



Welding Ovens
Since 1959

User Manual

Stationary Welding Rod Ovens
B1, B2, C1, C2, C2P, C3, C6, C9, MEC1, MEC2



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Safety

- The stationary oven sold with this manual should not be used for any purpose other than that for which it was designed.
- Before operating the oven it is advised that this user manual is read and understood by all users. Accidents and potential risks can be reduced by a thorough knowledge of the ovens operations and ideal working environment.
- It is important that the manual is kept in a tidy condition for any future reference, if a manual is misplaced or damaged, a replacement can be obtained from CIA Ovens.
- Do not damage or remove the safety and rating labels from the oven

All mineral coated electrodes begin absorbing moisture once they are unpacked. Welding with moist electrodes leads to increase arc spatter, undercutting and poor slag removal. Other side effects include porosity, underbead cracking and generally low grade welds. The range of ovens provides facilities for every application where quality welds are required. NOTE: ELECTRODES MUST ALWAYS be removed from their wrappers or packets prior to heating. Failure to do so will result in an increased risk of fire and moisture not being carried off and being re-absorbed into the coating when the electrodes cool.

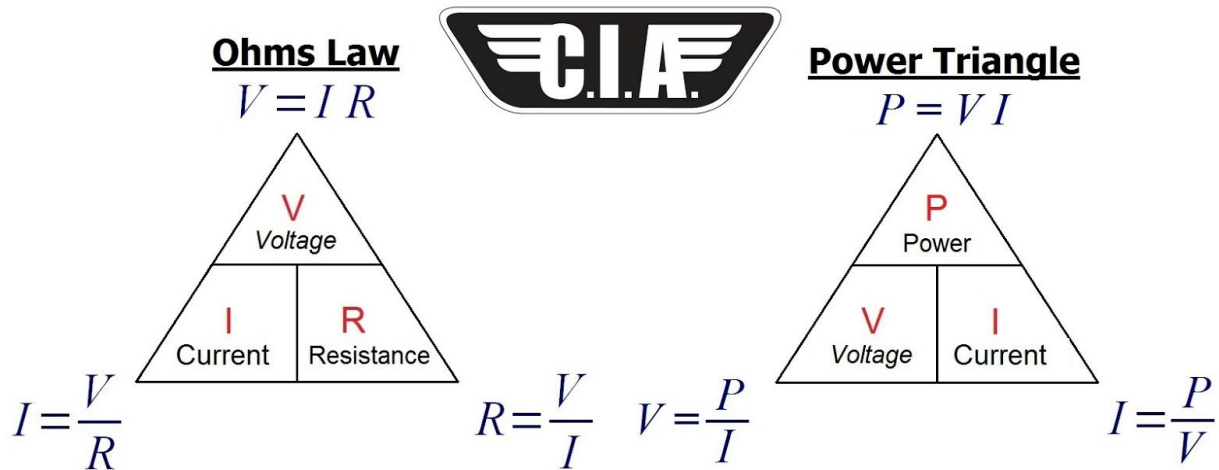
- In the event of danger such as fire or overheating it is important that the electrical supply be switched off at the first sight of danger
- Take great care when removing electrodes from the oven after heating, wear gloves and take care, the oven may still be very hot.
- Undergo all operations with general due care and attention





Electrical Information

To ensure that your CIA product is electrically safe, it is important to ensure that a suitably rated fuse is used in the plug when using the oven. By following simplistic electrical codes of practice such as Ohms law and the Power Triangle, determining the correct and appropriately rated fuse is used. Below is a explanation of these electrical theories:



Oven Model	Voltage (Volts)	Power Output (Watts)	Current (Amperes)	Total Resistance (Ohms)
B1	110	750	6.82	16.13
	240	750	3.13	76.8
B2	110	1500	13.63	8.06
	240	1500	6.25	38.4
C1	110	2250	20.45	5.37
	240	2250	9.375	25.6
C2/C2P	110	3000	27.27	4.03
	240	3000	12.5	19.2
C3	380	4700	12.37	30.72
C6	380	9400	24.74	15.36
C9	380	13500	35.53	10.7
MEC/1	240	2500	10.42	23.04
MEC/2	380	5100	13.42	28.31



Oven	Capacity	Max Temp	Power Output	
B1 110V, 240V	50 KG	300 C	750Watt	
B2 110V, 240V	150KG	300 C	1500Watt	
C1 110V, 240V	150KG	400 C	2250 Watt	
C2 110V, 240V	150KG	500 C	3000 Watt	



C2P 110V, 240V	150KG	500 C	3000 Watt	
C3 380V 3 Phase	225KG	400 C	4700 Watt	
C6 380V 3 Phase	450KG	400C	9400 Watt	
C9 380V 3 Phase	650KG	400C	13500 Watt	



MEC1 240V	300KG	300C	2500Watt	 A green industrial machine with a control panel on top and a large door on the front.
MEC2 380V 3 Phase	405KG	300C	5100Watt	 A green industrial machine, similar to the MEC1 model, with a control panel on top and a large door on the front.



Installation

The Oven is shipped in a durable cardboard box to provide protection during shipment, wherever possible try to re-use the box or dispose it in an environmentally responsible way. For ovens C3, C6, C9 a heavy duty wooden crate is also used for shipping, please dispose of the crate responsibly.

Great care should be taken with the ovens location and operating environment, please consider the following to ensure your CIA Stationary Oven is located safely:

Oven models C3, C6, C9, MEC1, MEC2 are equipped with eyebolts, use these to lift the oven into the desired location.

- Where possible place the oven on flat or level ground, avoid slanted, uneven and undulating surfaces, or any environment in which the oven could become unstable or fall over completely.
- Ensure the ovens power cable is not subject to high tension, always provide some slack
- Do not place the oven in places where it could be subject to draft or high levels of humidity.

Once the oven is placed in its optimal location adhere to the following guidelines for an efficient and safe installation:

- Check that the mains electrical supply is suitable for the oven. The voltage and power requirements are given on the rating plate located next to the mains supply cable.
- Connection to the mains electrical supply should be made via an appropriately fused plug for a single phase installation, or a fused isolator switch for a permanent 3 phase installation.
- It is recommended that the earth lead is connected with provision for some `slack` so that, in the event of the cable coming under stress the earth wire is the last to be affected

The colour coding of the mains supply is as follows:

<u>Single Phase</u>		<u>Three Phase</u>	
<u>Wire Colour</u>	<u>Connection</u>	<u>Wire Colour</u>	<u>Connection</u>
Brown	Live	Brown	Line Conductor 1
Blue	Neutral	Black	Line Conductor 2
Green/Yellow	Earth	Grey	Line Conductor 3
-	-	Blue	Neutral (Where Fitted)
-	-	Green/Yellow	Earth



Operating Instructions

Stationary Ovens B1, B2, C1, C2, C2P

Starting the oven:

1. Ensure the oven is sitting steadily
2. Open the door and fill with desired quantity of electrodes & close door firmly using door catch
3. Securely plug the oven into a suitable power source and switch on the supply
4. Turn the oven on via the neon switch located on the front of the oven, the digital display will begin to flash in its startup procedure.
5. The display will then indicate the ovens internal temperature.

Changing the ovens target temperature: (except C2P)

1. Press the 'P' key on the digital controller
2. Use the UP arrow or DOWN arrow keys to adjust to desired temperature
3. Confirm the new temperature by pressing the 'P' key
4. After a period of inactivity the controller will return to show the internal temperature whilst heating up to the desired temperature.

Stationary Oven C2P

Changing the ovens target temperature (Normal mode conditions)

This sequence allows the user to select a custom cycle comprising of a main set point-soak time-secondary set point

1. Ensure the controller is switched on and not running in standby mode, (press the 'O'ride' button to activate the controller)
2. Press 'P' key and Pr.S1 will be displayed, use the UP and DOWN arrow keys to adjust set point 1
3. Press 'P' key to confirm, Pr.t.1 will be displayed, use the UP and DOWN keys to adjust the soak/dwell time (Hours/Minutes), Press 'P' key to confirm
4. Pr.S.2 will be displayed, use the UP and DOWN arrow keys to adjust set point 2- 'P' Key to confirm
5. At the end of the cycle the the oven will remain in the active set point (set point 2) until the oven is switched off or the delay timer programme ceases.

Changing the ovens target temperature (Delayed Mode Conditions)

When used in conjunction with normal mode, this sequence allows the user to select a specific day and time to automatically switch the oven on and complete a pre-set cycle.

Setting the clock:

1. Press the 'Set' button, the display will show 0.00 with "C" flashing to the right of the display
2. Press the 'Day' button until the black indicator shows the desired day (1-7)
3. Use the 'HRS' button to set the hours followed by the 'Mins' button to set the minutes
4. Press 'Set' button to confirm



Now programme the controller to a desired sequence as explained in 'normal mode conditions' section.

Setting Programme 1:

1. Press the 'Set' button on the delay timer and hold for 3 seconds until the display shows --/-- with '1' flashing (indicating programme 1)- the day indicator will point to 'Day 1'
2. Set the 'ON' time required for day one using the 'Hrs' and 'Mins' buttons to set hour and minute time accordingly.
3. Press the 'Set' button briefly and the display will show --/-- with 'INT' appearing on the display, this now requires an 'OFF' point to be set
4. In order to trip the logic input on the controller to switch to the pre-programmed cycle, set the first 'OFF' point **1 minute after the "ON" time**
5. Press the 'Set' button briefly and the display will show --/-- and the ON time for programme 2 can be set
6. To set programmes for different days press the 'day' button and select the desired day-the display will show --/-- ready for programme 1 setting
7. Programmes for day 2-7 can be set in the same way as day 1.

Once the programming is complete press the 'Set' button and hold for 3 seconds until the display returns to the correct time of day, the timer is now in its operating condition.

Suspending Programmes

Press and hold down the Set button for about 3 seconds until the first "ON" programme, day 1 is displayed. Press the Day button repeatedly until the day indicator points to the day on which you wish to suspend the ON / OFF time. Press the Set button repeatedly until the "ON" or "OFF" time of the programme you wish to suspend is displayed. Now press the O'ride button. A black "X" will appear indicating that both the "ON" and "OFF" times for this programme have been suspended until reinstatement by the user. There is no limit to the number of programmes you can suspend. To reinstate a suspended programme return to either the "ON" or "OFF" time of the programme which has been suspended and cancel the black "X" by pressing the O'ride button. The ON / OFF programme will now operate on the selected day.

Reviewing The Programmes

Press and hold down the Set button for about 3 seconds until the first programme "ON" time for day 1 is displayed. Press the Day button repeatedly until the day indicator points to the day to be reviewed after which brief pressing of the Set button will display each programme or unused setting in sequence for that day. At any point the setting may be altered, if required, by using the hour & minute buttons. To review another day press the Day button until the day indicator points to the required day and use the Set button to select programmes as before.



Stationary Ovens MEC1, MEC2

Starting the oven:

1. Check the power supply connections
2. The 'white' pilot light confirms that the oven is on.
3. Set the desired temperature on thermo-regulator; electrodes can be loaded in the oven immediately
4. The 'Green' pilot light (labeled Resistenze) confirms that the oven is heating up to desired temperature.

Stationary Ovens C3, C6, C9

Starting the oven:

1. Load the oven with the desired amount of electrodes
2. Ensure the door is fully shut
3. Check that the power connections are secure
4. Turn the oven on via the main switch and check for power
5. After 10 seconds the thermoregulators are able to be programmed to the desired conditions.

Altering the temperature and time set-points:

In cases where a custom programme is required, please follow the instructions below:

a) ADJUSTMENT OF THE HEATING ELEMENTS CONTROL AND SAFETY THERMOREGULATOR (°C heating element) : press and release the key L1 : the L1 led starts flashing, 1SP is displayed for one second , then the value linked to the setpoint appears; press LEFT or RIGHT to change the value ; the new value and the return to normal mode can be saved; the same happens after 10 seconds of inactivity. Press 0/1 to return to normal mode without saving any value.

b) ADJUSTMENT OF THE OVEN-ENVIRONMENT THERMOREGULATOR (°C oven- environment) at active "SET POINT" stage (SP1 or SP2). Cycle **SP1** (drying): pressing the "P" key (for 1 sec.max.) , the SP1 adjustment is activated; act on UP and DOWN and set the required temperature (400°C max.); enter by pressing the "P" key (for max. 1 sec.)
After 6 hours (the time is adjustable from MENU as per following description) you can go to: Cycle **SP2** (keeping): pressing the "P" key (for 1 sec.max.), the SP2 adjustment is activated; act on UP and DOWN set the required temperature (200°C max.); enter by pressing the "P" key (for 1 second max.) During the programming time checking is halted

c) ADJUSTMENT OF THE OVEN-ENVIRONMENT THERMOREGULATOR (°C oven- environment) at inactive "SET-POINT" stage (SP1 – SP2): The programming menu is activated pressing on "P" key for more than 2 seconds.

Through UP and DOWN keys, select "OPER" and confirm with the "P" key. Select by UP/DOWN and choose "SP2", enter by pressing "P", 120° (or last programming) appears, select by UP/DOWN until the required value is achieved, enter by pressing "P" key.

(The thermoregulator gets back to start, whether no change is done in 20 seconds)



Drying Time Programming (T Lasting)

The programming menu is activated pressing on "P" key for more than 2 seconds.

Through UP & DOWN keys, select "OPER" and confirm with the "P" key.

/DOWN keys, "1REG" appears, press "P" and time last. appears, press "P" and 6.00 (last programming stated in hours, min.) appears, select by UP/DOWN keys, until the required value is achieved, enter by pressing "P" key. (The thermo regulator gets back to start, if no change is completed within 20 seconds).

It is necessary to switch the oven off and switch it on again when you change the parameters to apply them.



Operating Recommendations

Re-drying Temperatures

The temperature at which basic electrodes should be re-dried depends on the level of hydrogen considered permissible in the deposited weld. Recommended re-drying temperatures to reduce hydrogen content to various limits are as follows:

<u>Condition</u>	<u>Re-Drying Temperature</u>	<u>Typical Application</u>
10/15ml H₂/100 grams weld	150 Celsius-60 Minutes	To resist HAZ cracking on highly restrained joints & thick mild steel sections
5/10ml H₂/100 grams weld	250 Celsius-60 Minutes	For high duty applications pressure vessels structural work e.g. BS 1501. BS 4360
Below 5ml H₂/100	450 Celsius-60 Minutes	Highly critical alloyed materials

Note: It has been suggested that the presence of even the smallest amount of hydrogen can adversely affect lamellar tearing. Therefore where lamellar tearing is a problem re-drying at 450c for 60 minutes is often carried out.

Prolonged Drying Periods

Some fabricators who are concerned to obtain the highest possible radiographic standards of weld metal have developed a technique whereby, the electrodes, on completion of drying, remain in the oven at full temperature until they are required for use. The technique is very effective in providing thoroughly dry electrodes but may tend to decrease the strength of the coating. It is suggested, therefore, that the maximum drying period for various re-drying temperatures should be set as follows:

<u>Drying Temperature</u>	<u>Maximum Period at Temperature</u>
150 Celsius	72 Hours
250 Celsius	12 Hours
450 Celsius	2 Hours

Recommended Re-Drying Conditions

<u>Group</u>	<u>Size (mm)</u>	<u>Condition</u>
Mild steel rutile electrodes (Fastex 5, Zodian Universal)	1.6-6.0	80 Celsius- 60 Minutes
Stainless steel electrodes (e.g: Nicrex E347-16. Nicrex E308L-16, Nicrex E316L-16)	1.6-5.0	350 Celsius- 120 Minutes
Cellulosic electrodes (e.g: Celtian)	2.5-5.0	NOT RECOMMENDED



Maintenance

Planning of routine maintenance is an essential part of ensuring your CIA Ovens product is kept in the best possible condition and to ensure continual, efficient operation. Always conduct maintenance when the oven is out of service. Always ensure that the power cable is in good condition, free from breakages or tearing. NOTE: Check that the oven is cool before commencing maintenance work.

STATIONARY OVEN B1

Element Replacement

1. Switch off and disconnect the oven from the electrical mains supply.
2. Retain all screws, nuts etc. for re-assembly.
3. Turn the oven upside down and remove the six screws securing the control box.
4. Note the connections and remove nuts, washers and wires from the element terminals.
5. Remove the bottom shelf & release the p'clip securing the element. Remove the element.
6. Check the element/s for continuity.
7. Replace the faulty element.
8. Re-assemble in the reverse order

Thermocouple Replacement

1. Complete steps 1-3 of B1 element replacement
2. Note connections for the thermocouple into the controller, and disconnect where necessary
3. Remove the outer back panel with the 4 screws at the rear of the oven
4. Remove the clip holding the thermocouple at the back of the inner chamber and remove the thermocouple
5. Replace the faulty thermocouple and reverse steps 4-1 to build the oven back up

Digital Controller Replacement

1. Complete steps 1-3 of B1 element replacement
2. Carefully note the connections to the rear of the controller before disconnecting
3. Remove the two white plastic panel clips holding the controller to the fascia
4. Remove the faulty controller.
5. Replace with new controller and reverse steps 4-1 to build the oven back up

STATIONARY OVEN B2, C1, C2, C2P

Element removal

1. Switch off and disconnect the oven from the electrical mains supply.
2. Retain all screws, nuts etc. for re-assembly.
3. Remove the four screws securing the back panel.
4. Note the connections and remove the nuts, washers and wires from the element terminals.
5. Loosen the element retaining clips on the top and bottom shelves and slide the elements out of the oven.
6. Check the elements for continuity.
7. Replace the faulty element/s.
8. Re-assemble in the reverse order.



Thermocouple Replacement

1. Switch off and disconnect the oven from the electrical mains supply.
2. Retain all screws, nuts etc. for re-assembly.
3. Turn the oven upside down and remove the six screws securing the control box.
4. Note connections for the thermocouple into the controller, and disconnect where necessary
5. Remove the outer back panel with the 4 screws at the rear of the oven
6. Remove the nut holding the thermocouple at the back of the inner chamber and remove the thermocouple
7. Replace the faulty thermocouple and reverse steps 4-1 to build the oven back up

Digital Controller Replacement

1. Complete steps 1-3 of thermocouple replacement
2. Carefully note the connections to the rear of the controller before disconnecting
3. Remove the two white plastic panel clips holding the controller to the fascia
4. Remove the faulty controller.
5. Replace with new controller and reverse steps 4-1 to build the oven back up

STATIONARY OVENS C3, C6, C9

Element replacement

1. Open the oven door and remove the electrode trays.
2. Remove the metal hat shaped cover located on the rear of the oven.
3. Disconnect the faulty heating element and replace with a new one having the same properties and sizes.
4. Fit the new heating element.
5. Reassemble the bottom cover on the rear of the oven.
6. Place the electrode trays in the oven chamber
7. Switch on the oven main power switch for few minutes to eliminate any possible humidity residual on the new heating element.
8. Switch off the oven and let the heating elements cool.
9. The oven is now ready for operation.

Extraordinary maintenance

Periodically check the quality and connection of electrical wires and components, and replace where necessary. In the case of any further problem, please contact your dealer or directly to CIA Ovens who are on hand to help resolve your problem.



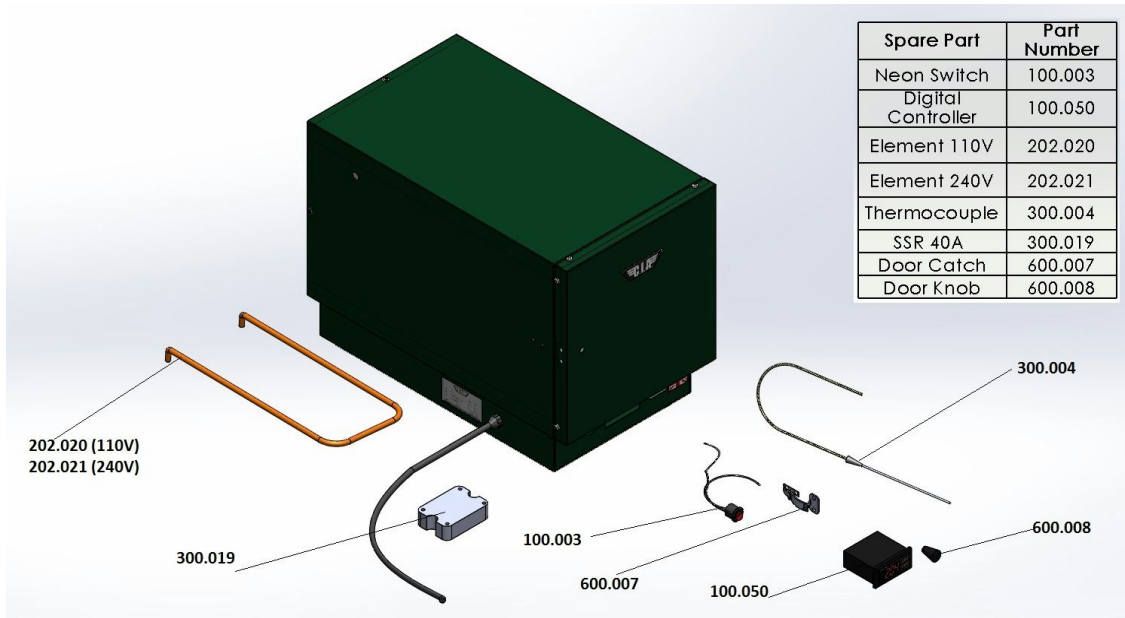
STATIONARY OVENS MEC1, MEC2

Element replacement

1. Disconnect the oven from the power source.
2. Open the door and remove the tray from the oven.
3. Remove the metal hat shaped cover located on the rear of the oven.
4. Disconnect the electrical cable from the faulty heating element.
5. Fit the new heating element having the same properties and sizes and restore the right connections.
6. Install the metal hat shaped cover electrical heating element connections.
7. Place the electrode trays in the oven chamber.
8. Switch on the oven main power switch for few minutes, then switch it off and let the heating elements cool and let them cool for about 15 minutes. This stabilizes the new heating element so it will last longer.
9. The oven is now ready for operation

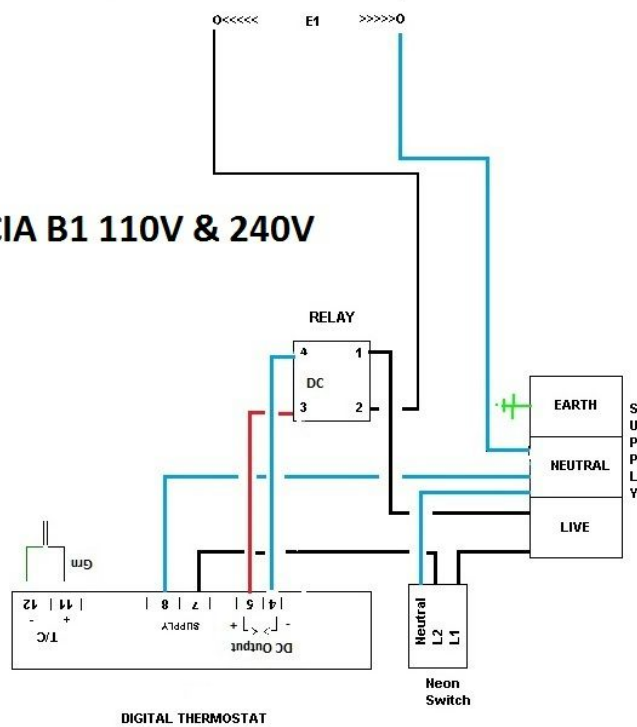


CIA B1



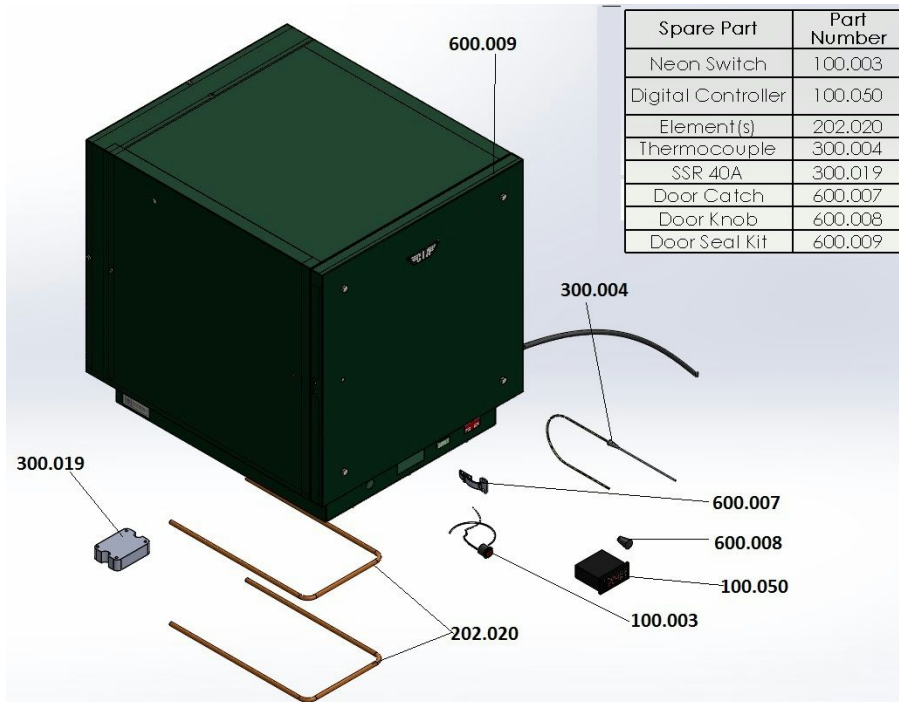
Spare Part	Part Number
Neon Switch	100.003
Digital Controller	100.050
Element 110V	202.020
Element 240V	202.021
Thermocouple	300.004
SSR 40A	300.019
Door Catch	600.007
Door Knob	600.008

CIA B1 110V & 240V



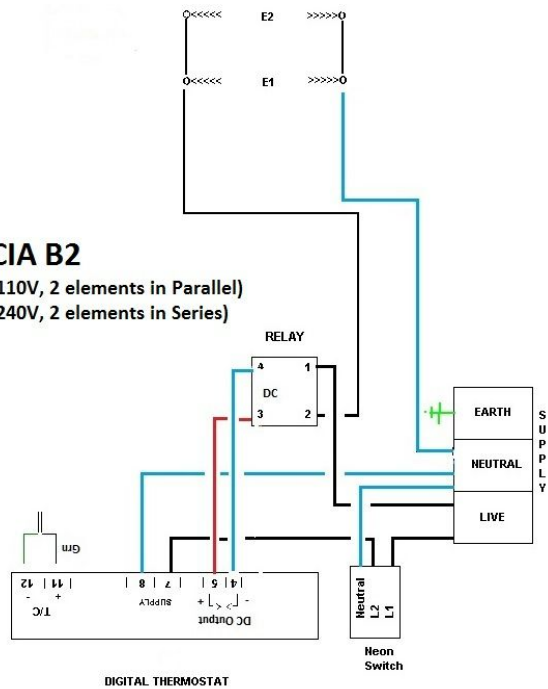


CIA B2



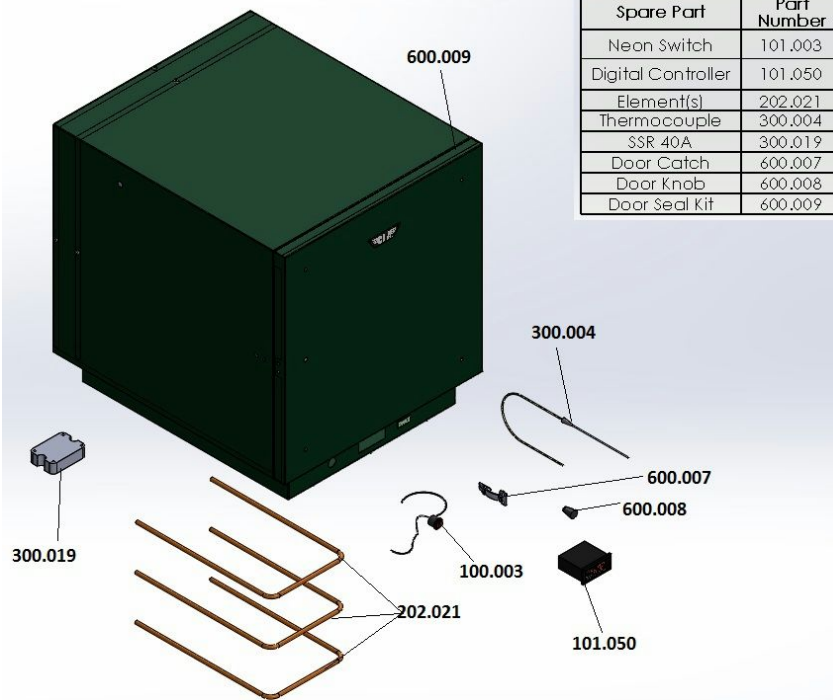
Spare Part	Part Number
Neon Switch	100.003
Digital Controller	100.050
Element(s)	202.020
Thermocouple	300.004
SSR 40A	300.019
Door Catch	600.007
Door Knob	600.008
Door Seal Kit	600.009

CIA B2 (110V, 2 elements in Parallel) (240V, 2 elements in Series)



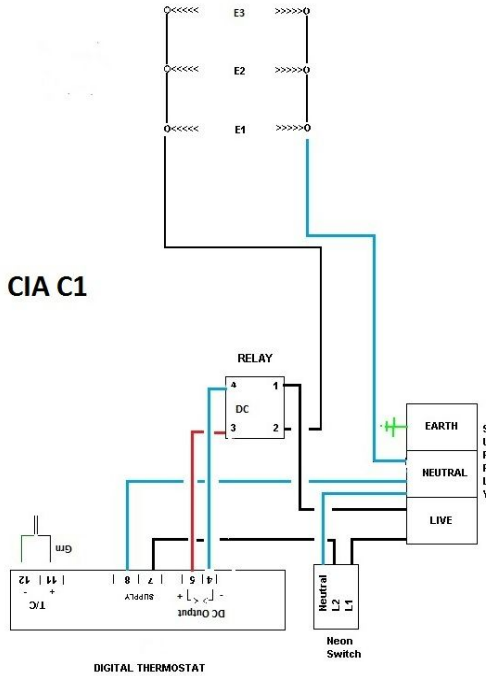


CIA C1



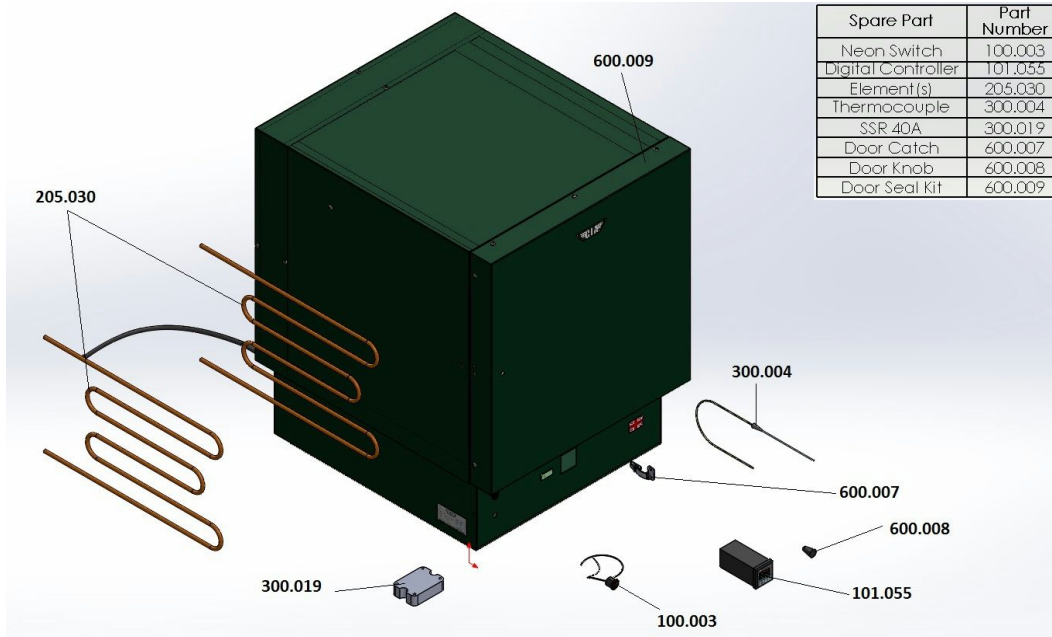
Spare Part	Part Number
Neon Switch	101.003
Digital Controller	101.050
Element(s)	202.021
Thermocouple	300.004
SSR 40A	300.019
Door Catch	600.007
Door Knob	600.008
Door Seal Kit	600.009

CIA C1

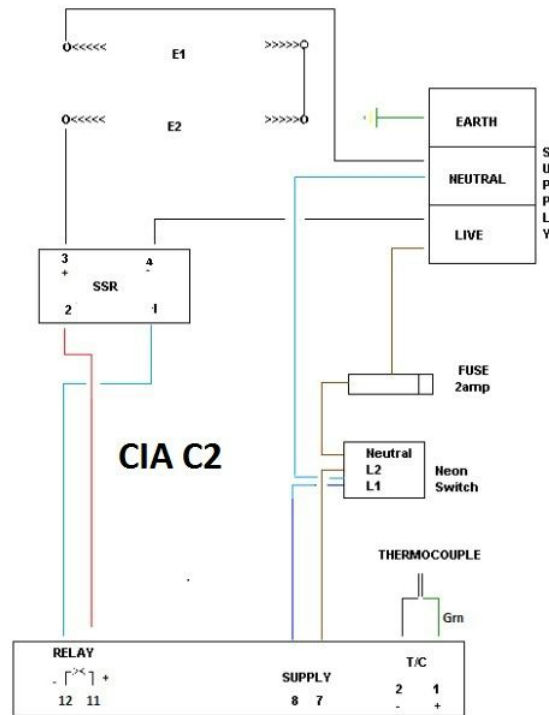




CIA C2

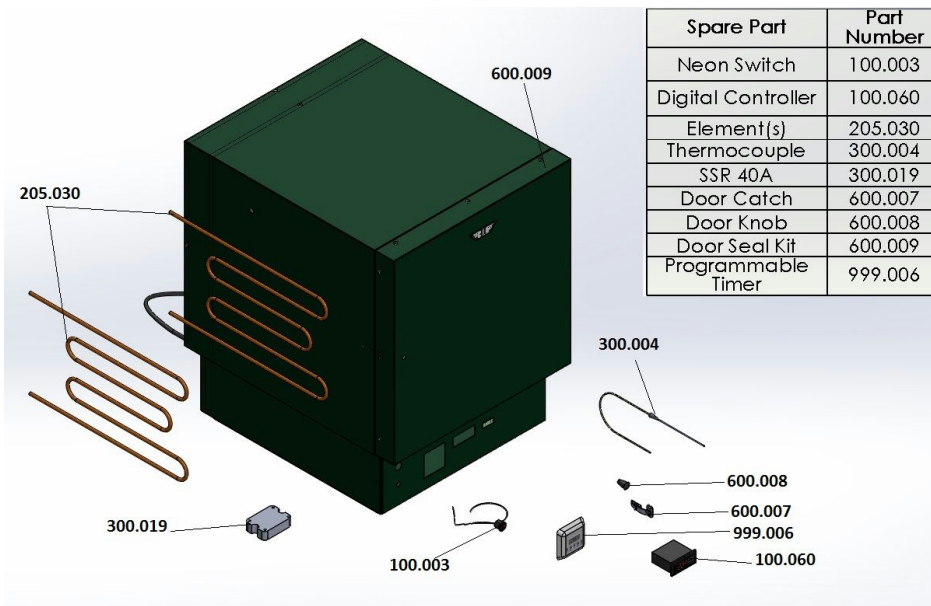


Spare Part	Part Number
Neon Switch	100.003
Digital Controller	101.055
Element(s)	205.030
Thermocouple	300.004
SSR 40A	300.019
Door Catch	600.007
Door Knob	600.008
Door Seal Kit	600.009

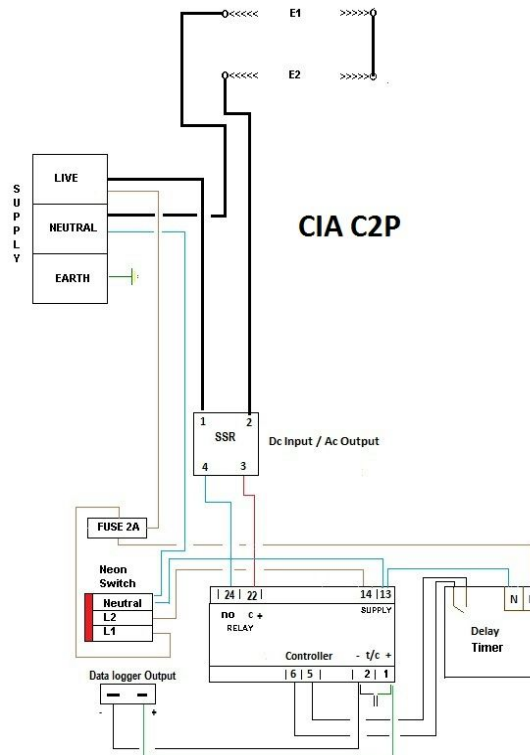




CIA C2P

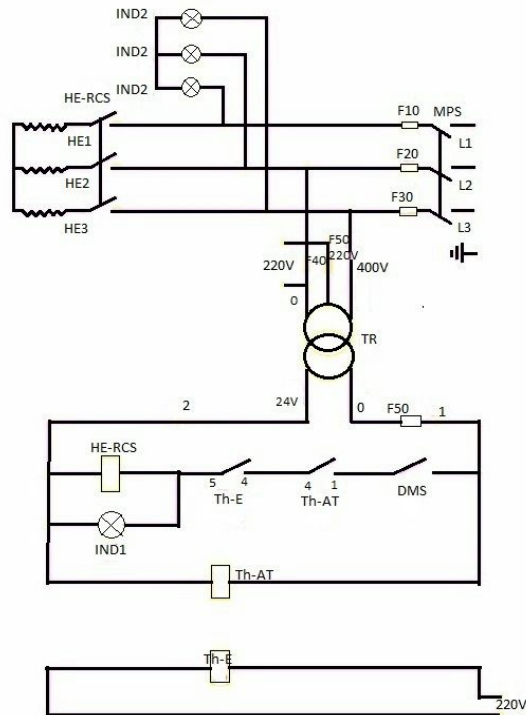


Spare Part	Part Number
Neon Switch	100.003
Digital Controller	100.060
Element(s)	205.030
Thermocouple	300.004
SSR 40A	300.019
Door Catch	600.007
Door Knob	600.008
Door Seal Kit	600.009
Programmable Timer	999.006





CIA C3, C6, C9

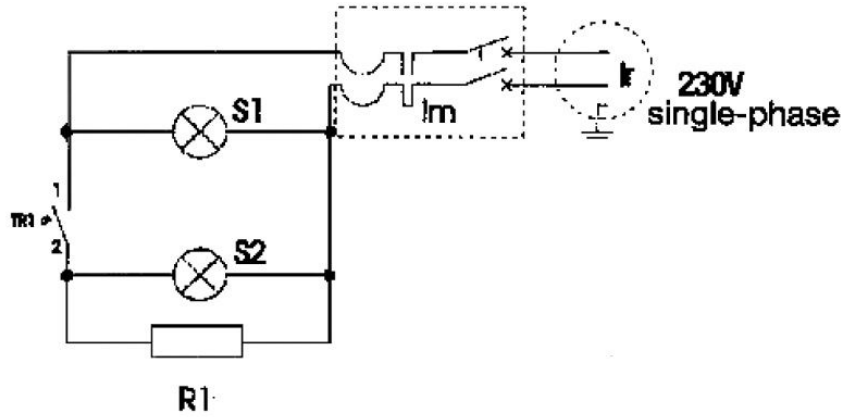


MPS	Main Power Switch 3x16/3x25/3x32A
Th-E	Element Thermoregulator
Th-AT	Air temp Thermoregulator
IND1	Green "ON" signal lamp
IND2	White "CONNECTION" signal lamp
HE-RCS	Element(s) remote control switch
HE1-HE2-HE3	Heating Elements 230V 1500W x C3-C6-C9-Fm2/ 2750W x Fm-Fm1/ 1300W x C100-C200-C400D
TR	220-380/24V Transformer
F10-F20-F30	Fuses 16A (C3)-20A (C6)-32A (C9)
F40-50	Fuse 2A
DMS	Door Micro Switch

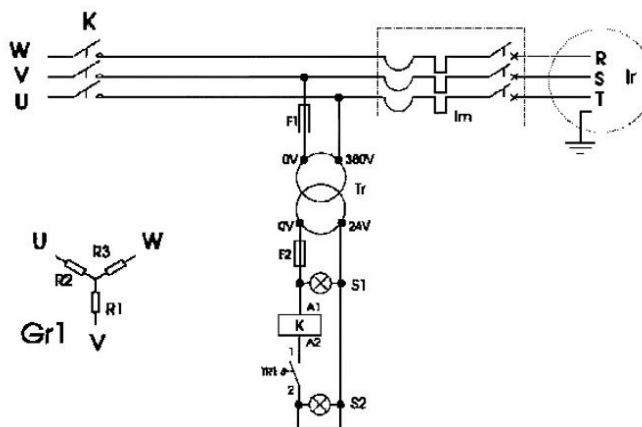


CIA MEC1, MEC2

Symbols description	
R1	Heating element 2500W, 220V
S2	Green Heating element pilot lamp
TR1	Thermoregulator
S1	White power supply pilot lamp
Im	Circuit breaker
Ir	Power supply



Symbols description	
F2	Fuse on secondary 4.0 A
F1	Fuse on primary
GR1	Heating elements set – 3 x 1700W 220V
K	Contactor
S2	Green Heating element pilot lamp
TR1	Thermoregulator
S1	White power supply pilot lamp
Tr	Transformer
Im	Circuit breaker
Ir	Power supply





Symbol	Description
Im	Circuit breaker 10° 1-ph+N
	Circuit breaker 10° 3-ph
Ir	IEC plug 230V (for MEC/1)
	IEC plug 380V (for MEC/2)
S1	Pilot lamp 220V with white lens cap (for MEC/1)
	Pilot lamp 24V with white lens cap (for MEC/2)
S2	Pilot lamp 220V with green lens cap (for MEC/1)
	Pilot lamp 24V with green lens cap (for MEC/2)
R	Heating element 2500W 220V (for MEC/1)
	Heating element 1700W 220V (for MEC/2)
TR1	Thermoregulator
Th	Thermometer 0-500°C
Tr	Transformer (for MEC/2)
F1	Fuse on primary
F2	Fuse on secondary 4.0 A
K	Contacto●



Item	Part Number	Item	Part Number
Neons		High Temp Elements	
Neon Indicator 110/240V	100.001	C2-C2P Element 1500Watt	205.030
Neon Indicator 48/85V Chrome Bezel	100.002	Thermocouple	
Neon switch 240V	100.003	Thermocouple Type K	300.004
Digital Controllers		Solid State Relay	
B1, B2, C1 Digital Controller	101.050	Solid State Relay (90-240V - 3-32Vdc) 40Amp	300.019
C2 Digital Controller	101.055	Door Parts	
C2P Digital Controller	101.060	Door Catch	600.007
Stationary Oven Elements		Door Knob (M6 Black Moulded Knob)	600.008
110V, 750Watt, 940mmx 6.5ø element	202.020	Door Seal Kit (Glass fibre tape + rivets)	600.009
240V 750W, 940mmx6.5ø element	202.021	Thermostats	
Quiver Elements		Thermostat Kit (120c)	700.120
110-240V Dual voltage element (P16)	203.001	Thermostat Kit (200c)	700.200
24V-150Watt 6.35ø element	203.002	Thermostat Kit (320c)	700.320
80V-200Watt 6.35ø element	203.003	Capacitors	
110V-150Watt 6.35ø element	203.004	Capacitor (48/85V versions only)	999.000
240V-150Watt 6.35ø element	203.008	Data Logger Kits	
48/85V-300Watt Element P8-P15	203.005	Data Logger	999.001
110V-300Watt Element P8-P15	203.006	Thermal Cut Out's	
240V-300Watt Element P8-P15	203.007	Thermal Cut out (24-48/85V Quiver only)	999.002
Dual voltage quiver element 110/240V 150W	203.009	Thermometers	
85V-275Watt 100x100 Square Element	204.060	0-250 Deg Thermometer	999.003
110V-275Watt 100x100 Square Element	204.061	32-500 Deg Thermometer	999.004
240V-275Watt 100x100 Square Element	204.062	Voltage Selectors	
		Voltage Selector Switch	999.005
		Programmable Timer	
		7 Day Programmable Timer C2P	999.006



Useful Information

<u>Model</u>	<u>Power (kW)</u>	<u>Capacity Kg</u>	<u>Internal dimensions (mm)</u>	<u>Shipping Weight Kg</u>
<u>B1</u>	0.75	50	250x480x250	19
<u>B2</u>	1.5	136	470x470x480	40
<u>C1</u>	2.25	136	470x470x480	40
<u>C2</u>	3	136	470x470x480	65
<u>C2P</u>	3	136	470x470x480	65
<u>C3</u>	4.7	225	740x530x470	150
<u>C6</u>	9.4	450	740x530x890	215
<u>C9</u>	13.5	650	740x530x1330	280
<u>MEC1</u>	2.5	300	650x520x550	95
<u>MEC2</u>	5.1	405	650x520x810	117

Warranty

General conditions

CIA guarantees the product mentioned in this manual for a period of 12 (twelve) months from the date of delivery. The warranty is valid for the above mentioned period and only for the parts that will have defect of design or defective material. CIA will give you further instructions for repairing or replacing the complained parts, free of charge. Any transport expenses will be covered by the customer.

Limitations

CIA Ovens Ltd **is not and will not be** responsible for:

- Improper use of the oven
- A use against the national and/or International regulations in force (where applicable)
- Improper or wrong connection
- Improper or insufficient care and maintenance
- Unauthorized modifications and/or services
- Use of non-original spare parts or non-specific components
- Partial or total Inobservance of the instructions



Declaration of *Conformity/Incorporation*

The electrical equipment which accompanies this declaration is in conformity with EU Directive(s)

*2006/95/EC Low Voltage Directive
2004/108/EC Electromagnetic Compatibility Directive*

CIA OVENS LTD

Unit 4, Station Road,
Furness Vale,
High Peak
United Kingdom

DIGITALLY CONTROLLED RE-BAKING OVENS

Models: B1,B2,C1,C2,C2P, MEC1, MEC2

The Technical Construction File is maintained at: CIA OVENS LTD.

Only for Declaration of Incorporation

This electrical equipment covered by this Declaration must not be put into service until the machinery into which it is to be incorporated has been declared in conformity with the provisions of the applicable Directive(s). This statement is only necessary where the product is to be incorporated into a machine or system.

The following harmonized standards have been used.

LVD	EMC <i>emission and immunity</i>
EN 60204-1:2006 - EN 60204-1:2006/A1:2009 EN 60529:1991 - EN 60529:1991/A1:2000 EN 60529:1991/AC:1993 EN 50525-1:2011 - EN 50525-2-11:2011 EN 50525-2-12:2011 - EN 50525-2-21:2011 EN 50525-2-71:2011	EN 61000-6-2:2005 - EN 61000-6-2:2005/AC:2005 EN 61000-6-3:2007 - EN 61000-6-3:2007/A1:2011 EN 61000-6-4:2007 - EN 61000-6-4:2007/A1:2011

The electrical equipment is CE-marked 2015



Declaration of Conformity

The Company: CIA Ovens Ltd

Declares under its sole responsibility that the product:

Stationary Ovens: C3,C6,C9

Is in conformity with the following standards:

**EN 61000-6-2
EN 61000-6-3
EN 60204-1**

**Test Reports: Electromagnetic Compatibility Rev 1 as of 19-05-2006
Electric Surety Rev 1 as of 29-05-2006**

The product is also in compliance with essential provisions of directives 2006/95/EEC & 2004/108/EEC