



DigiCure

AIR-2411-240V

Document # 16-433

Assembly and Operating Instructions

Please review all of these instructions prior to assembling, installing or operating the equipment. Verify the proper tools, materials, and personnel are available for the safe and successful use of the dryer.

The *DigiCure* Oven is attached to a skid for shipping purposes.

The following **assembly** procedure is recommended for this equipment:

Unpack, inspect and identify all of the shipped equipment and parts. Immediately report any suspected lost or damaged items to Customer Service (800) 654-4205

PRIOR TO CONNECTING POWER TO THE OVEN CHAMBER

A dedicated circuit disconnect is required for proper operation / protection of this oven.

Voltage: 240/208 Volts (single phase)

Frequency: 50/60 Hz

Recommended Disconnect: 70 amp

Note: Assure that all appropriate “**LOCK-OUT / TAG-OUT**” procedures are followed to prevent power from being distributed to the control panel before called for in these instructions.

- A dedicated electrical (earth) ground is required for proper operation of the equipment.
- Confirm the power disconnect switch on control panel is in the OFF position with the red lock out in the locked position.

Power may be connected to the disconnect switch by removing the cover of the control panel. Power cable may be run thru the bracket provided at the bottom of the control panel and appropriate cord grip used.

Wiring must be compatible with existing building receptacles and local electrical codes.

A five-inch exhaust collar has been provided for an exhaust fan to be added.

Connecting the unit to power

Have a certified electrician connect the unit to power in accordance with local electrical codes.

Before servicing or cleaning, switch power off at service panel and lock service panel to prevent oven from being switched on accidentally. If service panel cannot be locked, securely fasten a prominent warning device, such as a tag, to the service panel.

Initial Set-Up procedure recommended for this equipment:

IMPORTANT

DO NOT TURN OFF POWER TO UNIT AT RED AND BLACK HANDLE (DISCONNECT) WHILE CONVEYOR BELT IS MOVING. TURN OFF HEATERS AT AMBER ROCKER SWITCH. ONCE TEMPERATURE DROPS BELOW 250°F, BELT WILL STOP. POWER MAY THEN BE TURNED OFF AT DISCONNECT. CONVEYOR BELT MUST BE ON WHILE HEAT IS ON BELT MAY BE DAMAGED IF OVERHEATED (Note: Belt will not move while oven is below 250°F)

Conveyor Setting	Zone 1 Temperature	Zone 2 Temperature
1:30	675°	550°
3:00	650°	515°
4:00	650°	515°
5:00	610°	510°
6:00	610°	510°

Table: Recommended Settings

- 1) Conveyor Setting denotes time in oven chamber.
- 2) Settings will hold garment temperature between 320°F and 360°F while in chamber. The cure time needed must be obtained from you ink manufacturer.
 - a. Most white garments with NO white ink under-base will fully cure at 1:30 setting.
 - b. For dark garments, a setting of 3:00 or greater may be needed.
 - c. For light colored garments using a white ink under-base, temperatures may need to be decreased 5 – 10% to prevent discoloration. Wash test should be conducted for any setting to assure proper cure.

- 3) Turn the disconnect switch (on control panel) to the on position. If knob will not turn be sure the red "lock out" tab is pressed all the way in.
- 4) Set oven to desired settings.
- 5) Move the both rocker switches (Chamber and Conveyor) to the ON position. Heat control will illuminate and begin heating chamber. Conveyor switch will not illuminate, and belt will not move until oven temperature is above 250°F
- 6) After the zone temperatures have reached set point and the elements have cycled off and back on at least once. Cycling is determined by observing the small output indicator located below the green set temperature. This indicator will be lit when power is being applied to the elements it will not be seen when the elements are not receiving power. Allow an extra 10-15 minutes for oven temperature to stabilize.
- 7) Due to environmental conditions, the recommended settings from the table may need to be adjusted. Using scrap material, run a series of tests.
Use the same imprint and ink to determine the minimum time and temperature settings needed to fully cure the imprint.
- 8) Wash the test material to determine satisfactory results.

Powering Down Instructions:

Unit must finish cooling cycle before power is turned off using the red disconnect switch.

- 1) Turn off amber Heat Control switch.
- 2) The belt and internal fans will continue to operate until temperature drops below 250°F.
- 3) Once belt stops, turn power off by the red disconnect switch
- 4) **There is no need to turn off amber Conveyor Switch.** This switch was only provided to stop belt during special situations.

PREVENTATIVE MAINTENANCE AND REPAIR

Basic Trouble Shooting

Oven does not reach the temperature set point:

- A. Make sure the set point is below 700 deg F
- B. Confirm the oven is getting proper voltage. A drop in voltage will decrease the temperatures in the oven.
- C. Reduce any drafts or air currents such as open doors, fans, air conditioners that could be blowing into the chamber. Do not direct fans at the oven this will cause temperature variations in the chamber.
- D. Check to see if the thermocouple is broken (call electrician). Replace if necessary.
- E. Check to see if a contactor is “dead” (call electrician). Replace if necessary.

Conveyor belt stops:

- A. Check to make sure the amber rocker switch is in the ON or up position.
- B. Check to see if a fuse is blown. See electrical drawing, control panel.

Conveyor belt is torn:

- A. A Teflon mesh belt cannot be repaired. Over time the torn area may gradually increase to the point where the belt will need replacement.

Please contact the service department at *BBC Industries* (800-654-4205) or service@bbcind.com with any questions regarding these instructions.

WARRANTY

BBC Industries, Inc. warrants their products to be free from defects in workmanship at the time of shipment.

The obligation under the above warranty shall be limited to the repair or replacement of any part or parts manufactured by BBC Industries, Inc. without charge F.O.B. factory that may prove defective within 12 months from the date of shipment, which are returned to BBC Industries, Inc.

The above warranties are the only warranties made with respect to the equipment. There is no implied warranty of merchantability or of fitness.

EXCLUSIONS:

There is no warranty on parts not manufactured by BBC Industries, Inc., other than the respective manufacturer's warranty, if any.

The warranty against defects shall not extend to damage caused from any of the following:

- Transport by carrier
- Corrosion
- Operation or use in a manner inconsistent with specifications and/or operating instructions
- Ordinary wear, accident, improper installation, or maintenance
- Alterations made to equipment in any way

BBC Industries, Inc. shall not be liable for any losses or damages, including but not limited to incidental or consequential damages, suffered or incurred because the equipment proves to be defective either upon installation or during its operation or use.

Shipment of defective parts to BBC Industries, Inc. and the return shipment of any repaired or replacement parts from BBC Industries, Inc. shall be the purchaser's/user's expense.