

ANNUAL MAINTENANCE CHECKLIST

OPERATIONS

To ensure maximum output and turndown:

- Verify and adjust incoming gas pressure as necessary
- Verify each Zone Control Module's low and high operating pressures - adjust regulators
- Inspect heaters for any surface contamination or damage - our technicians will clean built up powder off face screen, and protect heaters from falling parts.

SAFETY CHECKS

As recommended by NFPA-86, Section 7.4, all safety circuits should be tested annually, to include:

- Test the main valve-train high and low gas pressure switches
- Leak test the valve-train safety shutoff valves
- Test the control emergency stop interlock
- Test the thermo-switch interlock circuit
- Test the exhaust flow and high temperature interlocks

SPARE PARTS

Based on likelihood of failure, and lead-time for replacement:

- | | |
|--|---|
| ➤ Gas Pressure Switches | Expanded Spare Parts list includes: |
| ➤ One pair of zone regulators and solenoid, or | • Pre-programmed PLC |
| ➤ spare Zone Control Module assembly | • Replacement I/O cards (if applicable) |
| ➤ Zone Control Relays | • HMI and Power Supply |
| ➤ Exhaust pressure switch | • Heater Panels as needed |
| ➤ Spare thermo-switches | |

SCOPE OF WORK

For a typical oven, the Operations Check per 1.0 should take 3-6 hours, depending on the number of zones, and access to the ZCMs. The Safety Checks per 2.0 should take 4-8 hours, based on the number of modules and thermo-switch circuits.

PRICING

\$155/hour, plus travel & expenses. Typical Spare Parts pricing based on 3 through 3.5 is approximately \$700. Spare parts for Section 3.6 average \$1,900 but will depend on oven size and features.

