



XD-9007B
EL-SWC-HC
10/15/2015

Simple. Smart.



XLT Electric Oven & AVI Hood Parts & Service 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 operation & must be installed in a suitably ventilated room in accordance with current regulations. This appliance should be serviced by qualified personnel at least every 12 months or sooner if heavy use is expected.

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

For use with the following XLT Electric Oven Versions:

Standard (S) C
World (W) C

For use with the following AVI Electric Hood Versions:

Standard (S) C
World (W) C



XLT Ovens
PO Box 9090
Wichita, Kansas 67277

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



SAFETY DEPENDS ON YOU



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.



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.

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

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

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

Definitions & Symbols

A safety instruction (message) includes a “Safety Alert Symbol” & a signal word or phrase such as **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 & other persons operating this equipment. Read the message & 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.

XLT warrants gas ovens manufactured after April 1, 2009 utilizing quietFIRE™ burners and all electric ovens manufactured after April 1, 2011 to be free from any defect in material and workmanship under normal use for five (5) years from the date of original purchase by the end user, and further warrants main fan blades, conveyor shafts, and conveyor bearings for ten (10) years. XLT further warrants all ovens to be free from rust for ten (10) years from the date the equipment is originally purchased. XLT warrants AVI hoods to be free from any defect in material and workmanship under normal use for two (2) years from the date of original purchase by the end user. In the event of a part failure, XLT will furnish a replacement part and pay for all labor associated with the replacement of the part if, upon inspection, XLT determines that the part is defective. This warranty is extended to the original end user purchaser and is not transferable without prior written consent of XLT. Damages are limited to the original purchase price.

DUTIES OF THE OWNER:

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

WHAT IS NOT COVERED:

The following items are not covered by this warranty:

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

CLAIMS HANDLED AS FOLLOWS:

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

XLT warrants gas ovens manufactured after January 1, 2011 utilizing quietFIRE™ burners and all electric ovens manufactured after April 1, 2011 to be free from any defect in material and workmanship under normal use for two (2) years from the date of original purchase by the end user. XLT warrants AVI hoods to be free from any defect in material and workmanship under normal use for one (1) year from the date of original purchase by the end user. In the event of a part failure, XLT will furnish a replacement part to the Authorized Dealer if, upon inspection, XLT determines that the part is defective. The Authorized Dealer will pay for all labor associated with the replacement of the part. This warranty is extended to the original end user purchaser and is not transferable without prior written consent of XLT. Damages are limited to the original purchase price.

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- The owner must inspect the equipment and crates at time of receipt. Damage during shipment is to be immediately reported to the carrier and also to XLT.
- The equipment must be installed and operated in accordance with the written instructions furnished with the unit.
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- The gas, electric, and HVAC utilities must be connected to the oven and installed by locally licensed contractors.
- Failure to contact the Authorized Dealer prior to contacting a repair company for warranty work voids any and all warranties.

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- Any electronic part that becomes defective because of moisture and/or other contaminants
- Conveyor belts
- Filters
- Exhaust Fans
- Light Bulbs
- Normal maintenance or adjustments
- This warranty shall not apply if the equipment or any part is damaged as a result of accident, casualty, alteration, misuse, abuse, improper cleaning, improper installation, improper operation, natural disasters, or man-made disasters.

CLAIMS HANDLED AS FOLLOWS:

Should any such defect be discovered, the Authorized Dealer must be notified. Upon notification, the Authorized Dealer will arrange for necessary repairs to be made by an authorized service agent. The Authorized Dealer will notify XLT Ovens of all discovered defects.

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

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

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

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

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

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

**WARNING**

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

Save this Manual

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

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

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

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

Revision History Table		
Revision	Comments	Date
A	New Release	10/17/12
B	Updated Hitachi X200 Parameters On Page 20	10/15/2015

When the Main Switch (S1) is turned on;

1. The Oven Fan Motor (M1) located in the Back Wall will run.
2. The Fans (M3) located on the Control Panel will run.
3. The Temperature Control (TC) should display both the actual and set-point temperatures.
4. The Conveyor Control (CC) should display the belt time.
5. The conveyor belt should move.

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

- Line voltage for Standard Ovens is assumed to be 208/240/480 VAC, 3 Φ , 60 Hz.
- Line voltage for World Ovens is assumed to be 380 VAC, 3 Φ , 50 Hz.

Power originates at the electrical connection on the wall. Line voltage is then carried into the oven through the power cord to the Power Block (PB). A wire connects Line 2 to the Terminal Strip (TS), which serves as a “neutral” for the single phase components. Several jumpers are used to bridge along the TS to make connection points for multiple “neutral” lines from all single phase components inside the Control Box and the Main Fan Motor (M1). A wire connects line 1 to Terminal T11 on Relay 1 (R1) and acts as the “hot” leg for all of the single phase components. From there, a wire connects single phase power through the normally closed High Limit Switch (S3), then through Circuit Breaker 1 (CB1), then to the Main Switch (S1). Three phase power is applied to Contactors 1 & 2 (C1 & C2) through Circuit Breakers 5 & 6 (CB5 & CB6) and the PB. Unless the power supply on the wall has no power, the single phase and three phase circuits just described have power at all times.

When S1 is turned on, line voltage will be carried through the switch simultaneously to three locations via two parallel circuits:

- Terminal T6 of R1
- Centrifugal Switch (S2) located in M1

And:

- Power Supply (PS)

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

CAP - The Capacitor is physically mounted inside the Control Box but wired to the externally mounted Main Motor (M1). The Main Motor is a permanent split capacitor (PSC) design, which is a motor in which the starting capacitor and the auxiliary winding remain in the circuit for both starting and running.

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

CC - The Conveyor Control is supplied 24 VDC by the Power Supply (PS) via a Circuit Breaker (CB3 & CB4, optional) to Terminals 4 & 5. The belt time is displayed, and is user-adjusted by pressing and holding the up or down arrow button switches. See the Specification Sheet for minimum and maximum belt times. The motor speed is calculated based on the time that is entered. This time is translated to a RPM on the motor shaft depending on the size of the oven, the diameter of the sprocket, and the gear ratio of the gearbox. Once the motor is running, hall sensor inputs are fed back into the driver to determine the speed the motor is currently running at. This input goes into a PID algorithm to adjust the PWM output to control the speed to match the target speed that was calculated first. This PWM is adjusting the average voltage that the motor phases are seeing. As the average voltage goes up, the motor will speed up. As the average voltage drops, the motor speed will also drop. The maximum speed is based on a continuous 18-24V being supplied to the motor. The phasing of the controller is dependent on the hall sensor signals that are being returned. The controller reads the hall sensor position and from there knows which phase of the motor receives the 18-24V signal, which phase of the motor is the return and which phase of the motor is left open. As the motor spins, the hall sensors change, which dictate which phases are energized.

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

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

Please refer to the Parts section for the proper application.

M1 – The Main Motor is a Permanent Split Capacitor (PSC), single phase, capacitor run motor and has an internal centrifugal switch (S2). The motor is dual voltage and reversible. The voltage to power the motor comes from the Cool Down Timer (R1), and the motor will continue to operate for approximately 30 minutes after the main switch is turned off. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

M2 - The conveyor motor (M2) is a brushless 24 VDC gear motor. The motor receives current from the Conveyor Control (CC) through three (3) wires; 1) A black or “W” phase, 2) a white or “V” phase, and 3) a red or “U” phase. They carry between 18 to 24 VDC. Each wire is energized by the Conveyor Control (CC) in sequence to provide power to the individual stator coils which, in turn, provide motor rotation.

To determine the rotors position and send this position to the controller, three (3) Hall Effect switches are utilized. They read the rotational information from a disc mounted on the rotor assembly. This information is transmitted to the CC by three (3) wires; 1) an orange “U” phase pole signal output, 2) a green “V” phase pole signal output, and 3) a green/white “W” phase pole signal output. These are located in a plug that inserts into the CC. There are two (2) additional wires in this plug; 1) a purple wire which is supply voltage for the pole sensor, and 2) a gray wire that is ground.

The CC, using an internal logic circuit, energizes the stator coils to provide proper rotation and sets the energization (phase) timing to obtain the desired belt speed set on the controller. The motor drives an integral gear box that reduces the motor output speed to give the correct travel time to the conveyor belt. The integral gear box is sealed and permanently lubricated with grease. The ratio is 1/200.

M3 - These Motors have fan blades attached to them that provide cool air to the control box components. It is wired in parallel with M1 and will continue to operate for 30 minutes after S1 is turned off. Filters are provided to ensure clean air.

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

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

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

R1 - R1 is a 30-minute off delay relay which functions as a cool down timer. Applying power to terminal T6 activates the relay, which sends a voltage signal out from terminal T9. When power is removed from T6, voltage continues from T9 for 30 minutes. T9 supplies voltage to the Main Fan

Motor (M1) through a Circuit Breaker (CB2), and also supplies voltage to M3. M1 and M3 are the only components that will continue to operate for 30 minutes after S1 is turned off. The off delay relay is a safety feature to allow the oven to cool down to room temperature, and to eliminate heat stress on the components of the oven.

S1 - The Main Switch is a SPST normally open switch, mounted on the front of the Control Box. Activating this switch applies voltage to Terminal T6 of the Cool-Down Timer (R1). When used with the optional AVI Hood System, a remote switch mounted in the front of the AVI Hood replaces it.

S2 - This Switch is a SPDT centrifugal switch physically mounted inside the Main Motor (M1). When M1 comes up to full speed, S2 closes and sends voltage to the Temperature Control (TC) and the Contactors (C1 & C2). It functions as a safety feature to prevent heating element operation if the M1 fails to rotate.

S3 - High Limit Switch. This is a bi-metal, NC, SPST switch physically mounted in the side panel of the Bake Chamber. Its purpose is to provide fail safe operation. If the temperature of S3 exceeds 600°F, it opens and interrupts line voltage to all components except the Main Motor (M1).

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

T/C - The thermocouple is type K. It consists of two different conductors that produce a voltage proportional to temperature. The T/C is connected to terminals 2 & 3 of the Temperature Control (TC). The milli-volt signal is used to display the actual temperature.

TC - The Temperature Control (TC) has line voltage applied to terminal 10, and “neutral” voltage applied to terminal 9. There are two displays; one for actual temperature and one for set-point temperature. Actual temperature is determined by the Thermocouple (T/C), connected to terminals 2 & 3, with terminal 2 being the negative terminal and terminal 3 being the positive terminal. The user determines the set-point temperature by pressing and holding the up or down arrow button switches. The TC sends a 14-24 VDC signal to the Solid State Relay (SSR) depending upon the relationship between actual temperature and set-point temperature. If the actual temperature rises above maximum temperature, an internal switch contact opens thereby interrupting power.

When any one of, or all of, the Hood Operator Switches (S2, S3, & S4) are turned on;

1. The Exhaust Fan Motor (M1) located on the roof will run.
2. The Variable Frequency Drive (VFD) will display a set value. The values are preset from the factory and can be referenced in the I&O manual.
3. The ovens associated with the corresponding switches will turn on.

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

- Line voltage for Standard Hoods is assumed to be 208/240 VAC, 60 Hz. (1) Phase
- Line voltage for World & Australian Hoods is assumed to be 230 VAC, 50 Hz. (1) Phase

Power for the hood originates at building's electrical service panel. A total of two (2) circuits are required; (1) is a single phase high voltage circuit for VFD/Fan circuit that connects to TS 1 terminals 1 & 2, and (2) is a single phase low voltage circuit for Fire Suppression circuits and relays that connect to TS 2 terminals 23 & 24.

Switches mounted on the hood control lighting, VFD activation, Make Up Air (MUA) activation and oven function. When S1 is activated voltage will be carried to the lights turning them on. When XLT Ovens are installed with an AVI Hood, the Switch Relocation Cord (SRC) effectively eliminates the Main Switch located on the oven and transfers control to the DPDT switches on the hood. When S2-S4 switches are activated a contact on the back of the switch will allow a low voltage signal to be sent to the VFD signaling it to turn on to a set frequency, at the same time when S2 is activated another contact switch will allow line voltage to be carried through the Switch Relocation Cord (SRC) to the oven activating it. Also the S2 switch sends line voltage to R4 to activate a MUA relay coil which switches from Normally Open (NO) to Normally Closed (NC) and completes the circuit to allow operation of the MUA unit.

The NO switch in the fire alarm system in the building needs to be connected to TS 2 terminals 13 & 14. When the alarm is activated it will supply line voltage to R3 making the relay switch from NC to NO, disabling the lights and cooling fans. It will also send a signal to disable contacts for oven power and R2. When the ovens shut off, the power is removed from R4-R6, removing power from the MUA units. When line voltage is supplied to R2, the relay switches from NC to NO activating the VFD to run full speed.

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

CS - The Current Sensor is a device that detects electrical current in a wire, and then generates a signal proportional to it. It drives an LED indicator lamp (LT3) to indicate that the fan is drawing current and operating. A minimum of 1.5 VAC is required.

LT1 & LT2 - These are standard incandescent light bulbs, and should illuminate when the contacts of S1 are closed.

LT3 - This is a green LED indicator that is driven by the CS to indicate that the fan is drawing current and operating.

M1 - The Exhaust Fan Motor is a 3-phase, direct drive motor. In normal operation, it is powered by the VFD through R6, and it's RPM will vary as the frequency from the VFD varies. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

M2 & M3 - The Cooling Fan Motor is a 1-phase, direct drive motor. In normal operation, it is powered through R1. These fans are used to keep the control box for the hood cool. There are no user serviceable parts in the motor, and the bearings are permanently lubricated.

PLUG 1, 2, & 3 - These are circular electrical plugs on one end of the Switch Relocation Cord (SRC). The Plugs connect to Receptacles 1, 2, & 3 on the bottom of the Hood Control Box. The other end of the SRC plugs into the oven wire harness, and eliminates the operator switch supplied in the oven. Conversely, when the operator switch on the hood is turned off, the corresponding oven is turned off as well.

R1 - Is a SPDT relay, which is a electrically operated switch. It uses an electromagnet to operate a switching mechanism. Line voltage is supplied from the VFD and current flows through a coil in the relay, causing the contacts in the relay to close. This will complete a circuit for the M2 & M3 to activate and turn on.

R2 - Is a SPDT relay, which is a electrically operated switch. It uses an electromagnet to operate a switching mechanism. No line voltage is supplied from TS2 via R3 until the fire alarm is activated. Once fire alarm is activated voltage is supplied to the coil in the relay, causing the contacts in the relay to close. This will complete a circuit between terminal 1 and 5 on the VFD activating the VFD to turn on to full speed.

R3 - Is a SPDT relay, which is a electrically operated switch. It uses an electromagnet to operate a switching mechanism. No line voltage is supplied from TS2 to R3 until the fire alarm is activated. Once fire alarm is activated voltage is supplied to the coil in the relay, causing the contacts in the relay to switch from NC to NO. This will interrupt the circuit in the relay supplying voltage to the lights, the ovens and the cooling fans, the MUA will shut down and the exhaust will run at full speed.

R4, R5, & R6 - These are SPDT relays, which are electrically operated switches. They use an electromagnet to operate a switching mechanism. When S2, S3, or S4 are activated line voltage is supplied to the coil of corresponding relay switching it from NC to NO. This completes a circuit for a damper that could be wired into 17,19, or 21 on TS 2. If only one damper is used install a jumper between 17,19, and 21 to activate damper no matter which oven is on.

REC 1, 2, & 3— These are circular electrical receptacles mounted on the bottom of the Hood Junction Box. The switch relocation cord (SRC) connects into these and to main switch in the corresponding oven. This deactivates the switch on the oven and relocates the operation of it onto the front of the hood.

S1 - This SPST (NO) switch is located on the front of the hood and controls the lights.

S2, 3, & 4 - These DPST (NO) switches are located on the front of the hood and control the ovens, as well as initiating and sequencing the operation of the VFD and damper circuits.

Line voltage is continuously applied to pin 1 of REC 4, 5, & 6, which is connected by a wire to a contact in S2, 3, & 4. This is shown on the schematic as the lower RH connection point of S2, 3, & 4. When the switch contacts are closed, shown on the upper LH connection point on the schematic, power is applied to pin 2 of the receptacles, as well as terminal B of R1, 2, & 3. Wires also connect terminal B and pin 4 of the receptacles. In essence, S2, 3, & 4 replace the switches on the ovens, and also energize the coils of R4, 5, & 6, which closes the relay contacts and sends a control signal to dampers or Make-up Air System.

The other set of contacts, shown as the upper set on the schematic, connect terminal 24 of the VFD and terminals 4, 3, & 2 respectively. The VFD generates it's own 24 VDC signal voltage, and the switches serve as inputs to the VFD. The VFD outputs user-selected frequencies depending upon the combination of switches that are closed.

TS 1, 2, & 3- These are terminal strips, which serves as a connection point for wires.

VFD - The Variable Frequency Drive (VFD) converts the AC supply voltage to DC and then converts the DC to a suitable three-phase frequency source for M1. Incoming power connects to terminals L1, L2, & L3. M1 connects to terminals T1, T2, & T3 through TS1. The VFD generates it's own 24 VDC control voltage on terminal P24. S2, S3, & S4 serve as user-controlled inputs and connect terminals 1, 2, & 3 to terminal P24. User inputs include a <RUN> and <STOP/RESET> buttons, as well as <UP> and <DOWN> arrow buttons. A complete manual can be found at www.xltovens.com.

Mechanical Function

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

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

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

Initial troubleshooting of the hood:

1. Make sure that the RUN lamp and POWER lamp on the VFD are lit.
2. Check to see that the green fan LED on the switch plate is on.
3. Check the actual frequency of the VFD controller. To access the actual frequency, press and hold the <FUNC> button until the Display Mode shows D001. Release the button, and then press one (1) more time. This will show actual operating parameters, not programmed parameters.
4. Check to see that the breaker on the hood electrical box is not tripped.
5. Check to see that the breaker in the service panel is not tripped.
6. Make sure the Switch Relocation Cords (SRC) are properly installed to the oven(s).
7. Check to see that the grease filters are clean & installed properly.
8. Check to see if the exhaust fan is rotating in the correct rotation. To verify fan rotation, remove the lid on the exhaust fan. Visually inspect rotation in accordance with label on fan housing.

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

- E01-E04 Inverter output was short circuited
- E05 motor overload is detected by electronic thermal function
- E07 DC bus voltage exceeds a threshold
- E09 DC bus voltage is below a threshold
- E14 Ground fault detected between controller output and motor

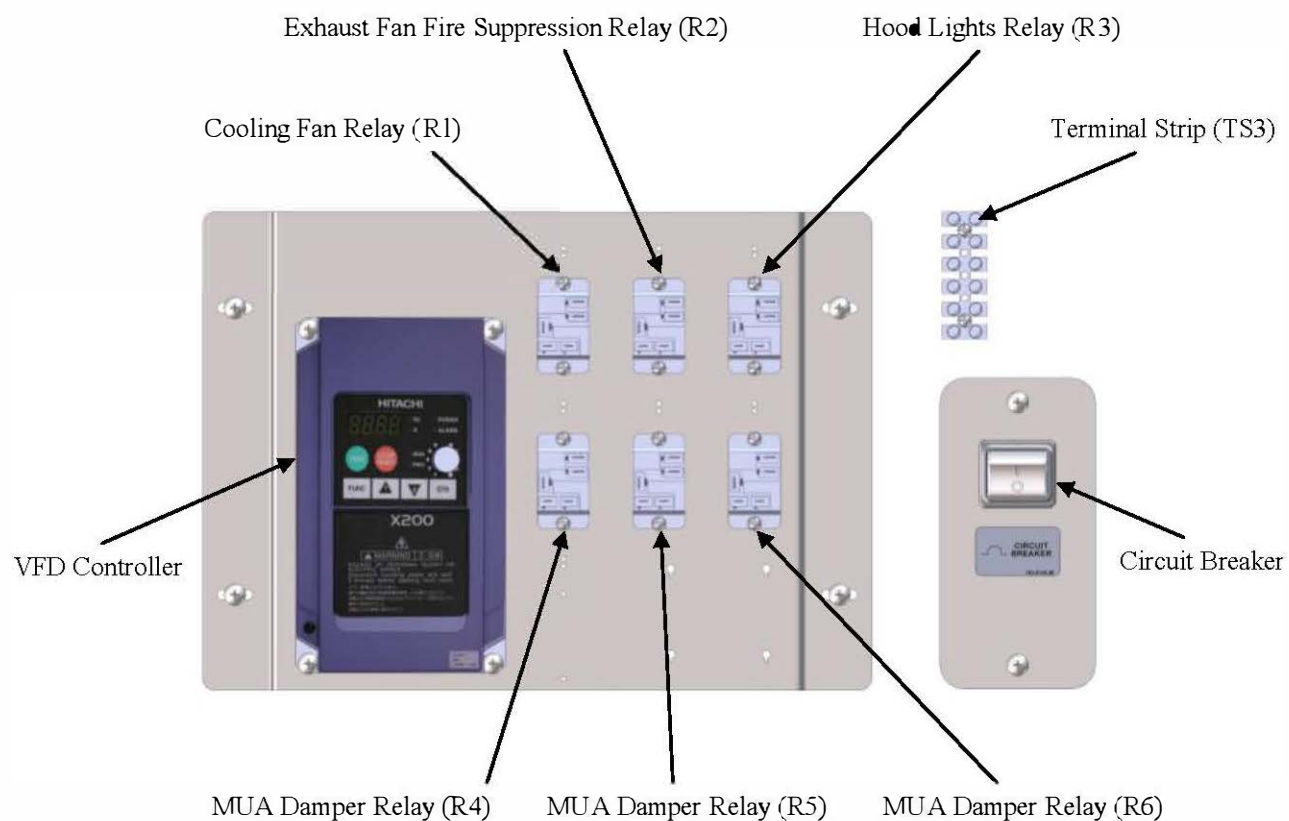
If any of the above error codes are displayed, then follow these steps to clear them.

1. Check VFD display for error code and record it.
2. Clear error by pressing the <STOP RESET> button.
3. Press the <RUN> button to activate exhaust fan.
4. Normal operation resumes with no error codes.
5. If error codes return press the <STOP RESET> button.

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

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

VFD Control Box - Standard w/Fire Suppression



VFD Control Box (Cover removed)

Conveyor Control Programming Procedure



TIP

Read the entire instruction before programming.

Configuration Key Functions

- < L > = Behind the <L> in XLT is a hidden button. This is used along with the up and down button to access the programming mode. Use this after each step to advance to the next parameter when programming.
- △ UP = Increases the setting of the selected parameter.
- ▽ DOWN = Decrease the setting of the selected parameter.

1. Enter Programming Mode/Program the bake length

- Press the <L> button and both <UP> and <DOWN> button simultaneously to enter programming mode.
- 0055 will appear on screen, this is already set from factory
- Press the <UP> button until the desired belt length is displayed. Belt lengths will read as follows:

1832 = 0032

1855 = 0055

2440 = 0040

3240 = 0040

3255 = 0055

3855 = 0055

2. Program the Total Reduction Value - Press the <UP> button until the desired settings is reached. All ovens = 300.
3. Set Speed Trimming Value - Press the <DOWN> button until the display shows 0000.
4. Set Fast Bake Limit - Press the <UP> button until the display shows 1:30.
5. Set Slow Bake Limit - Press the <UP> button until the display shows 17:00.
6. Set Conveyor Motor Rotation - Press the <UP> OR <DOWN> buttons until the display shows 1 for right-to-left direction, or 2 for left-to-right belt direction.
7. Save and Exit Programming Mode - Press the <L> button two (2) times to save and exit Programming Mode.

After leaving Program Mode, 1:30 run time will appear on the display. Press and hold the <UP> or <DOWN> buttons until desired run time appears.

Temperature Control Programming Procedure



TIP

Read the entire instruction before programming.

Configuration Button Functions

<FUNC> =The new setting of the selected parameter is stored and the display advances to the next parameter. This is required between each parameter.

△ UP= Increases the setting of the selected parameter.

▽ DOWN=Decrease the setting of the selected parameter.

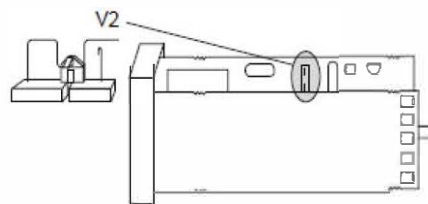


Figure 1

1. Open V2 switch for Basic Configuration (Figure 1)
 - Remove instrument from its case
 - Open switch V2
 - Re-insert the instrument back in its case
2. Basic Configurations
 - Using the configuration buttons, scroll through parameter codes, changing them to match (Figure 2)
 - After P12 _._._. Will appear
3. Close V2 switch after Basic Configuration (Figure 1)
 - Remove instrument from its case
 - Close Switch V2
 - Re-insert the instrument back in its case
 - Error 400 will appear. Press and hold the △ and ▽ to clear
 - 000 will appear
4. Advanced Configurations Procedure
 - Scroll through the parameter codes to nnn. Change nnn to 311 to unlock the advanced configuration
 - Using the configuration buttons, scroll through parameter codes, changing them to match Figure 3
 - Scroll through the parameter codes again and change the nnn to 5. This locks the advanced configuration
 - Scroll through the parameter codes again and verify nnn is ON

P1	2°C/10°F
P2	0
P3	315°C/600°F
P4	r
P5	1
P6	H.A.
P7	d
P8	OFF
P9	0
P10	100
P11	311
P12	7

Figure 2

SP	260°C/500°F
nm	311/5
AL	315°C/600°F
HSA	.1
Pb	4.0
ti	5.0
td	.00
1P	30
C	2
rL	204°C/400°F
rH	310°C/590°F
OLH	100
tOL	InF

Figure 3

Hitachi X200 Restoring AVI Defaults



TIP

Read the entire instruction before programming.

Access program parameters by pressing the <FUNC> button one time and using the up and down arrow buttons to navigate to the appropriate parameter press the <FUNC> button again to make adjustments to that parameter by using the up and down arrows. To store the new settings press the <STR> button one time.

B031 = 01

B084 = 01

Press and hold the <FUNC> <Down Arrow> and <Stop/Reset> buttons all at the same time. Release the buttons all at once and the country code should appear in the display (USA). Hitachi's factory settings are now restored.

To install AVI Defaults press <FUNC> button one time and enter following parameters

A001 = 01

A003 – USA = 60 Hz. World = 50 Hz.

A082 = Supply voltage at location 200, 215, or 230 choose appropriate voltage.

A093 = 3000

A094 = 01

A096 = 10

B002 = 25

C001 = 00

C002 = 02

C003 = 03

C004 = 04

C005 = 05

C014 = 00

F001 = See Figure 1

H004 = 4

B031 = 03



Put controller into display mode by pressing the <FUNC> button and holding until d001 appears on the display release and then press the <FUNC> button one time. The display should show 0.0.

Test run the motor by turning on one of the oven/hood switches located on the face of the hood.

Complete VFD manual available at www.xltovens.com.

VFD Controller Settings						
	Switches On			1832, 1855 & 2440	3240 & 3255	3855
	Top	Middle	Bottom			
Single	X			20 Hz	25 Hz	30Hz
Double	X			20 Hz	25 Hz	30Hz
			X	35 Hz	40 Hz	45 Hz
	X		X	35 Hz	40 Hz	45 Hz
Triple	X			20 Hz	25 Hz	30Hz
		X		30 Hz	35 Hz	40 Hz
			X	40 Hz	45 Hz	50 Hz
	X	X		30 Hz	35 Hz	40 Hz
	X		X	40 Hz	45 Hz	50 Hz
		X	X	40 Hz	45 Hz	50 Hz
	X	X	X	45 Hz	50 Hz	55 Hz
Fire Suppression				60 Hz		

How to order Parts

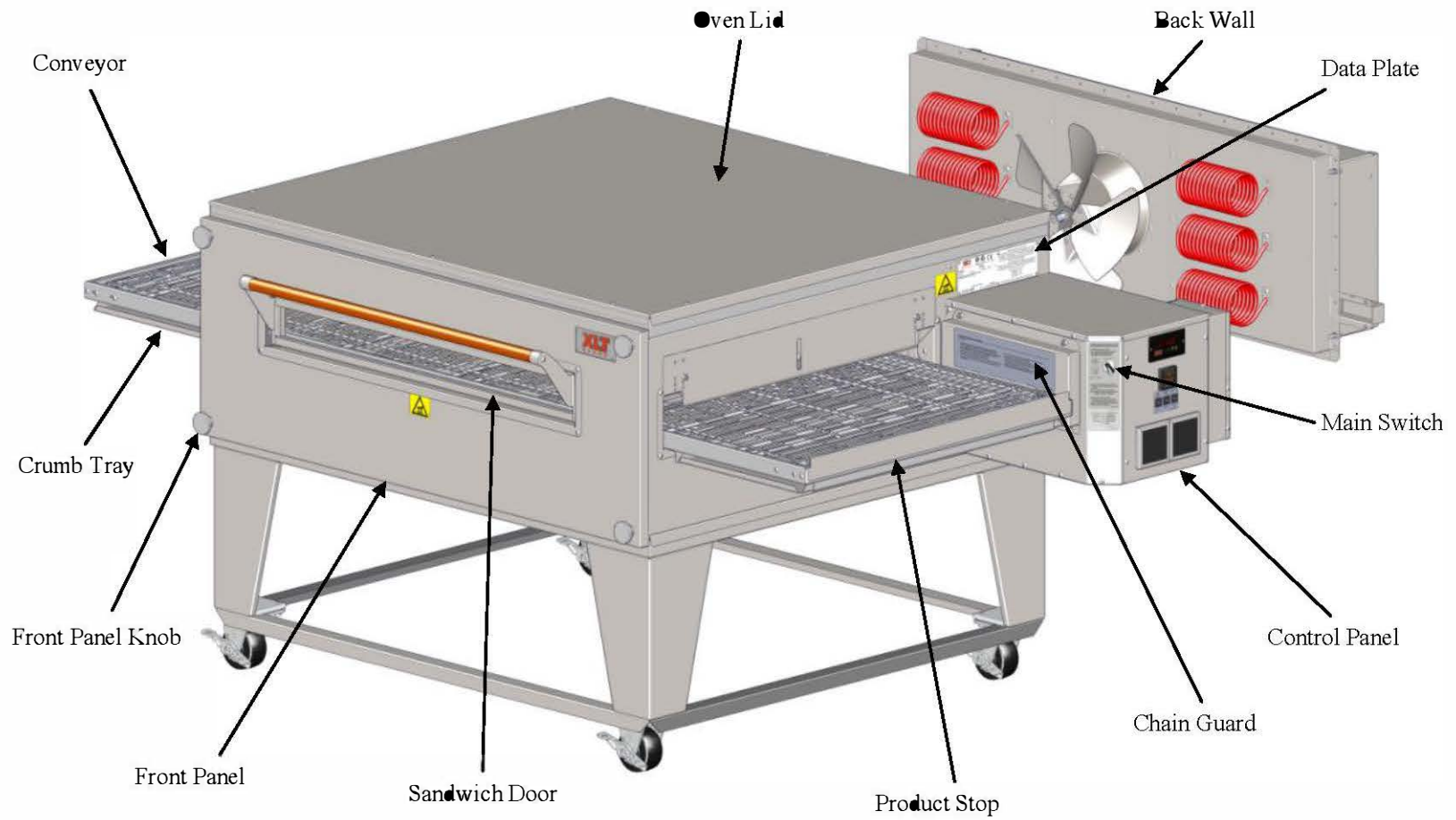
Have all information ready when calling XLT. Below is a list of information that is required for all orders. At the bottom of the Bill of Materials (BOM) on the following parts overview pages are additional requirements needed depending on your parts order.

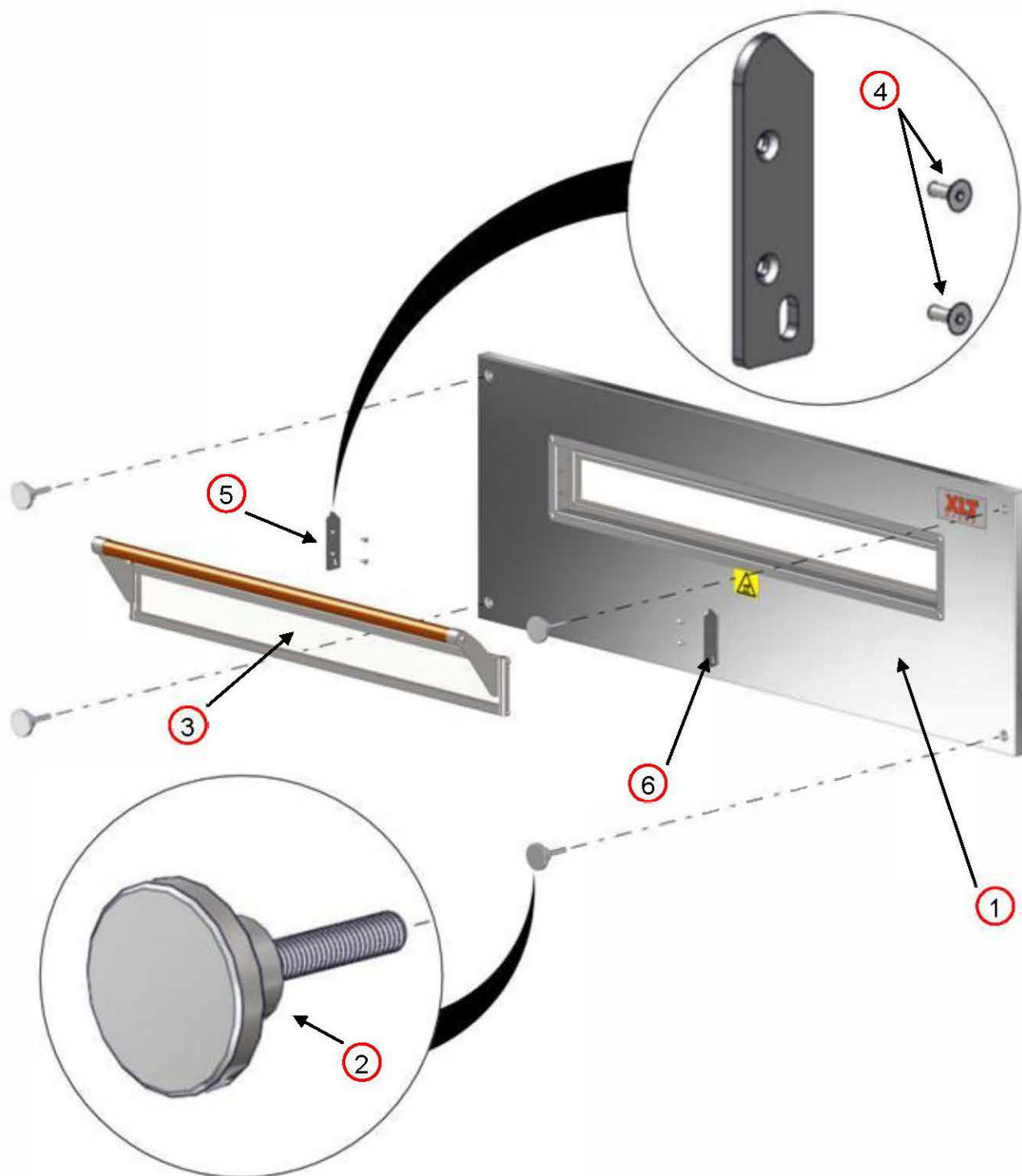
Oven/Hood information required:

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

P.O.R = Price On Request

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

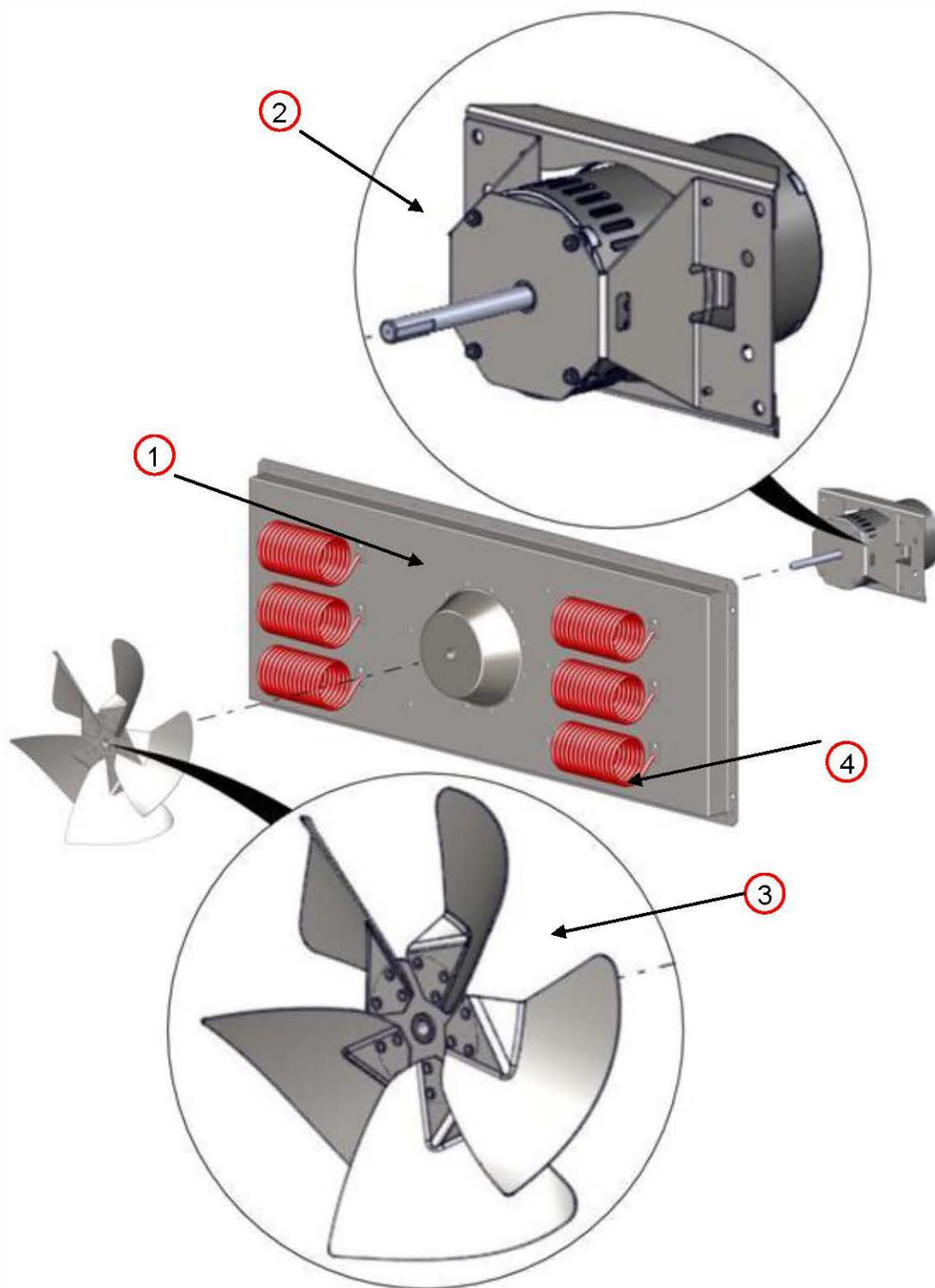




FRONT PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 6500	Front Panel Assembly	P.O.R
2	XA 6505	Front Panel Knob	\$15.90
3	XA 6600	Sandwich Door	P.O.R
4	XF 126-2	Screw 10-24	P.O.R
5	XM 6703	Door Retainer Left	\$13.80
6	XM 6704	Door Retainer Right	\$13.80

Front Panel information required:

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

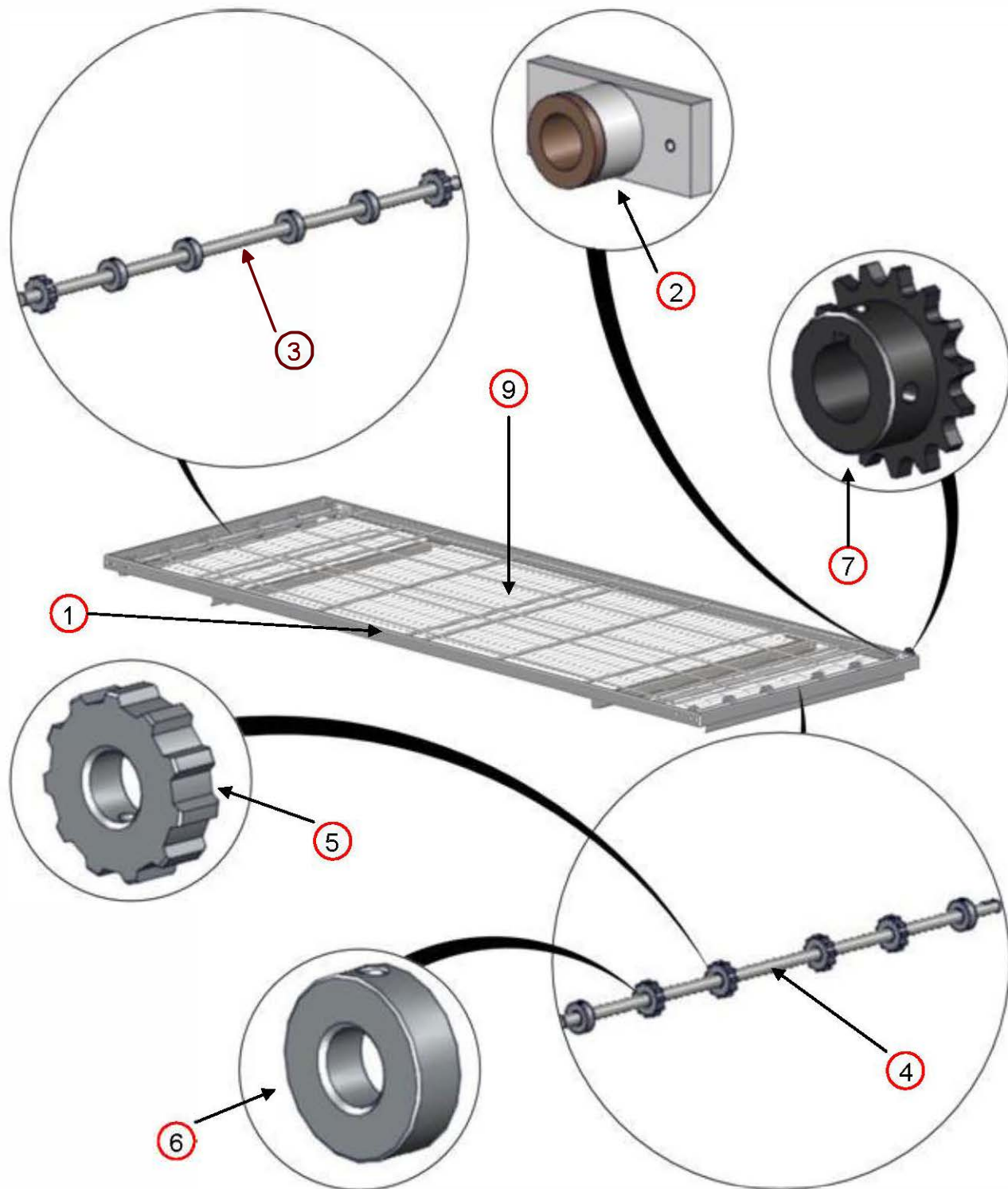


Electric Oven Element Usage								
Oven Size	208V- 4500W	Qty	240V- 4500W	Qty	208V- 5300W	Qty	240V- 5300W	Qty
1832-208 V					x	3		
1832-240 V							x	3
1832-380 V							x	3
1855-208 V					x	6		
1855-240 V							x	6
1855-380 V							x	6
1855-480 V							x	6
2440-208 V	x	6						
2440-240 V			x	6				
2440-380 V			x	6				
2440-480 V			x	6				
3240-208 V	x	6						
3240-240 V			x	6				
3240-380 V			x	6				
3240-480 V			x	6				
3255-208 V					x	6		
3255-240 V							x	6
3255-380 V							x	6
3255-480 V							x	6
3855-208 V					x	6		
3855-240 V							x	6
3855-380 V							x	6
3855-480 V							x	6

BACK WALL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 50	Back Wall Assembly	P.O.R
2	SP 5009A-75	Fan Motor w/ Mount 3/4 HP	\$283.20
3	XA 5200	Fan Blade	P.O.R
4	XP 5201/5202	Heating Element	P.O.R

Back Wall information required:

- Size of Oven
- Voltage

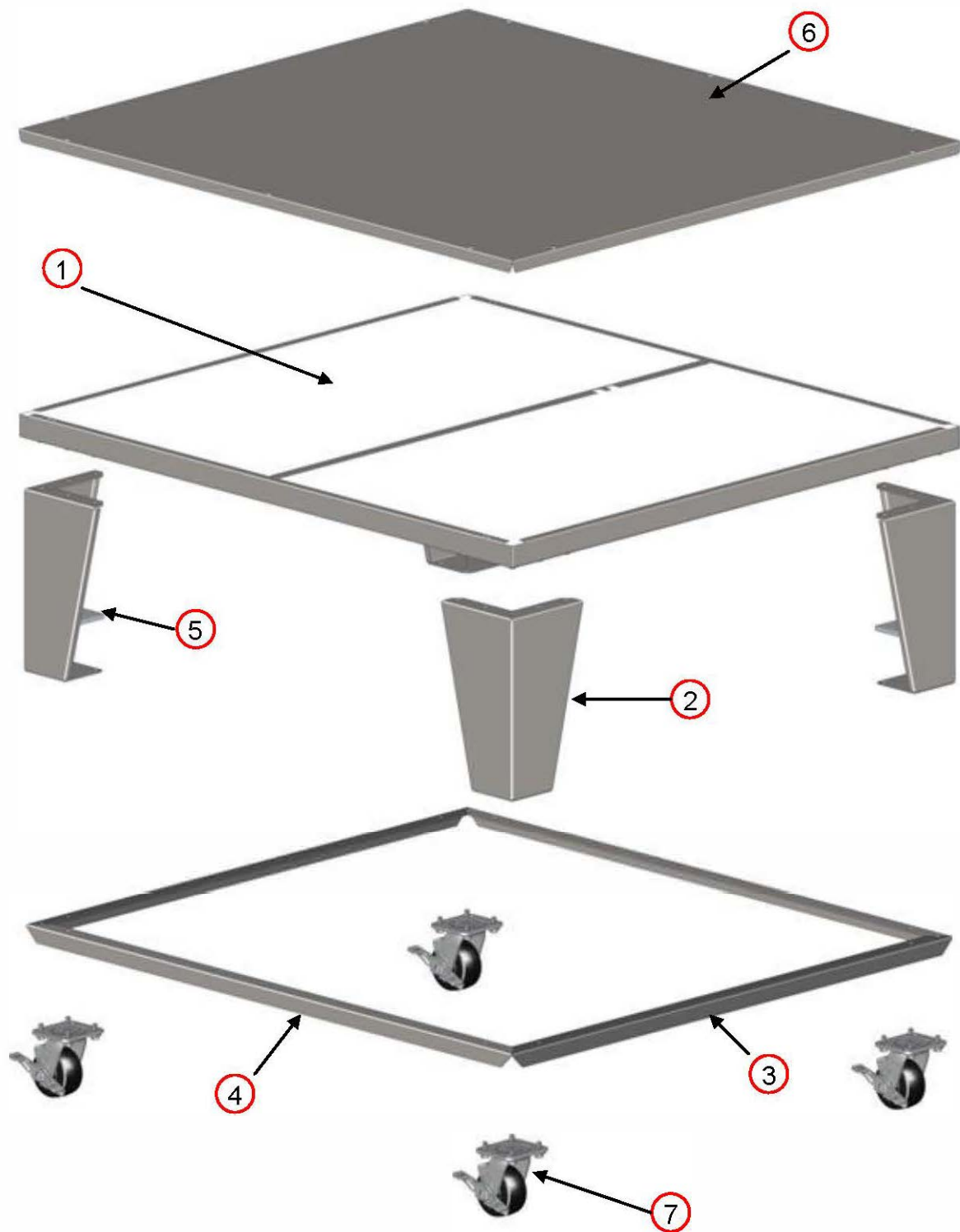


Conveyor Drive Chain not shown

CONVEYOR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 7000	Conveyor Assembly	P.O.R
2	XA 7200	Conveyor Bearing Assembly	\$9.30
3	XM 7301	Conveyor Shaft Idle	P.O.R
4	XM 7302	Conveyor Shaft Drive	P.O.R
5	XP 7403	Conveyor Roll Notched	\$12.20
6	XP 7404	Conveyor Roll Plain	\$11.00
7	XP 9503	Conveyor Sprocket Driven 15	\$15.50
8	XP 9504	Conveyor Drive Chain	\$23.60
9	XP 9506	Conveyor Belt	P.O.R

Conveyor information required:

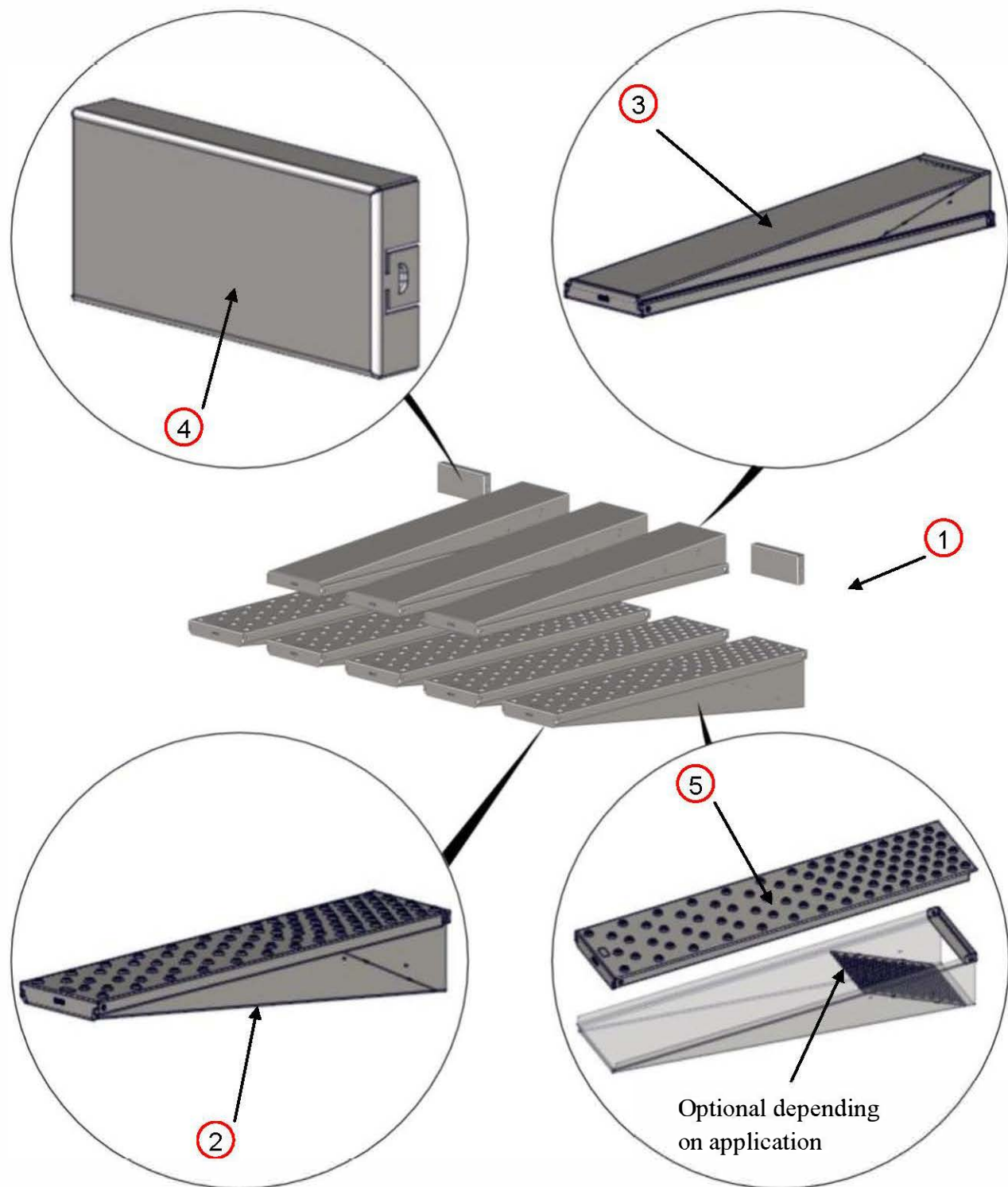
- Oven Size
- Split Belt or Standard Belt



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

Base information required:

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



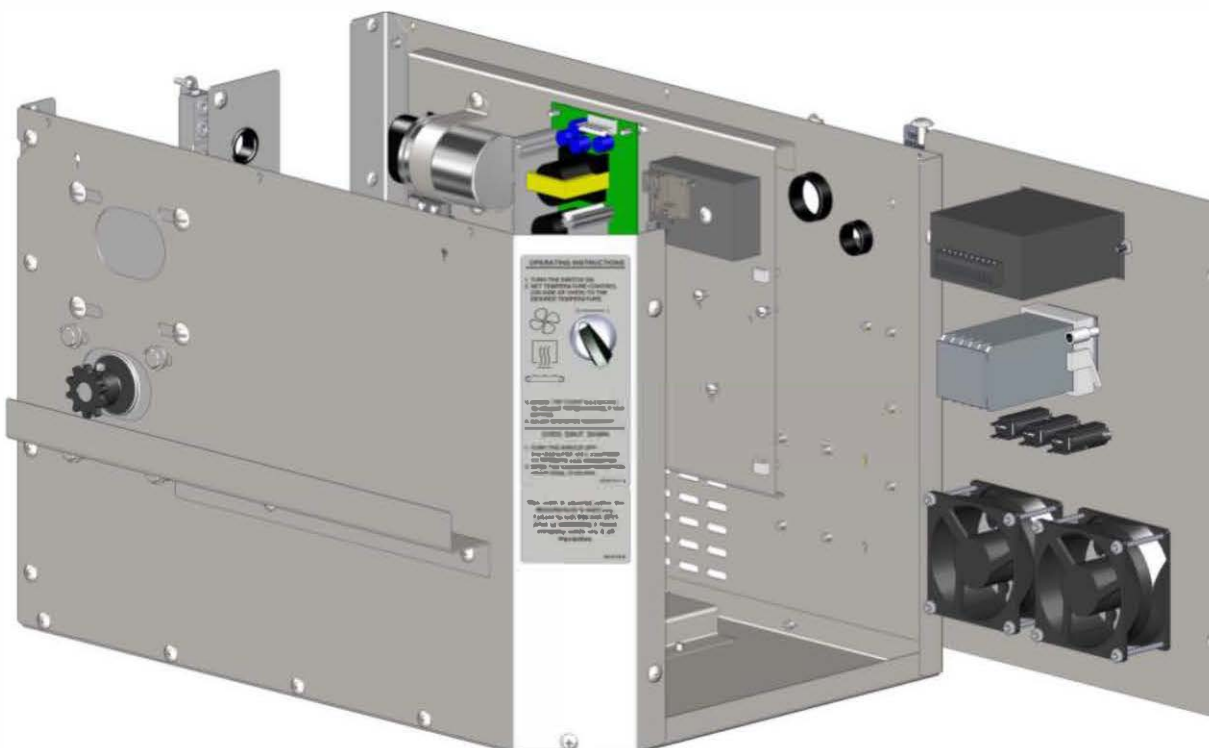
FINGERS			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 8XXXX	Finger Group Assembly	P.O.R
2	XA 8001-B	Finger Body Bottom	P.O.R
3	XA 8001-T	Finger Body Top	P.O.R
4	XM 8009-S	Finger Block Off Plate	\$12.60
5	XM 8XXX	Finger Outer Plate	P.O.R

Finger information required:

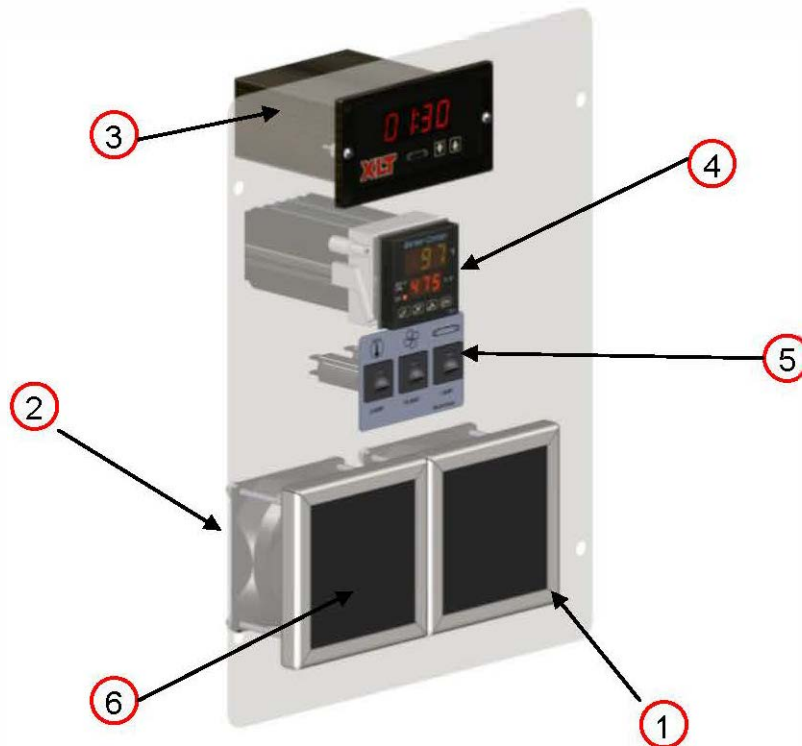
- Size of Oven
- Customer name
- Part number on front of finger outer



Operating Position (shown with lid removed)



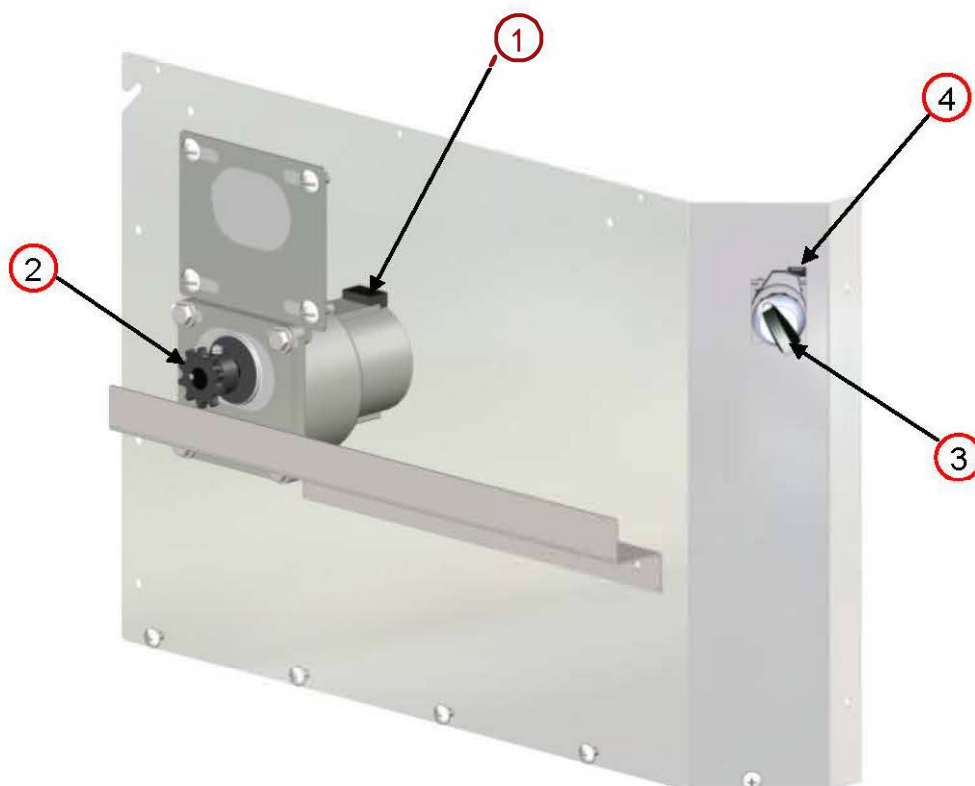
Service Position



CONTROL PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	SP 4520-EL	Fan Guard / Filter Holder	\$9.30
2	XP 4501-EL	FPPG Fan EL M2	\$35.20
3	XP 4507-24-A	Conveyor Speed Control 24VDC	\$277.10
4	XP 4508-EL	Temperature Control ELECTRIC	\$343.50
5	XP 4515-CB	Circuit Breaker	\$6.95
6	XP 4520-EL	Fan Filter	\$1.95

Control Panel information required:

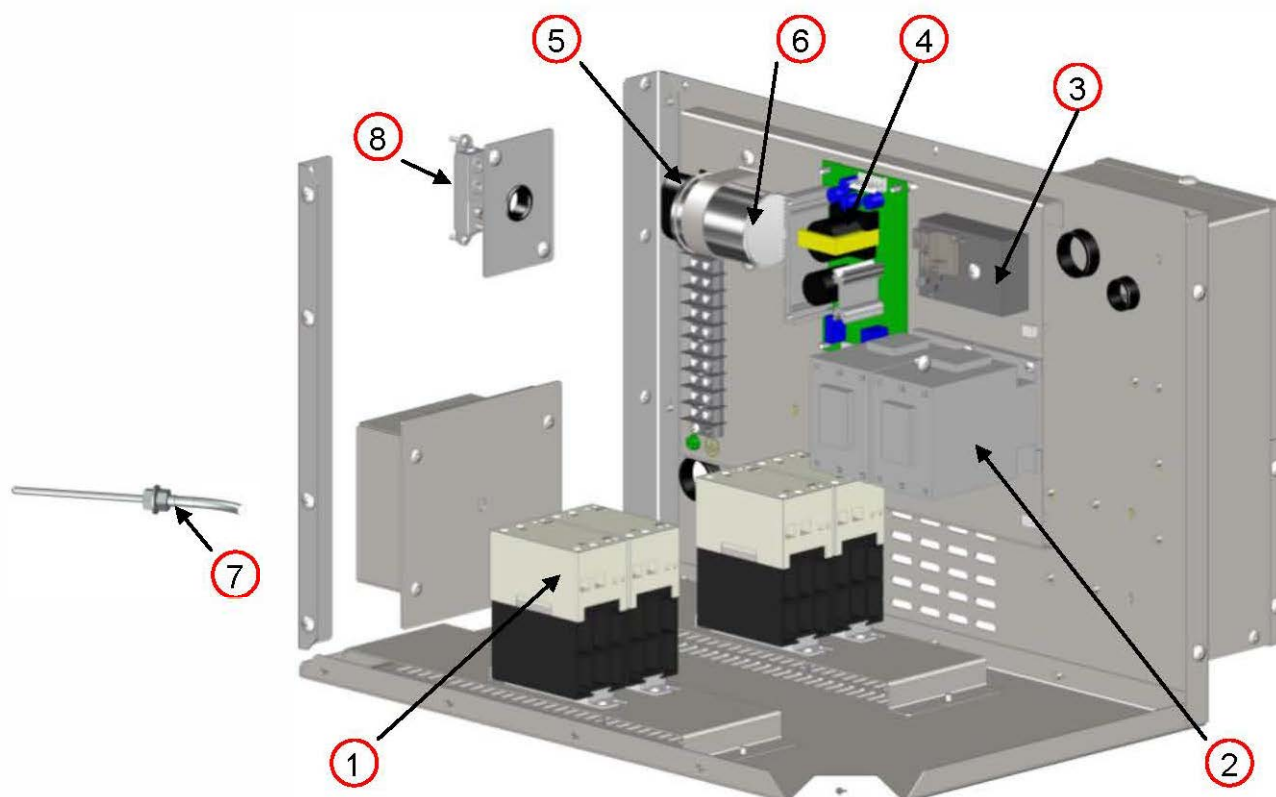
- Size of Oven
- Voltage
- Circuit Breaker amp rating
- Conveyor Belt direction



CONTROL BOX FRONT			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 4117-12.5 RPM STD	Conv Motor Assy 12.5 RPM STD	\$305.30
2	XP 4155	Sprocket Conveyor Drive 10T	\$15.70
3	XP 4101	Switch Operator	\$21.40
4	XP 4102	Contact Block 1 Pole w/Mount	\$21.40

Control Box Front information required:

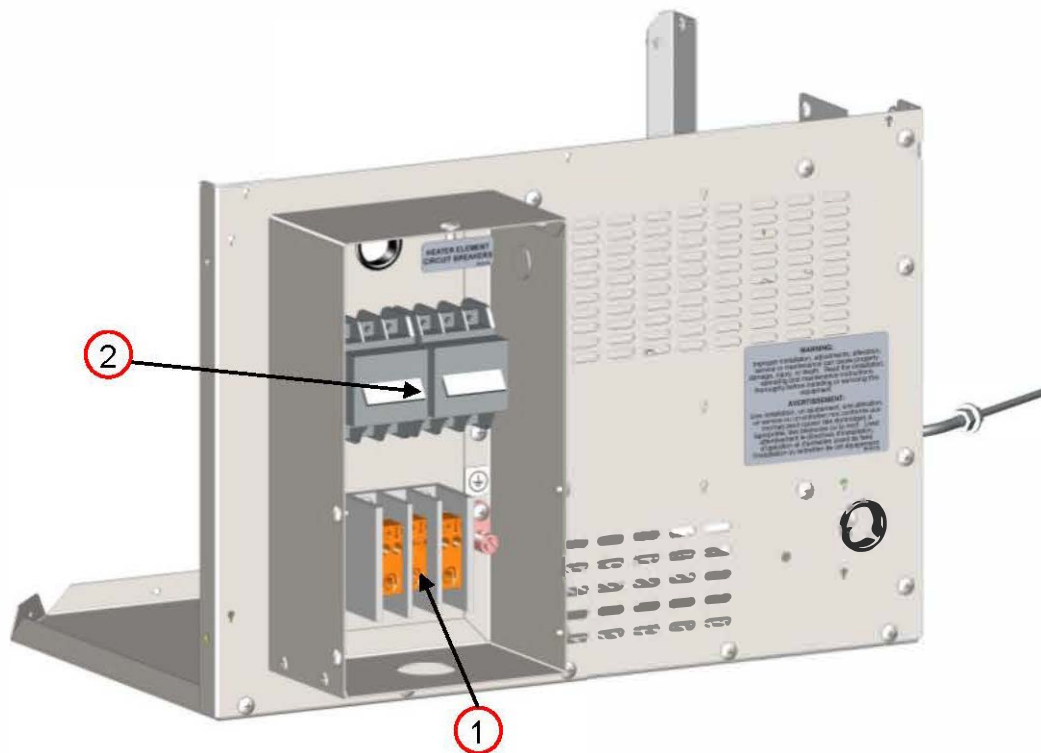
- Size of Oven
- Split Belt or Standard Belt



CONTROL BOX BACK			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4305-50	Relay 50A Solid State	\$159.70
2	XP 4306-50	50 Amp 3 Phase Contactor	\$236.60
3	XP 4704-230 VOLT	Cool Down Timer 230 Volt R1	\$46.70
4	XP 4716	Power Supply PS	\$32.40
5	XP 5012	Capacitor Boot	\$2.30
6	XP 5014-30	Capacitor Baldor 3/4 HP 30uF	\$18.60
7	XP 4509	Thermocouple Type K 48	\$31.80
8	XP 4713	High Temp Limit Switch S3	\$53.10

Control Box Back information required:

- Size of Oven
- Voltage



CONTROL BOX REAR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4302-3	3 Pole Power Block Electric	\$121.60
2	XP 4303	3 Pole Circuit Breaker EL	\$160.40

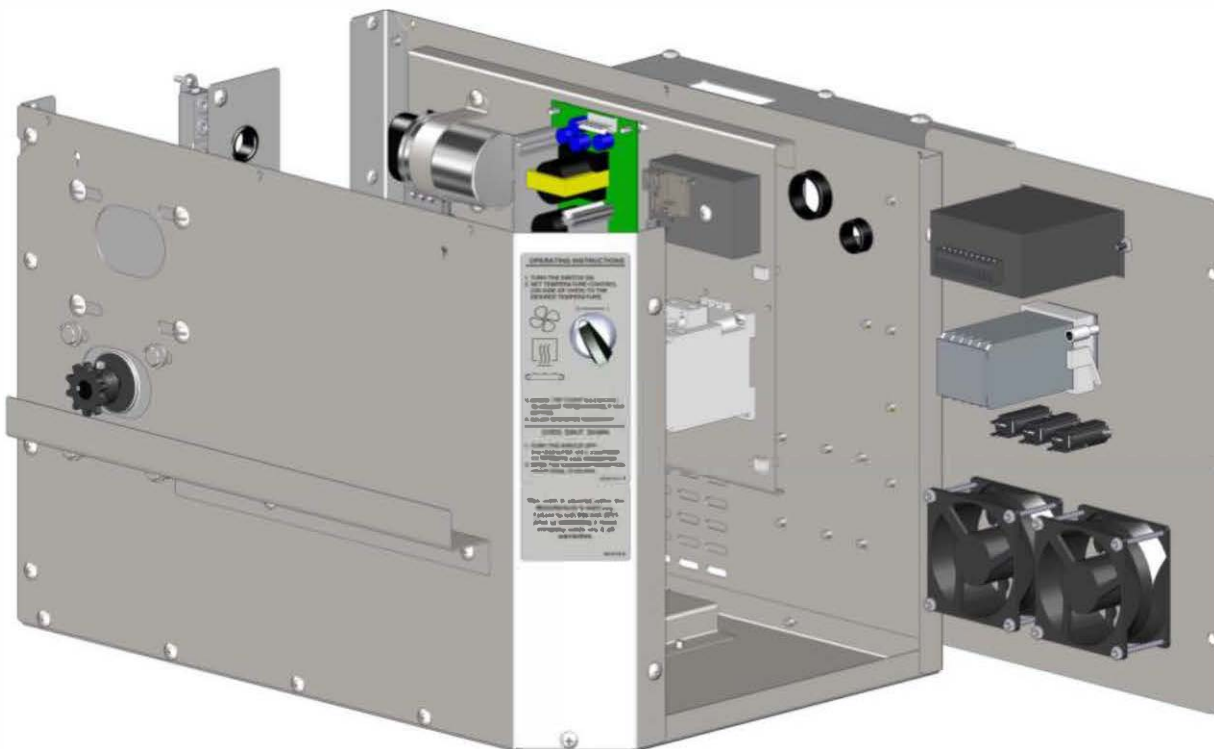
Control Box Rear information required:

- Size of Oven
- Voltage

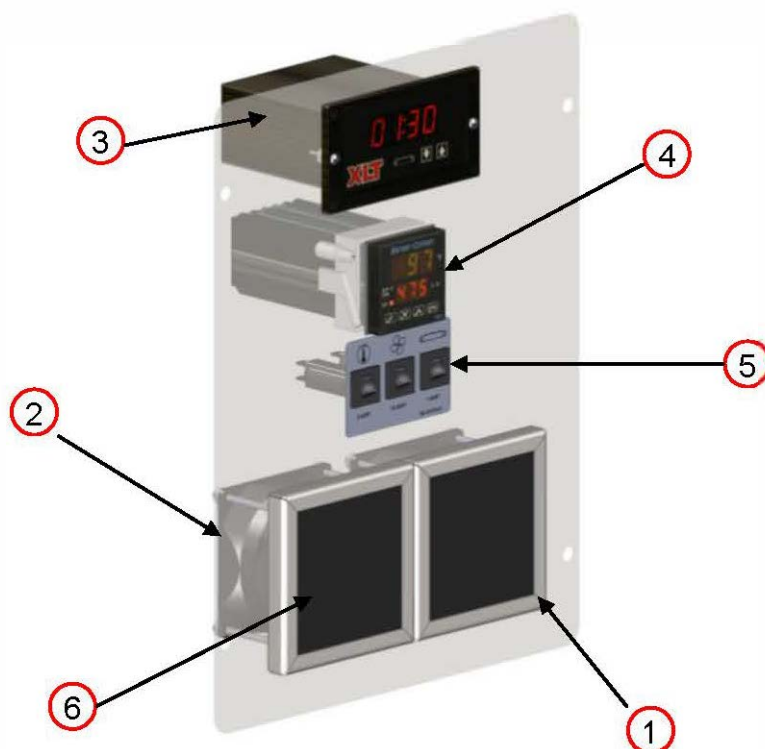
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Operating Position (shown with lid removed)



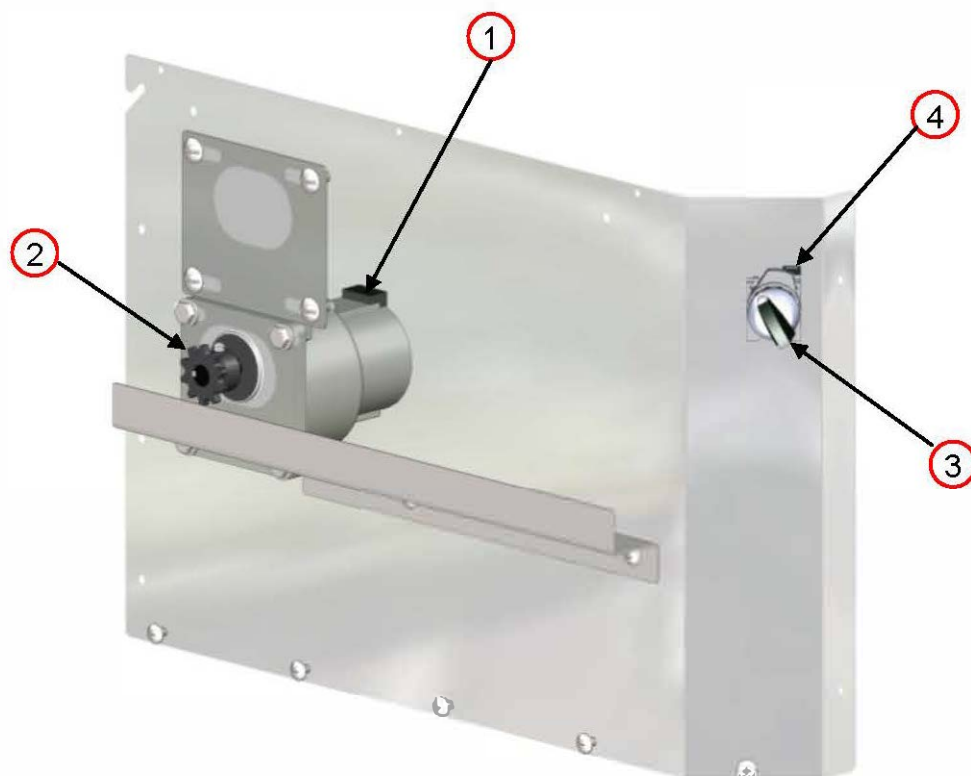
Service Position



CONTROL PANEL			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	SP 4520-EL	Fan Guard / Filter Holder	\$9.30
2	XP 4501-EL	FPPG Fan EL M2	\$35.20
3	XP 4507-24-A	Conveyor Speed Control 24VDC	\$277.10
4	XP 4508-EL	Temperature Control ELECTRIC	\$343.50
5	XP 4515-CB	Circuit Breaker	\$6.95
6	XP 4520-EL	Fan Filter	\$1.95

Control Panel information required:

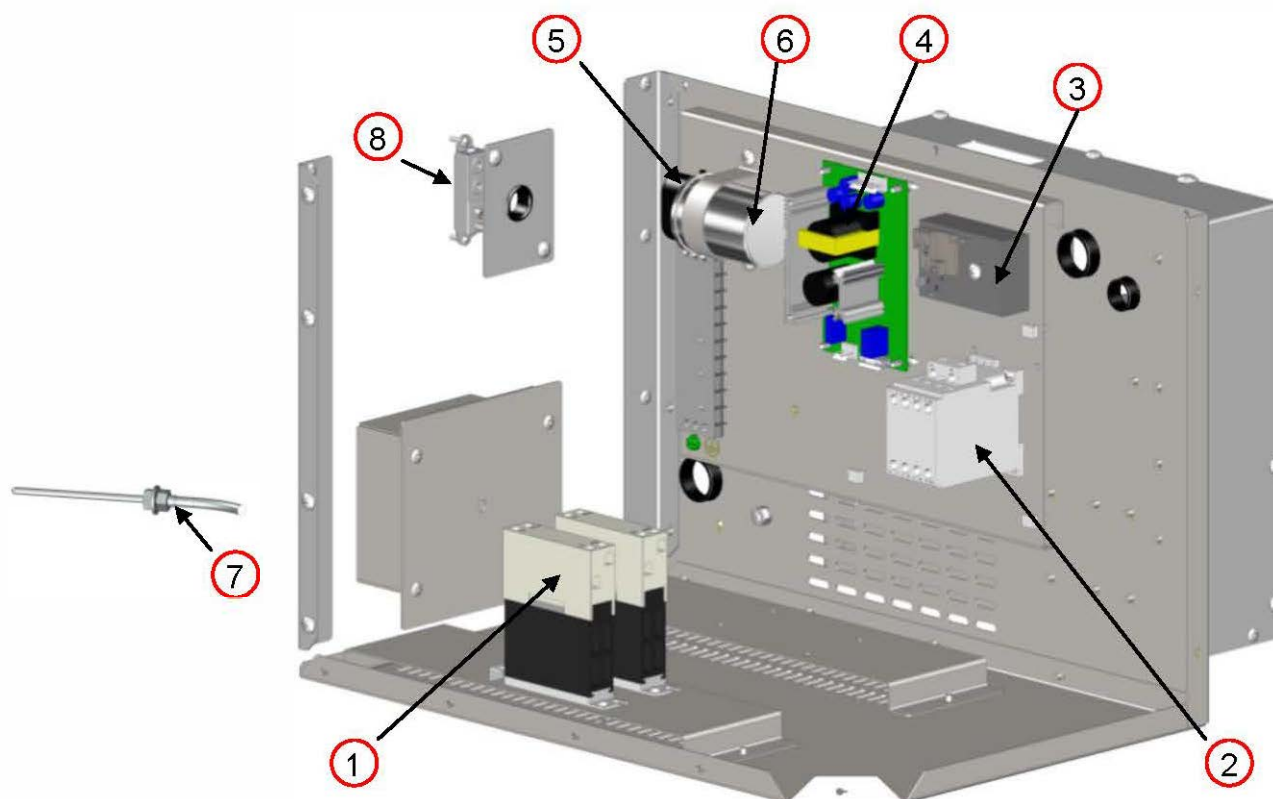
- Size of Oven
- Voltage
- Circuit Breaker amp rating
- Conveyor Belt direction



CONTROL BOX FRONT			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XA 4117-12.5 RPM STD	Conv Motor Assy 12.5 RPM STD	\$305.30
2	XP 4155	Sprocket Conveyor Drive 10T	\$15.70
3	XP 4101	Switch Operator	\$21.40
4	XP 4102	Contact Block 1 Pole w/Mount	\$21.40

Control Box Front information required:

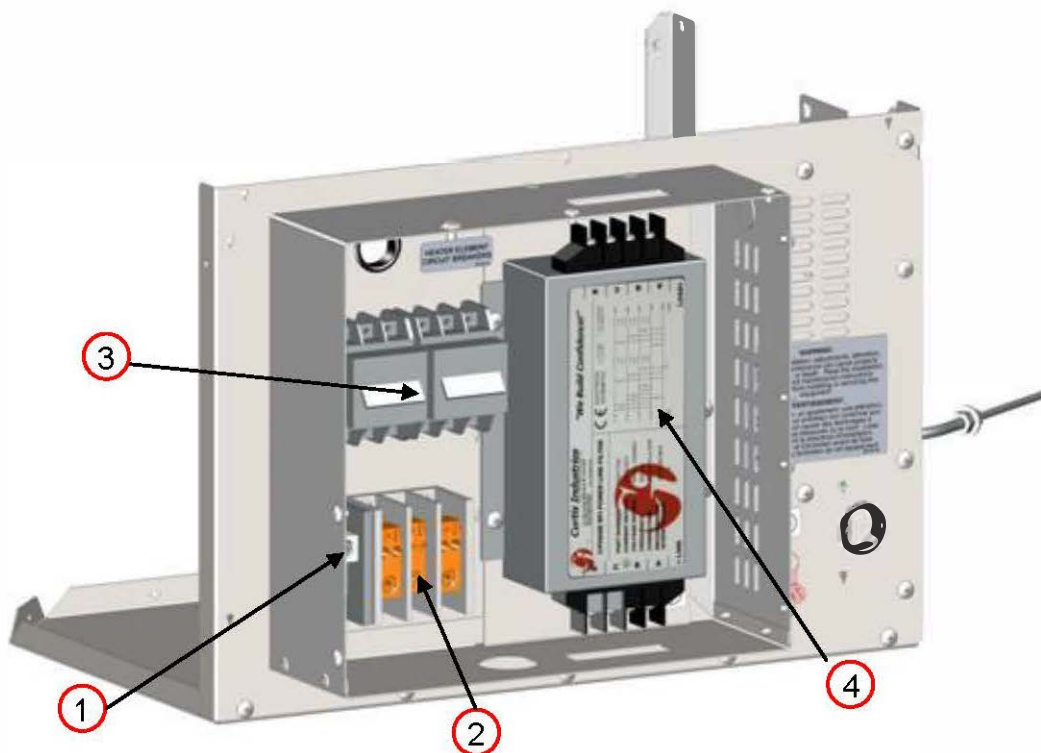
- Size of Oven
- Split Belt or Standard Belt



CONTROL BOX BACK			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4305A-30	Relay 30A Solid State	\$176.20
2	XP 4306A-30	30 Amp 3 Phase Contactor	\$195.80
3	XP 4704-230 VOLT	Cool Down Timer 230 Volt R1	\$46.70
4	XP 4716	Power Supply PS	\$32.40
5	XP 5012	Capacitor Boot	\$2.30
6	XP 5014-30	Capacitor Baldor 3/4 HP 30uF	\$18.60
7	XP 4509	Thermocouple Type K 48	\$31.80
8	XP 4713	High Temp Limit Switch S3	\$53.10

Control Box Back information required:

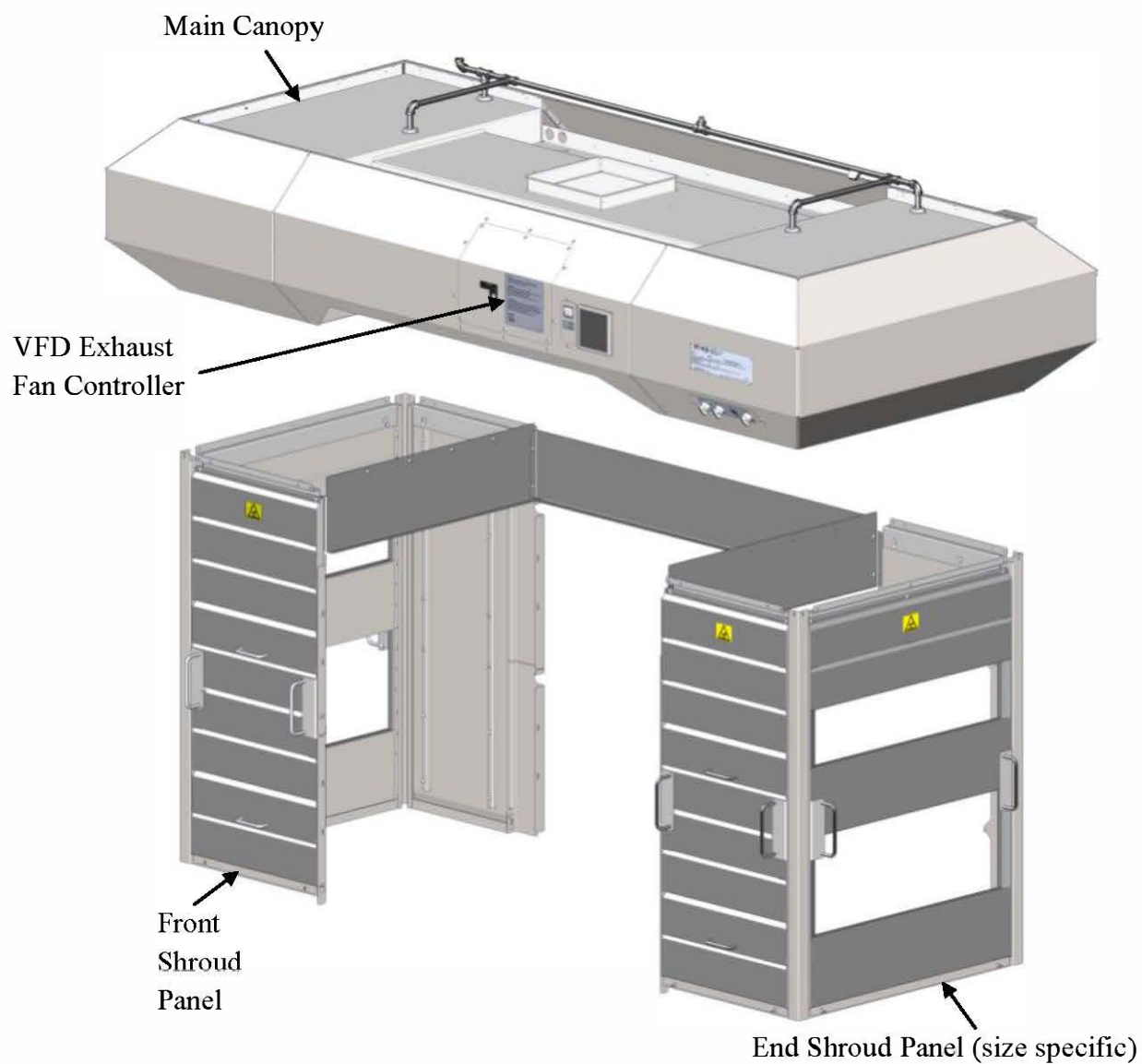
- Size of Oven
- Voltage

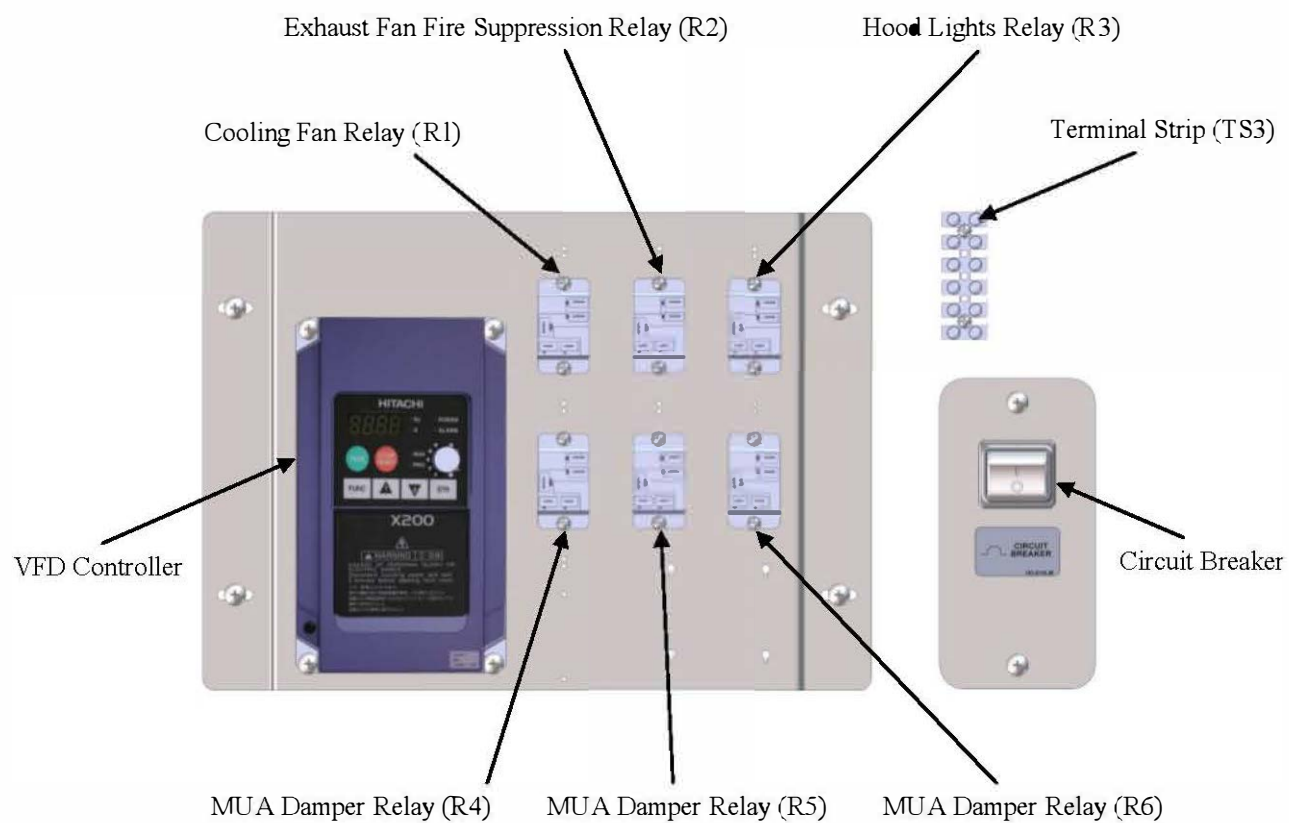


CONTROL BOX REAR			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4302-1	1 Pole Power Block Electric	\$16.80
2	XP 4302-3	3 Pole Power Block Electric	\$121.60
3	XP 4303	3 Pole Circuit Breaker EL	\$160.40
4	XP 4304	Filter EMI 4 Wire	\$312.70

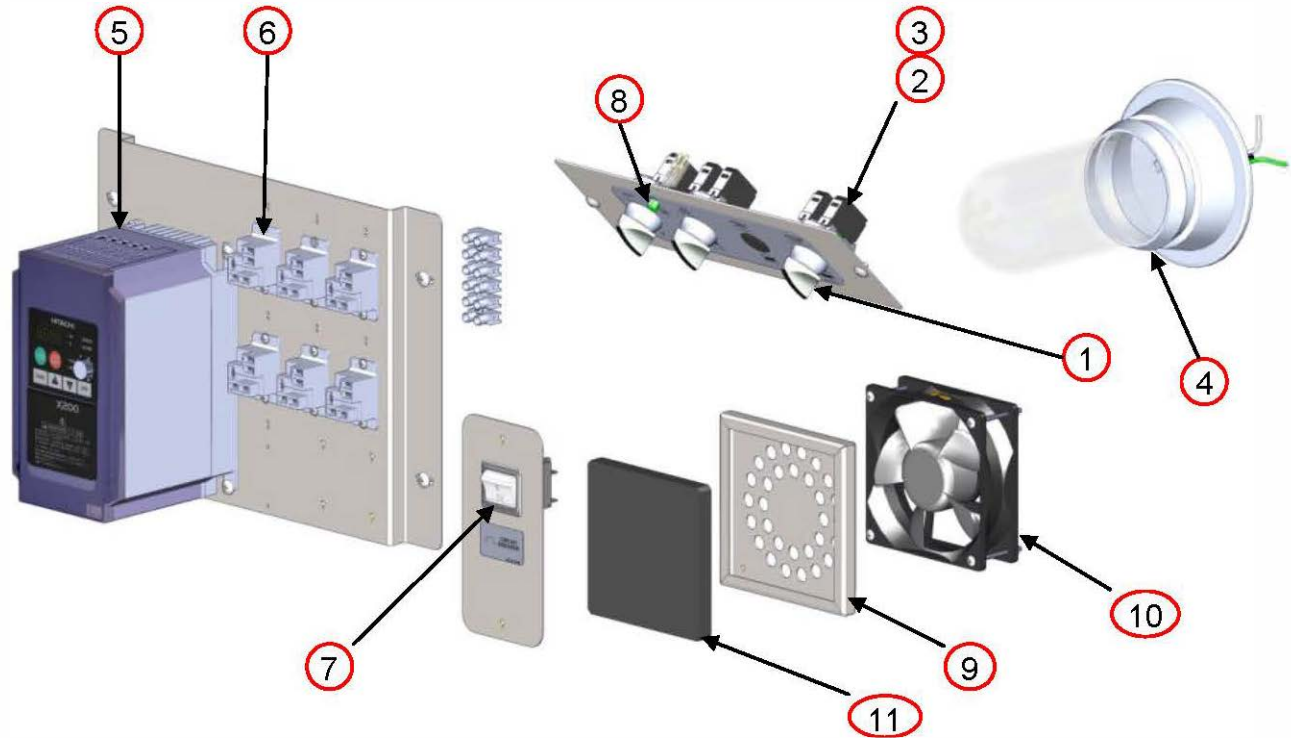
Control Box Rear information required:

- Size of Oven
- Voltage



VFD Control Box w/Fire Suppression

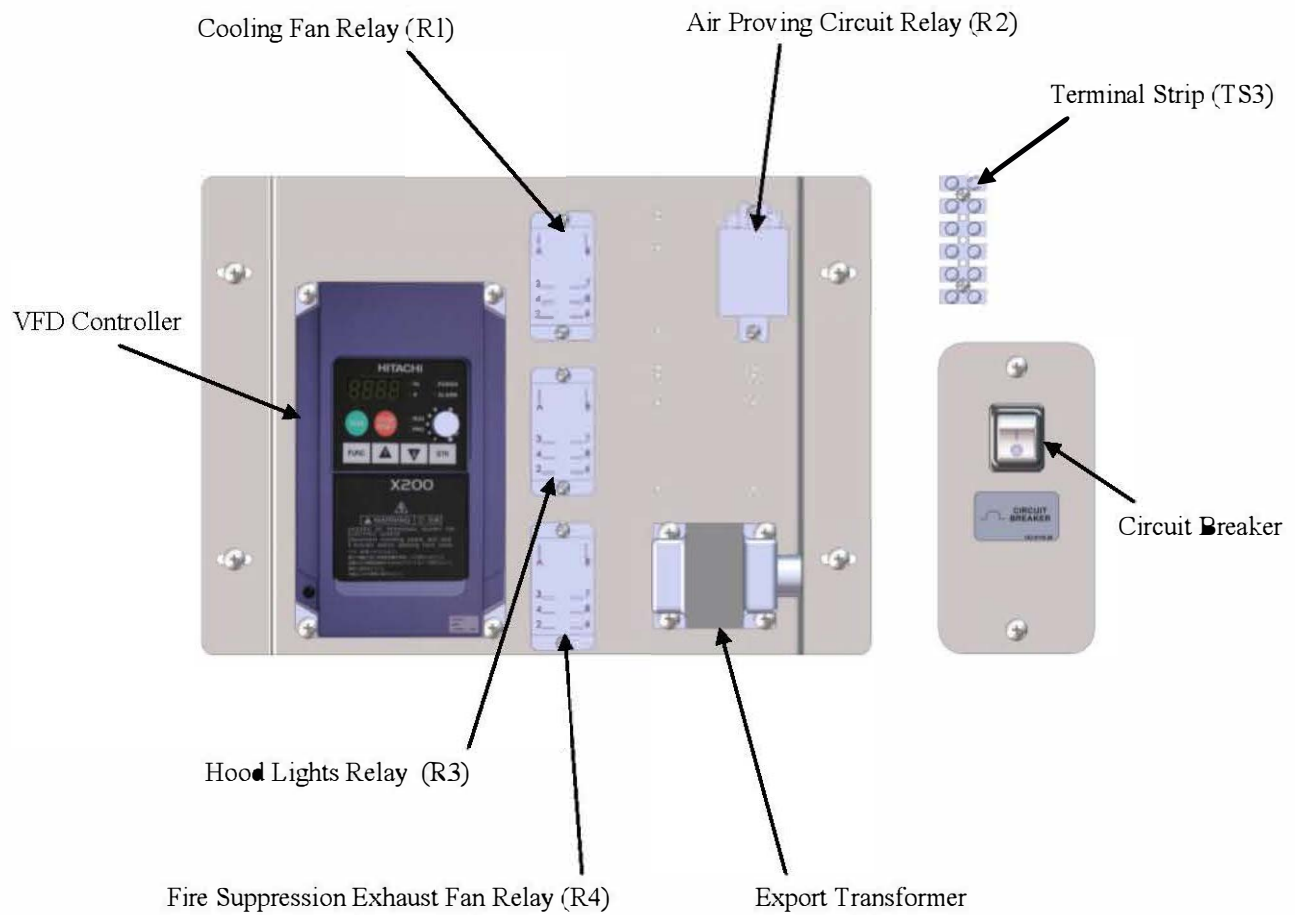
VFD Control Box (Cover removed)



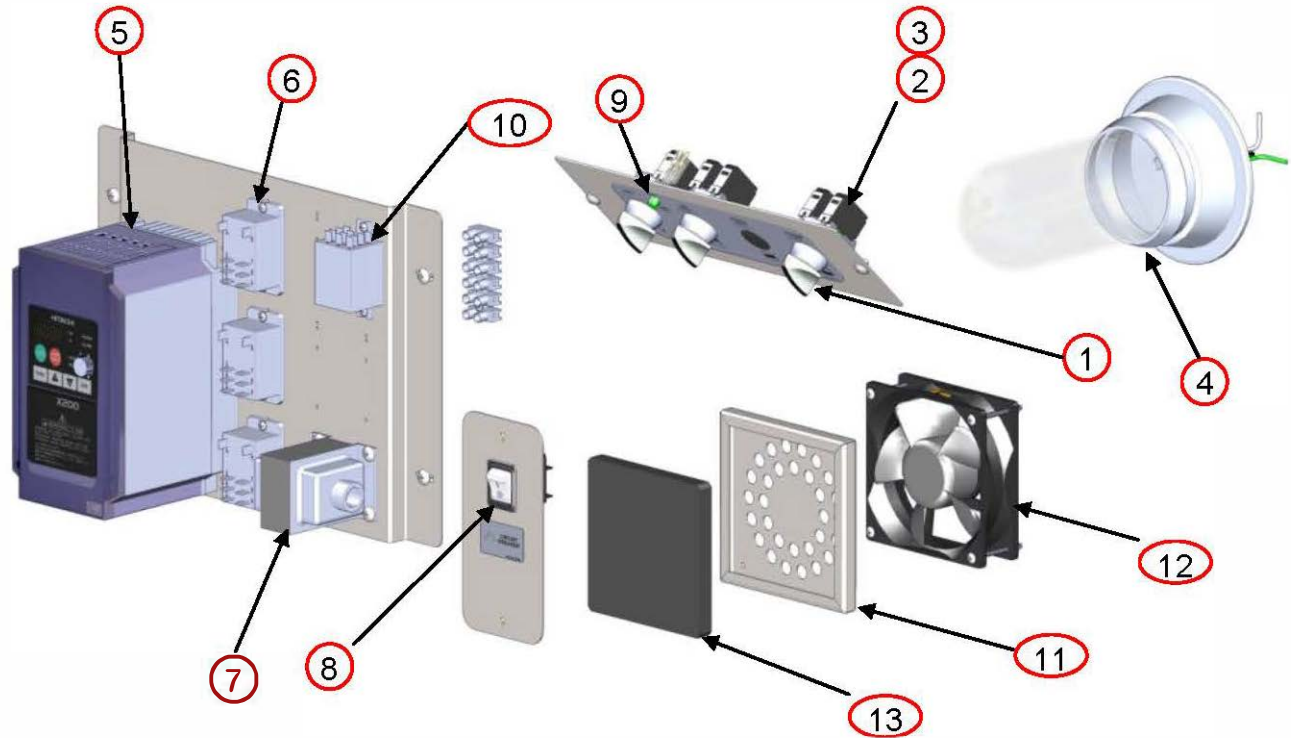
VFD			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4101	Switch Operator	\$21.40
2	XP 4102	Contact Block 1 Pole w/Mount	\$21.40
3	XP 4102-C	Contact Block 1 Pole	\$16.30
4	HP 1251	Light Assembly	\$57.80
5	HP-2051	VFD Hitachi X200-007NFU	\$198.30
6	HP-2056A	W9A Minature Power Relay	\$13.70
7	HP-2060-S	Circuit Breaker Exhaust Fan	\$52.30
8	HP-2061	Current Sensing Light	\$35.10
9	SP 4520-GA	Fan Guard / Filter Repl Kit GA	\$5.60
10	XP 4501-S	FPPG Fan Standard M2	\$36.20
11	XP 4520-GA	Fan Filter	\$1.95

VFD Control Box Back information required:

- Size of Oven
- Voltage

VFD Control Box w/Fire Suppression

VFD Control Box (Cover removed)

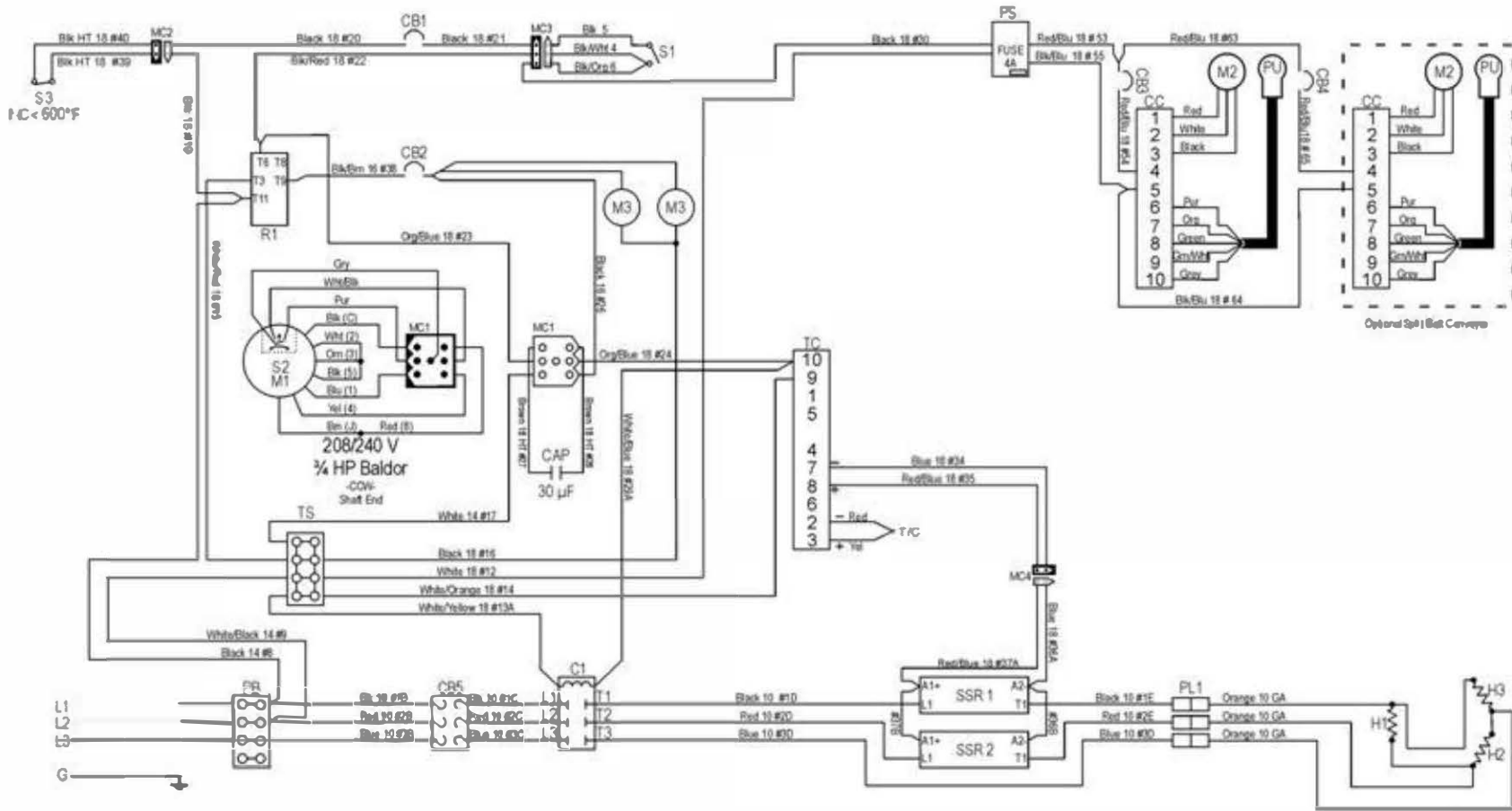


VFD			
ITEM	PART NUMBER	DESCRIPTION	YOUR PRICE
1	XP 4101	Switch Operator	\$21.40
2	XP 4102	Contact Block 1 Pole w/Mount	\$21.40
3	XP 4102-C	Contact Block 1 Pole	\$16.30
4	HP 1251	Light Assembly	\$57.80
5	HP-2051	VFD Hitachi X200-007NFU	\$198.30
6	HP-2055A-W	Relay 8 Pin 3A	\$21.30
7	HP-2059	24vac 40va Transformer	\$55.70
8	HP-2060-W	Circuit Breaker Exhaust Fan	\$52.30
9	HP-2061	Current Sensing Light	\$35.10
10	HP-2065-W	Relay 11 Pin 20A	\$40.00
11	SP 4520-GA	Fan Guard / Filter Repl Kit GA	\$5.60
12	XP 4501-W	FPPG Fan Standard M2	\$33.70
13	XP 4520-GA	Fan Filter	\$1.95

VFD Control Box Back information required:

- Size of Oven
- Voltage

1832-EL Standard 208/240 VAC



C1 - CONTACTOR, 50 AMP
CAP - CAPACITOR, 30 μ
CB1 - CIRCUIT BREAKER, 2 AMP
CB2 - CIRCUIT BREAKER, 10 AMP
CB3 - CIRCUIT BREAKER, 1 AMP
CB4 - CIRCUIT BREAKER, 1 AMP
CB5 - CIRCUIT BREAKER, 63 AMP
CC - CONVEYOR CONTROL

H1 - HEATING ELEMENT, 208 VAC OR 240 VAC, 5300 W
H2 - HEATING ELEMENT, 208 VAC OR 240 VAC, 5300 W
H3 - HEATING ELEMENT, 208 VAC OR 240 VAC, 5300 W
M1 - MOTOR, OVEN FAN
M2 - MOTOR, CONVEYOR
M3 - MOTOR, COOLING FAN
MC1 - MOLEX CONNECTOR 9 PIN, OVEN FAN
MC2 - MOLEX CONNECTOR 2 PIN, HIGH LIMIT

MC3 - MOLEX CONNECTOR 3 PIN, MAIN SWITCH
MC4 - MOLEX CONNECTOR 2 PIN, SSR
PS - POWER BLOCK
PL1 - PUSH LOCK 1-3 ELEMENTS
PS - POWER SUPPLY 24 VDC
PU - CONVEYOR MOTOR PICK-UP
R1 - RELAY-COOL-DOWN TIMER

S1 - SWITCH, MAIN
S2 - SWITCH, CENTRIFUGAL
S3 - SWITCH, HIGH LIMIT
SSR1 - SOLID STATE RELAY, 50 AMP
SSR2 - SOLID STATE RELAY, 50 AMP
T/C - THERMOCOUPLE
TC - TEMPERATURE CONTROL
TS - TERMINAL STRIP

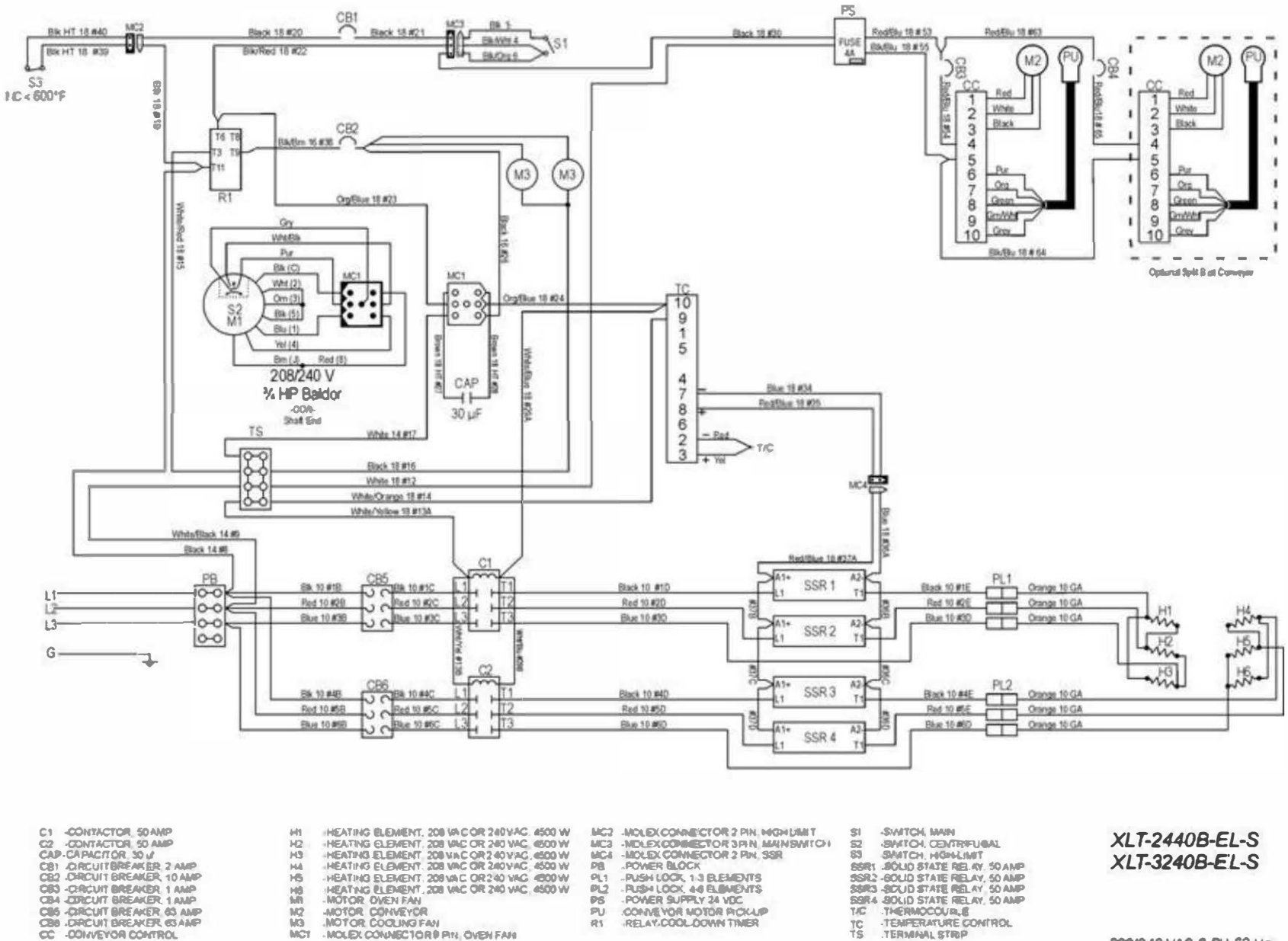
XLT-1832B-EL-S

208/240 VAC 3 PH 60 Hz
XD-9130B-208/240-5300-3
05/07/2012

OVEN SCHEMATIC - STANDARD

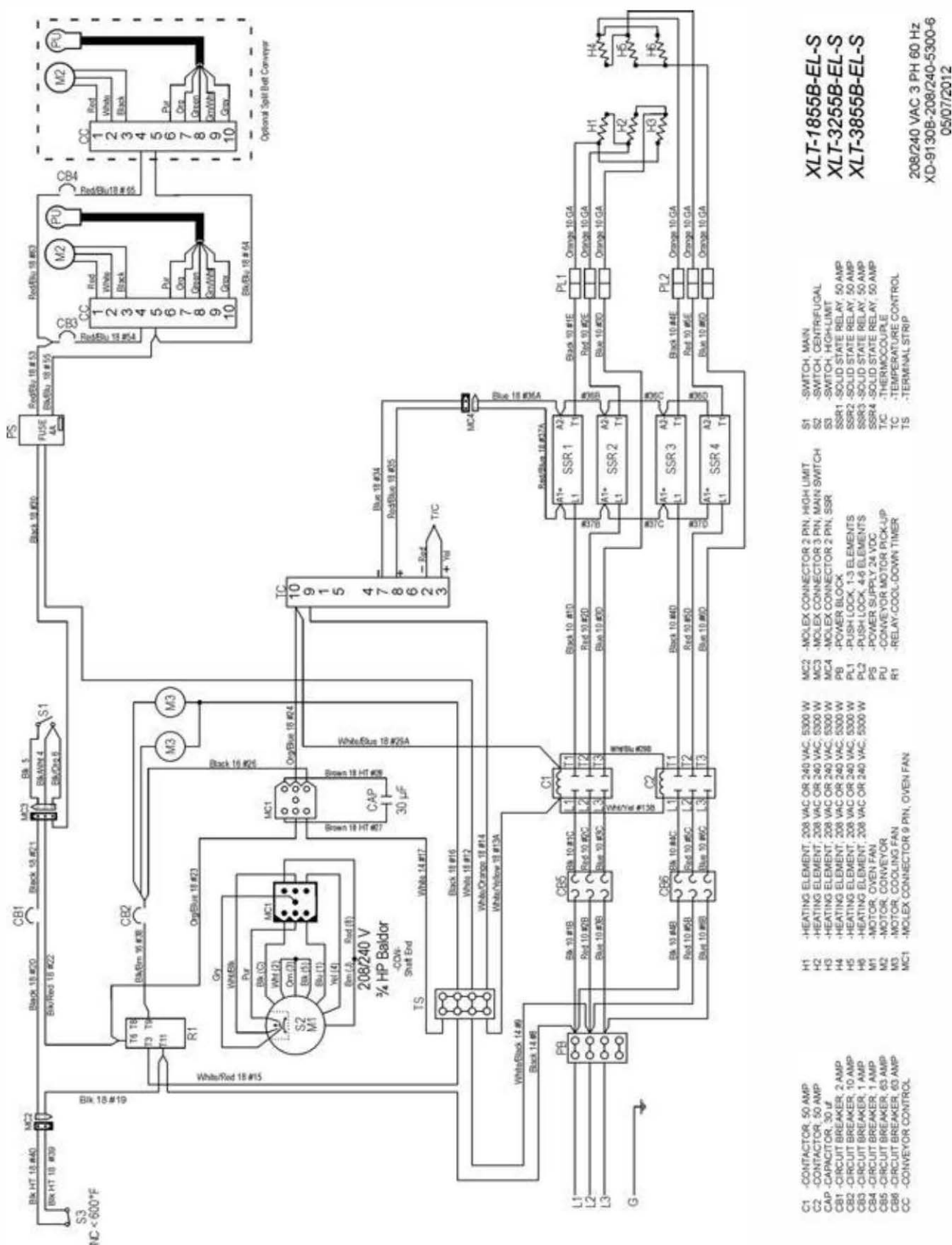
2440-EL, 3240-EL Standard 208/240 VAC

51



XLT-2440B-EL-S
XLT-3240B-EL-S

208/240 VAC 3 PH 60 Hz
XD-91308-208/240-4500-6
05/07/2012



XLT-1855B-EL-S
XLT-3255B-EL-S
XLT-3855B-EL-S

208/240 VAC 3 PH 60 Hz
XD-9130B-208/240-5300-6
05/07/2012

- S1 -SWITCH, MAIN
- S2 -SWITCH, CENTRIFUGAL
- S3 -SWITCH, HIGH-LIMIT
- SSR1 -SOLID STATE RELAY, 50 AMP
- SSR2 -SOLID STATE RELAY, 50 AMP
- SSR3 -SOLID STATE RELAY, 50 AMP
- SSR4 -SOLID STATE RELAY, 50 AMP
- TIC -THERMOCOUPLE
- TC -TEMPERATURE CONTROL
- TS -THERMAL STRIP

- MC2 -MOLEX CONNECTOR 2 PIN, HIGH LIMIT
- MC3 -MOLEX CONNECTOR 3 PIN, MAIN SWITCH
- MC4 -MOLEX CONNECTOR 2 PIN, SSR
- MC5 -MOLEX CONNECTOR 2 PIN, SSR
- PB -POWER BLOCK
- PL1 -PUSH LOCK 1,3 ELEMENTS
- PL2 -PUSH LOCK 4,6 ELEMENTS
- PPS -POWER SUPPLY 24 VDC
- PPU -CONVEYER MOTOR PICK-UP
- RT1 -RELAY-COOL-DOWN TIMER

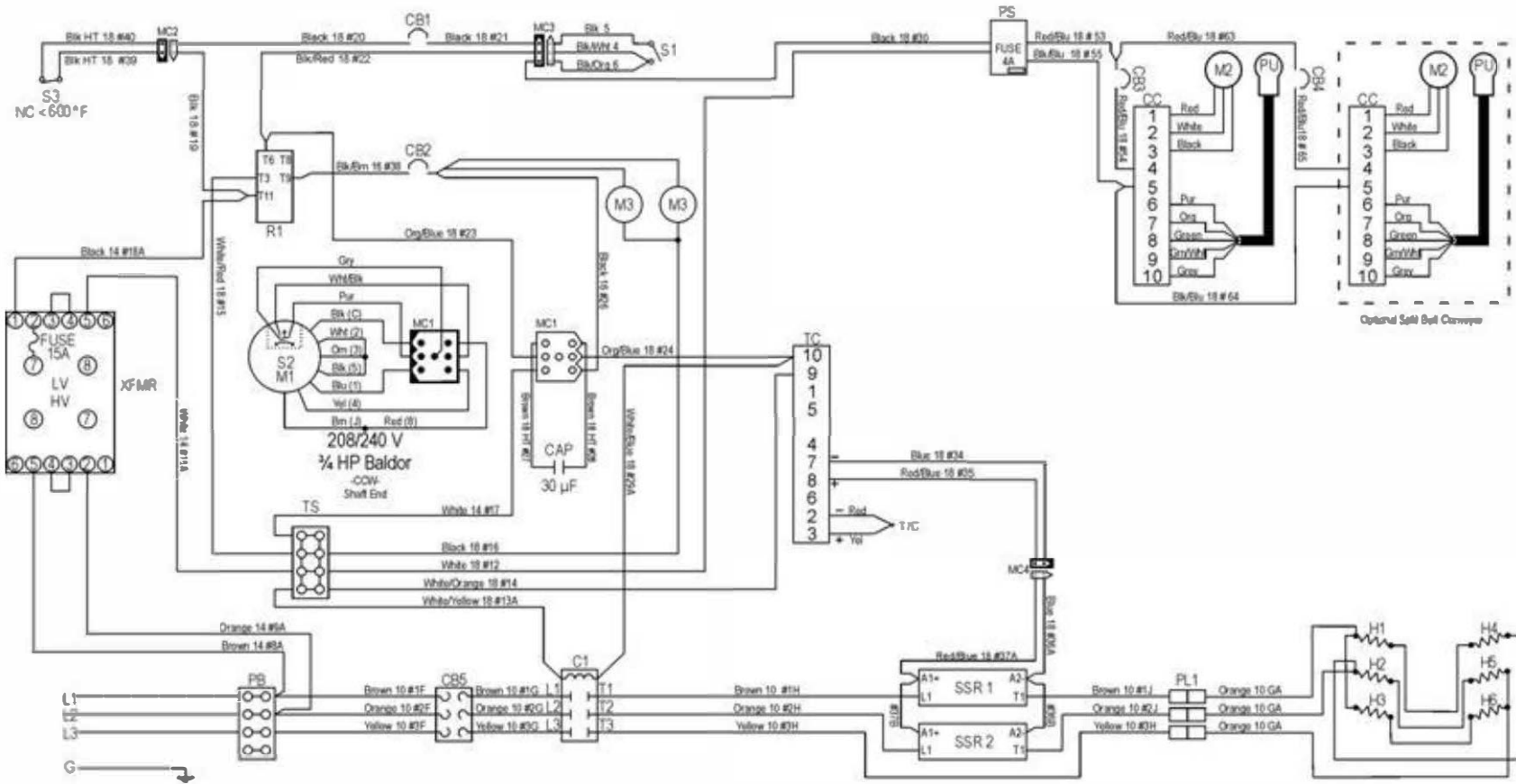
H1	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
H2	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
H3	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
H4	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
H5	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
H6	-HEATING ELEMENT, 208 VAC OR 240 VAC, 5500 W
M1	-MOTOR, OVER FAN
M2	-MOTOR, CONVEYOR
M3	-MOTOR, COOLING FAN
MCT	-MOLEX CONNECTOR 9 PIN, OVER FAN

C1 - CONTACTOR, 50 AMP
C2 - CONTACTOR, 50 AMP
CAP - CAPACITOR, 30 μ
CB1 - CIRCUIT BREAKER, 2 AMP
CB2 - CIRCUIT BREAKER, 10 AMP
CB3 - CIRCUIT BREAKER, 1 AMP
CB4 - CIRCUIT BREAKER, 1 AMP
CB5 - CIRCUIT BREAKER, 63 AMP
CB6 - CIRCUIT BREAKER, 63 AMP
C - CONVEYOR CONTROL

OVEN SCHEMATIC - STANDARD

2440-EL, 3240-EL Standard 480 VAC

53



C1 - CONTACTOR, 50 AMP
CAP - CAPACITOR, 30 µF
CB1 - CIRCUIT BREAKER, 2 AMP
CB2 - CIRCUIT BREAKER, 10 AMP
CB3 - CIRCUIT BREAKER, 1 AMP
CB4 - CIRCUIT BREAKER, 1 AMP
CB5 - CIRCUIT BREAKER, 63 AMP
CC - CONVEYOR CONTROL

H1 - HEATING ELEMENT, 240VAC, 4500 W
H2 - HEATING ELEMENT, 240 VAC, 4500 W
H3 - HEATING ELEMENT, 240VAC, 4500 W
H4 - HEATING ELEMENT, 240VAC, 4500 W
H5 - HEATING ELEMENT, 240 VAC, 4500 W
H6 - HEATING ELEMENT, 240VAC, 4500 W
M1 - MOTOR, OVEN FAN
M2 - MOTOR, CONVEYOR
M3 - MOTOR, COOLING FAN

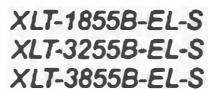
MC1 - MOLEX CONNECTOR 9 PIN, OVEN FAN
MC2 - MOLEX CONNECTOR 2 PIN, HIGH LIMIT
MC3 - MOLEX CONNECTOR 3 PIN, MAIN SWITCH
MC4 - MOLEX CONNECTOR 2 PIN, SSR
PB - POWER BLOCK
RL1 - PUSH LOCK, 1-3 ELEMENTS
PS - POWER SUPPLY 24 VDC
PU - CONVEYOR MOTOR PICK-UP
RT - RELAY, COOL DOWN TIMER

S1 - SWITCH, MAIN
S2 - SWITCH, CENTRIFUGAL
SS - SWITCH, HIGH-LIMIT
SSR1 - SOLID STATE RELAY, 50 AMP
SSR2 - SOLID STATE RELAY, 50 AMP
T/C - THERMOCOUPLE
TC - TEMPERATURE CONTROL
TS - TERMINAL STRIP
XFMR - TRANSFORMER, 240 VAC

XLT-2440B-EL-S
XLT-3240B-EL-S

480 VAC 3 PH 60 Hz
XD-9130B-480-4500-6
05/07/2012

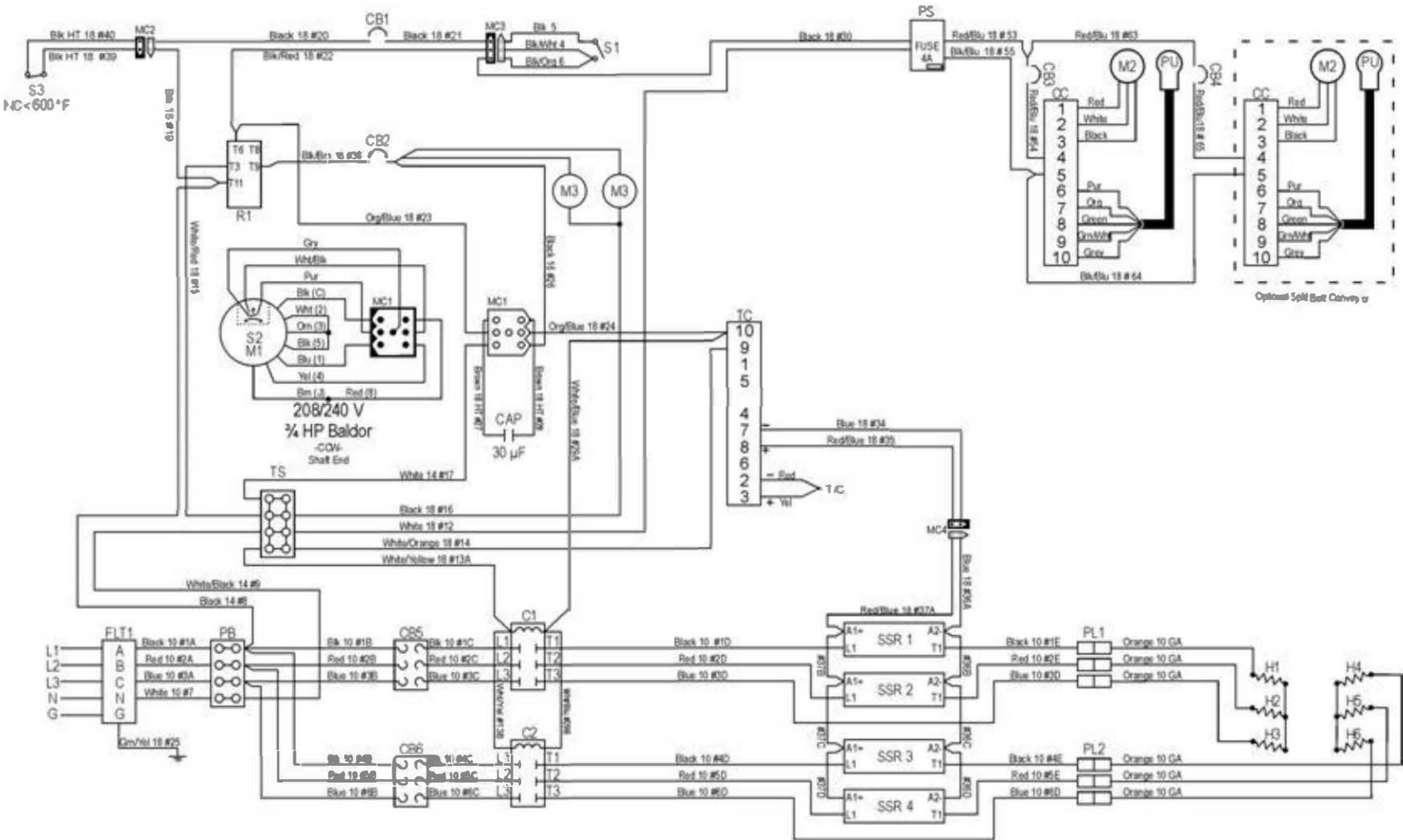
1855-EL, 3255-EL, 3855-EL Standard 480 VAC



480 VAC 3 PH 60 Hz
XD-9130B-480-5300-B
05/07/2012

- | | | | | | | | |
|-----|-------------------------|----|----------------------------------|------|------------------------------------|------|---------------------------|
| C1 | CONTACTOR, 90 AMP | H1 | HEATING ELEMENT, 240 VAC, 5300 W | MC1 | MOLEX CONNECTOR 2 PIN, OVEN FAN | S1 | SWITCH, MAIN |
| CAP | CAPACITOR, 30 uF | H2 | HEATING ELEMENT, 240 VAC, 5300 W | MC2 | MOLEX CONNECTOR 2 PIN, HIGH LIMIT | S2 | SWITCH, CENTRIFUGAL |
| C81 | CIRCUIT BREAKER, 2 AMP | H3 | HEATING ELEMENT, 240 VAC, 5300 W | MC3 | MOLEX CONNECTOR 3 PIN, MAIN SWITCH | S3 | SWITCH, HIGH-LIMIT |
| C82 | CIRCUIT BREAKER, 10 AMP | H4 | HEATING ELEMENT, 240 VAC, 5300 W | MC4 | MOLEX CONNECTOR 2 PIN, SSR | SSR1 | SOLID STATE RELAY, 50 AMP |
| C83 | CIRCUIT BREAKER, 1 AMP | H5 | HEATING ELEMENT, 240 VAC, 5300 W | PB | PUSH BLOCK | SSR2 | SOLID STATE RELAY, 50 AMP |
| C84 | CIRCUIT BREAKER, 1 AMP | H6 | HEATING ELEMENT, 240 VAC, 5300 W | PL1 | PUSH LOCK, 1-3 ELEMENTS | TRC | THERMOCOUPLE |
| C85 | CIRCUIT BREAKER, 15 AMP | M1 | MOTOR, OVEN FAN | PL2 | PUSH LOCK, 2 ELEMENTS | TR1 | TEMPERATURE CONTROL |
| C86 | CONVEYOR CONTROL | M2 | MOTOR, CONVEYOR | PL3 | PUSH LOCK, 3 ELEMENTS | TR2 | TEMPERATURE CONTROL |
| | | M3 | MOTOR, COOLING FAN | PL4 | PUSH LOCK, 4 ELEMENTS | TR3 | TEMPERATURE CONTROL |
| | | | | PL5 | PUSH LOCK, 5 ELEMENTS | TR4 | TEMPERATURE CONTROL |
| | | | | PL6 | PUSH LOCK, 6 ELEMENTS | TR5 | TEMPERATURE CONTROL |
| | | | | PL7 | PUSH LOCK, 7 ELEMENTS | TR6 | TEMPERATURE CONTROL |
| | | | | PL8 | PUSH LOCK, 8 ELEMENTS | TR7 | TEMPERATURE CONTROL |
| | | | | PL9 | PUSH LOCK, 9 ELEMENTS | TR8 | TEMPERATURE CONTROL |
| | | | | PL10 | PUSH LOCK, 10 ELEMENTS | TR9 | TEMPERATURE CONTROL |
| | | | | PL11 | PUSH LOCK, 11 ELEMENTS | TR10 | TEMPERATURE CONTROL |
| | | | | PL12 | PUSH LOCK, 12 ELEMENTS | TR11 | TEMPERATURE CONTROL |
| | | | | PL13 | PUSH LOCK, 13 ELEMENTS | TR12 | TEMPERATURE CONTROL |
| | | | | PL14 | PUSH LOCK, 14 ELEMENTS | TR13 | TEMPERATURE CONTROL |
| | | | | PL15 | PUSH LOCK, 15 ELEMENTS | TR14 | TEMPERATURE CONTROL |
| | | | | PL16 | PUSH LOCK, 16 ELEMENTS | TR15 | TEMPERATURE CONTROL |
| | | | | PL17 | PUSH LOCK, 17 ELEMENTS | TR16 | TEMPERATURE CONTROL |
| | | | | PL18 | PUSH LOCK, 18 ELEMENTS | TR17 | TEMPERATURE CONTROL |
| | | | | PL19 | PUSH LOCK, 19 ELEMENTS | TR18 | TEMPERATURE CONTROL |
| | | | | PL20 | PUSH LOCK, 20 ELEMENTS | TR19 | TEMPERATURE CONTROL |
| | | | | PL21 | PUSH LOCK, 21 ELEMENTS | TR20 | TEMPERATURE CONTROL |
| | | | | PL22 | PUSH LOCK, 22 ELEMENTS | TR21 | TEMPERATURE CONTROL |
| | | | | PL23 | PUSH LOCK, 23 ELEMENTS | TR22 | TEMPERATURE CONTROL |
| | | | | PL24 | PUSH LOCK, 24 ELEMENTS | TR23 | TEMPERATURE CONTROL |
| | | | | PL25 | PUSH LOCK, 25 ELEMENTS | TR24 | TEMPERATURE CONTROL |
| | | | | PL26 | PUSH LOCK, 26 ELEMENTS | TR25 | TEMPERATURE CONTROL |
| | | | | PL27 | PUSH LOCK, 27 ELEMENTS | TR26 | TEMPERATURE CONTROL |
| | | | | PL28 | PUSH LOCK, 28 ELEMENTS | TR27 | TEMPERATURE CONTROL |
| | | | | PL29 | PUSH LOCK, 29 ELEMENTS | TR28 | TEMPERATURE CONTROL |
| | | | | PL30 | PUSH LOCK, 30 ELEMENTS | TR29 | TEMPERATURE CONTROL |
| | | | | PL31 | PUSH LOCK, 31 ELEMENTS | TR30 | TEMPERATURE CONTROL |
| | | | | PL32 | PUSH LOCK, 32 ELEMENTS | TR31 | TEMPERATURE CONTROL |
| | | | | PL33 | PUSH LOCK, 33 ELEMENTS | TR32 | TEMPERATURE CONTROL |
| | | | | PL34 | PUSH LOCK, 34 ELEMENTS | TR33 | TEMPERATURE CONTROL |
| | | | | PL35 | PUSH LOCK, 35 ELEMENTS | TR34 | TEMPERATURE CONTROL |
| | | | | PL36 | PUSH LOCK, 36 ELEMENTS | TR35 | TEMPERATURE CONTROL |
| | | | | PL37 | PUSH LOCK, 37 ELEMENTS | TR36 | TEMPERATURE CONTROL |
| | | | | PL38 | PUSH LOCK, 38 ELEMENTS | TR37 | TEMPERATURE CONTROL |
| | | | | PL39 | PUSH LOCK, 39 ELEMENTS | TR38 | TEMPERATURE CONTROL |
| | | | | PL40 | PUSH LOCK, 40 ELEMENTS | TR39 | TEMPERATURE CONTROL |
| | | | | PL41 | PUSH LOCK, 41 ELEMENTS | TR40 | TEMPERATURE CONTROL |
| | | | | PL42 | PUSH LOCK, 42 ELEMENTS | TR41 | TEMPERATURE CONTROL |
| | | | | PL43 | PUSH LOCK, 43 ELEMENTS | TR42 | TEMPERATURE CONTROL |
| | | | | PL44 | PUSH LOCK, 44 ELEMENTS | TR43 | TEMPERATURE CONTROL |
| | | | | PL45 | PUSH LOCK, 45 ELEMENTS | TR44 | TEMPERATURE CONTROL |
| | | | | PL46 | PUSH LOCK, 46 ELEMENTS | TR45 | TEMPERATURE CONTROL |
| | | | | PL47 | PUSH LOCK, 47 ELEMENTS | TR46 | TEMPERATURE CONTROL |
| | | | | PL48 | PUSH LOCK, 48 ELEMENTS | TR47 | TEMPERATURE CONTROL |
| | | | | PL49 | PUSH LOCK, 49 ELEMENTS | TR48 | TEMPERATURE CONTROL |
| | | | | PL50 | PUSH LOCK, 50 ELEMENTS | TR49 | TEMPERATURE CONTROL |
| | | | | PL51 | PUSH LOCK, 51 ELEMENTS | TR50 | TEMPERATURE CONTROL |
| | | | | PL52 | PUSH LOCK, 52 ELEMENTS | TR51 | TEMPERATURE CONTROL |
| | | | | PL53 | PUSH LOCK, 53 ELEMENTS | TR52 | TEMPERATURE CONTROL |
| | | | | PL54 | PUSH LOCK, 54 ELEMENTS | TR53 | TEMPERATURE CONTROL |
| | | | | PL55 | PUSH LOCK, 55 ELEMENTS | TR54 | TEMPERATURE CONTROL |
| | | | | PL56 | PUSH LOCK, 56 ELEMENTS | TR55 | TEMPERATURE CONTROL |
| | | | | PL57 | PUSH LOCK, 57 ELEMENTS | TR56 | TEMPERATURE CONTROL |
| | | | | PL58 | PUSH LOCK, 58 ELEMENTS | TR57 | TEMPERATURE CONTROL |
| | | | | PL59 | PUSH LOCK, 59 ELEMENTS | TR58 | TEMPERATURE CONTROL |
| | | | | | | | |

1855-EL, 3255-EL, 3855-EL World 380 VAC



C1 - CONTACTOR 30 AMP
C2 - CONTACTOR 30 AMP
CAP - CAPACITOR 30 uF
CB1 - CIRCUIT BREAKER 2 AMP
CB2 - CIRCUIT BREAKER 10 AMP
CB3 - CIRCUIT BREAKER 1 AMP
CB4 - CIRCUIT BREAKER 1 AMP
CB5 - CIRCUIT BREAKER 3 AMP
CB6 - CIRCUIT BREAKER 3 AMP
CB7 - CIRCUIT BREAKER 3 AMP
CB8 - CIRCUIT BREAKER 3 AMP
CB9 - CIRCUIT BREAKER 3 AMP
CB10 - CIRCUIT BREAKER 3 AMP
CB11 - CIRCUIT BREAKER 3 AMP
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CB91 - CIRCUIT BREAKER 3 AMP
CB92 - CIRCUIT BREAKER 3 AMP
CB93 - CIRCUIT BREAKER 3 AMP
CB94 - CIRCUIT BREAKER 3 AMP
CB95 - CIRCUIT BREAKER 3 AMP
CB96 - CIRCUIT BREAKER 3 AMP
CB97 - CIRCUIT BREAKER 3 AMP
CB98 - CIRCUIT BREAKER 3 AMP
CB99 - CIRCUIT BREAKER 3 AMP
CB100 - CIRCUIT BREAKER 3 AMP

PLT2 - FILTER CONTROL VOLTAGE
H1 - HEATING ELEMENT 240VAC 5300 W
H2 - HEATING ELEMENT 240VAC 5300 W
H3 - HEATING ELEMENT 240VAC 5300 W
H4 - HEATING ELEMENT 240VAC 5300 W
H5 - HEATING ELEMENT 240VAC 5300 W
H6 - HEATING ELEMENT 240VAC 5300 W
H7 - HEATING ELEMENT 240VAC 5300 W
H8 - HEATING ELEMENT 240VAC 5300 W
H9 - HEATING ELEMENT 240VAC 5300 W
H10 - HEATING ELEMENT 240VAC 5300 W
H11 - HEATING ELEMENT 240VAC 5300 W
H12 - HEATING ELEMENT 240VAC 5300 W
H13 - HEATING ELEMENT 240VAC 5300 W
H14 - HEATING ELEMENT 240VAC 5300 W
H15 - HEATING ELEMENT 240VAC 5300 W
H16 - HEATING ELEMENT 240VAC 5300 W
H17 - HEATING ELEMENT 240VAC 5300 W
H18 - HEATING ELEMENT 240VAC 5300 W
H19 - HEATING ELEMENT 240VAC 5300 W
H20 - HEATING ELEMENT 240VAC 5300 W
H21 - HEATING ELEMENT 240VAC 5300 W
H22 - HEATING ELEMENT 240VAC 5300 W
H23 - HEATING ELEMENT 240VAC 5300 W
H24 - HEATING ELEMENT 240VAC 5300 W
H25 - HEATING ELEMENT 240VAC 5300 W
H26 - HEATING ELEMENT 240VAC 5300 W
H27 - HEATING ELEMENT 240VAC 5300 W
H28 - HEATING ELEMENT 240VAC 5300 W
H29 - HEATING ELEMENT 240VAC 5300 W
H30 - HEATING ELEMENT 240VAC 5300 W
H31 - HEATING ELEMENT 240VAC 5300 W
H32 - HEATING ELEMENT 240VAC 5300 W
H33 - HEATING ELEMENT 240VAC 5300 W
H34 - HEATING ELEMENT 240VAC 5300 W
H35 - HEATING ELEMENT 240VAC 5300 W
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H46 - HEATING ELEMENT 240VAC 5300 W
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H48 - HEATING ELEMENT 240VAC 5300 W
H49 - HEATING ELEMENT 240VAC 5300 W
H50 - HEATING ELEMENT 240VAC 5300 W
H51 - HEATING ELEMENT 240VAC 5300 W
H52 - HEATING ELEMENT 240VAC 5300 W
H53 - HEATING ELEMENT 240VAC 5300 W
H54 - HEATING ELEMENT 240VAC 5300 W
H55 - HEATING ELEMENT 240VAC 5300 W
H56 - HEATING ELEMENT 240VAC 5300 W
H57 - HEATING ELEMENT 240VAC 5300 W
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H59 - HEATING ELEMENT 240VAC 5300 W
H60 - HEATING ELEMENT 240VAC 5300 W
H61 - HEATING ELEMENT 240VAC 5300 W
H62 - HEATING ELEMENT 240VAC 5300 W
H63 - HEATING ELEMENT 240VAC 5300 W
H64 - HEATING ELEMENT 240VAC 5300 W
H65 - HEATING ELEMENT 240VAC 5300 W
H66 - HEATING ELEMENT 240VAC 5300 W
H67 - HEATING ELEMENT 240VAC 5300 W
H68 - HEATING ELEMENT 240VAC 5300 W
H69 - HEATING ELEMENT 240VAC 5300 W
H70 - HEATING ELEMENT 240VAC 5300 W
H71 - HEATING ELEMENT 240VAC 5300 W
H72 - HEATING ELEMENT 240VAC 5300 W
H73 - HEATING ELEMENT 240VAC 5300 W
H74 - HEATING ELEMENT 240VAC 5300 W
H75 - HEATING ELEMENT 240VAC 5300 W
H76 - HEATING ELEMENT 240VAC 5300 W
H77 - HEATING ELEMENT 240VAC 5300 W
H78 - HEATING ELEMENT 240VAC 5300 W
H79 - HEATING ELEMENT 240VAC 5300 W
H80 - HEATING ELEMENT 240VAC 5300 W
H81 - HEATING ELEMENT 240VAC 5300 W
H82 - HEATING ELEMENT 240VAC 5300 W
H83 - HEATING ELEMENT 240VAC 5300 W
H84 - HEATING ELEMENT 240VAC 5300 W
H85 - HEATING ELEMENT 240VAC 5300 W
H86 - HEATING ELEMENT 240VAC 5300 W
H87 - HEATING ELEMENT 240VAC 5300 W
H88 - HEATING ELEMENT 240VAC 5300 W
H89 - HEATING ELEMENT 240VAC 5300 W
H90 - HEATING ELEMENT 240VAC 5300 W
H91 - HEATING ELEMENT 240VAC 5300 W
H92 - HEATING ELEMENT 240VAC 5300 W
H93 - HEATING ELEMENT 240VAC 5300 W
H94 - HEATING ELEMENT 240VAC 5300 W
H95 - HEATING ELEMENT 240VAC 5300 W
H96 - HEATING ELEMENT 240VAC 5300 W
H97 - HEATING ELEMENT 240VAC 5300 W
H98 - HEATING ELEMENT 240VAC 5300 W
H99 - HEATING ELEMENT 240VAC 5300 W
H100 - HEATING ELEMENT 240VAC 5300 W

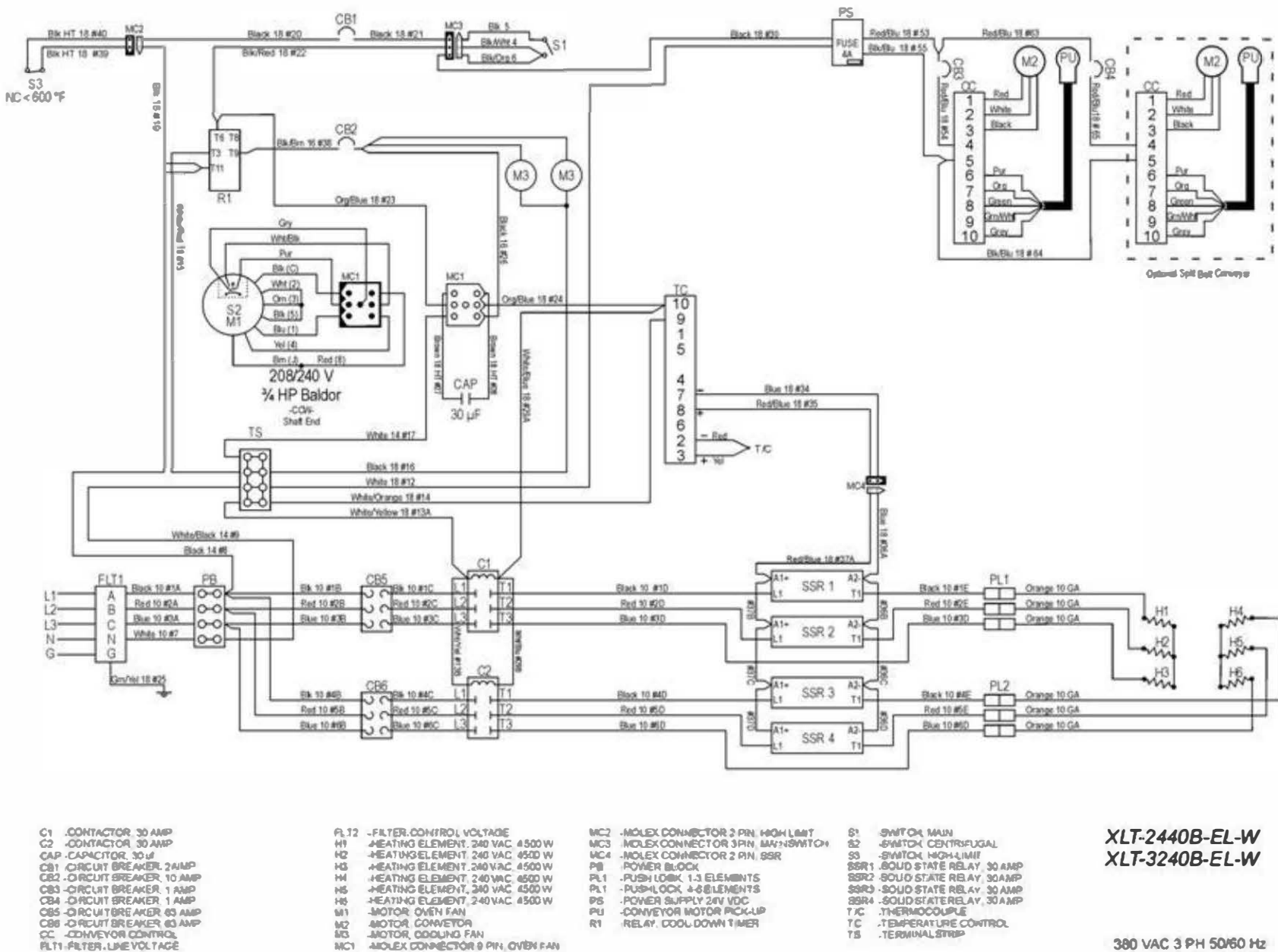
MC2 - MOLEX CONNECTOR OR 2 PIN HIGH LIMIT
MC3 - MOLEX CONNECTOR 3 PIN MAIN SWITCH
MC4 - MOLEX CONNECTOR 2 PIN SSR
PB - POWER BLOCK
PL1 - PUSH LOCK 1-3 ELEMENTS
PL2 - PUSH LOCK 4-6 ELEMENTS
PS - POWER SUPPLY 24 VDC
PU - CONVEYOR MOTOR PICK-UP
R1 - RELAY COOL-DOWN TIMER

S1 - SWITCH MAIN
S2 - SWITCH CENTRIFUGAL
S3 - SWITCH HIGH LIMIT
SSR1 - SOLID STATE RELAY 30 AMP
SSR2 - SOLID STATE RELAY 30 AMP
SSR3 - SOLID STATE RELAY 30 AMP
SSR4 - SOLID STATE RELAY 30 AMP
TC - THERMOCOUPLE
TS - THERMAL STRIP

XLT-1855B-EL-W
XLT-3255B-EL-W
XLT-3855B-EL-W

380 VAC 3 PH 50/60 Hz
XD-9130B-380-5300-6
05/07/2012

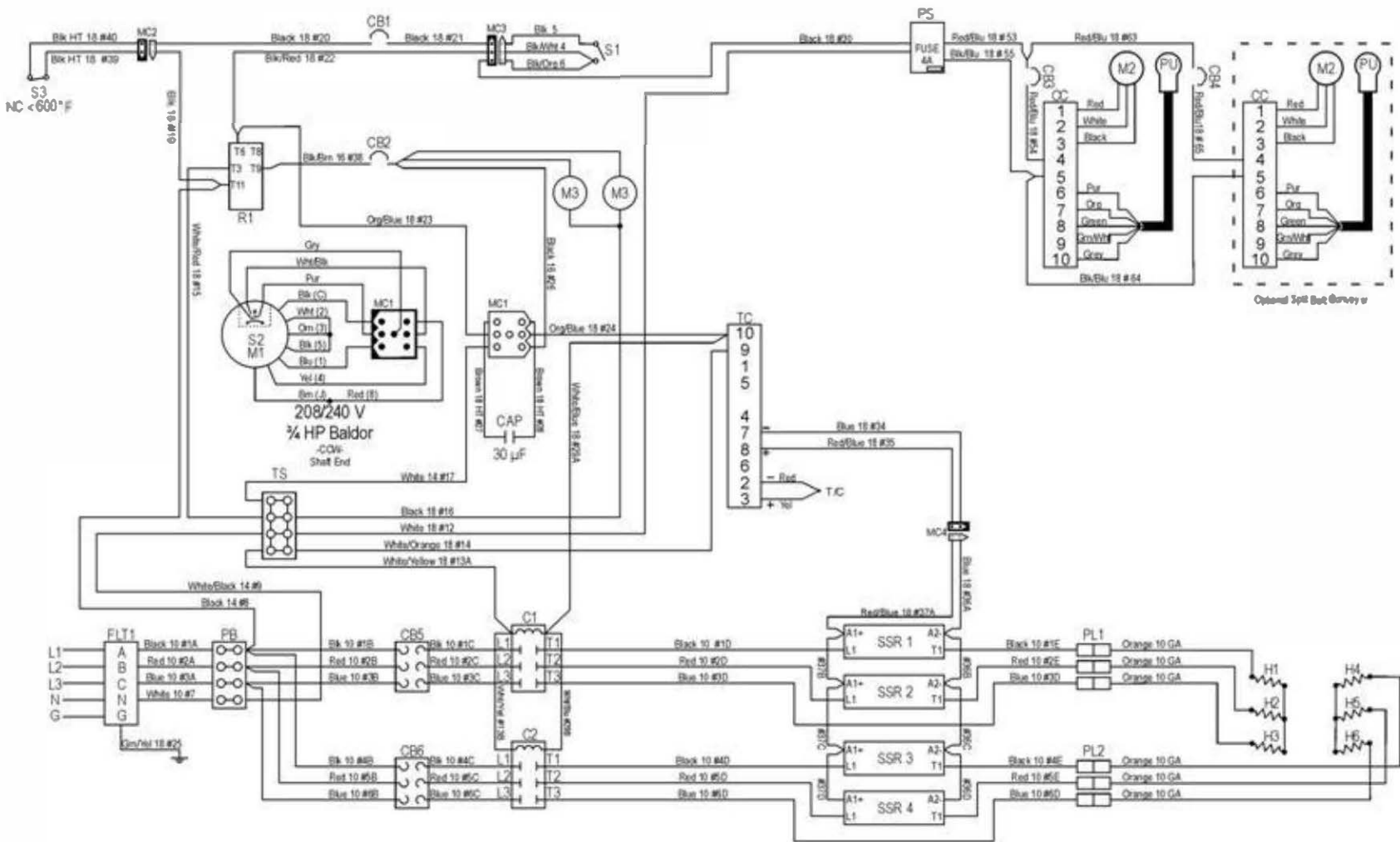
2440-EL, 3240-EL World 380 VAC



XLT-2440B-EL-W
XLT-3240B-EL-W

380 VAC 3 PH 50/60 Hz
 XD-91308-380-4500-6
 05/07/2012

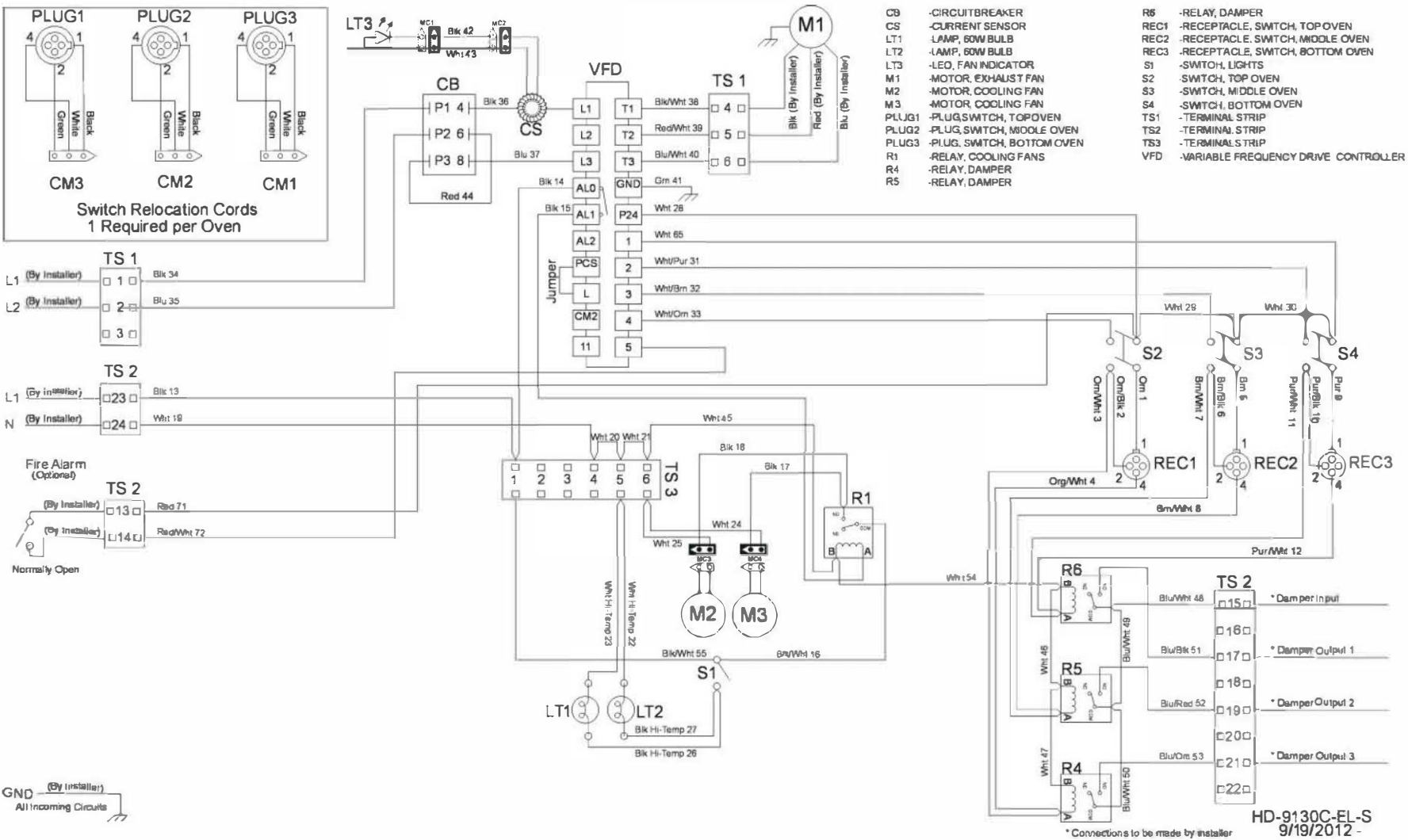
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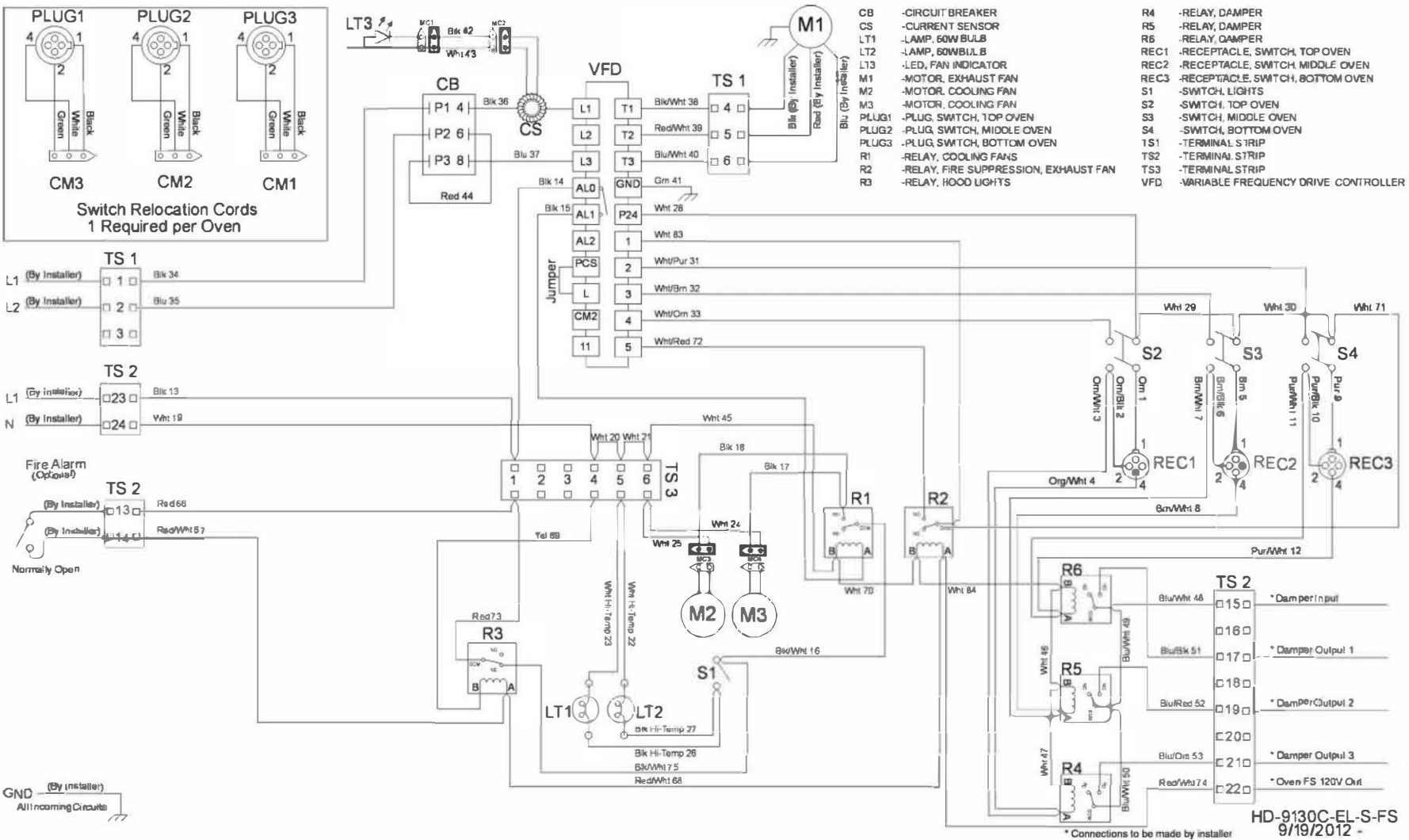


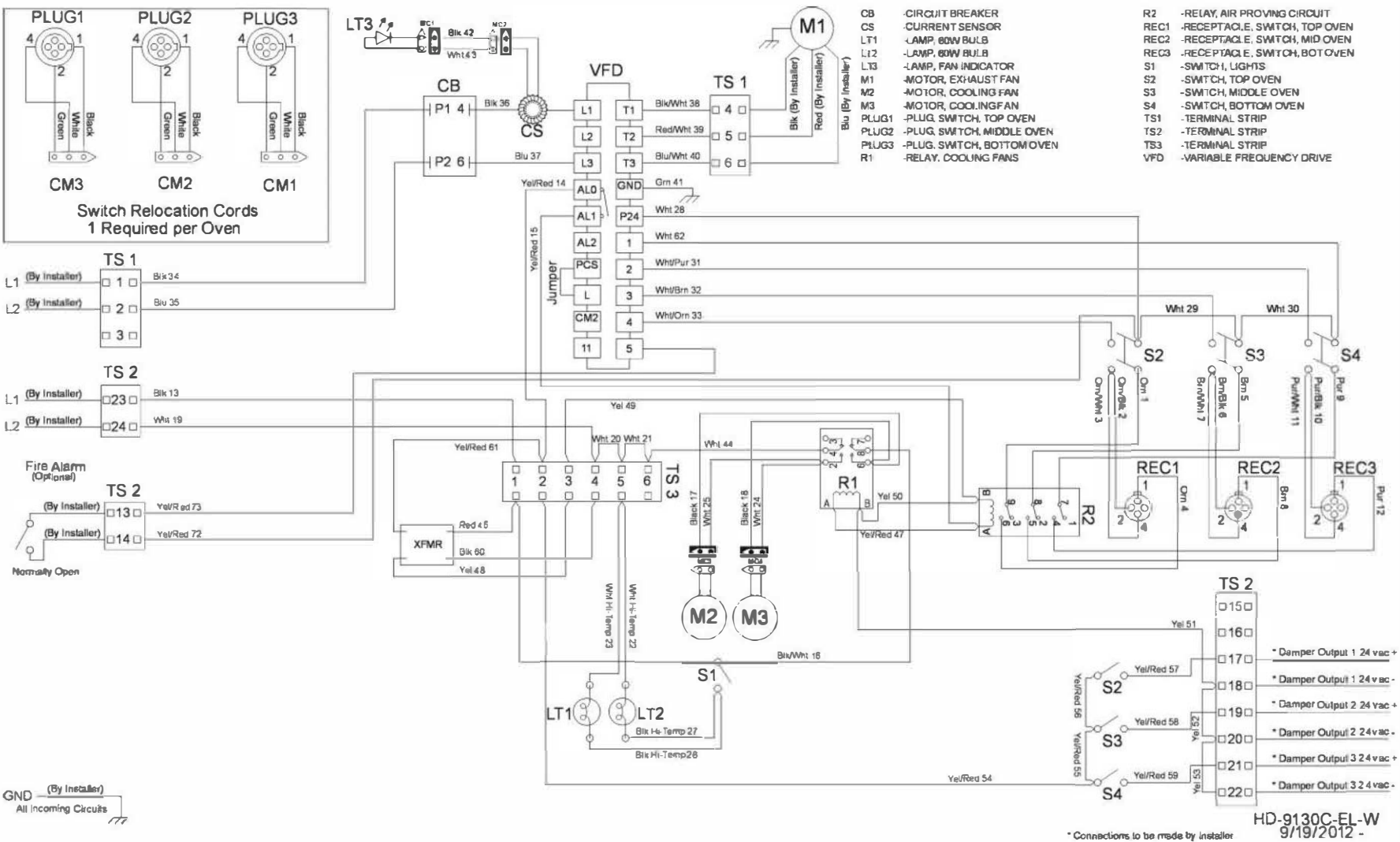
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XLT-3255B-EL-W
XLT-3855B-EL-W

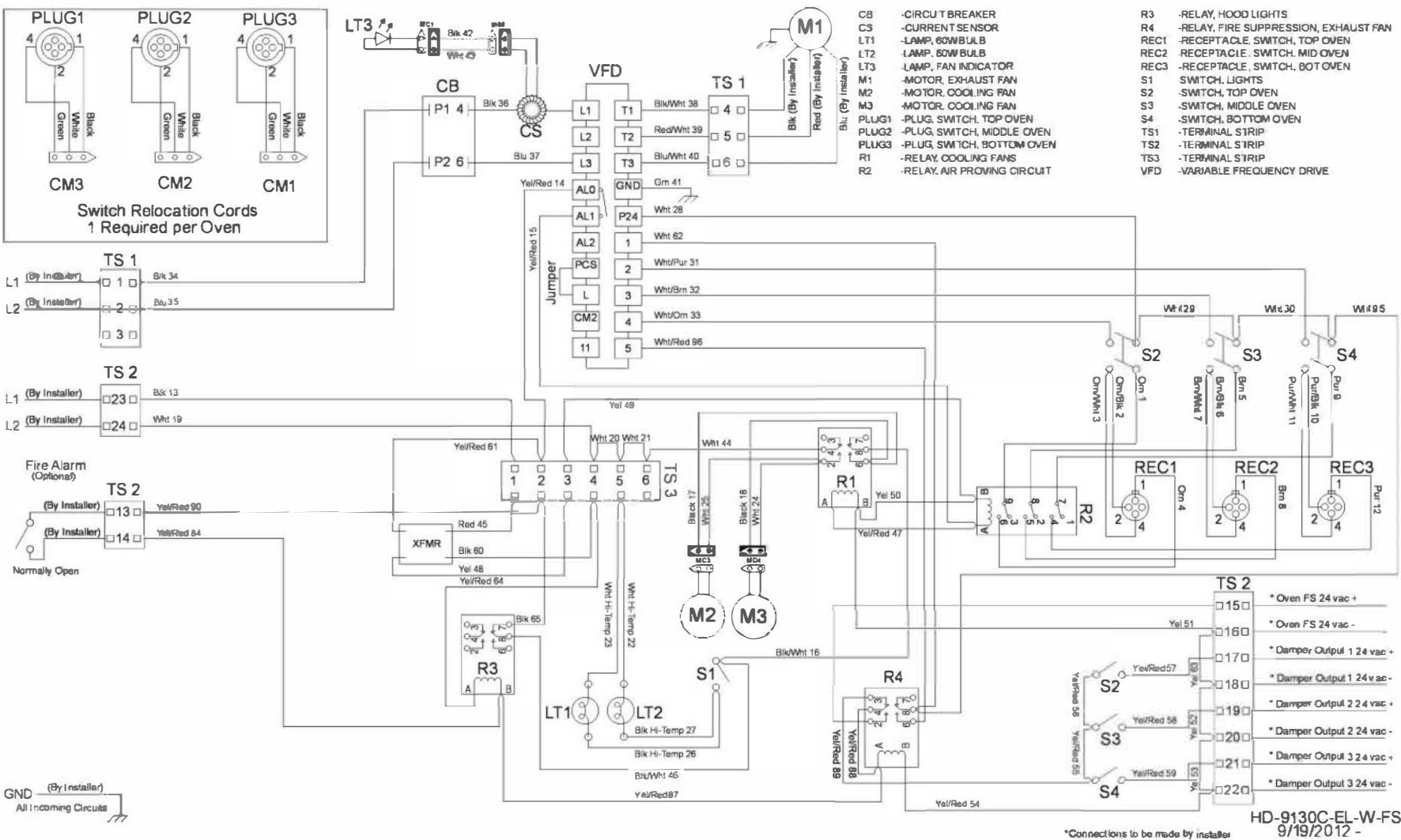
380 VAC 3 P H 50/60 Hz
XD-91308-380-5300-6
05/07/2012

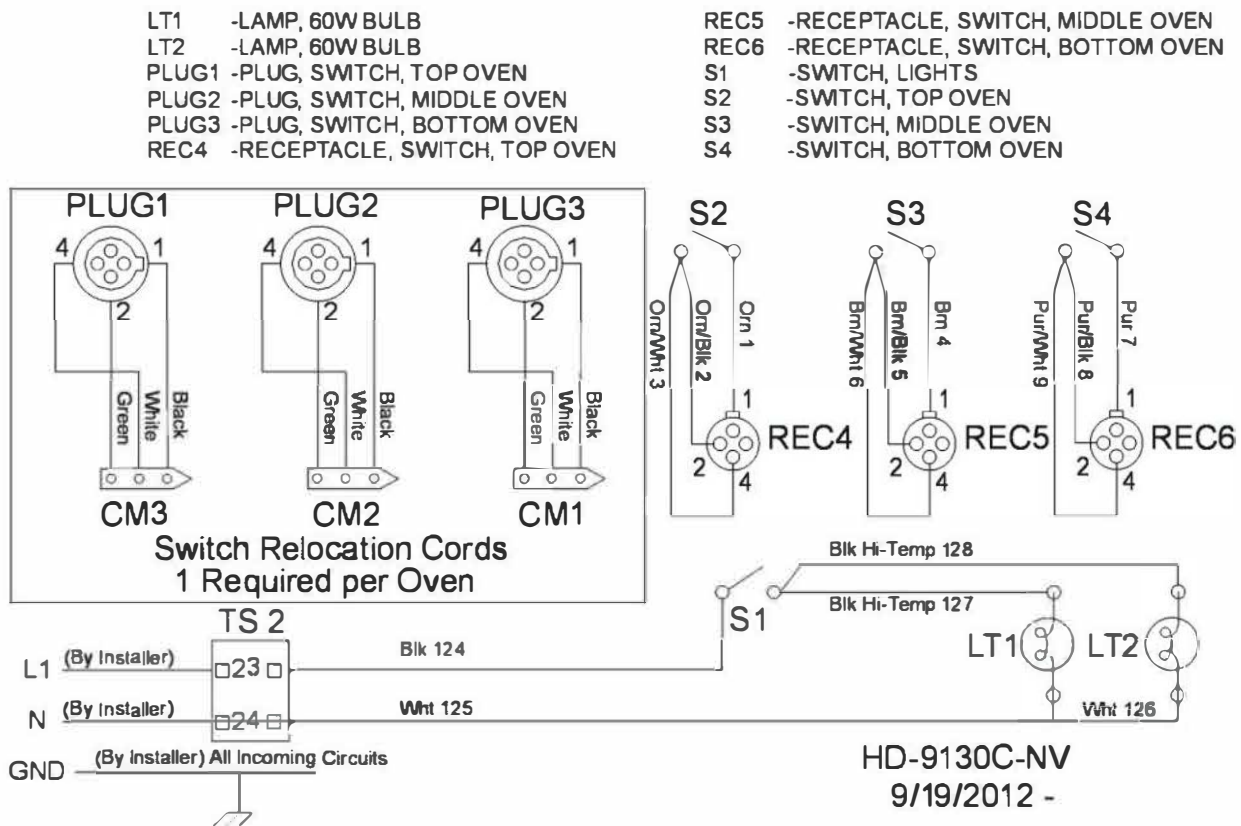
- | | | | | | | | |
|------|--------------------------|------|-----------------------------------|-----|-------------------------------------|------|----------------------------|
| C1 | -CONTACTOR, 30 AMP | FLT2 | -FILTER, CONTROL VOLTAGE | MC2 | -MOLEX CONNECTOR 3 PIN, HIGH LIMIT | S1 | -SWITCH, MAIN |
| C2 | -CONTACTOR, 30 AMP | H1 | -HEATING ELEMENT, 240 VAC, 5300 W | MC3 | -MOLEX CONNECTOR 3 PIN, MAIN SWITCH | S2 | -SWITCH, CENTRIFUGAL |
| CAP | -CAPACITOR, 30 uF | H2 | -HEATING ELEMENT, 240 VAC, 5300 W | MC4 | -MOLEX CONNECTOR 2 PIN, SSR | S3 | -SWITCH, HIGH LIMIT |
| CB1 | -CIRCUIT BREAKER, 2 AMP | H3 | -HEATING ELEMENT, 240 VAC, 5300 W | PB | -POWER BLOCK | SSR1 | -SOLID STATE RELAY, 30 AMP |
| CB2 | -CIRCUIT BREAKER, 10 AMP | H4 | -HEATING ELEMENT, 240 VAC, 5300 W | PL1 | -PUSH LOCK, 1-3 ELEMENTS | SSR2 | -SOLID STATE RELAY, 30 AMP |
| CB3 | -CIRCUIT BREAKER, 1 AMP | H5 | -HEATING ELEMENT, 240 VAC, 5300 W | PL1 | -PUSH LOCK, 4-6 ELEMENTS | SSR3 | -SOLID STATE RELAY, 30 AMP |
| CB4 | -CIRCUIT BREAKER, 1 AMP | H6 | -HEATING ELEMENT, 240 VAC, 5300 W | PS | -POWER SUPPLY, 1 VDC | SSR4 | -SOLID STATE RELAY, 30 AMP |
| CB5 | -CIRCUIT BREAKER, 63 AMP | M1 | -MOTOR, OVER FAN | P1 | -CONVEYOR MOTOR, PICK-UP | TC | -THERMOCOUPLE |
| CB6 | -CIRCUIT BREAKER, 63 AMP | M2 | -MOTOR, CONVEYOR | R1 | -RELAY, COOL-DOWN TIMER | TC | -TEMPERATURE CONTROL |
| CC | -CONVEYOR CONTROL | M3 | -MOTOR, COOLING FAN | | | TS | -THERMAL STRIP |
| FLT1 | -FILTER, LINE VOLTAGE | MC1 | -MOLEX CONNECTOR 9 PIN, OVEN FAN | | | | |











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Wichita, Kansas 67277

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