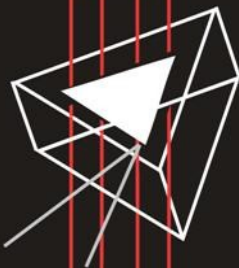


Rollabout Models 5A, 6B, 7C, 8E

English Manual

PDQ Ovens



Fillauer®

2710 Amnicola Highway
Chattanooga, TN 37406

Phone# (423) 624-0946 TF (800) 251-6398



Contents

1. Contents
2. Safety Warnings (please read first)
3. Oven Setup
4. Oven Setup
5. Oven Setup
6. Emitter Installation
7. Emitter Passthrough Assembly Replacement
8. Electrical Connections
9. Electrical Connections
Over Temperature Shut Off Device Check
10. Electrical and Warning Labels
11. Oven Controls Operation
12. Operating Suggestions
13. 208-240V Single Phase Wiring Diagram
14. 380-400V Three Phase Wiring Diagram
15. Warranty Information

**FOR YOUR SAFETY, PLEASE
OBSERVE THESE WARNINGS!**



Dangerous
Electrical
Voltage



Caution, refer to
accompanying
documents



Caution
Hot Surface

PDQ Ovens are designed for use in an indoor, dry, climate controlled environment of 70-77°F and a relative humidity of 35-65% at an altitude of 2000 meters or less.

PDQ Ovens are Overvoltage category II and Pollution degree 2.

PDQ Ovens are designed specifically for heating plastics for vacuum forming and have features that make it then inappropriate for other uses. The design is such that heating other materials may be dangerous, or may damage the oven. Protection provided by the equipment may be impaired if the unit is not used in a manner specified by the manufacturer.

Do not install or operate the PDQ Oven on or near flammable materials or gasses. Be sure to allow sufficient ventilation around oven surfaces. The recommended spacing is 6" minimum.

Cleaning: We recommend cleaning the inside of your PDQ Oven with either glass cleaner for water based stains, or a solvent such as acetone or mineral spirits for oil based stains. Do not use solvents on powder-coated surfaces. When using solvents, be sure the oven is turned off and cool to the touch.

Moving the oven: The PDQ Oven is light enough to be moved by 2-4 people. Let the oven cool, disconnect the electrical power and remove the cart before moving the oven. It is always advisable to secure the oven to the floor for permanent use.

Oven Setup

To save you freight cost and prevent damage to your new PDQ Oven, we have shipped it to you partially disassembled. These assembly instructions and diagrams should make setup fairly simple. You will require 2-4 people, a 7/16" wrench and a 1/8" and 5/32" hex wrench, along with the included hardware kit, to complete the setup.

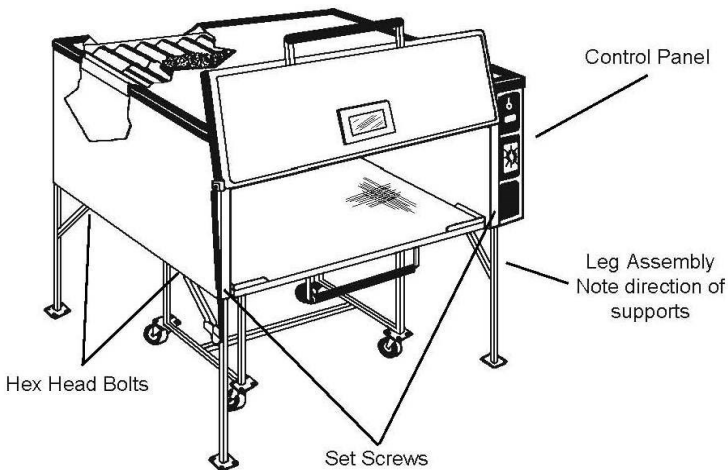


1. Unband and unpack the oven. (**Caution: Rollabout ovens have tubes wrapped to the back containing the infrared emitters, handle with care.**)

2. The oven MUST be slid back 2"-4" away from the cart before lifting.

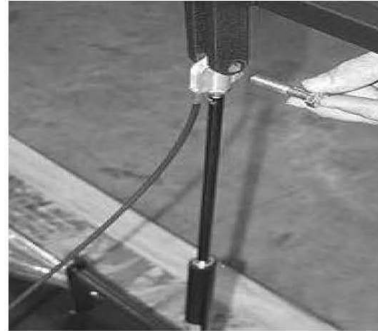


3. Lifting the side of the oven opposite the control panel, insert the round section of the legs into the leg holes on the underside of the oven. (see drawing) Install the hex bolts through the hole in the leg support into the threaded hole on the underside of the oven and tighten the two set screws for each leg with a 1/8" hex wrench. Lift the control panel side of the oven and repeat the process. (**Note that the angled supports on the legs run from front to back on the two front legs and side to side on the back legs.**)



Oven Setup

4. If you have a 5A model, install the casters on the cart using the hardware provided.
5. Lift the lower section of the cart high enough to accept the gas spring, then rotate the gas spring upward until the male portion fits into the female portion of the cart. Insert the bolt and lightly tighten the lock nut against the mount. Do not over tighten as this is a pivot point.



6. Flip the cart over onto the wheels. Then carefully remove and unpack the Teflon sheeted tray and replace it on the cart. Adjust the cart height using the quick release lever. *(Use the upper level for flat plastics and the lower level for bubble forming)*

Maximum weight on cart and tray is 50 lbs



UNLOCKED

Cart may be raised or lowered to required height



LOCKED

Cart height is now locked into position

Oven Setup

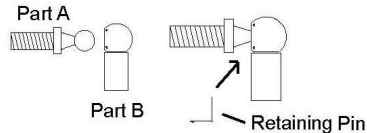


7. Open the door (*We suggest you secure the door in the open position with a length of rope. Since it has nothing to retain it at this point, it could potentially snap closed, causing injury.*) and snap the gas shocks on to the ball studs built into the door. Secure in place with the retaining pins. (see drawing)

PDQ door shock clip assembly:

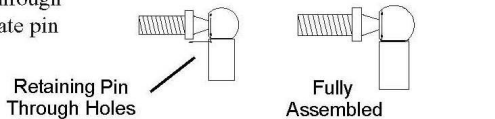
Step #1

Insert part A into part B
(a gentle force may be needed)



Step #2

Slide retaining pin up through holes in part B, and rotate pin around neck of part B



8. The oven should be bolted to the floor to insure that the door and cart operate properly. The location of the front legs can be determined by measuring the width of the door opening at the top and using that same measurement for the bottom of the door opening. Not bolting the legs to the floor can lead to jamming of the door or cart.
9. Install the door handle using the 4 screws provided. (*The screws are shipped in their appropriate holes in the door to keep the door trim secure during shipping.*)

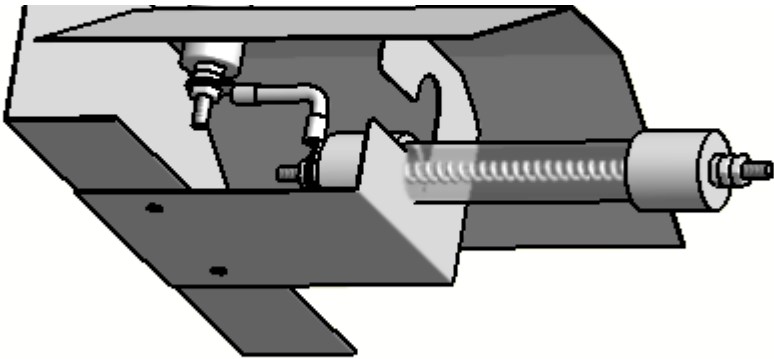


Emitter Installation



CAUTION: INFRARED EMITTERS ARE FRAGILE. HANDLE WITH CARE

1. Disconnect electrical power to the oven.
2. Remove the Emitter Passthrough assembly guards
3. Install the emitters into the hangers and then attach the jumper wires and tighten the hex nuts.
4. Clean the emitters with a soft cloth and glass cleaner.
5. Reinstall the Emitter Passthrough assembly guards and tighten the screws so that the guards lightly touch the emitter hangers for support.
6. Reconnect electrical power to the oven.

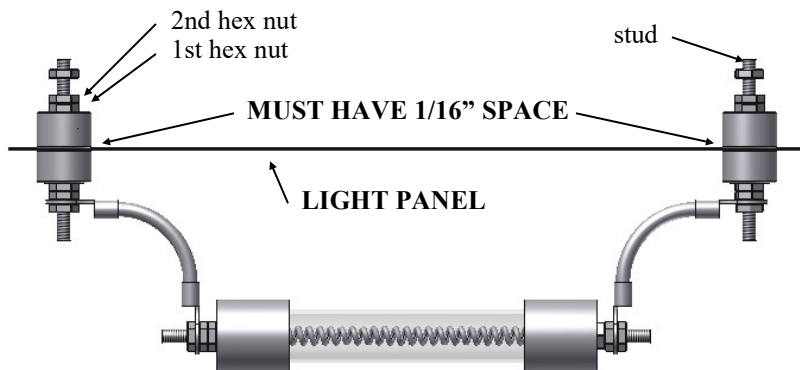


Emitter Passthrough Assembly Replacement



CAUTION: INFRARED EMITTERS ARE FRAGILE. HANDLE WITH CARE

1. Disconnect electrical power to the oven.
2. Remove the trim ring and lid to access the Emitter Passthrough assembly.
3. Remove the 3" strips of insulation covering the jumper wires and Emitter Passthrough assemblies.
4. Remove the Emitter Passthrough assembly guards inside the oven.
5. Remove the Emitters and Emitter Passthrough assemblies as required.
6. Install the new Emitter Passthrough assembly and adjust the 1st hex nut so that the required 1/16" spacing is achieved. See diagram below. **WARNING** failing to have the 1/16" spacing can cause the ceramic insulators to break. Too large of a gap could result in the post shorting to the light panel causing a ground fault.
7. Hold the stud and 1st hex nut while tightening the 2nd hex nut against the 1st hex nut.
8. Reattach the jumper wires.
9. Reinstall the emitters.
10. Clean the emitters with a soft cloth and glass cleaner.
11. Reinstall the Emitter Passthrough guards and tighten the screws so that they lightly touch the emitters hangers for support.
12. Reinstall the insulation strips and all previously removed parts.
13. Reconnect electrical power to the oven.



Electrical Connections



All electrical connections must be performed by a certified electrician following all national and local codes and regulations.

External Circuit Breaker and Shut Off required and it must be marked as the disconnecting device for the equipment. The main supply wire must be at least 75°C copper wire of the appropriate gauge for the circuit breaker recommended for the oven model.

208-240 L1-L2 volt single phase units must be hardwired to your electrical system utilizing an external circuit breaker and shut off mounted as close as possible to the oven.

380-400 volt 3 phase units are provided with 8' of VDE rated cord. The oven must be connected to an external circuit breaker and shut off mounted as close as possible to the oven.

208-240 L1-L2 Volt Single Phase

Oven Model	Actual Amperage	Recommended Circuit Breaker
5A, 6B	20 Amp	30 Amp
7C	23 Amp	30 Amp
8D	59 Amp	70 Amp
8E	39 Amp	50 Amp

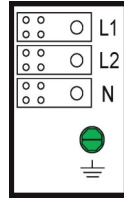
380-400 Volt Three Phase

Oven Model	Actual Amperage Per Phase	Recommended Circuit Breaker
5A, 6B	8 Amp	Check Local and National Regulations
7C	9 Amp	
8D	23 Amp	
8E	16 Amp	

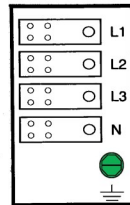
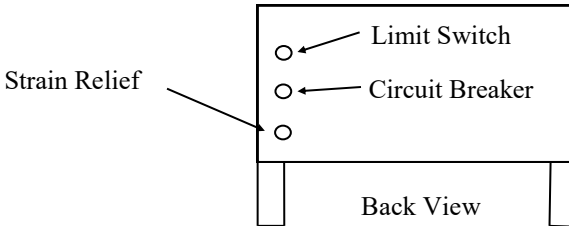
Electrical Connections

CAUTION: SHEETMETAL EDGES MAY BE SHARP

1. Remove the electrical panel (right side panel) by removing the 3 screws on the side and the 3 screws across the lower edge of the panel with a 1/8" hex wrench.
2. Insert the power cord through the strain relief and connect the power wires to the terminal blocks and ground screw.
3. Reinstall the side panel.



208-240V
L1-L2
Single
phase



380-400V
Three
phase

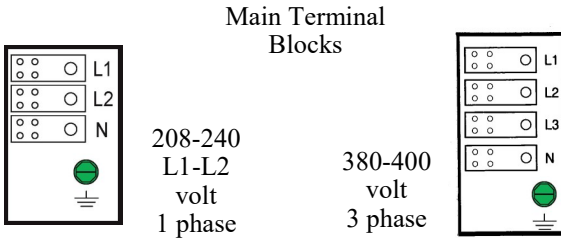
Over Temperature Protection:

The PDQ Ovens have a maximum temperature setting of 450°F or 243°C. In addition an over temperature shut off device (**Limit Switch**) is supplied that will turn the emitters off if the temperature exceeds 500° - 525°F or 260° - 275°C. A reset button is located on the back of the oven above the main power supply entry point. Unscrew the cap and push the button firmly if an over temperature situation occurs.

Over Temperature Protection Device Check:

1. Disconnect electrical power and ensure the oven is cool to the touch.
2. Remove the devices' temperature probe (short copper bulb and capillary tube not the long chrome probe) from the mount on the inside of oven.
3. Insert probe into a handheld dry-well calibrator (ex. Hart Scientific 9100S) and heat the probe.
4. The device should trip between 500° and 525°F or 260° and 275°C.
5. Allow the probe to cool to room temperature and reinstall in mount.
6. Reset the device by pressing the reset button on the device.

Electrical and Warning Labels



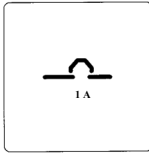
Dangerous
Electrical
Voltage



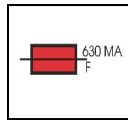
Caution, refer to
accompanying
documents



Caution
Hot Surface



1 Amp
Circuit
Breaker
Single
Phase



630 MA
Fuse
3 Phase



Fan Control



Main Switch
Control



Oven Control

Oven Controls Operation

380-400 Volt Ovens:



OFF ON

The **MAIN SWITCH** is located on the control panel on the front of the oven. Rotate the knob to the ON position to enable oven use.

208-240 and 380-400 Volt Ovens:



OFF ON

The **OVEN CONTROL SWITCH** is located on the control panel on the front of the oven. Rotate the knob to the **ON** position to enable oven use.

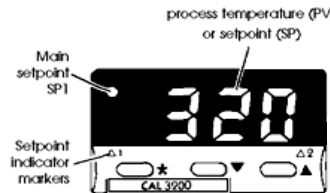


The **FAN CONTROL KNOB** is located on the control panel on the front of the oven. Rotate the knob all the way to the left to turn the fan OFF and gradually rotate the knob to the right until the desired fan speed is achieved.

The **TEMPERATURE CONTROLLER** is located on the control panel on the front of the oven. To set the temperature of the oven, press and hold the left hand (★) button and either increase the set point using the right hand (▲) button, or decrease the set point using the middle (▼) button.

Routine adjustments

- ★ View set point
- ★▲ Increase set point
- ★▼ Decrease set point



Operating Suggestions

Flat Plastic:

1. Preheat the oven and tray/cart to the desired cooking temperature.
2. Place the plastic in the center of the cooking tray and roll the tray/cart into the oven.
3. Your new PDQ Oven will work best if set at 400°F or 200°C for plastics such as Polypropylene, Copolymer and Polyethylene. Special plastics may require a different setting.
4. Plastics less than 1/8" or 3mm cook best when utilizing a "cool tray" or by removing the tray/cart from the oven and allowing it to cool to room temperature before placing the plastic on the tray and sliding it into the oven.
5. Colored plastics generally will require 2-3 minutes longer to cook than the same thickness natural color plastics.



The Teflon sheeting on the tray is a durable nonstick material. However, it is not indestructible. It is wise to exercise care when using it. For example, avoid sliding hard objects across the surface. As with other materials, the surface will degrade over time.

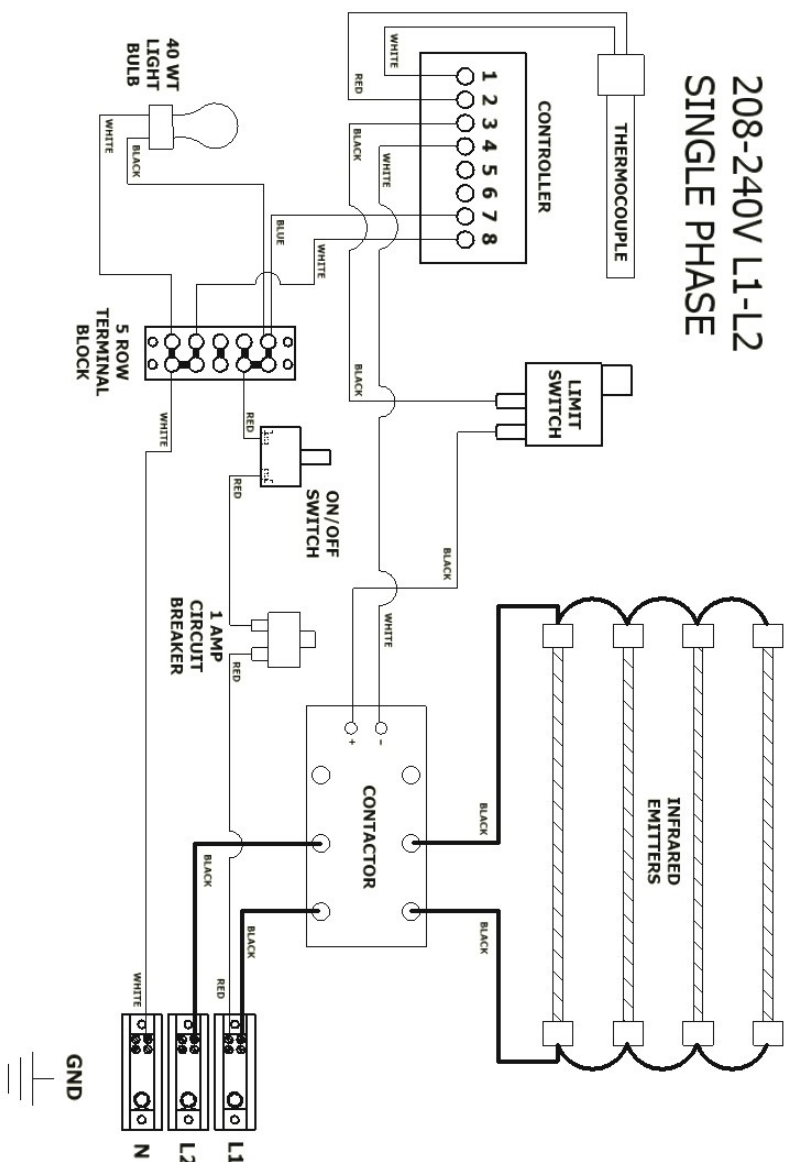
Bubble Forming:

1. Lower the tray/cart to the lower position.
2. Preheat the oven to the desired cooking temperature. Normally between 375°F and 440°F or 190°C and 225°C
3. Select the appropriate size bubble forming frame and insert the plastic into the frame.
4. Position the bubble forming stand in the center of the tray/cart and place the bubble forming frame on the stand and roll into the oven.

Oven Fan/s:

1. The fan/s circulate the heated air in the oven. The fan/s do not draw external air into the oven or exhaust heated air out of the oven.
2. The fan/s are variable speed and are controlled by the fan control knob on the front of the oven.
3. The oven operator shall determine the fan/s usage based on cooking requirements and preferences.

208-240V L1-L2 SINGLE PHASE



PDQ OVEN 1 YEAR LIMITED WARRANTY

Fillauer North Carolina ("Seller") warrants to the original purchaser ("Purchaser") that the PDQ Oven manufactured by Seller is free from defects in material and workmanship under normal use and service, but only if it has been properly installed and operated. Seller's obligation under this warranty shall be limited to the repair or exchange of any part or parts which may prove defective under normal use and service within one (1) year from the date of purchase by Purchaser. Any such defective parts must be returned to Seller's factory at Weaverville, North Carolina not later than one (1) year after purchase of the PDQ Oven. Parts not manufactured by Seller will carry only the warranty of their manufacturer. Transportation charges or duties shall be borne by Purchaser. Labor to replace the defective part will be by local, licensed electrician, obtained by the Purchaser with Seller approval, and shall be paid by Seller. The foregoing shall be the limit of Seller's liability for any breach of warranty within thirty(30) days after discovery thereof, but within the one (1) year guarantee period, otherwise, such claims shall be deemed waived. No allowance will be granted for any repairs or alterations made by Purchaser without Seller's prior written consent.

Seller does not warrant its PDQ Oven to meet the requirements of any safety code of any state, municipality, or other jurisdiction, and Purchaser assumes all risk and liability whatsoever resulting from the use thereof, whether used singly or in combination with other machines or apparatus.

This warranty shall not apply to any PDQ Oven or parts thereof, which has been repaired or altered, without Seller's written consent, or which has been damaged as a result of misuse, negligence, or accident, or which has not been operated in accordance with Seller's printed instructions, or has been operated under conditions more severe than, or otherwise exceeding, those set forth in any specifications.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR USE, FOR A PARTICULAR PURPOSE, AND OF ALL OTHER OBLIGATIONS OR LIABILITIES ON THE PART OF THE SELLER. SELLER NEITHER ASSUMES NOR AUTHORIZES ANY OTHER PERSON TO ASSUME ANY OTHER LIABILITY IN CONNECTION WITH THE SALE OF THE PDQ OVEN. SELLER MAKES NO WARRANTY WHATSOEVER WITH RESPECT TO ACCESSORIES OR PARTS NOT SUPPLIED BY SELLER.

Seller shall not be liable for any loss or damage resulting, directly or indirectly, from the use or loss of use of the PDQ Oven. Without limiting the generality of the foregoing, this exclusion from liability embraces the Purchaser's expenses for down time or for making up down time, damages for which the Purchaser may be liable to other parties, damages to property, and injury or death of any persons. Seller neither assumes nor authorizes any person to assume for it, any other liability in connection with the sale or use of the PDQ Oven, and there are no oral agreements or warranties in connection therewith.

The warranty hereinabove set forth shall not be deemed to cover infrared tubes, for which Seller shall have no responsibility or liability whatsoever.

Under no circumstances shall the liability of Seller exceed the purchase price paid by Purchaser. Some states do not allow limitations on the length of any warranty or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to the Purchaser.

For Your Records:

Serial No. _____ Model No. _____

Date Purchased: _____