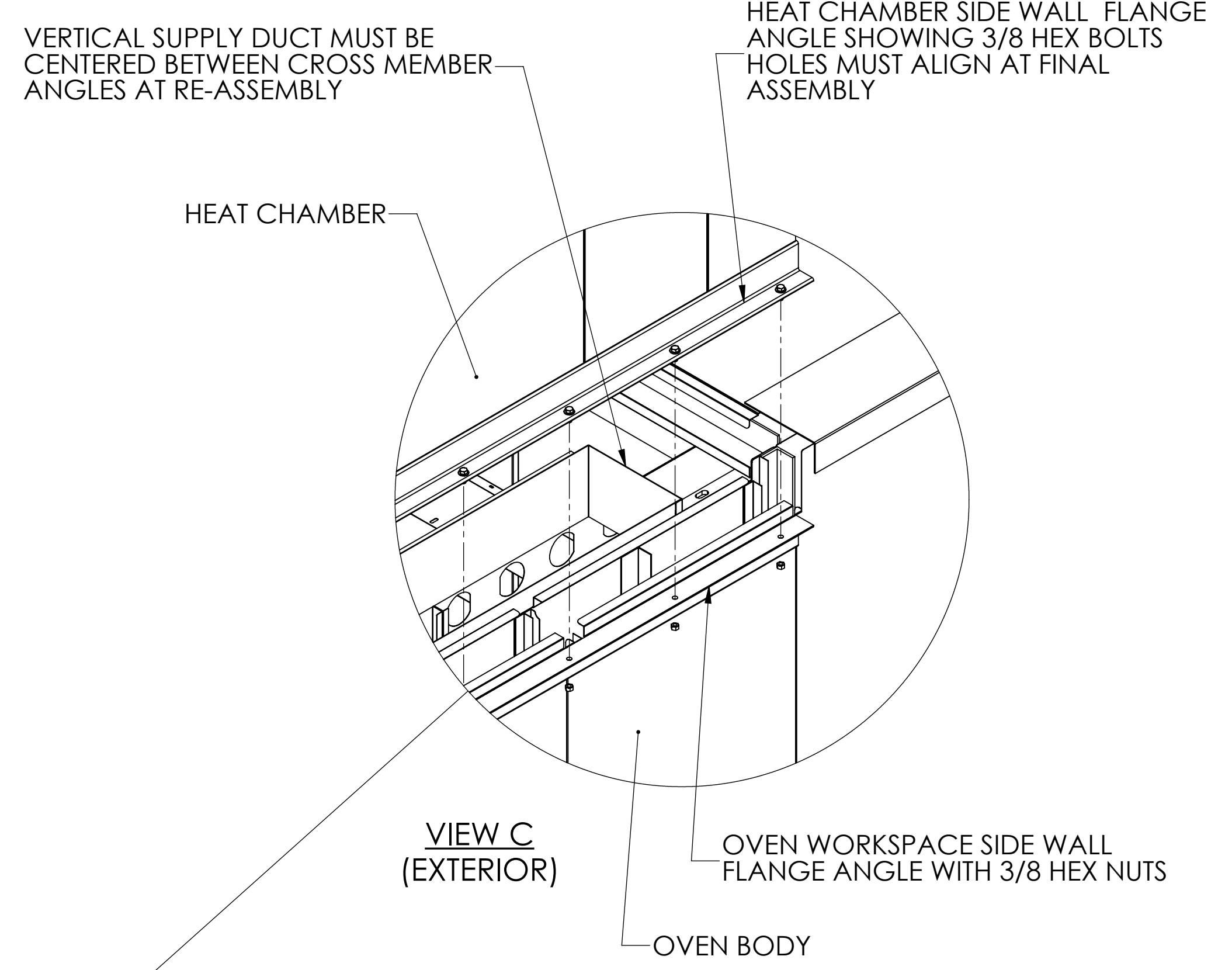
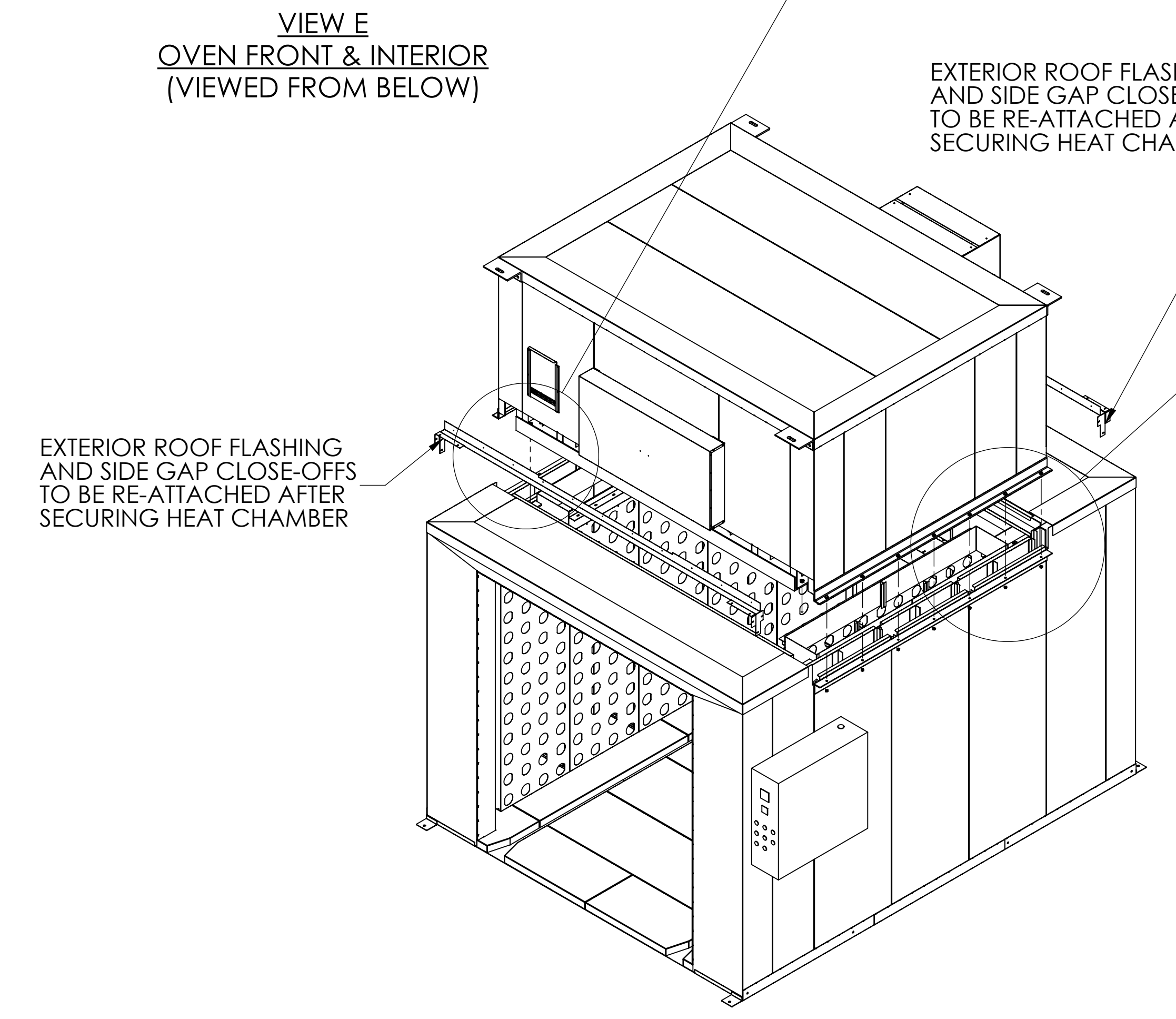


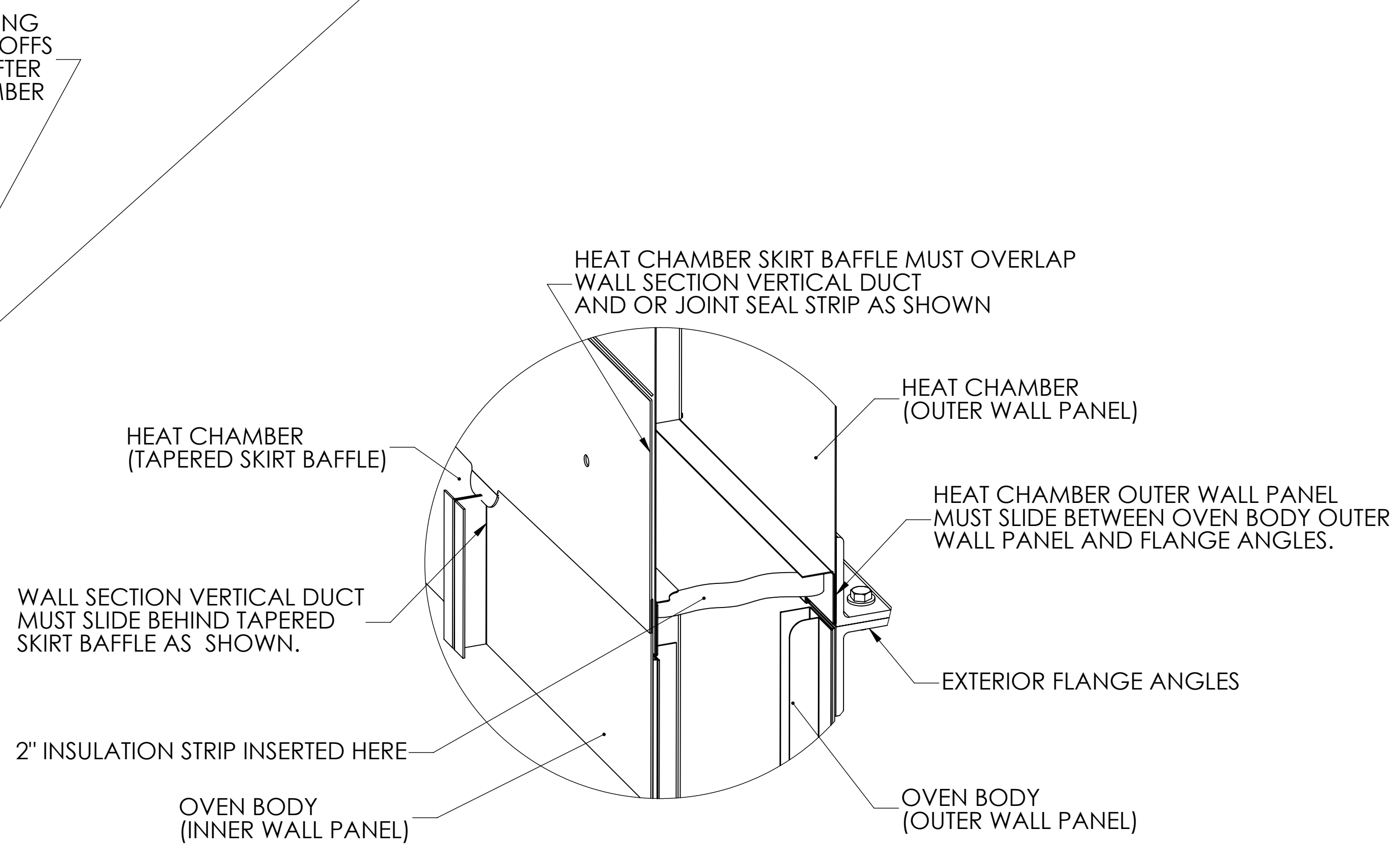
VIEW B



VIEW C (EXTERIOR)



VIEW A



VIEW D
CROSS SECTION AT OVEN BODY & HEAT CHAMBER JOINT
HORIZONTAL AIRFLOW MODELS (WTH): ONE SIDE ONLY
COMBINATION AIRFLOW MODELS (WTC): BOTH SIDES

REASSEMBLY OF REMOVABLE TOP-MOUNTED HEAT CHAMBERS

Removable top mounted heat chambers are fully assembled to the oven body and tested prior to shipment. After the oven has been fully tested, the heat chamber is removed to reduce shipping height.

Reassembly of the heat chamber must proceed as follows for satisfactory results. Please read through these instructions completely before starting to determine which steps are necessary for your unit.

PLEASE NOTE: The heat chamber is very heavy and must be handled carefully otherwise, some of its components may be damaged during installation. The heat chamber should be lifted by the lifting points at the top corners of the heat chamber. If for any reason the heat chamber must be lifted from the bottom make sure that it is lifted around the perimeter. The bottom center of the heat chamber is not strong enough to support the heat chamber weight.

- For some ovens, the oven body may be spliced into two or more sections. In these cases, make sure the body is completely assembled and secured before proceeding. Position the body sections and pull them together aligning the angle flanges and bolting the sections together. The body tongue and groove joints have a 2" thick strip of insulation that is compressed into the joint as the sections are pulled together. Make sure this insulation is present.
- Move the oven body into position and level it making sure that the oven is completely supported and not resting on two or three high spots on the floor. One indication that the oven is level is that the door openings are square. The top center corners of the doors will line up horizontally when the door openings are square.
- The oven body is flexible and will change shape based on the contour of the floor. Before installing the heat chamber check that the opening for the heat chamber in the top of the oven is square. Measure the diagonal distance from opposite corners of the heat chamber opening to make sure the distances are the same. When the diagonal distances are equal, the opening is square. Shim the perimeter of the oven as necessary to square the top opening before attempting to lower the heat chamber into the opening. After squaring the heat chamber opening, check the door openings to make sure they are square as indicated by the top center corners of the doors lining up horizontally.
- There is a tongue and groove joint on each side of the heat chamber that sits down into the oven body walls. A 2" thick strip of insulation is compressed in this joint. This insulation has been installed at the factory. Make sure the insulation remains in place while the heat chamber is being installed.
- Remove side and ceiling ductwork panels as necessary (varies depending on oven) in order to expose inner wall side panels where heat chamber meets oven body.
- The heat chamber is provided with structural lifting points at each of the four (4) corners of its roof, to be used to lift the heat chamber. We suggest that spreader bars (not provided by Grieve) be attached to the lifting cables to prevent damage to the heat chamber.
- Lift the heat chamber up by the lifting points at the corners of the chamber roof (Step 6 above) and then carefully move the heat chamber into position above the opening for the heat chamber in the top of the oven.
- Before proceeding, make sure that the electrical wiring on the heat chamber is not in a position that will risk it getting pinched or crimped between the heat chamber and the oven body. It may be necessary to remove some conduit supports or conduit clips in order to move the electrical wiring out of the way.
- Carefully lower the heat chamber into place, taking care that the heat chamber skirt baffles overlap the oven interior wall panels and that the heat chamber outer wall panel slides between the oven body outer wall and the flange angles (see View D). Verify that the four (4) 1/2" bolt holes located at the corners of the bottom structural support of the heat chamber are aligned to the slots in the structural support members on the oven body (see View B).
- Once heat chamber is settled down into oven and joints are aligned inside and out, install the four (4) 1/2" bolts inside the oven to pull the heat chamber down to the oven body. The bolts are inserted upwards through the slots in the structural support members inside the oven body into the heat chamber at the four corners. Once these bolts are installed, install the bolts in the outer wall splice angles (see View B & C).
- Reattach all flashing across exterior roof of the oven and the corners where heat chamber meets oven body (see View A). Reattach inner flashing between workspace ceiling and heat chamber (see View E).
- Reattach any and all ductwork that was removed during step 5 above.
- Electrical wires and connections have been numbered and labeled for ease of reassembly. Once the heat chamber is securely reattached to the oven body, reconnect all electrical wiring and feed wires through the appropriate conduits, referencing the wiring diagram and any photographs provided. Reattach and secure any electrical conduit supports or conduit clips that were removed for clearance in Step 8.
- Hold-down plates have been provided at each of the four (4) corners of the oven base for bolting to the floor. At the least the front corners should be bolted to the floor. Long ovens or ovens operating at high temperature will grow substantially in when heated. For this reason, it may not be possible to bolt both front and rear of the oven without the bolts being sheared off when the oven is heated.

- NOTES:**
- SAMPLE OVEN SHOWN. UNITS MAY VARY AS ORDERED.
 - FOR CLARITY, DOORS ARE NOT DISPLAYED.

THE GRIEVE CORPORATION	
OVENS & FURNACES	
LABORATORY <input type="checkbox"/> INDUSTRIAL <input type="checkbox"/> CLEANROOM <input type="checkbox"/> PHARMACEUTICAL <input type="checkbox"/>	
CUSTOMER	
DESCRIPTION	REMOVABLE HEAT CHAMBER FIELD RE-INSTALLATION INSTRUCTIONS
MODEL	WTH & WTC MODELS
PURCHASE ORDER NO.	SHOP ORDER