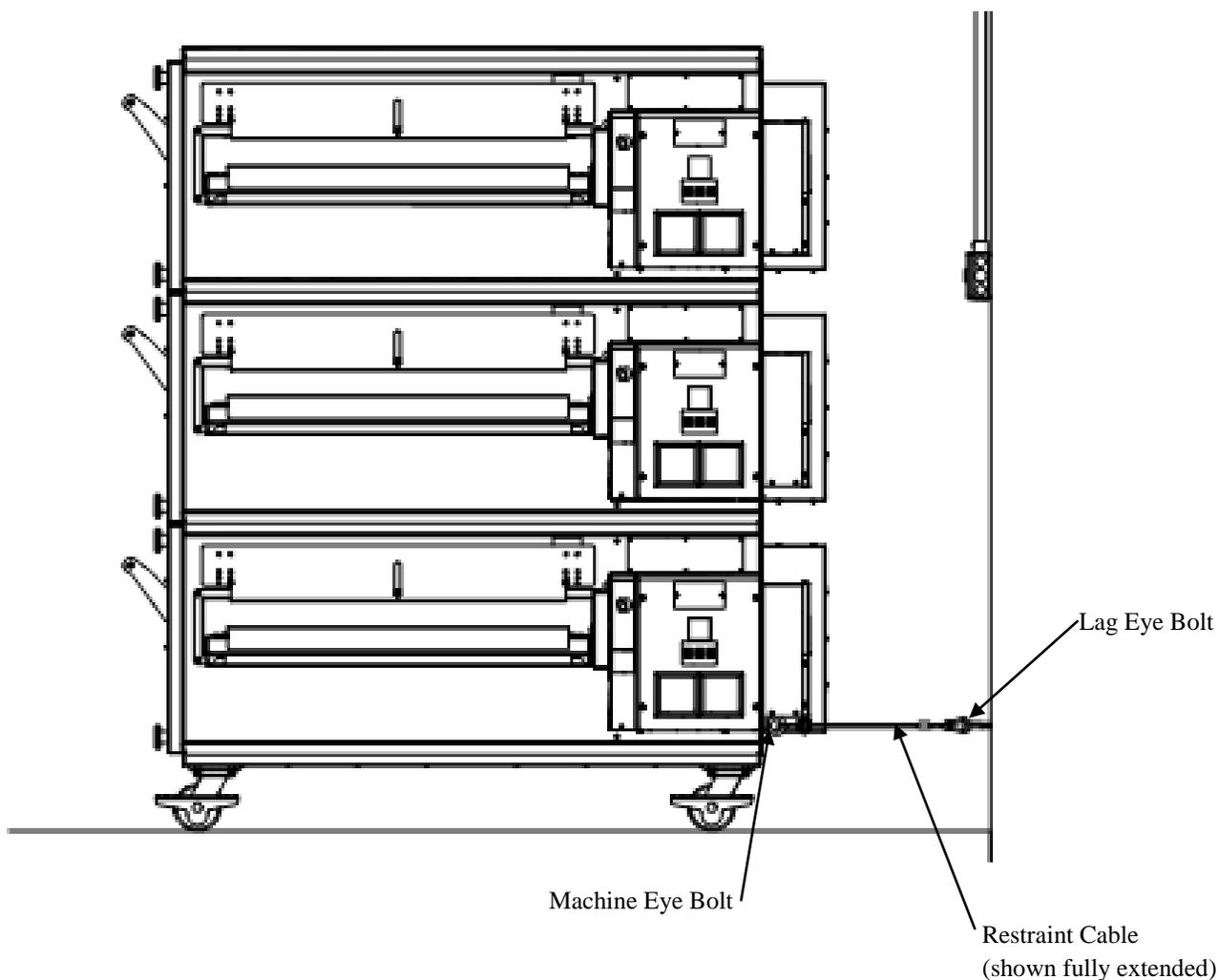
All installations must conform to local building and mechanical codes.

NOTE

Restraint

Because all ovens are equipped with casters, all installations must be configured with a restraint to limit the movement of the oven without depending on the gas connector and quick-disconnect device or its associated piping, and the electric power supply cord to limit the oven movement. One (1) restraint kit, which includes two (2) eye bolts and a cable, is required for each oven stack, regardless if used on a single, double, or triple configuration. The machine eye bolt should be installed in the lowest hole of the back wall on the control end of the lowest oven in the stack. The lag eye bolt must be installed into a structural member of a wall.

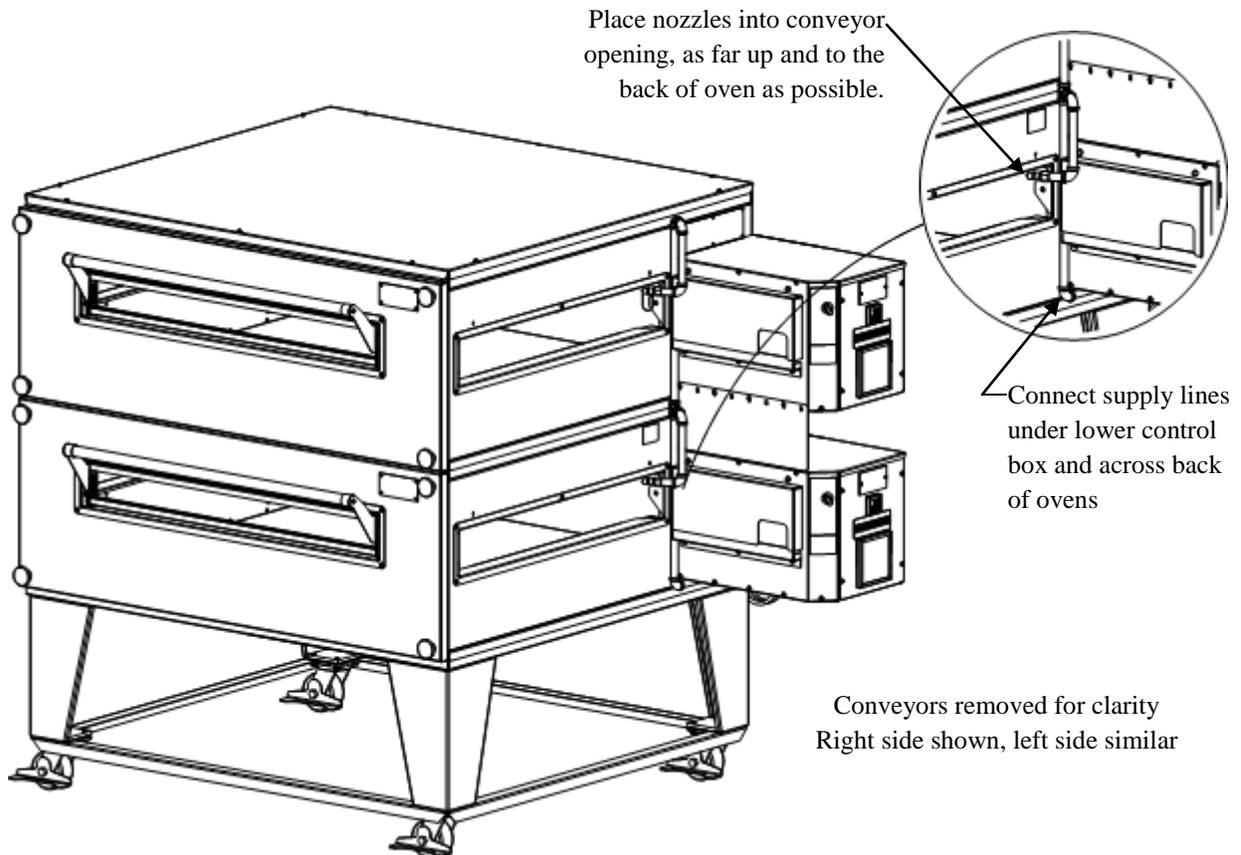
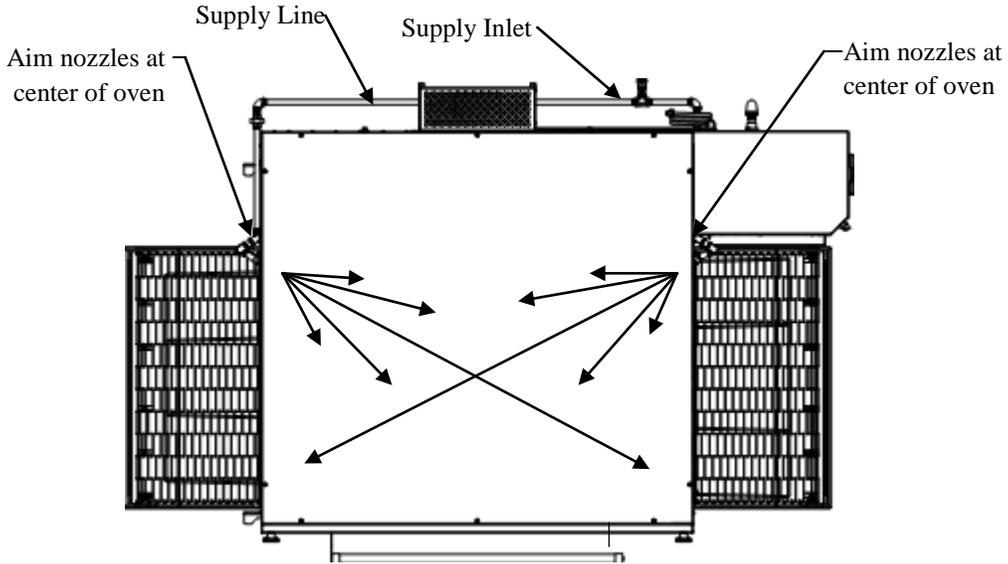
Upon completion of performing any service or cleaning functions that require removal of the restraint, insure that it is correctly re-attached to the oven. In Australia, install the restraint cable in accordance with AS 5601, latest version.



Oven Installation

Fire Suppression

The requirement for fire suppression systems vary by location and the authority having jurisdiction. Contact XLT Ovens for fire suppression kit availability. Crumb trays and chain guards must be removable without disturbing fire suppression piping.



Conveyors removed for clarity
Right side shown, left side similar

Ventilation Requirements

Most gas burning appliances produce CO (carbon monoxide), a poison. CO and heat must be vented to the outside. A powered ventilation hood is required to remove these. The hood and HVAC installation must meet local building and mechanical codes. In Australia, a ventilation hood should be installed in accordance with AS5601 Gas Installation. Requirements vary throughout the country depending on the location by city. Proper ventilation is the oven owner's responsibility. The AVI Hood system is designed to meet all requirements on XLT ovens and it is our recommendation that this system be used.

Ventilation Guidelines

Obtain information from the authority having jurisdiction to determine the requirements for your installation. Your ventilation hood supplier and HVAC contractor should be contacted to provide guidance. An air balance test is highly recommended, performed by a licensed contractor. A properly engineered and installed ventilation hood and HVAC system will expedite approval, reduce oven maintenance cost, and provide a more comfortable working environment.

Ventilation Performance Test

After the oven and ventilation hood have been installed and are operating, a smoke candle can be used to "see" if the heat and products of combustion are being properly exhausted. Smoke candles can be purchased through HVAC contractors. The test procedure is outlined below.

- The oven must be operating at 450°-500°F / 232°-260°C.
- The conveyor must be turned off.
- The ventilation hood exhaust fan must be turned on.
- Put a smoke candle in a pan on the conveyor belt at the center of the oven.
- Observe the smoke pattern coming out of the oven.

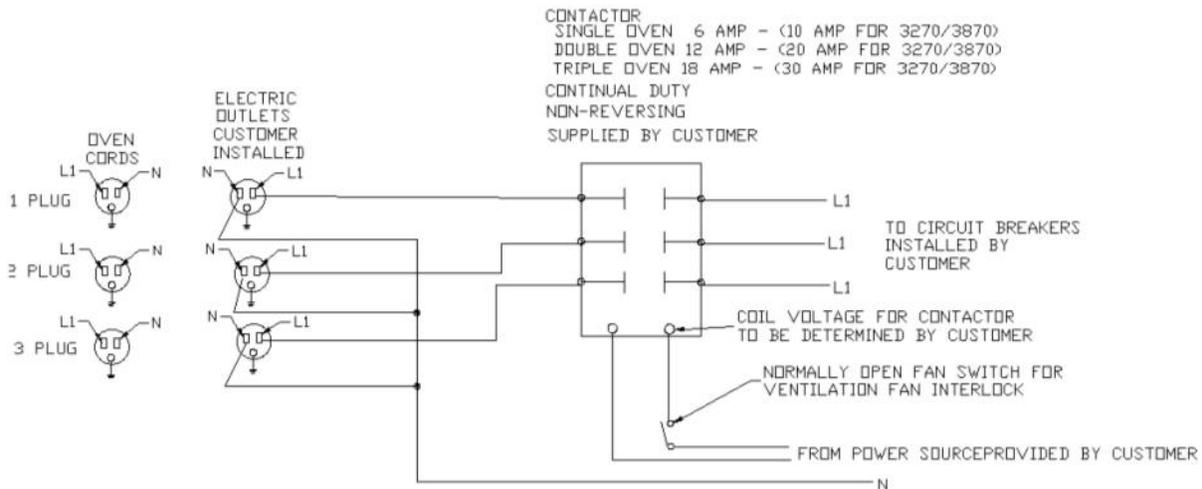
The ventilation hood must capture all of the smoke from the oven. An air balance test can help determine the proper amount of exhaust and make-up air flow rates.

Oven & Hood Interlock

An interlock system between the oven and hood is highly recommended and is required in some jurisdictions. AVI hoods have this feature.

Non-AVI Hood Interlock

The following is a recommended method of providing an interlock system (if required), between the exhaust fan and ovens. The circuit shown will stop the ovens from operating if the exhaust fan fails and also prevent the ovens from starting if the exhaust fan is not first operating. It is recommended that the fan interlock switch be located on the exhaust fan itself rather than the motor to prevent a false run signal in the case of a broken fan drive belt. It is the customer's responsibility to have the interlock system installed by a licensed electrician and that it meets all required local codes.



CAUTION

Always use the proper oven shut down procedure for turning ovens off. Do not turn off the exhaust fan until cool down sequence on oven is completed. The use of the exhaust fan control to shut off ovens manually may void the warranty on ovens.

Oven Initial Start-Up

All XLT ovens are test-fired at the factory. Operation is verified, and adjustments are made to ensure proper function. However, field conditions are sometimes different than factory conditions, such as voltage and fuel pressure. These variables make it necessary to have an authorized service technician verify operation and make field adjustments if needed. The following items must be checked and verified to meet the specifications and requirements stated in this manual prior to the oven being commissioned:

- Fuel line pipe size
- Fuel pressure (static)
- Fuel pressure (dynamic)
- Proper electrical connections
- Proper ventilation

The following Initial Start-Up Checklist must be completed (both sides) at time of installation, signed by the Customer and returned to XLT Ovens to initiate Warranty Policy.

Oven Initial Start-up Checklist - Remove & Return to XLT Ovens

Date of installation: _____
 Installed by: XLT installer: _____
 Other: Company: _____
 Installer: _____
 Phone #: _____

Oven Size: 1832 2440 3240 3255

3270 3855 3870

Heat Source: Natural Gas LP Electric

Facility Information

Store Name: _____

Physical Address: _____

City: _____ State: _____ Zip: _____

Phone #: _____

E-mail: _____

Contact Person: _____

Freestanding Strip Mall New construction

Existing location Remodel

Oven Location: Against wall In corner Island

I&O Manual presented to store operator: Yes No

Utilities present at installation: Electric Gas

On-Site dough prep: Yes No

Air-born contaminates: Flour Cornmeal Grease

Other _____

HVAC/Contractor Contact: _____

Address: _____

City: _____ State: _____ Zip: _____

Phone #: _____ Cell: _____

E-mail: _____

Restraint Cable Installed (bottom oven): Yes No

Customer or store operator shown how to disassemble and clean ovens and hood: Yes No _____

Test cook performed: Yes No _____

Ovens ran for 20 min. Yes No _____

All features explained: Yes No _____

Damage to ovens or hood during shipment or installation: _____

Missing parts: _____

Customer Signature: _____

Electrical

Electrical supply accessible after installation: Yes No

Separate electrical circuit per oven: Yes No

Electrical Supply (per oven): _____ Volt _____ Amp
 _____ Hz _____ Phase

Gas N/A

Inlet Pressures: Static: _____ " W/C

Dynamic (full burn): _____ " W/C

Gas Line Size: _____ Teflon Tape: Yes No

List all gas appliances in store (with gas requirements)

XLT Oven #1 _____

XLT Oven #2 _____

XLT Oven #3 _____

Total gas requirements for store: _____

Regulator Capacity: _____

Meter Capacity: _____

Shut off valve accessible after installation: Yes No

One shut off valve per oven: Yes No

Gas line purged of air prior to installation: Yes No

Fittings tested for gas leaks: Yes No

Results: _____

Ventilation

Hood manufacturer AVI Other (specify) _____

Interlock system for non-AVI hood: Yes No

Air balance test performed: Yes No

Smoke test performed: Yes No

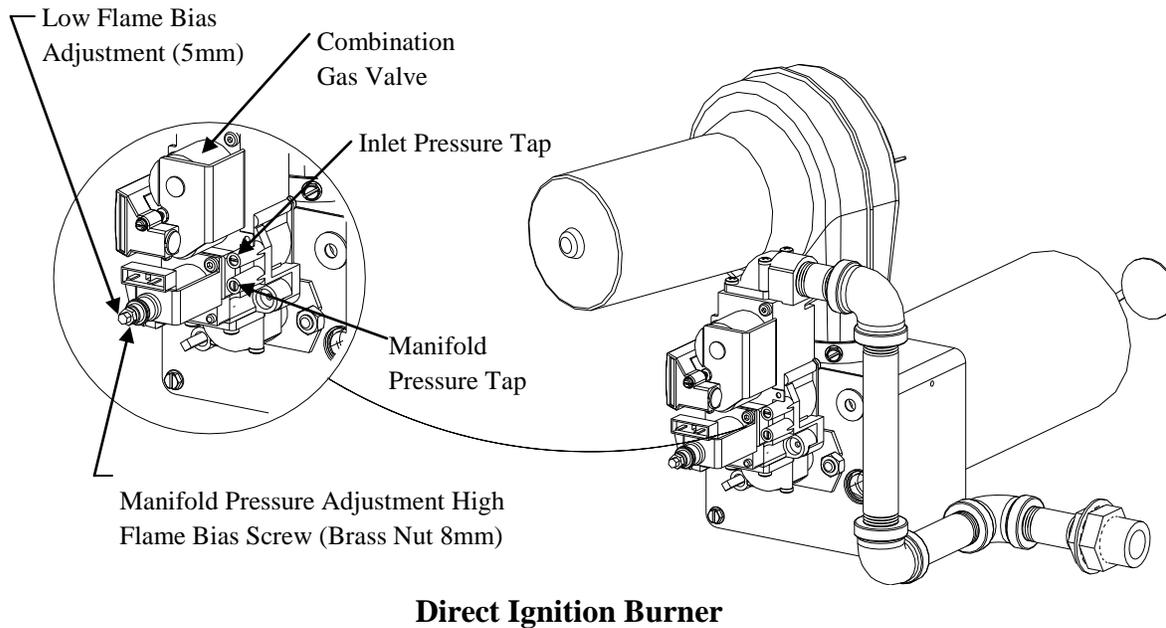
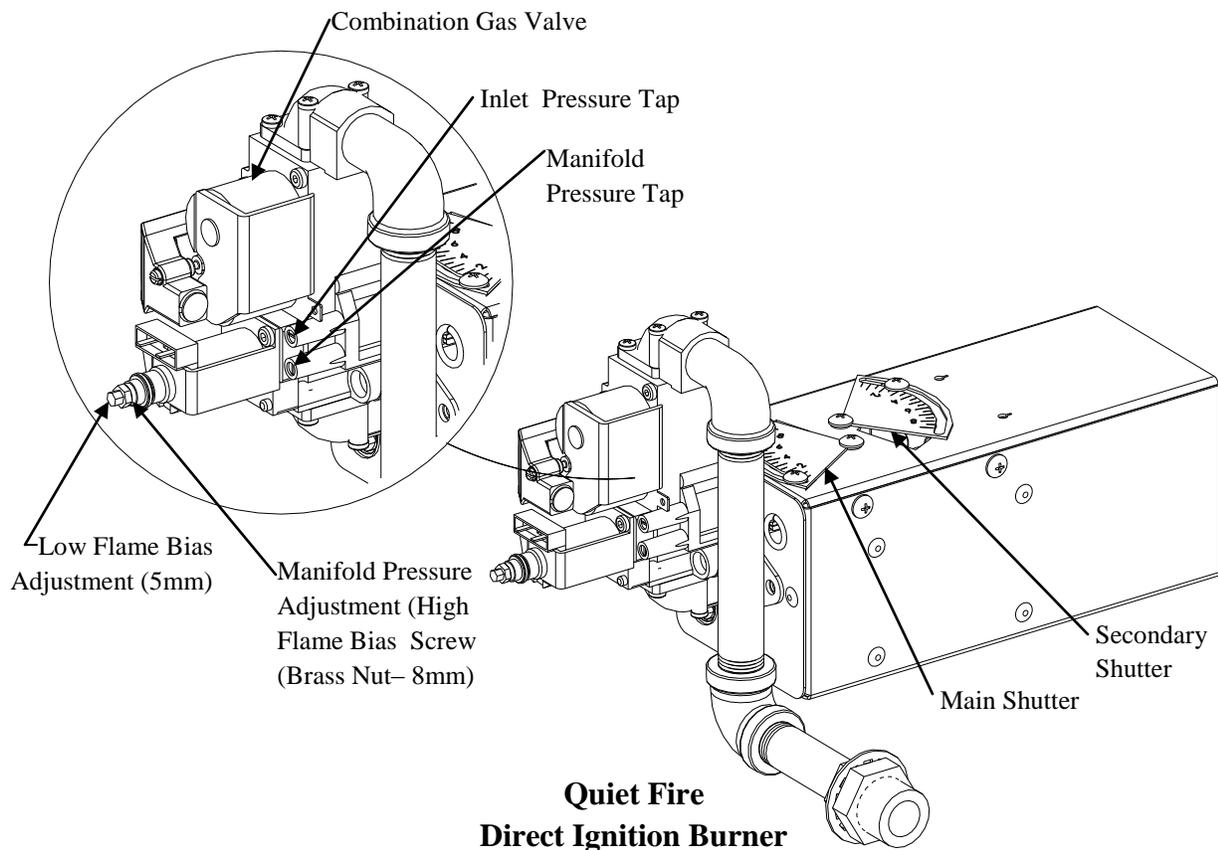
Return to: XLT Ovens
 PO Box 9090
 Wichita, KS 67277
 FAX: 316-943-2769

Oven Initial Start-up Checklist - Remove & Return to XLT Ovens

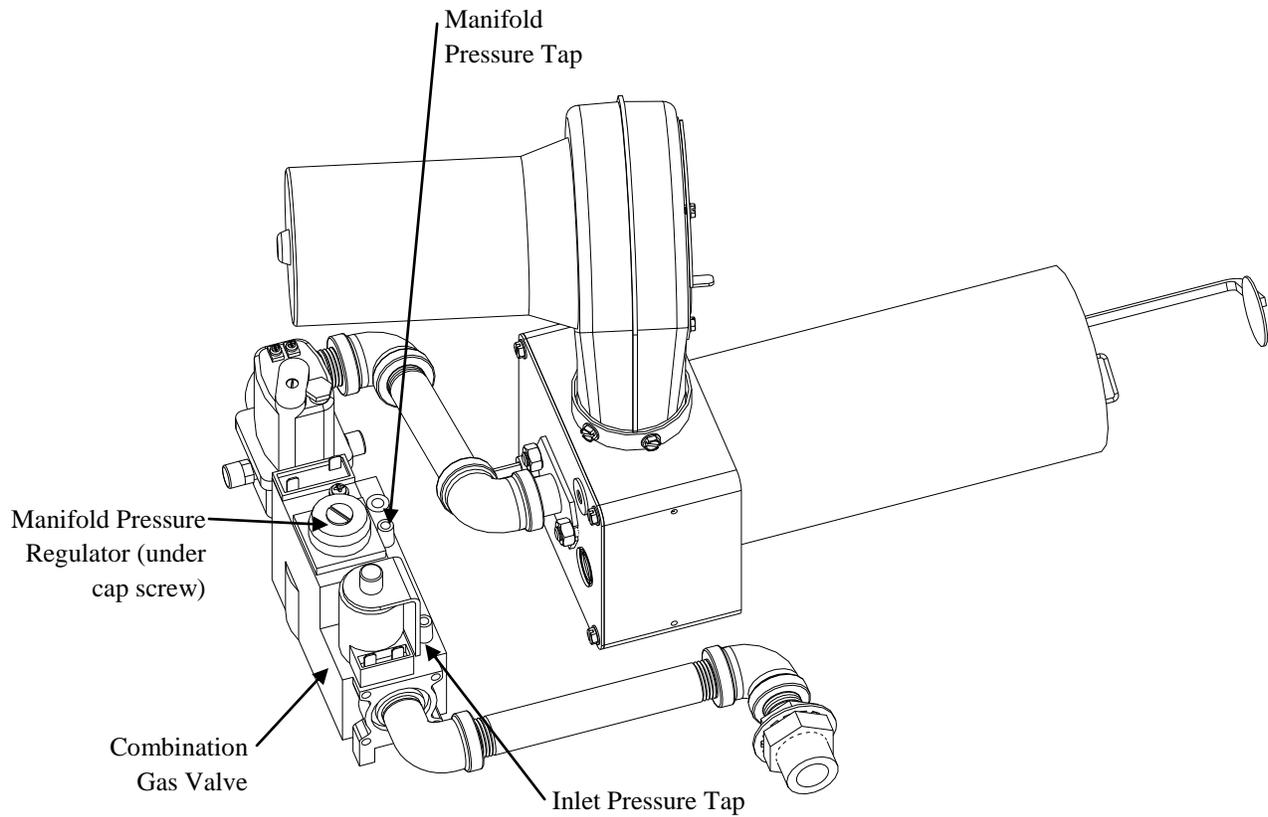
Top Oven	<input type="checkbox"/> N/A
Model #: _____	_____
Serial #: _____	_____
<input type="checkbox"/> Thin Crust <input type="checkbox"/> Thick Crust <input type="checkbox"/> Pan <input type="checkbox"/> Screen	_____
Other Product: _____	_____
Front Belt Speed: _____ min _____ sec	_____
Back Belt Speed: _____ min _____ sec	<input type="checkbox"/> N/A
Good Belt Tension: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Conveyor Belt Direction: <input type="checkbox"/> L to R <input type="checkbox"/> R to L	_____
Set Point Temp: Left _____ Right _____	_____
Fingers in proper location: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Crumb Trays: <input type="checkbox"/> Solid <input type="checkbox"/> Perforated <input type="checkbox"/> None	_____
Fire Suppression Installed: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Right Burner: <input type="checkbox"/> Square <input type="checkbox"/> Round	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____
Left Burner: <input type="checkbox"/> N/A	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____

Middle Oven	<input type="checkbox"/> N/A
Model #: _____	_____
Serial #: _____	_____
<input type="checkbox"/> Thin Crust <input type="checkbox"/> Thick Crust <input type="checkbox"/> Pan <input type="checkbox"/> Screen	_____
Other Product: _____	_____
Front Belt Speed: _____ min _____ sec	_____
Back Belt Speed: _____ min _____ sec	<input type="checkbox"/> N/A
Good Belt Tension: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Conveyor Belt Direction: <input type="checkbox"/> L to R <input type="checkbox"/> R to L	_____
Set Point Temp: Left _____ Right _____	_____
Fingers in proper location: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Crumb Trays: <input type="checkbox"/> Solid <input type="checkbox"/> Perforated <input type="checkbox"/> None	_____
Fire Suppression Installed: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Right Burner: <input type="checkbox"/> Square <input type="checkbox"/> Round	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____
Left Burner: <input type="checkbox"/> N/A	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____

Bottom Oven	<input type="checkbox"/> N/A
Model #: _____	_____
Serial #: _____	_____
<input type="checkbox"/> Thin Crust <input type="checkbox"/> Thick Crust <input type="checkbox"/> Pan <input type="checkbox"/> Screen	_____
Other Product: _____	_____
Front Belt Speed: _____ min _____ sec	_____
Back Belt Speed: _____ min _____ sec	<input type="checkbox"/> N/A
Good Belt Tension: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Conveyor Belt Direction: <input type="checkbox"/> L to R <input type="checkbox"/> R to L	_____
Set Point Temp: Left _____ Right _____	_____
Fingers in proper location: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Crumb Trays: <input type="checkbox"/> Solid <input type="checkbox"/> Perforated <input type="checkbox"/> None	_____
Fire Suppression Installed: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Right Burner: <input type="checkbox"/> Square <input type="checkbox"/> Round	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____
Left Burner: <input type="checkbox"/> N/A	_____
Main Shutter Setting: _____	_____
Secondary Shutter Setting: _____	_____
Low flame after temperature drop: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
Was Combination Valve adjusted: <input type="checkbox"/> Yes <input type="checkbox"/> No	_____
High Bias: _____ Low Bias: _____	_____



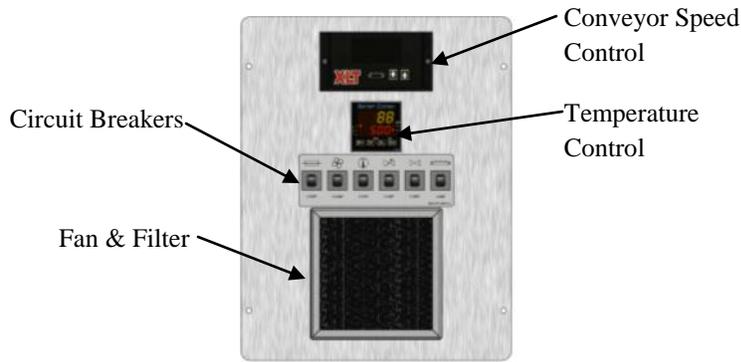
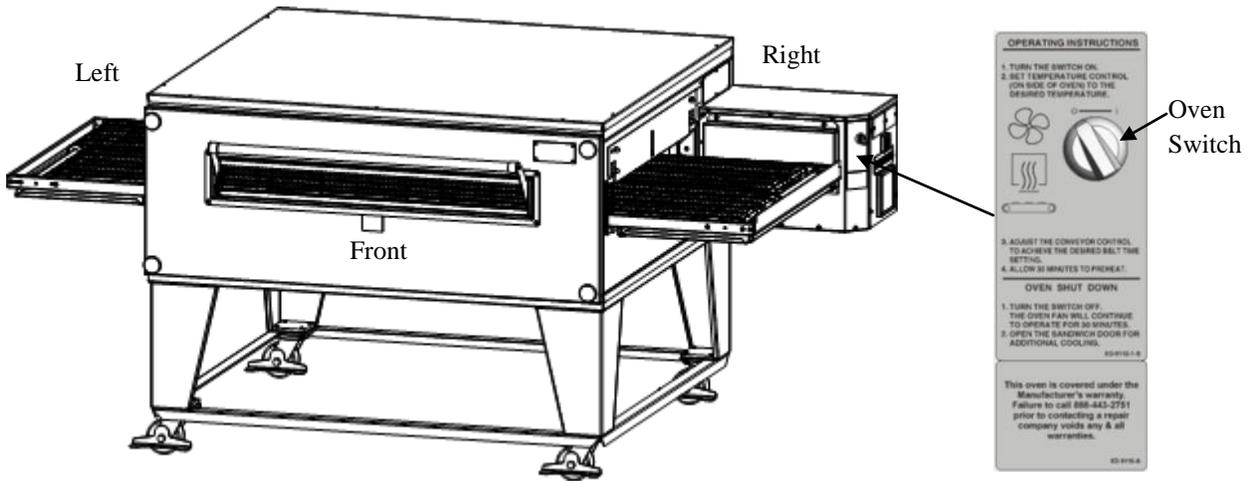
Contact XLT Ovens or your designated representative to make all gas pressure adjustments.

**Direct Ignition Burner - Australia**

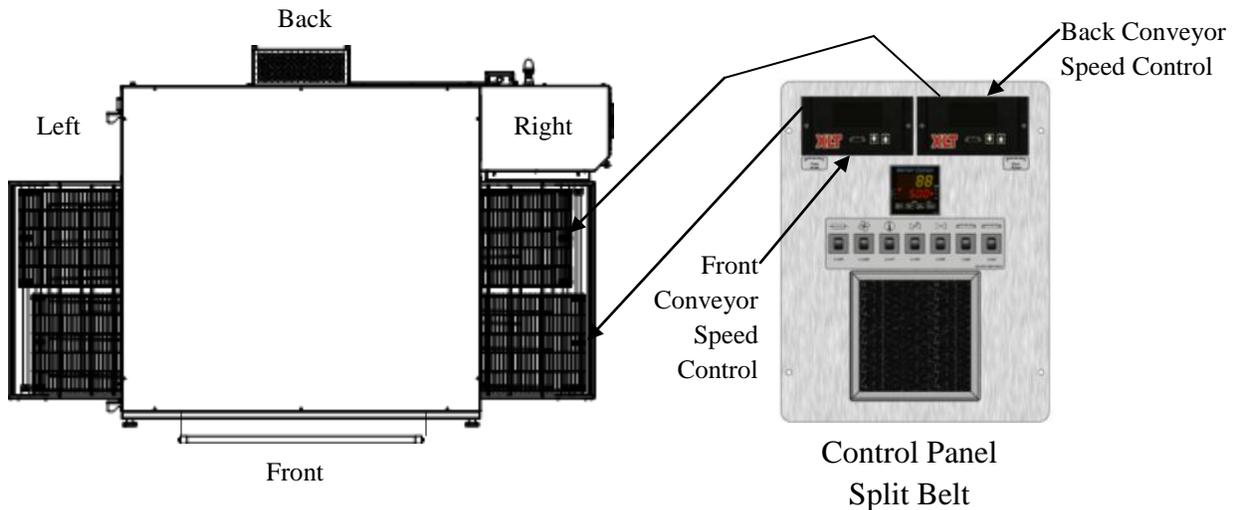
Contact XLT Ovens or your designated representative to make all gas pressure adjustments.

Oven Operator Controls

Models 1832, 2440, 3240, 3255 & 3855
Single oven shown, Double and Triple Stack similar



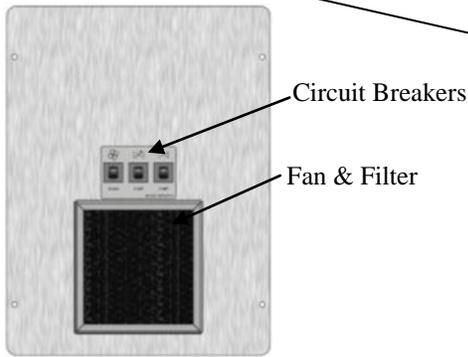
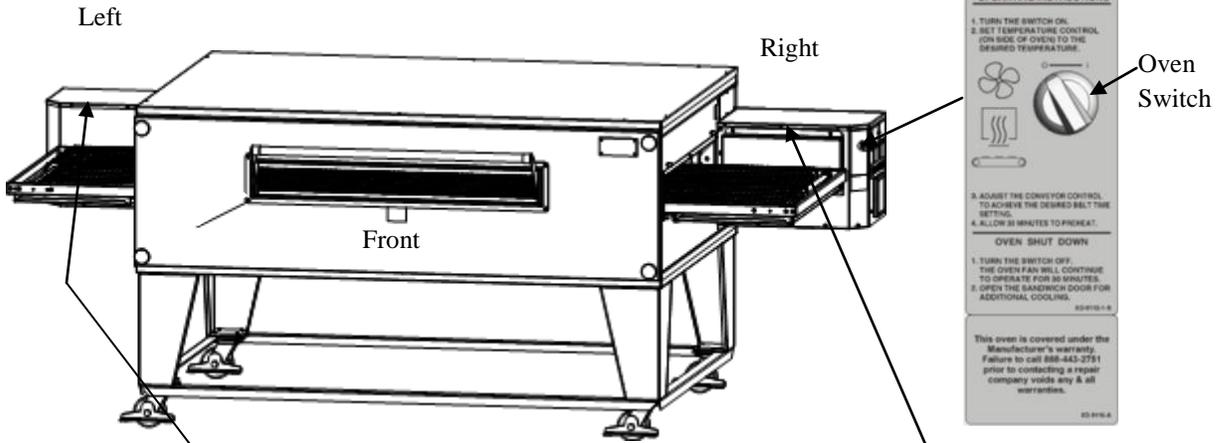
Control Panel Standard Belt



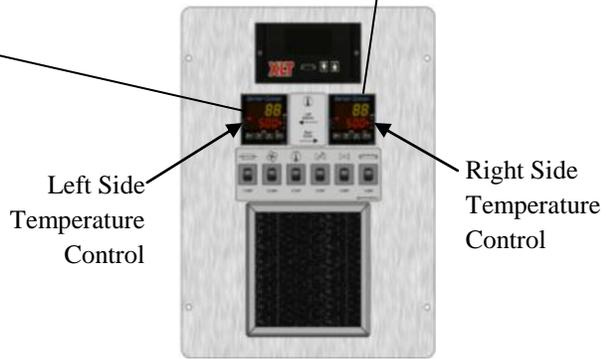
Oven Operator Controls

Models 3270 & 3870

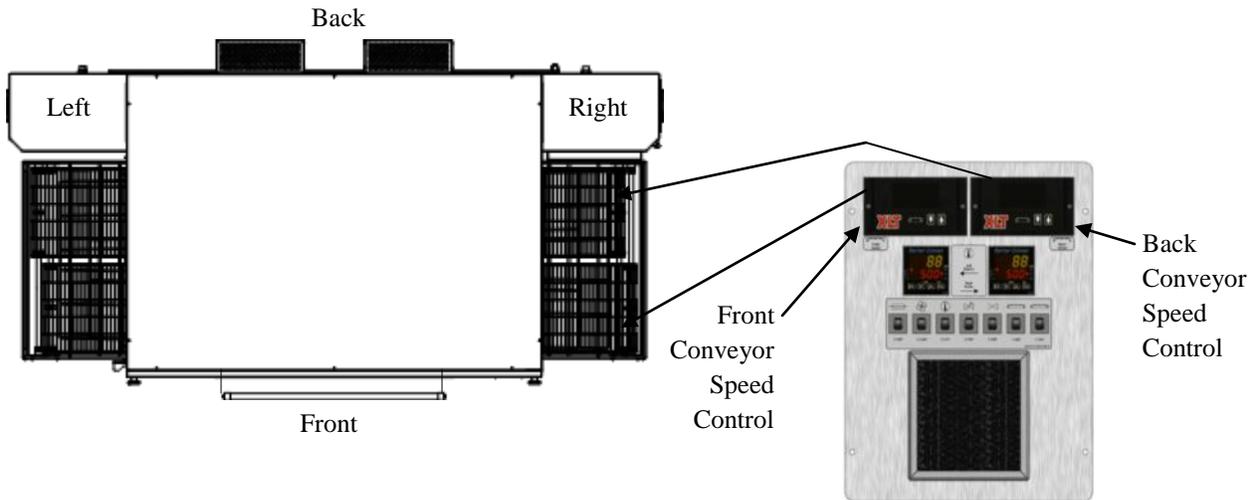
Single oven shown, Double and Triple Stack similar



Left Side Control Panel
(Standard & Split Belt)



Right Side Control Panel
Standard Belt



Right Side Control Panel
Split Belt



This oven is not capable of being safely placed in operation in the event of a power failure. No attempt should be made to operate this oven during power failure.

CAUTION

1. Turn the switch on. The fan(s) will energize, the temperature and conveyor control will light up, and the conveyor will start to move.
2. Adjust the temperature controller set-point to the desired temperature. To change the oven set-point temperature, press and hold either the UP or DOWN key. The keys needs to be depressed for at least 2 seconds. After UP or DOWN key inactivity, the display will blink once indicating that the set point temperature has been set. The FUNC and MAN keys are used at the factory to program the variables in the controller. It is recommended that the FUNC and MAN keys be left alone. If either of these keys has been pressed, simply press them again until the display matches the Figure shown. It may take several key-presses to cycle through all the variables.
3. Adjust the conveyor control to the desired belt time. To change the belt time, press and hold either the UP or DOWN key.
4. To turn the conveyor ON or OFF, push both arrow keys simultaneously.
5. Allow about 30-45 seconds for the burner to ignite. You should hear combustion and see the indicated temperature rise.
6. If the burner does not ignite, turn the switch off, wait five (5) minutes, and repeat step 1. If it does not light after three (3) attempts, please see the troubleshooting section of this manual.
7. Allow about 30 minutes for the oven to reach the desired temperature.
8. To turn the oven off, turn the switch to the off position. Do not unplug the oven from electrical power. The oven is equipped with an automatic cool down feature that allows the fan to run until the oven is cooled to a safe level (approximately 30 minutes).



Actual Temperature
Set Point Temperature

Up Key
Down Key

Temperature Control



Belt Time (MIN: SEC)

Up and Down Arrow Buttons

Conveyor Control



NOTE

The Conveyor Control is factory preset at 1:30 minute minimum and 17:00 minutes maximum. If a belt time is desired that is outside these limits, contact XLT Ovens for proper service procedures.

As with any appliance, periodic cleaning and maintenance is required. Many factors affect this schedule such as product mix and hours of usage. An example schedule is included.

Your XLT oven is constructed of stainless steel. Most commercial cleaning agents may be used safely on all stainless steel surfaces. Check application restrictions on product label prior to usage. Observe recommended precautionary and safety measures as dictated by the product manufacturer.

Do not use abrasive cleaners or abrasive pads as they can scratch stainless steel surfaces.

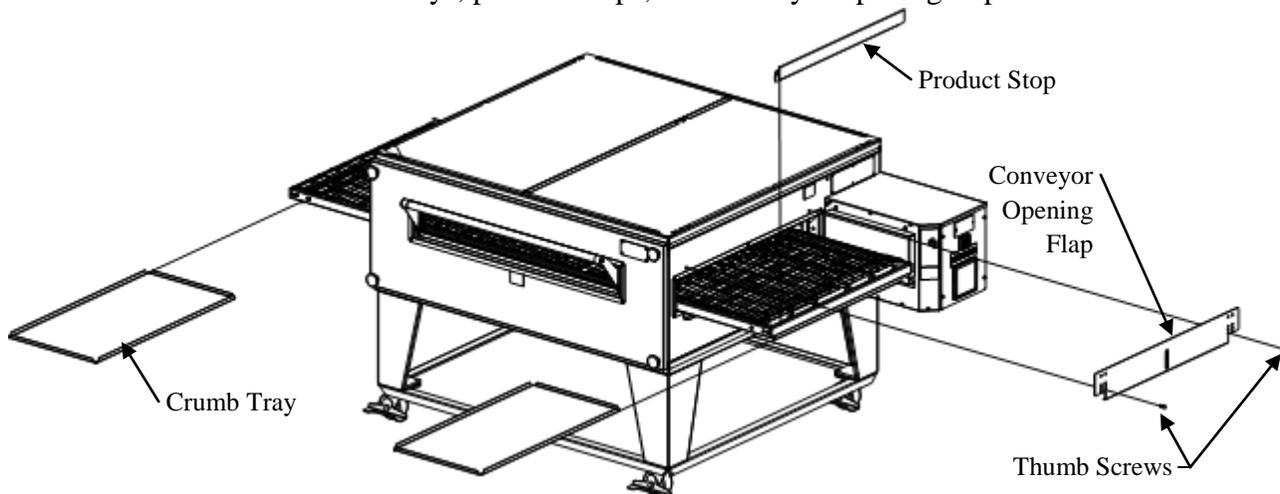
Example Cleaning Schedule for XLT Ovens				
Task	Daily	Weekly	Monthly	Semi- annual
Wipe down front	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Clean sandwich window	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wipe down sides	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wipe down top	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wipe down control box	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wipe down motor cover	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Empty Crumb Trays	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Remove large debris from conveyor	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Clean / replace cooling fan filters		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Clean finger covers			<input type="checkbox"/>	<input type="checkbox"/>
Clean bake chamber floor			<input type="checkbox"/>	<input type="checkbox"/>
Clean bake chamber walls			<input type="checkbox"/>	<input type="checkbox"/>
Clean bake chamber top			<input type="checkbox"/>	<input type="checkbox"/>
Clean inside of face panel			<input type="checkbox"/>	<input type="checkbox"/>
Clean control box sides and top			<input type="checkbox"/>	<input type="checkbox"/>
Clean control box face and switches			<input type="checkbox"/>	<input type="checkbox"/>
Clean conveyor				<input type="checkbox"/>
Clean finger bodies				<input type="checkbox"/>
Deep clean oven chamber				<input type="checkbox"/>
Clean Main Fan Motor/Motor Cover				<input type="checkbox"/>



WARNING

Oven must be cool and the electric cord unplugged before any cleaning is done.

1. Remove and clean crumb trays, product stops, and conveyor opening flaps.



2. Hold the front panel in place while removing the four (4) front panel knobs. Then remove and clean the front panel.



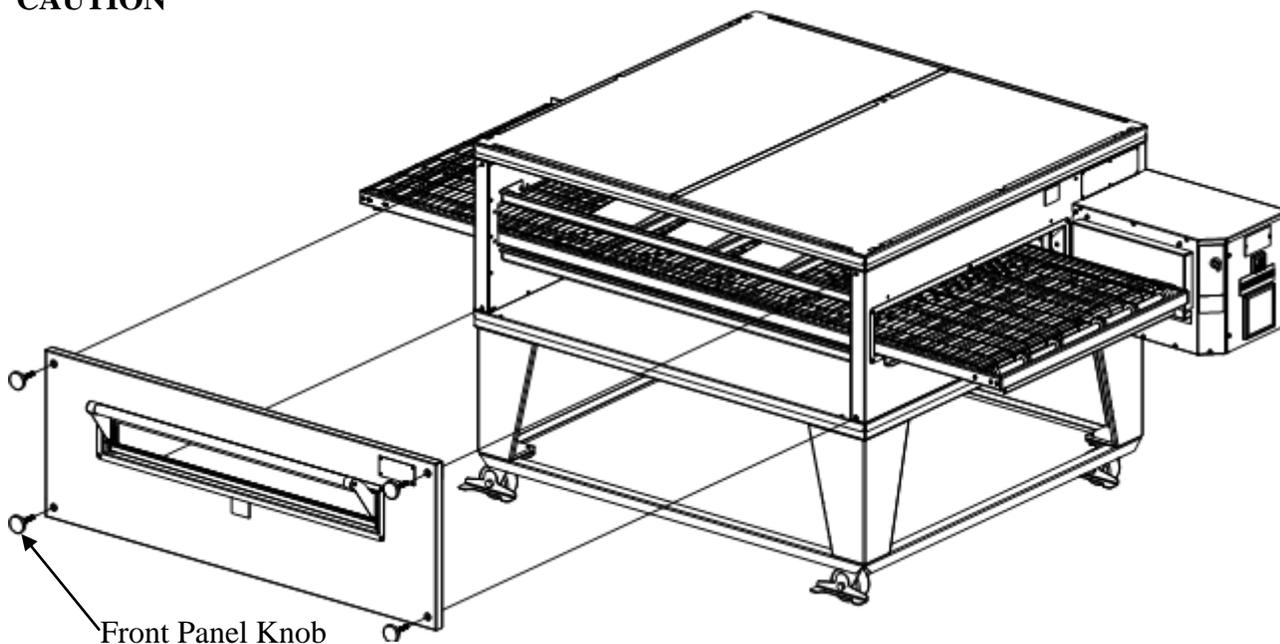
Opening the sandwich door will provide a grip location for removing the front panel.

TIP



Front panels can weigh up to 75 lbs. or 34 kg. Use caution when lifting.

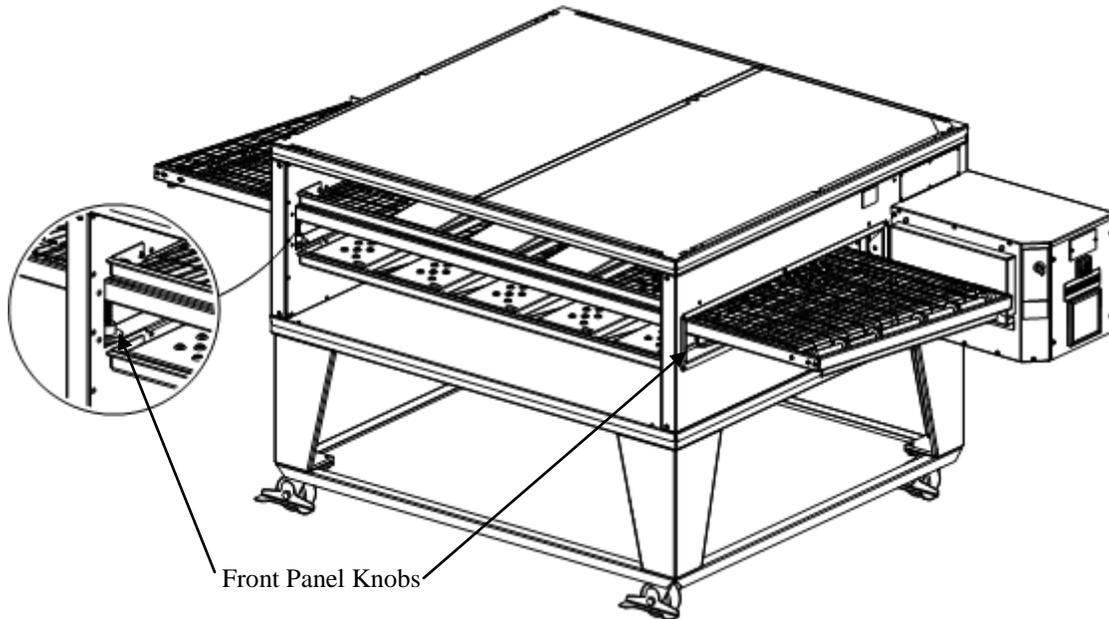
CAUTION



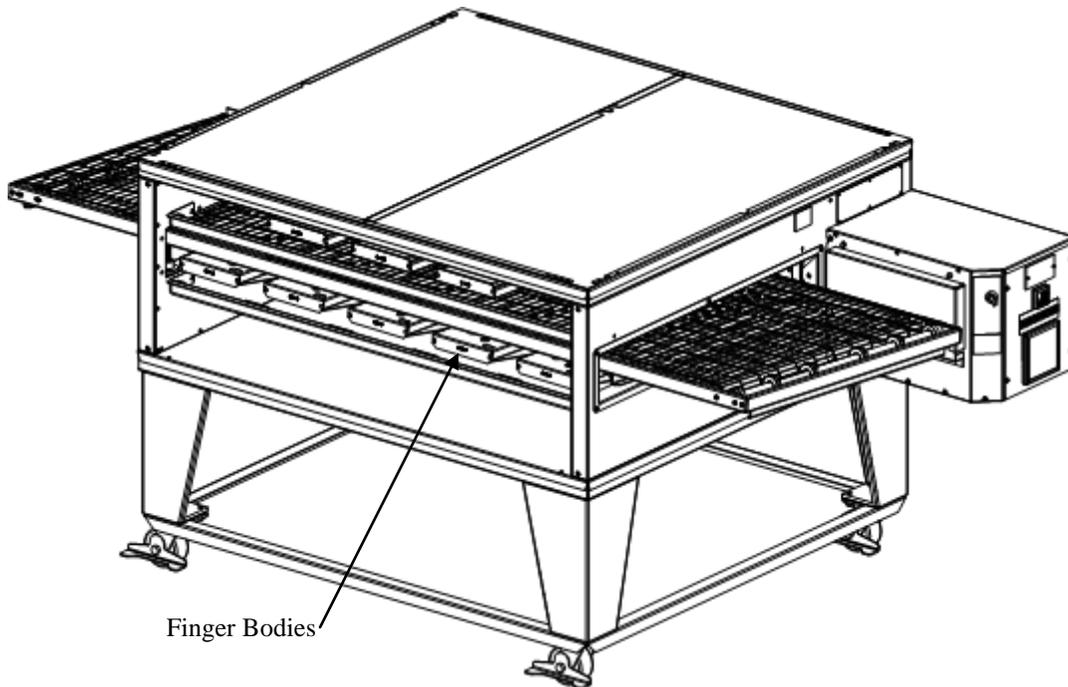
DO NOT immerse front panel as it contains insulation that could become saturated.

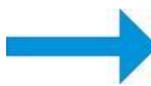
NOTE

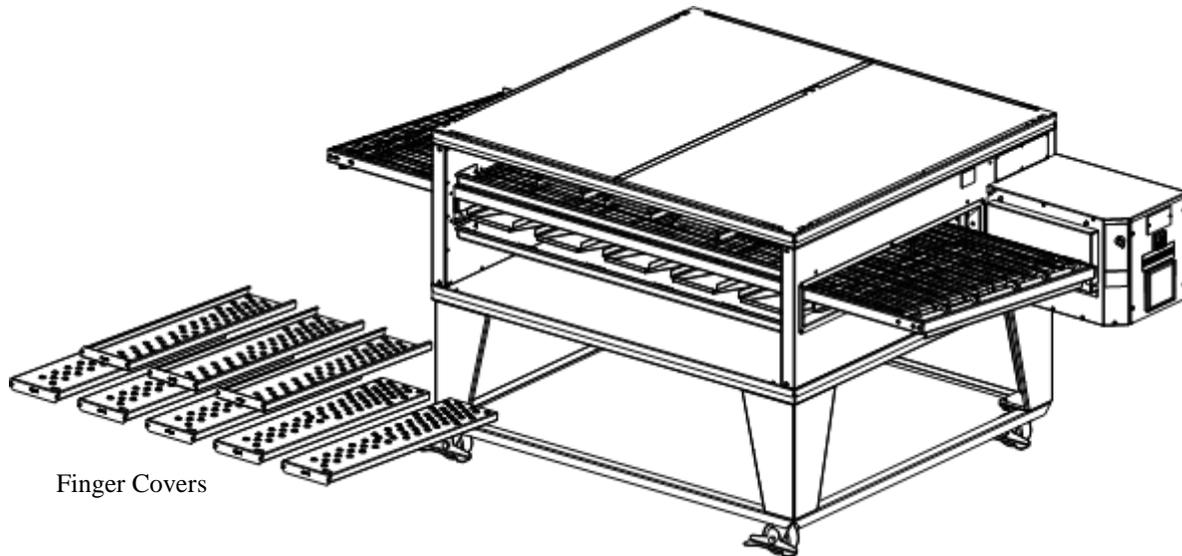
3. To remove and clean the lower finger outer panels and lower finger body assemblies, raise the front of the conveyor and insert two (2) front panel knobs, one (1) each side, as shown.



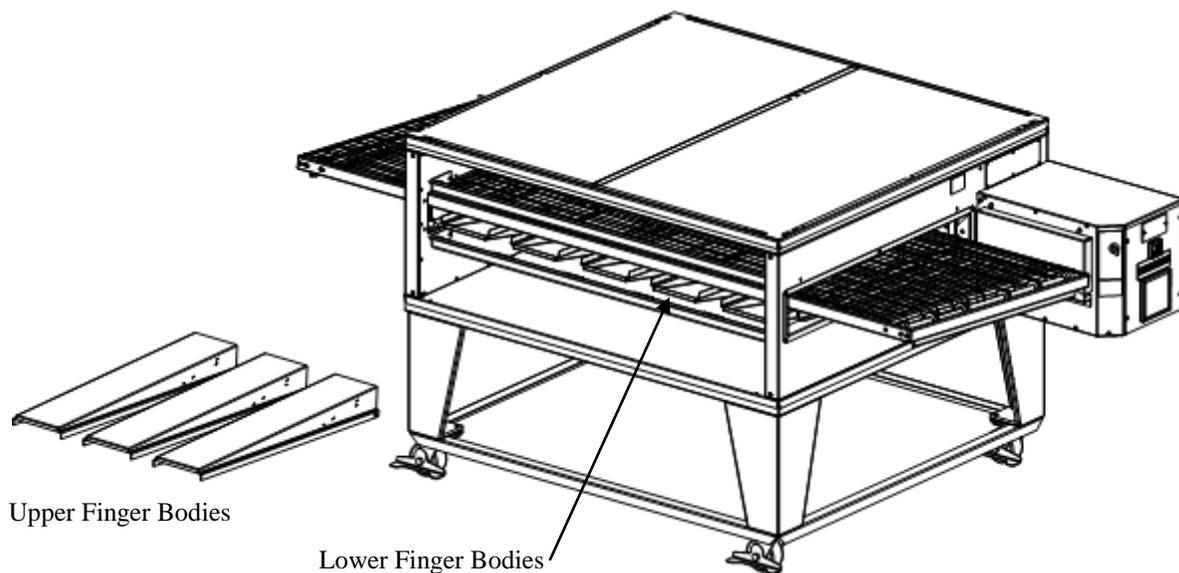
4. Raise the front of the lower finger bodies, one at a time, approximately one inch, [25 cm], and slide the finger outer panels out towards the front.



NOTE  Prior to the removal of the finger covers, note the location and configuration to ensure proper reassembly. Typically, upper finger bodies are approximately 2" [50 mm] thinner than lower finger bodies. The finger outer panels are the same dimensions.



5. Raise the front of the upper finger bodies, one at a time, approximately 1" [25 cm], and slide the finger assembly out towards the front.



6. Wipe down and clean all interior and exterior surfaces.



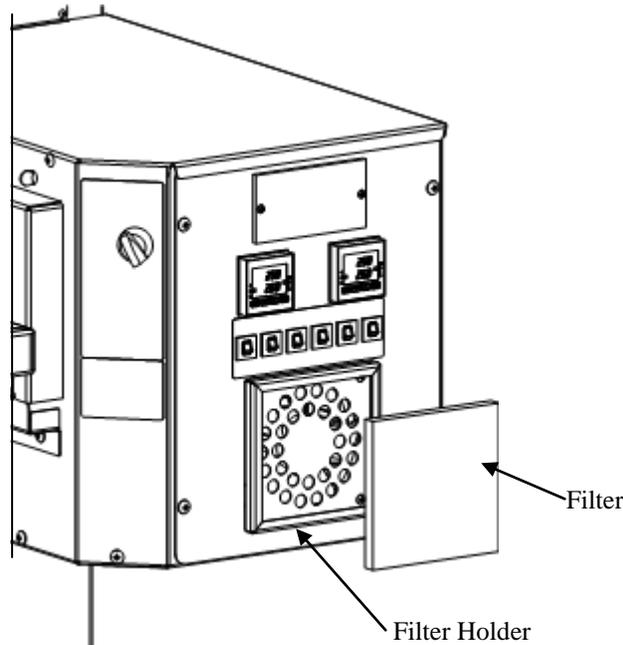
CAUTION

DO NOT spray liquid cleaning agents in the slots and holes in the following locations:

- Back of Control Box
- Underneath Control Box
- Main Fan Motor Cover

7. After all components are clean and dry, re-assemble the oven in the reverse order.

The most critical item to be maintained is the filter on the Flow Path Pressure Generating fan. The filter is held in place by the stainless steel fan guard/filter mount and can be washed several times. Regular cleaning of the Flow Path Pressure Generating Fan filter is important to provide combustion air and to maintain air circulation within the control box. Depending upon store conditions, this filter should be cleaned weekly or as it gets clogged with dust. After several cleanings the filter will need to be replaced.



Contact a factory representative or a local service company to perform all other maintenance and repairs.

NOTICE: If the oven is to be removed from its installed location for cleaning or servicing, the following procedure is to be implemented:

1. Shut off main manual gas valve.
2. Unplug electric cord.
3. Unplug gas line.
4. Unlock casters.
5. Disconnect restraint.
6. When servicing or cleaning is complete, move oven to original location.
7. Connect restraint.
8. Lock casters.
9. Plug in electric cord.
10. Plug in gas line.
11. Turn manual gas valve on.
12. Follow normal lighting instructions.

Oven Problems

Before trouble-shooting the oven;

1. Make sure that the oven is connected to the proper voltage.
2. Check to see that the breaker in the service panel is not disengaged.
3. Check to see that all circuit breakers on the oven are not disengaged.
4. Check to see if the gas supply is adequate.
5. The gas hose must be connected to the oven and the manual shutoff valve fully opened.
6. Check to see that the oven is fully assembled. All of the fingers must be properly installed.

XLT Ovens has qualified customer service personnel that can provide assistance on any type of issue that you may experience. Customer Service can be contacted at 888-443-2751, 24 hours per day, 7 days per week. For Australian and World Ovens, contact your designated representative.

Proper Cooking

Experimentation is about the only way to determine proper time and temperature settings. While a pizza may look perfectly cooked on the outside, the inside may be undercooked. A thermometer is necessary to determine if food items are being properly cooked. Most health departments have rules and regulations that establish minimum temperatures for internal food temperatures. Most operators want to cook foods as fast as possible in order to serve more customers per hour. However, cooking foods slower is the only way to achieve a proper internal temperature. If your food product look acceptable on the outside, but has an internal temperature that is too low, then lowering the temperature and decreasing the belt speed (thereby increasing the cook time), will be necessary.

Several factors may affect the cooking performance and characteristics:

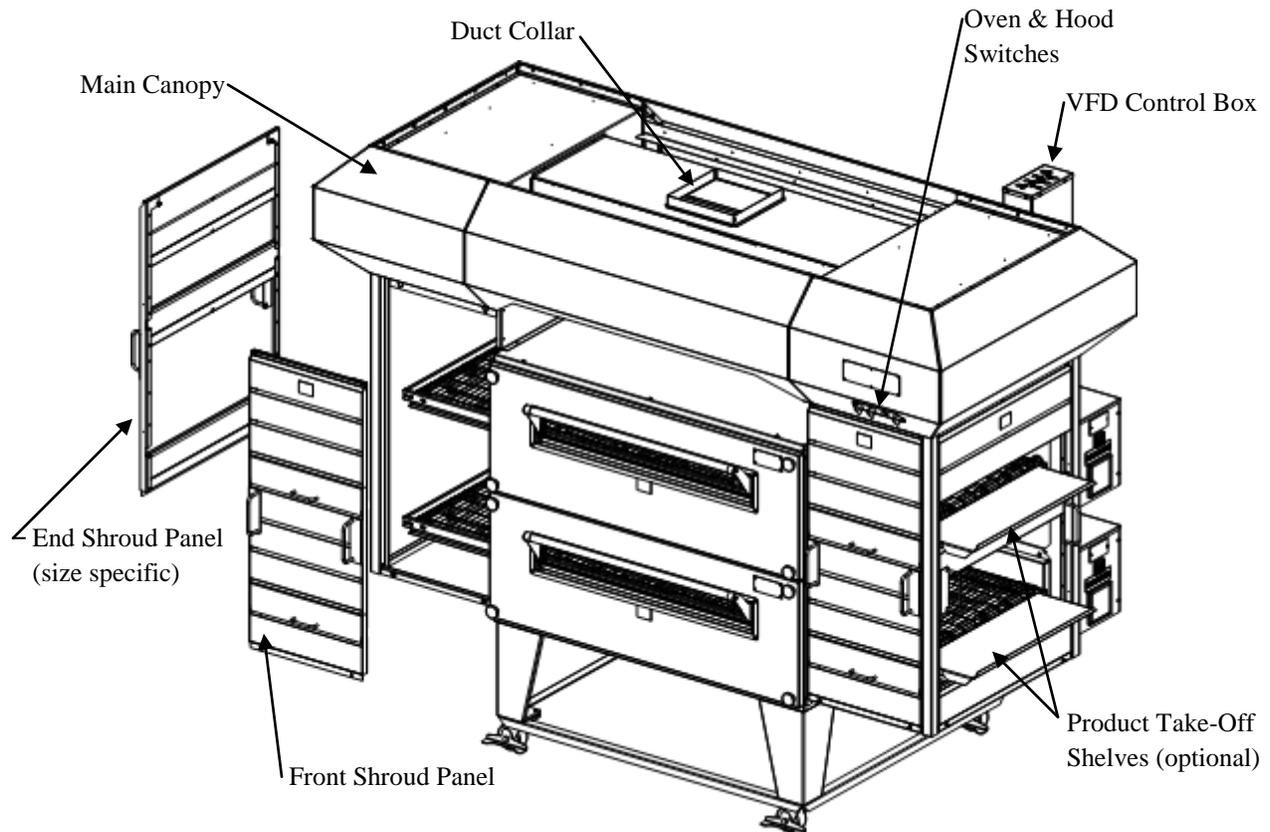
1. Oven temperature (generally affects color)
2. Conveyor speed (generally affects doneness)
3. Finger arrangement
4. Altitude
5. Pans versus screens
6. Dough thickness
7. Cheese type
8. Raw ingredient temperature (frozen?)
9. Quantity of toppings

XLT ovens can be configured to cook a wide variety of food items. This is accomplished by arranging the fingers to control the baking characteristics. Generally speaking, most cooking is a “bottom up” process. The hot air from the bottom row of fingers has to go through the conveyor (a distance of about 2” / 50.8mm), heat the pan or screen, and then actually cook raw dough. The hot air from the top, on the other hand, basically only has to melt cheese and re-heat precooked toppings. Consequently, most operators will use the oven with the fingers arranged so that a lot more air is directed to the bottom of the pizza than to the top. There are places for an equal number of fingers above and below the conveyor. Available are finger cover plates that have six rows of holes, four rows of holes, two rows of holes, and no holes (or blank cover plates). A typical finger arrangement might have most or all fingers on the bottom “full open”, that is fingers with all six rows of holes, and only two or three fingers on top with four or six rows of holes. The top fingers can be arranged in a symmetrical pattern or can be shifted asymmetrically to either the entrance or exit end of the conveyor. We encourage you to experiment by trying different finger arrangements, temperatures and belt speeds. XLT Ovens can assist you with your oven/product configurations.

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AVI Exhaust Hood

Hood Description



The AVI Hood System consists of three (3) major parts, the main canopy, the shrouds, and the Variable Frequency Drive (VFD) exhaust fan controller.

The main canopy serves to collect heat and products of combustion and transmits the effluents to the exhaust fan. It houses filters, lights, and switches. The switches control both the hood and ovens. The main canopy size is dependent upon oven size.

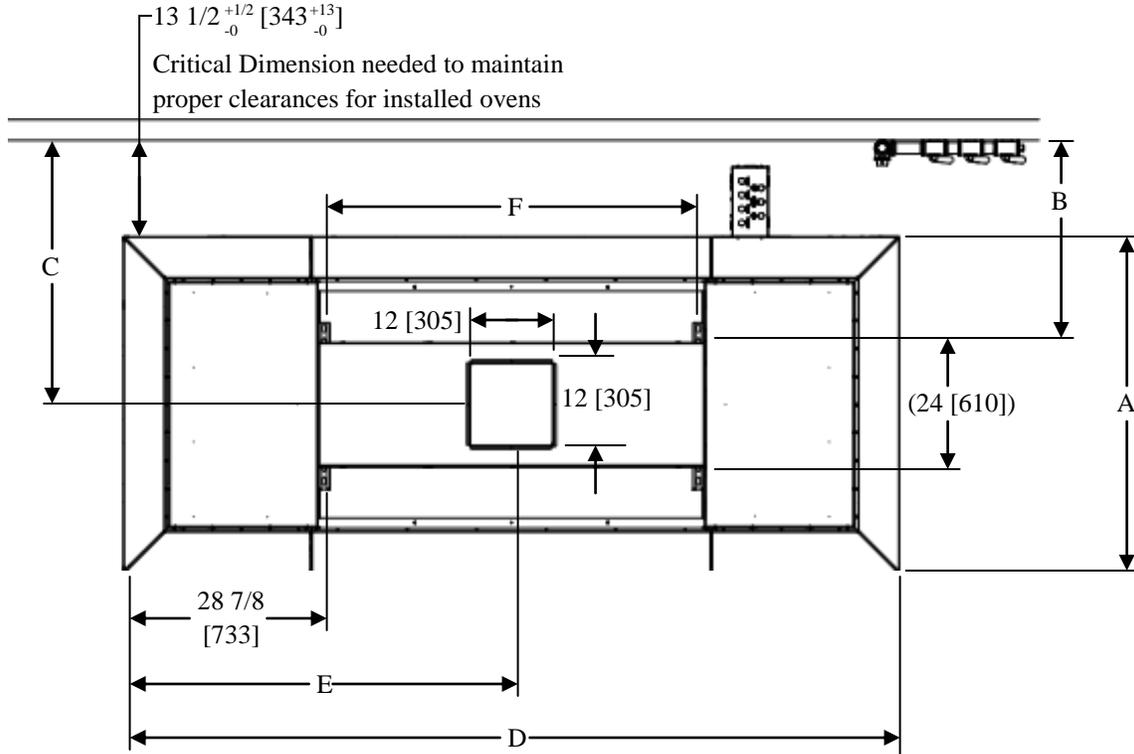
The shrouds assist the efficiency of the main canopy by entrapping heat and products of combustion. They are configurable for either side or end loading or unloading, and are easily removable for cleaning and maintenance.

The VFD control box operates at 208/230 VAC single phase, 50/60 Hz. All electric utilities for the hood, oven(s), and exhaust fan connect to the VFD control box. The control box houses a variable frequency drive, fuses, receptacles, and relays. The VFD converts the single-phase input power to adjustable three-phase output power to vary the speed of the exhaust fan. The oven(s) plug in to the receptacles to provide a safety interlock. The optional relays provide fire suppression interlocks and interlocks for up to three (3) HVAC dampers.

All AVI hoods are available pre-piped for fire suppression, allowing for simple, in-field installations..

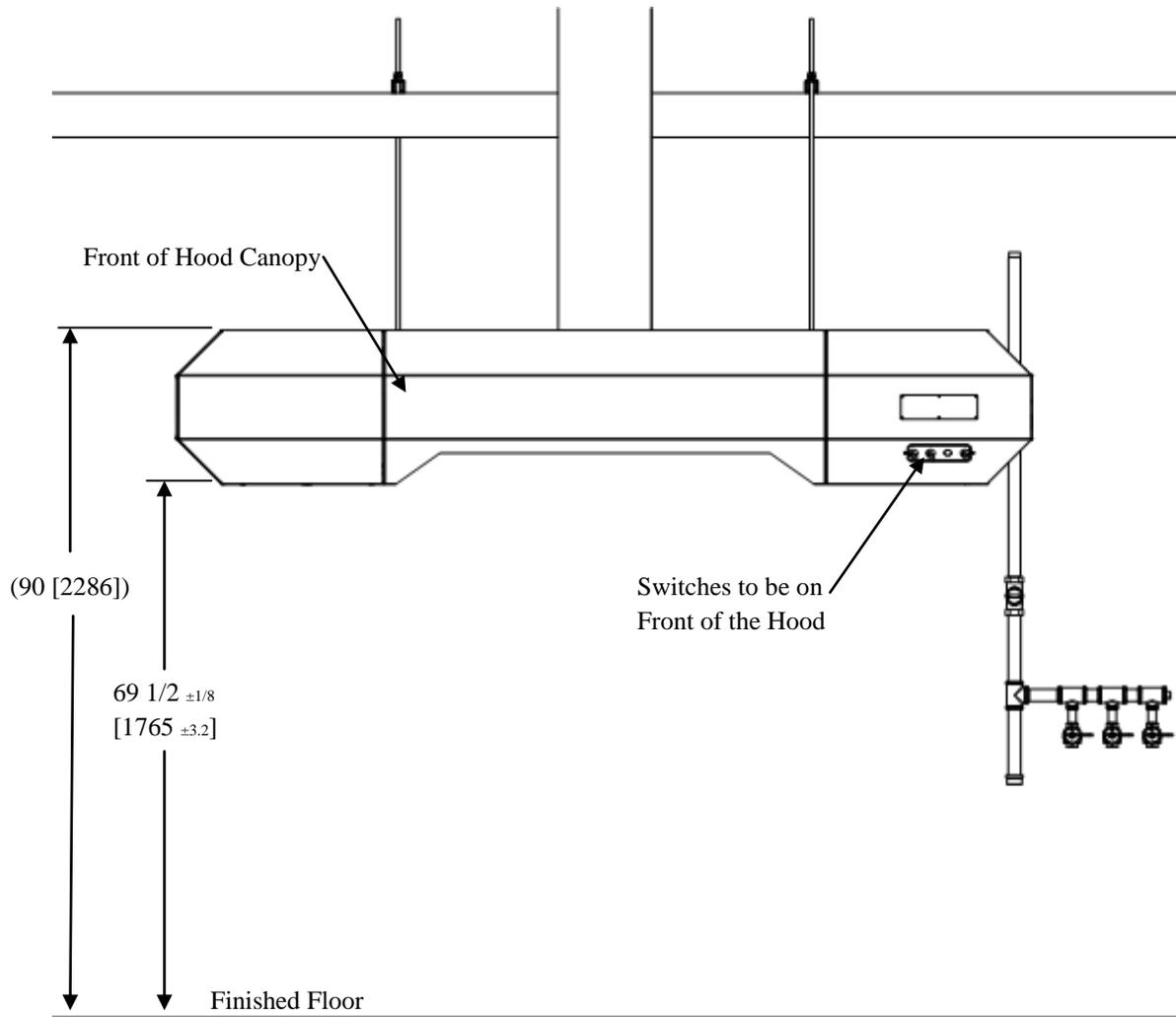
 Most illustrations in this manual show the ovens and hood in a double stack configuration. All instructions apply to single and triple stack configurations unless noted otherwise.

NOTE



Model Numbers							
	AVI 1832	AVI 2440	AVI 3240	AVI 3255	AVI 3270	AVI 3855	AVI 3870
“A”	34-11/32 [872]	40-11/32 [1025]	48-11/32 [1228]	48-11/32 [1228]	48-11/32 [1228]	54-11/32 [1380]	54-11/32 [1380]
“B”	18-11/16 [474]	21-11/16 [550]	25-11/16 [652]	25-11/16 [652]	25-11/16 [652]	28-11/16 [728]	28-11/16 [728]
“C”	30-11/16 [779]	33-11/16 [856]	37-11/16 [957]	37-11/16 [957]	37-11/16 [957]	40-11/16 [1033]	40-11/16 [1033]
“D”	88-19/32 [2250]	96-19/32 [2454]	96-19/32 [2454]	111-19/32 [2835]	126-19/32 [3216]	111-19/32 [2454]	126-19/32 [3216]
“E”	44-5/16 [1125]	48-5/16 [1227]	48-5/16 [1227]	55-13/16 [1417]	63-5/16 [1608]	55-13/16 [1417]	63-5/16 [1608]
“F”	30 [762]	38 [965]	38 [965]	53 [1346]	68 [1727]	53 [1346]	68 [1727]

NOTE: All dimensions in inches [mm] unless otherwise noted.



NOTE: All dimensions in inches [mm] unless otherwise noted.

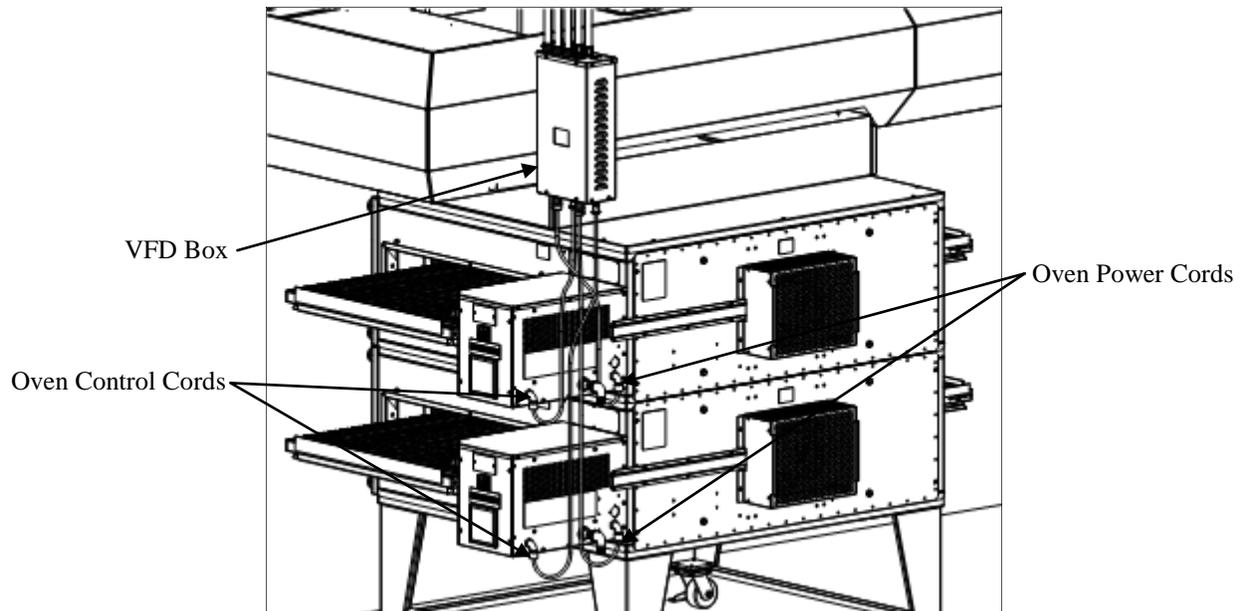
Hood Weight (Does not include ovens)							
	AVI 1832	AVI 2440	AVI 3240	AVI 3255	AVI 3270	AVI 3855	AVI 3870
Single Stack	560.39 [254]	644.84 [292]	708.73 [321]	757.05 [343]	790.12 [358]	812.03 [368]	845.32 [383]
Double Stack	513.78 [233]	576.72 [262]	640.25 [290]	681.29 [309]	704.08 [319]	728.01 [330]	750.23 [340]
Triple Stack	594.64 [270]	593.48 [269]	657.82 [298]	698.99 [317]	709.52 [322]	840.39 [381]	754.55 [342]

NOTE: All weights in pounds [kg].

Inputs into VFD Box

The AVI Hood system requires two (2) separate electrical inputs and has provision for one (1) optional input. All inputs and input connection points are located on the top of the VFD control box, as well as the connection to the exhaust fan. All optional outputs (fire suppression, HVAC dampers), are also located on the top of the VFD control box. Inputs are:

- One (1), 230 VAC, 10 Amp, 50/60 Hz, single phase connection to power the VFD (Variable Frequency Drive), which powers the ventilation fan.
- Standard - Three (3), 120 VAC, 20 Amp, 60 Hz, single phase connections to power each individual XLT oven.
- World - Three (3), 230 VAC, 10 Amp, 50/60 Hz, single phase connections to power each individual XLT oven.
- One (1) optional Normally Closed (N/C) input from the fire suppression system.



Double Stack configuration shown, Single and Triple stack configurations wire similarly.

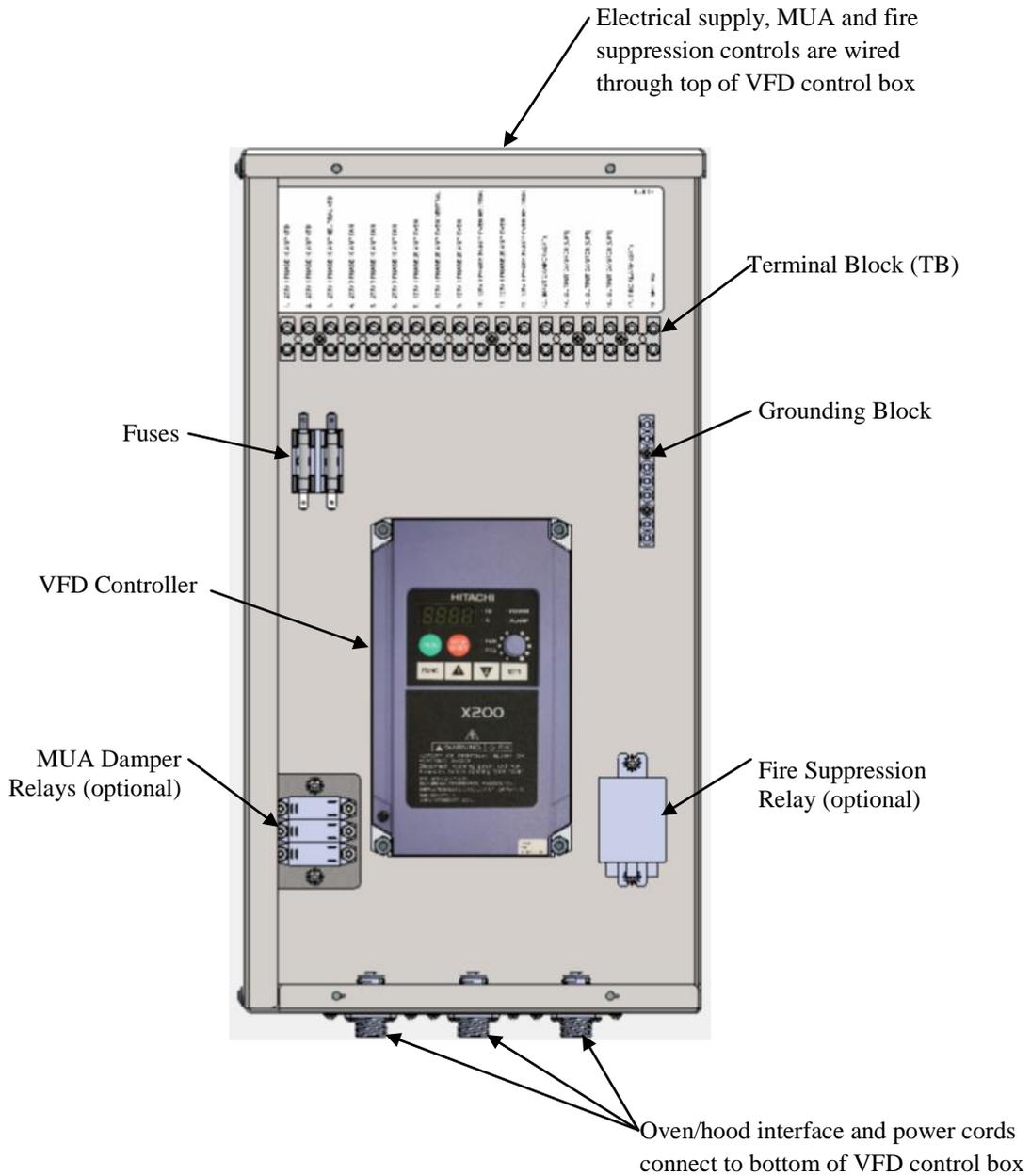
Outputs from VFD Box

The AVI Hood system provides three (3) power and signal outputs. The power outputs for the ovens are on the bottom of the box, while the signal outputs for fire suppression and HVAC dampers are on the top of the box. Outputs are:

- One (1) 230 VAC, 10 Amp, variable frequency, three phase output for the ventilation exhaust fan.
- Standard - Three (3), 120 VAC, 20 Amp, 60 Hz, single phase power outputs for each individual XLT oven.
- World - Three (3), 230 VAC, 10 Amp, 50/60 Hz, single phase connections to power each individual XLT oven.
- Three (3) optional Normally Open (N/O) outputs for HVAC dampers.

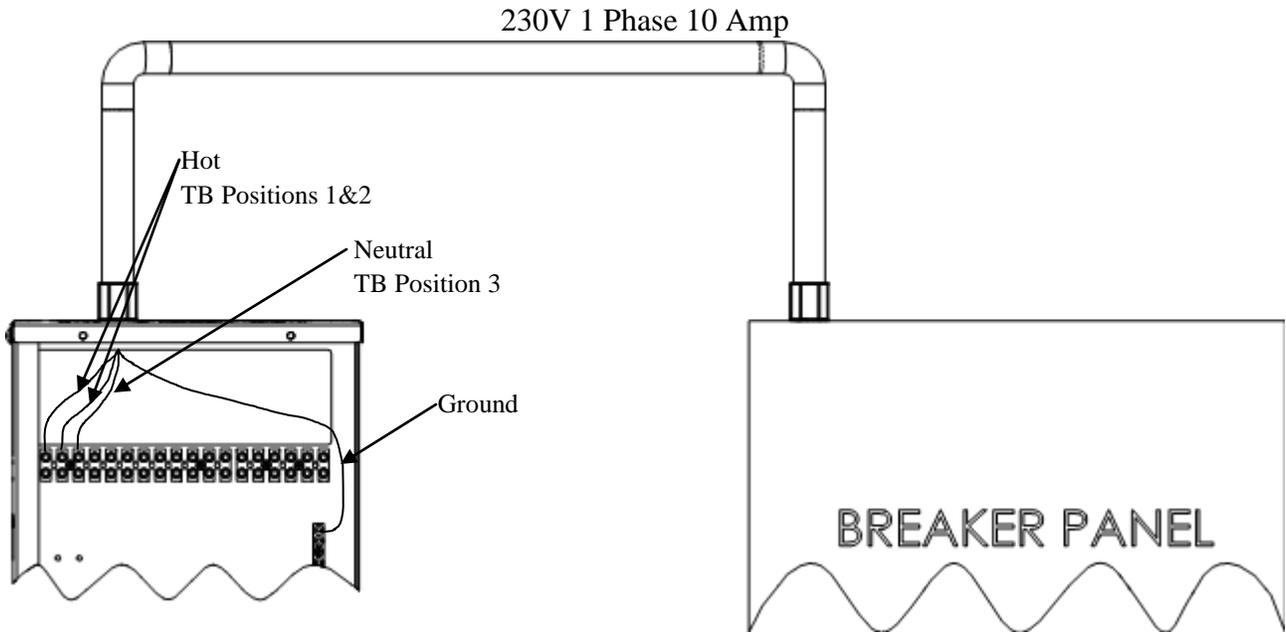
Hood Electrical Requirements

VFD Control Box - Standard

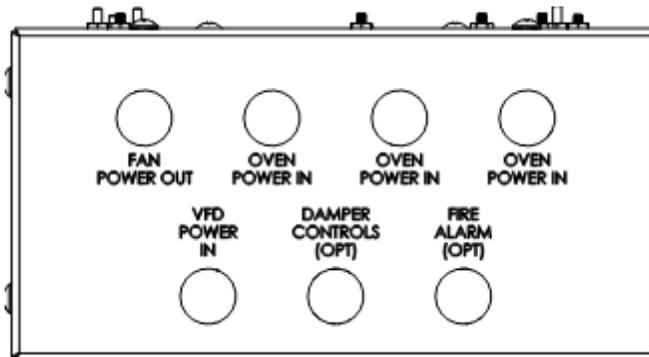
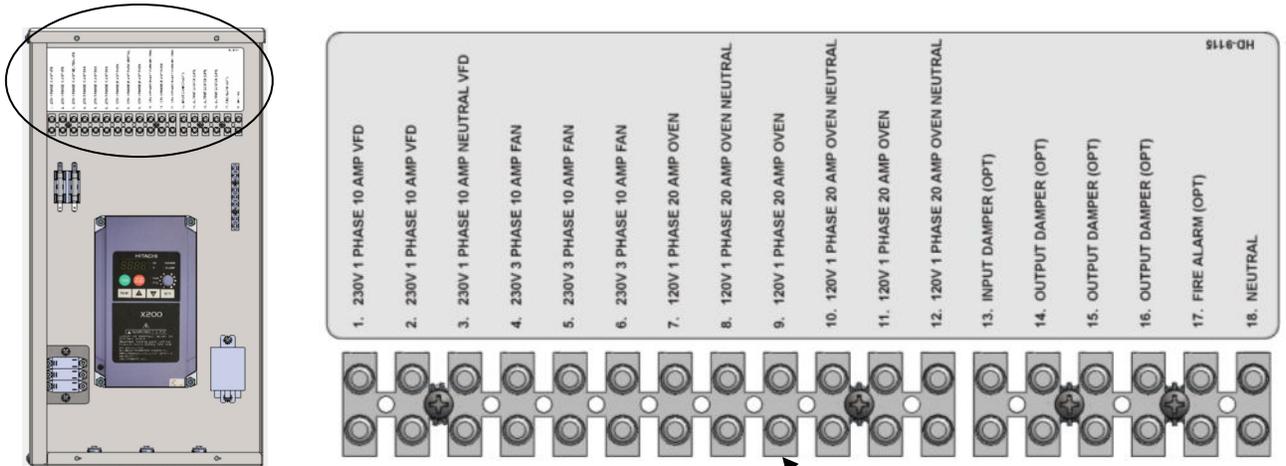


Wiring removed for clarity. See schematic for wiring details.

Power to VFD Controller - Standard



Conduit and breaker panel shown for reference only

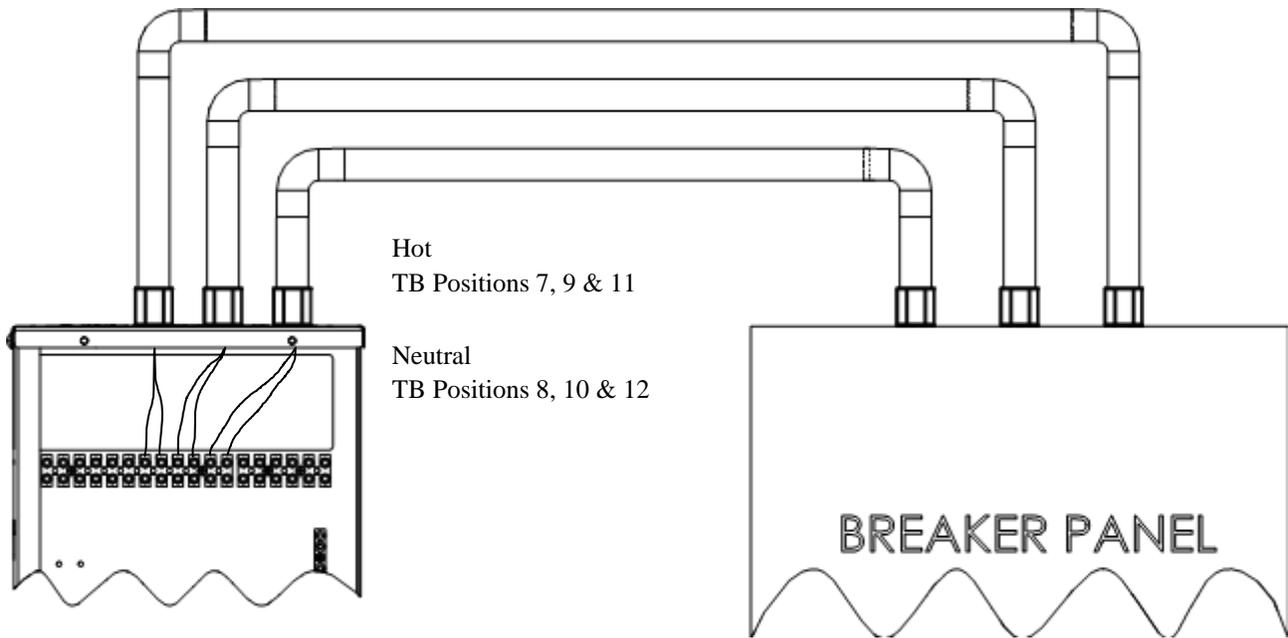


Top of Variable Frequency Drive (VFD) Box

Hood Electrical Requirements

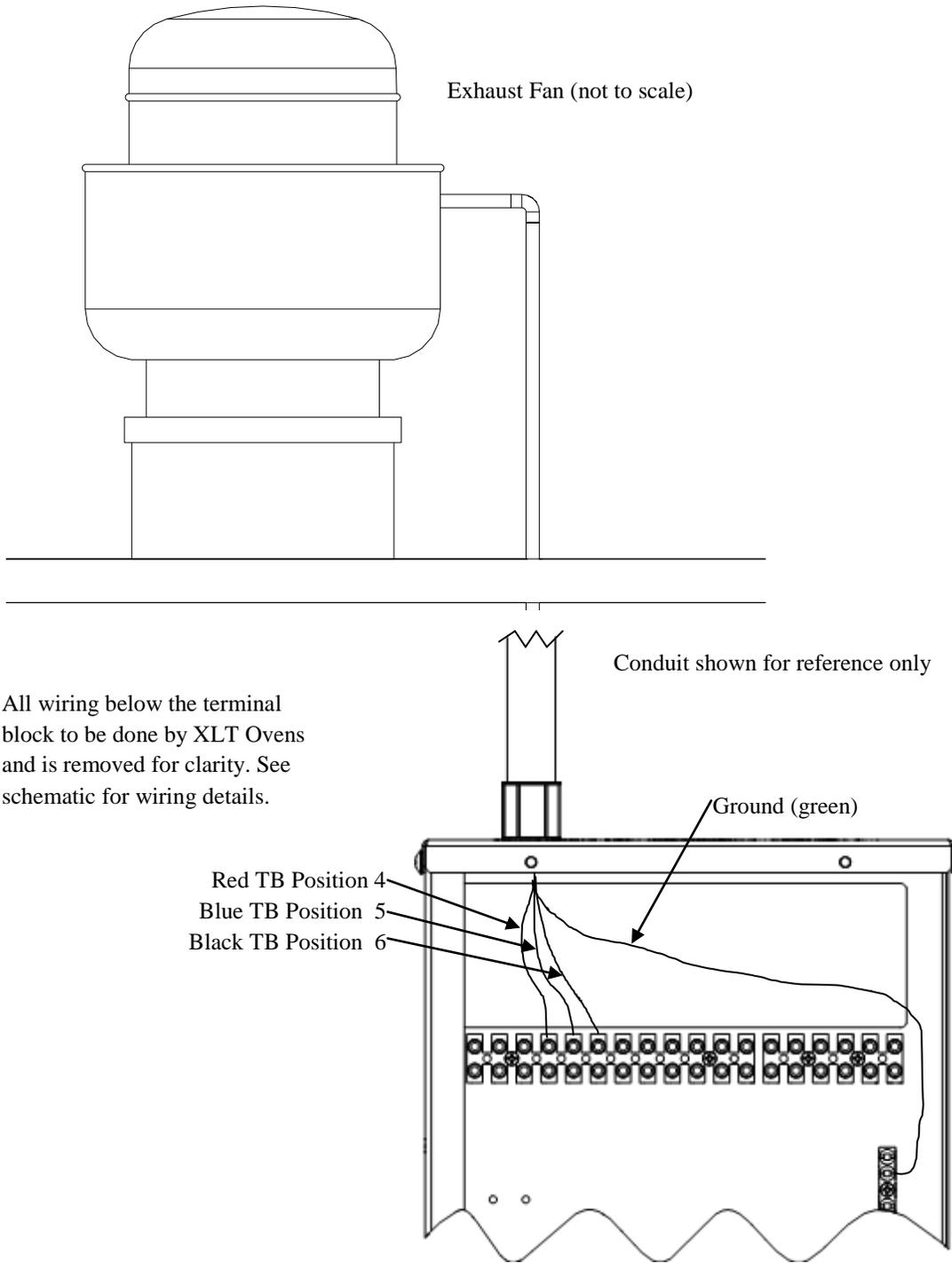
Power for Ovens - Standard

Three (3) 120V 1 Phase 20 Amp Circuits



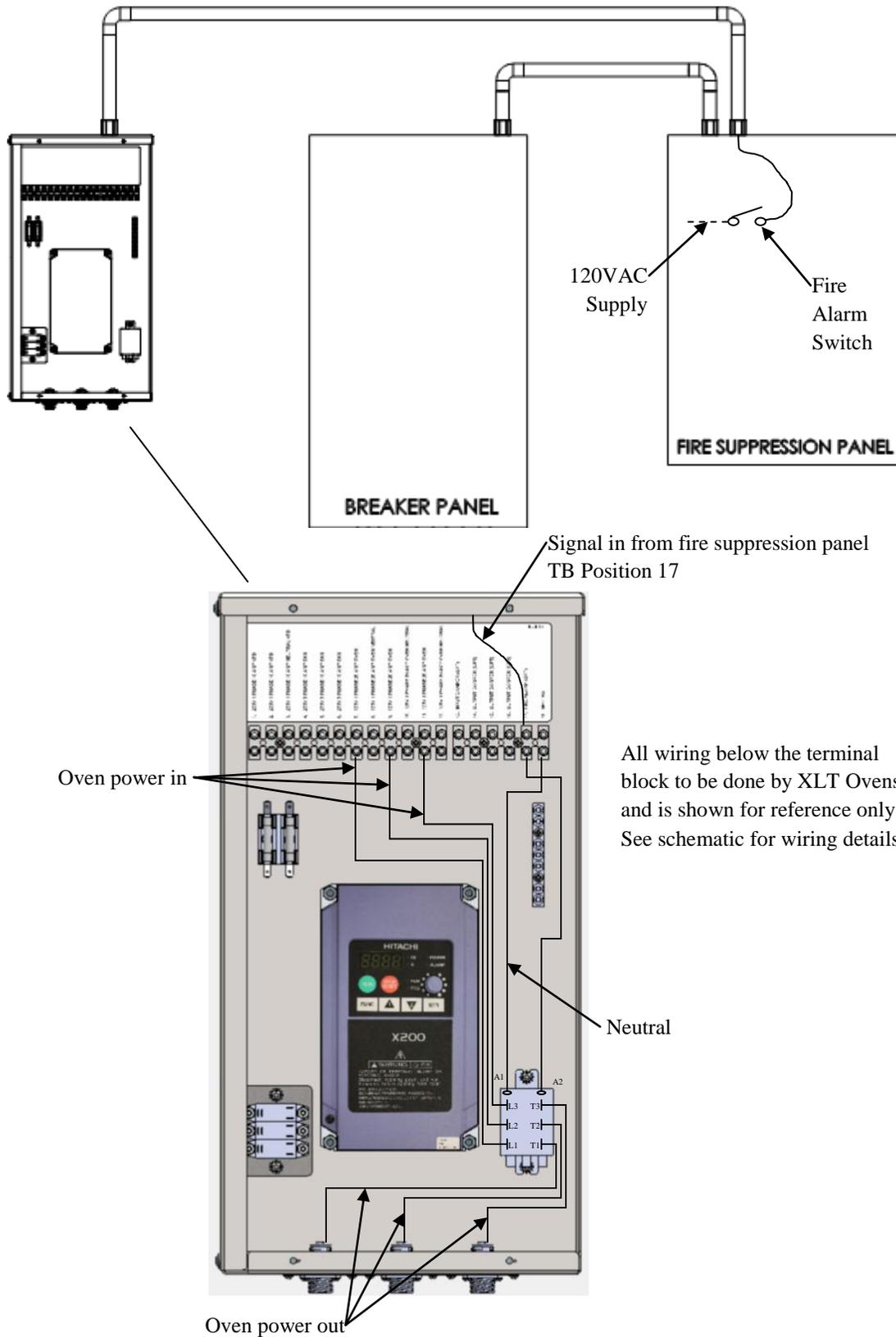
Conduit and breaker panel shown for reference only

Power from VFD to Exhaust Fan - Standard



Hood Electrical Requirements

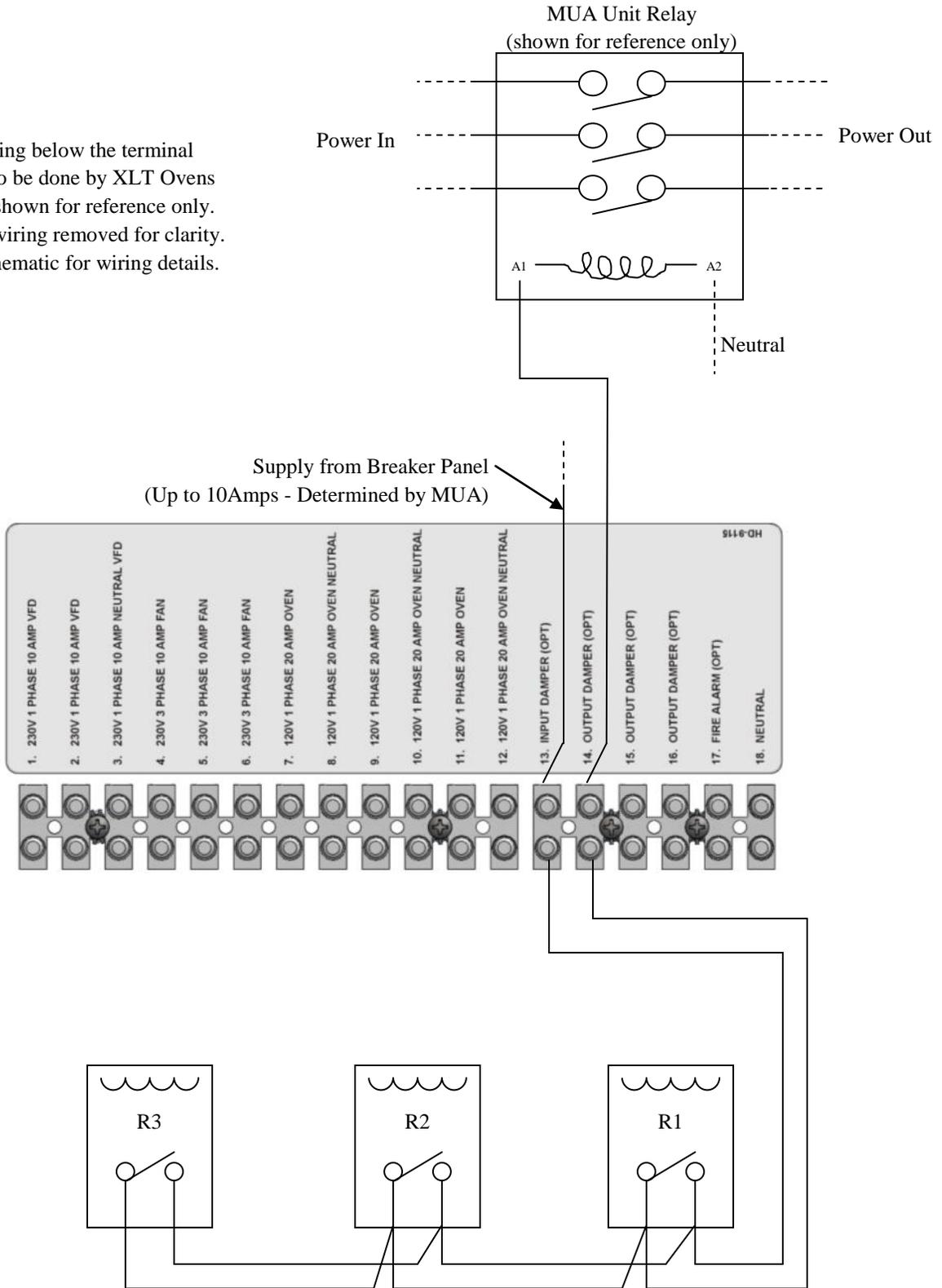
Fire Alarm Relay - Standard (optional)



Conduit, breaker panel and fire suppression panel shown for reference only.

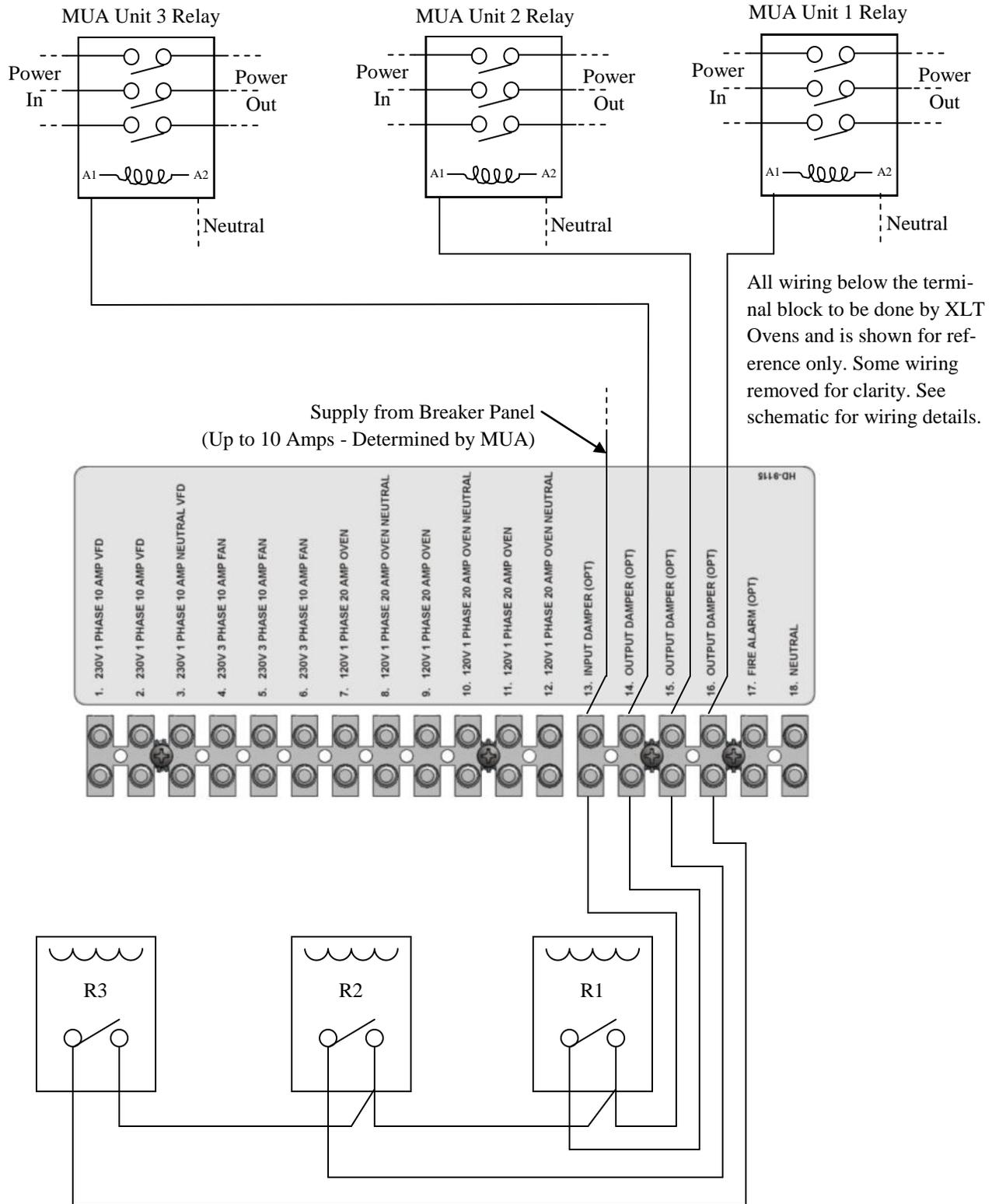
MUA Damper Relays - Single Output Configuration - Standard (optional)

All wiring below the terminal block to be done by XLT Ovens and is shown for reference only. Some wiring removed for clarity. See schematic for wiring details.



Relays located in VFD box

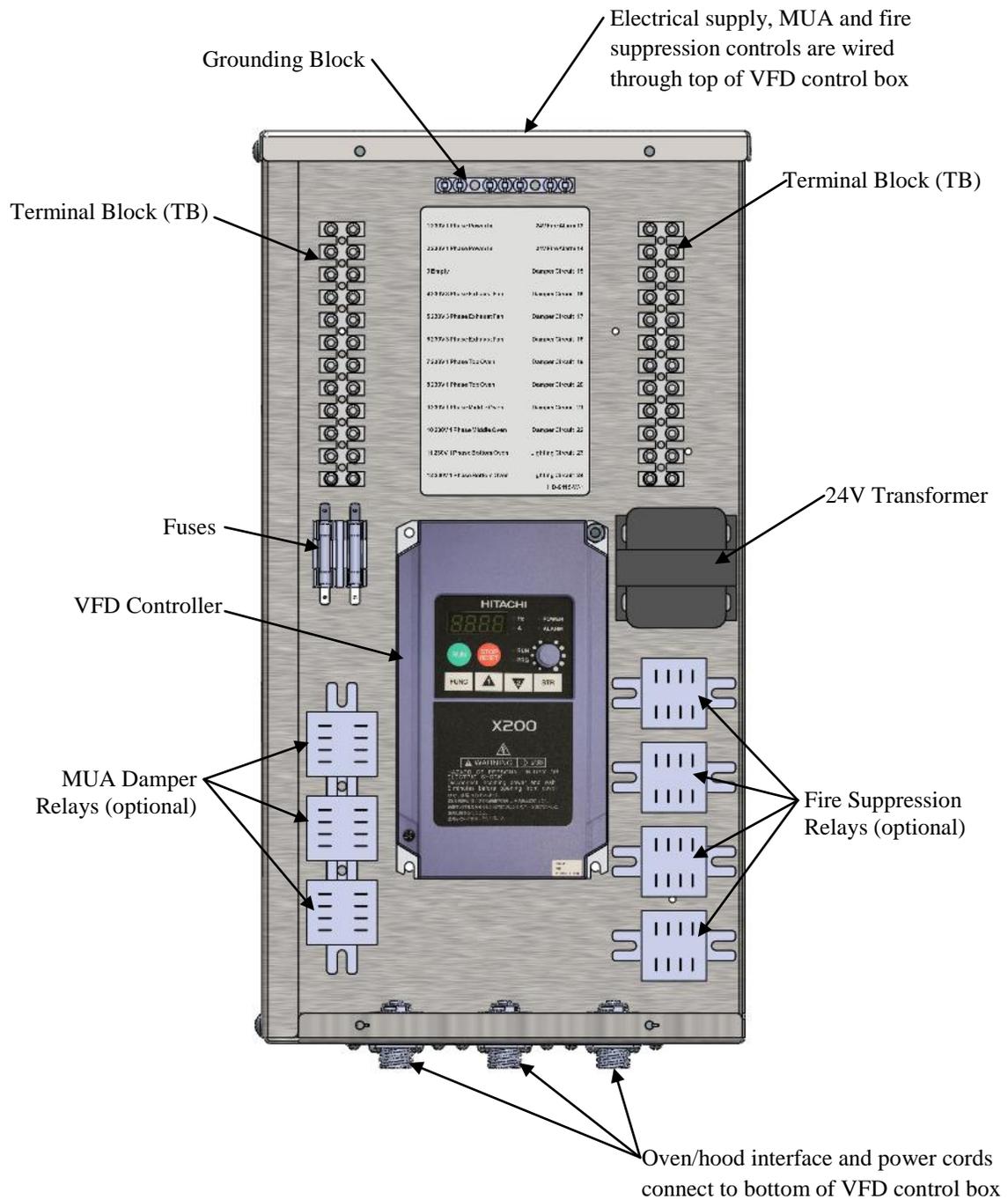
MUA Damper Relays - Multiple Output Configuration - Standard (optional)



All wiring below the terminal block to be done by XLT Ovens and is shown for reference only. Some wiring removed for clarity. See schematic for wiring details.

Relays located in VFD box

VFD Control Box - World

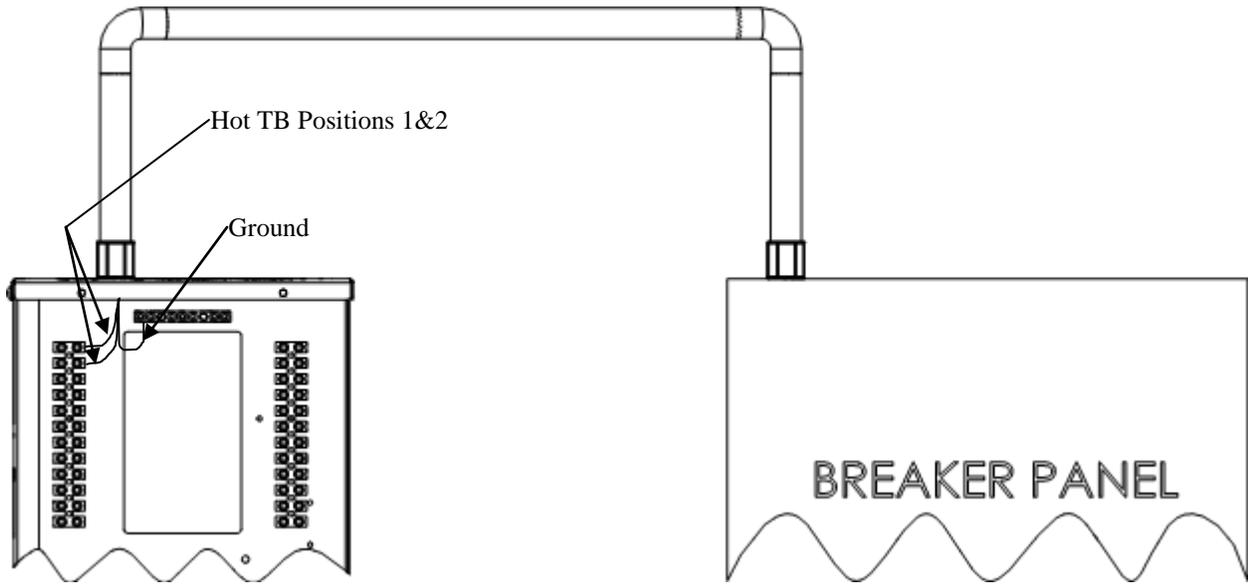


Wiring removed for clarity. See schematic for wiring details.

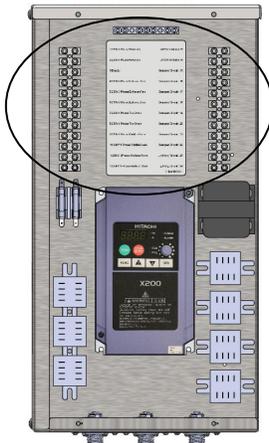
Hood Electrical Requirements

Power to VFD Controller - World

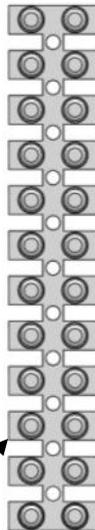
230V 1 Phase 10 Amp



Conduit and breaker panel shown for reference only



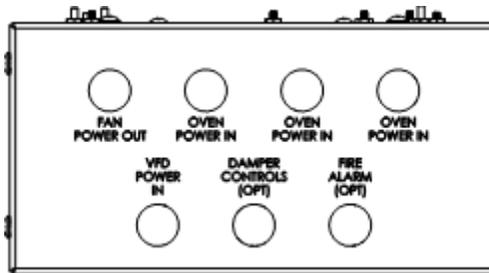
Terminal Block (TB)



1 230V 1 Phase Power In	24V Fire Alarm 13
2 230V 1 Phase Power In	24V Fire Alarm 14
3 Empty	Damper Circuit 15
4 230V 3 Phase Exhaust Fan	Damper Circuit 16
5 230V 3 Phase Exhaust Fan	Damper Circuit 17
6 230V 3 Phase Exhaust Fan	Damper Circuit 18
7 230V 1 Phase Top Oven	Damper Circuit 19
8 230V 1 Phase Top Oven	Damper Circuit 20
9 230V 1 Phase Middle Oven	Damper Circuit 21
10 230V 1 Phase Middle Oven	Damper Circuit 22
11 230V 1 Phase Bottom Oven	Lighting Circuit 23
12 230V 1 Phase Bottom Oven	Lighting Circuit 24
HD-9115-W-1	



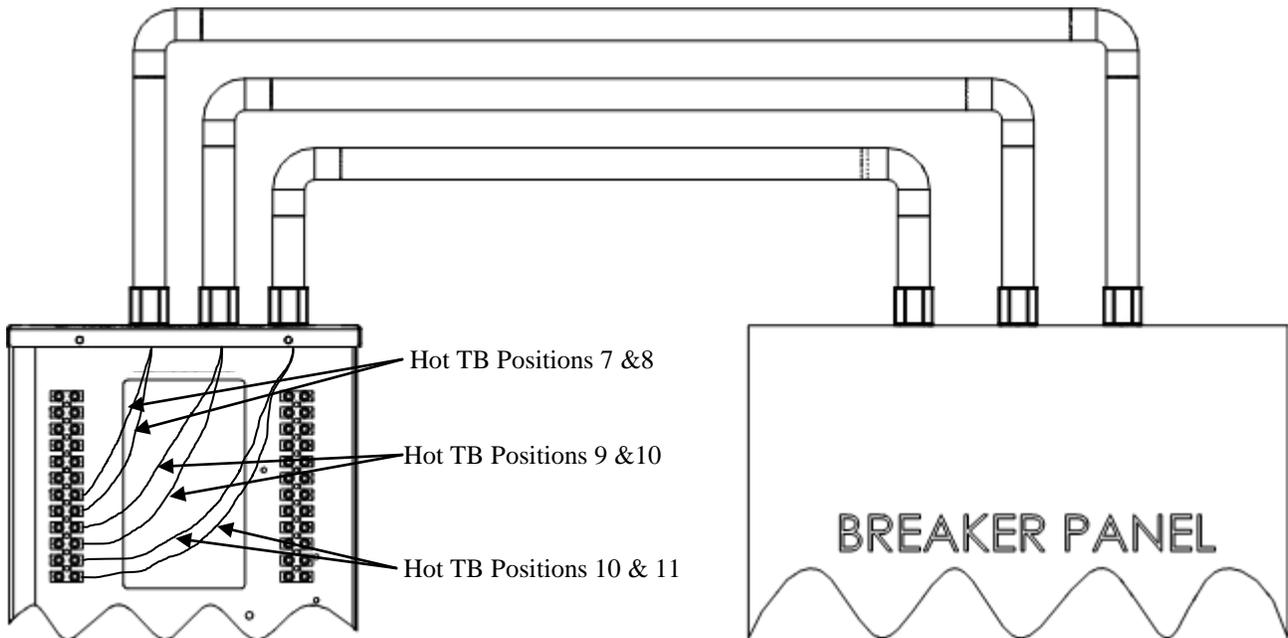
Terminal Block (TB)



Top of Variable Frequency Drive (VFD) Box

Power for Ovens - World

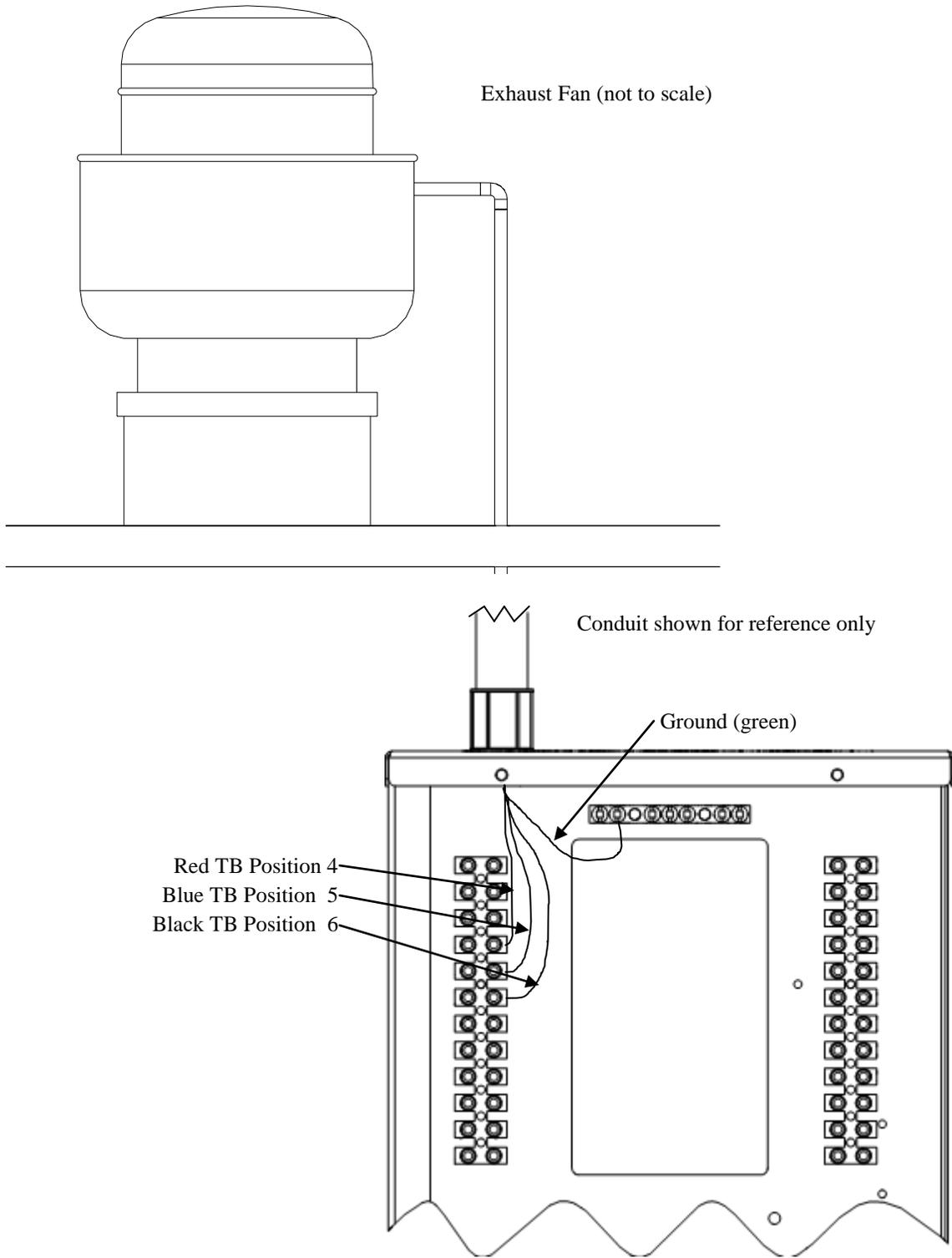
Three (3) 230V 1 Phase 20 Amp Circuits



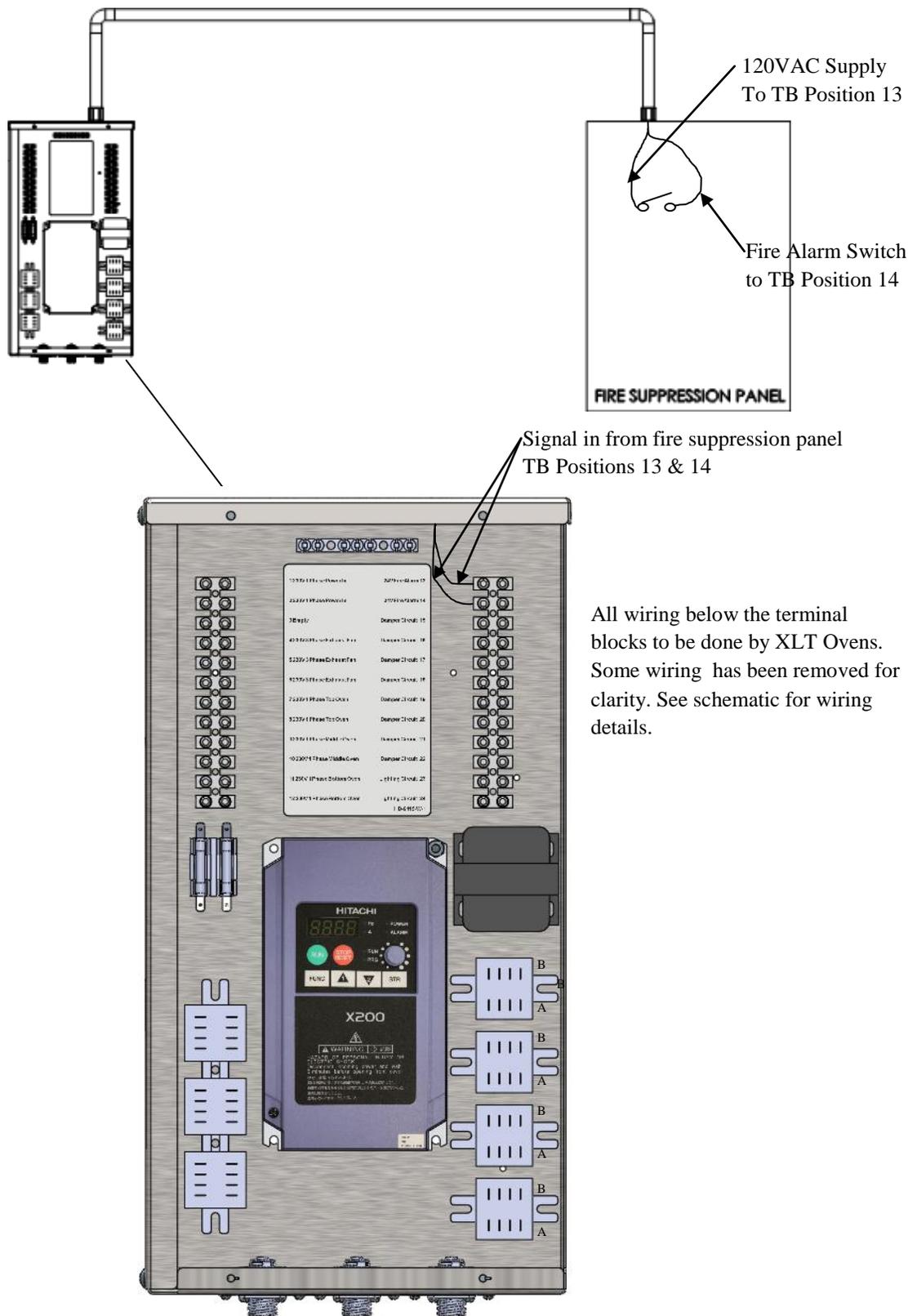
Conduit and breaker panel shown for reference only

Hood Electrical Requirements

Power from VFD to Exhaust Fan - World



Fire Alarm Relay - World (optional)

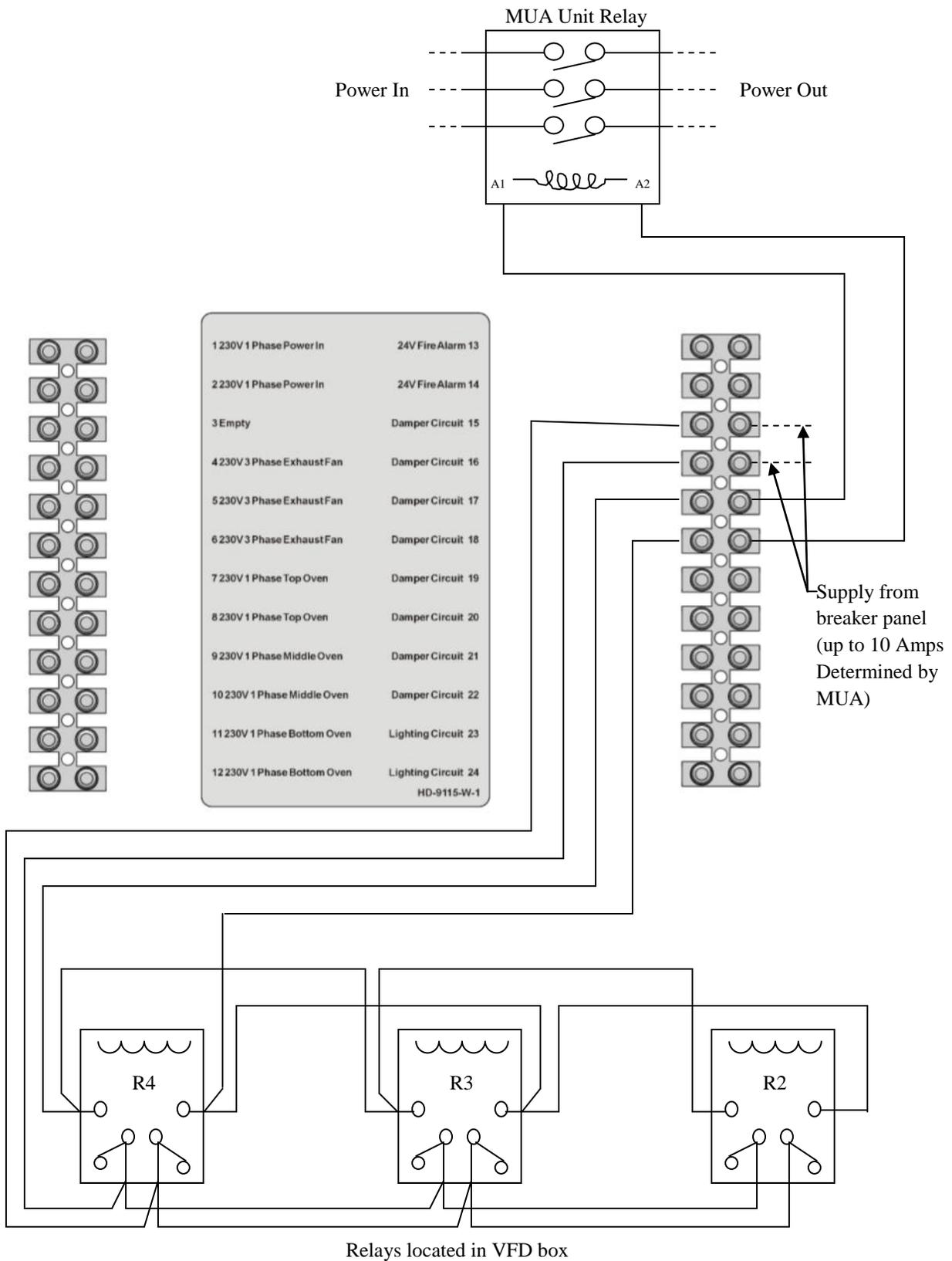


All wiring below the terminal blocks to be done by XLT Ovens. Some wiring has been removed for clarity. See schematic for wiring details.

Conduit, breaker panel and fire suppression panel shown for reference only.

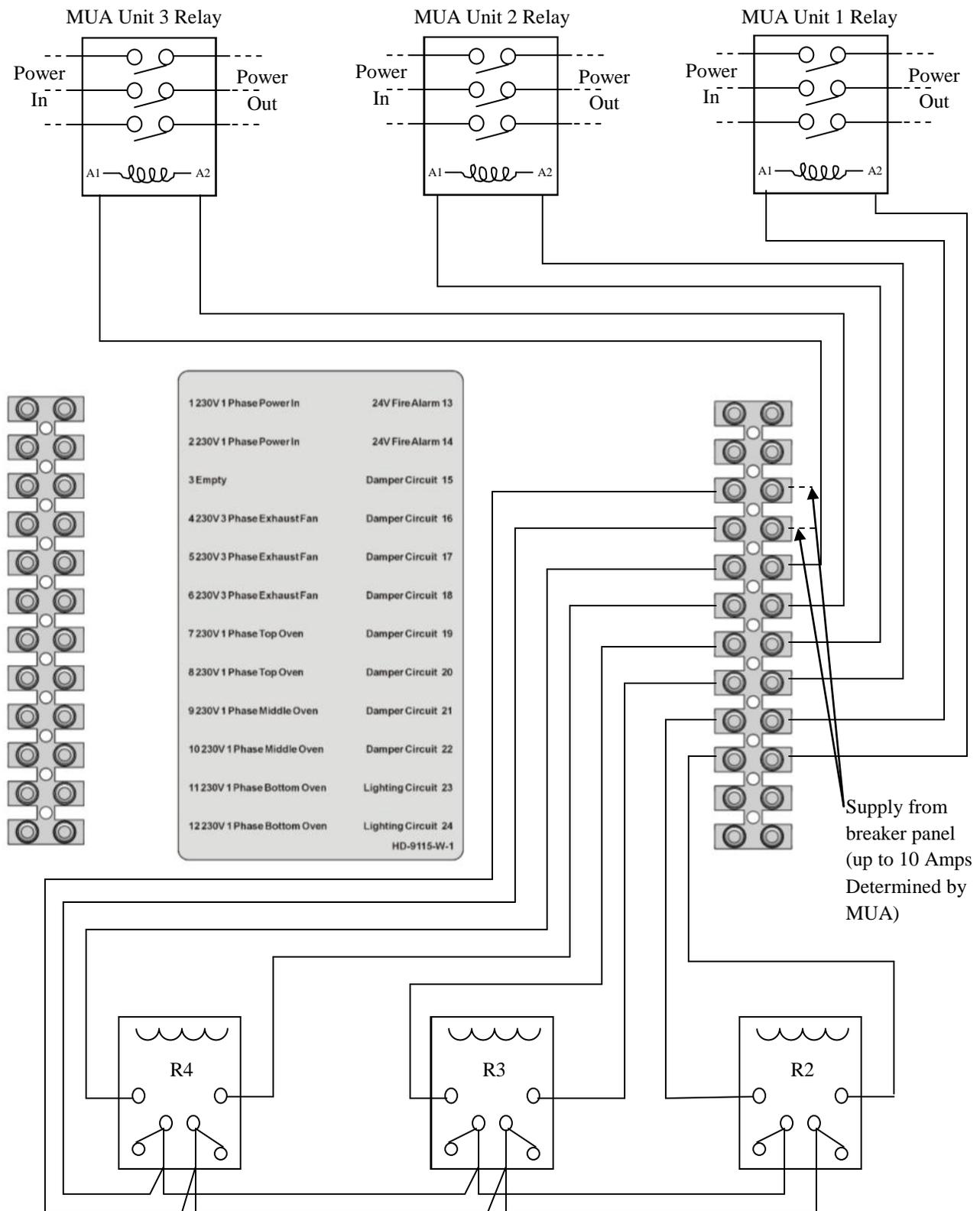
Hood Electrical Requirements

MUA Damper Relays - Single Output Configuration - World (optional)



All wiring below the terminal block to be done by XLT Ovens and is shown for reference only.
Some wiring removed for clarity. See schematic for wiring details.

MUA Damper Relays - Multiple Output Configuration - World (optional)



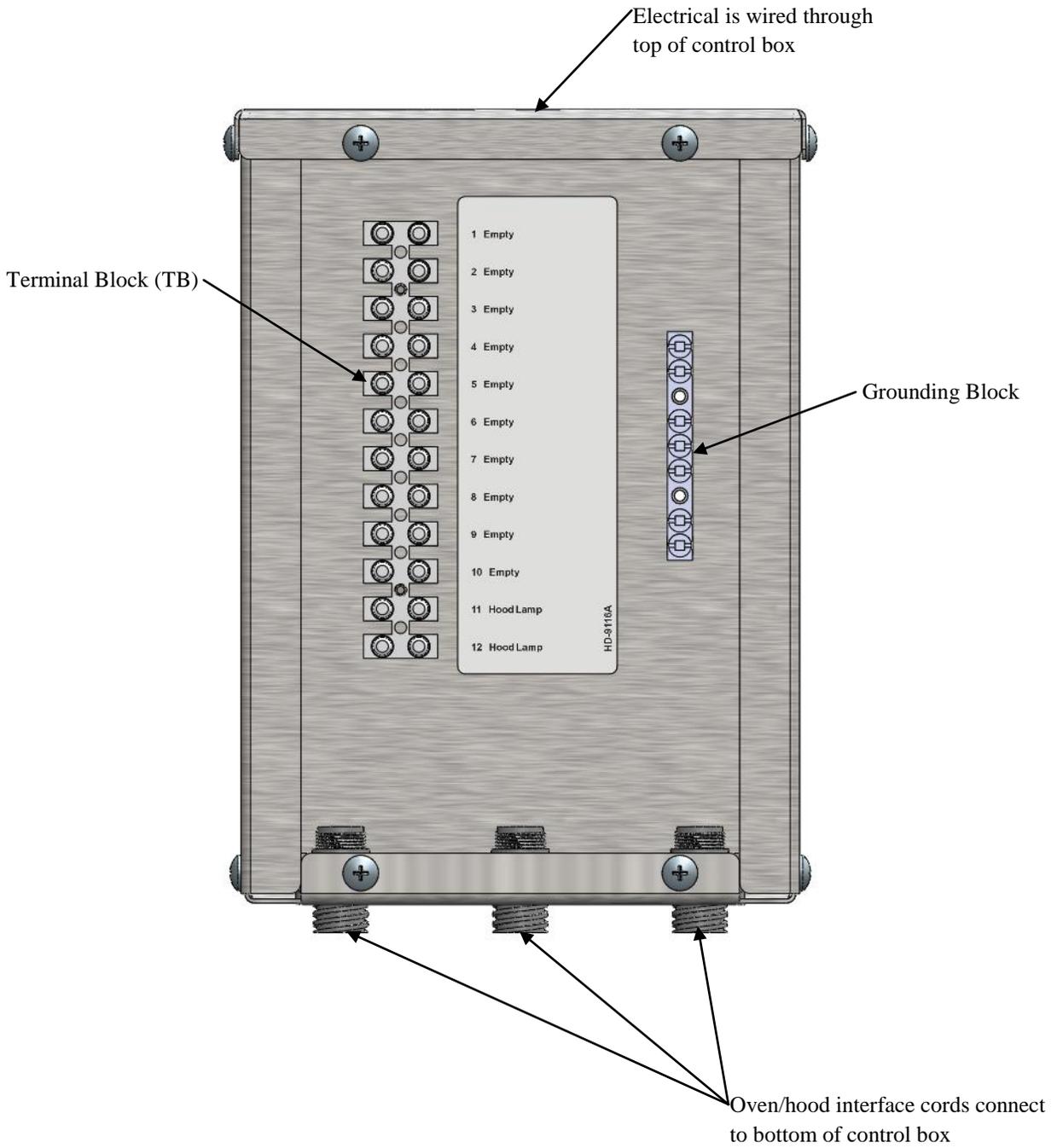
Relays located in VFD box

All wiring below the terminal block to be done by XLT Ovens and is shown for reference only.

Some wiring removed for clarity. See schematic for wiring details.

Hood Electrical Requirements

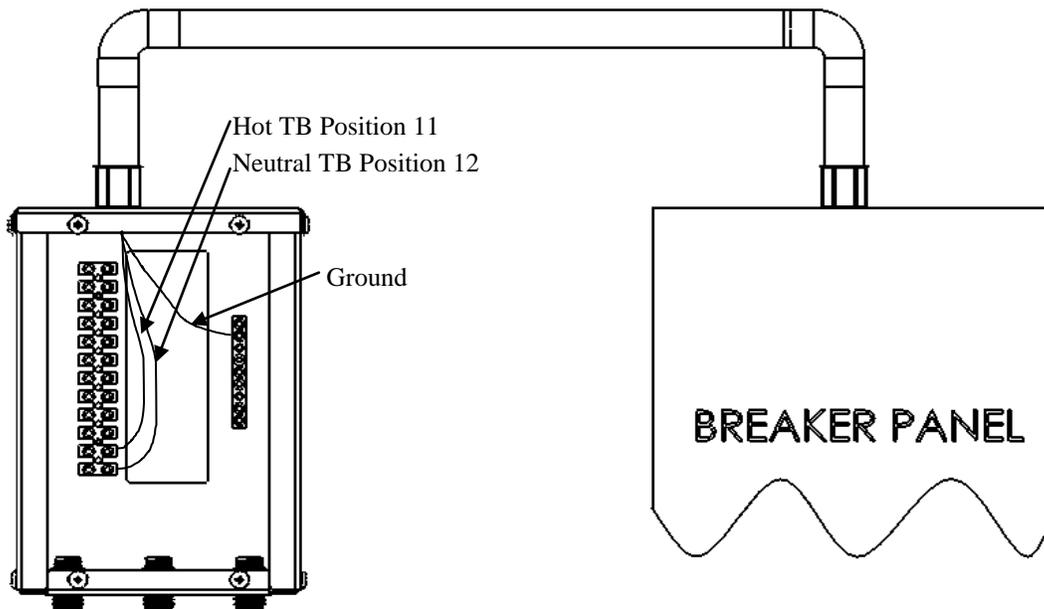
Without VFD Controller



Wiring removed for clarity. See schematic for wiring details.

Without VFD Controller Standard

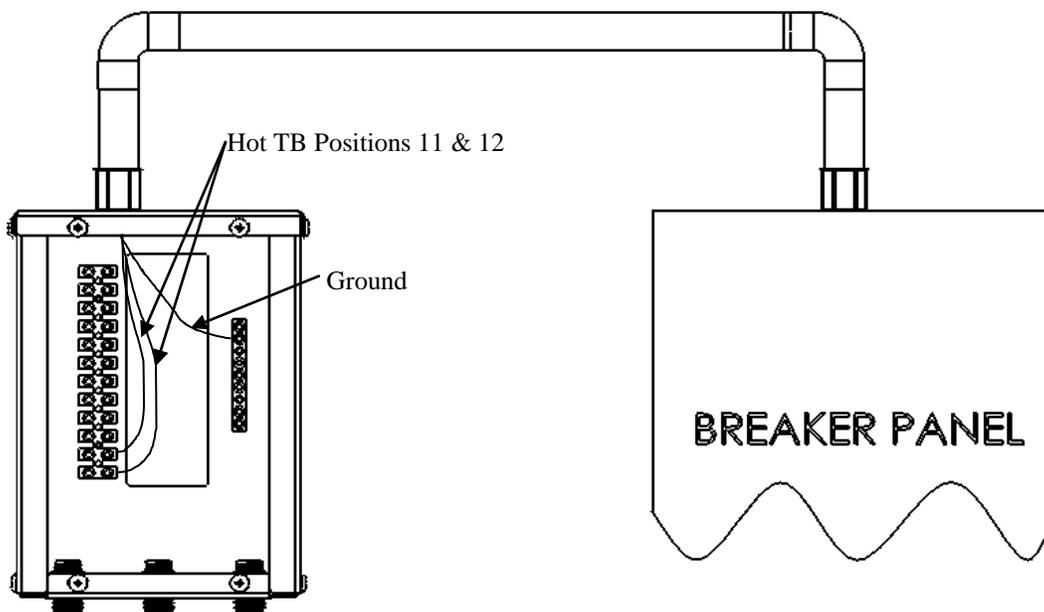
120V 1 Phase 10 Amp Circuit



Some wiring removed for clarity. See schematic for wiring details.

Without VFD Controller World

2300V 1 Phase 10 Amp Circuit



Some wiring removed for clarity. See schematic for wiring details.

Hood Ventilation Requirements

	Exhaust Flow Rates (min. recommended)						
	AVI 1832	AVI 2440	AVI 3240	AVI 3255	AVI 3270	AVI 3855	AVI 3870
Single	246 [6.97]	313 [8.86]	402 [11.38]	402 [11.38]	469 [13.28]	402 [11.38]	469 [13.28]
Double Stack	506 [14.33]	644 [18.24]	828 [23.45]	828 [23.45]	966 [27.35]	828 [23.45]	966 [27.35]
Triple Stack	766 [21.69]	975 [27.61]	1254 [35.51]	1254 [35.51]	1463 [41.43]	1254 [35.51]	1463 [41.43]

NOTE: All flow rates are CFM (M³/Min)

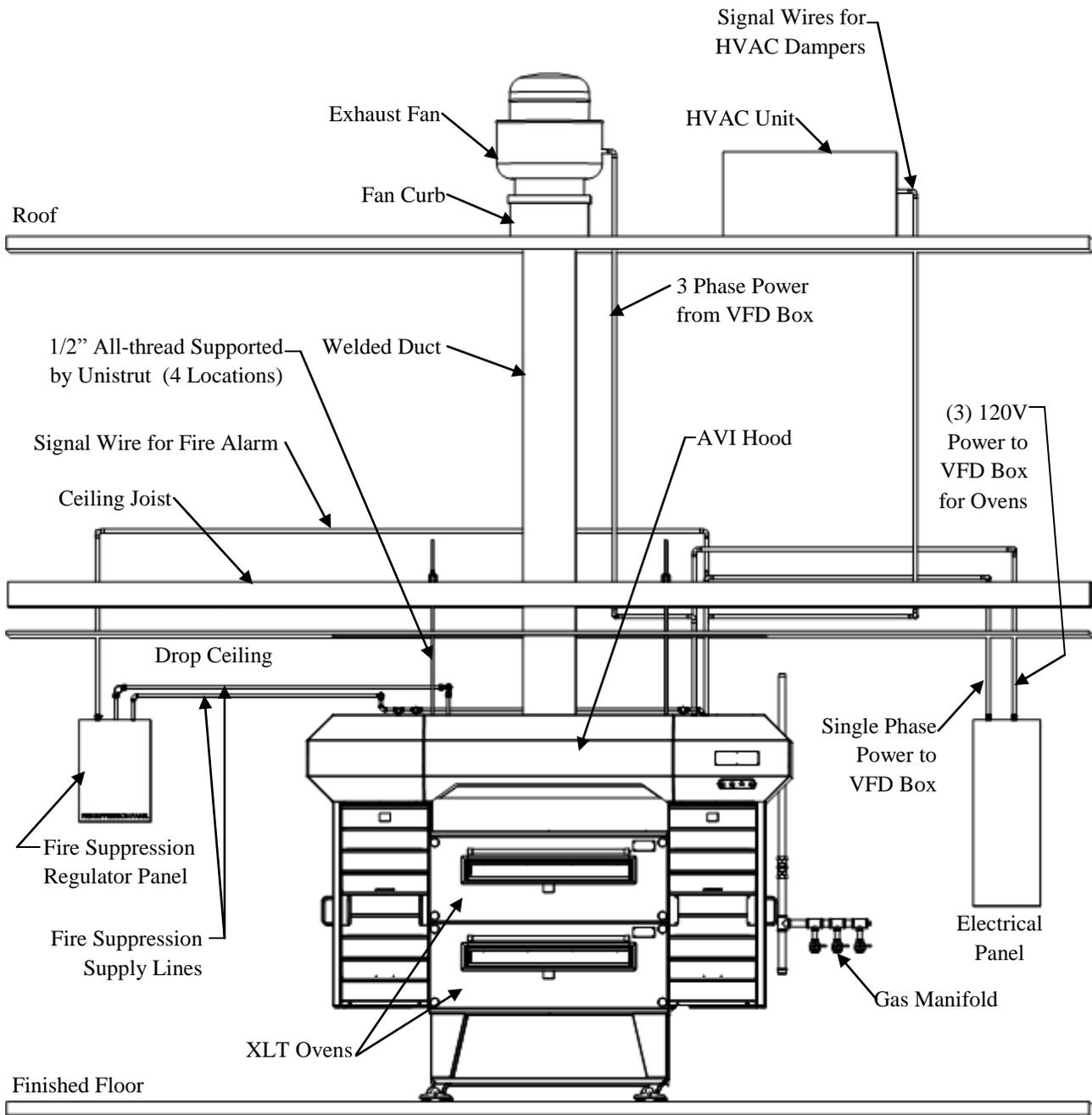
In accordance with mechanical codes, make up air must be supplied. For commercial kitchen make up air, the amount is determined by the exhaust hood flow rate requirements and all other exhaust flow rate requirements in the kitchen.

At a minimum, smoke candles must be used for a Capture and Containment (C&C) test. Refer to the Ventilation Requirements disclosed in the Oven section in this manual.

A Test and Balance (TAB) report is recommended after installation has been completed. Below are the minimum items to be included in this report:

- Total airflow on all A/C, Make-Up Air (MUA), and exhaust systems.
- Airflow on each supply and exhaust grille.
- Airflows on exhaust hoods compared to design specifications.

A final air balance report, with any corrections of issues found in the report, will help to insure that your building systems are functioning properly and efficiently.



All structural members, electrical, gas & fire suppression equipment shown for reference only.

**WARNING**

Check all local codes prior to installation. Special requirements may be necessary depending upon building material construction. It is the installing contractor's responsibly to ensure that the structure the hood is to be hung from meets all codes and can carry the hood weight.

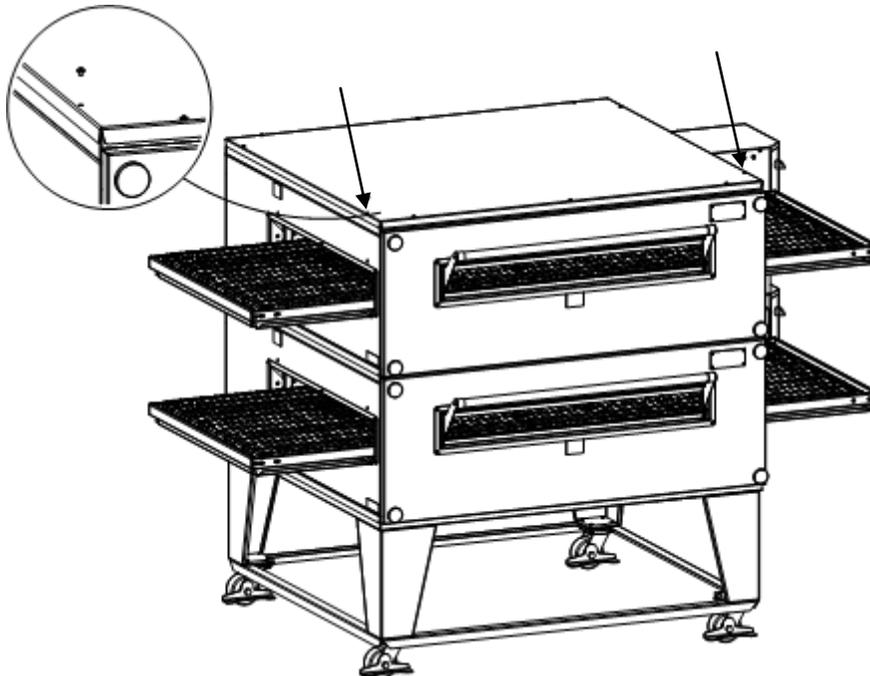
Purchaser's Responsibility

It is the responsibility of the purchaser:

- Thoroughly review the floor plans and specifications. The exact location of the oven must be determined before installing the hood.
- To unload, uncrate, assemble, and install the hood to it's intended location.
- To ensure that electric utilities are installed on site in accordance with local building codes and with the specifications in this manual.
- To see that electric utilities are connected properly by a qualified installer using the proper hardware.
- To ensure a qualified installer has performed an initial start-up procedure.
- Location should minimize long and twisted duct runs. Make efforts to have a straight clear path to the roof fan curb.
- All Hood supporting structures must be strong enough to support the weight of the hood and shrouds. Refer to the Specifications page for weight.
- Maintain the proper clearances from combustibile materials according to International Mechanical code (IMC), and National Fire Protection Agency (NFPA) 96, and local mechanical codes.

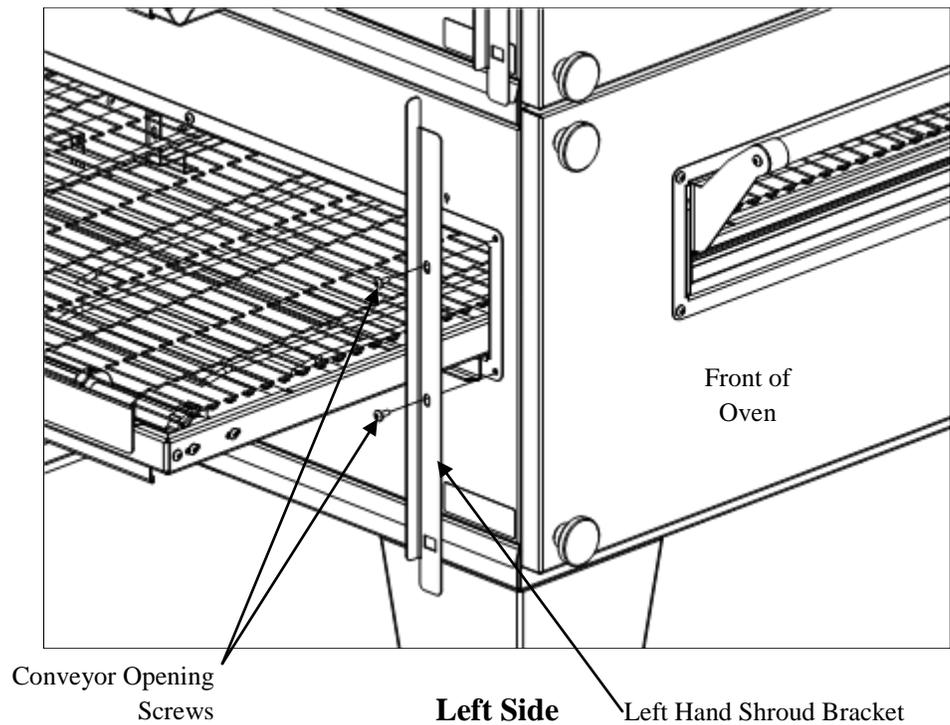
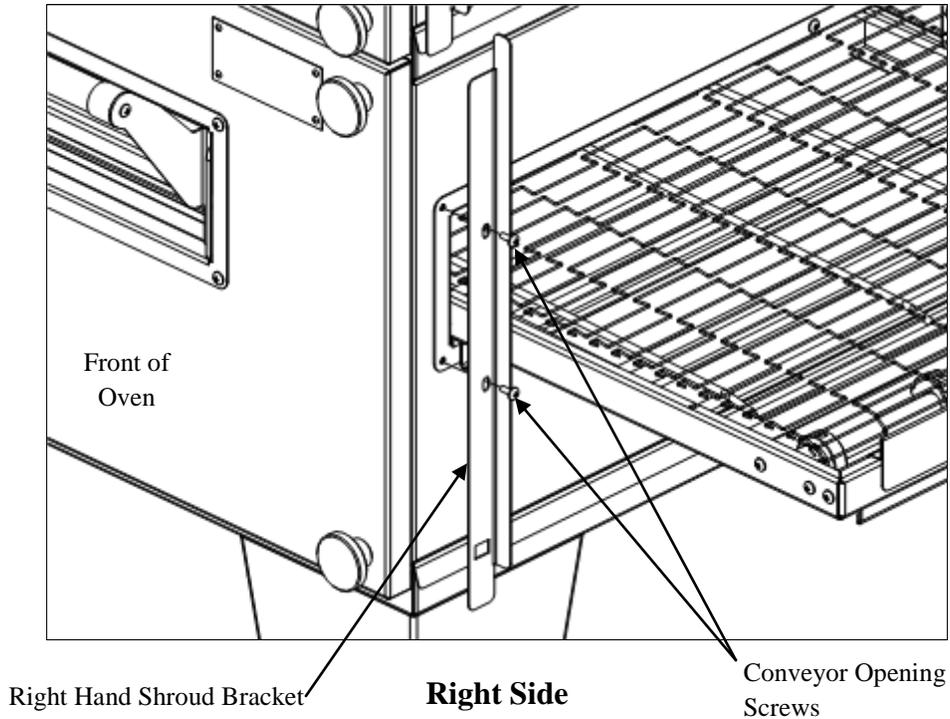
Prepare Ovens

Remove two (2) screws from the oven lid. Save for re-use.



Prepare Ovens—Front Shroud Brackets

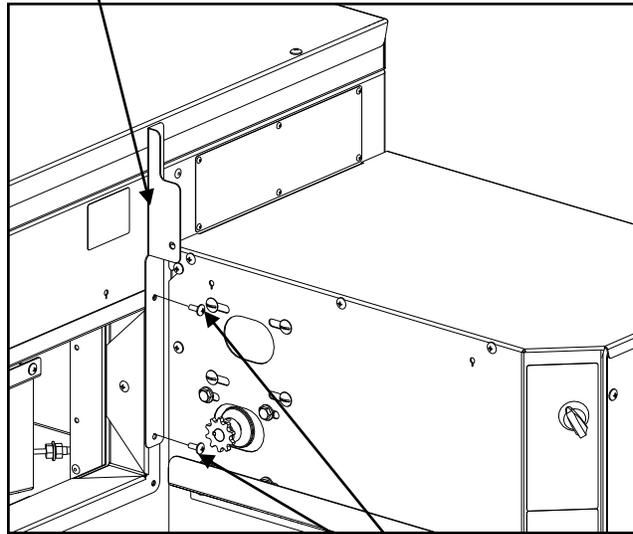
Install one (1) right and one (1) left front shroud bracket on each oven using the two (2) screws already installed in conveyor opening bezel. Orientate brackets with square hole towards bottom and flange toward center of oven.



Prepare Ovens - Right Hand Control Box Closeout Bracket

Install one (1) control box closeout bracket on top oven using the two (2) screws already installed in conveyor opening bezel. Orientate bracket with flange toward center of conveyor.

Control Box Closeout Bracket

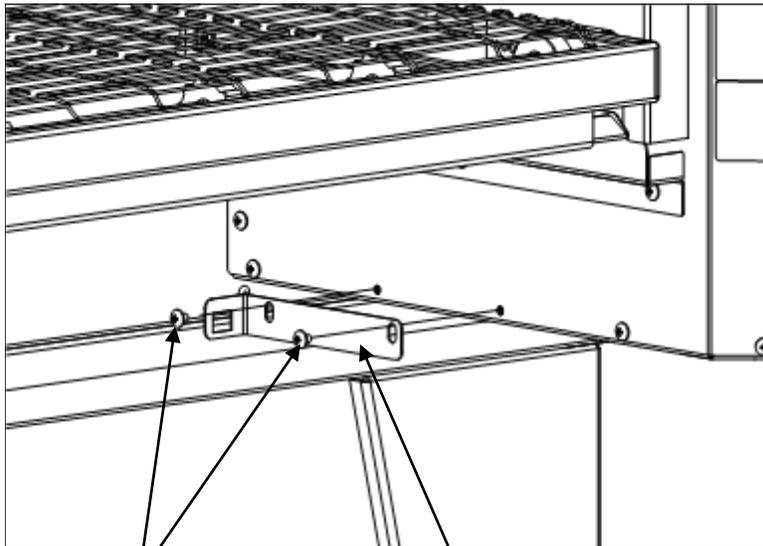


Conveyor Opening Screws

Conveyor and chain guard removed for clarity

Prepare Ovens - Right Side Bottom Rail Bracket

Install one (1) bottom rail bracket on bottom oven using two (2) center screws already installed in control box. Orientate bracket with square hole down and flange toward oven.



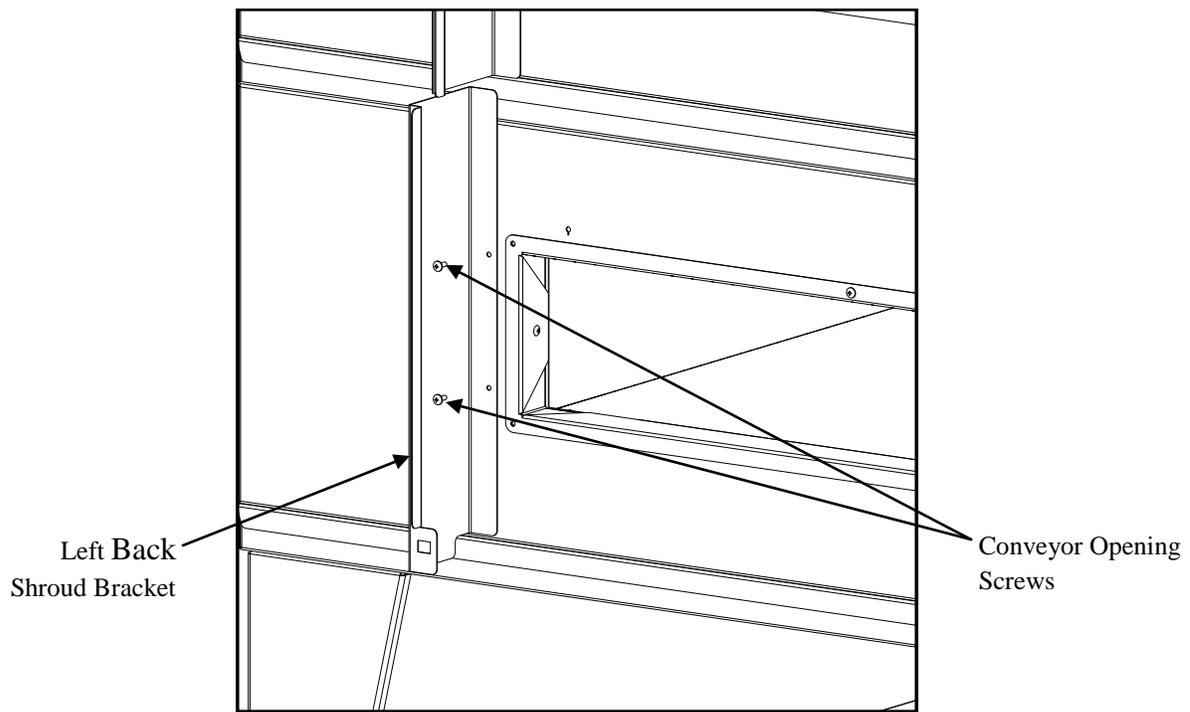
Control Box Screws

Bottom Rail Bracket

Prepare Ovens - Left Side Back Shroud Brackets

For Models 1832, 2440, 3240, 3255 & 3855

Install one (1) Left Back Shroud Bracket for each oven. The bottom oven will receive the bracket with a square hole, orientate this bracket with the square hole toward the floor. The other ovens will receive one(1) bracket each without the square hole.

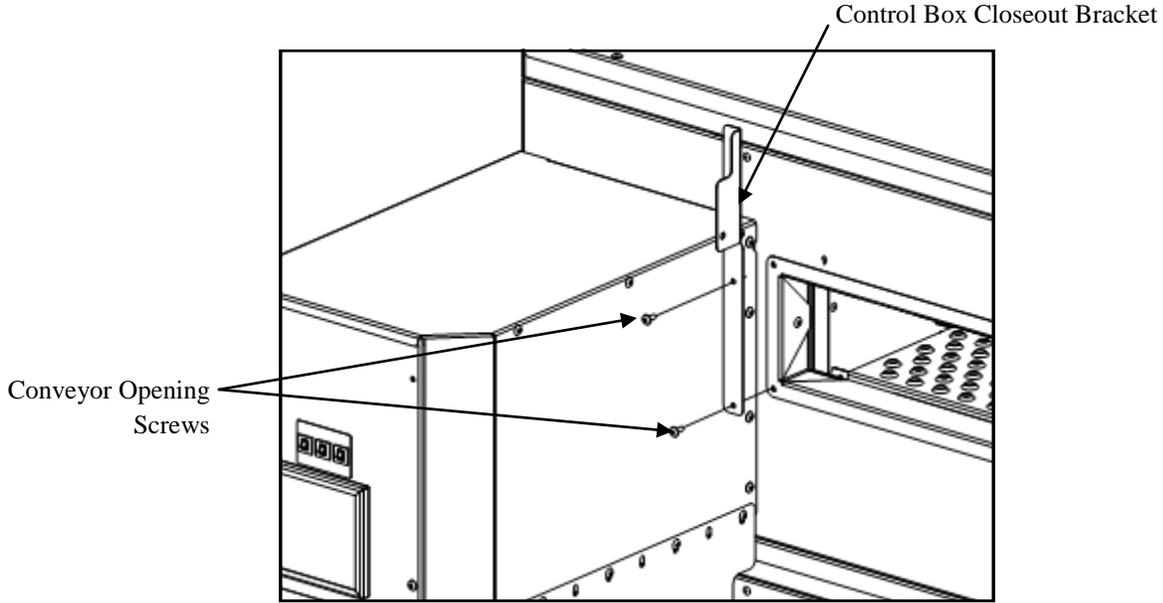


Conveyor removed for clarity.

Prepare Ovens - Left Hand Control Box Closeout Bracket

For Models 3270 & 3870

Install one (1) control box closeout bracket on top oven using the two (2) screws already installed in conveyor opening bezel. Orientate bracket with flange toward center of conveyor.

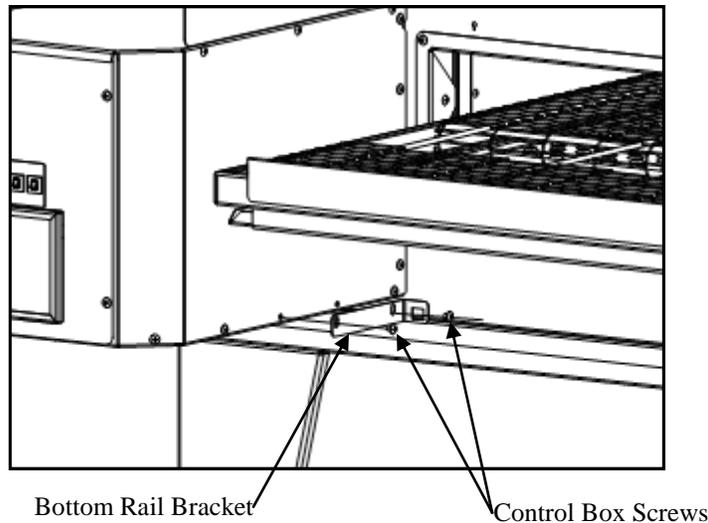


Conveyor removed for clarity

Prepare Ovens - Left Side Bottom Rail Bracket

For Models 3270 & 3870

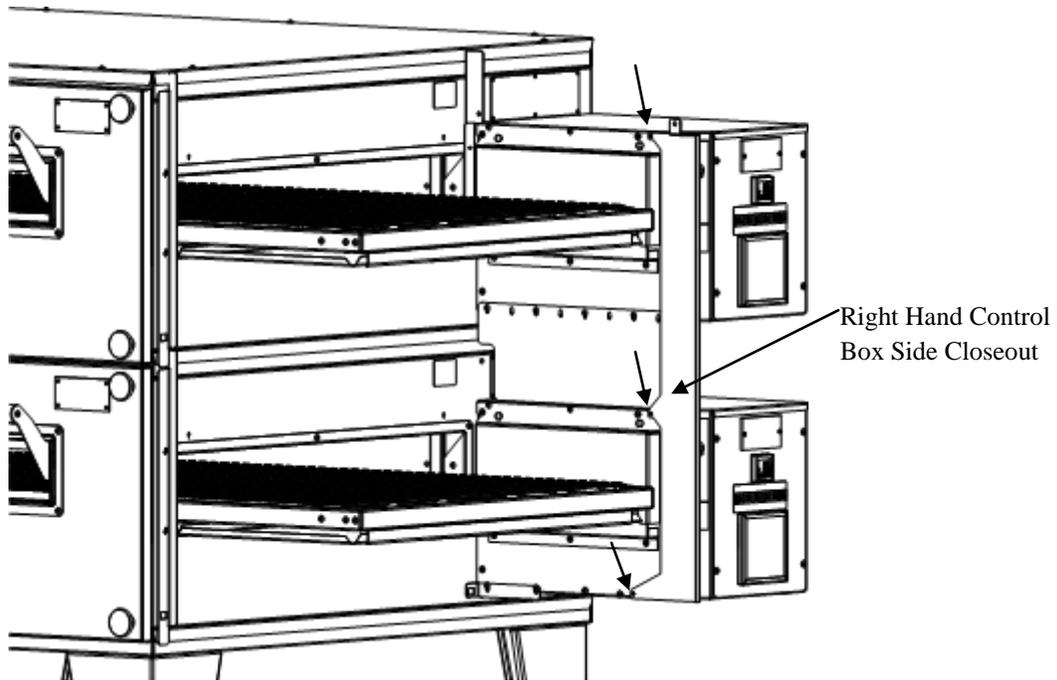
Install one (1) bottom rail bracket on bottom oven using two (2) center screws already installed in control box. Orientate bracket with square hole down and flange toward oven.



Prepare Ovens - Control Box Side Closeout

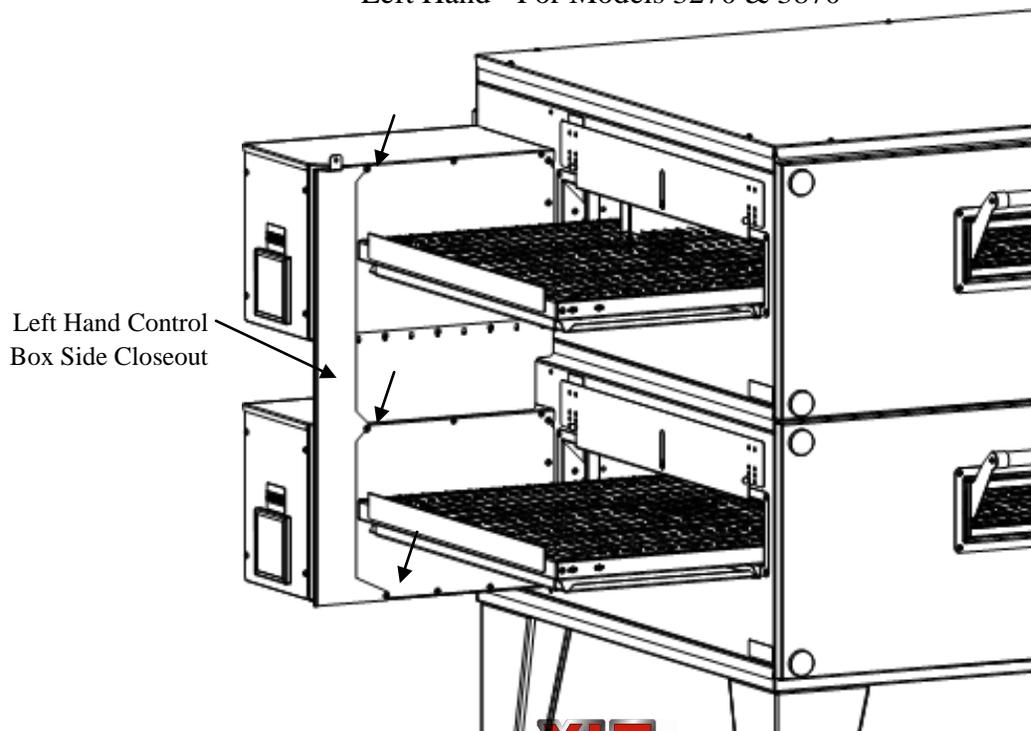
Right Hand - For All Models

Install right hand control box side closeout using screws already installed on control boxes, at locations shown with arrows. Upper flange of closeout to face front of oven. (double stack shown, brackets for single and triple will look slightly different)



Install left hand control box side closeout by same method as right side.

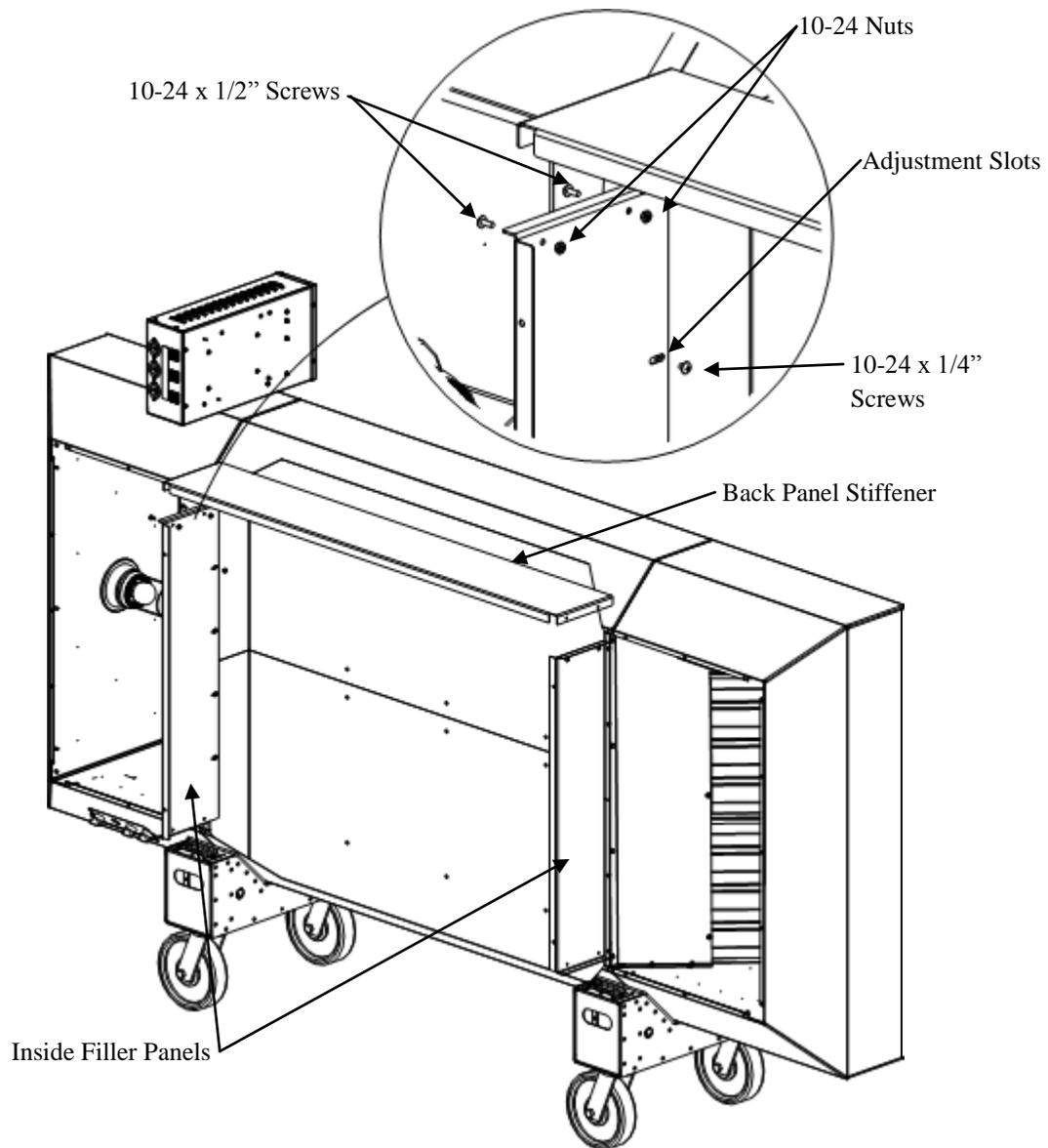
Left Hand - For Models 3270 & 3870



Prepare Hood

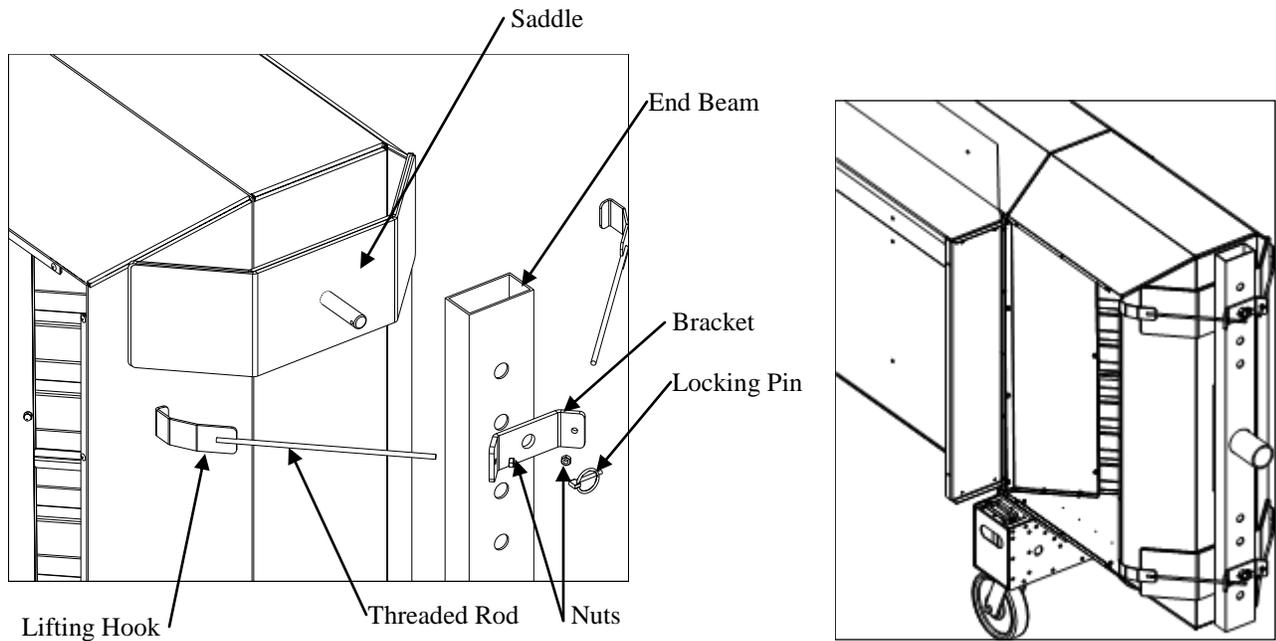
Attach inside filler panels using eight (8) 10-24 x 1/4" screws (provided). Tighten screws in adjustment slots with panels pushed as far as possible toward hood.

Attach back panel stiffener to inside filler panels using 10-24 x 1/2" Screws and Nuts, two (2) each end (provided). Install so that the screw heads are inside filter areas.

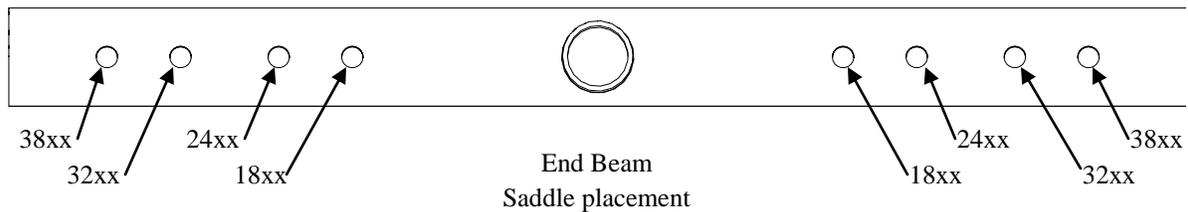


Illustrations shown with AVI hood on cart, same instructions apply when AVI hood is crate shipped.

Lifting Gear Setup



Left end shown, right end similar

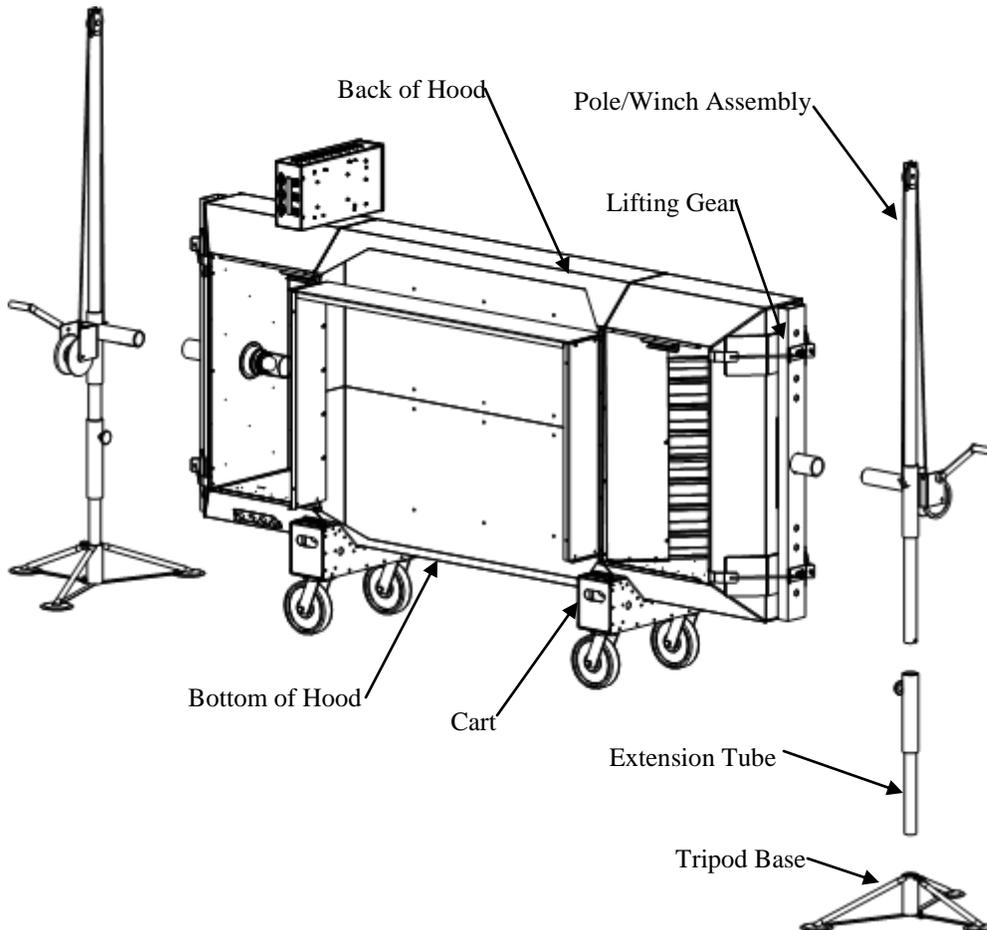


1. Insert end of each threaded rod into the small holes located on bracket so that ends are to the inside of bracket.
2. Thread nuts about 1/2" (12.7mm) onto threaded rod ends.
3. Slide saddle pin through appropriate hole located on End Beam, see placement diagram above.
4. Slide bracket and lifting hook assembly onto saddle pin with bracket resting flat on end beam.
5. Insert locking pin in hole located near end of saddle pin.
6. Place lifting gear assembly against end of hood with saddle pads against vertical surface.
7. Insert each lifting hook into notch located at corner of fascia end.
8. Tighten nuts on threaded rods until End Beam can not be moved.

Lifting Jack Setup

Each lifting jack consists of three (3) parts; the pole/winch assembly, extension tube, and tripod base.

1. Place the smaller end of extension tube into tripod base.
2. Place bottom of the pole into the top of the extension tube and tighten knob.
 - Check for smooth operation. The cable should not be pinched and should pass smoothly over the pulley on top of the pole assembly.
 - Inspect cable prior to each use.
 - If cable is frayed or shows signs of excessive wear and tear, DO NOT USE until cable is replaced.
 - At a minimum replace the cable annually with wire rope that meets or exceeds the jack manufacturer's specifications.
 - Do not exceed the stated capacity of the jack.



Illustrations shown with AVI hood on cart, same instructions apply when hood is crate shipped.

Stacking Hood on the Ovens

1. Fully insert the lifting jacks into the lifting gear assemblies attached to each end of the hood.
 - Failure to engage properly can result in damage, injury, or death from a falling Hood.



WARNING

2. Raise the hood high enough to clear the cart or skid.
 - Both jacks should be raised in unison, otherwise they may bind and a dangerous situation may develop.
 - Do not put any part of yourself under the hood at any time.
 - The hood is top heavy. Be careful!

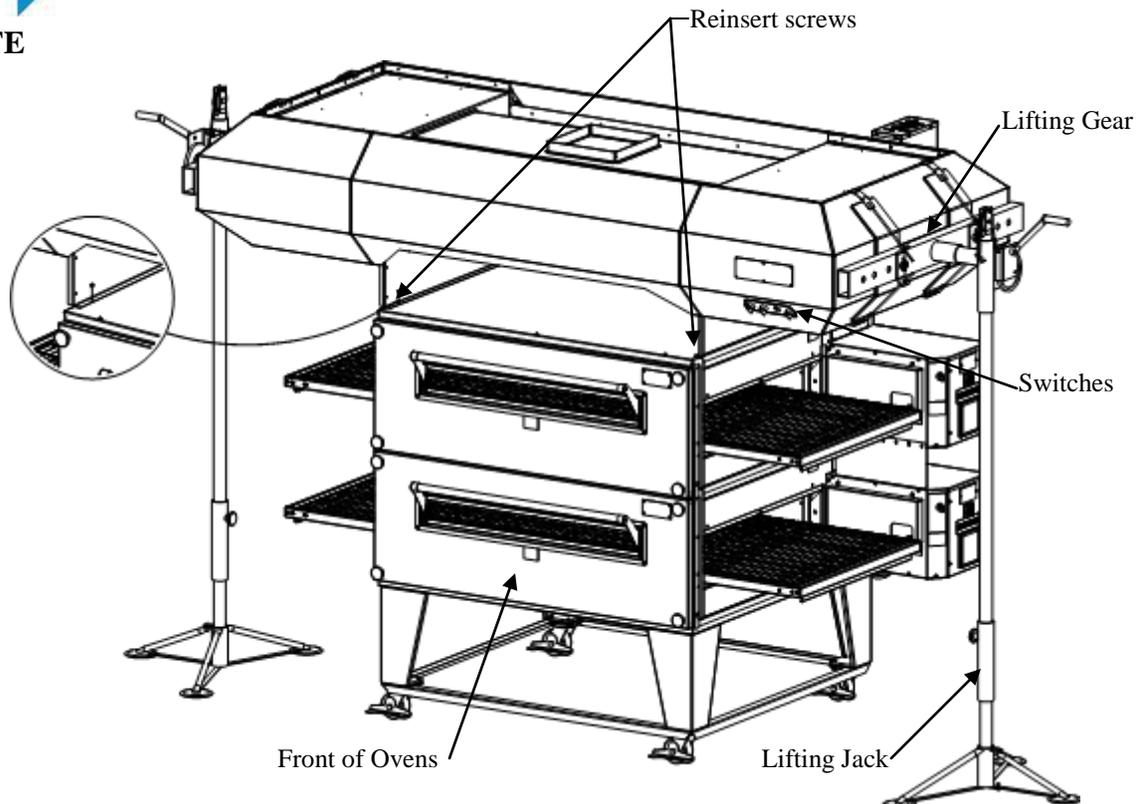


WARNING

3. Remove the cart or skid.
4. Rotate the hood as shown.
5. Raise the hood high enough to clear top oven.
6. Roll the oven stack underneath the hood.
7. Lower the hood onto the ovens lining up the two (2) front screw holes in the inside filler panels with the screw holes on oven lid.
8. Reinsert screws saved from previous step.
9. Remove lifting jacks and lifting gear from ends of hood
10. Move oven/hood stack into position.

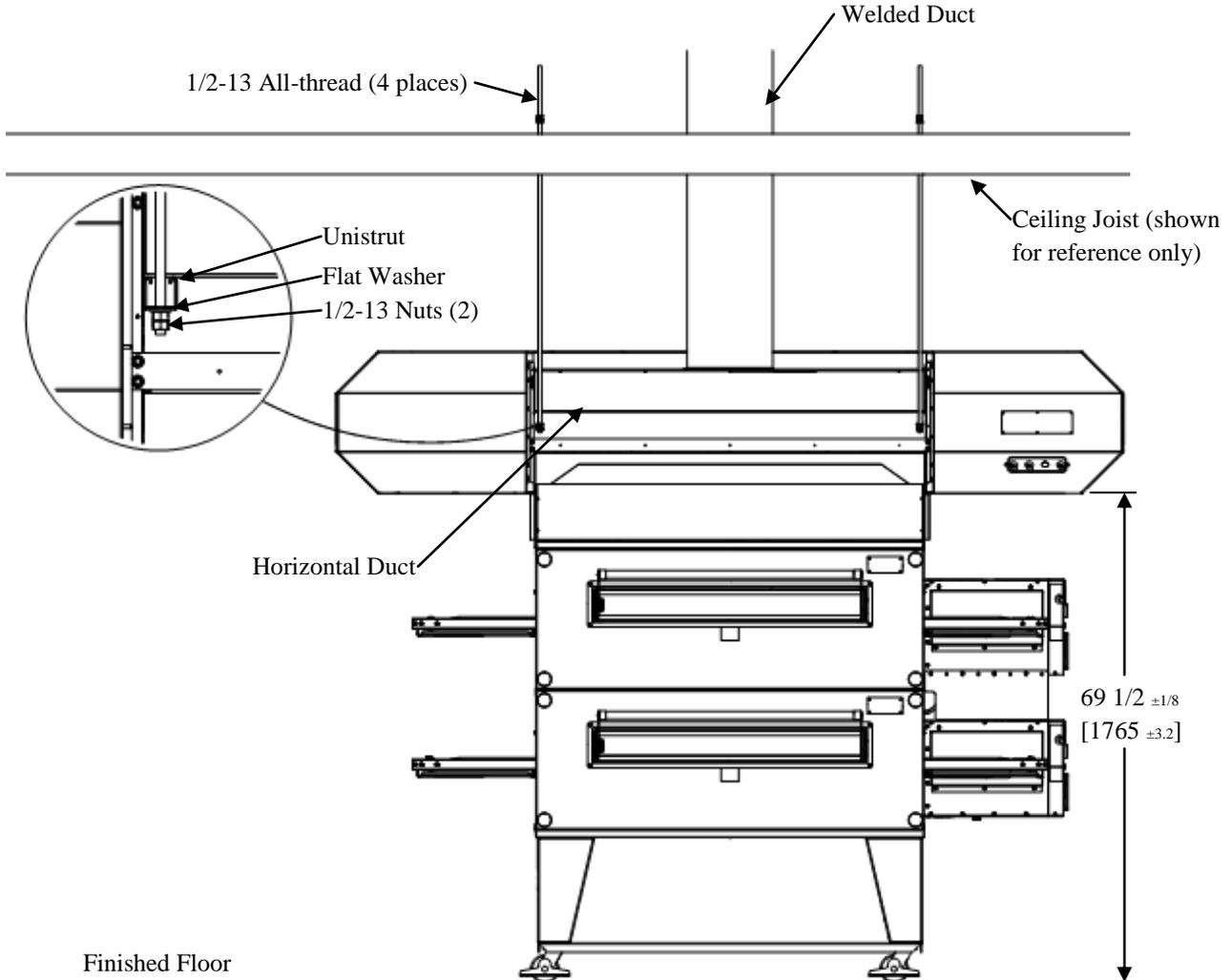
 Switches **MUST** face front of ovens.

NOTE



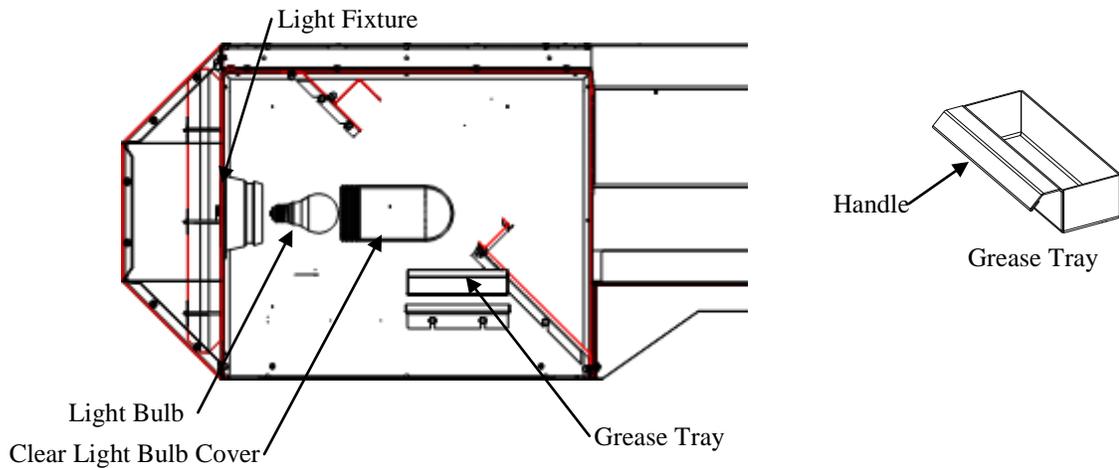
Hang Hood From Ceiling Joists

After the AVI Hood has been installed on top of the ovens and moved into position, it must be hung from the building structure to relieve the weight from the ovens and to allow the ovens to be moved for maintenance and cleaning. XLT Ovens supplies two (2), 24" [610mm] long pieces of Unistrut for installation under the horizontal air duct located in the center of the hood. Shown below is a typical installation using four (4) pieces of Unistrut and four (4) lengths of 1/2"-13 all-thread. It is recommended that a flat washer and two (2) nuts be placed under the bottom piece of Unistrut and over the top piece to prevent the hood from moving after installation is complete. Please note the final distance from the finished floor to the bottom of the hood must be 69 1/2" +/- 1/8" [1765mm +/- 3.2], measured at all four (4) corners.



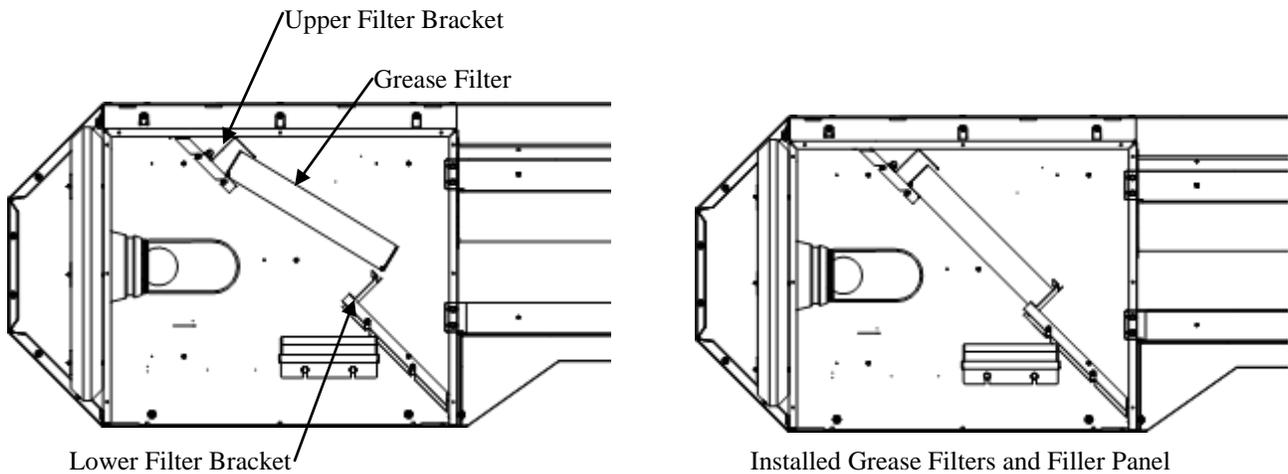
Front fascia panel removed for clarity

Install Grease Trays, Light Bulbs & Light Bulb Covers



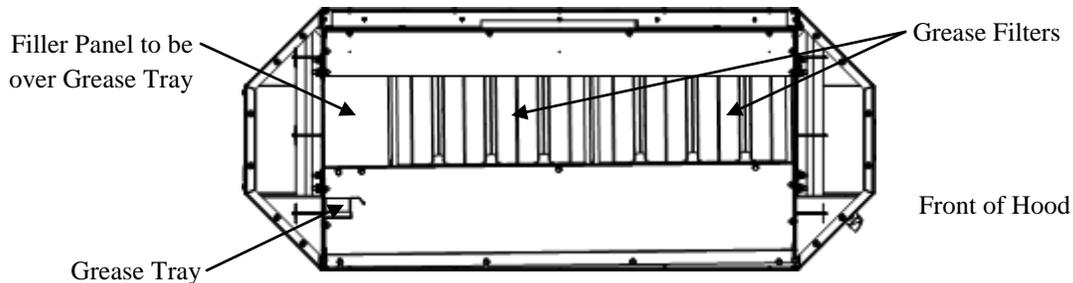
Left end shown - Repeat for right end

Install Grease Filters & Filler Panels



Left End Shown - Repeat for Right End

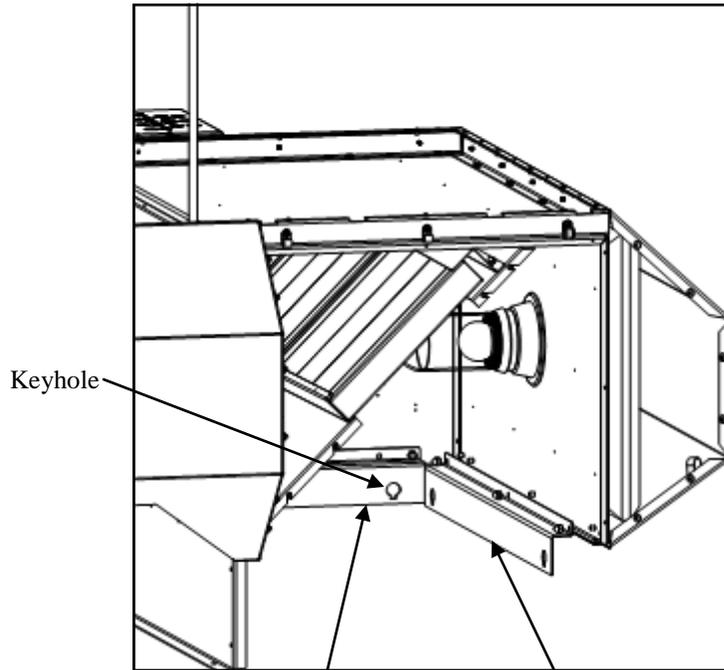
1. Insert bottom of grease filter filler panel behind lower filter bracket.
2. Slide top of grease filter/filler panel into upper filter bracket.
3. Raise grease filter/filler panel up until bottom clears back of lower filter bracket.
4. Rest bottom of grease filter/filler panel into lower filter bracket.



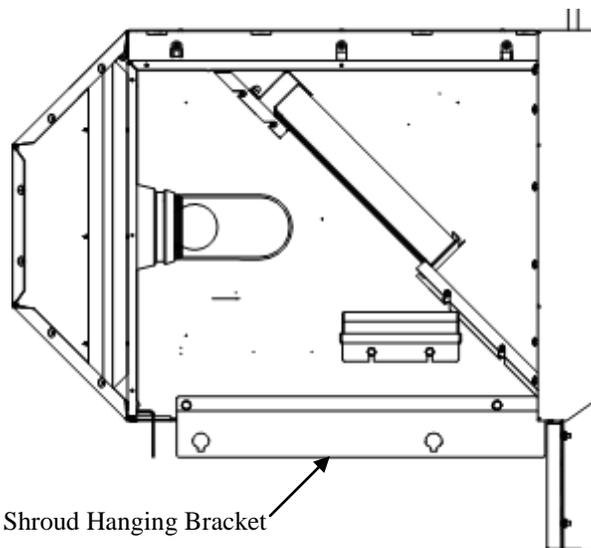
As viewed from end. Some parts removed for clarity.

Install Shroud Hanging Brackets

Install the end and front/back shroud hanging brackets with acorn nuts (provided). End brackets require three (3) acorn nuts and front/back brackets require (2) acorn nuts. Flange with keyholes should protrude into filter area.



Keyhole
 Front/Back Shroud Hanging Bracket
 (Back right shown, both front brackets similar)
 End Shroud Hanging Bracket

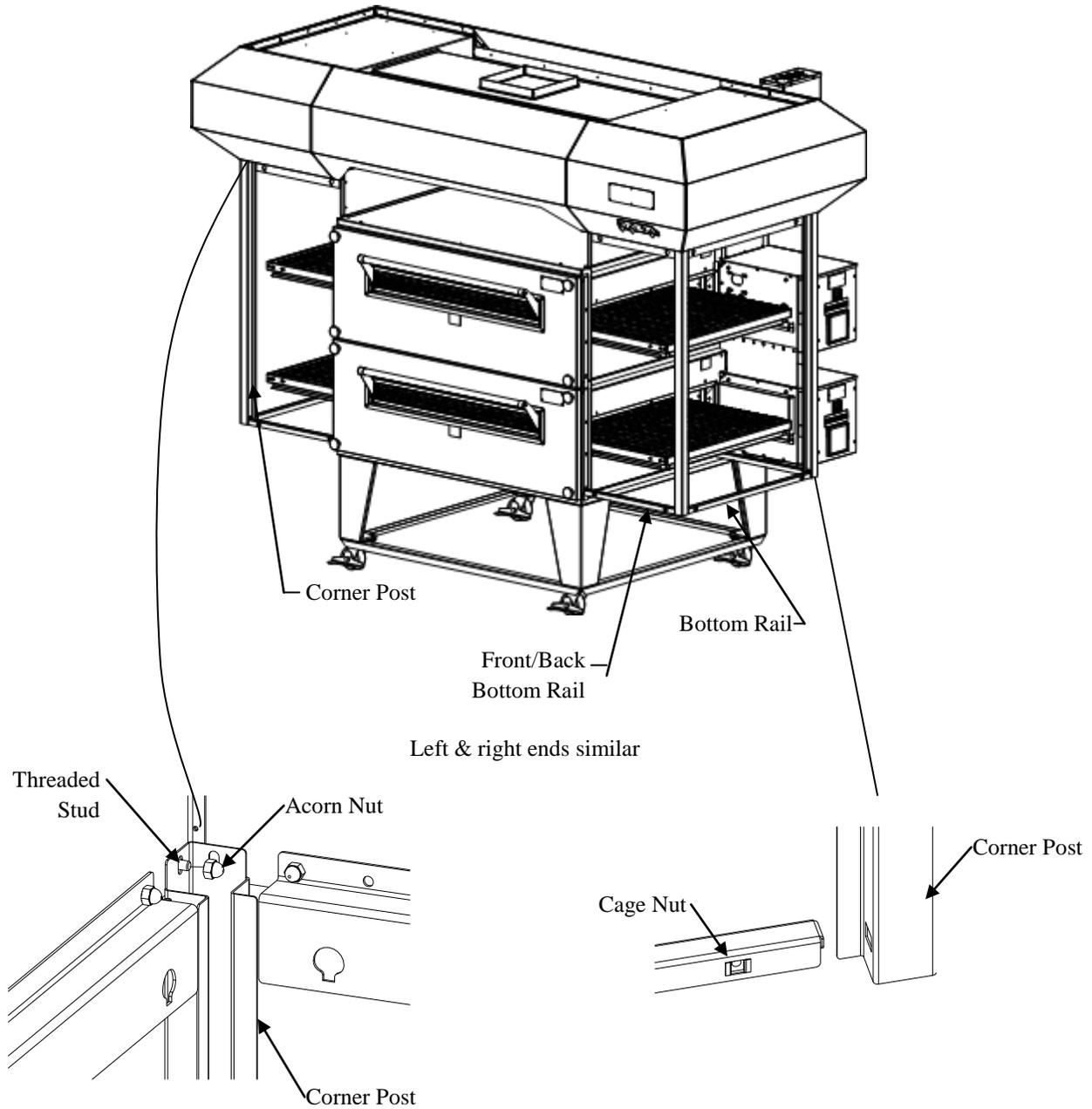


Left Back Shroud Hanging Bracket
 Note: Keyholes are offset for this bracket only

Left end shown, right end similar. Some parts removed for clarity

Install Corner Posts & Bottom Rails

Install corner post onto threaded stud located in between shroud hanging brackets. Secure with one (1) acorn nut. (4 locations)

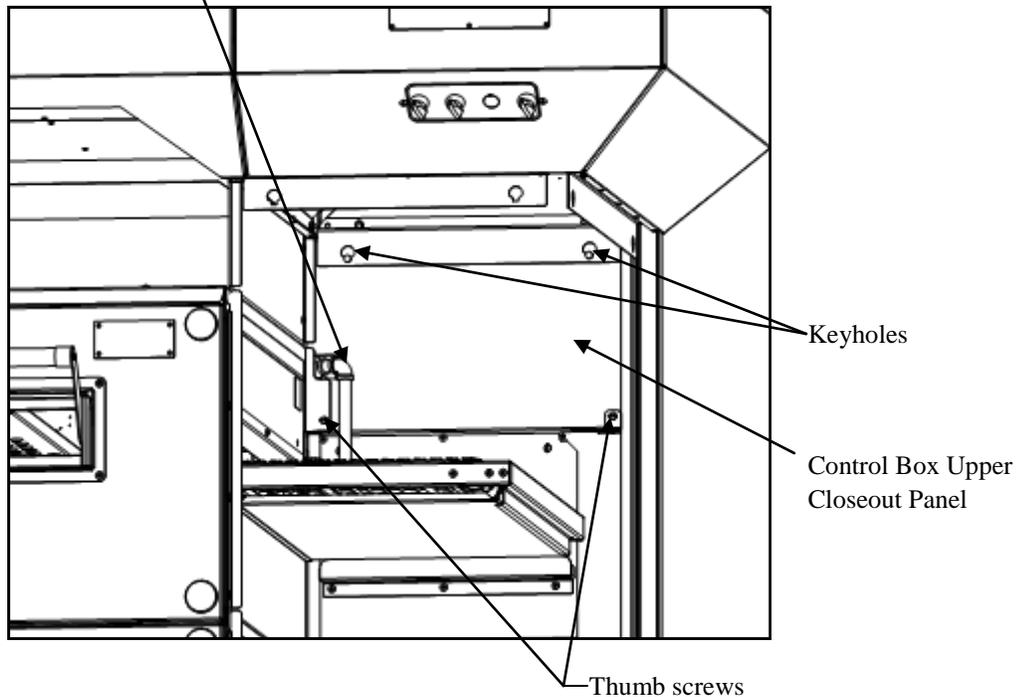


Slide tabs on bottom rails into square holes in bottom of corner posts and brackets. Install with cage nuts facing away from ovens.

Install Control Box Upper Closeout

1. Install one (1) Control Box Upper Closeout Panel above upper Control Box.
2. Line up shoulder bolts located near top of panel with keyholes in bracket, allow panel to drop into place.
3. Install thumb screws from conveyor side through previously installed bracket, thread into Control Box Upper Closeout Panel.
4. Repeat for left side if ovens have left hand control boxes.

Fire Suppression Piping (optional)

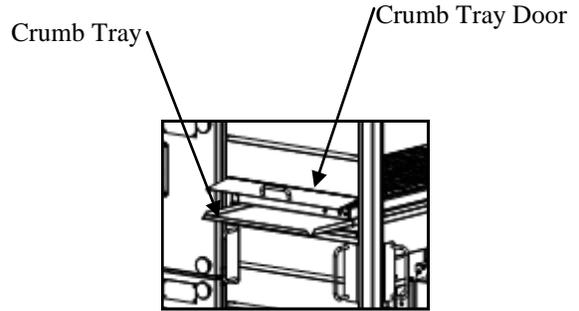
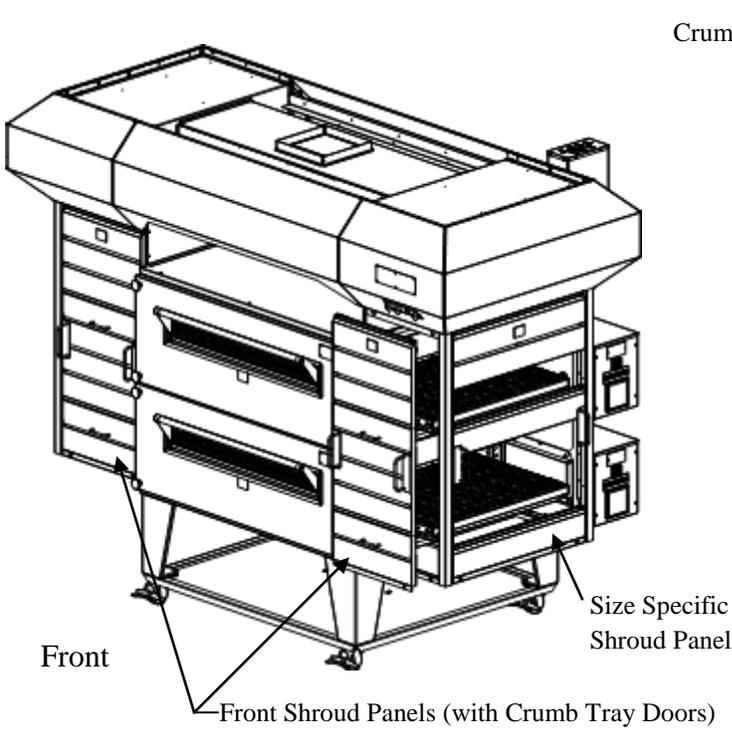


Some components removed for clarity. Right side shown, left side similar if applicable.

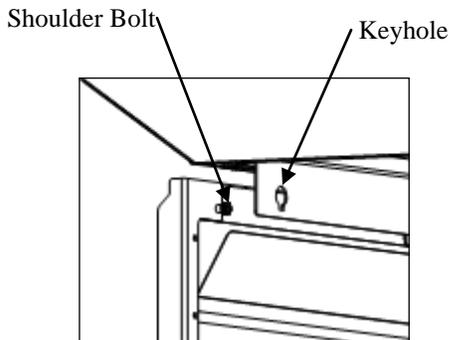
Install Shroud Panels - Front and Ends

End load/end unload shown. Other configurations available.

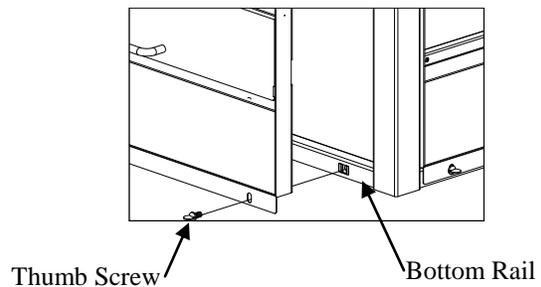
Line up shoulder bolts with keyholes in bracket. Allow panel to drop into place. Secure bottom of Shroud Panel to bottom rail with two (2) thumb screws.



Open crumb tray doors located in front shroud panels & verify crumb trays are easily removable.
Adjust All-thread supporting hood from ceiling joists as needed for best fit.



Top inside of Shroud Panel
(applies to all Shroud Panels)

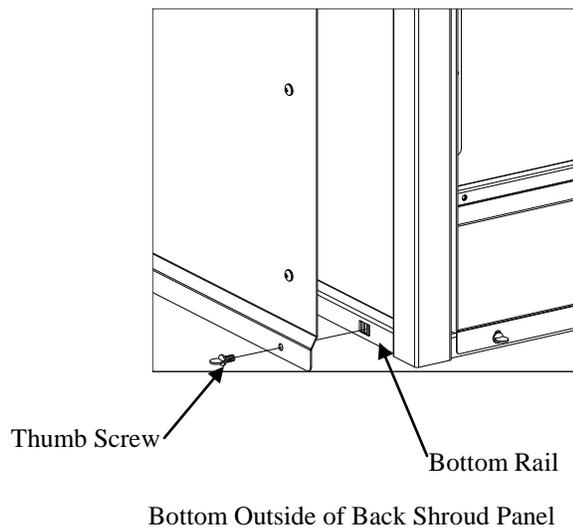
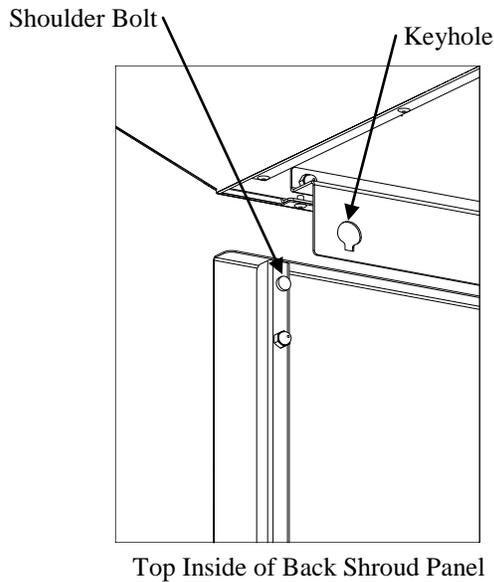
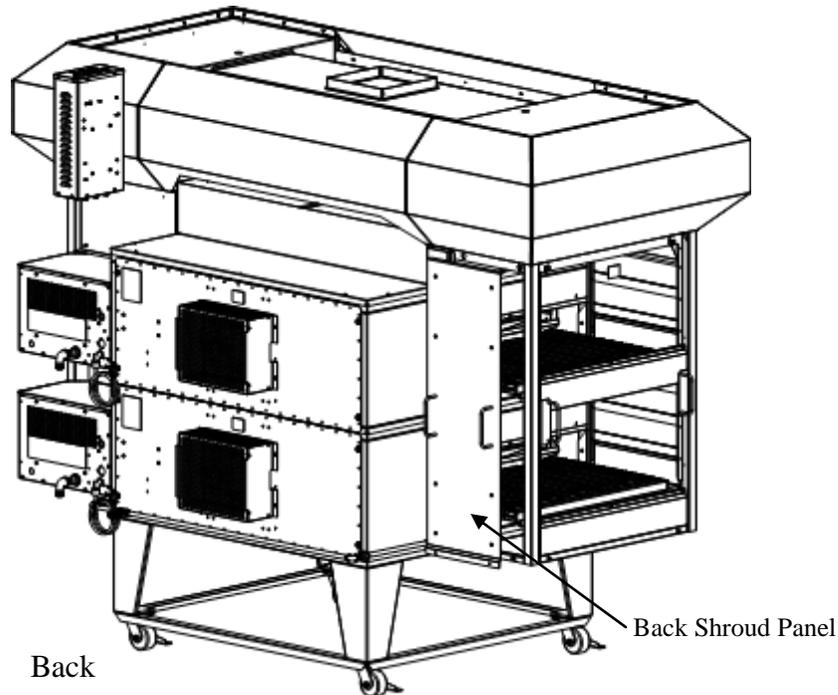


Bottom Outside of Shroud Panel
(applies to all Shroud Panels)

Install Back Shroud Panel

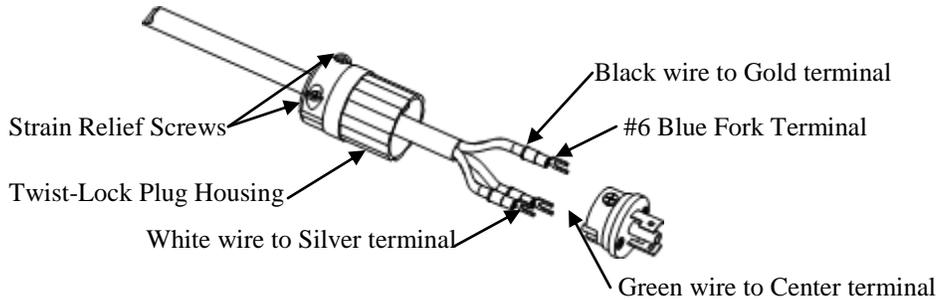
For models 1832, 2440, 3240, 3255 & 3855

Line up shoulder bolts with keyholes in bracket. Allow panel to drop into place. Secure bottom of Shroud Panel to bottom rail with two (2) thumb screws.



Oven Power Cord Modification

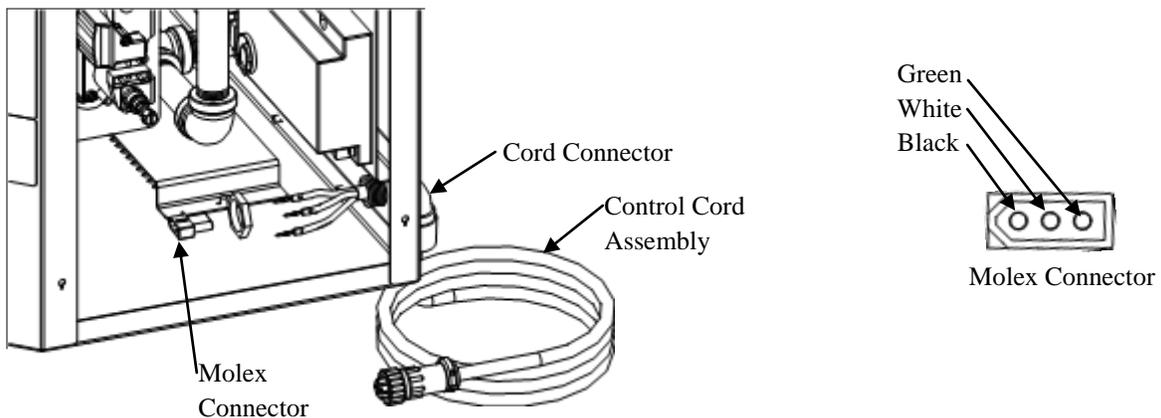
Replace the straight-blade plug with a twist-lock plug. Follow the plug manufacturer's instructions.



Hood Control Cord Assembly

The Oven ON/OFF switch must be bypassed when used with an AVI Hood. To bypass the switch, a control cord assembly must be installed from the back of the control box to the VFD box.

1. Remove the control box lid.
2. Move the Control Panel to the service position.
3. Remove the knock-out located on the lower right hand corner of the control box back panel.
4. Install the cord connector through the knock-out hole.
5. Insert male Molex pins on the ends of the cord into the Molex connector, following the diagram below.
6. Unplug the Molex connector going to the main switch assembly located in the control box.
7. Plug the control cord assembly into the Molex connector that goes to the oven switch.

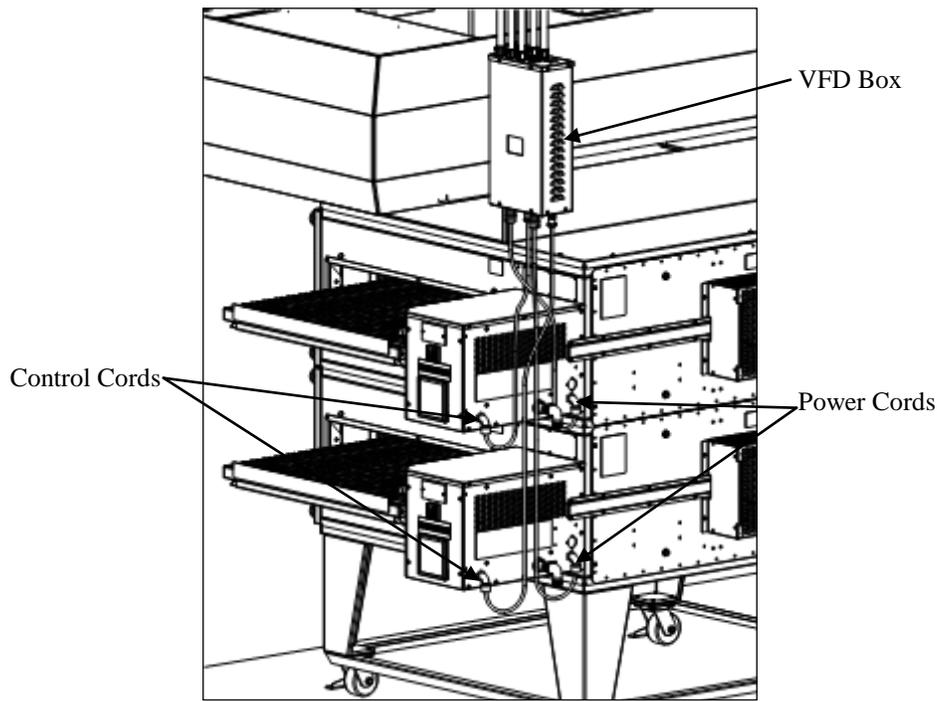
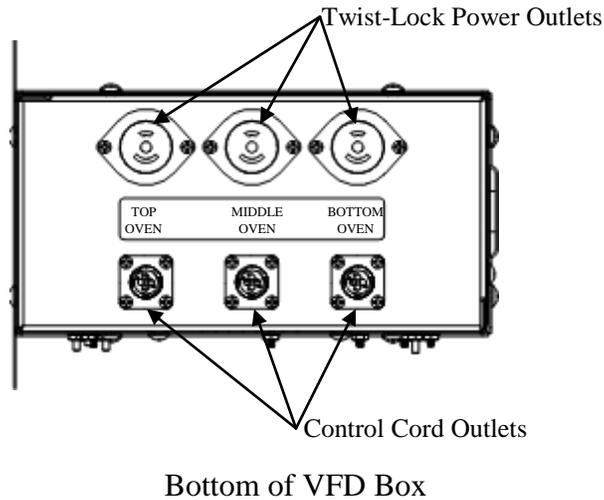


Note: Some components removed for clarity.

Connect Oven Power and Controls to Hood

After appropriate connections have been made, the oven power and control cords must be connected to the VFD box located on the right back corner of the AVI Hood. All VFD boxes are outfitted with three (3) power outlets and three (3) control cord outlets, regardless of how many XLT Ovens are installed. For a single oven use “Top” location. For a double stack use “Top” location for upper oven and “Bottom” location for lower oven, leaving “Middle” location open.

1. Insert and twist each oven power cord into the designated location on the bottom of the VFD box.
2. Insert and lock each oven control cord into the designated location on the bottom of the VFD box.



Back of Oven & Hood unit

Double stack shown, setup for single and triple stacks is similar.

At initial start up, the VFD controller must be set to ensure proper exhaust fan operation.

1. Set F001 (Main profile parameters). This will set the output frequency for the exhaust fan.
 - a. Press & hold the function key until **d001** displays.
 - b. Use the up / down arrows to reach the **F001**.
 - c. Press the function key one time.
 - d. With all of the switches in the off position the display should read **0.0**
 - e. Turn on the oven switches to be set.
 - f. Press the Up/Down arrows until you reach the desired initial settings.

1832 & 2440

- (1) Oven = 20 Hz
- (2) Ovens = 30 Hz
- (3) Ovens = 40 Hz

3240, 3255, & 3270

- (1) Oven = 25 Hz
- (2) Ovens = 35 Hz
- (3) Ovens = 45 Hz

3855 & 3870

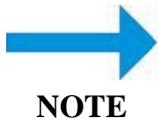
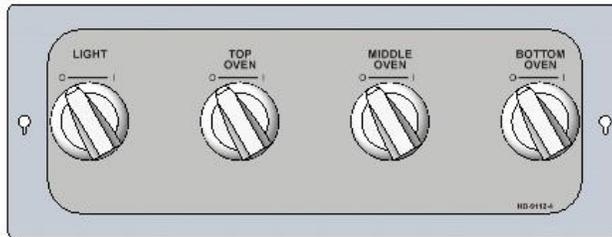
- (1) Oven = 30 Hz
- (2) Ovens = 40 Hz
- (3) Ovens = 50 Hz

- g. Press the store button once to store the new setting.
2. Repeat steps d – g for additional settings.
 3. When finished turn all of the switches to the off position.
 4. Next press the function key & hold until **d001** (Display Mode) appears on the display.
 - a. Press the function one more time **0.0** should display.
 - b. Press the store button one time to store display mode as the default.



VFD Controller Display

The control switches are located on the front of the hood.



When XLT Ovens are outfitted with AVI Hoods, the main switch on the oven is disabled and no longer operates. The switch on the AVI Hood overrides the oven switch.

NOTE

Hood Operation

1. Turn the light switch on.
2. Turn the desired oven switch on. Refer to the Oven start-up section for instructions on how to adjust temperature and conveyor speed. The oven(s), exhaust fan, and make-up air unit will be activated by this switch.
3. When additional oven switches are turned on, the VFD will automatically increase the exhaust fan speed.
4. When shutting down the ovens, turn the desired switch off. Refer to the Oven shutdown section for instructions.

Hood Initial Start-Up

All AVI Hoods are function tested at the factory. Operation is verified, and adjustments are made to ensure proper operation. However, field conditions are sometimes different than factory conditions, such as voltage and CFM pressure. These variables make it necessary to have an authorized service technician verify operation and make field adjustments if needed. The following items must be checked and verified to meet the specifications and requirements stated in this manual prior to the hood being commissioned:

- Length of duct run.
- Number of bends in duct.
- Correct fan rotation.
- Balanced make-up air.

The following Initial Start-Up Checklist must be completed at time of installation, signed by the Customer and returned to XLT Ovens to initiate Warranty Policy.

Hood Initial Start-up Checklist - Remove & Return to XLT Ovens

AVI Hood

Model #: _____

Serial #: _____

Hood hung prior to oven installation: Yes No

Height from bottom of hood to finished floor: _____

Hood hung to local & state codes: Yes No

Switches face front of ovens: Yes No

VFD box cover replaced after installation: Yes No

All shroud panels properly installed: Yes No

Grease filters installed (note top and front markings):
 Yes No

Drip trays installed: Yes No

Crumb trays easily removable: Yes No

Oven power cords connected to VFD box: Yes No
Electric Oven N/A

Oven switch cords connected to VFD box: Yes No

Lights operate with switch: Yes No

Light globes installed over bulbs: Yes No

VFD power supplied: _____ Volt _____ Amp
_____ Hz _____ Phase

Exhaust fan purchased from XLT: Yes No

Rating of exhaust fan: _____ CFM

Exhaust fan operates with hood switches: Yes No

Correct fan rotation: Yes No

Length of duct run (from top of hood to fan): _____

Number of bends in duct run: _____ 45° _____ 90°

VFD to exhaust fan controller set-up:

Top Switch: _____ Hz

Middle Switch: _____ Hz

Bottom Switch: _____ Hz

Fire suppression relay in VFD box utilized: Yes No

Number of MUA relays in VFD box utilized: _____

Valance Kit: Yes Ceiling Height: _____ No

Duct Valance Kit: Yes Height: _____ No

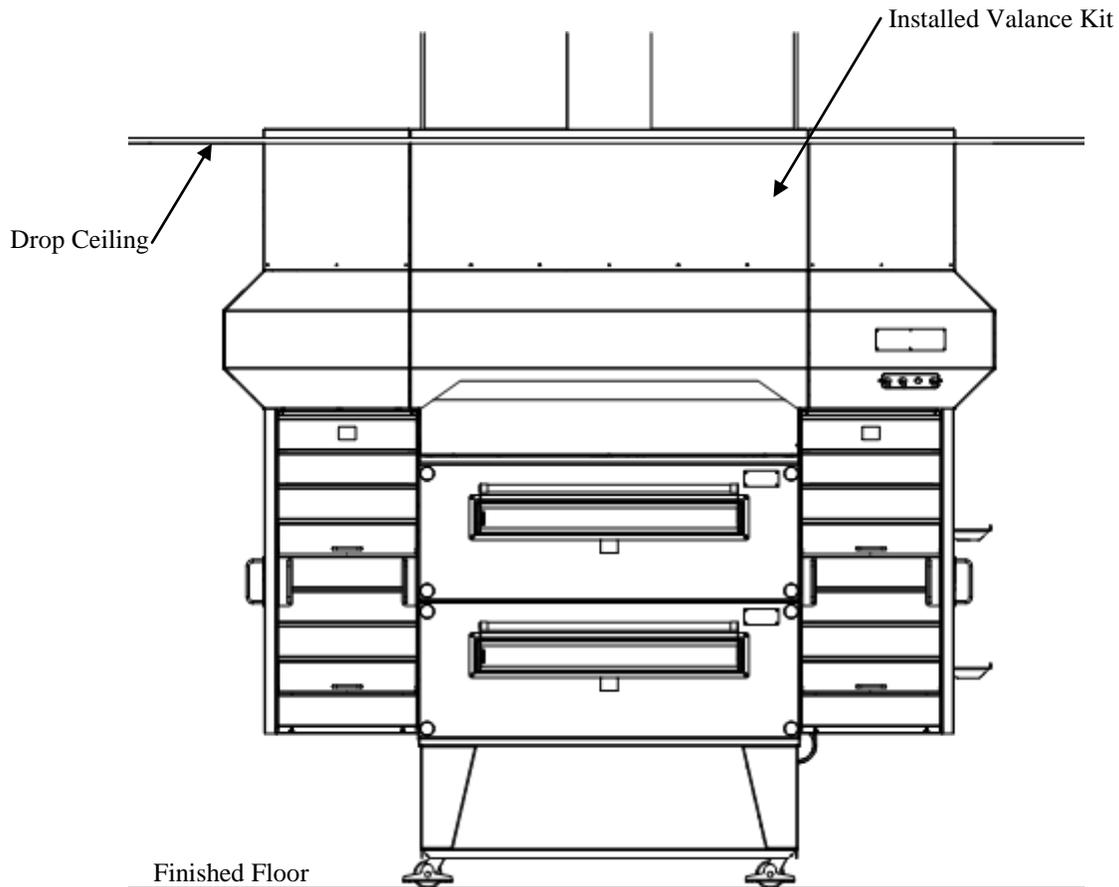
Customer Signature: _____

Notes: _____

Return with Oven Initial Start-up form to: XLT Ovens
PO Box 9090
Wichita, KS 67277
FAX: 316-943-2769

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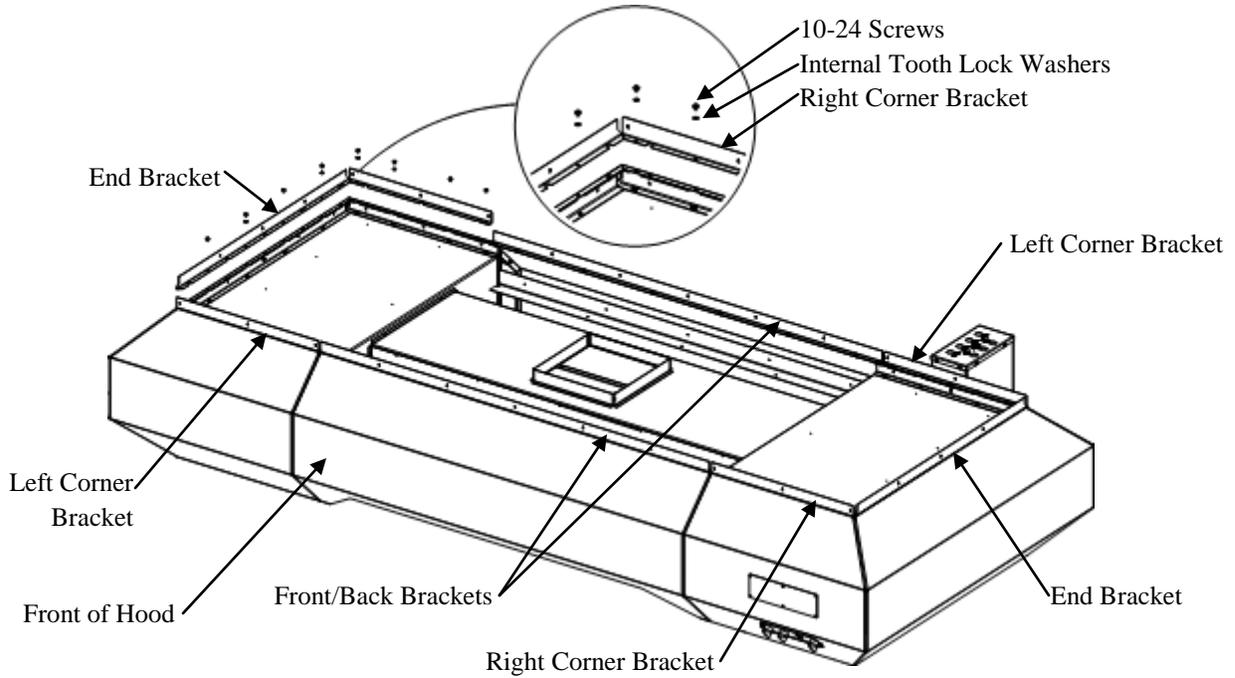
The valance kit size is determined by AVI Hood size and distance from the finished floor to the installed drop ceiling height. The valance kit screws directly to the AVI Hood and does not require any structural support. All kits have provisions for hood fire suppression piping to pass through without modification. The plastic coating must be removed from all parts prior to installation.



AVI hood valance kits are available for different floor to ceiling heights. Contact XLT Ovens or your designated representative for more information.

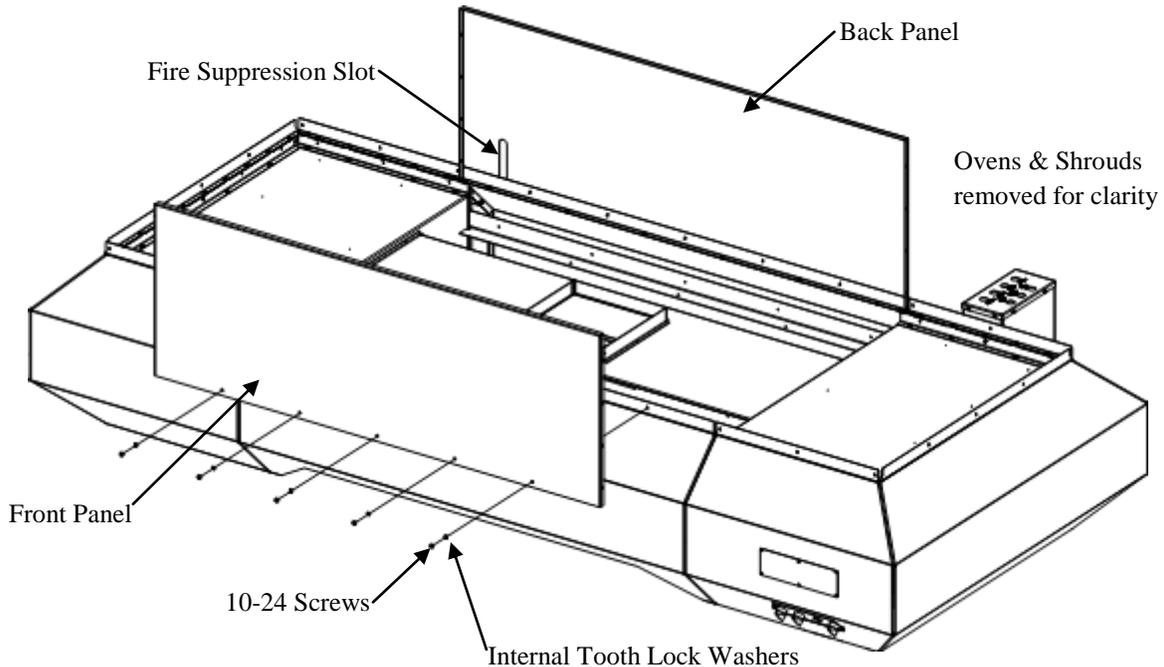
Hood Valance Kit (Optional)

Install Valance Brackets



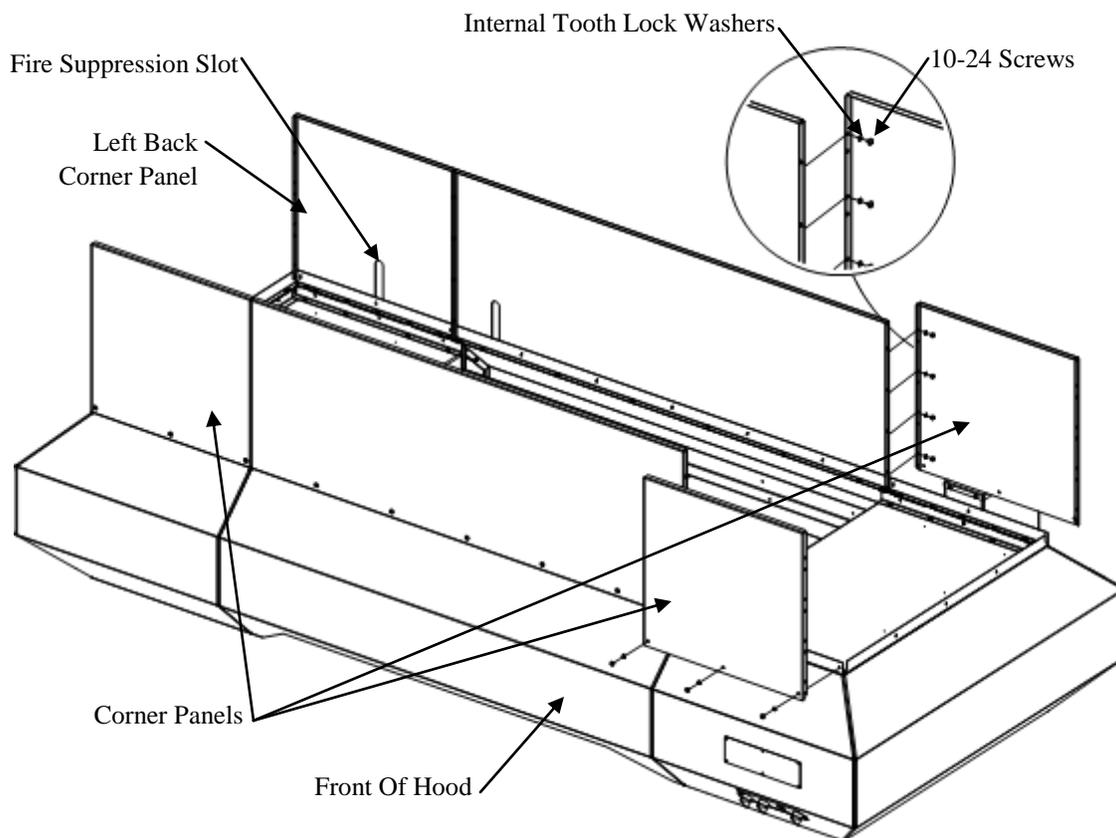
Install all brackets with through holes down and vertical flange facing away from center of hood. Fasten to top of hood with screws & washers provided.

Install Front & Back Panels



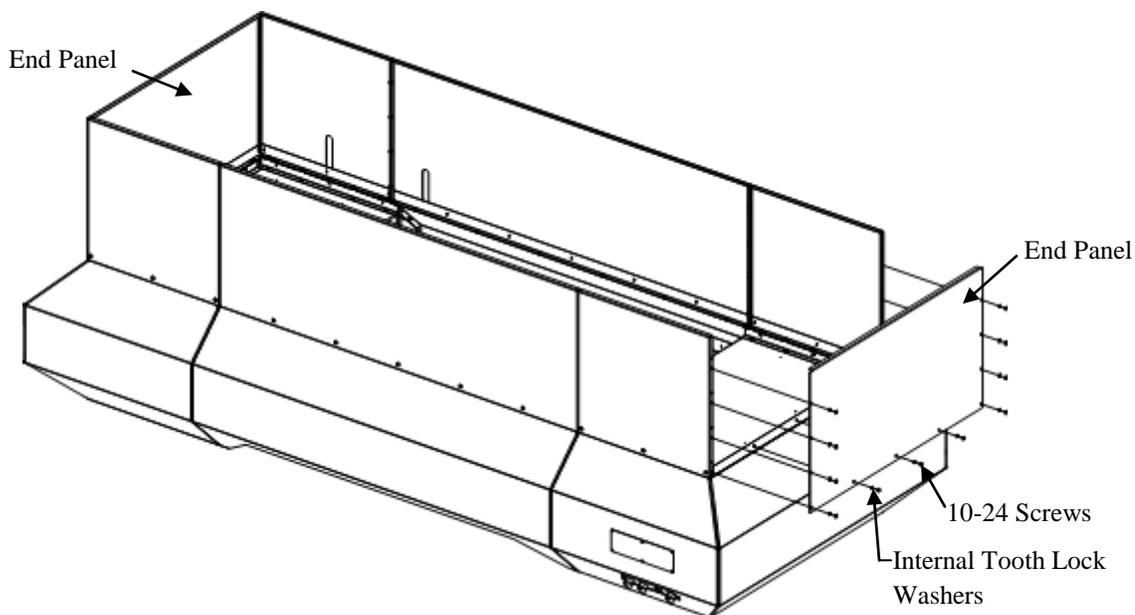
Install front & back panels with flanges toward center of hood. Fasten to brackets with screws & washers provided.

Install Corner Panels



Install corner panels with flanges toward center of hood. Fasten to brackets, front, and back panels with screws & washers provided.

Install End Panels



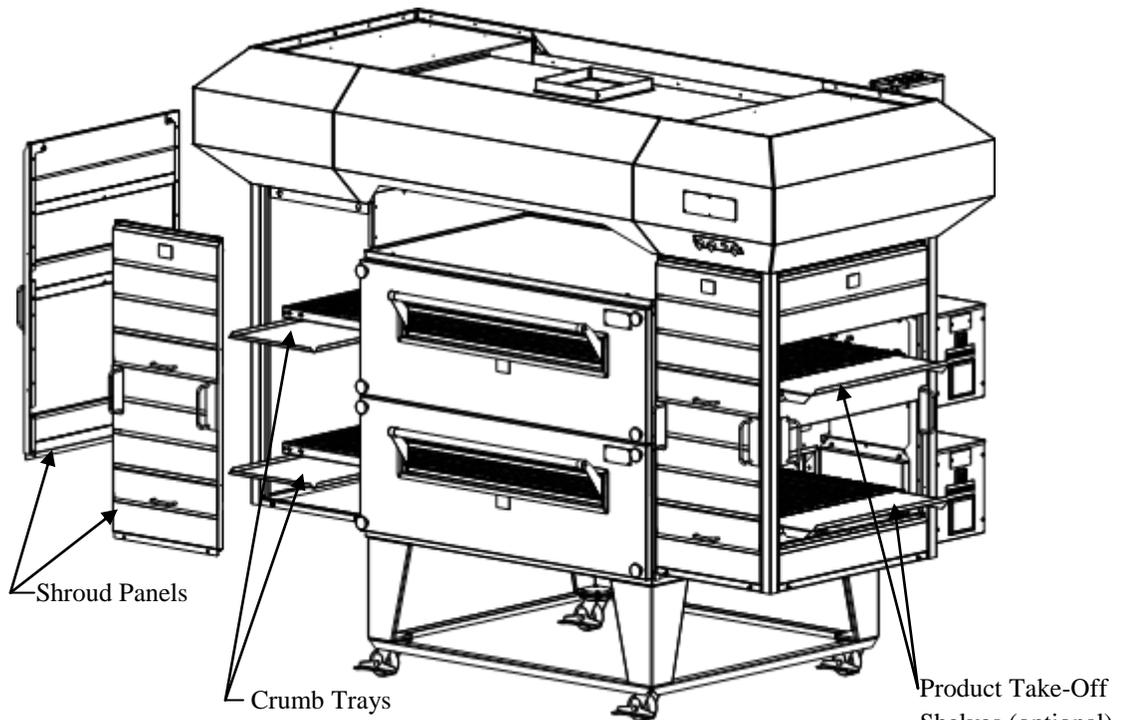
Install end panels with flanges toward center of hood. Fasten to brackets and corner panels with screws & washers provided.

Example Maintenance & Cleaning Schedule for AVI Hoods				
Task	Daily	Weekly	Monthly	Semi- annual
Wipe down Exterior	<input type="checkbox"/>			
Clean Exterior				<input type="checkbox"/>
Clean Light Globe			<input type="checkbox"/>	
Replace Light Bulbs	As needed			
Empty Grease Tray		<input type="checkbox"/>		
Check Filters		<input type="checkbox"/>		
Clean Filters			<input type="checkbox"/>	
Clean Duct Work / Fan	As per manufacturer's recommendation			



Ovens must be cool and the oven power cord must be unplugged from the VFD before any cleaning is done.

1. Remove and wipe clean front and end shroud panels.
2. Remove and clean product take-off shelves (if installed) and crumb trays.

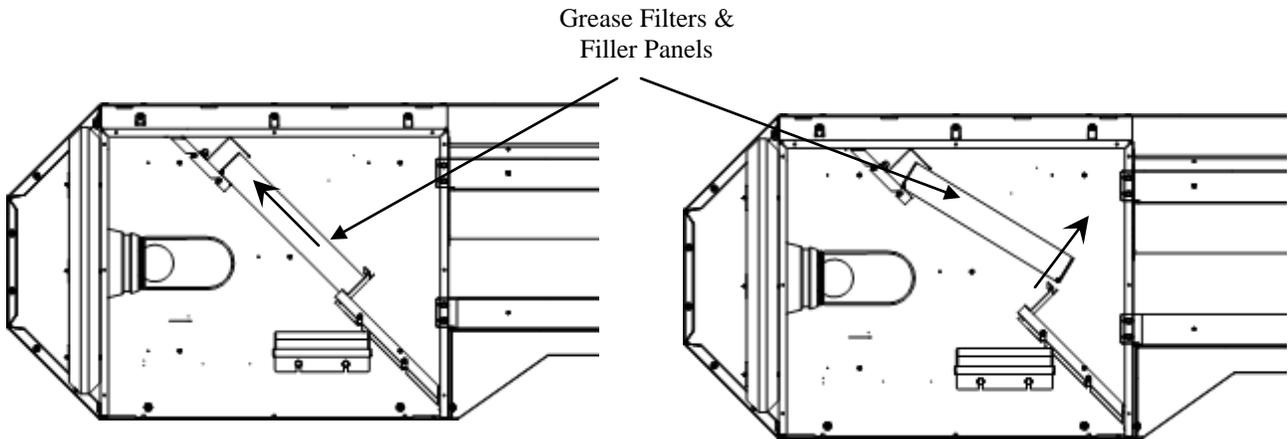


Shroud Panels can weight up to 60 lbs [27 kg]. Use caution when lifting.

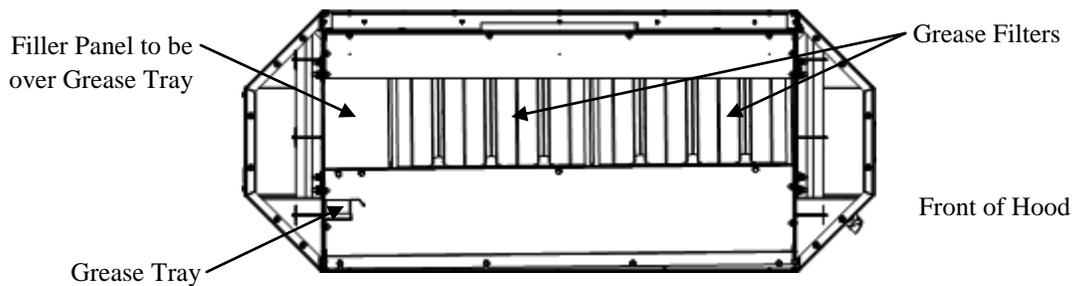
3. Remove and clean grease filters, filler panel and grease tray.

To remove grease filters and filler panels.

- a. Slide the filter or filler panel up.
- b. Tilt bottom into duct area until filter clears lower filter mount as shown and remove.



As viewed from front. Some parts removed for clarity.



As viewed from end. Some parts removed for clarity.

Left end shown, repeat for right end of hood.

4. Wipe clean all interior and exterior surfaces.



CAUTION

DO NOT spray liquid cleaning agents in the slots and holes of the following locations:

- VFD Box
- Back of control box
- Underneath control box

Before trouble-shooting the hood;

1. Make sure that the hood is connected to the proper voltage.
2. Check to see that the breaker in the service panel is not disengaged.
3. Check to see that all fuses in the hood control box are not blown.
4. Check to see that the filters are clean and installed properly.
5. Check to see if the exhaust fan is rotating in the correct direction.
6. Check to see if the VFD Controller is in Run Mode.

XLT Ovens has qualified customer service personnel that can provide assistance on any type of issue that you may experience. Customer Service can be contacted at 888-443-2751, 24 hours per day, 7 days per week. For Australian and World Ovens or AVI Exhaust Hoods, contact your designated representative.

International Distributors

For service and spare parts in Australia, please contact your XLT Australian Distributor:

J. L. Lennard Food Equipment PTY LTD.

Service hotline: 1800 777 440

Spare parts hotline: (during office hours 8:00 am – 4:30 pm, Mon-Fri)

1800 777 144

After Hours service:

1800 077 081

For service and spare parts in New Zealand, please contact your XLT New Zealand Distributor:

J. L. Lennard Ltd.

2/ 25 Allright Place

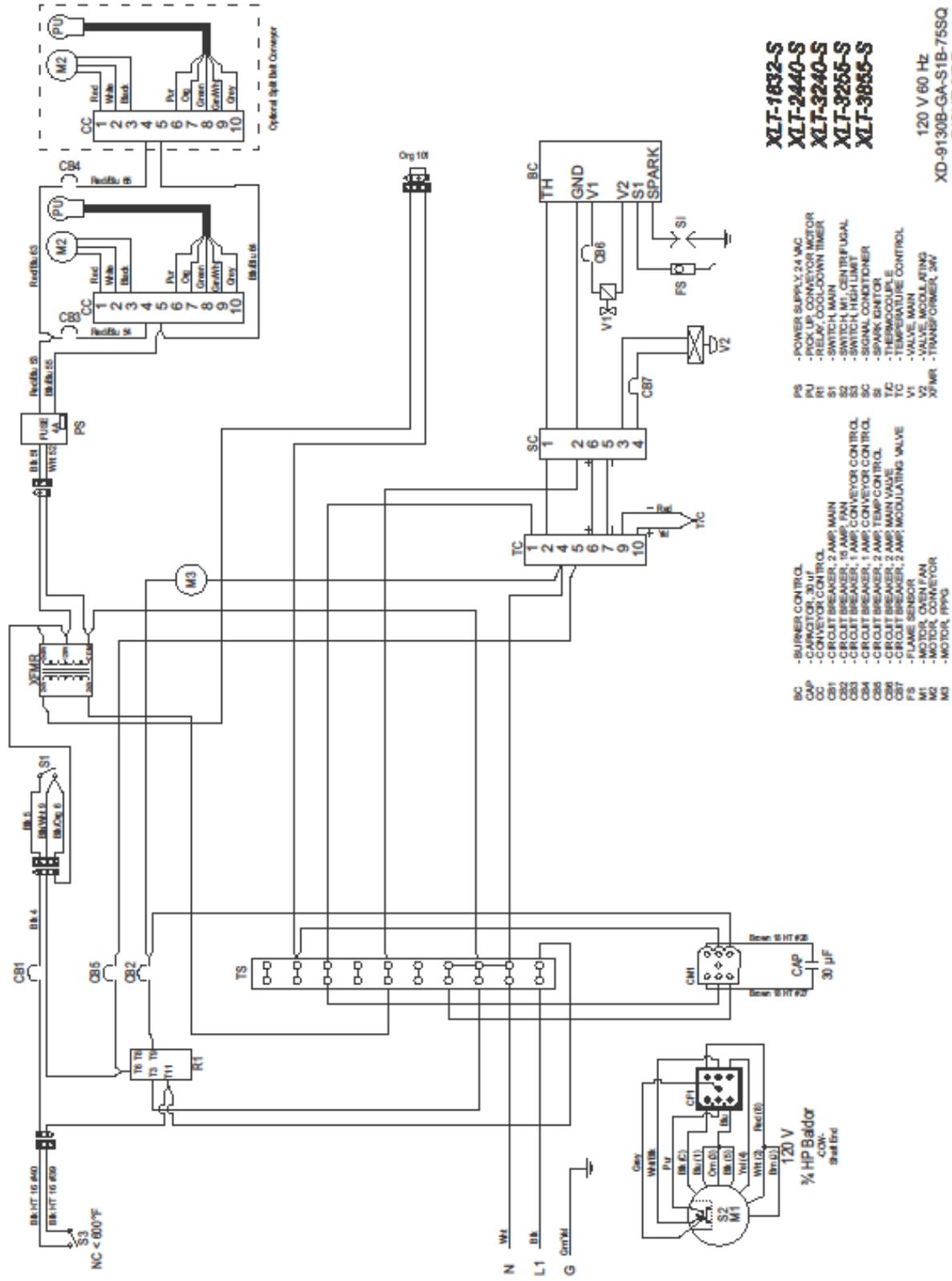
Mt Wellington, Auckland

New Zealand

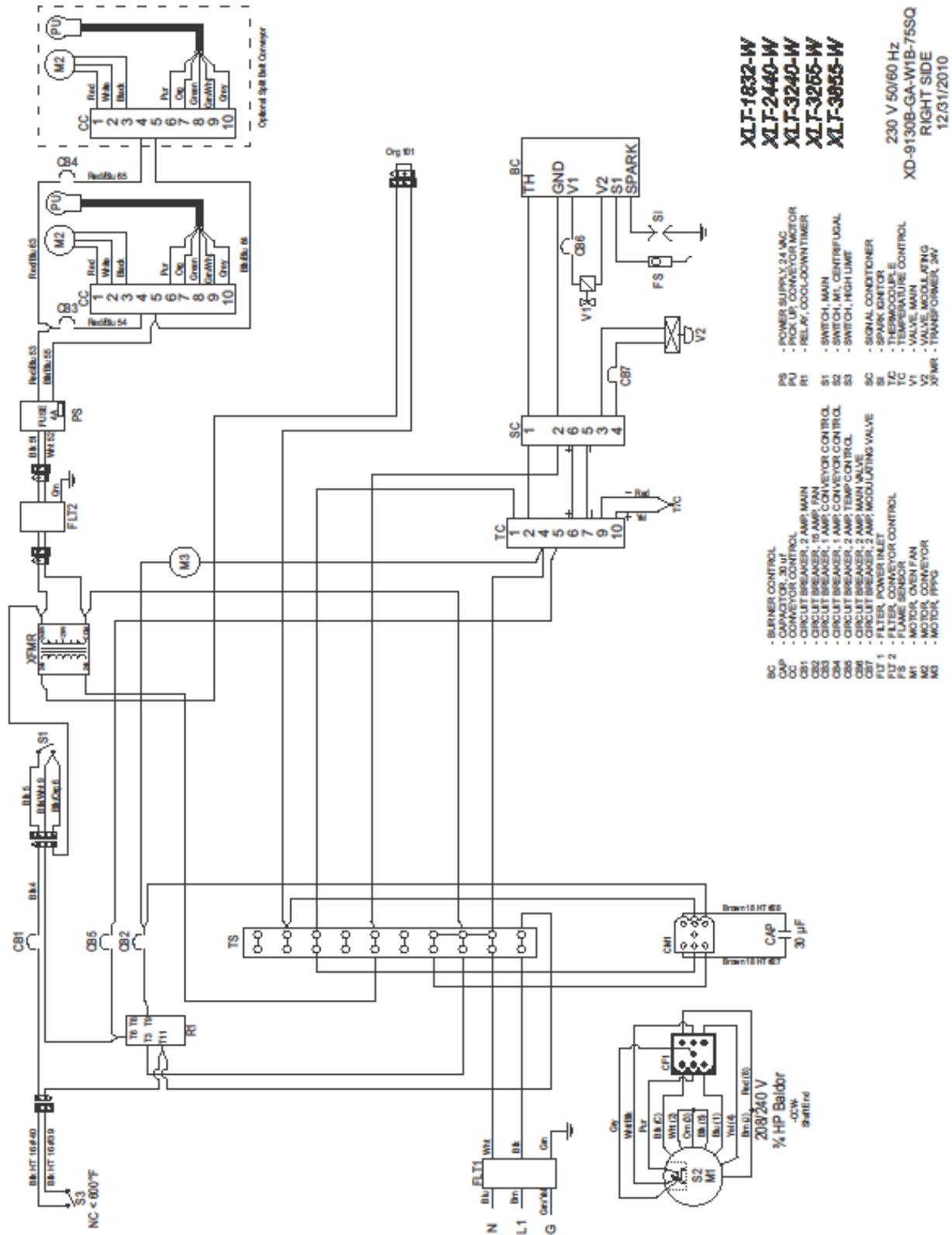
Phone: 0800 850 085

Web: www.jllennard.co.nz

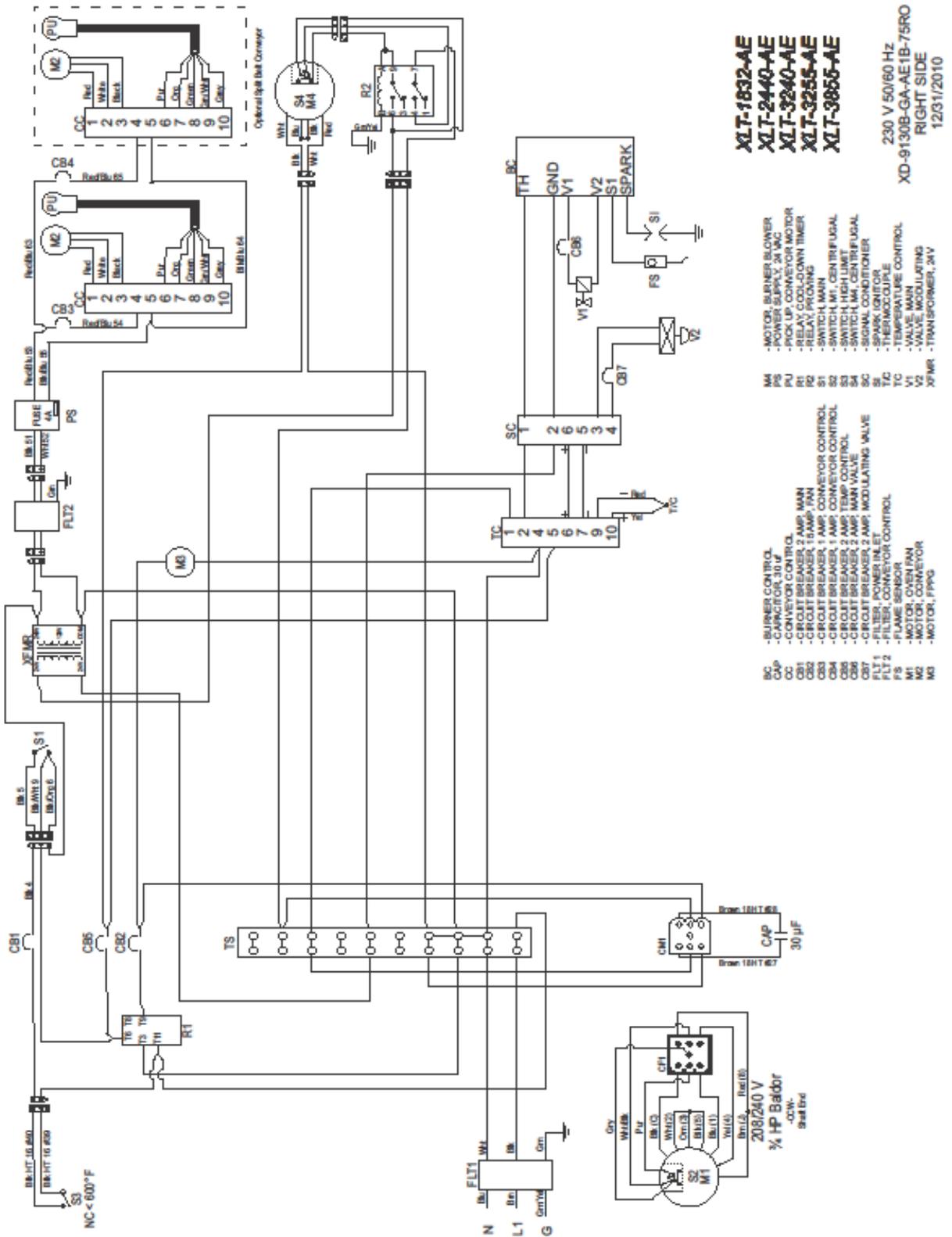
1832, 2440, 3240, 3255 & 3855 - Square Burner - Standard



1832, 2440, 3240, 3255 & 3855 - Square Burner - World



1832, 2440, 3240, 3255 & 3855 - Round Burner - Australia

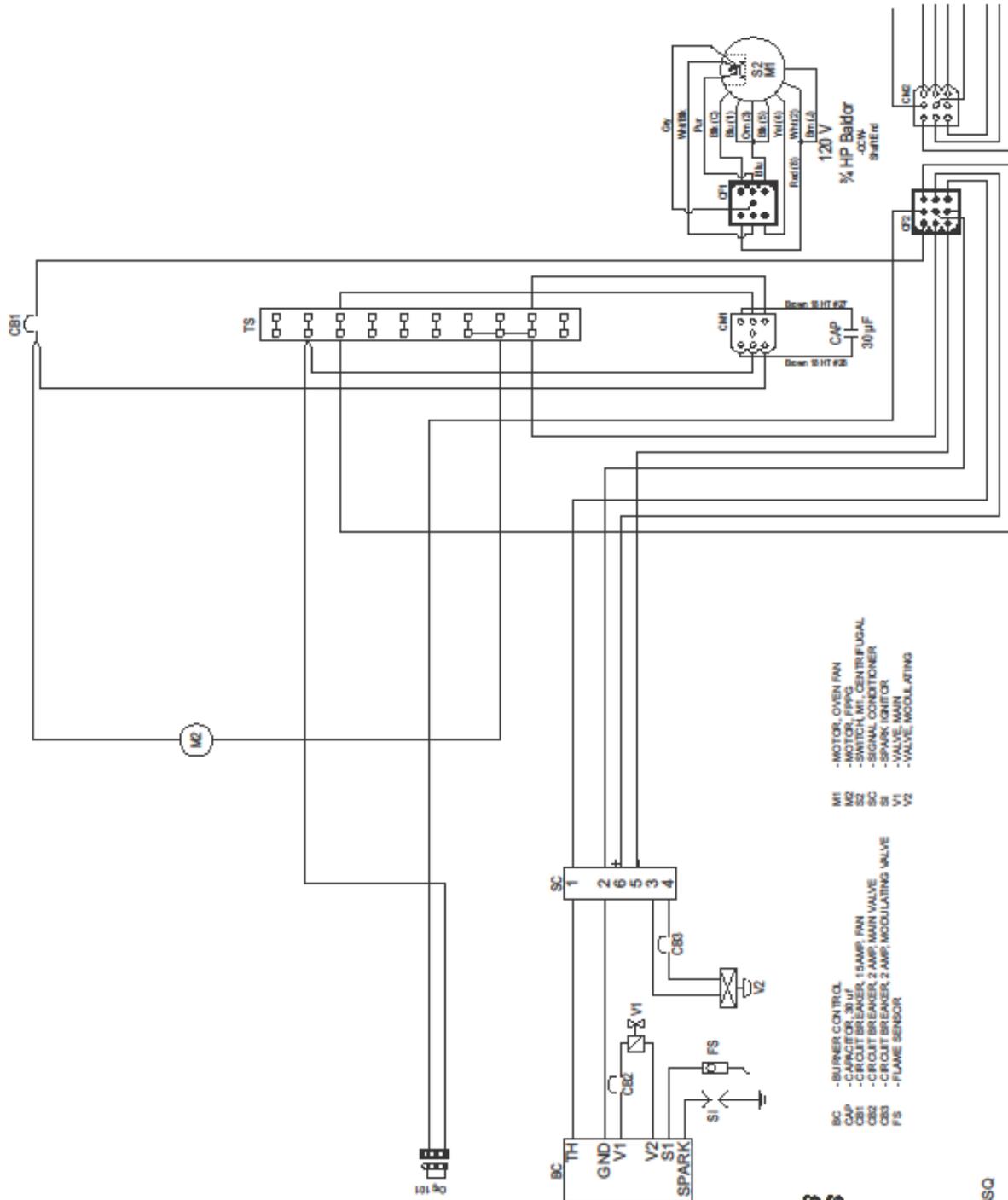


XLT-1832-AE
XLT-2440-AE
XLT-3240-AE
XLT-3255-AE
XLT-3855-AE

230 V 50/60 Hz
 XD-9130B-GA-AE1B-75R0
 RIGHT SIDE
 12/31/2010

- MOTOR, BURNER BLOWER
 - PICK UP, CONVEYOR MOTOR
 - PICK UP, CONVEYOR MOTOR
 - RELAY, PROOVING
 - SWITCH, MAIN
 - SWITCH, M1, CENTRIFUGAL
 - SWITCH, HIGH LIMIT
 - SWITCH, M4, CENTRIFUGAL
 - SIGNAL, CONDITIONER
 - SPARK, ON/OFF
 - TEMPERATURE CONTROL
 - TEMPERATURE CONTROL
 - VALVE, MAIN
 - VALVE, MODULATING
 - TRANSFORMER, 2kV
- M1 - MOTOR, BURNER BLOWER
 - M2 - PICK UP, CONVEYOR MOTOR
 - M3 - PICK UP, CONVEYOR MOTOR
 - PS - RELAY, PROOVING
 - S1 - SWITCH, MAIN
 - S2 - SWITCH, M1, CENTRIFUGAL
 - S3 - SWITCH, HIGH LIMIT
 - S4 - SWITCH, M4, CENTRIFUGAL
 - S5 - SIGNAL, CONDITIONER
 - S6 - SPARK, ON/OFF
 - S7 - TEMPERATURE CONTROL
 - S8 - TEMPERATURE CONTROL
 - S9 - VALVE, MAIN
 - S10 - VALVE, MODULATING
 - S11 - TRANSFORMER, 2kV
- BC - BURNER CONTROL
 - CAP - CAPACITOR, 30 µF
 - CC - CONVEYOR CONTROL
 - CB1 - CIRCUIT BREAKER, 1 AMP, MAIN
 - CB2 - CIRCUIT BREAKER, 1 AMP, PAN
 - CB3 - CIRCUIT BREAKER, 1 AMP, PAN
 - CB4 - CIRCUIT BREAKER, 1 AMP, CONVEYOR CONTROL
 - CB5 - CIRCUIT BREAKER, 1 AMP, CONVEYOR CONTROL
 - CB6 - CIRCUIT BREAKER, 2 AMP, TEMP CONTROL
 - CB7 - CIRCUIT BREAKER, 2 AMP, MAIN VALVE
 - CB8 - CIRCUIT BREAKER, 2 AMP, MODULATING VALVE
 - FLT1 - FUSE, POWER INLET
 - FLT2 - FUSE, MAIN
 - F3 - FLAME SENSOR
 - M1 - MOTOR, OVEN PAN
 - M2 - MOTOR, CONVEYOR
 - M3 - MOTOR, FPPG

3270 & 3870 - Square Burner - Standard - LH Control Box



- MOTOR, CASE FAN
- MOTOR, FAN
- SWITCH, MT. CENTRIFUGAL
- SIGNAL CONDITIONER
- SPARK IGNITOR
- VALVE, MAIN
- VALVE, MODULATING

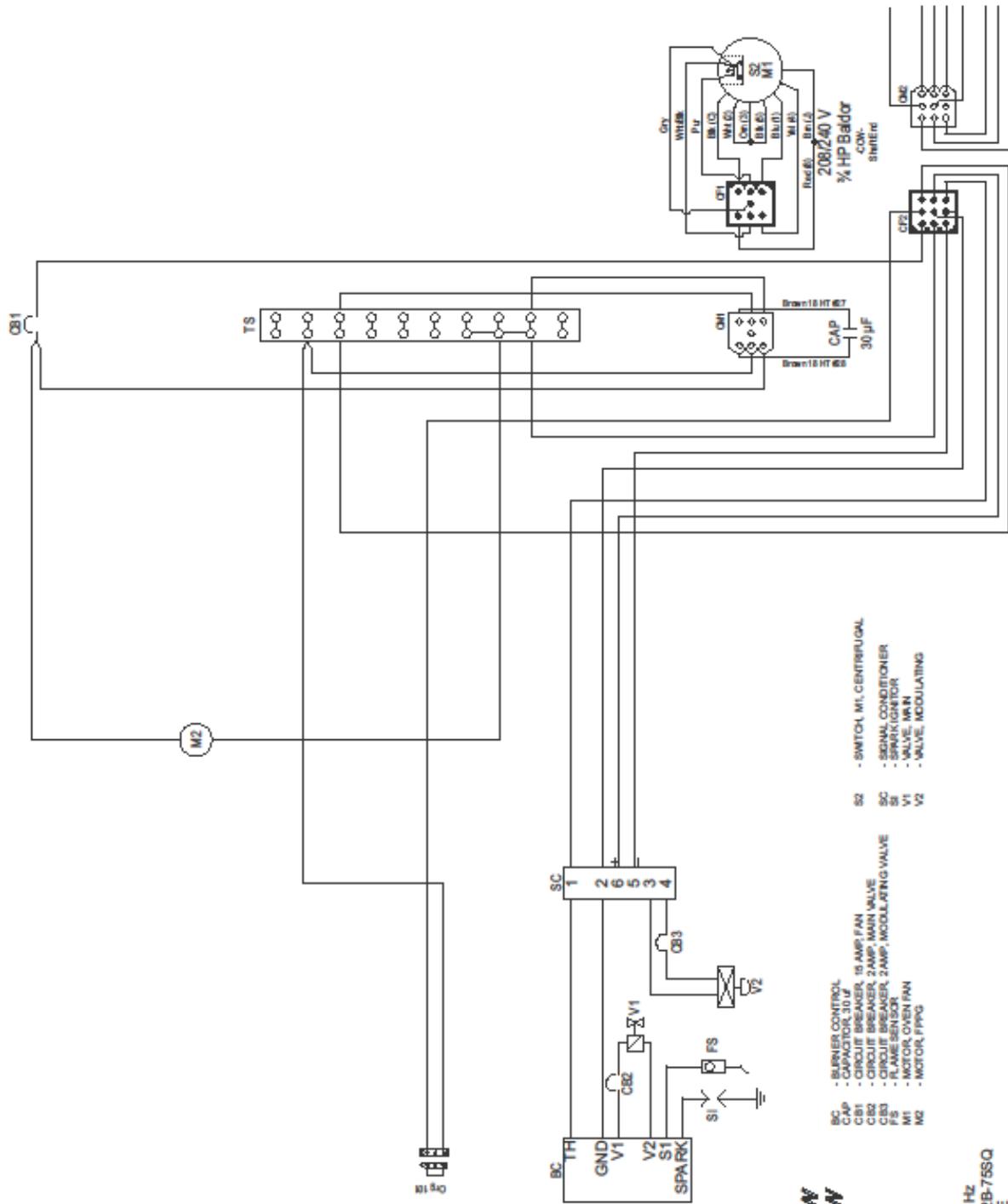
- BC - BURNER CONTROL
- CAP - CAPACITOR, 30 µF
- CB1 - CIRCUIT BREAKER, 15 AMP FAN
- CB2 - CIRCUIT BREAKER, 2 AMP MAIN VALVE
- CB3 - CIRCUIT BREAKER, 2 AMP MODULATING VALVE
- FS - FLAME SENSOR

- M1 - MOTOR, CASE FAN
- M2 - MOTOR, FAN
- S2 - SWITCH, MT. CENTRIFUGAL
- S1 - SIGNAL CONDITIONER
- S1 - SPARK IGNITOR
- V1 - VALVE, MAIN
- V2 - VALVE, MODULATING

XLI-3270-S
XLI-3870-S

120 V 60 HZ
XD-9130B-GA-S2B-75SQ
LEFT SIDE
12/31/2010

3270 & 3870 - Square Burner - World - LH Control Box



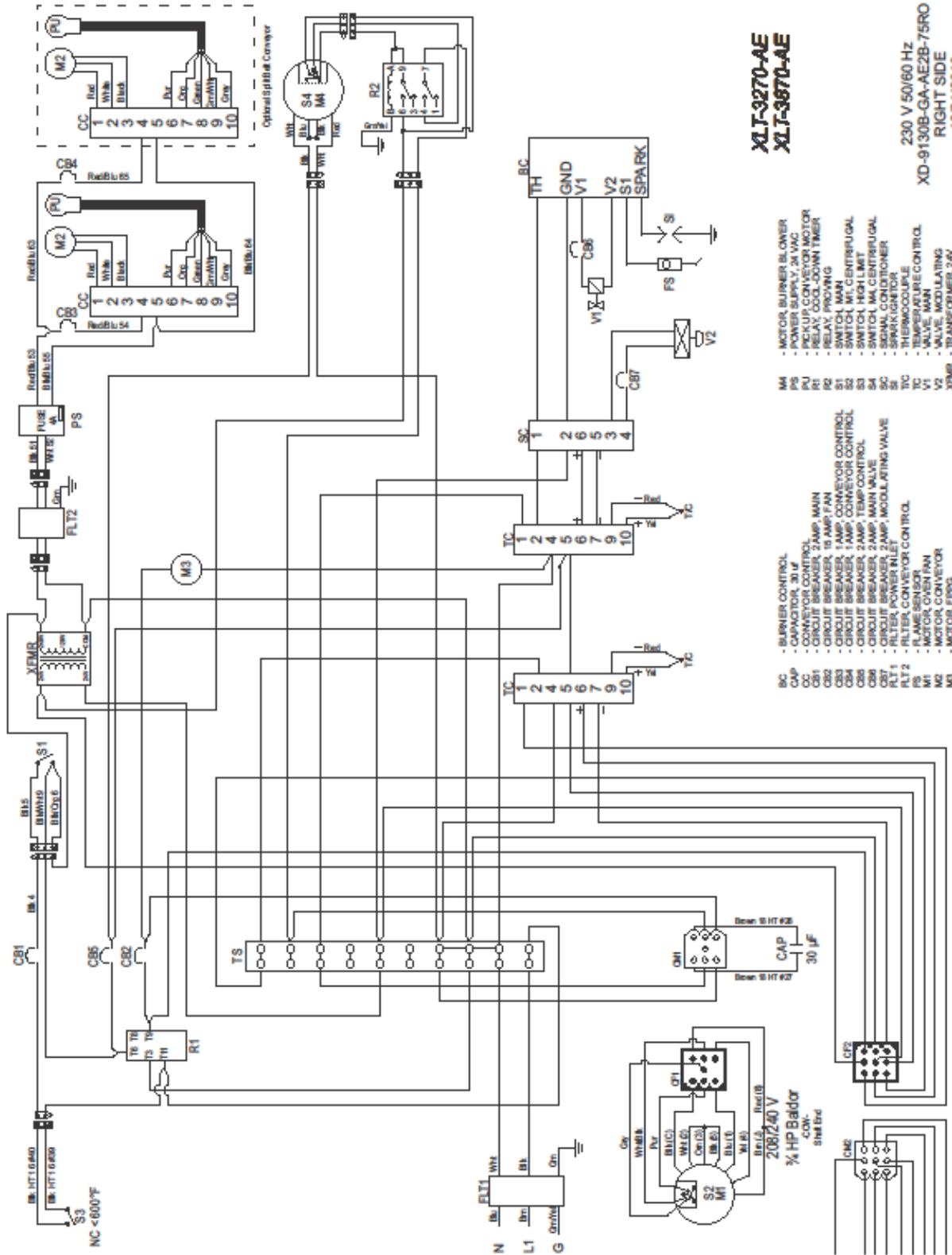
- SC - SWITCH, M1, CENTRIFUGAL
- SI - SIGNAL CONDITIONER
- SP - SPARK IGNITOR
- V1 - VALVE, MAIN
- V2 - VALVE, MODULATING

- BC - BURNER CONTROL
- CAP - CAPACITOR, 30 µF
- CB1 - CIRCUIT BREAKER, 15 AMP, FAN
- CB2 - CIRCUIT BREAKER, 2 AMP, MAIN VALVE
- CB3 - CIRCUIT BREAKER, 2 AMP, MODULATING VALVE
- FS - FLAME SENSOR
- M1 - MOTOR, OVEN FAN
- M2 - MOTOR, FPPG

XLT-3270-W
XLT-3870-W

230 V 50/60 Hz
XD-9130B-GA-W2B-76SQ
LEFT SIDE
12/31/2010

3270 & 3870 - Round Burner - Australia - LH Control Box

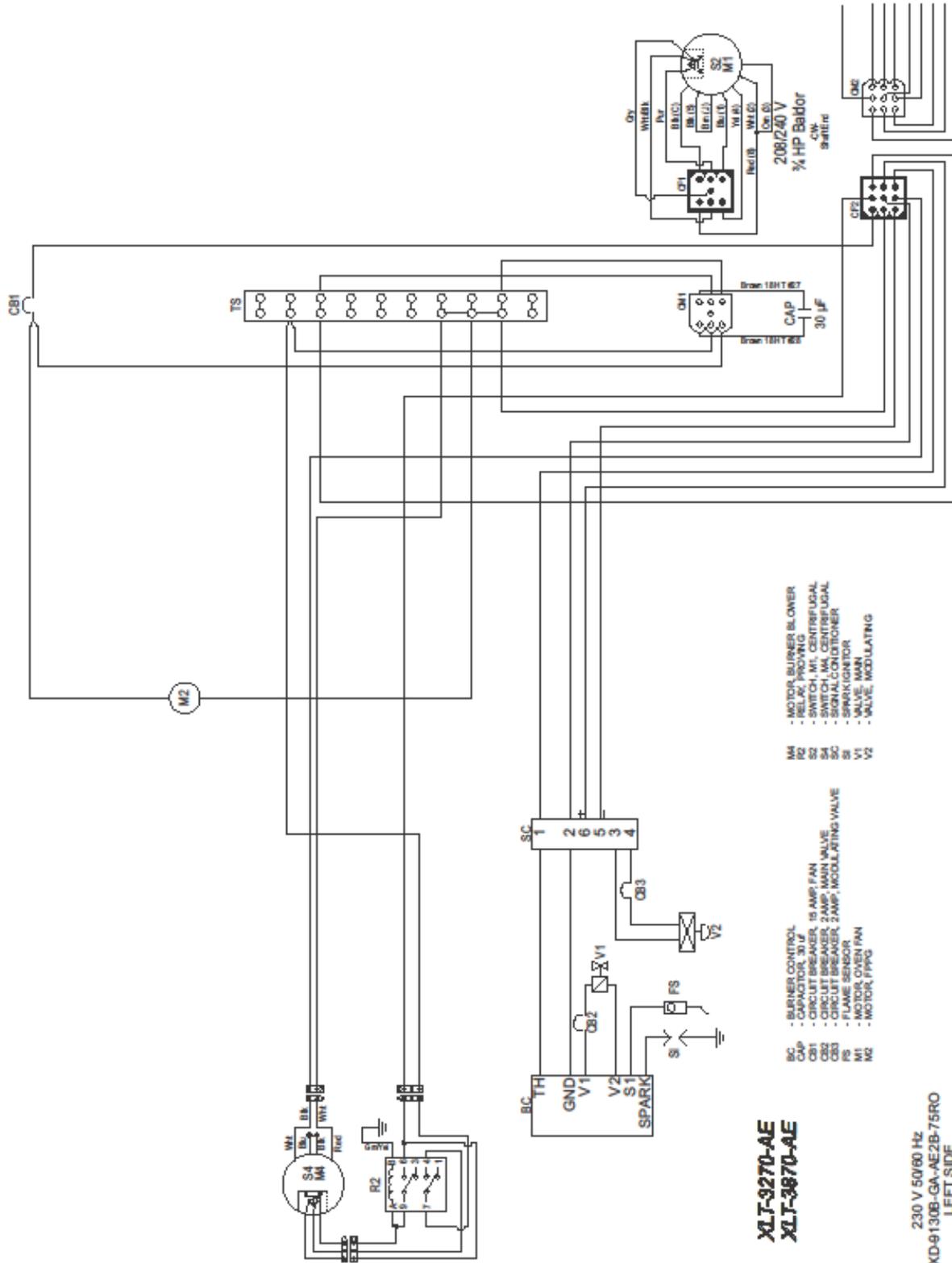


XLJ-3270-AE
XLJ-3870-AE

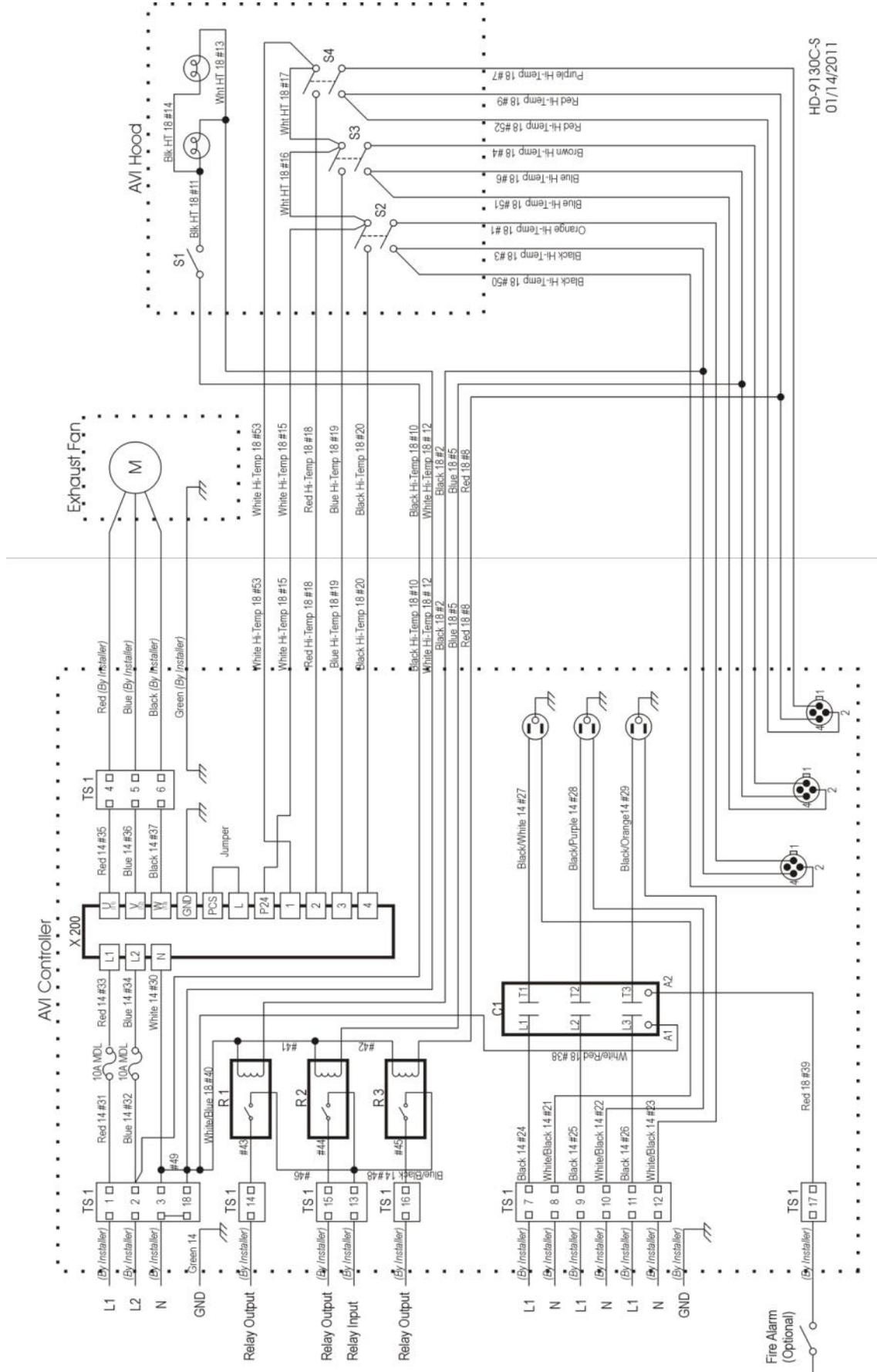
230 V 50/60 HZ
 XD-9130B-GA-AE2B-75RO
 RIGHT SIDE
 12/31/2010

- MOTOR BURNER BLOWER
 - POWER SUPPLY, 24 VAC
 - RELAY, CONTACTOR MOTOR
 - RELAY, CONTACTOR TIMER
 - RELAY, PROOVING
 - SWITCH, MAIN
 - SWITCH, M1, CENTRIFUGAL
 - SWITCH, HIGH LIMIT
 - SWITCH, M4, CENTRIFUGAL
 - SIGNAL CONDITIONER
 - THERMOPILE
 - TEMPERATURE CONTROL
 - VALVE, MAIN
 - VALVE, MODULATING
 - TRANSFORMER, 24V
- BURNER CONTROL
 - CAPACITOR, 30 μF
 - CONTACTOR CONTROL
 - CIRCUIT BREAKER, 15 AMP FAN
 - CIRCUIT BREAKER, 15 AMP MAIN
 - CIRCUIT BREAKER, 1 AMP, CONVEYOR CONTROL
 - CIRCUIT BREAKER, 1 AMP, CONVEYOR CONTROL
 - CIRCUIT BREAKER, 2 AMP, MAIN VALVE
 - CIRCUIT BREAKER, 2 AMP, MAIN VALVE
 - CIRCUIT BREAKER, 2 AMP, MODULATING VALVE
 - FILTER, CONVEYOR CONTROL
 - FLAME SENSOR
 - MOTOR, OVEN FAN
 - MOTOR, CONVEYOR
 - MOTOR, FPPG
- MOTOR BURNER BLOWER
 - POWER SUPPLY, 24 VAC
 - RELAY, CONTACTOR MOTOR
 - RELAY, CONTACTOR TIMER
 - RELAY, PROOVING
 - SWITCH, MAIN
 - SWITCH, M1, CENTRIFUGAL
 - SWITCH, HIGH LIMIT
 - SWITCH, M4, CENTRIFUGAL
 - SIGNAL CONDITIONER
 - THERMOPILE
 - TEMPERATURE CONTROL
 - VALVE, MAIN
 - VALVE, MODULATING
 - TRANSFORMER, 24V

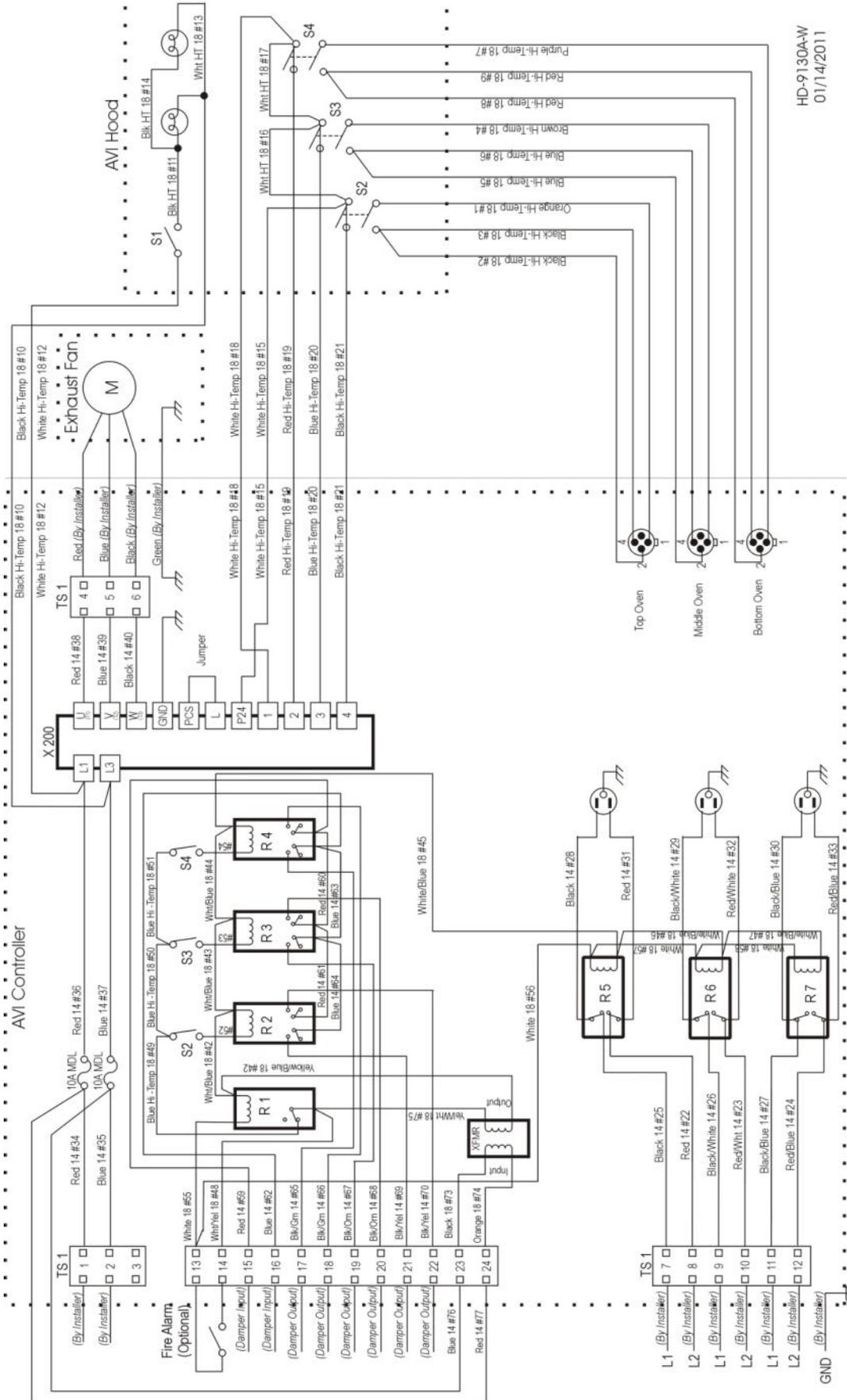
3270 & 3870 - Round Burner - Australia - RH Control Box



Hood Schematic - Standard

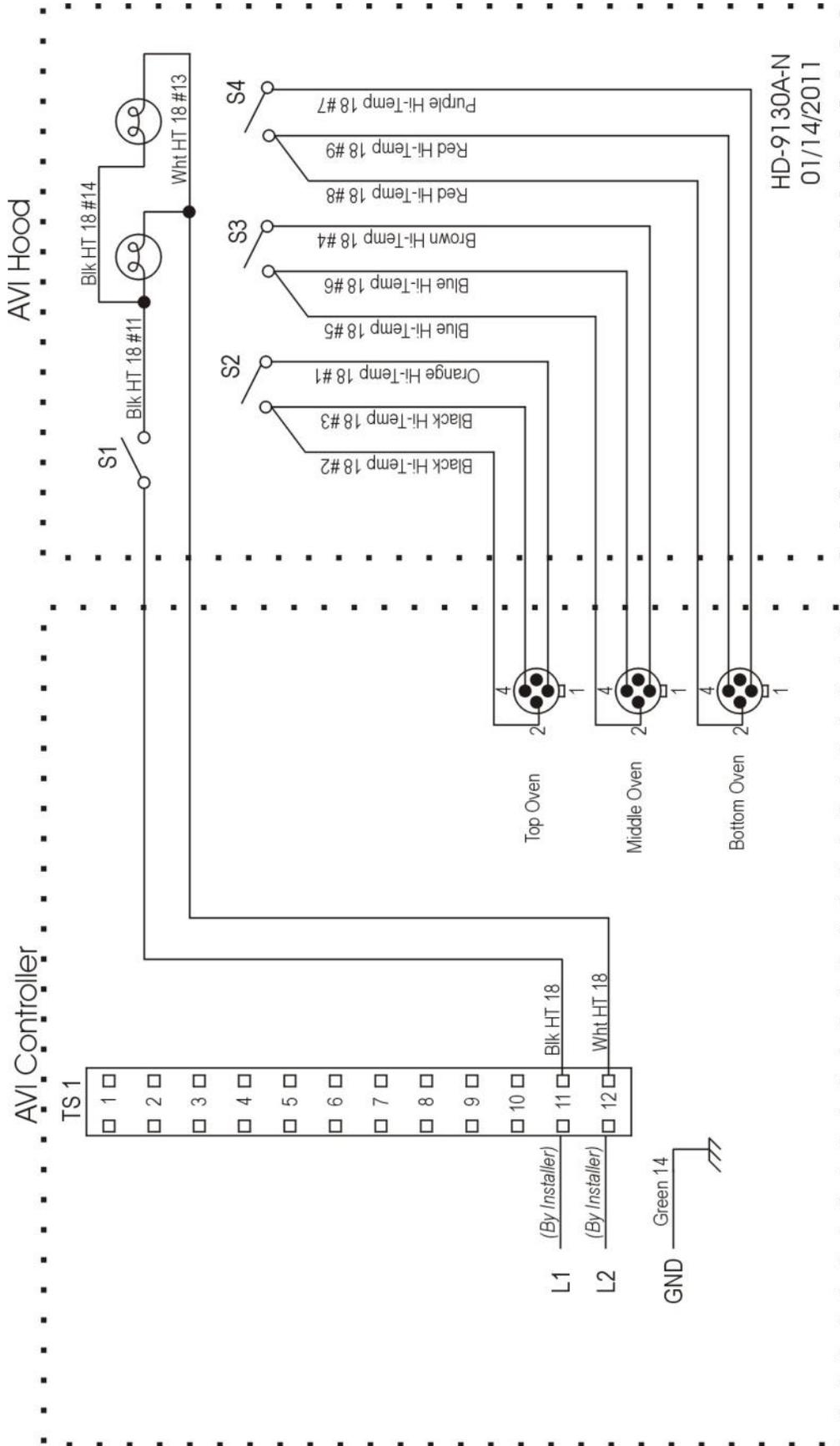


HD-9130C-S
01/14/2011



HD-9130A-W
01/14/2011

Hood Schematic - Without VFD Controller



HD-9130A-N
01/14/2011