

## Reflow oven installation manual

### Preparation:

Dear Customer, thanks for choosing our KTR reflow oven, to make sure the machine runs smoothly, please prepare below material before installation:

1. One bottle of solder paste.
2. PCB for testing.
3. Power: 380V 3 phase, 5 wires.

Circuit breaker: 160A, wire capacity: 25sqm. Starting power: 29KW, and total power:80KW, normal running power: 12KW.

4. Exhausting requirement:

External exhausting: 10cbm/min.\*2 (entrance and exit) or more, the diameter of exhausting hole is 200mm, the distance between two exhausting holes is 5450mm.

5. If the machine has nitrogen system, the requirement for nitrogen is 0.5-0.8Mpa, the oxygen content of nitrogen source  $\leq 10$ PPM.

### Quick installation guidance

1. Place the machine in a certain location, remove the package and adjust the level.  
Adjust the foot cup and make sure each foot cup touches the ground well.
2. Induct electricity (3 phase, 5 wires, 380V)
3. Fix the display, connect each joints of the computer with relevant cable. After this, check every electrical parts and circuits to see if there is any loose or drop of the cables. Tighten the screws of the heater if there is any loose.
4. Connect the power, turn on the computer and open the top hood, remove the rail fixtures.
5. Close the top hood, connect the exhaust pipe (diameter is 200mm) at the two ends.
6. Enter into the software, open the “conveyor” “cooling”, set the temperature in heating zones. Run the machine for 1 hour, and if there is no problem, begin the production.

### Maintenance guidance

1. Lubricate the rail and chain once a week.
2. Lubricate the racks, ball screws and sliding parts inside the hood once a month.
3. Clean all flux filters (at the two ends of the machine, inside the flux box) every half a month.
4. Lubricate the driving motors with grease every two months.
5. Check if there is any loose of drop of electrical parts and cables.