

Instructions for Service Kits 50117 and 50118

PS536GS High Speed Conveyor Retrofit Kits

KIT COMPONENTS:

Qty.	P/N	Description
1	--	Assembly, PS536GS High Speed Conveyor (single belt in Kit 50117; split belt in Kit 50118)
2	2000105	Screw, slot truss hd #8-32 x 3/8"
A/R	34128	Drive motor sprocket, 20T
2	48707	Crumb pan
1	48851	Chain cover
1	50040	Exit tray
1	50050	Drive chain, 19-1/2"
A/R	50051	Drive chain, 12"
1	50057	Conveyor belt, complete
1	50060	Master link, left
1	50061	Master link, right
2	50062	Master link, center
1	50106	Template, PS536GS chain cover
1	50119	Instructions

TOOLS REQUIRED:

- Flat-bladed screwdriver
- Needle-nosed pliers
- Wire cutters
- Drill with #29 bit
- #8-32 tap
- Vacuum
- Template (MM P/N 50106, supplied with Kit)

These Service Kits update one Middleby Marshall PS536 oven to use the current PS536GS high-speed conveyor. Kit 50117 includes parts for one single-belt oven. Kit 50118 includes parts for one split belt oven.



WARNING

BEFORE PERFORMING ANY SERVICE WORK, THE ELECTRICAL POWER SUPPLY AND THE GAS SUPPLY MUST BE TURNED OFF.

1. Disconnect the oven from its electrical power supply at the circuit breaker/fused disconnect. For gas ovens, shut off the gas supply to the oven.
2. Remove the following components from the oven:
 - Chain cover
 - Upper end plugs
 - Drive chain(s)
 - Conveyor assembly
3. Place the kit-supplied template onto the front wall of the control compartment as shown in Figure 1. Check that the template lies flush on the wall and that its sides are aligned with the sides of the compartment.
4. Mark and drill the mounting holes for the new chain cover on the control compartment wall. Tap the holes with a #8-32 tap. Then, vacuum any metal shavings.
5. Install the conveyor belt onto the frame. Refer to Figure 2 to check the following:
 - The belt must be aligned properly according to the direction of conveyor travel.
 - The master links must be positioned properly.

Figure 1 - Template location

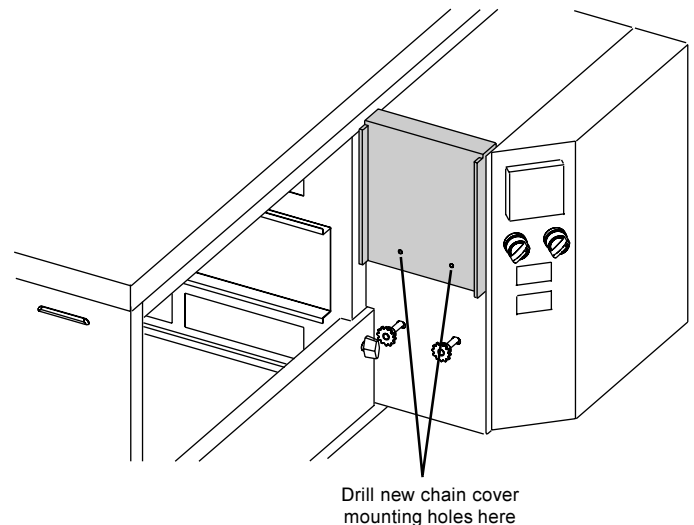
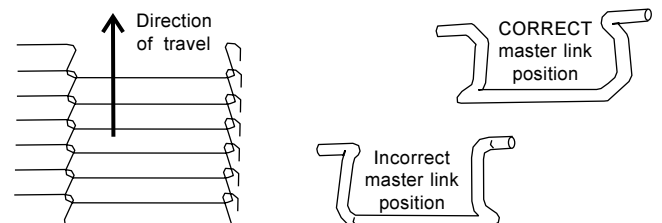


Figure 2 - Conveyor belt and master link orientation



6. Install the conveyor assembly into the oven. Then, install the kit-supplied drive chain(s).
7. Check that the conveyor assembly is positioned properly against the lower end plugs, as shown in Figure 3. Then, install the kit-supplied chain cover and fasten it in place with the kit-supplied #8-32 x 3/8" slotted truss head screws.
8. Replace the upper end plugs.
9. Install the crumb pans and exit tray onto the oven.
10. Check that the conveyor belt is properly tensioned as shown in Figure 4. The belt should be tensioned to a deflection of 1" (51mm) when lifted as shown.

11. Access the DIP switches on the conveyor speed controllers, and check that they are set as follows:

DIP switch

1	ON
2	ON
3	OFF
4	ON
5	ON
6	OFF
7	OFF
8	OFF

12. Restore the gas and electrical supply to the oven. The oven is now ready for operation.

Figure 3 - Conveyor placement

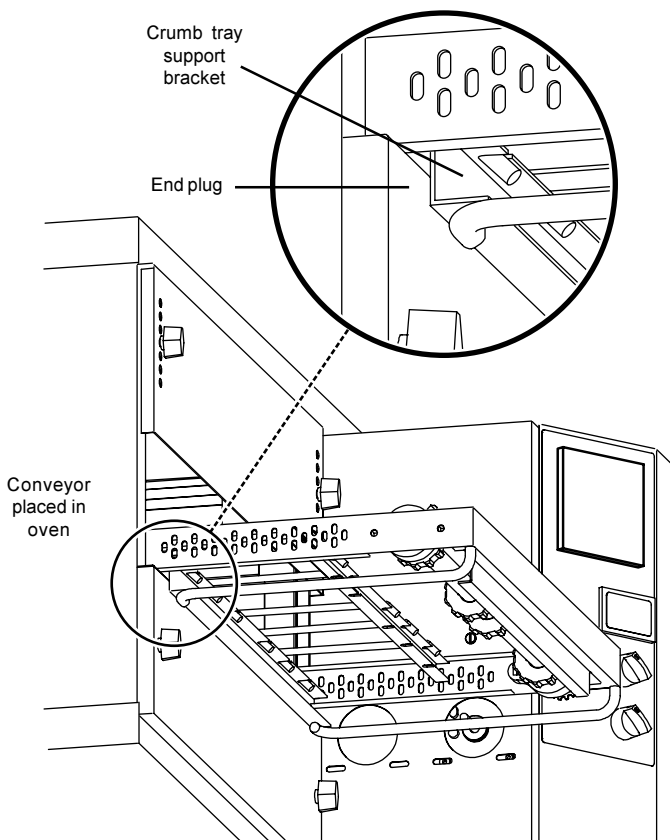
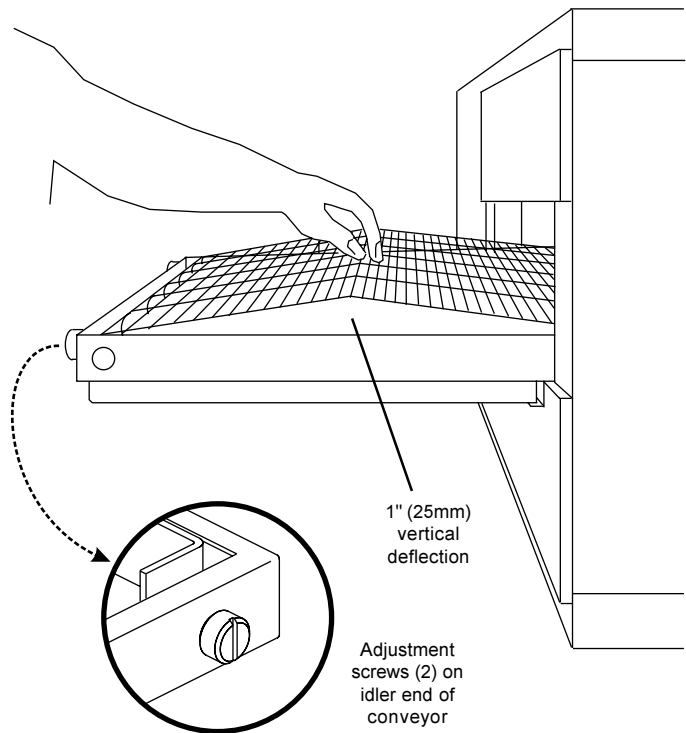


Figure 4 - Conveyor belt tension



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