

INSTRUCTIONS:
**RETROFIT KIT FOR CONTROLLING A 115 VOLT, 50 HZ
ROLLER OVEN**

This kit is designed to replace all of the existing controls on a roller oven being operated on 115 volts, 50 HZ. The only electrical equipment to be left in place are the heaters and the motor driving the rollers.

To make the replacement:

1. Disconnect the oven from the power.
2. Remove any protective cover at the back of the old control box on the top of the oven.
3. Remove the screws holding the old control box to the top of the oven case. Use a short screwdriver or offset screwdriver.
4. Lift the control box to expose all the wiring. Trace the wires from the motor back to where they are connected to the fuse and to the power cord and cut at the connections. Then trace the wires from the heaters back to the old thermostat and to the power cord and disconnect or cut as required. This procedure is to leave these wires as long as possible.
5. Remove the old temperature sensor (or thermocouple) from the inside of the oven through the hole in the back wall.
6. Remove the old control box.
7. Set the new control box in place. Check the screw holes in the new control box and the top of the oven to be sure they match. If they do not match, mark the proper locations and drill new holes (clearance size for the screws in the control box, or thread size for the screw in the top of the oven case, if necessary).
8. Before screwing the control box to the oven, support it on the face to give access to the terminal strip at the back left edge of box looking at the back of the oven.
9. Connect the two wires from the motor to terminals A and B on the terminal strip using the crimp-on terminals provided. To install the terminals, the insulation on the wires must be stripped off about 3/8 of an inch (1 cm). If the wires are not long enough to reach the terminal strip, add an extra length of No. 14 wire insulated with high temperature material 600 deg. Or higher – using the butt connectors provided.

10. Although four wires are brought out from the heaters, they should be joined to 2 single wires, which were connected to the controls – one to the thermostat and one to the power switch or power cord so the heaters were connected in parallel. The two wires now are to be connected to terminals D and F with the crimp-on connectors provided, lengthening with #14 wire as required. If there is any question about the connections to the heaters, the wiring should be traced out with a test set using the resistivity scale. One end of each heater should be connected to one side of the power source through the relay and temperature controller. The other end of each heater should be connected to the other side of the power source through the heater power switch.
11. Uncoil the thermocouple attached to the back of the temperature controller and feed it through the holes provided in the top and back of the oven only far enough for the thermocouple tube to lay in the protective cover on the back inside wall of the oven above the rollers.
12. Recheck the above procedure.
13. Place the control box in its proper position. Make sure all wiring is clear of the motor and drive mechanism.
14. Connect the oven to the power and check out the operation of the controls and then oven. When satisfied it is correct, go to step 15.
15. Remove the power and fasten down the control box and put the protective cover on the back.
16. Now put the oven in operating position and connect to the power for normal operation.

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