

SPECIFICATIONS:

ELECTRICAL: 480/3/60 APPROX. 30 AMPS

FUEL: NATURAL GAS @ 2-5 PSIG
1,250 SCFH @1,000 BTU/SCF
1,250,000 BTUH

RECIRCULATION: 18,500 CFM @ 15 HP

EXHAUST: 5,000 CFM @ 3 HP

ROTATE MECHANISM: 1/2 HP (2)

TEMPERATURE: 500° F MAXIMUM
450° F NORMAL
50° F ABOVE AMBIENT MINIMUM

PAINT COLOR: OVEN - WOC GRAY (341-0187)
CONTROL PANEL - MANUFACTURER'S GRAY
CONDUIT - NOT PAINTED
GUARDS - OSHA YELLOW

**ALL DIMENSIONS
ARE IN INCHES**

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NOTES:

- WOC LARGE LOGO TO BE LOCATED ON CENTERLINE OF OVEN ABOVE PROFILE OPENING
- EXHAUST BLADE SIZED TO ALLOW 1255 CFM MINIMUM EXHAUST AND A 9 MIN PURGE TIME. VERIFY EXHAUST AT FINAL INSTALLATION.
- SOLVENT LOADING: 0.75 GAL PER BATCH @ 500°F
0.81 GAL PER BATCH @ 400°F
- 145.3 SQ FT OF EXPLOSION RELIEF REQUIRED
79.7 SQ FT OF EXPLOSION RELIEF PROVIDED BY DOORS
65.4 SQ FT OF EXPLOSION RELIEF PROVIDED BY ROOF
DO NOT BLOCK DOORS - STAY CLEAR DURING OPERATION
- SPLIT OVEN INTO (3) PIECES FOR SHIPPING. MATCH MARK & REMOVE BLOWERS & ROTATIONAL DRIVES FOR SHIPPING. FLOOR SHIPS LOOSE. SMALLEST DOOR/PASSAGEWAY: 11' 3" HIGH X 11' 3" WIDE
HEIGHT RESTRICTION AT FINAL JOBSITE: 11' 4" (BOTTOM OF CRANE)
- APPROXIMATE SHIPPING WEIGHT: SECTION 1: 5,500 LBS
SECTION 2: 5,500 LBS
SECTION 3: 5,500 LBS
LOOSE ITEMS: 2,500 LBS
TOTAL: 8,000 LBS
- EXHAUST NOTE:
THE EXHAUST STACK FROM OUR EQUIPMENT TO ATMOSPHERE MUST BE DESIGNED WITH A MAXIMUM AIRFLOW RESISTANCE OF 3/4" WC FOR POWERED EXHAUST; 1/2" WC FOR NON-POWERED EXHAUST, AND MUST BE SUPPORTED INDEPENDENTLY OF THE EXHAUST BLOWER.
- INSTALLATION PROCEDURE:
THE EQUIPMENT MUST BE LEVELED AND SET PLUMB. SHIMS CAN BE USED TO LEVEL THE EQUIPMENT. AFTER LEVELING, ANY GAPS ALONG THE BOTTOM MUST BE FILLED WITH INSULATION AND GROUTED TO PREVENT THE INFILTRATION OF COLD AIR OR THE SPILLAGE OF HOT AIR. THE EQUIPMENT MUST BE LAGGED TO THE FLOOR WITH THE PROVIDED MOUNTING PADS. THE EQUIPMENT MUST BE LAGGED BEFORE REMOVING THE "SHIPPING BAR OR ANGLE" (THE BAR OR ANGLE ON THE OUTSIDE OF THE DOOR). FAILURE TO INSTALL THE EQUIPMENT AS NOTED WILL VOID THE WARRANTY.
IN ACCORDANCE WITH NFPA 86, SPECIFICATION 5.1.4.1 STATES "FURNACES (OVENS) SHALL BE LOCATED WITH SPACE ABOVE AND ON ALL SIDES FOR INSPECTION AND MAINTENANCE PURPOSES." WISCONSIN OVEN CORPORATION RECOMMENDS 18" OF CLEARANCE, WHICH PROVIDES ROOM FOR HEAT DISSIPATION. INTERPRETATION AND COMPLIANCE WITH THE REQUIREMENT ARE THE SOLE RESPONSIBILITY OF THE PURCHASER.
- FIFTEEN (15) POINT TEMPERATURE UNIFORMITY SURVEY: ±5°F @ 145°F & ±10°F @ 450°F
* INDICATES TEMPERATURE UNIFORMITY TEST LOCATION, SEE SIGNED TEST SHEET.
- 12GA OVEN FLOOR INCLUDED. OVEN MUST BE INSTALLED ON A NON-COMBUSTABLE FLOOR RATED FOR THE MAXIMUM OPERATING TEMPERATURE OF THE OVEN.

ITEM	QTY	DESCRIPTION	LENGTH	WIDTH	PART NUMBER	DRAWING	GRP
1	1	PANEL ASSEMBLY				208-X07030A-1	
2	1	SUPPLY AND RETURN DUCT ASSEMBLY				202-X07030A-1	
3	1	BI PARTING DOOR ASSEMBLY				203-X07030A-1	
4	1	STANDARD MOUNTING ANGLE			S	220-3-3442	1
5	REF	AIR FLOW SWITCH					
6	REF	EXHAUST AIR FLOW SWITCH MOUNTING			S	241-S-1173	4
7	1	LARGE WOC LOGO			343-0001		
8	3	EXPL RELIEF SIGN SMALL			640-0068		
9	1	EXPL RELIEF SIGN LARGE			640-0070		
10	1	CHAMBER PRESSURE PORT			S	220-S-3643	
11	1	RECIRCULATION BLOWER, 18500 CFM, 15 HP				NYB 308 PLR	
12	REF	BURNER, W/ AIR FILTER			APX 1.5	MAXON	
13	1	BURNER TRIM ASSEMBLY, APX1.5, 6" WALL				209-APX-1.5_6	
14	2	THERMOCOUPLE MOUNTING: XTC = 12, CTC = 18 LOC @ TEST			S	220-4-1813	1
15	1	DOOR LIMIT SWITCH ASSEMBLY			S	220-4-1855	4
16	1	BLASTGATE, 10" FULL			311-0161		
17	1	POWERED EXHAUST ASSEMBLY, MODULATED, 5000 CFM @ 3 HP				241-X07030A-1	
18	1	POWER & CONTROL WIRING				502-X07030A-1	
19	1	12 GA ALZD FLOOR ASSEMBLY				240-X07030A-1	
20	1	ROTATION DRIVE ASSEMBLY				220-X07030A-1	
21	1	GAS PIPING ASSEMBLY					
22	1	OVEN FRONT ASSEMBLY				245-X07030A-1	
23	2	ACTUATOR, SPRING RETURN, MODULATING, 142 LB-IN, 24 VAC, 2 AUX SWITCHES			313-0260	SIEMENS GCA166.1U	
24	3	CHANNEL, STEEL, 3" @ 4.1#/FT x 20' LG	56	15/16	306-0004		COE
25	1	18in DIA MODULATED DAMPER			S	241-S-1171	

B	AS BUILT	6/10/14	BD
REV	DESCRIPTION	DATE	BY

REVISION HISTORY

WISCONSIN OVEN CORP.
EAST TROY, WISCONSIN 53120

GENERAL ASSEMBLY
BATCH-12/18/6.5-G/EP

DRAWN BY: bdavis DATE: 3/24/2014 DWG. NO.: 102-X07030A-1
CHK'D BY: JAL DATE: 3/27/2014
SCALE: 1/24 JOB NO: 07030ABCD

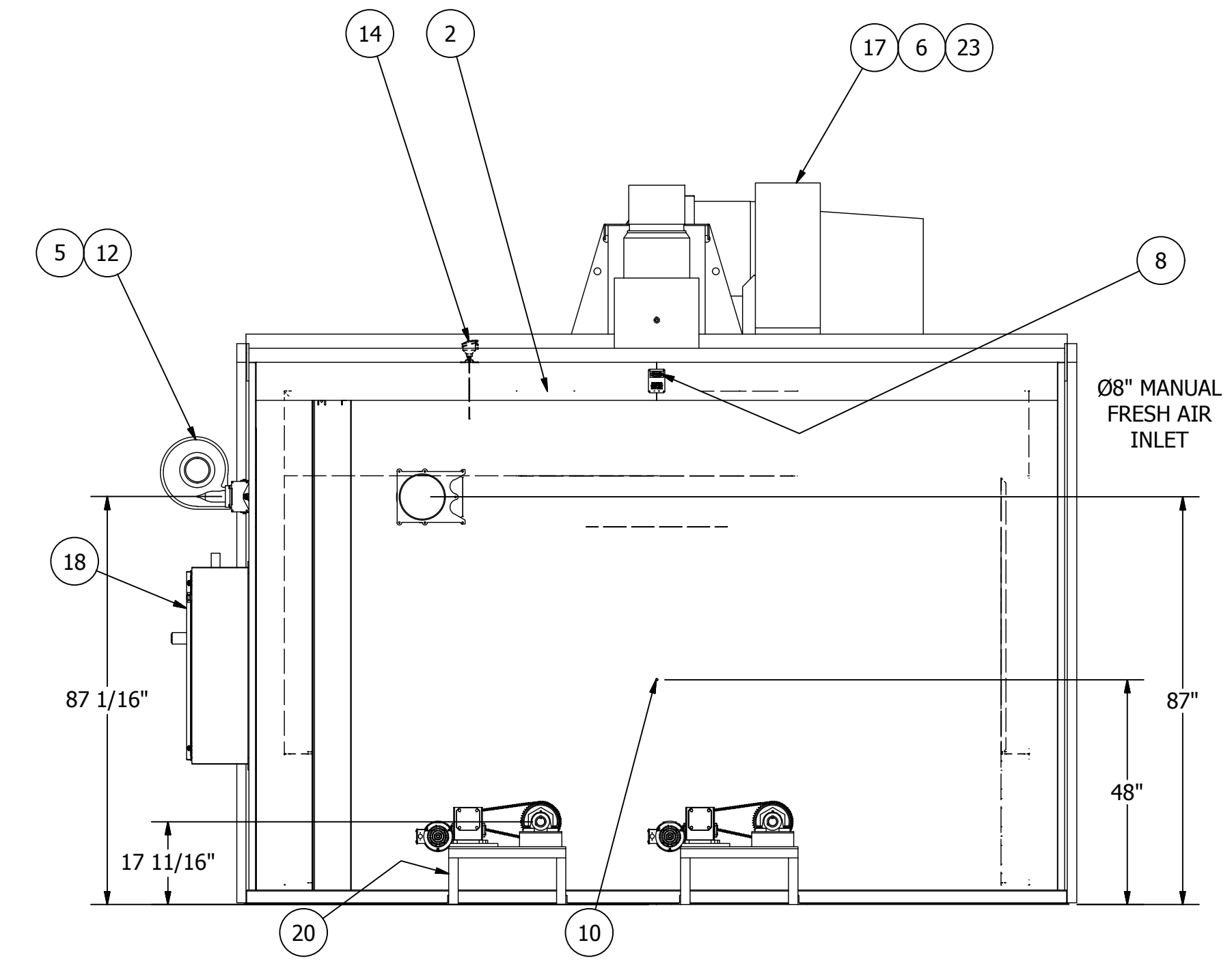
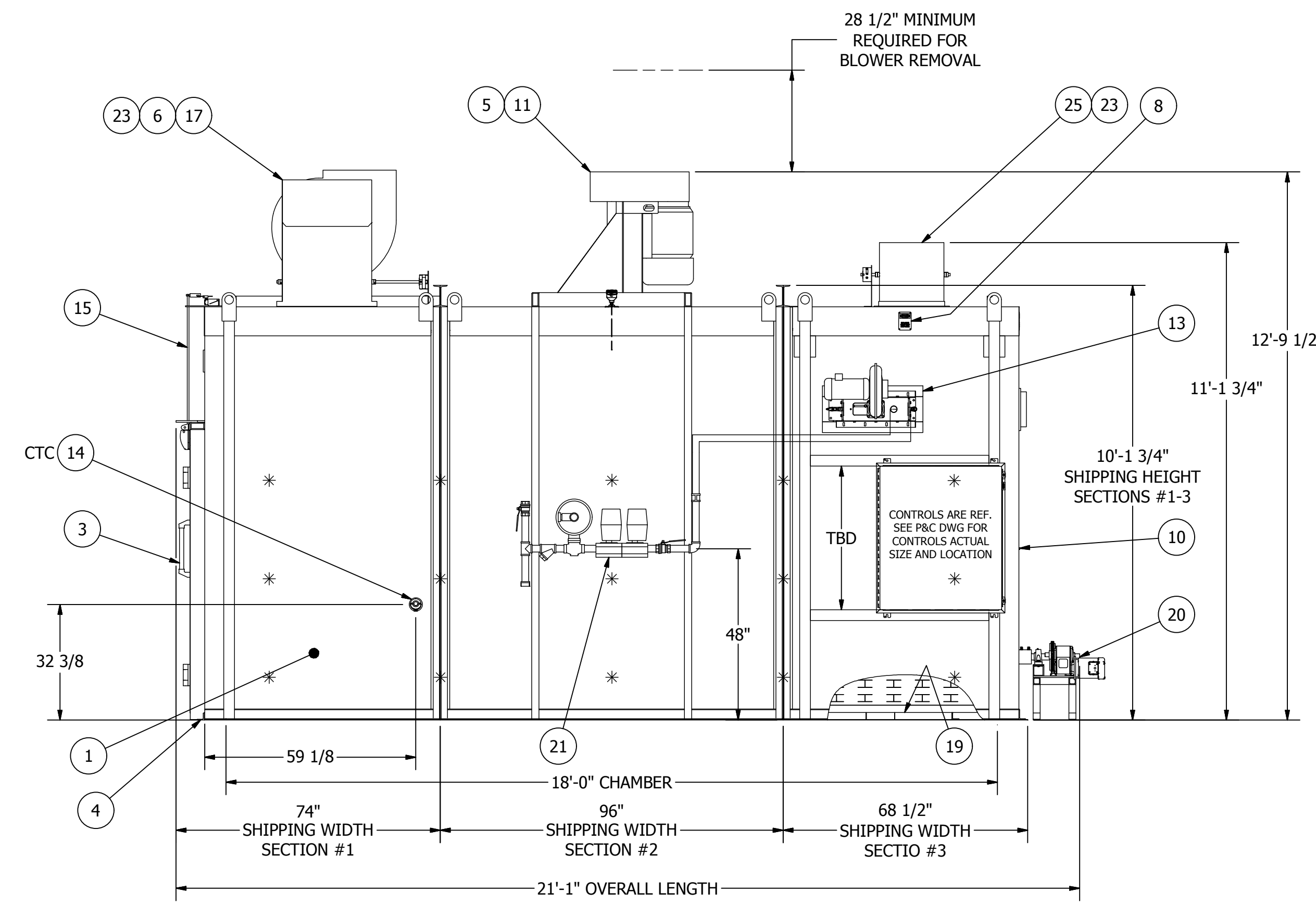
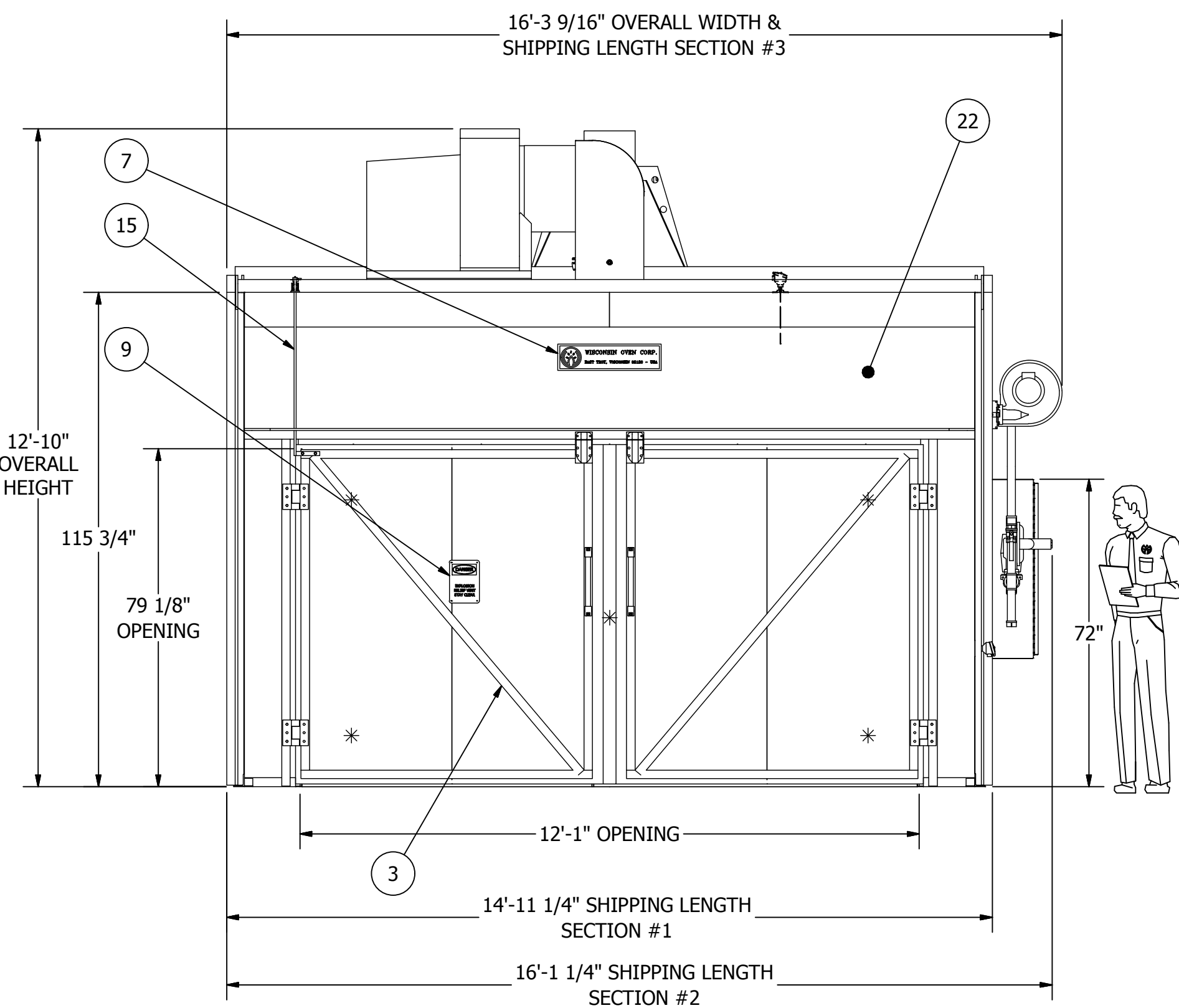
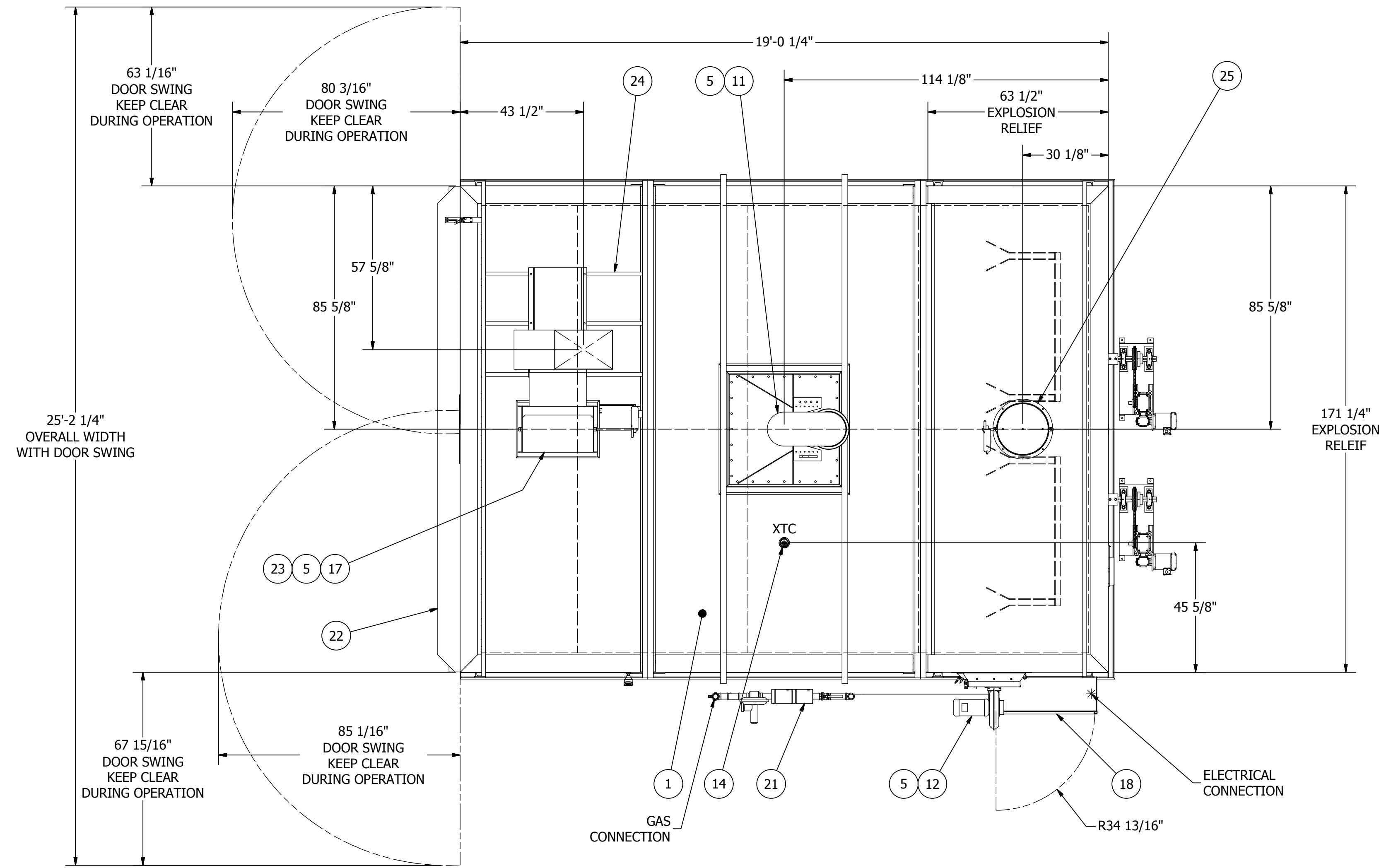
REV. **B**

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NOTE:
A & B OVEN SHOWN.
C & D OVEN HAS BURNER
GAS TRAIN & CONTROLS
ON LH SIDE OF OVEN.



WISCONSIN OVEN CORP. EAST TROY, WISCONSIN 53120			
GENERAL ASSEMBLY BATCH-12/18/6.5-G/EP			REV. B
DRAWN BY	bdavis	DATE	3/24/2014
CHK'D BY	JAL	DATE	3/27/2014
SCALE	1/24	JOB NO	07030ABCD
DWG. NO.		102-X07030A-1	
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