



# HOT ROCKS

## PARTS AND SERVICE MANUAL



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# 1. GENERALITIES

## 1.1 Revisions

Revision	Date	Modifications
0	2017-03-31	New technician's manual
1	2017-07-18	Table modification
2	2017-12-13	New interface and connection
3	2020-02-06	Update manual format
4	2020-11-02	New generation of the oven

## 1.2 Warnings

**DO NOT USE OR STORE GASOLINE, PRODUCTS WITH FLAMMABLE VAPORS / LIQUIDS WITHIN THE VICINITY OF THIS, OR ANY OTHER APPLIANCE.**



### **WARNING**

**This symbol specifies important safety instructions which, if not followed, could endanger personal safety and/or property. Read and follow all instructions in this manual before attempting to operate the oven.**

**Failure to comply with these instructions may result in personal injury.**

- Read, comprehend, and follow all instructions in this manual before starting. Keep this manual in a safe place for regular reference.
- Only allow responsible individuals familiar with the instructions to operate the oven. Be sure to know the controls, and how to stop the oven quickly.
- Never put hands near moving parts.
- Only allow authorized technicians to perform the maintenance of the oven.
- Remove all obstacles which may interfere with the oven's function.
- Clear the work area of any items such as electrical wires, buckets, knives, etc.
- Do not sit or stand on the oven.
- Always turn off the oven with the main switch or leave it on standby mode after the work is done.
- Never leave a running oven unattended.
- Always disconnect the electric plug and wait until the oven has cooled before attempting any maintenance.
- Do not wear loose-fitting clothes or jewellery as they may get caught in the moving parts of the oven.
- Always wear appropriate shoes to prevent, to prevent injury caused by moving the oven or hot objects falling from the oven.
- Work only in full daylight or with sufficient artificial light.
- Do not operate the oven while under the influence of alcohol, drugs or any illegal substance

## 1.3 Service

Determine the proper method to dispose of waste from the local office of the Environmental Protection Agency. Recycling centers are established to properly dispose of materials in an environmentally safe fashion.



### **WARNING**

**This oven should only be operated by staff that has read, comprehend and will respect warnings and instructions regarding this oven in the owner manual. The parts and service manual is dedicated to authorized technicians (see section 1.4).**

**DO NOT SPRAY LIQUIDS OR VAPORS ON, OR NEAR, ELECTRICAL EQUIPMENT.  
DO NOT USE THIS APPLIANCE IF ANY OF ITS PARTS HAVE BEEN UNDER WATER.**

**IMMEDIATELY CONTACT A QUALIFIED SERVICE TECHNICIAN TO INSPECT THE APPLIANCE AND TO REPLACE ANY PARTS WHICH WERE SPRAYED OR SUBMERGED UNDER WATER.**

## 1.4 Authorized technician

All installations and/or service on any Hot Rocks ovens must be performed by qualified, certified, licensed and/or authorized installers and technical service personnel. All electrical, gas and plumbing connections must be made by authorized technicians and in compliance with all electrical, gas, plumbing and safety requirements.

It is possible to obtain these services by contacting Hot Rocks customer service or a local service company. Refer to the [Hot Rocks website](#) for a list.

## 1.5 Definitions

### **USER(S)**

A user is those who will operate the oven. There are two different levels of users; basic user and advanced User.

### **BASIC USER**

Basic users are those who will work everyday with the oven to cook pizza. A basic user has been trained by an advanced user or an authorized technician to safely operate the oven. They can also perform daily and weekly operator maintenance.

### **ADVANCED USER**

Advanced users are those who received the proper training from the authorized technician to perform monthly operator maintenances. They can lock cooking parameters from the basic user.

### **QUALIFIED AND/OR AUTHORIZED TECHNICIAN**

Qualified or authorized technicians are professional that are authorized by Hot Rocks to work on the oven. The technician must comply with all requirements of state or local authorities having jurisdiction.

### **QUALIFIED INSTALLATION PERSONNEL**

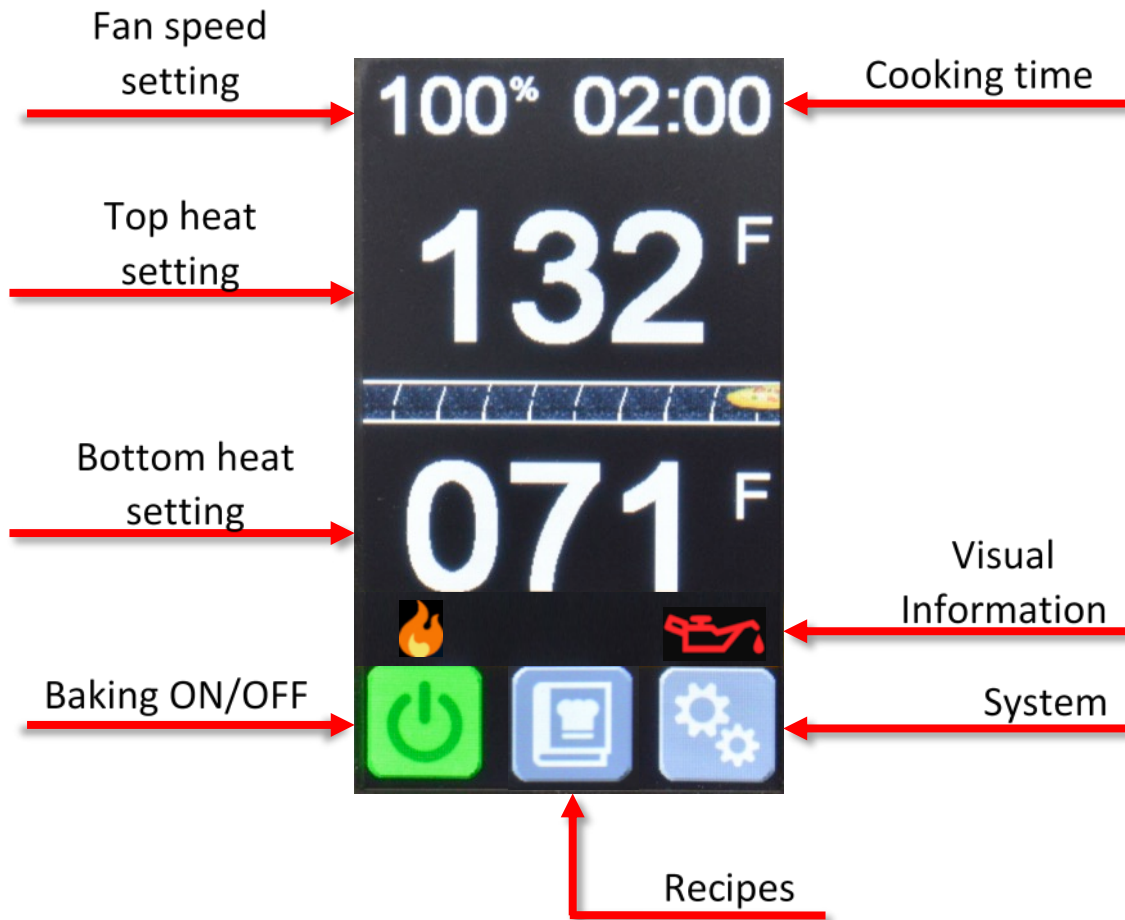
Qualified installation personnel can be represented by an individual, a firm, a corporation or a company which will perform and is responsible for:

1. The installation of gas piping from the outlet side of the gas meter or service regulator when the meter is not provided, and the connection and installation of the gas appliance. The qualified installation technician must be experienced in such work, familiar with all required precautions, and comply with all requirements of state or local authorities having jurisdiction. Reference in Canada: Canadian Standard CAN/ CSA-B149.1 and Z223.1 / NFPA 54 (Natural and/or propane gas installation code)
2. The installation of electrical wiring from the electric meter, main control box or service outlet to the electric appliance. The qualified installation technician must be experienced in such work, familiar with all required precautions, and comply with all requirements of state or local authorities having jurisdiction.
3. The appliance, when installed, must properly be electrically grounded in accordance with local codes. In the absence of local codes, it needs to respect the National Electrical code ANSI/NFPA 70, or the Canadian Electrical code, CSA 22.1 No 109 or conform to UL STD 197.



## 2. OPERATION




### 2.1 Technician interface



\* Note that this is referred to as the “main screen.”

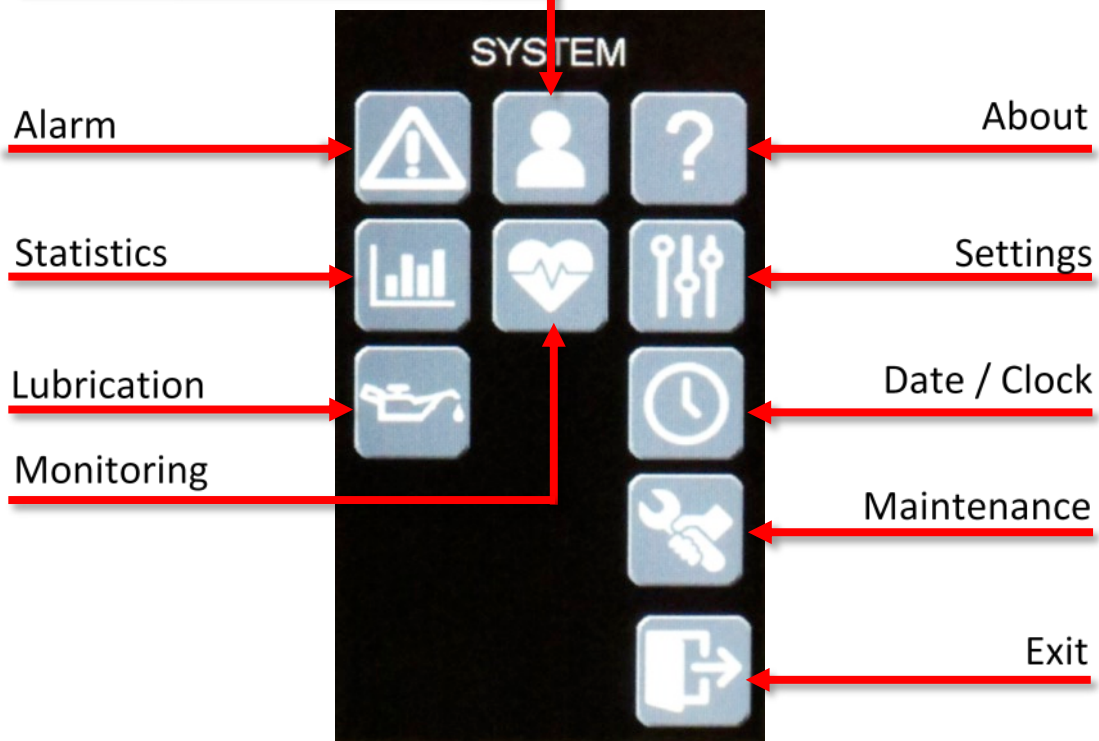
#### 2.1.1 Visual Information

This section provides important information about the state of the oven.

ICON DISPLAYED	DESCRIPTION
	Shown during start-up to inform that the oven is rising in temperature to reach the selected set point. Once the bottom temperature reaches over 250°F for 5 minutes, the icon will disappear.
	Icon shown during the standby mode to cool down the oven rapidly. Once the bottom temperature cools under 250°F for 5 minutes, the icon will disappear.
	Icon shown when the lubrication of the main conveyor chains is due. Once the lubrication is done, the icon will disappear.

## 2.1.2 Technician Login

### User login



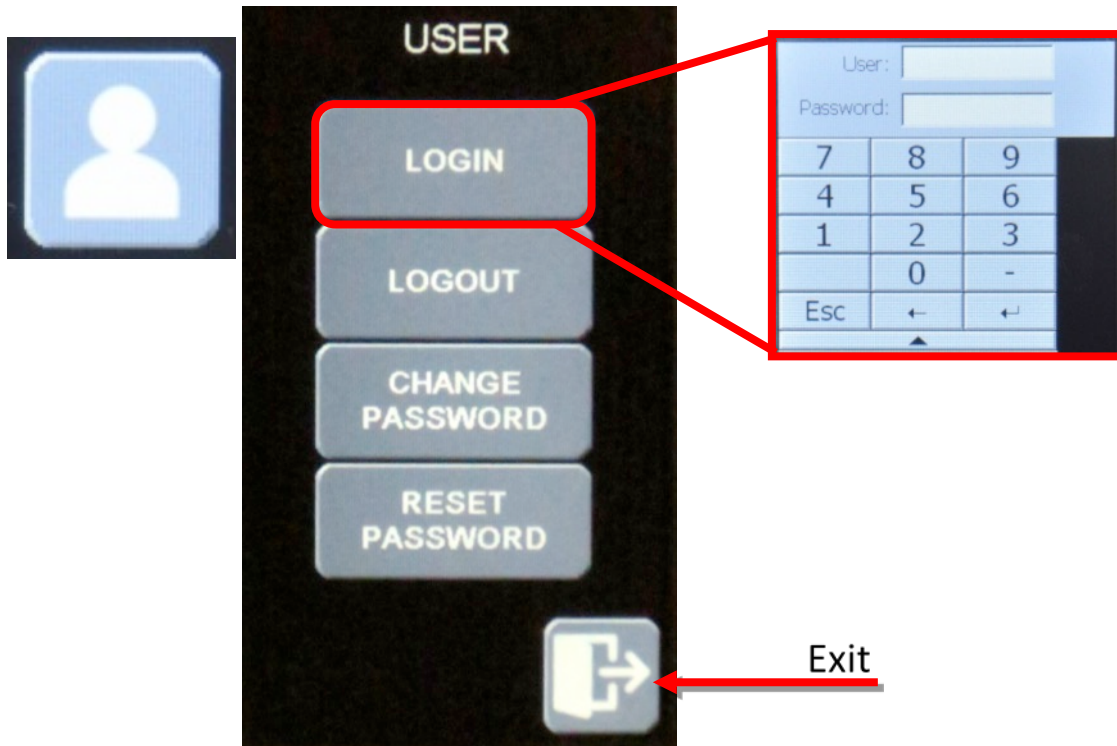
Labels of all available sections. (access is limited by user)

Default settings do not allow the basic user to modify any of the oven's parameters. It is possible to automatically enable the advanced user's authorizations when the oven is powered on.

PERMISSIONS	BASIC USER	ADVANCED USER	TECHNICIAN USER
Set Cooking time	X <sup>1</sup>	X	X
Set Top Temperature	X <sup>1</sup>	X	X
Set Bottom Temperature	X <sup>1</sup>	X	X
Set Convection Speed	X <sup>1</sup>	X	X
Load Recipe	X	X	X
Save Recipe	-	X	X
Access Alarm page	X	X	X
Access User Login Page	X	X	X
Access Statistics page	X	X	X
Access About page	X	X	X
Access Monitoring page	X	X	X
Access Lubrication page	-	X	X
Access Setting page	-	X	X
Access Date & Clock page	-	X	X
Access Maintenance page	-	X	X
Access Configuration page	-	-	X
Access Input/Output page	-	-	X

<sup>1</sup> Authorizations can be granted by the Advanced User. See User Manual.

Opens the login menu.



Technician users can login using the following credentials:

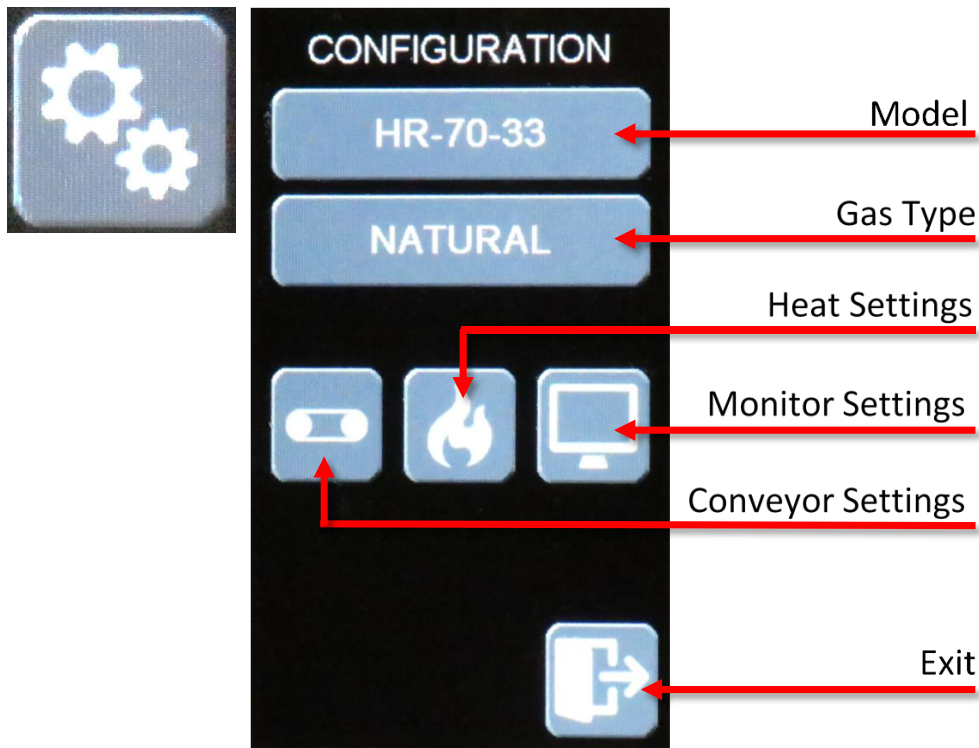
**User: 1**

**Password: 1234**

This menu also allows a technician user to change their password or reset it. The technician user can also log out to be sure that their settings won't be changed.

After 15 minutes without touching the screen, the technician user will be automatically logged out resetting rights to those of the basic user.

## 2.1.3 Configuration



### Model

Allows to select between three models of Hot Rocks Oven:

- HR7022
- HR7033
- HR9333

### Gas type

Allows to select the type of gas:

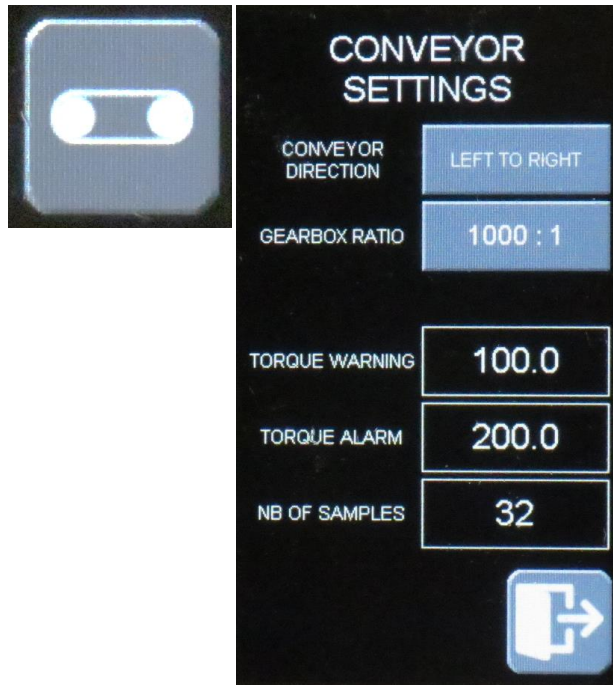
- Propane
- Natural Gas

### Monitor settings

Opens the monitor settings.

## Conveyor Settings

Shows the conveyor setting page.



This page allows the followings changes:

### CONVEYOR DIRECTION

- Left to right
- Right to left

### GEARBOX RATIO

- 1000:1 (cooking ratio 2 to 30 min)
- 435: 1 (cooking ratio 1 to 15 min)

Shows the settings of the torque limiter:

### Torque Warning

Maximum torque percentage allowed before sending a warning on the user interface.

### Torque Alarm

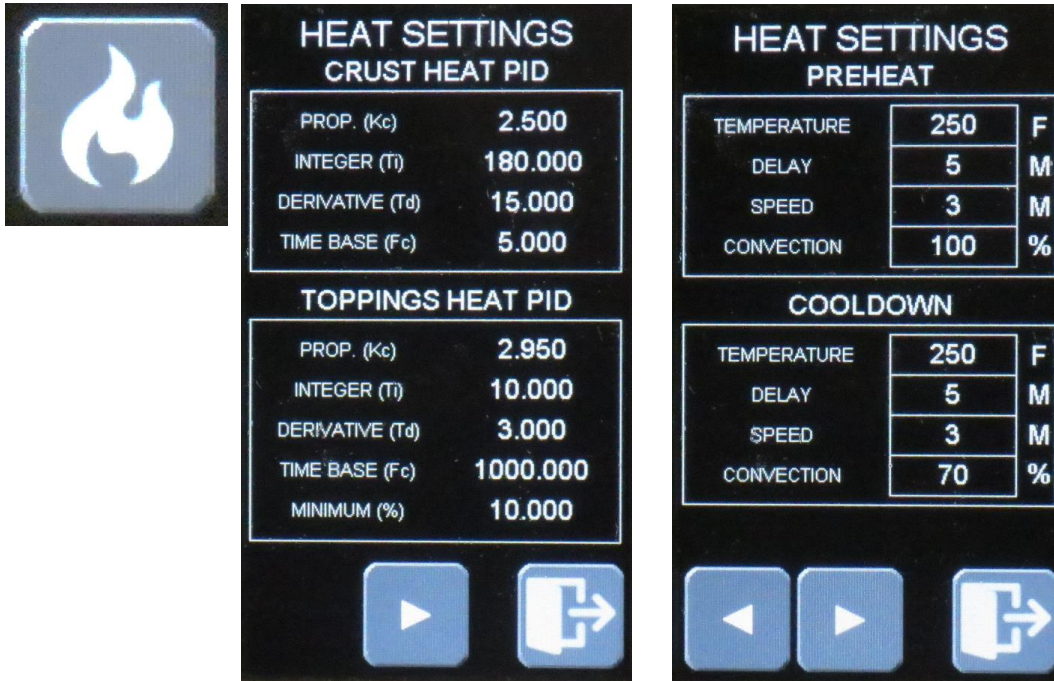
Maximum torque percentage allowed before sending an alarm on the user interface.

### Nb of sample

The number of cycles the oven will try before sending a warning or alarm.

## Heat Settings

Shows the heat setting menu.



This menu has three pages as shown below.

The first page shows the PID control settings.

The second page shows the preheat and cooldown modes. The following can be adjusted:

### Temperature

The temperature to reach to finish the mode

- 250°F for the preheat mode
- 250°F for the cooldown mode

### Delay

The delay the oven needs to remain at the set temperature to finish the mode

- 5 minutes for the preheat mode
- 5 minutes for the cooldown mode

### Speed

The cooking time during these modes

- 3 minutes for the preheat mode
- 3 minutes for the cooldown mode

### Convection

The fan speed during these modes

- 100% for the preheat mode
- 70% for the cooldown mode

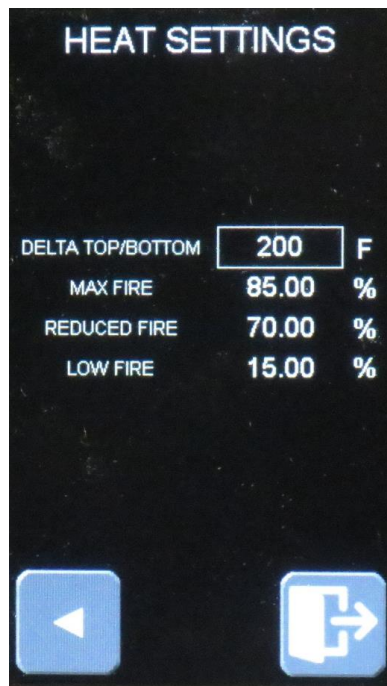
The third page show the burner parameters.

### **Delta Top/Bottom**

The max temperature allowed between the top temperature and the bottom temperature.

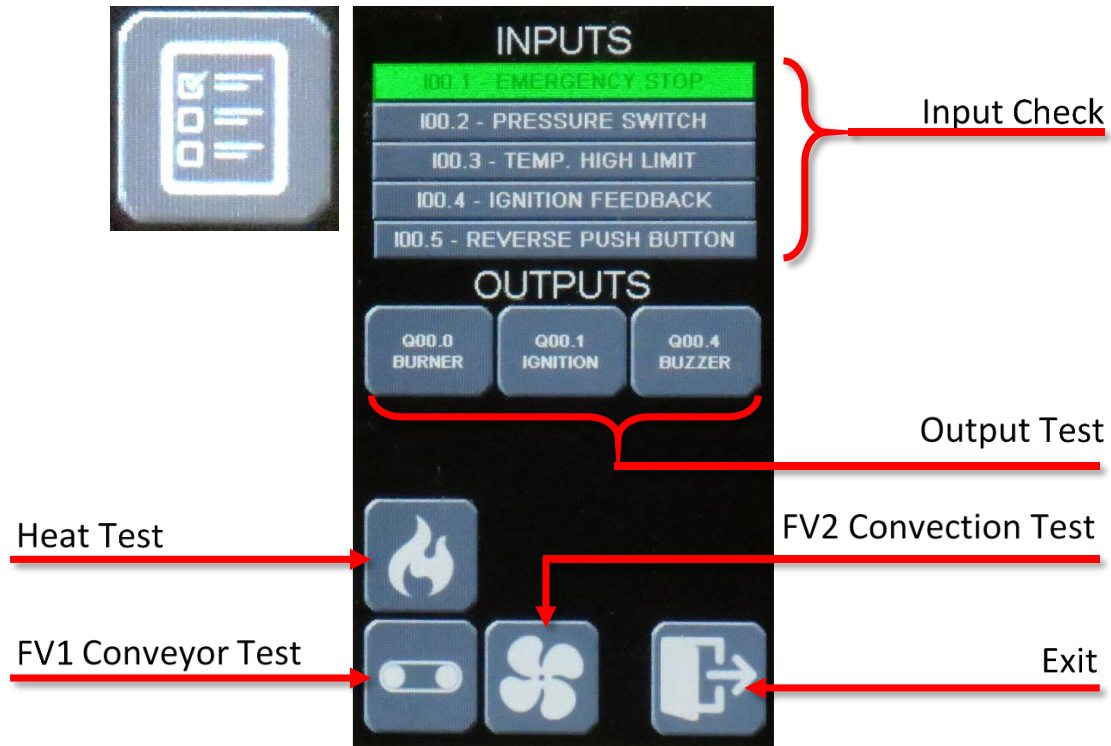
### **Max Fire, Reduce Fire, Low Fire**

These settings are completed at the factory and will differ between models.



## 2.1.4 Input/Output

This button opens the configuration page.



### Input Check

These squares show which PLC inputs are used. The numbers shown at the start of each input are related to the PLC "input" pinout.

- I00.1 - EMERGENCY STOP: Test by engaging any of the emergency stop buttons on the oven.
- I00.2 - PRESSURE SWITCH: Test by disconnecting the pressure switch cable on the rear of the oven located next to the gas entry.
- I00.3 - TEMP. HIGH LIMIT: This value comes from the high limit display on the rear of the oven located next to the gas entry.
- I00.4 - IGNITION FEEDBACK: This value comes from the ignition box located in the electrical panel; used to confirm flame detection.
- I00.5 - REVERSE PUSH BUTTON: Test by engaging any of the reverse buttons on the oven.



## Output Test

These squares show which PLC outputs are used. The numbers shown at the start of each output are related to the PLC “output” pinout.

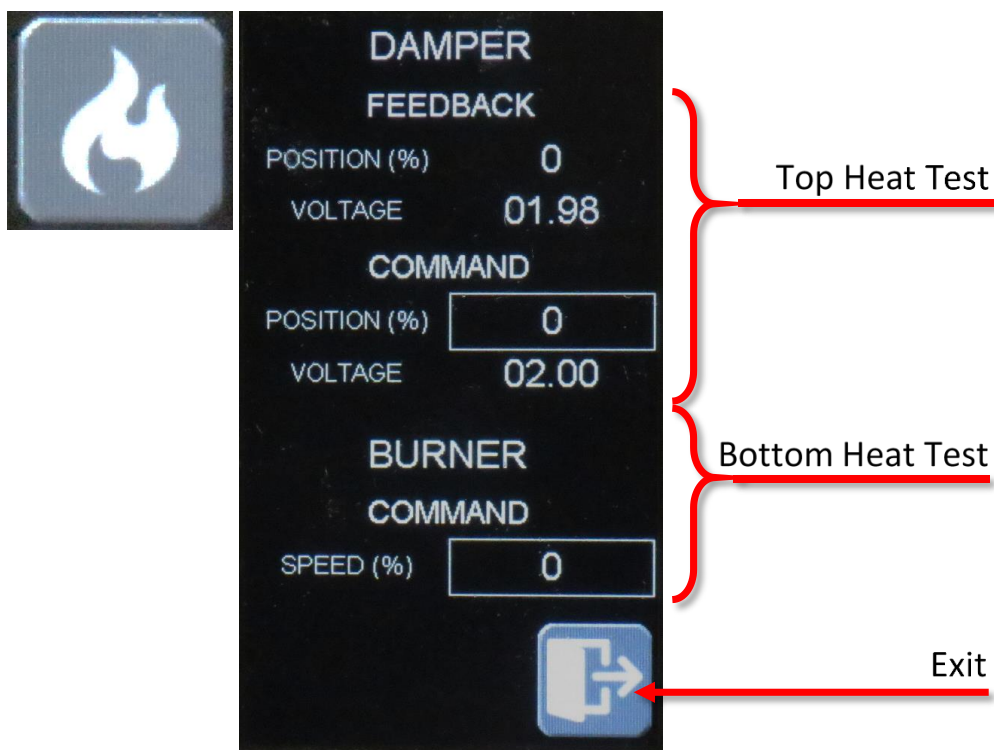
Q00.1 - BURNER: This button tests the burner’s fan.

Q00.2 - IGNITION: This button tests the ignition.

Q00.3 - BUZZER: This button tests the buzzer.

## Heat Test

This button opens the heat control menu.

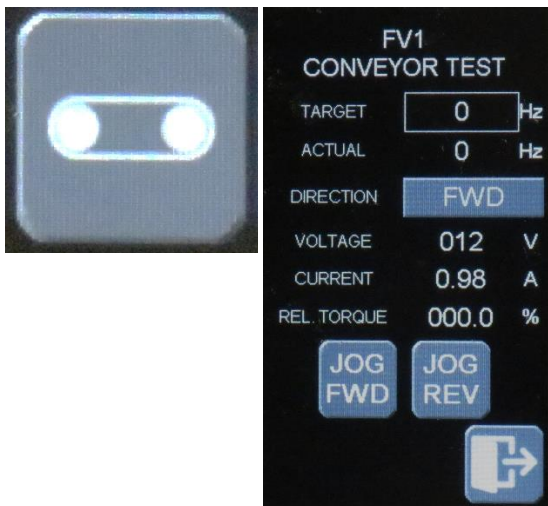


The Top Heat Test section tests and verifies the damper position. Insert a percentage value in the COMMAND section, and verify that the position is correctly reached in the FEEDBACK section.

The Bottom Heat Test section test the burner’s fan speed. Insert a percentage value in the COMMAND section, and verify that the speed changes by listening to the blower’s noise increasing or decreasing. There is no FEEDBACK on this value.

## FV1 Conveyor Test

This button opens into the FV1 CONVEYOR TEST page.



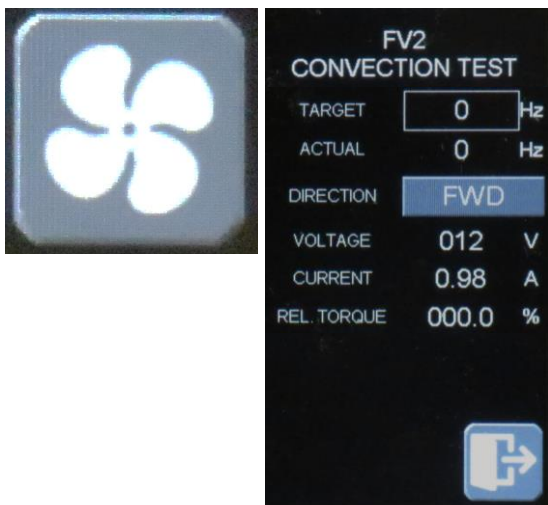
Insert a specific hertz in the TARGET box and verify that the drive is sending this information in the ACTUAL box.

**DIRECTION** changes the direction of the conveyor.

**\* Note: The change of direction is only for the test. It does not permanently change the direction setting. JOG FWD will move the stone conveyor forward and JOG REV will run it backwards.**

## FV2 Convection Test

This button opens into the FV1 CONVEYOR TEST page.



Insert a specific hertz in the TARGET box and verify that the drive is sending this information in the ACTUAL box.

**DIRECTION** changes the direction of the conveyor.

**\* Note: The change of direction is only for the test, and does not permanently change the direction setting.**

# 3. INSTALLATION

Prior to the installation, ensure the following:

- The entrance of the building, all the way to the desired location respects the overall dimensions of the oven model. See section 2.1 for measurements.
- The oven will not be enclosed, and there is a proper venting hood.
- The connections required to start the oven are already installed and verified to be working.
- A minimum of 6 inches of clearance all around the oven.

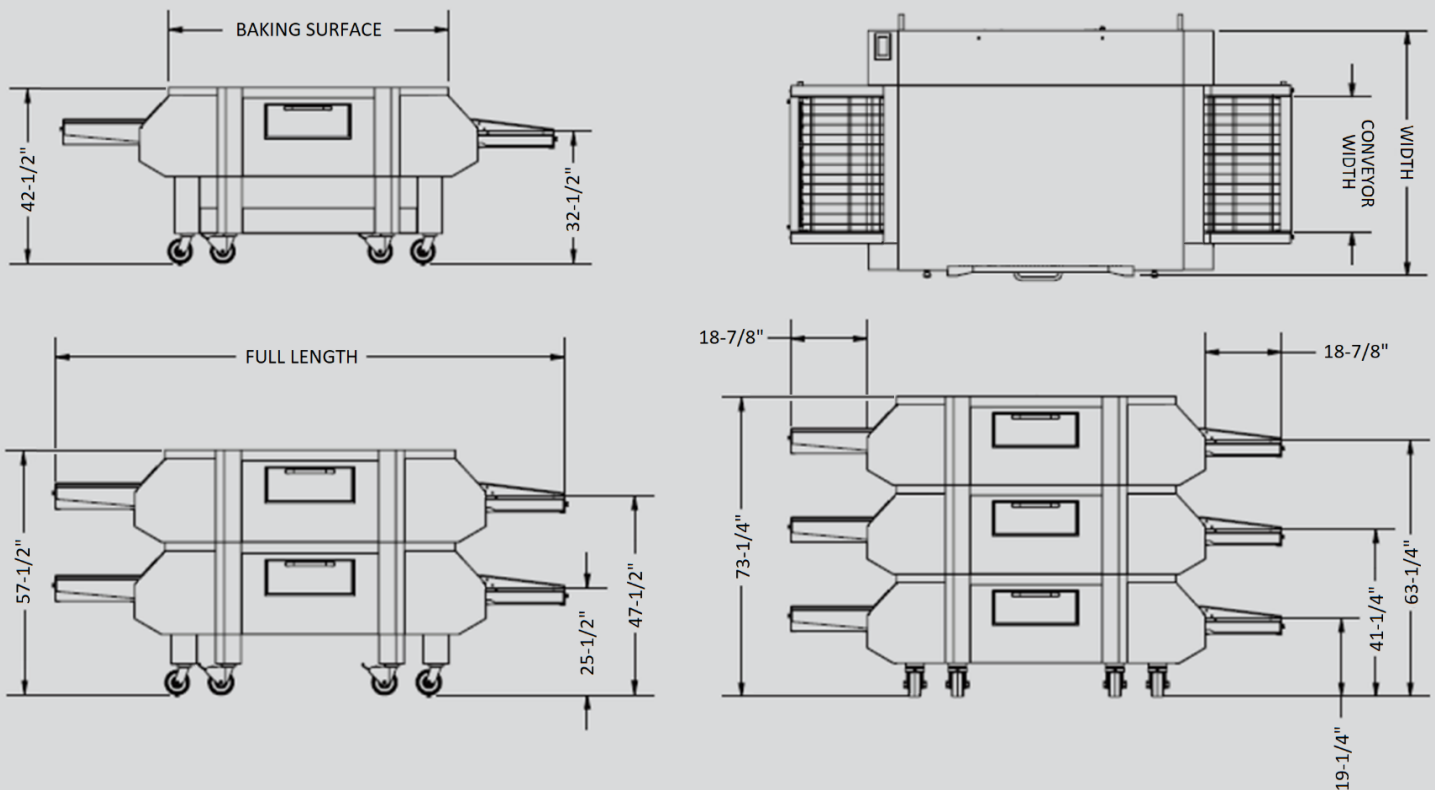
Refer to the [Hot Rocks specification sheet](#) for installation requirements.

## 3.1 Moving the ovens

### 3.1.1 Shipping

The Hot Rocks oven can be shipped in two different configurations depending on the entryway available to bring the oven in the location. Refer to the [specification sheet](#) available on the Hot Rocks website for more information.

### 3.1.2 Oven dimensions



### 3.1.3 Oven assembly

The main oven parts are shipped in a crate. Fragile and removable parts are shipped in separate packaging.

1. Bring all packaging into the location. Lift equipment will be required to move crates.
2. Uncrate the first oven deck then install legs and wheels.
3. If the oven was shipped vertically, flip the oven onto its wheels.
4. Flip the other oven decks and stack them. A video showing this procedure is available on the [Hot Rocks Ovens YouTube page](#). When stacking multiple ovens, silicone must be applied between each unit to provide a proper sanitary seal.
5. Determine the proper method to dispose of waste from the local office of the Environmental Protection Agency. Recycling centers are established to properly dispose of materials in an environmentally safe fashion.

### 3.2 Start-up ovens

The first start-up of the oven must be performed by an authorized technician. Fill the installation checklist located in the appendix of this document and send the completed copy to the service department.

#### 3.2.1 Complete the assembly

##### 1. Silicone seal



#### **WARNING**

**Make sure that the silicone seal is smooth with no bubbles; it must not allow food particles in between units.**

## 2. Stone installation

Power on the oven and access to the JOG menu as shown in section 2.1.4. Install all stones using a torque of 105 lbs-in.

## 3. Install entry and exit conveyors

### 4. Physically inspect the oven

Take notes and photos of any scratches on the oven. Report these to the Hot Rocks service department.

## 3.2.2 Installation check list

The installation check list (See appendix) is the key to perform the final validation of the install. Complete one check list for each oven. Once completed, the list(s) must be sent to the service department by [email](#). The original may remain in the technician's manual with the oven.

For more information on the installation check list, contact the Hot rocks customer service at 1 800 668-1883 or [support@hotrocksoven.com](mailto:support@hotrocksoven.com).

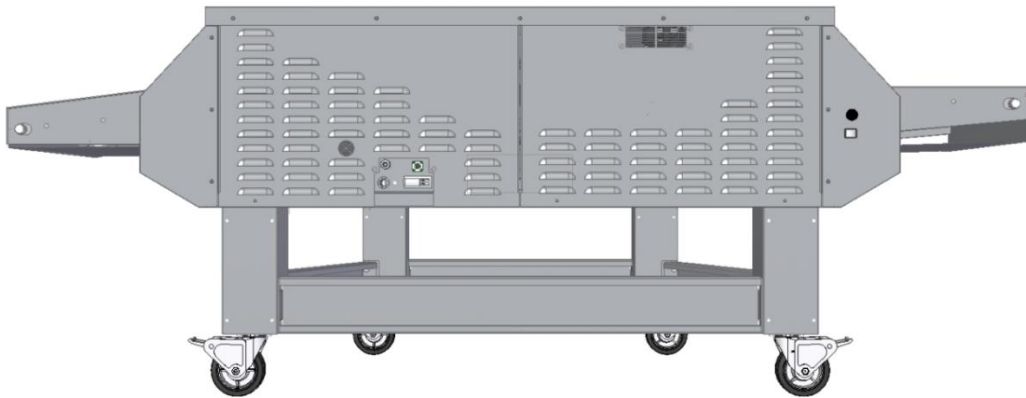
## 4. MAINTENANCE – 6 MONTH

This maintenance must be performed every 6 months. A reminder on the user interface will appear whenever the maintenance is due.

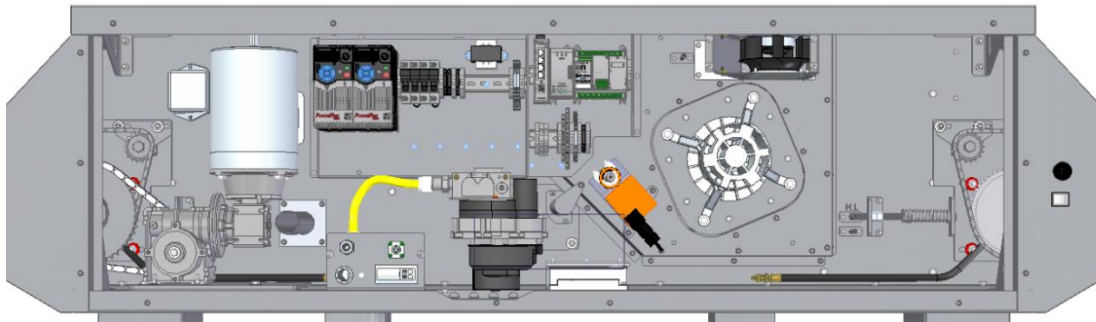
The [Hot Rocks Oven YouTube channel](#) has videos on how to perform all maintenance.

### 4.1 Main Bearings Lubrication

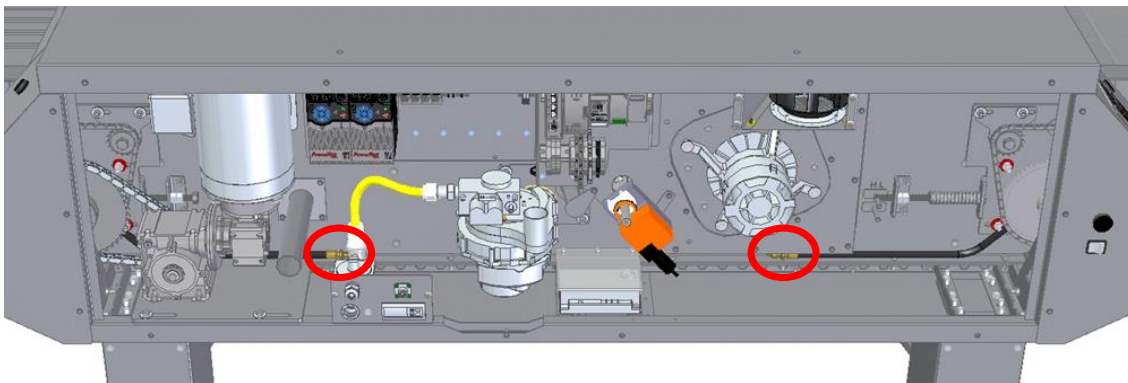
#### 4.1.1 Back Side Bearings Lubrication



1. Access the back of the oven.



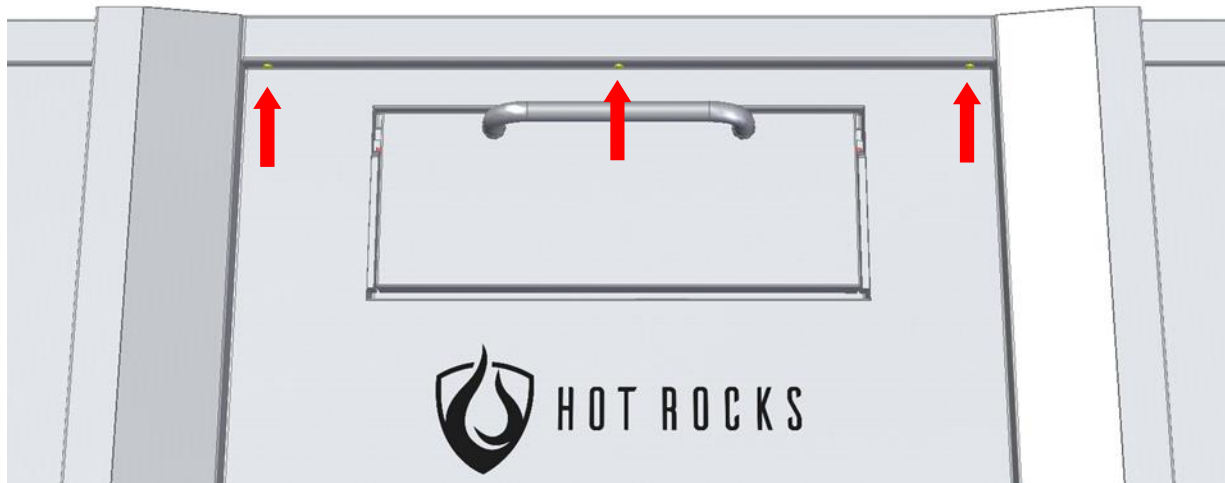
2. Remove the back panels.



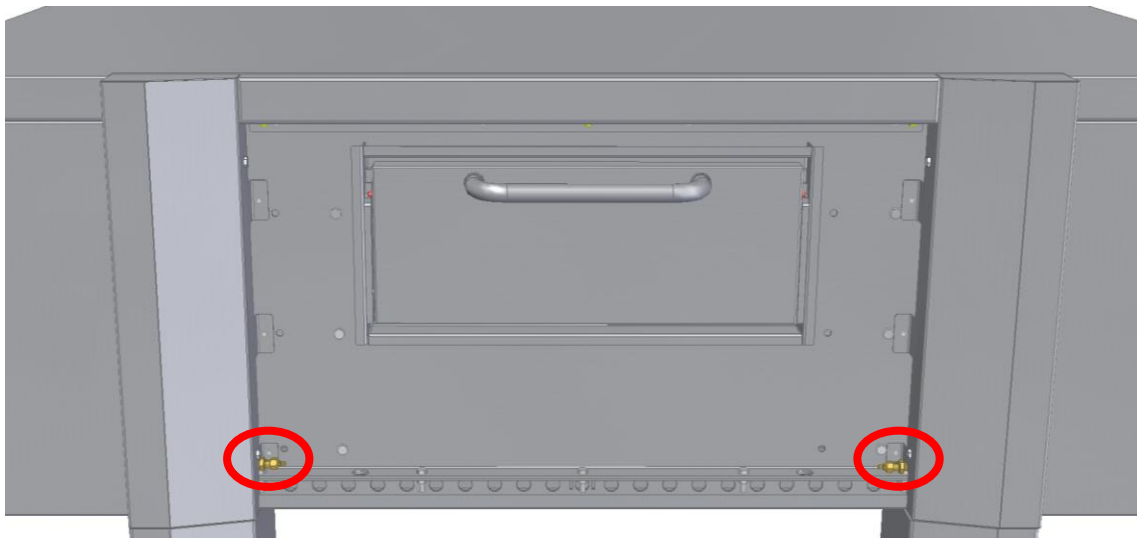
3. Locate the two grease points highlighted in the above illustration. Using a grease gun and food Grade high temperature lubricant (FO75-0015) grease the two points. To verify if done properly, check if grease is coming out of the bearings.

4. Reassemble the back panels.

## 4.1.2 Front Side Bearings Lubrication



1. Remove the front panel, around the door.

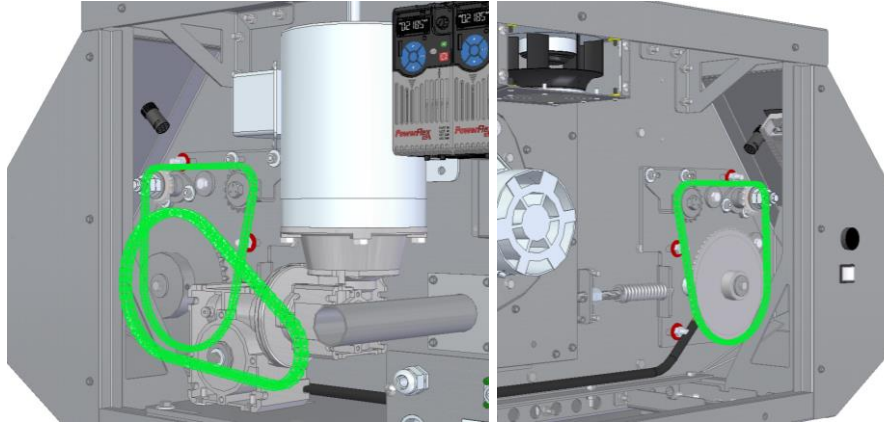


2. Locate the two grease points highlighted in the above illustration. Using a grease gun and food grade high temperature lubricant (FO75-0015) grease the two points. To verify if done properly, check if grease is coming out of the bearings.

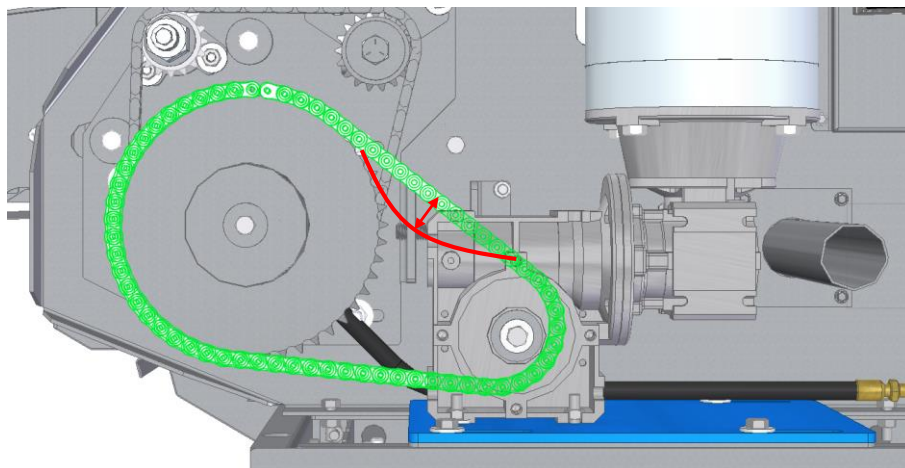
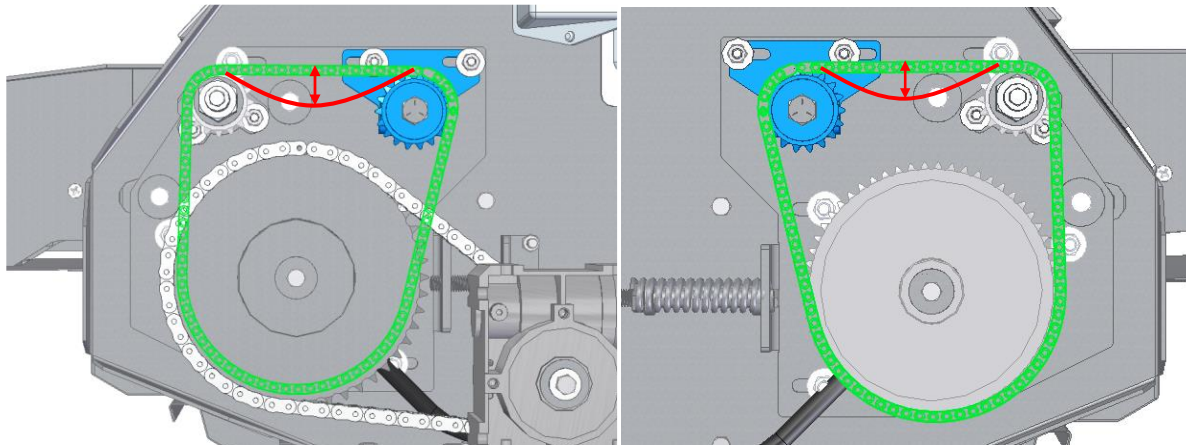
3. Reassemble the front panel.

## 4.2 Chain lubrication

### 4.2.1 Back side chains lubrication and adjustment



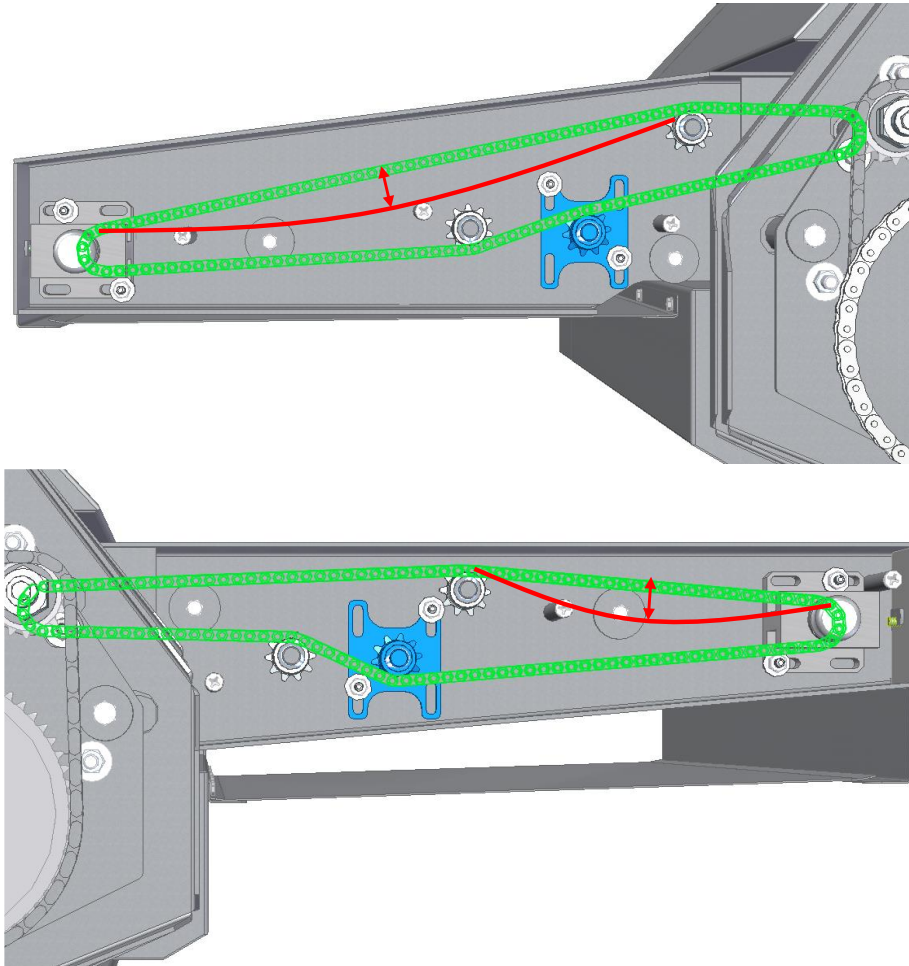
1. Remove the back panels.
2. Apply the food-grade high temperature lubricant on all visible chains and sprockets. See the green highlights in the above illustration for where the chains are located.
3. Verify that chains have proper adjustments. The bending of the chains (shown by the red arrows below) should not exceed a bend of more than 6 mm (0,25 inch).



4. If required, adjust chains by using the tensioner shown in blue on the illustrations..



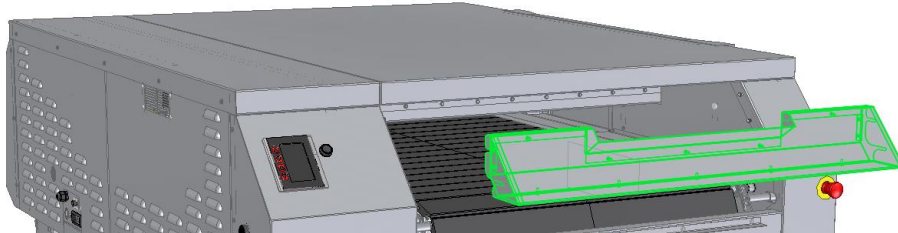
## 4.2.2 Lubrication and adjustment of entry and exit conveyor



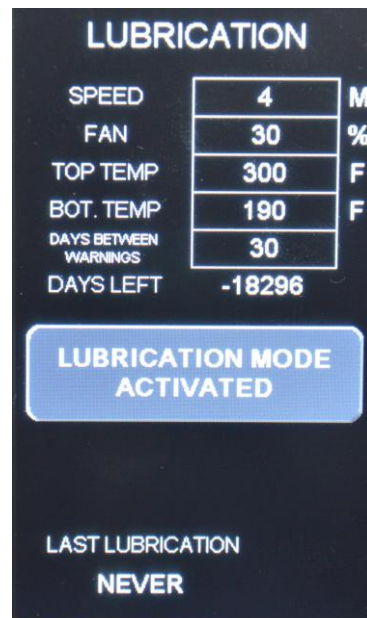
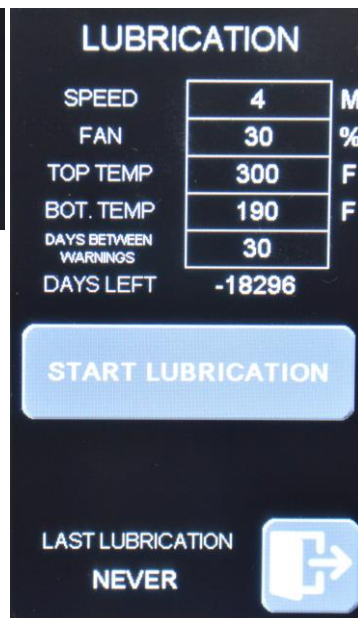
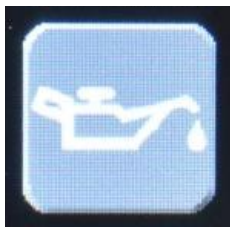
1. Keeping the conveyor arms attached to the oven, remove the back panels of each arm.
2. Apply the food-grade high temperature lubricant on all visible chains and sprockets. See the green highlights in the above illustration for where the chains are located.
3. Verify that chains have proper adjustments. The bending of the chains (shown by the red arrows below) should not exceed a bend of more than 6 mm (0,25 inch).
4. If required, adjust chains by using the tensioner shown in blue on the illustrations.

## 4.3 Main Conveyor Lubrication

1. Make sure the oven is cold before starting this procedure.
2. Remove the end cover and the entry conveyor.



3. On the HMI screen, go to the lubrication setup page and select “start lubrication.” The oven will adjust itself to the proper settings for the lubrication.

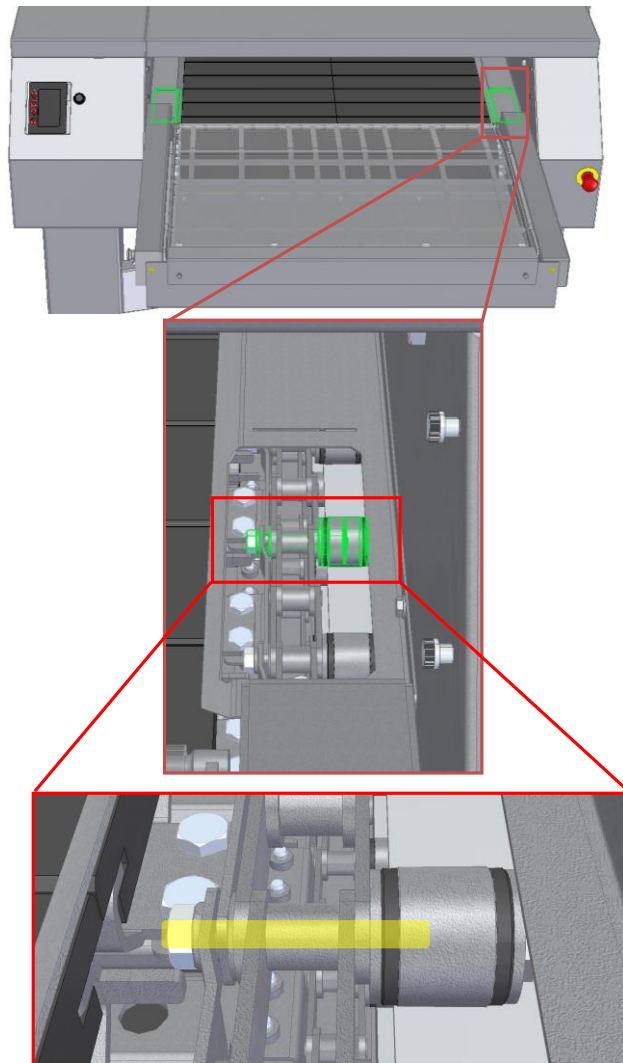


4. On average, wait about 30 minutes for the oven reach the lubrication settings.
5. Locate the lubricant (FO75-0050) and shake well for 2 minutes.

This lubricant is food grade quality and has been designed specifically for application on these ovens. No other lubricant will provide the correct coverage. Note: using a different lubricant type will void the warranty on these parts.

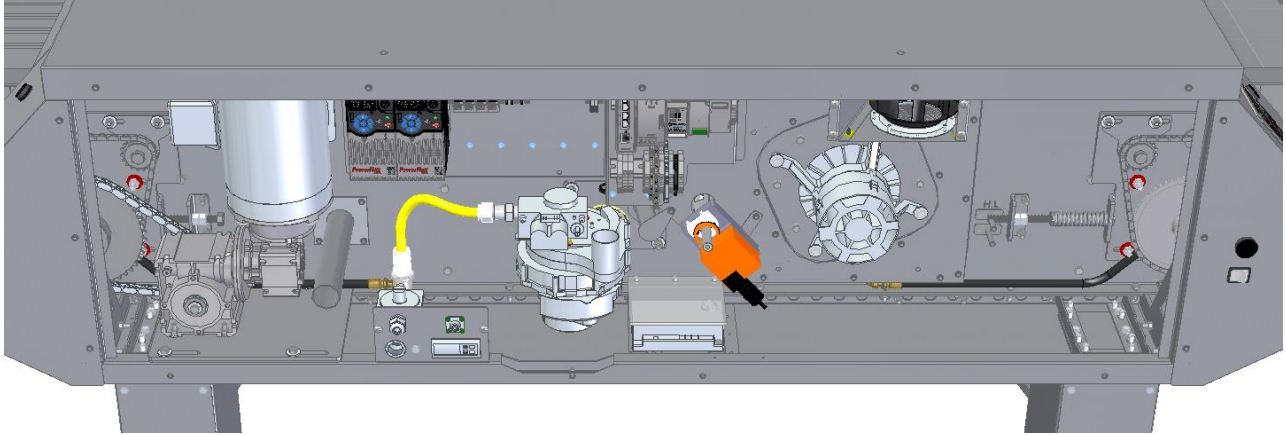


6. Apply the approved lubricant to each link of the chain as shown by a yellow strip in the illustration below. This needs to be done on both sides of the chain. There is 6 months worth of lubricant in one container.



7. After applying lubricant on both chains, leave the oven functioning for 30 minutes to allow the lubricant to evaporate.
8. Reassemble the removed parts, and put the oven back into normal usage. Depending on the amount of lubricant applied, the excess will still continue to evaporate. The evaporation will produce an odourful non-toxic fume.

## 4.4 Cleaning of the electrical cabinet



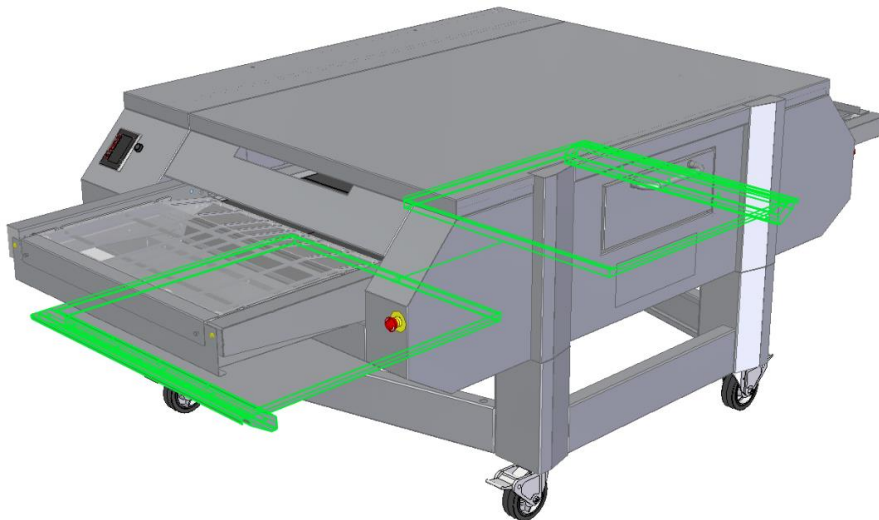
1. Remove the back panels.
2. Vacuum and wipe out any dust or debris.
3. Reassemble the back panels



### **WARNING**

**Always use a vacuum for cleaning.  
It is prohibited to use pressurized air inside the electrical cabinet.**

## 4.5 Inspection the condition of the stone conveyor crumbs trays

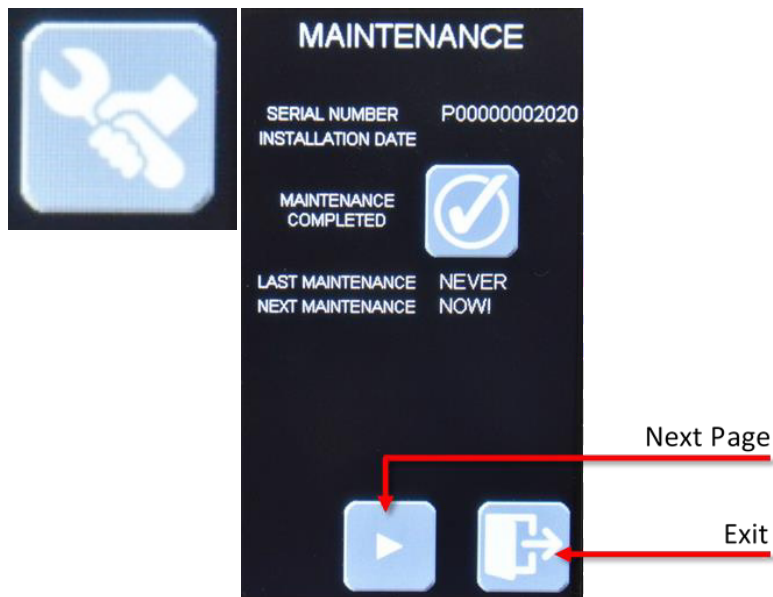


1. Remove both the stone conveyor crumbs trays and inspect if they are clean or if there is a major accumulation of particles.
2. If a major accumulation is found, make sure to let the manager know and explain problems that can arise when proper maintenance is not performed

## 4.6 General inspection (Skip to Maintenance – 12 month if needed)



1. Reassemble all oven parts and test the to make sure everything is working as intended:
  - Front access door opens properly
  - Both emergency stop buttons engage and disengage
  - Cooling fan works
  - Inspect the flame through the eye sight for proper colour and strength
  - Verify that conveyors are adjusted properly
2. Debrief the manager on what was done and make recommendations including comments on the daily maintenance of the oven.
3. Report anything that should be followed-up in the next preventive maintenance visit to the Hot Rocks service team.
4. Verify that there is enough lubricant left in the bottle. One bottle should last 6 months.
5. Confirm the maintenance in the “MAINTENANCE” page



## 5. MAINTENANCE – 12 MONTH

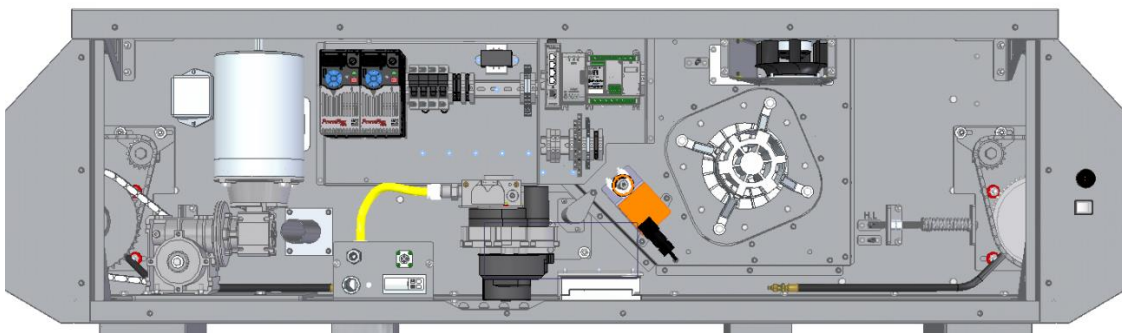
This maintenance must be performed every 12 months. A reminder on the user interface will appear whenever the maintenance is due.

The [Hot Rocks Oven YouTube channel](#) has videos on how to perform all maintenance.

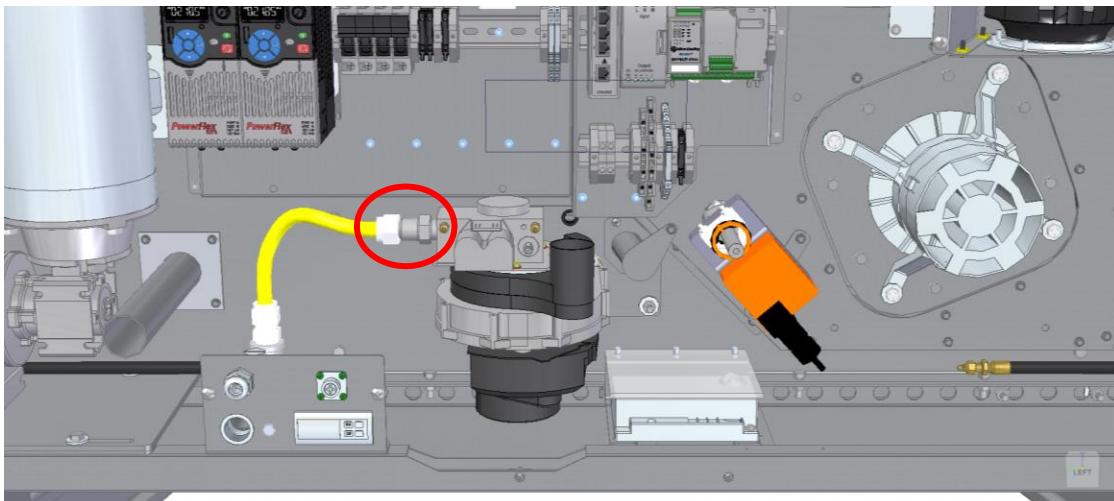
### 5.1 Replace spark and flame rod



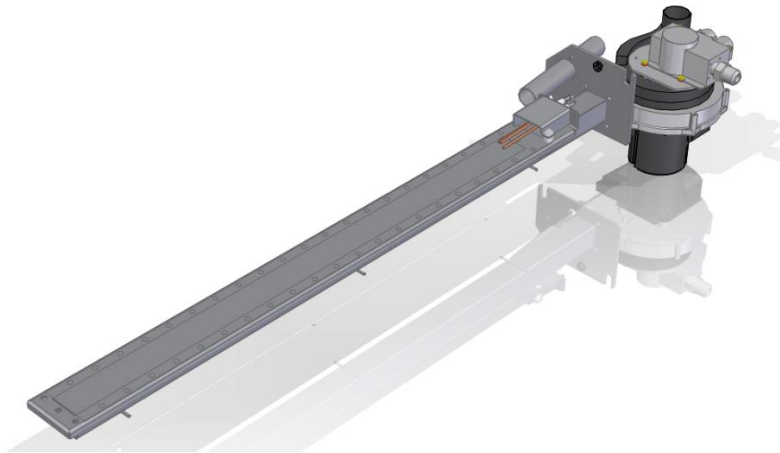
1. Access the back of the oven.



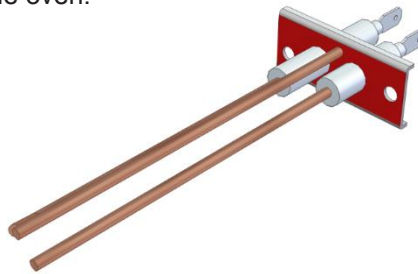
2. Remove the back panels.



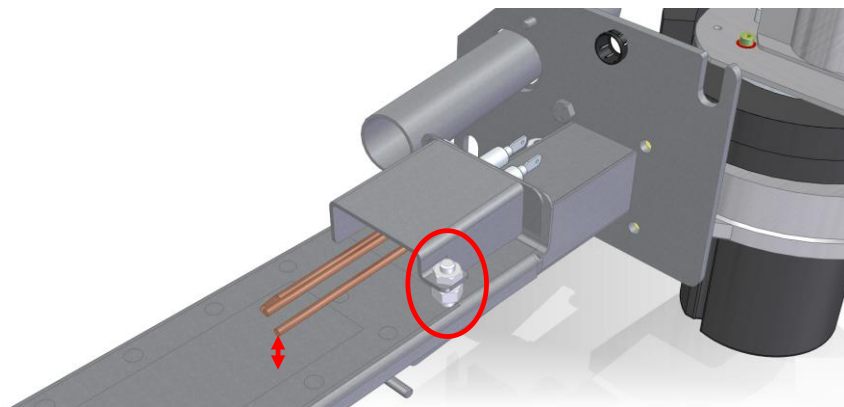
3. Disconnect the gas hose circled in red as well as the electrical wires.



4. Unscrew the two bolts holding the burner to the internal wall of the oven, and then pull forward to remove the burner from the oven.

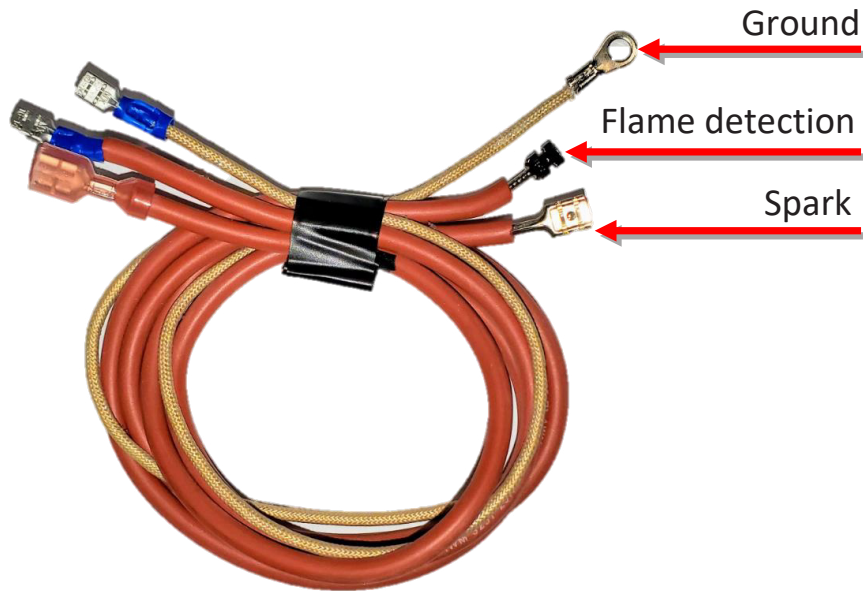


5. Remove the old electrode rod, and replace with the one located in the 12-month kit.
6. Apply a generous amount of electrical compound (code FO75-0044) to the electrode metal base (red zone). Do not put any electrical compound on the electrodes of the ceramic insulator (white zone).
7. Replace the ignition cables and connect it to the electrode rod and ground terminals.



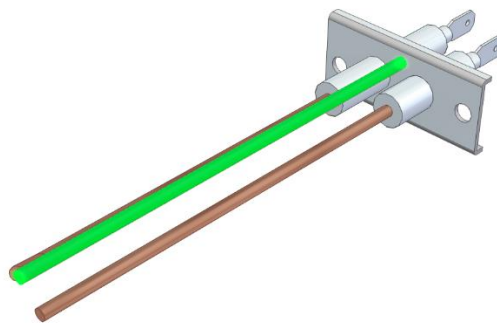
8. Adjust the flame sensing electrode (the straight rod, with the smallest ceramic insulator) to achieve a gap of exactly 6 mm (1/4 inch) between the end of the electrode and the mesh membrane of the burner terminals.

## 5.2 Replace ignition cables



1. Disconnect the ignition cables from the burner and the ignitor box. Use pliers to remove connectors from the ignitor box, thus preventing damage to the wires.
2. Inspect replacement cables to make sure they are in good condition.
3. Connect the replacement ignition cables the same way as the old ones.

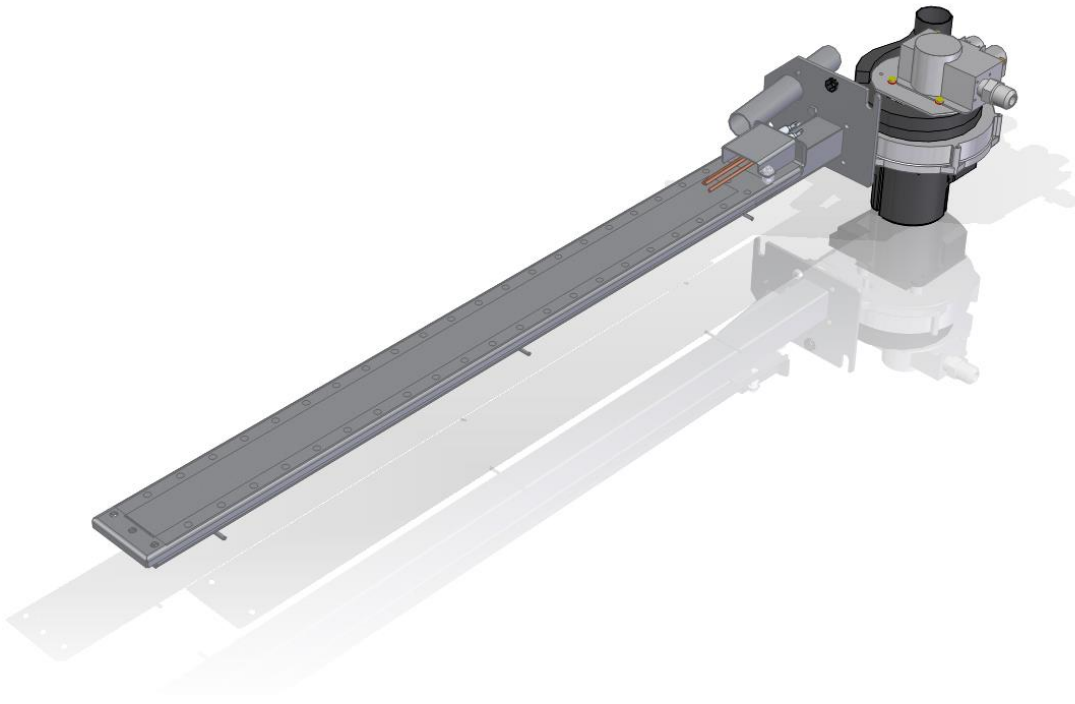
## 5.3 Inspect the ground conductivity



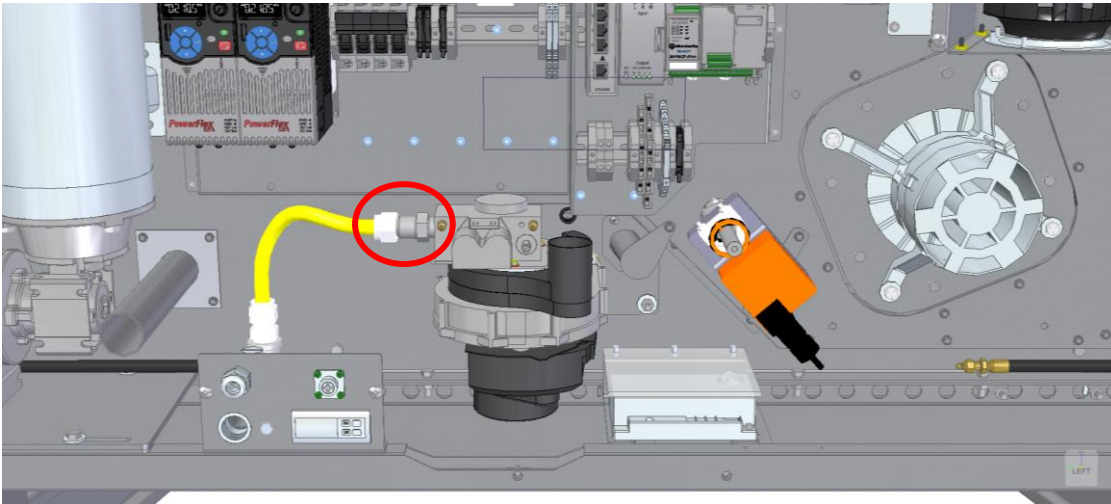
1. Using a multimeter, measure the resistance between the tip of the ground rod (shown in green) and the flat connector that attaches to the ignition box of the green ground wire.
2. The resistance must be less than 0.1 Ohms. If not, reapply electrical compounds (product code FO75-0044).



## 5.4 Inspect and clean the burner



1. Vacuum the burner, including its fan.
2. Verify the condition of the burner, check if the membrane is damaged and if there is rust or iron fillings.

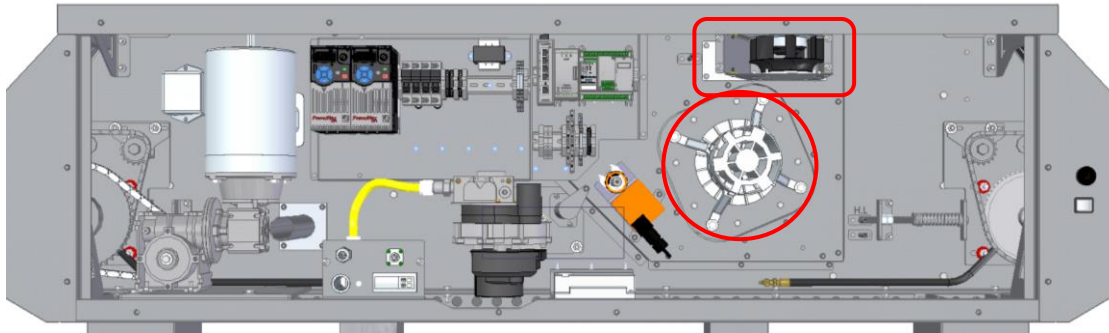


3. Reinstall the burner and reconnect the gas and the cables. Vacuum the electrical compartment while the back panel is removed.



**WARNING**  
Always use a vacuum for cleaning.  
It is prohibited to use pressurized air inside the electrical cabinet.

## 5.5 Inspect and clean fans



1. Vacuum the fans.
2. Inspect the fan motors for any problems or degradation.
3. Check for fan blades for damage or for anything that will obstruct the rotation of the fans.  
For the inspection the use of a small mirror is recommended.

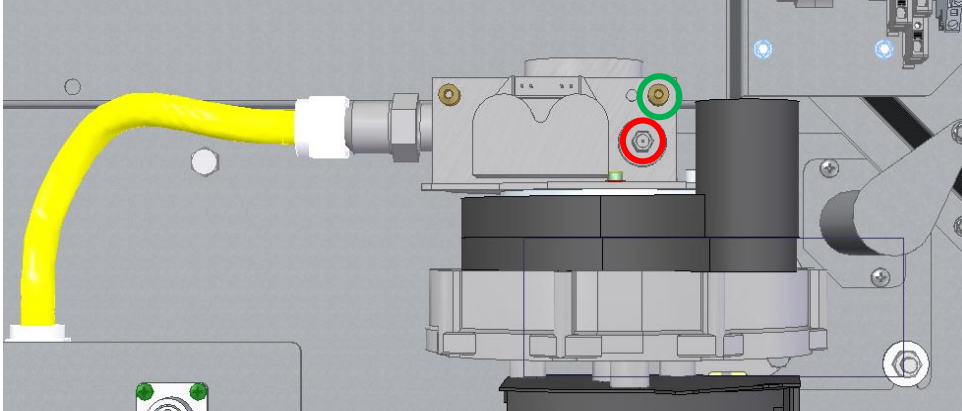


### **WARNING**

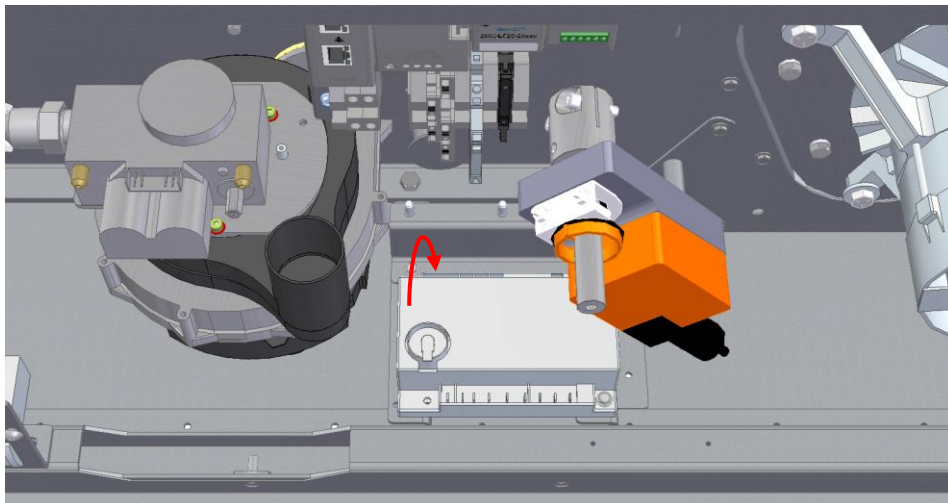
**Always use a vacuum for cleaning.**

**It is prohibited to use pressurized air inside the electrical cabinet.**

## 5.6 Verify the gas pressure



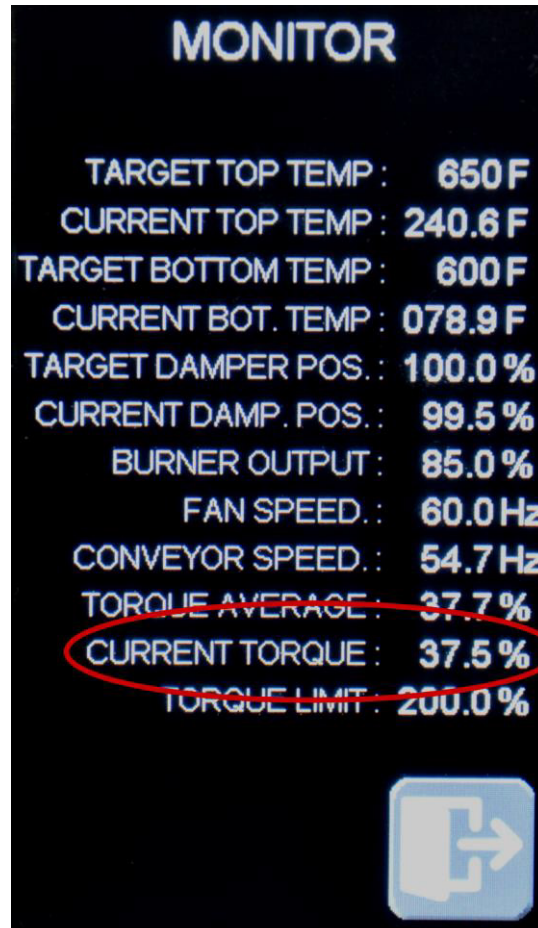
1. Start the oven, and let it drop to “low fire”. This will be reached when the temperature parameters are stabilized.
2. With a small flat screwdriver, unscrew the plug inside the right port (highlighted as a green circle in the above illustration) and plug a precision manometer. Configure the meter in differential mode to 0.00 inches of H<sub>2</sub>O to that port, then measure the pressure; it should be between -0.01 and 0.00 inches of H<sub>2</sub>O (small vacuum).
3. If the measurement is outside of the scope, adjust the low fire level using a hex key on the nut highlighted by a red circle).
4. Once the adjustment is confirmed correct, screw the plug back into the port



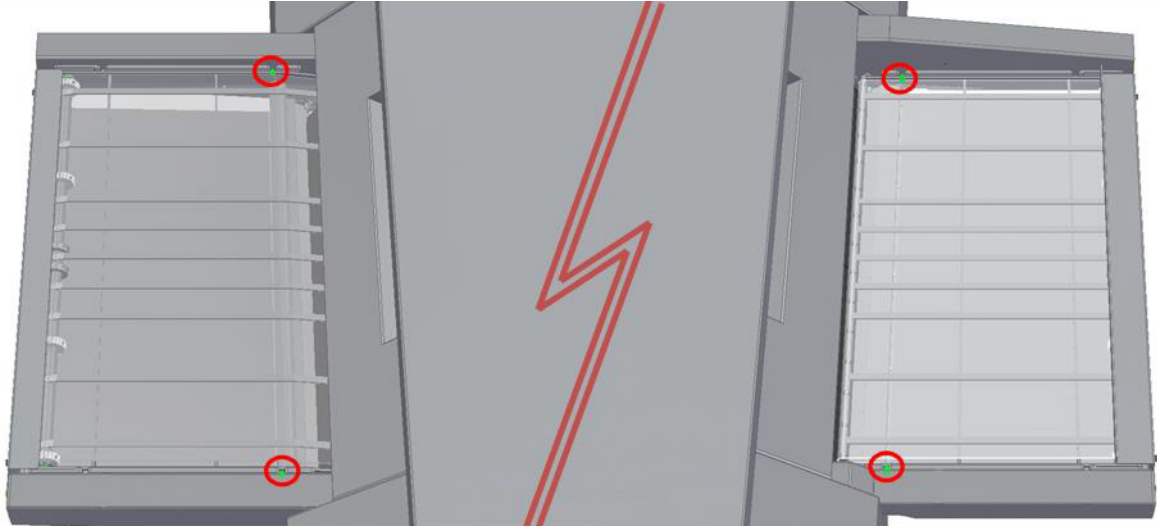
5. Using a multimeter, measure the current between terminal FC- and FC+ on the ignition control box. Readings should be at least 3  $\mu$ A at “low fire.” Typical is around 5.5  $\mu$ A.

## 5.7 Verify stone conveyor torque

1. Set the conveyor to the correct speed for the gearbox ratio:
  - a. 15 minutes for 1000:1
  - b. 7.5 minutes for 490:1
2. Enter the monitoring screen
3. Make sure the value of the current torque is between 36% and 45%.



## 5.8 Adjust the entry and exit conveyor

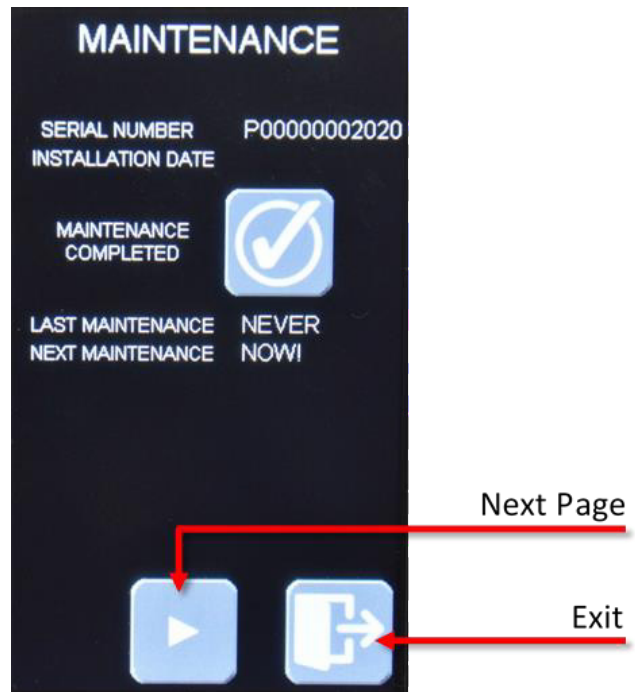


1. The adjustment of the entry and exit conveyors is done by adjusting the set screw circled in red. The minimum distance between underneath of the mesh belt and the top of the stone conveyor must be approximately 3 mm (1/8 inch).

## 5.9 General inspection



1. Reassemble all oven parts and test the to make sure everything is working as intended:
  - Front access door opens properly
  - Both emergency stop buttons engage and disengage
  - Cooling fan works
  - Inspect the flame through the eye sight for proper colour and strength
  - Verify that conveyors are adjusted properly
2. Debrief the manager on what was done and make recommendations including comments on the daily maintenance of the oven.
3. Report anything that should be followed-up in the next preventive maintenance visit to the Hot Rocks service team.
4. Verify that there is enough lubricant left in the bottle. One bottle should last 6 months.
5. Confirm the maintenance in the "MAINTENANCE" page



# 6 APPENDIX I – INSTALLATION CHECKLIST

## HOT ROCKS - INSTALLATION CHECK LIST

### INFORMATION

Customer business name

Today's Date

Oven model

Oven serial number

Oven position

WELCOME KIT given to the owner

### LOCATION INSPECTION

Gas connection already installed on site

Electrical connection already installed on site

Make sure hood size is respecting the minimum requirements

\*6 inch overhang all around the Hot Rocks

The ventilation interlocks have been installed by the customer?

Test the ventilation interlocks of each oven deck. Unplug the cable and confirm a pressure switch. failure appear on the main screen.

### HOT ROCKS PHYSICAL INSPECTION

Verify that large crumb trays under the main conveyor are placed correctly on both sides of the oven.

Verify the wire connections, the terminal strips and contacts for loose wires in the electrical cabinet.

Pull off the burner and verify that the flame sensing rod is at 1/4" from the burner's membrane.

Adjust rod if needed.

Verify that the spark rod is at 3/8" from the burner's membrane. Adjust rod if needed.

Verify that the spark rod to ground rod gap is 1/8". Adjust rod if needed.

Verify that the resistance from the ground rod to V2 terminal on the ignition box is 0 omh.

Verify the inlet gas pressure with the oven off (static pressure). Should be between 6 and 10 InH2O.

### RUN TEST

Power up the oven and set the oven with the following parameters.

- Bottom Temperature: 190°F

- Top Temperature: 225°F

- Fan: 100%

- Cooking time: 2 minutes

Measure the entry gas pressure. Should be between 6 and 10 InH2O.

Verify that the conveyor motor direction is correct versus the required oven exit side.

If not, reverse the direction on the screen.



- Verify the ventilation motor rotation. Should turn clockwise.
- Verify that both emergency stop buttons are working.
- Verify main power amperage. Use L1 or L2 coming from the main rocker switch. To do so, make sure the conveyor is running and fan output is 100%. Must be under 10 Amps.
- Measure current on the Fenwal ignition box test terminals (FC+) (FC-). Should be higher than 4mA.
- Set the oven with the following parameters 
  - Bottom Temperature: 190°F
  - Top Temperature: 310°F
  - Fan: 75%
  - Cooking time: 2:30 minutes
- Lubricate the main conveyor chain. See section 4.3.
- Set the oven with the following parameters and wait 30 minutes to let the oven stabilize: 
  - Bottom temperature: 400°F
  - Top temperature: 550°F
  - Fan: 100:
  - Cooking time: 5 minutes
- Verify bottom temperature accuracy with the monitoring screen. Bottom Temperature (+/-5°F).
- Verify top temperature accuracy with the monitoring screen. Top Temperature (+/- 15°F).
- Verify high limit temperature accuracy. High Limit Temperature (approx + 60°F).

**FINAL INSPECTION**

- Look for cracked stones.
- Verify that all the panels and covers are properly fastened.
- Clean up the ovens.
- Clean your work space.
- Have you done any damage to the oven or location? Report it.

**OWNER TRAINING**

- Show the customer the daily maintenance requirements of the oven. Use the wall chart in the welcome kit.
- Show the customer how to lube the main conveyor chain monthly.
- Explain to the customer that if there is an issue with the oven, he needs to contact the service department at 1 800 668-1883 or [support@hotrocksoven.com](mailto:support@hotrocksoven.com).

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Technician's name

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Technician's signature

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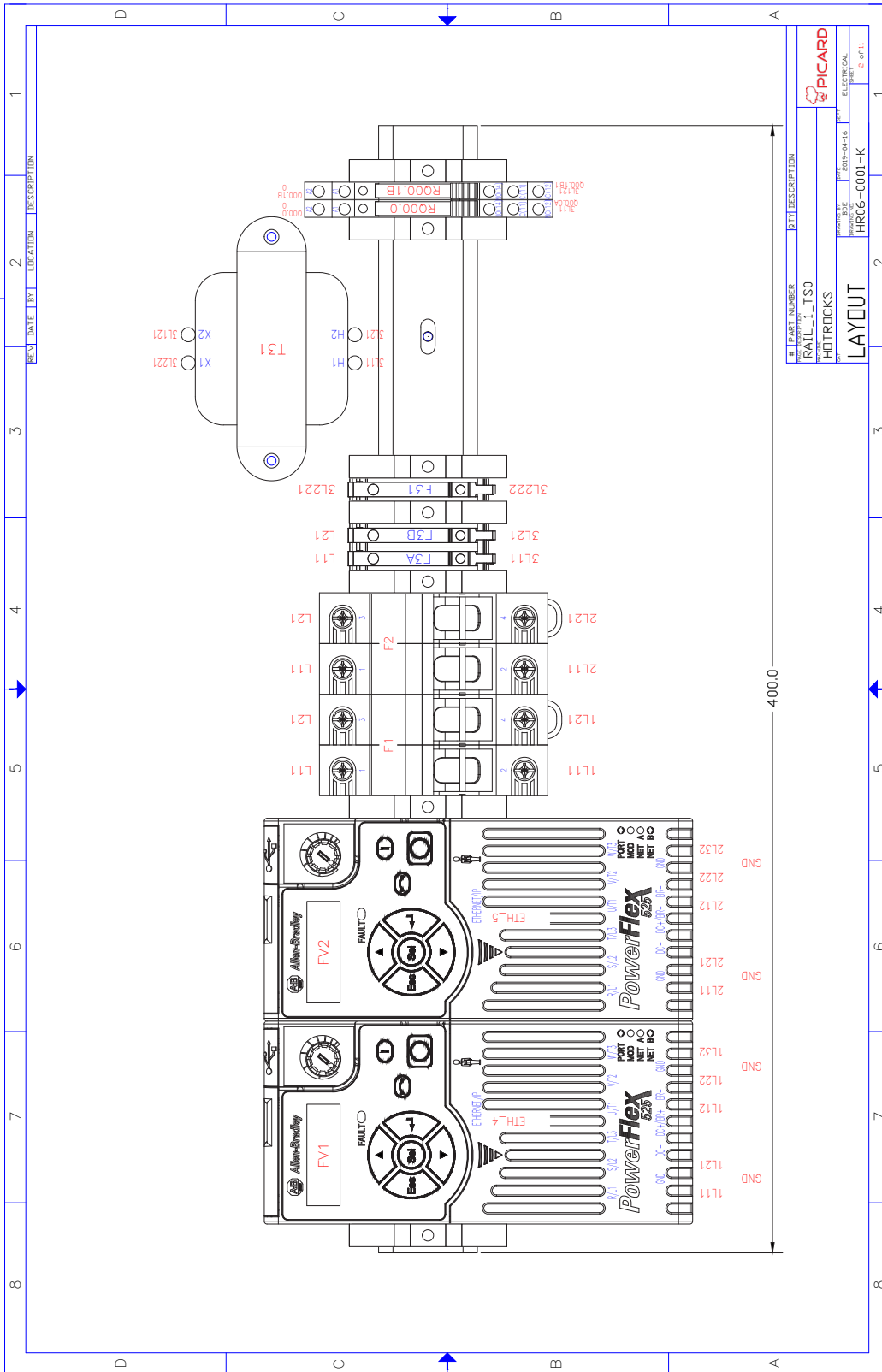
Customer's name

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Customer's signature

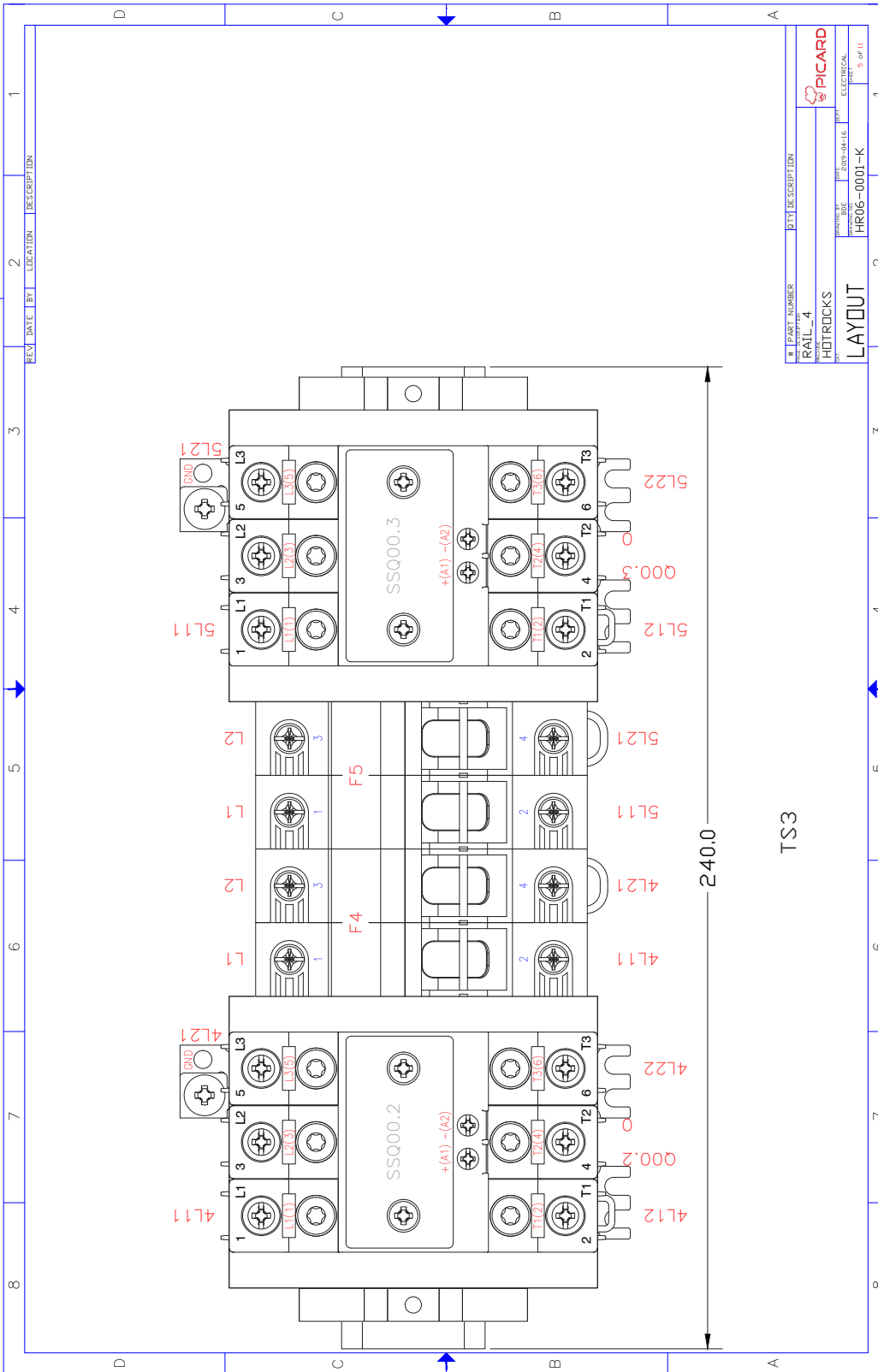












REV	DATE	BY	LOCATION	DESCRIPTION
1				
2				
3				
4				
5				
6				
7				
8				

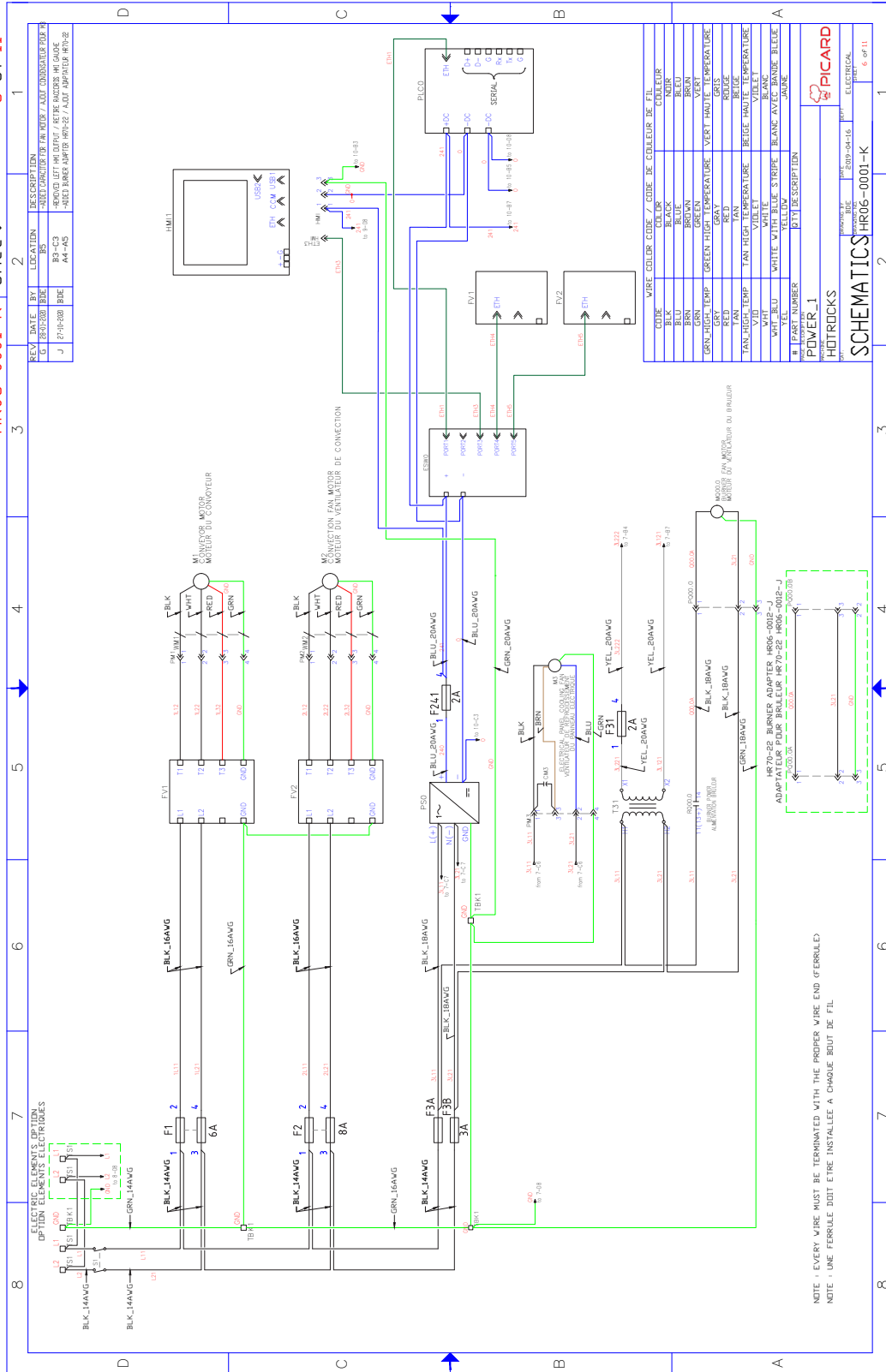
  

PART NUMBER	QTY	DESCRIPTION
RAIL_4		
HOTROCKS		

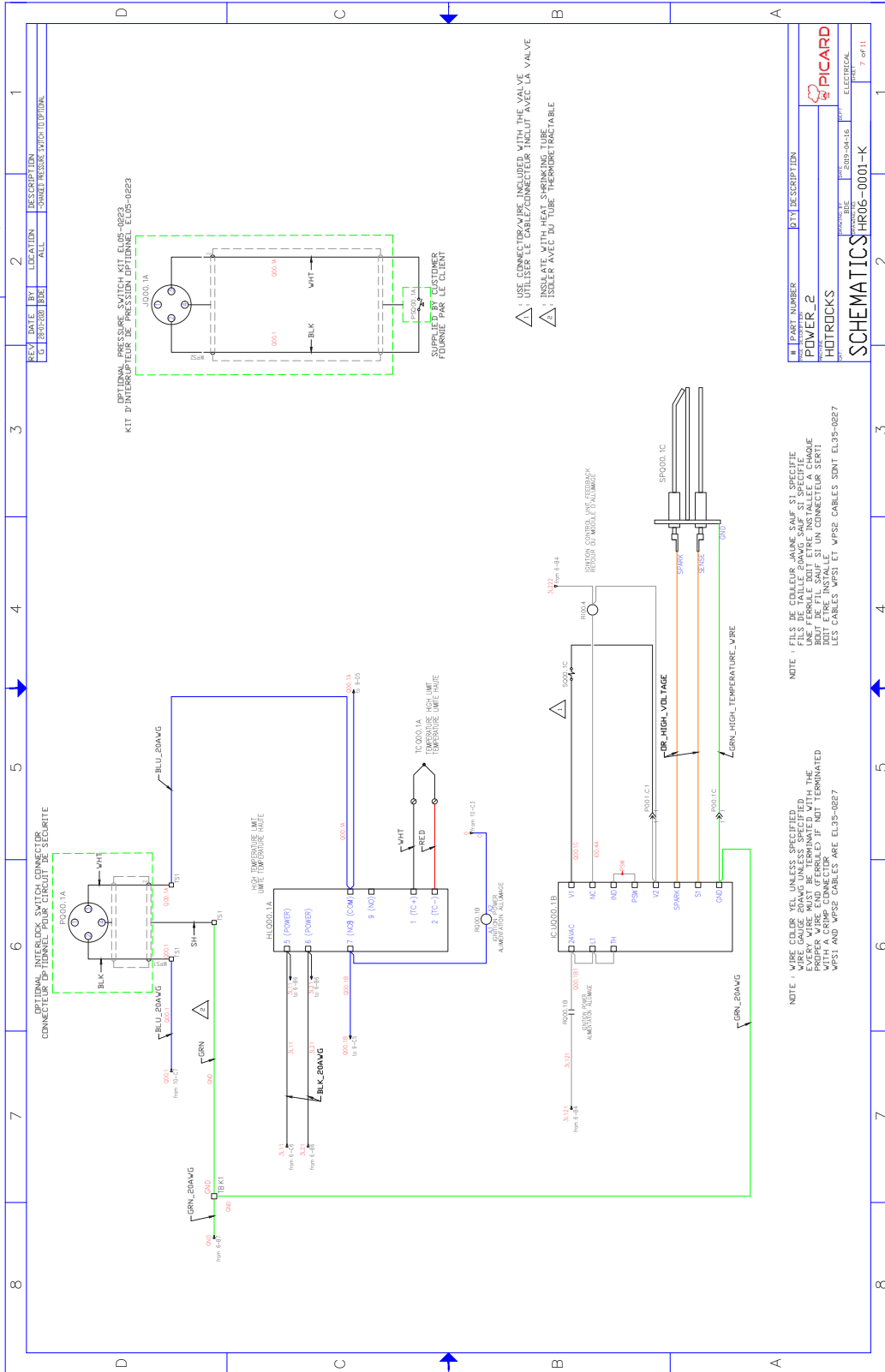
  

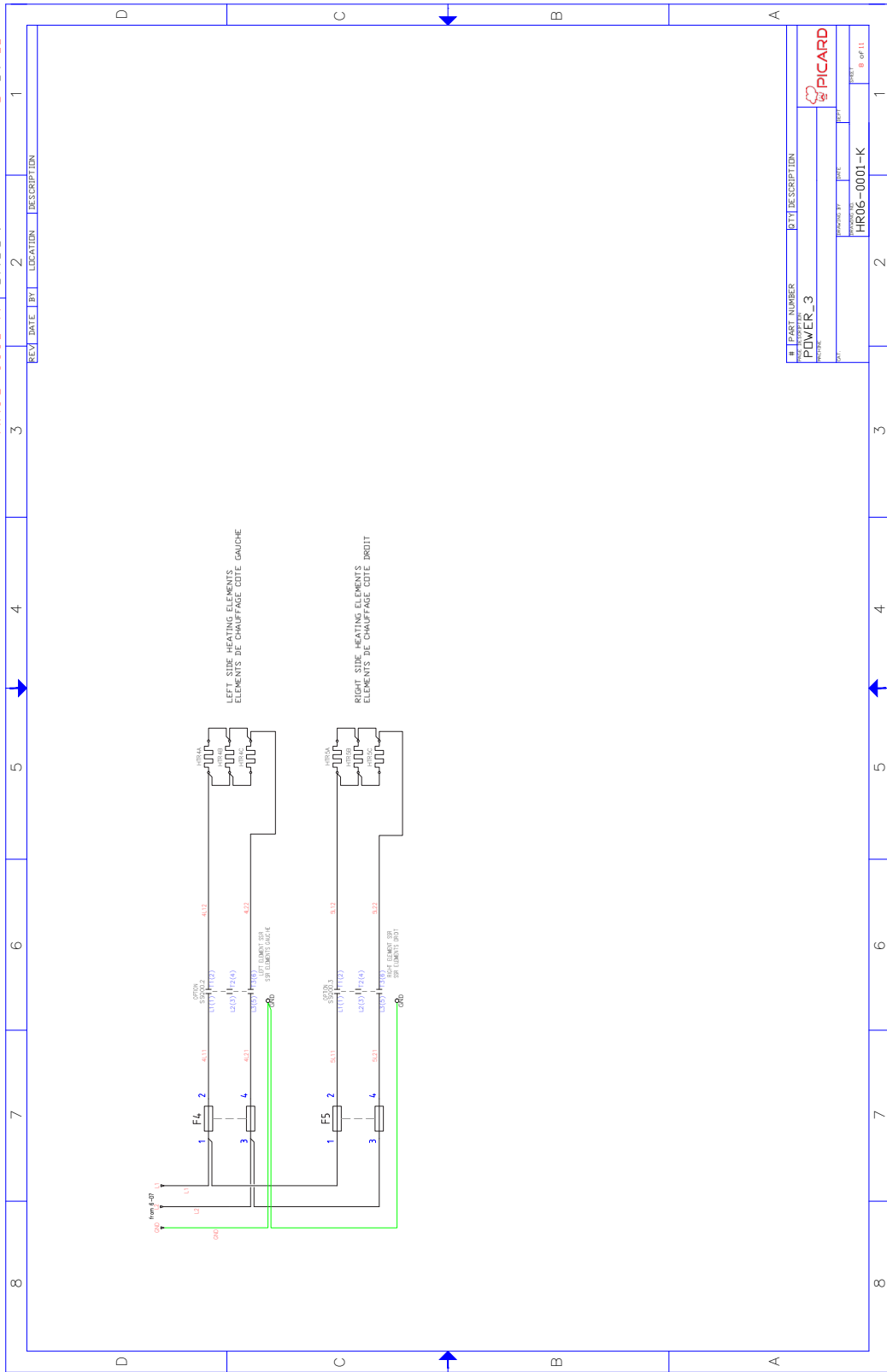
REV	DATE	BY	LOCATION	DESCRIPTION
1	200-04-15			ELECTRICAL

HR06-0001-K  
Page 5 of 11



NOTE : EVERY WIRE MUST BE TERMINATED WITH THE PROPER WIRE END (FERRULE)  
 NOTE : LINE FERRULE DOIT ETRE INSTALLEE A CHAQUE BOUT DE FIL

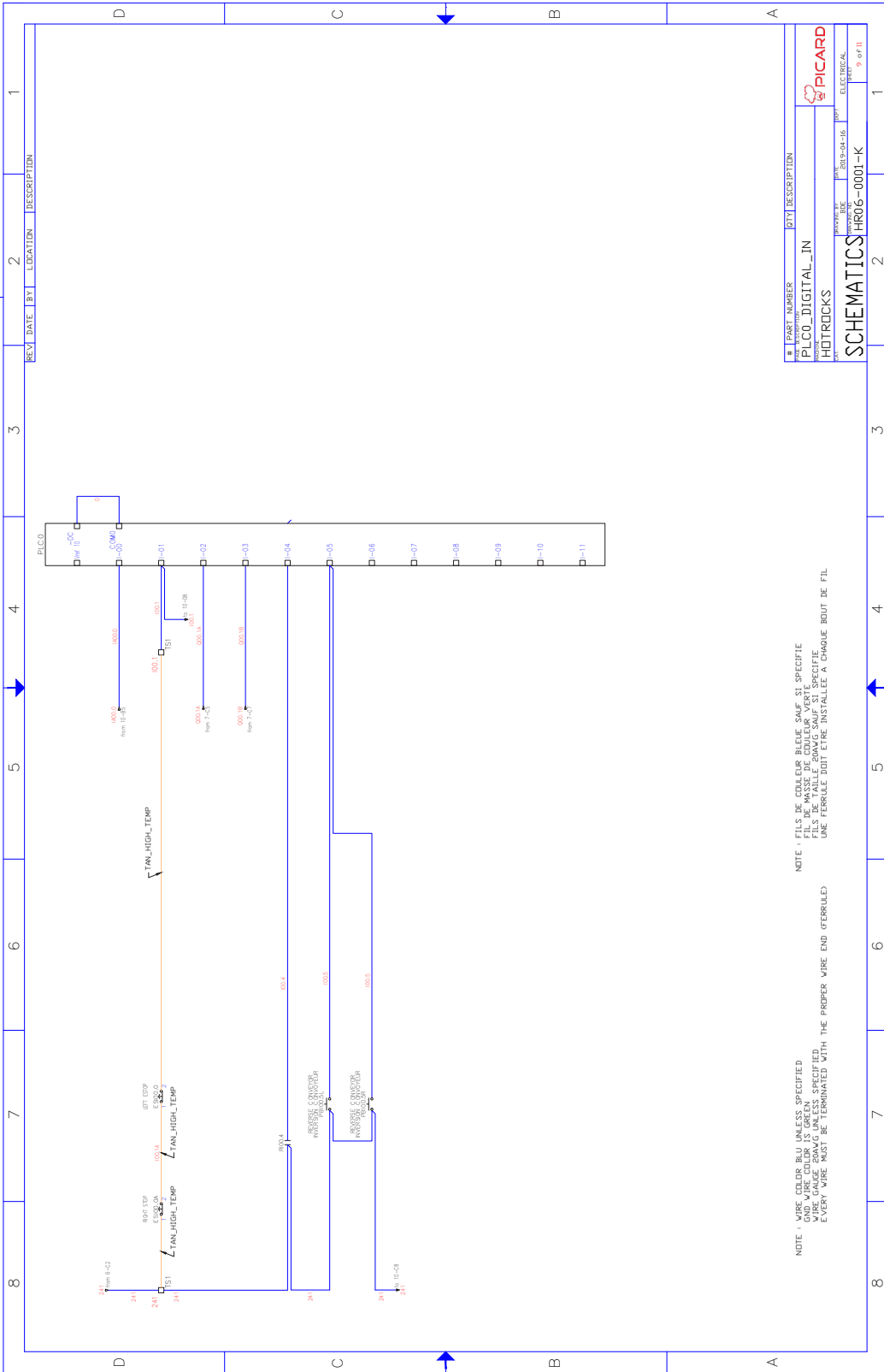




#	PART NUMBER	QTY	DESCRIPTION
1	POWER_3		
2	HR06-0001-K		

DRAWN BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 CHECKED BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 APPROVED BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 PICARD  
 8 of 11





NOTE : WIRE COLOR BUL UNLESS SPECIFIED  
 WIRE GAUGE UNLESS SPECIFIED  
 EVERY WIRE MUST BE TERMINATED WITH THE PROPER WIRE END (FERRULE)

NOTE : FILS DE COULEUR BLEUE SAUF SI SPECIFIE  
 FILS DE TABLE 20AWG SAUF SI SPECIFIE  
 UNE FERRULE DOIT ETRE INSTALLEE A CHAQUE BOUT DE FIL

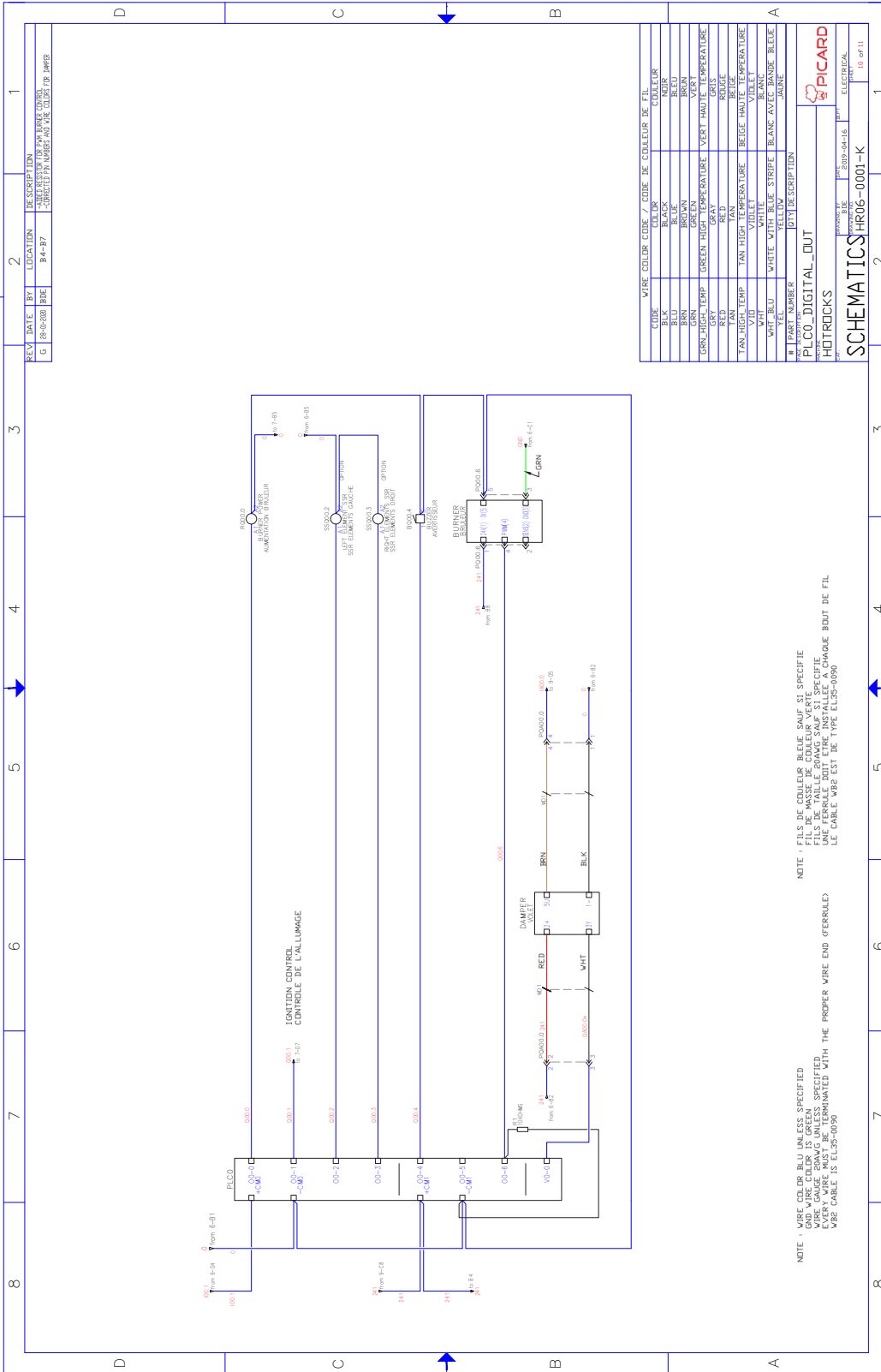
REV	DATE	BY	LOCATION	DESCRIPTION
1				

PART NUMBER	QTY	DESCRIPTION
CCO-DIGITAL_IN		
HOTROCKS		

PROJECT	DATE	REV	DESCRIPTION
HR06-0001-K	2019-04-16	101	ELECTRICAL



NOTE : WIRE COLOR BLU UNLESS SPECIFIED  
 AND WIRE COLOR IS GREEN  
 EVERY WIRE MUST BE TERMINATED WITH THE PROPER WIRE END (FERRULE)  
 WIRE CABLE IS ELUS-0090

NOTE : FILS DE COULEUR BLEUE SAUF SI SPECIFIE  
 FIL DE MASSE DE COULEUR VERTE  
 TOUTE LIGNE DE FIL DOIT ETRE INSTALLEE A CHAQUE BOUT DE FIL  
 LE CABLE WBE EST DE TYPE ELUS-0090

WIRE NUMBER	WIRE COLOR	CODE	DE COULEUR DE FIL
000.0	BLK	BLK	NOIR
000.1	BLU	BLU	BLEU
000.2	BRN	BRN	MARRON
000.3	GRN	GRN	VERT
000.4	GRY	GRY	GRIS
000.5	TAN	TAN	TAN
000.6	WHI	WHI	BLANC
000.7	YEL	YEL	JAUNE

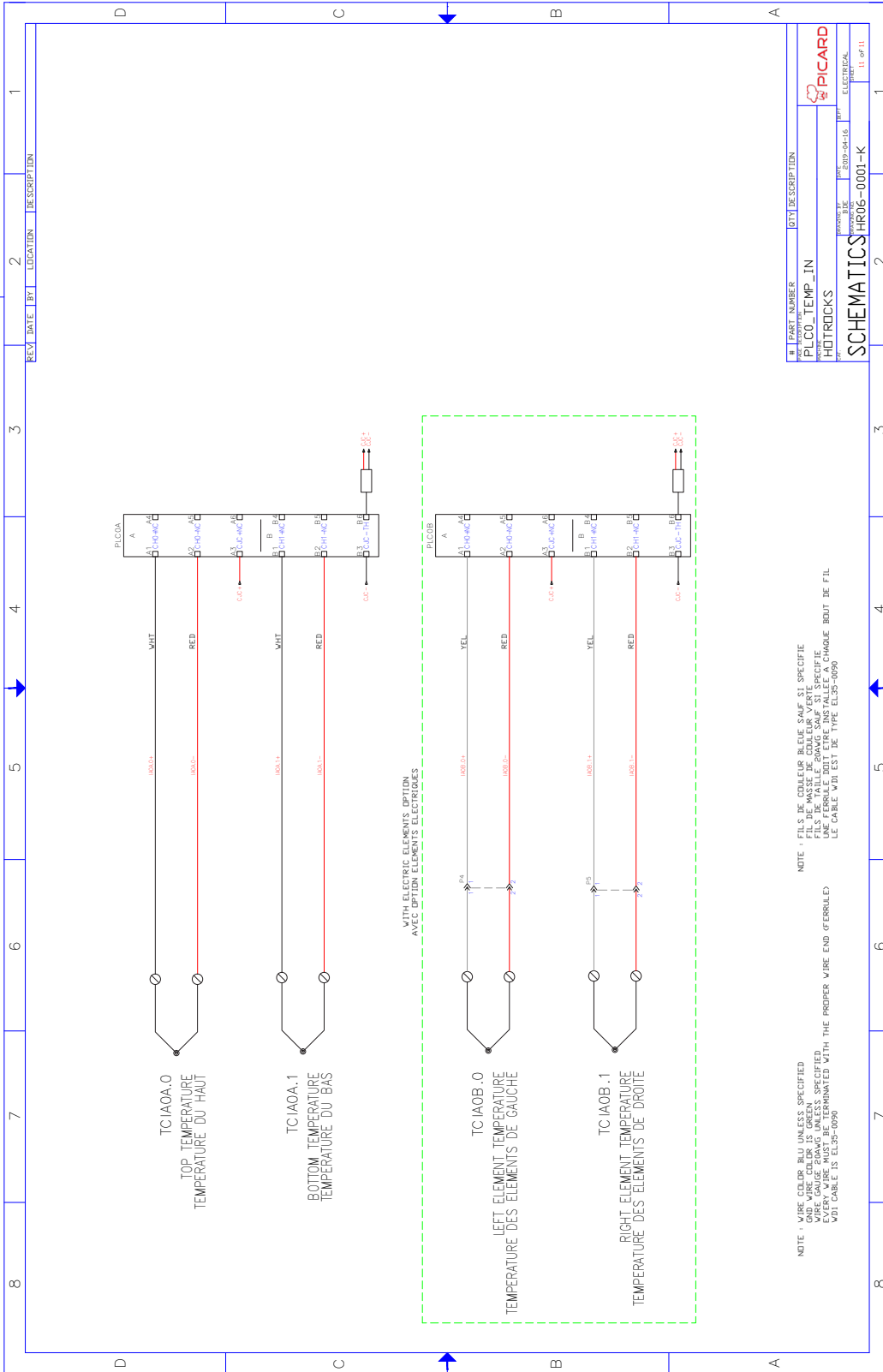
WIRE NUMBER	WIRE COLOR	CODE	DE COULEUR DE FIL
000.8	BLK	BLK	NOIR
000.9	BLU	BLU	BLEU
000.10	BRN	BRN	MARRON
000.11	GRN	GRN	VERT
000.12	GRY	GRY	GRIS
000.13	TAN	TAN	TAN
000.14	WHI	WHI	BLANC
000.15	YEL	YEL	JAUNE

WIRE NUMBER	WIRE COLOR	CODE	DE COULEUR DE FIL
000.16	BLK	BLK	NOIR
000.17	BLU	BLU	BLEU
000.18	BRN	BRN	MARRON
000.19	GRN	GRN	VERT
000.20	GRY	GRY	GRIS
000.21	TAN	TAN	TAN
000.22	WHI	WHI	BLANC
000.23	YEL	YEL	JAUNE

WIRE NUMBER	WIRE COLOR	CODE	DE COULEUR DE FIL
000.24	BLK	BLK	NOIR
000.25	BLU	BLU	BLEU
000.26	BRN	BRN	MARRON
000.27	GRN	GRN	VERT
000.28	GRY	GRY	GRIS
000.29	TAN	TAN	TAN
000.30	WHI	WHI	BLANC
000.31	YEL	YEL	JAUNE

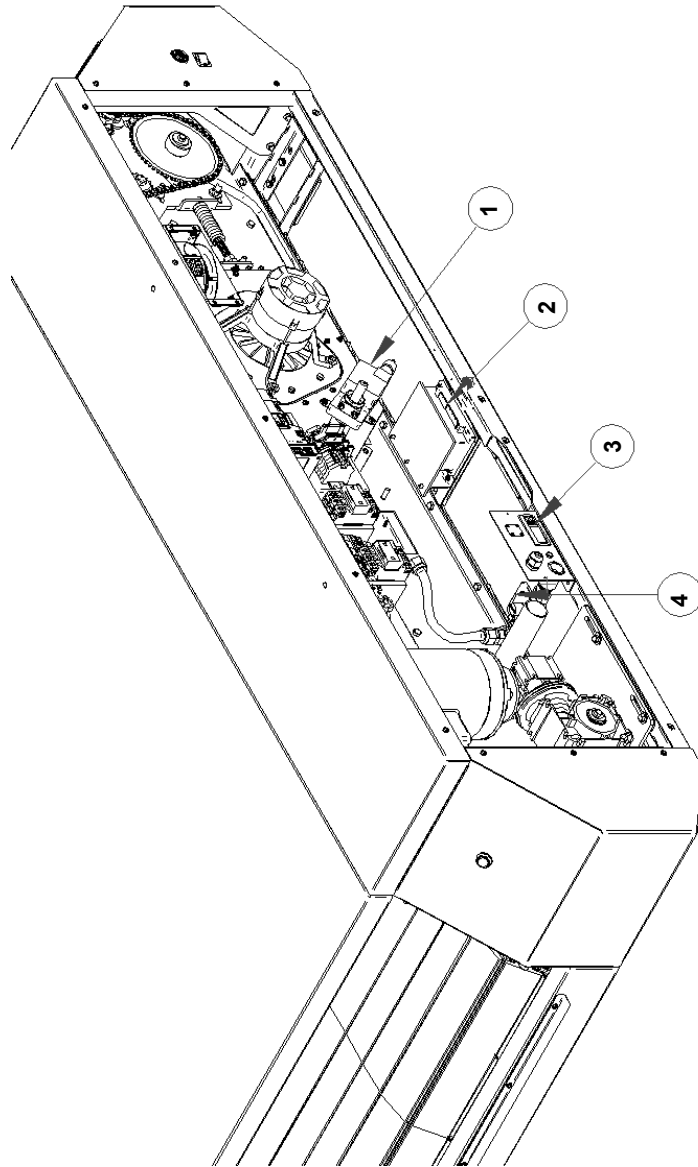


# 8 APPENDIX III – MECHANICAL DRAWINGS

ITEM	PART #	DESCRIPTION	MODEL
1	HR04-0040-A	WELDING FRONT RIGHT CORNER	ALL MODELS
2	HR04-0038-A	WELDING FRONT LEFT CORNER	ALL MODELS
3	HR01-0477-A	BACK LEFT FINITION CORNER	ALL MODELS
4	HR01-0136-A	BACK RIGHT FINITION CORNER	ALL MODELS
5	026-1410	EMERGENCY STOP BUTTON	ALL MODELS
6	026-1414	REVERSE BUTTON	ALL MODELS
7	HR06-0009-K	HMI PROGRAMMED	ALL MODELS

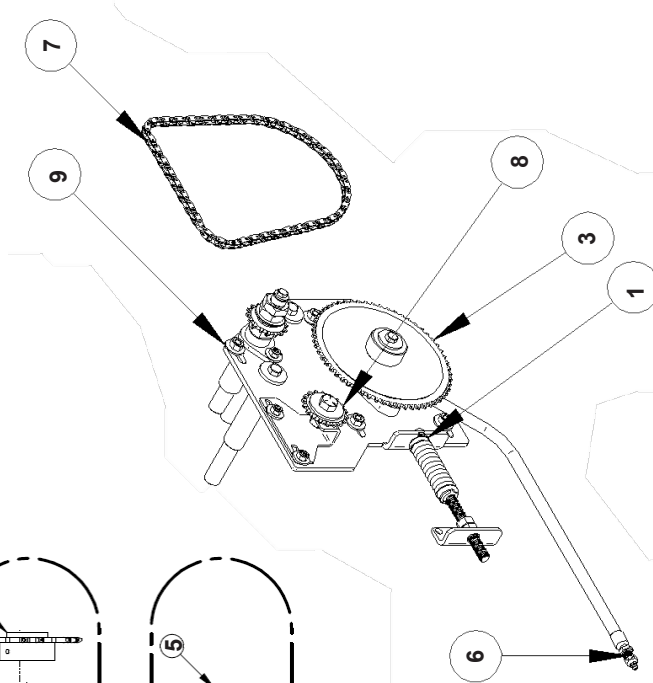
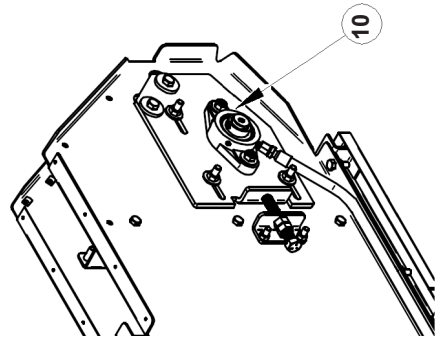
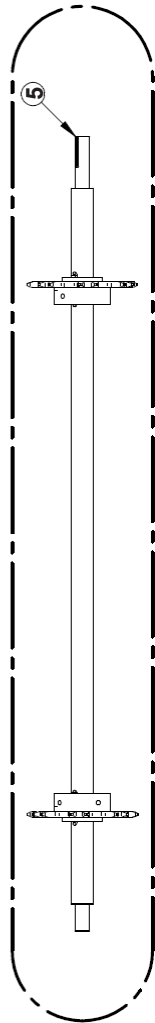
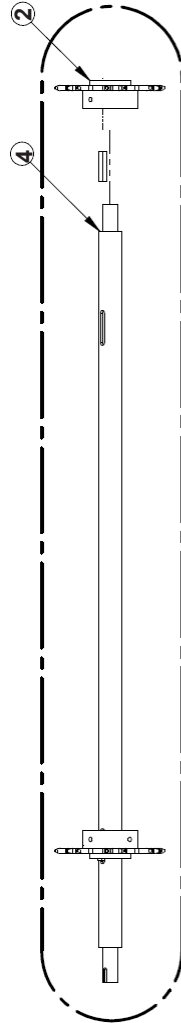
<b>ASS'Y EXT. CORNER</b>	
<b>HOT ROCKS</b>	
GENERAL TOLERANCES	SCALE
X ± 1.0	20-01-10
X.X ± 0.5	SCALE
X.XX ± 0.25	SCALE
ANGLE ± 1°	SCALE
M(M) DRAW REV: 1 HR05-0038-A	

ITEM	PART #	DESCRIPTION	MODEL
1	EL02-0222	DAMP. ROTARY ACTUATOR	ALL MODELS
2	EL02-0165	IGNITION CONTROL FENWAL	ALL MODELS
3	HR06A0008	HIGH LIMIT CONTROL PROGRAMMED	ALL MODELS
4	HR05-0091-A	GAZ CONDUCT ASSEMBLY	ALL MODELS



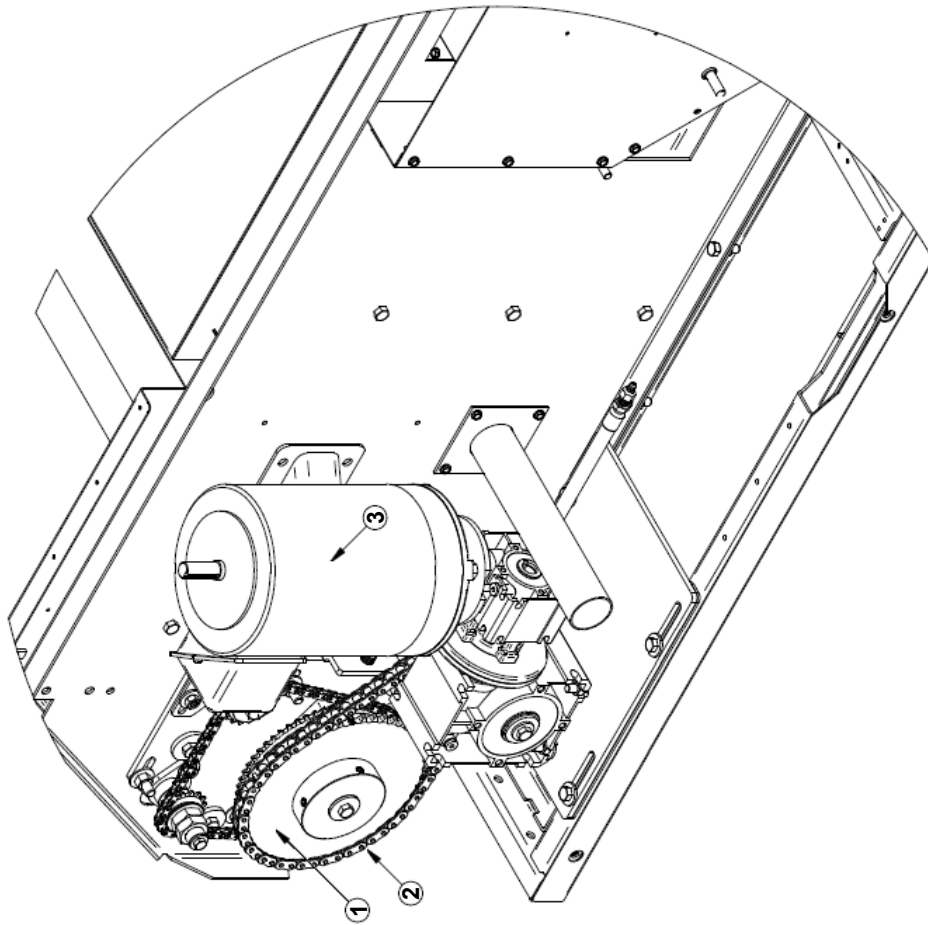
GENERAL TOLERANCES		SIPROMAC	
X	± 1.0	ASS'Y ELECTRICAL CABINET	
X.X	± 0.5	HOT ROCKS	
X.XX	± 0.25	SCALE	20-01-10
ANGLE	± 1°	SCALE	N.T.S.
		UNIT TYPE	HR05-0053-A
		REV	1
		UNIT	M-(M)

ITEM	PART #	DESCRIPTION	MODEL
1	QU28-0156	COMPRESSION SPRING	ALL MODELS
2	HR02-0062-A	CUSTOM SPROCKET	ALL MODELS
3	ME57-0198	SPROCKET #35	ALL MODELS
4	HR02-0103-A	DRIVE SHAFT	HR7022
4	HR02-0003-A	DRIVE SHAFT	HR7033 / HR9333
5	HR02-0104-A	FREE SHAFT	HR7022
5	HR02-0004-A	FREE SHAFT	HR7033 / HR9333
6	ME24-0129	GREASING TUBE 2FT	ALL MODELS
7	ME61-0058	CHAIN #35	ALL MODELS
8	HR05-0020-A	TENSIONNER	ALL MODELS
9	HR05-0021-A	TORQUE LIMITER	ALL MODELS
10	ME24-0119	BEARING HIGH TEMPERATURE	ALL MODELS



GENERAL TOLERANCES		ASS'Y MECHANICS	
X	± 1.0	HOT ROCKS	
XX	± 0.5	HOT ROCKS	
XXX	± 0.25	HOT ROCKS	
ANGLE	± 1°	HOT ROCKS	
SCALE		SCALE	
20-01-10		20-01-10	
MATERIAL		MATERIAL	
N.T.S.		N.T.S.	
REV		REV	
1		1	
DATE		DATE	
HR05-0017-A		HR05-0017-A	

ITEM	PART #	DESCRIPTION	MODEL
1	ME57-0175	SPROCKET #40	ALL MODEL
2	ME61-0060	CHAIN #40	ALL MODEL
3	HR05-0042-A	ASSY MOTOR	ALL MODEL



GENERAL TOLERANCES		SCALE		UNIT	
X	± 1.0	20-01-10	N.T.S.	M (M)	1
XX	± 0.5	VGM			
XXX	± 0.25	SCALE			
ANGLE	± 1°	UNIT TYPE			

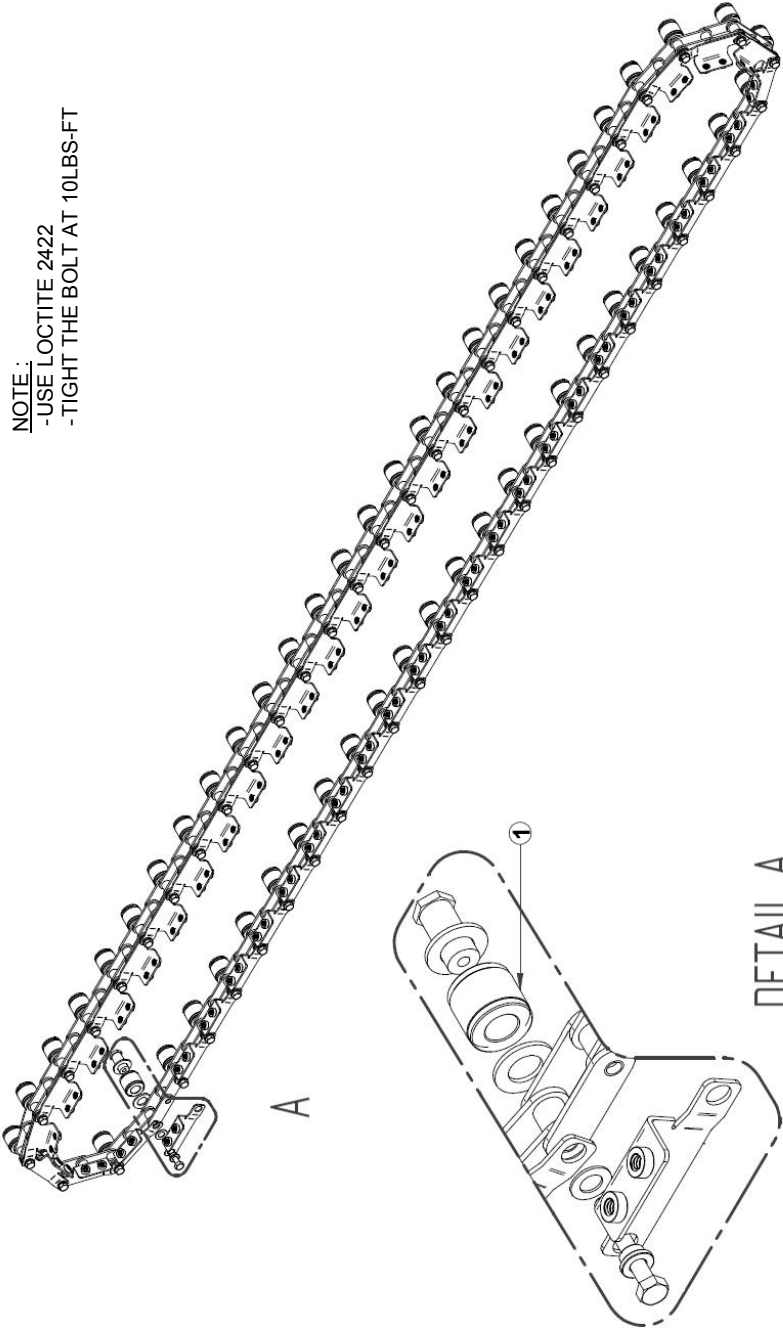


ASSY CONVEYOR MOTOR

HOT ROCKS

HR05-0043-A

ITEM	PART #	DESCRIPTION	MODEL
0	HR05-0033-A	ASSY CHAIN	HR7022 / HR7033
0	HR05-0172-A	ASSY CHAIN	HR9333
1	HR11-0001-A	KIT BUSHING (KIT 5X)	ALL MODELS



NOTE:  
 -USE LOCTITE 2422  
 -TIGHT THE BOLT AT 10LBS-FT

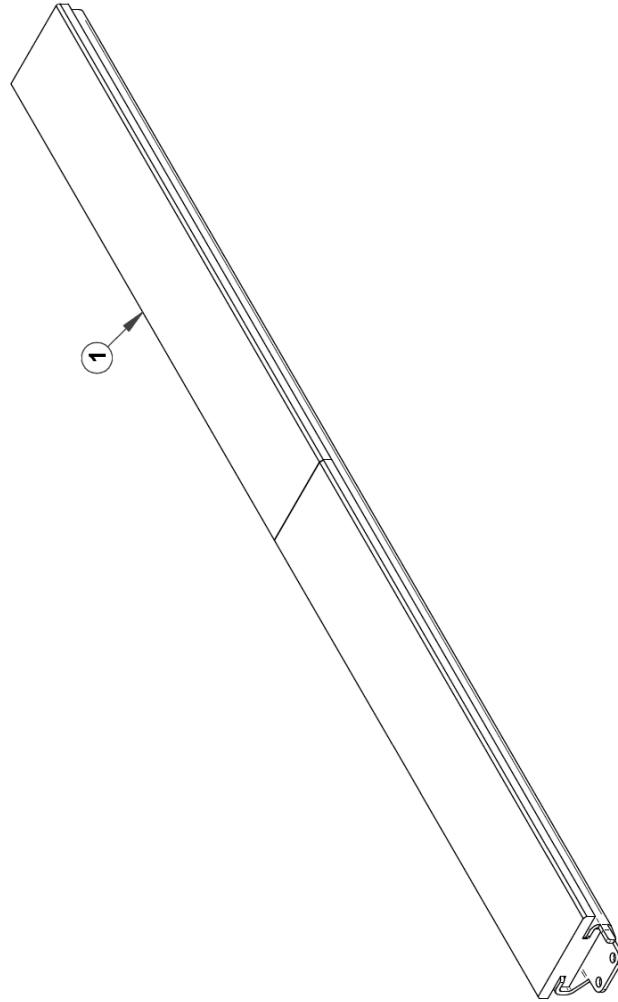
DETAIL A

GENERAL TOLERANCES		SCALE		MATERIAL		FINISH	
X	± 1.0	SCALE	20-01-10	MATERIAL	VGM	FINISH	N.T.S.
X.X	± 0.5	SCALE	20-01-10	MATERIAL	VGM	FINISH	N.T.S.
X.XX	± 0.25	SCALE	20-01-10	MATERIAL	VGM	FINISH	N.T.S.
ANGLE	± 1°	SCALE	20-01-10	MATERIAL	VGM	FINISH	N.T.S.

HR05-0033-A



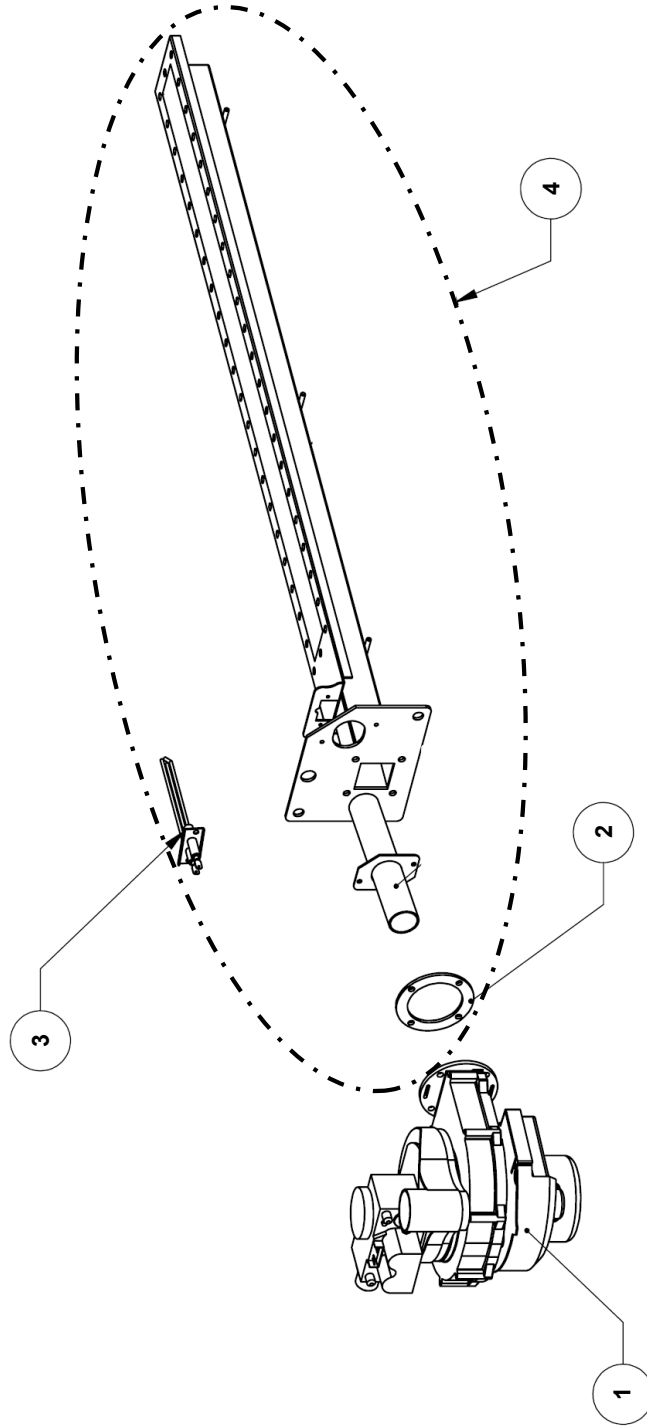
ITEM	PART #	DESCRIPTION	MODEL
0	HR05-0154-A	ASSY STONE	HR7022
0	HR05-0034-A	ASSY STONE	HR7033 / HR9333
0	HR04-0172-A	ASSY STEEL	HR7022
0	HR04-0134-A	ASSY STEEL	HR7033 / HR9333
1	ME84-0023	GRANITE STONE 10.96IN	HR7022
1	ME84-0024	GRANITE STONE 16.46IN	HR7033 / HR9333



GENERAL TOLERANCES		SCALE		UNIT TYPE		PART TYPE	
X	± 1.0	20-01-10	VGM	N.T.S.			
X.X	± 0.5						
X.XX	± 0.25						
ANGLE	± 1°						
PART		SIPROMAC		M-M		REV. 1	
ASSY ROCK		HOT ROCKS		HR05-0034-A			

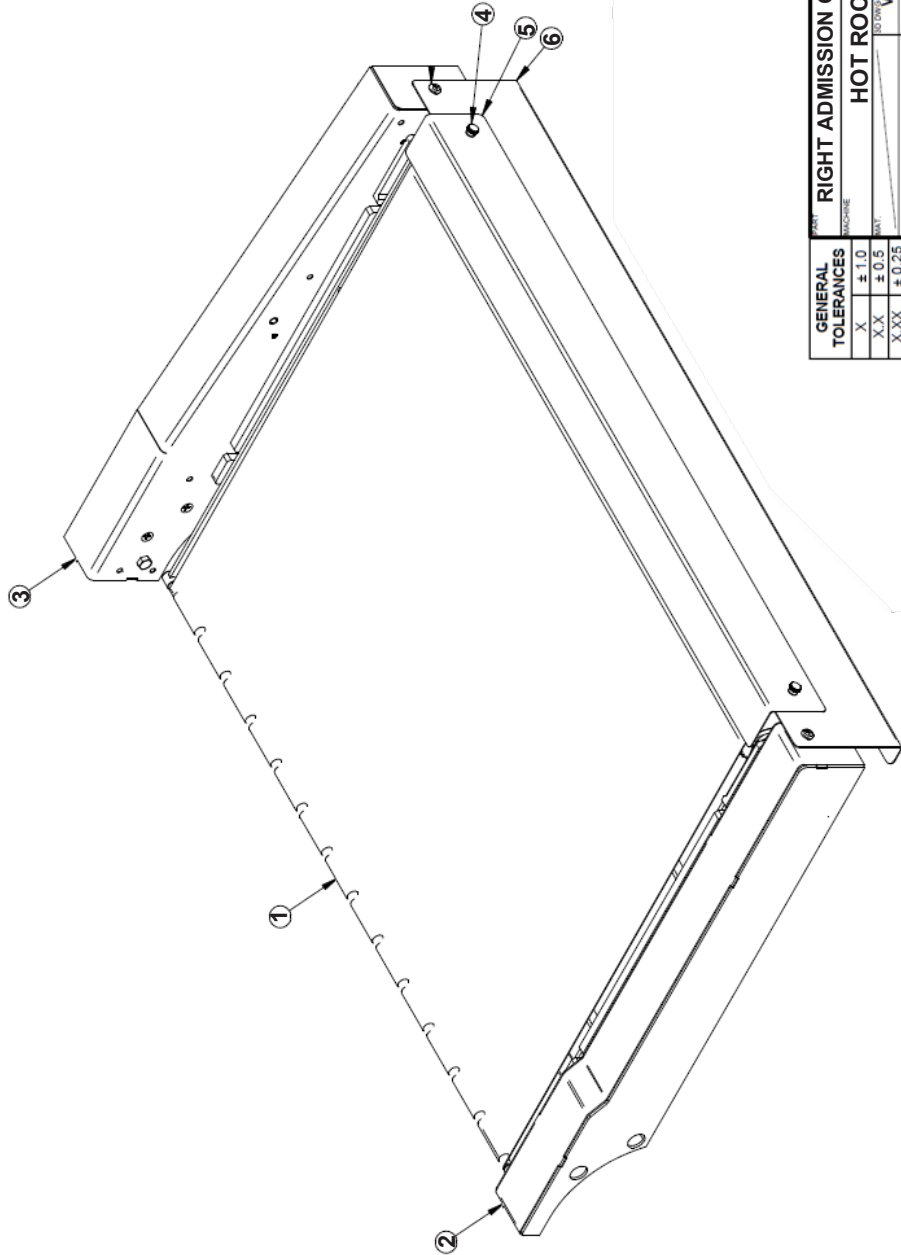


ITEM	PART #	DESCRIPTION	MODEL
1	HR11-0004-A	KIT BLOWER NATURAL GAS	HR7022
1	HR11-0005-A	KIT BLOWER PROPANE GAS	HR7022
1	HR11-0006-A	KIT BLOWER NATURAL GAS	HR7033
1	HR11-0007-A	KIT BLOWER PROPANE GAS	HR7033
1	HR11-0008-A	KIT BLOWER NATURAL GAS	HR9333
1	HR11-0009-A	KIT BLOWER PROPANE GAS	HR9333
2	RE800418	BURNER SEAL	ALL MODELS
3	HR11-0028-A	KIT FLAME SENSOR-SPARK ROD	ALL MODELS
4	HR11-0015-A	KIT BURNER W/O BLOWER NATURAL GAS	HR7022
4	HR11-0018-A	KIT BURNER W/O BLOWER PROPANE GAS	HR7022
4	HR11-0021-A	KIT BURNER W/O BLOWER NATURAL GAS	HR7033 / HR9333
4	HR11-0023-A	KIT BURNER W/O BLOWER PROPANE GAS	HR7033 / HR9333



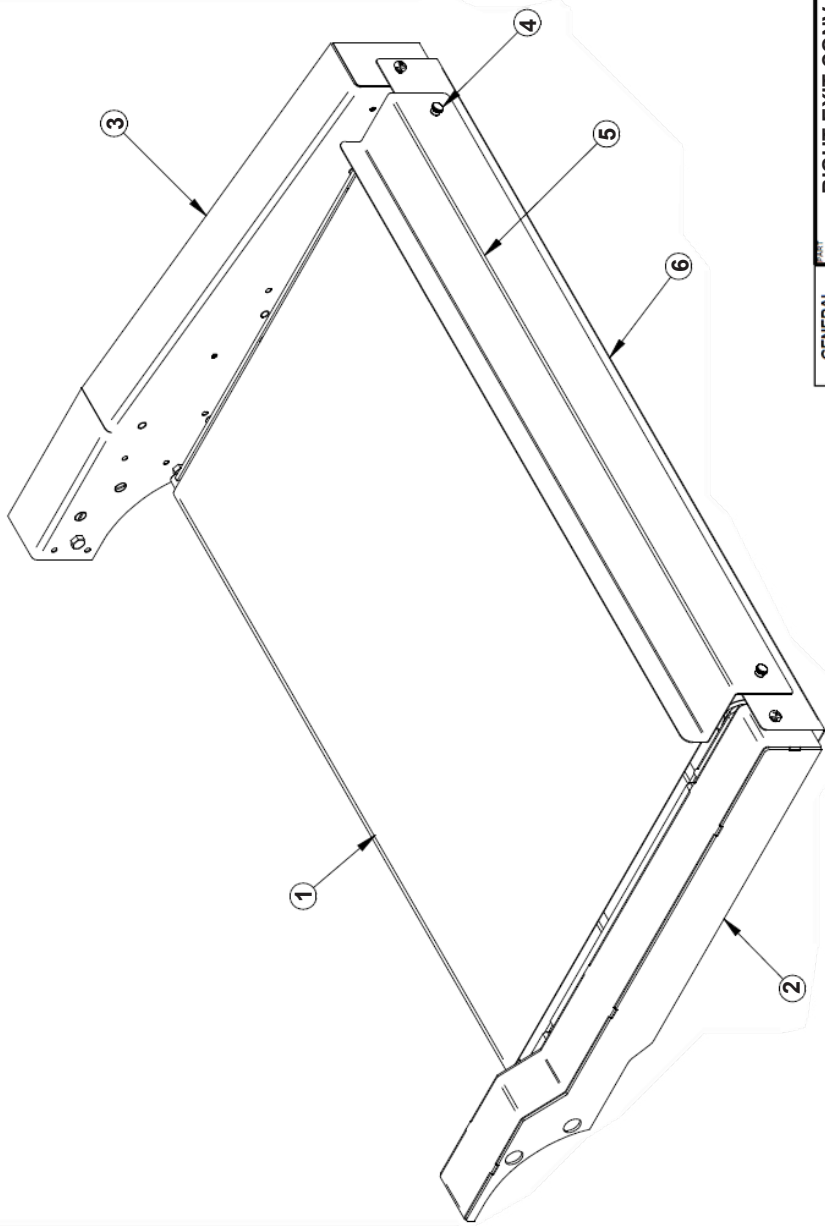
GENERAL TOLERANCES		SIPROVAC	
X	± 1.0	HOT ROCKS	
X.X	± 0.5	ASSY BURNER	
X.XX	± 0.25	HOT ROCKS	
ANGLE	± 1°	SCALE	20-01-10
		UNIT TYPE	N.T.S.
		TO DIM	VGM
		UNIT	M-(M)
		REV	1
		SCALE	HR05-0040-B

ITEM	PART #	DESCRIPTION	MODEL
0	HR05-0219-A	RIGHT ADMISSION CONV. ASSY	HR7022
0	HR05-0218-A	RIGHT ADMISSION CONV. ASSY	HR7033 / HR9333
1	HR05-0161-A	MESH WIRE 51IN	HR7022
1	HR05A0082	MESH WIRE 51IN	HR7033 / HR9333
2	HR05-0216-A	RIGHT ADMISSION CONV. FRONT ARM ASSY	ALL MODELS
3	HR05-0215-A	RIGHT ADMISSION CONV. BACK ARM ASSY	ALL MODELS
4	HR11-0002-A	KET THUMB SCREW (QTY: 4X)	HR7033 / HR9333
5	HR01B0017	ADMISSION CONV. FINITION BRACKET	HR7022
5	HR01B0009	ADMISSION CONV. FINITION BRACKET	HR7033 / HR9333
6	HR04A0007	CRUMB RECEPTACLE SUPPORT WELDING	HR7022
6	HR04A0004	CRUMB RECEPTACLE SUPPORT WELDING	HR7033 / HR9333



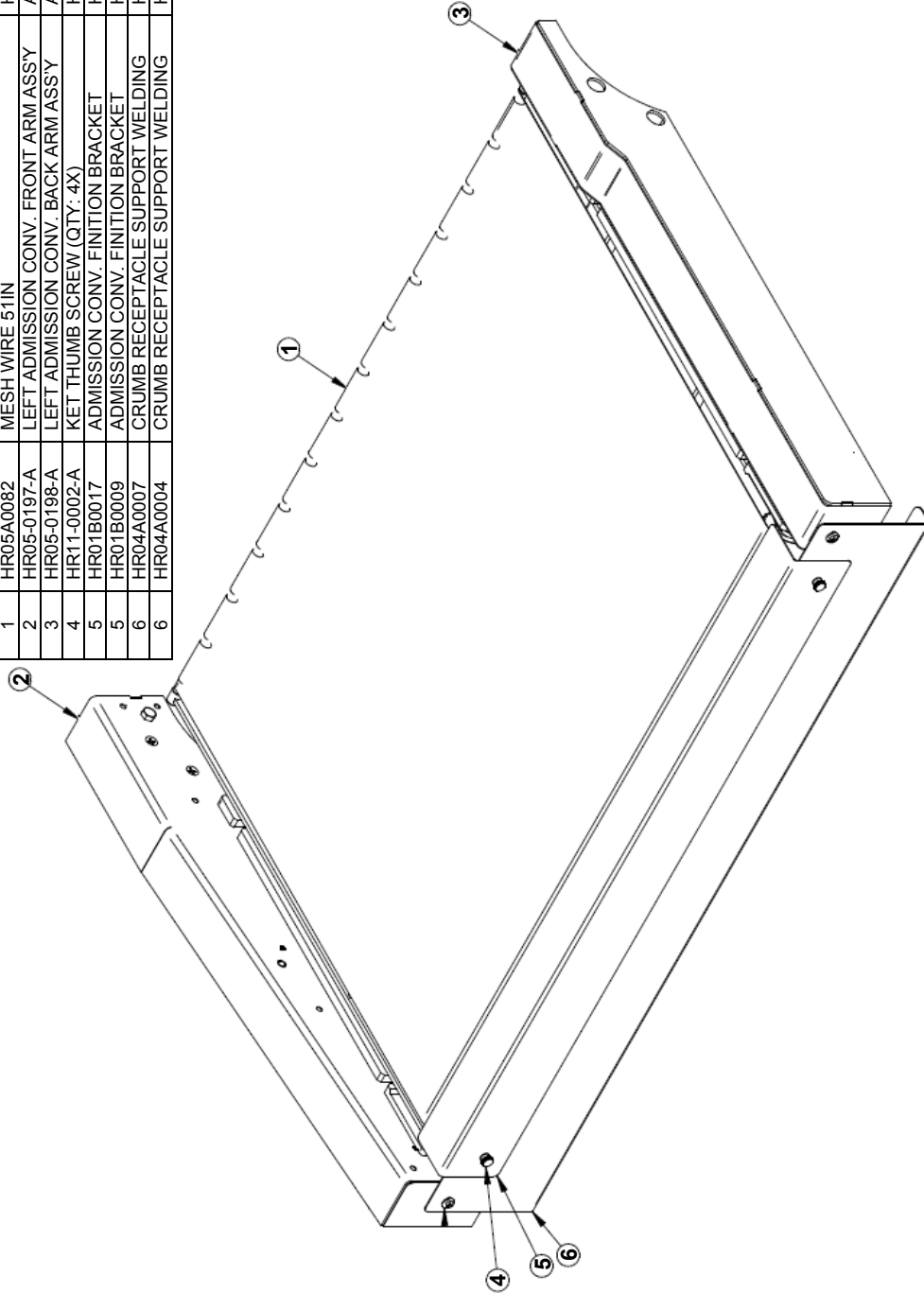
GENERAL TOLERANCES		SIPROMAC	
X	± 1.0	RIGHT ADMISSION CONV. ASSY	
X.X	± 0.5	HOT ROCKS	
X.XX	± 0.25	SCALE	20-01-10
ANGLE	± 1°	SCALE	N.T.S.
		REV	1
		DATE	HR05-0218-A

ITEM	PART #	DESCRIPTION	MODEL
0	HR05B0069	RIGHT EXIT CONV. ASS'Y	HR7022
0	HR05A0060	RIGHT EXIT CONV. ASS'Y	HR7033 / HR9333
1	HR05-0162-A	MESH WIRE 43IN	HR7022
1	HR05A0083	MESH WIRE 43IN	HR7033 / HR9333
2	HR05B0059	RIGHT EXIT CONVEYOR FRONT ARM	ALL MODELS
3	HR05B0057	RIGHT EXIT CONVEYOR BACK ARM	ALL MODELS
4	HR11-0002-A	KIT THUMB SCREW (QTY: 4X)	ALL MODELS
5	HR01A0260	EXIT CONVEYOR STOPPER	HR7022
5	HR01B0177	EXIT CONVEYOR STOPPER	HR7033 / HR9333
6	HR04A0079	CRUMB RECEPTABLE SUPPORT	HR7022
6	HR04A0056	CRUMB RECEPTABLE SUPPORT	HR7033 / HR9333



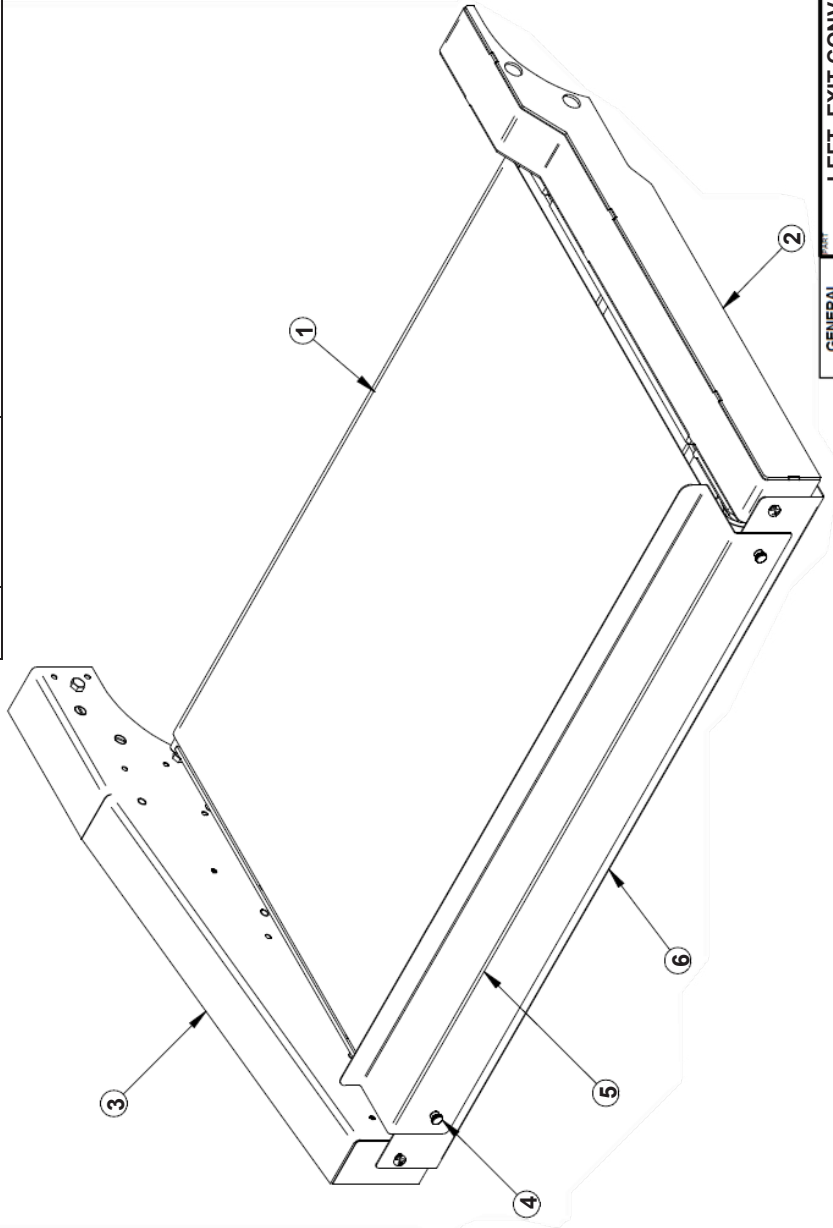
GENERAL TOLERANCES		RIGHT EXIT CONV. ASS'Y	
X	± 1.0	HOT ROCKS	
X.X	± 0.5	SIPROMAC	
X.XX	± 0.25	UNIT	M-(M)
ANGLE	± 1°	SCALE	20-01-10
		DATE	20-01-10
		SCALE	N.T.S.
		REV	1
		REV	HR05B0060

ITEM	PART #	DESCRIPTION	MODEL
0	HR05-0220-A	LEFT ADMISSION CONV. ASSY	HR7022
0	HR05-0219-A	LEFT ADMISSION CONV. ASSY	HR7033 / HR9333
1	HR05-0161-A	MESH WIRE 51IN	HR7022
1	HR05A0082	MESH WIRE 51IN	HR7033 / HR9333
2	HR05-0197-A	LEFT ADMISSION CONV. FRONT ARM ASSY	ALL MODELS
3	HR05-0198-A	LEFT ADMISSION CONV. BACK ARM ASSY	ALL MODELS
4	HR11-0002-A	KEY THUMB SCREW (QTY: 4X)	HR7033 / HR9333
5	HR01B0017	ADMISSION CONV. FINITION BRACKET	HR7022
5	HR01B0009	ADMISSION CONV. FINITION BRACKET	HR7033 / HR9333
6	HR04A0007	CRUMB RECEPTACLE SUPPORT WELDING	HR7022
6	HR04A0004	CRUMB RECEPTACLE SUPPORT WELDING	HR7033 / HR9333



GENERAL TOLERANCES		LEFT ADMISSION CONV. ASS'Y	
X	± 1.0	HOT ROCKS	
X.X	± 0.5	SCALE	
X.XX	± 0.25	20-01-10	
ANGLE	± 1°	N.T.S.	
MATERIAL		MATERIAL	
MESH WIRE		MESH WIRE	
VGM		VGM	
SCALE		SCALE	
20-01-10		20-01-10	
N.T.S.		N.T.S.	
HR05-0196-A		HR05-0196-A	

ITEM	PART #	DESCRIPTION	MODEL
0	HR05A0071	LEFT EXIT CONV. ASS'Y	HR7022
0	HR05A0065	LEFT EXIT CONV. ASS'Y	HR7033 / HR9333
1	HR05-0162-A	MESH WIRE 43IN	HR7022
1	HR05A0083	MESH WIRE 43IN	HR7033 / HR9333
2	HR05B0064	LEFT EXIT CONVEYOR FRONT ARM	ALL MODELS
3	HR05B0063	LEFT EXIT CONVEYOR BACK ARM	ALL MODELS
4	HR11-0002-A	KIT THUMB SCREW (QTY: 4X)	ALL MODELS
5	HR01A0260	EXIT CONVEYOR STOPPER	HR7022
5	HR01B0177	EXIT CONVEYOR STOPPER	HR7033 / HR9333
6	HR04A0079	CRUMB RECEPTABLE SUPPORT	HR7022
6	HR04A0056	CRUMB RECEPTABLE SUPPORT	HR7033 / HR9333



GENERAL TOLERANCES		LEFT EXIT CONV. ASS'Y	
X	± 1.0	HOT ROCKS	
X.X	± 0.5	HOT ROCKS	
X.XX	± 0.25	HOT ROCKS	
ANGLE	± 1°	HOT ROCKS	
UNITS		SCALE	
M (M)		20-01-10	
REV		SCALE	
1		N.T.S.	
PART NO		HR05B0065	



**HR06-0001-K - ELECTRIC PARTS 208-240V/1PH/50-60Hz/10A**

CODE	DESCRIPTION	QTY TOT.	NOTE
HR06-0002-K	208-240VAC HARNESS	1	
HR06-0003-K	24VAC HARNESS	1	
HR06-0004-K	24VDC HARNESS	1	
HR06-0006-K	PROGRAMMED HOTROCKS CONVEYOR VARIABLE FREQUENCY DRIVE	1	FV1
HR06-0007-K	PROGRAMMED HOTROCKS CONVECTION VARIABLE FREQUENCY DRIVE	1	FV2
HR06-0008-K	PROGRAMMED HOTROCKS PLC	1	PLC0
HR06-0009-K	PROGRAMMED HOTROCKS HMI	1	HMI0
HR06-0011-K	208-240VAC MOTOR PIGTAIL	1	
HR06B0002	IGNITION CABLES FOR HOTROCKS	1	
HR06A0008	HIGH LIMIT TEMPERATURE CONTROL (LOVE) PROGRAMED 800F	1	
EL36-0052	FUSE LPCC8 8A/600V TIME DELAY , CSA	2	F1
034-1710	FUSE LPCC 6A/600V TIME DELAY	2	F2
034-0215	FUSE 5X20MM 3A/250V TIME DELAY	2	F3A, F3B
034-0210	FUSE 5X20MM 2A/250V TIME DELAY	2	F31, F241
EL40-0037	TRANSFORMER 40VA 208/240V - 24VAC 50/60HZ	1	T31
040-0270	5 PORTS ETHERNET SWITCH 24VDC	1	ESW0
040-0281	POWER SUPPLY 38..4W-1.6A, -20°C TO 65°C, 100-240V IN	1	PS0
040-0251	CARTRIDGE I/O EXTENSION, 2 TEMPERATURE INPUT, THERMOCOUPLE, MICRO800	1	PLC0A
026-1410	MUSHROOM MONOLITHIC OPERATOR, TWIST TO RELEASE, 1 X N.C.	2	ESI00.0L, ESI00.0R
EL02-0222	DAMP. ROTARY ACTUATOR 24VAC/DC, CSA	1	DAMPER
026-1414	BLACK MONOLITHIC PUSH BUTTON, 1 X N.O., IDENTIFICATION (R)	2	PBI00.5L, PBI00.5R
EL02-0216	BUZZER AL- 6-28VAC/DC FAST PULSE	1	BQ00.4
EL32-0087	MOTOR 1/4 HP 1800 RPM 230/460V 60HZ 3 PHASES FRAME 56 ACCU-TORQ (C-FLANGE)	1	M1
EL01-0114	ROCKER SWITCH ON-OFF DPST 16A 250VAC	1	S1
EL32-0095	MOTOR 560W /3400RPM/ 208V/60HZ 3PHASE	1	M2
EL64-0105	TYPE J THERMOCOUPLE, NON GROUNDED 60" WIRE, 12" PROBE, 1/4 "DIA EXT	2	
EL64-0111	TYPE J THERMOCOUPLE, NON GROUNDED 12" WIRE, 12" PROBE, 1/4 "DIA EXT	1	
EL02-0165	EL02-0165 (CONTROLE D'ALLUMAGE POUR VENTILATEUR DE COMBUSTION)	1	
040-0096	ETHERNET CABLE SHIELDED CAT6 6' VERT, CSA. UL	2	ETH_4 ,ETH_5
040-0093	ETHERNET CABLE SHIELDED CAT6 10' VERT, CSA. UL	1	ETH_3
040-0097	ETHERNET CABLE SHIELDED CAT6 1' VERT, CSA. UL	1	ETH_1
EL02-0165	IGNITION CONTROL (FENWAL)		

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