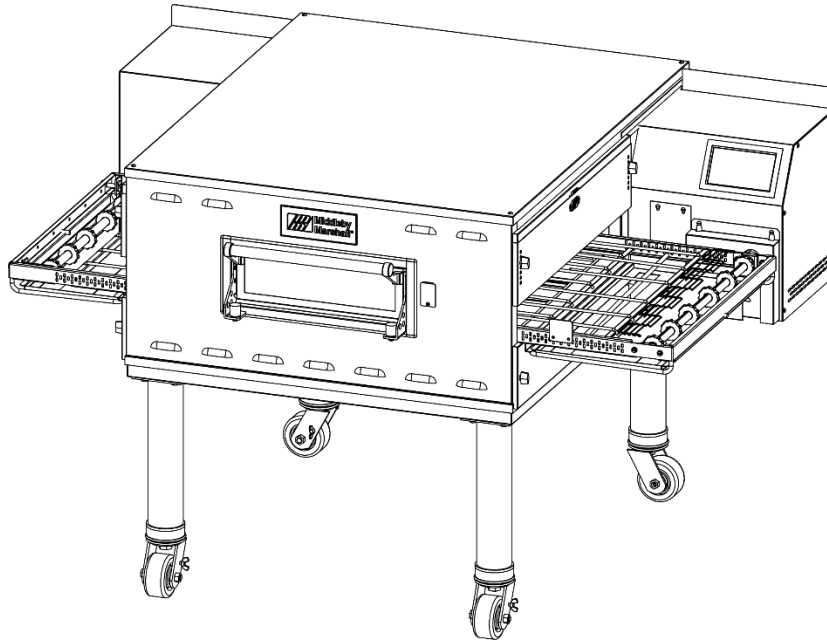


PS638 Series  
Electric and Gas Oven  
Domestic & Standard Export



P/N: 79059  
Revision C  
July 25<sup>th</sup>, 2023  
ENGLISH



## PS638 Series Electric and Gas Ovens

### ***Model:***

- PS638E Electric
- PS638G Gas

### ***Combinations:***

- Single Oven
- Double Oven (Two-Stack)
- Triple Oven (Three-Stack)
- KOF Applications

# ***OWNER'S OPERATING AND INSTALLATION MANUAL***

***for Domestic & Standard Export Ovens***

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**NOTICE:**

This Owner's Operating and Installation Manual should be given to the user. The operator of the oven should be familiar with the function and operation of the oven.

This manual must be kept in a prominent, easily reachable location near the oven.

Ovens are shipped from the factory configured for use with Natural gas. If permitted by local, national and international codes, at the time of installation the oven may be converted to Propane gas operation. This conversion requires the use of a Gas Conversion Kit that is supplied with the oven. For CE-approved ovens, the conversion is described in the *Installation* section of this manual. For domestic and standard export ovens, instructions are included in the Gas Conversion Kit.

It is recommended to obtain a service contract with a Middleby Authorized Service Company (ASC).

**WARNING**

**POST IN A PROMINENT LOCATION, THE EMERGENCY TELEPHONE NUMBER OF YOUR LOCAL GAS SUPPLIER AND INSTRUCTIONS TO BE FOLLOWED IN THE EVENT YOU SMELL GAS.**

**INSTRUCTIONS TO BE FOLLOWED IN THE EVENT THE USER SMELLS GAS SHALL BE OBTAINED BY CONSULTING THE LOCAL GAS SUPPLIER. IF THE SMELL OF GAS IS DETECTED, IMMEDIATELY CALL THE EMERGENCY PHONE NUMBER OF YOUR LOCAL GAS COMPANY. THEY WILL HAVE PERSONNEL AND PROVISIONS AVAILABLE TO CORRECT THE PROBLEM.**

**WARNING**

**DO NOT SPRAY AEROSOLS IN THE VICINITY OF THIS APPLIANCE WHILE IT IS IN OPERATION.**

**FOR YOUR SAFETY**

**DO NOT STORE OR USE GASOLINE OR OTHER FLAMMABLE VAPORS OR LIQUIDS IN THE VICINITY OF THIS OR ANY OTHER APPLIANCE.**

**WARNING: IMPROPER INSTALLATION, ADJUSTMENT, ALTERATION, SERVICE OR MAINTENANCE CAN CAUSE PROPERTY DAMAGE, INJURY OR DEATH. READ THE INSTALLATION, OPERATING AND MAINTENANCE INSTRUCTIONS THOROUGHLY BEFORE INSTALLING OR SERVICING THIS EQUIPMENT.**

**MESURE DE SÉCURITÉ**

**NE PAS ENTREPOSER NI UTILISER D'ESSENCE NI AUTRES VAPEURS OU LIQUIDES INFLAMMABLES À PROXIMITÉ DE CET APPAREIL OU DE TOUT AUTRE APPAREIL!**

**AVERTISSEMENT: L'INSTALLATION, LE RÉGLAGE, LA MODIFICATION, LA RÉPARATION OU L'ENTRETIEN INCORRECTS DE CET APPAREIL PEUVENT CAUSER DES DOMMAGES MATÉRIELS, DES BLESSURES OU LA MORT. LIRE ATTENTIVEMENT LES INSTRUCTIONS D'INSTALLATION, DE FONCTIONNEMENT ET D'ENTRETIEN AVANT DE PROCÉDER À SON INSTALLATION OU ENTRETIEN.**

**IMPORTANT**

An oven electrical wiring diagram is located in this manual and inside the machinery compartment.

**IMPORTANT**

It is the customer's responsibility to report any concealed or non-concealed damage to the freight company. Retain all shipping materials until it is certain that the equipment has not suffered concealed shipping damage.

**NOTICE**

CONTACT YOUR MIDDLEBY AUTHORIZED SERVICE COMPANY TO INSTALL AND PERFORM MAINTENANCE AND REPAIRS AND IF NECESSARY TO CONVERT EQUIPMENT FOR USE WITH OTHER GASES. AN AUTHORIZED SERVICE COMPANY DIRECTORY IS SUPPLIED WITH YOUR OVEN AND AVAILABLE HERE: [WWW.MIDDLEBY-MARSHALL.COM](http://WWW.MIDDLEBY-MARSHALL.COM)

**NOTICE**

Using parts other than genuine Middleby Marshall factory manufactured parts relieves the manufacturer of all warranty and liability.

**NOTICE**

Middleby Marshall (Manufacturer) reserves the right to change specifications at any time.

**NOTICE**

The equipment warranty is not valid unless the oven is installed, started, and demonstrated under the supervision of a factory authorized installer.

**NOTICE**

THE EQUIPMENT IS ONLY FOR PROFESSIONAL USE AND SHALL BE USED BY QUALIFIED PERSONNEL.

**RETAIN THIS MANUAL FOR FUTURE REFERENCE**

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**MIDDLEBY MARSHALL  
NO QUIBBLE LIMITED WARRANTY  
(U.S.A. ONLY)**

MIDDLEBY MARSHALL HEREINAFTER REFERRED TO AS "THE SELLER", WARRANTS EQUIPMENT MANUFACTURED BY IT TO BE FREE FROM DEFECTS IN MATERIAL AND WORKMANSHIP FOR WHICH IT IS RESPONSIBLE. THE SELLER'S OBLIGATION UNDER THIS WARRANTY SHALL BE LIMITED TO REPLACING OR REPAIRING AT SELLER'S OPTION, WITHOUT CHARGE, ANY PART FOUND TO BE DEFECTIVE AND ANY LABOR AND MATERIAL EXPENSE INCURRED BY SELLER IN REPAIRING OR REPLACING SUCH PART. SUCH WARRANTY SHALL BE LIMITED TO THE ORIGINAL PURCHASER ONLY AND SHALL BE EFFECTIVE FOR A PERIOD OF ONE YEAR FROM DATE OF ORIGINAL INSTALLATION OR 18 MONTHS FROM DATE OF PURCHASE, WHICHEVER IS EARLIER, PROVIDED THAT TERMS OF PAYMENT HAVE BEEN FULLY MET.

This warranty is valid only if the equipment is installed, started, and demonstrated under the supervision of a factory-authorized installer.

Abuse, acts of God, belt jams, cleaning, customer abuse, insufficient utilities, lubrication, maintenance, non-oven related issues, preventative maintenance, or normal maintenance function including adjustment of airflow, burners, conveyor components, door mechanisms, microswitches, pilot burners, thermostats, and replacement of bushings, light bulbs, fuses, indicating lights and wear points, are not covered by this **no quibble limited warranty**.

Seller shall be responsible only for repair or replacement of defective parts performed by Seller's authorized service personnel. Authorized service companies are located in principal cities throughout the contiguous United States, Alaska, and Hawaii. This warranty is valid in the 50 United States and is void elsewhere unless the product is purchased through Middleby International with warranty adder included.

**The foregoing warranty is exclusive and in lieu of all other warranties, expressed or implied. There are no implied warranties of merchantability or of fitness for a particular purpose.**

The foregoing shall be the Seller's sole and exclusive obligation and Buyer's sole and exclusive remedy for any action, including breach of contract or negligence. In no event shall Seller be liable for a sum in excess of the purchase price of the item. Seller shall not be liable for any prospective or lost profits of the buyer.

***This warranty is effective on Middleby Marshall equipment sold on, or after January 1<sup>st</sup>, 2007.***

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**MIDDLEBY MARSHALL  
OVEN LIMITED WARRANTY  
(Non U.S.A.)**

The Seller warrants equipment manufactured by it to be free from defects in material and workmanship for which it is responsible. The Seller's obligation under this warranty shall be limited to replacing or repairing, at Seller's option, without charge, F.O.B. Seller's factory, any part found defective and any labor and material expense incurred by Seller in repairing or replacing such part. Such warranty is limited to a period of one year from the date of original installation or 15 months from date of shipment from Seller's factory, whichever is earlier, provided that terms of payment have been fully met. All labor shall be performed during regular working hours. Overtime premium will be charged to the Buyer.

**This warranty is not valid unless equipment is installed, started, and demonstrated under the supervision of a factory-authorized installer.**

Normal maintenance functions including lubrication, adjustment of airflow, thermostats, door mechanisms, microswitches, burners and pilot burners, and replacement of light bulbs, fuses, and indicating lights, are not covered by warranty.

Any repair or replacement of defective parts shall be performed by Seller's authorized service personnel. Seller shall not be responsible for any costs incurred if the work is performed by anyone other than the Seller's authorized service personnel.

When returning any part under warranty, the part must be intact and complete, without evidence of misuse or abuse, freight prepaid.

Seller shall not be liable for any consequential damages of any kind which occurs during the course of installation of equipment, or which results from the use or misuse by Buyer, its employees, or others, of the equipment supplied hereunder, at Buyer's sole and exclusive remedy against Seller for any breach of the foregoing warranty or otherwise shall be for the repair or replacement of the equipment or parts thereof affected by such breach.

The foregoing warranty shall be valid and binding upon Seller if and only if Buyer loads, operates and maintains the equipment supplied hereunder in accordance with the instruction manual provided to Buyer. Seller does not guarantee the process of manufacture by Buyer or quality of product to be produced by the equipment supplied hereunder and Seller shall not be liable for any prospective or lost profits of Buyer.

The foregoing shall be Seller's sole and exclusive obligation and Buyer's sole and exclusive remedy for any action, whether in breach of contract or negligence. In no event shall Seller be liable for a sum in excess of the purchase price of the item.

THE FOREGOING WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER EXPRESS AND IMPLIED WARRANTIES WHATSOEVER, SPECIFICALLY THERE ARE NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

# SECTION 1 - DESCRIPTION

## I. OVEN USES

The PS638 Series Continuous Batch WOW Conveyor Ovens can be used to bake, cook, crisp, dry, heat, or finish a wide variety of products, such as catering, pastries, pizza, pizza-type products, cookies, sandwiches, and other items

## II. OVEN COMPONENTS – See Figure 1-1

### A. Conveyor Drive Motor (inside cabinet)

Moves the Conveyor Belting (65756).

### B. Crumb Pans

Catch crumbs and other materials that drop through the conveyor belt. One crumb pan is located at each end of the conveyor belt.

### C. Conveyor

Moves the food product through the oven.

### D. End Plugs

Allow access to the oven's interior.

### E. Eyebrows

Can be adjusted to various heights to lessen heat loss to the environment (72709).

### F. Window (Optional)

Allows the user to access the food products within the baking chamber, or place product into the oven for shorter bake times (51054).

### G. Control Cabinet Doors

Allow access to the oven's control components. No user serviceable parts are located within these cabinets.

### H. Serial Plate

Provides specifications for the oven pertinent to installation, operation and maintenance. Refer to Section 2, Installation for details.

### I. Control Panel (User Interface)

Allows user to adjust temperature, bake time, and top and bottom air flow. Also provides diagnostic messages for oven operation.

### J. Photo Sensor (Optional)

Puts oven into the Baking Mode when the beam is interrupted by product being placed on the belt (72209).

### K. Door Photo Sensor (Optional)

Puts oven into the Baking Mode when the beam is interrupted by the front window being opened to insert product.

### L. Circuit Breaker Resets

Permits resetting breakers inside control cabinet without opening control door or directly touching the circuit breakers.

### M. Burner or Heater (inside left control cabinet)

Heat recirculating air within the plenum and oven cavity.

### N. Blowers (not shown)

Move heated air that recirculates through the oven cavity.

### O. Fingers (inside oven cavity)

Direct air in controlled fashion to the product being baked through a highly specialized pattern arrangement of extruded holes. See Standard Finger Arrangement (73555).

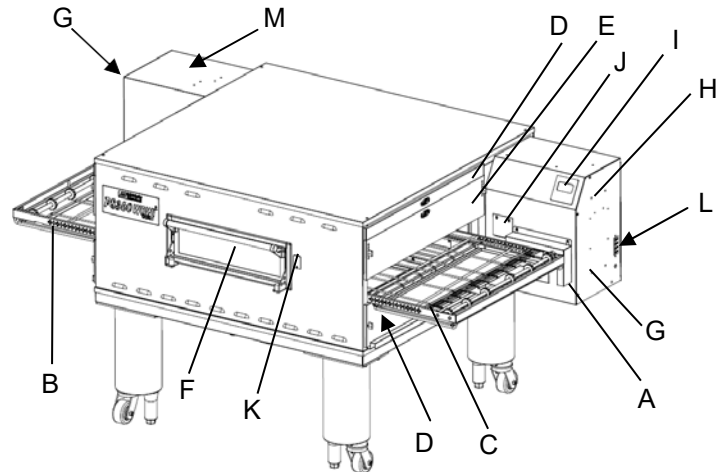
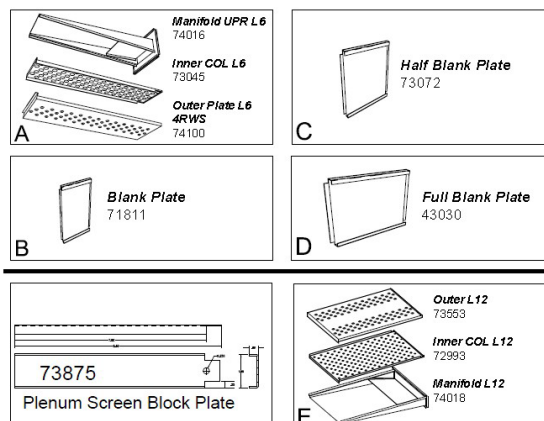
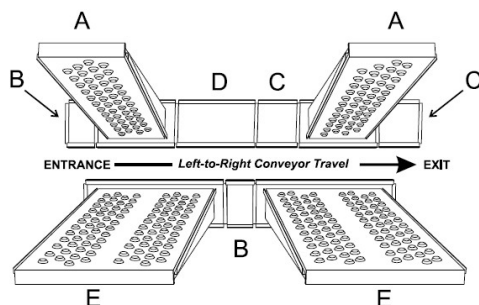


Figure 1-1



Left-to-Right configuration is shown.  
Upper Air Block P/N 73875 QTY (2) Installed in Top Air  
Return RT & LT Side

For Right-to-Left - Is mirror image



### III. OVEN SPECIFICATIONS – PS638E

| <b>Table 1-1 Dimensions</b>                 | <i>Single Oven</i> | <i>Double Oven</i> | <i>Triple Oven</i> |
|---------------------------------------------|--------------------|--------------------|--------------------|
| Overall Height                              | 41.9" (1,064 mm)   | 51.23" (1,301 mm)  | 63.47" (1,612 mm)  |
| Overall Depth                               | 50" (1,270 mm)     | 50" (1,270 mm)     | 50" (1,270 mm)     |
| Overall Length                              | 65.21" (1,656 mm)  | 65.21" (1,656 mm)  | 65.21" (1,656 mm)  |
| Conveyor Width – Belt width is 25" (635 mm) | 26.9" (683.3 mm)   | 26.9" (683.3 mm)   | 26.9" (683.3 mm)   |

#### Recommended Minimum Clearances

|                            |           |
|----------------------------|-----------|
| Rear of Oven to Wall       | 0" (0 mm) |
| Right Side of Oven to Wall | 0" (0 mm) |
| Left Side of Oven to Wall  | 0" (0 mm) |

#### Table 1-2: General Specifications **PS638E**

|                                    |                               |                     |                            |
|------------------------------------|-------------------------------|---------------------|----------------------------|
| Weight                             | 838 lbs. (380 kg)             | 1,676 lbs. (760 kg) | 2,514 lbs. (1,140 kg)      |
| Rated Heat Input (per oven cavity) | 208/240V: 22.0 kW (79.2 MJ/h) |                     | 380V: 20.25 kW (72.9 MJ/h) |
| Maximum Operation Temperature      | 600°F (315°C)                 |                     |                            |
| Air Blowers                        | 2 at 2,145 rpm                |                     |                            |
| Warm-up Time                       | 15 minutes to 500°F           |                     |                            |

#### Table 1-3: Electrical Specifications

| Main Blower & Element Voltage | Control Circuit Voltage | Phase | Frequency | Current Draw | Poles | Wires                                |
|-------------------------------|-------------------------|-------|-----------|--------------|-------|--------------------------------------|
| 208 VAC                       | 24 VDC                  | 3φ    | 50/60 Hz  | 80 Amps      | 3     | 4 Wire<br>3 hot, 1 ground            |
| 240 VAC                       | 24 VDC                  | 3φ    | 50/60 Hz  | 70 Amps      | 3     | 4 Wire<br>3 hot, 1 ground            |
| 380 VAC                       | 24 VDC                  | 3φ    | 50/60 Hz  | 50 Amps      | 4     | 5 Wire<br>3 hot, 1 neutral, 1 ground |

#### Table 1-4: Heater Amperage

| Voltage    | kW    | Average Amps |      |      |      |
|------------|-------|--------------|------|------|------|
|            |       | L1           | L2   | L3   | L4   |
| 208 VAC    | 22.0  | 63           | 63   | 63   | 60   |
| 240 VAC    | 22.0  | 54           | 54   | 54   | 51   |
| 380 VAC    | 20.25 | 39           | 39   | 35   | 35   |
| 380 VAC CE | 18.0  | 37.4         | 37.4 | 27.4 | 27.4 |

#### NOTE

Wiring diagrams are contained in Section 5 of this manual and are also located inside the oven control compartment. Additional electrical information is provided on the oven's serial plate.

#### IV. OVEN SPECIFICATIONS – PS638G

**Table 1-1 Dimensions**

|                                             | <i>Single Oven</i> | <i>Double Oven</i> | <i>Triple Oven</i> |
|---------------------------------------------|--------------------|--------------------|--------------------|
| Overall Height                              | 41.9" (1,064 mm)   | 51.23" (1,301 mm)  | 63.47" (1,612 mm)  |
| Overall Depth                               | 50" (1,270 mm)     | 50" (1,270 mm)     | 50" (1,270 mm)     |
| Overall Length                              | 65.21" (1,656 mm)  | 65.21" (1,656 mm)  | 65.21" (1,656 mm)  |
| Conveyor Width – Belt width is 25" (635 mm) | 26.9" (683.3 mm)   | 26.9" (683.3 mm)   | 26.9" (683.3 mm)   |

**Recommended Minimum Clearances**

|                            |           |
|----------------------------|-----------|
| Rear of Oven to Wall       | 0" (0 mm) |
| Right Side of Oven to Wall | 0" (0 mm) |
| Left Side of Oven to Wall  | 0" (0 mm) |

**Table 1-2: General Specifications**

**PS638E**

|                                    |                                   |                     |                       |
|------------------------------------|-----------------------------------|---------------------|-----------------------|
| Weight                             | 820 lbs. (372 kg)                 | 1,640 lbs. (744 kg) | 2,460 lbs. (1,488 kg) |
| Rated Heat Input (per oven cavity) | 89,000 BTU/hr (93.9MJ/h, 26.1 kW) |                     |                       |
| Maximum Operation Temperature      | 600°F (315°C)                     |                     |                       |
| Air Blowers                        | 2 at 1,650 rpm                    |                     |                       |
| Warm-up Time                       | 15-20 minutes to 500°F            |                     |                       |

**Table 1-3: Electrical Specifications**

| Main Blower Voltage | Control Circuit Voltage | Phase | Frequency | Current Draw                  | Poles | Wires                     |
|---------------------|-------------------------|-------|-----------|-------------------------------|-------|---------------------------|
| 208/240 VAC, 3φ     | 24 VDC                  | 1     | 50/60 Hz  | 4.5 Amps Run<br>10 Amps Start | 2     | 3 Wire<br>L1, L2/N, & GND |

**Table 1-4: Gas Orifice and Pressure Specifications**

| Gas Type     | Main Orifice Diameter               | Inlet Pressure               | Manifold Pressure                   | Bypass Orifice                     |
|--------------|-------------------------------------|------------------------------|-------------------------------------|------------------------------------|
| Natural Gas  | #39 = 0.0995"<br>(2.527 mm) (72023) | 7-9" W.C.<br>(1.7 – 2.2 kPa) | 3.5" W.C. at manifold<br>(0.87 kPa) | #49 = 0.073"<br>(1.854 mm) (59145) |
| Propane/UPLG | 0.0689" (73785)<br>(1.75 mm)        | 12-14" W.C.<br>(3.0-3.5 kPa) | 6.0" W.C. at manifold<br>(1.49 kPa) | #55 = 0.052"<br>(1.321 mm) (49948) |

**Table 1-5: Gas Orifice and Pressure Specifications (Per Oven Cavity) – CE Ovens**

| Gas Type    | Main Orifice Diameter      | Orifice Pressure |         |         |            |         |         |               |         |            |            |                        | Rated Heat Input      |                           |
|-------------|----------------------------|------------------|---------|---------|------------|---------|---------|---------------|---------|------------|------------|------------------------|-----------------------|---------------------------|
|             |                            | I2H              | I2L     | I2E     | I2E+       | I3P     | I3P     | I3B/P         | I3B/P   | I3B/P      | I3B/P      | I3+                    |                       | Orifice Manifold Pressure |
| Natural G20 | #39<br>0.0995"<br>2.527 mm | 20 mbar          | --      | 20 mbar | 20/25 mbar | --      | --      | --            | --      | --         | --         | --                     | 3.5" w.c.<br>8.7 mbar | 25.9 kW                   |
| Natural G25 | #39<br>0.0995"<br>2.527 mm | --               | 25 mbar | --      | --         | --      | --      | --            | --      | --         | --         | --                     | 3.5" w.c.<br>8.7 mbar | 25.9 kW                   |
| Butane G30  | 0.0689"<br>1.75 mm         | --               | --      | --      | --         | --      | --      | 28-30/50 mbar | 30 mbar | 37/50 mbar | 28-30 mbar | 6.0" w.c.<br>14.9 mbar | 29.2kW                |                           |
| Propane G31 | 0.0689"<br>1.75 mm         | --               | --      | --      | --         | 37 mbar | 50 mbar | --            | 30 mbar | 37/50 mbar | 37 mbar    | 6.0" w.c.<br>14.9 mbar | 29.2kW                |                           |

**NOTE**

Wiring diagrams are contained in Section 5 of this manual and are also located inside the oven control compartment. Additional electrical information is provided on the oven's serial plate.

**THIS MANUAL MUST BE KEPT FOR FUTURE REFERENCE**

## SECTION 2 - INSTALLATION

### I. GENERAL

**WARNING – After any conversions, readjustments, or service work on the oven:**

- Perform a gas leak test
- Test for proper combustion and gas supply
- Test for correct air supply, particularly to the burner
- Check that the ventilation system is in operation

**WARNING – Keep the appliance area free and clear of combustibles.**

**WARNING – The oven must be installed on even (level) non-flammable flooring and any adjacent walls must not be flammable. Recommended minimum clearances are specified in Section 1, Description of this manual.**

**WARNING – Do not obstruct the flow of ventilation air to and from the oven. There must be no obstruction around or underneath the oven. Constructional changes to the area where the oven is installed shall not affect the air supply to the oven.**

**CAUTION:** To reduce the risk of fire, the appliance is to be mounted on floors of non-combustible construction with noncombustible flooring and surface finish and with no combustible material against the underside thereof, or on noncombustible slabs or arches having no combustible material against the underside thereof, such construction shall in all cases extend not less than 12 inches (304 mm) beyond the equipment on all sides.

**CAUTION:** For additional installation information, contact your local Authorized Service Agent.

**NOTE –** There must be adequate clearance between the oven and combustible construction. Clearance must also be provided for servicing and proper operation.

**NOTE –** An electrical wiring diagram for the oven is located inside the machinery compartment.

**NOTE:** All aspects of the oven installation, including placement, utility connections, and ventilation requirements, must conform to any applicable local, national, and/or international codes. These codes supersede the requirements and guidelines provided in this manual.

**NOTE:** In the USA, the oven installation must conform to local codes. In the absence of local codes, gas oven installations must conform to the National Fuel Gas Installation Code, ANSI Z223.1. Gas and electric ovens, when installed, must be electrically grounded in accordance with local codes, or in the absence of local codes, with the National Electric Code (NEC), or ANSI/NFPA 70.

**NOTE:** In Canada, the oven installation must conform to local codes. In the absence of local codes, gas oven installations must conform to the Natural Gas Installation Code, CAN/CGA-B149.1 or Propane Gas Installation Code, CAN/CGA-B149.2, as applicable. Gas and electric ovens, when installed, must be electrically grounded in accordance with local codes, or in the absence of local codes, with Canadian Electrical Code, CSA C22.2.

**NOTE:** In Australia, the oven installation must conform to AS/NZ5601 and carry local Authority or any other relevant statutory regulations.

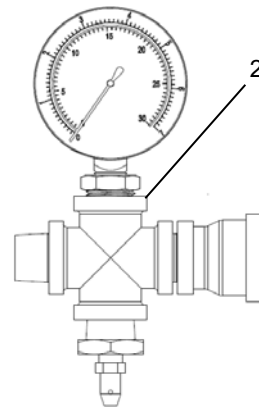
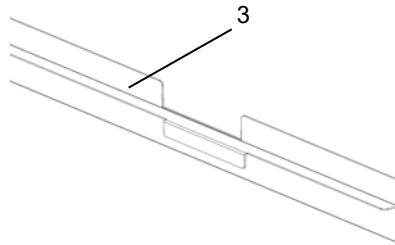
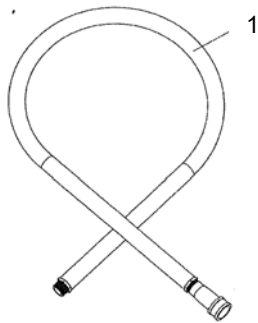


## II. PS638 OVEN INSTALLATION – BASE/TOP KITS & EQUIPMENT

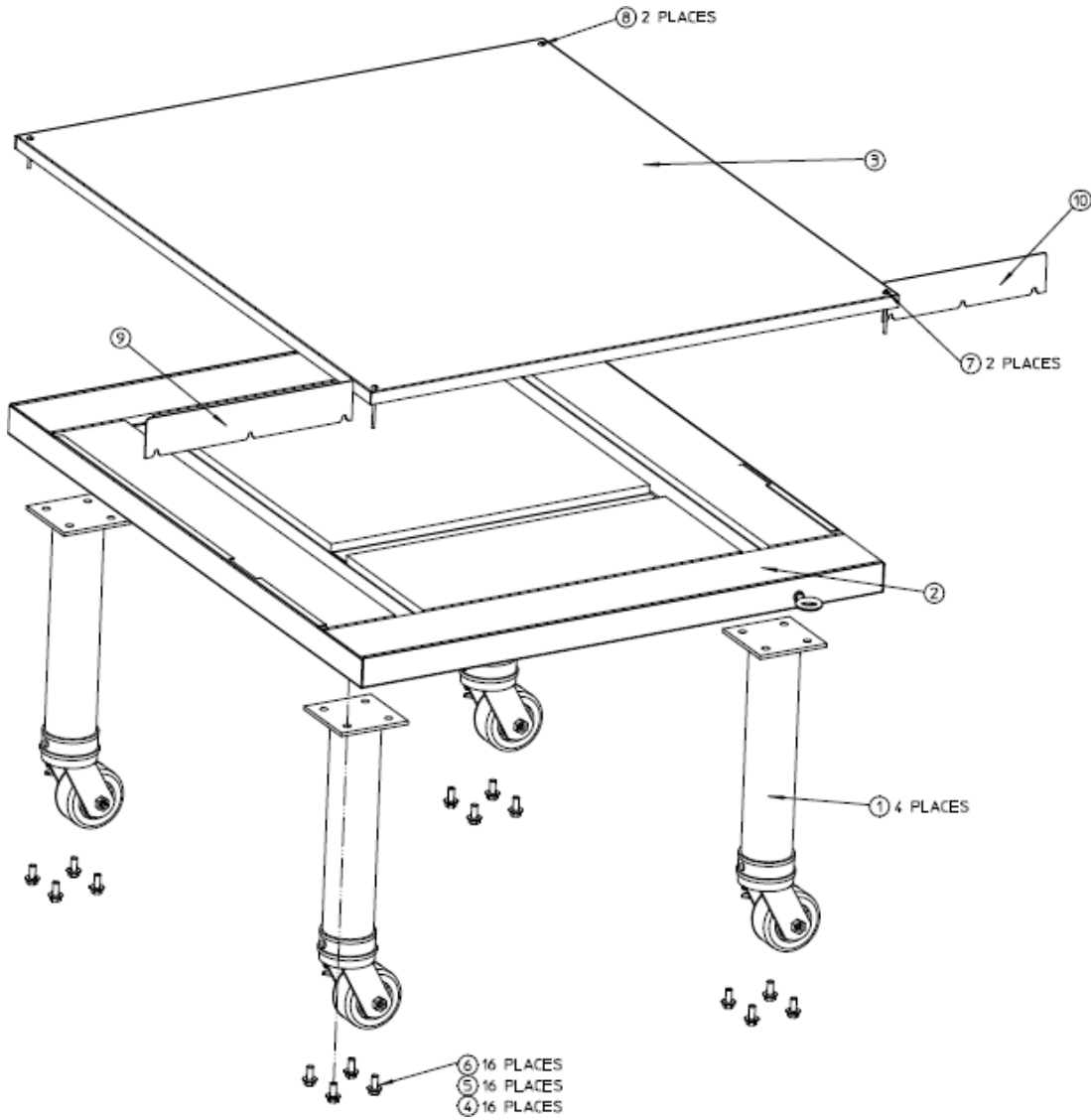
| TYPE OF INSTALLATION        | PS638 Installation Kit | Single Oven Kit Base w/ 15" Legs, Casters & Top | Double Oven Kit Base w/ 6" Legs, Casters & Top | Triple Oven Kit Base, Casters & Top |
|-----------------------------|------------------------|-------------------------------------------------|------------------------------------------------|-------------------------------------|
| PS638E Single Electric Oven | 74121                  | One (1) PN 71687                                | --                                             | --                                  |
| PS638E Double Electric Oven | 74121                  | --                                              | One (1) PN 73754                               | --                                  |
| PS638E Triple Electric Oven | 74121                  | --                                              | --                                             | One (1) PN 73556                    |
| PS638G Single Gas Oven      | 74075                  | One (1) PN 71687                                | --                                             | --                                  |
| PS638G Double Gas Oven      | 74075                  | --                                              | One (1) PN 73754                               | --                                  |
| PS638G Triple Gas Oven      | 74075                  | --                                              | --                                             | One (1) PN 73556                    |

### A. Loose Parts & Kits for PS638 Series Oven Installation Kits (PN 74121-E & 74075-G)

| GAS OR ELECTRIC | ITEM NUMBER | PART NUMBER   | DESCRIPTION              | QTY |
|-----------------|-------------|---------------|--------------------------|-----|
| Gas             | 1           | 22361-0001    | Flexible Gas Hose 3/4"   | 1   |
| Gas             | 2           | 72782         | Tap and Adapter          | 1   |
| Both            | 3           | 72836         | Conveyor End Stop        | 1   |
| Optional        | not shown   | 51054         | Glass Door & Handle Assy | 1   |
| Both            | not shown   | 75057 & 75058 | Crumb Pans               | 2   |
| Gas             | not shown   | 62307         | Manual Ball Gas Valve    | 1   |

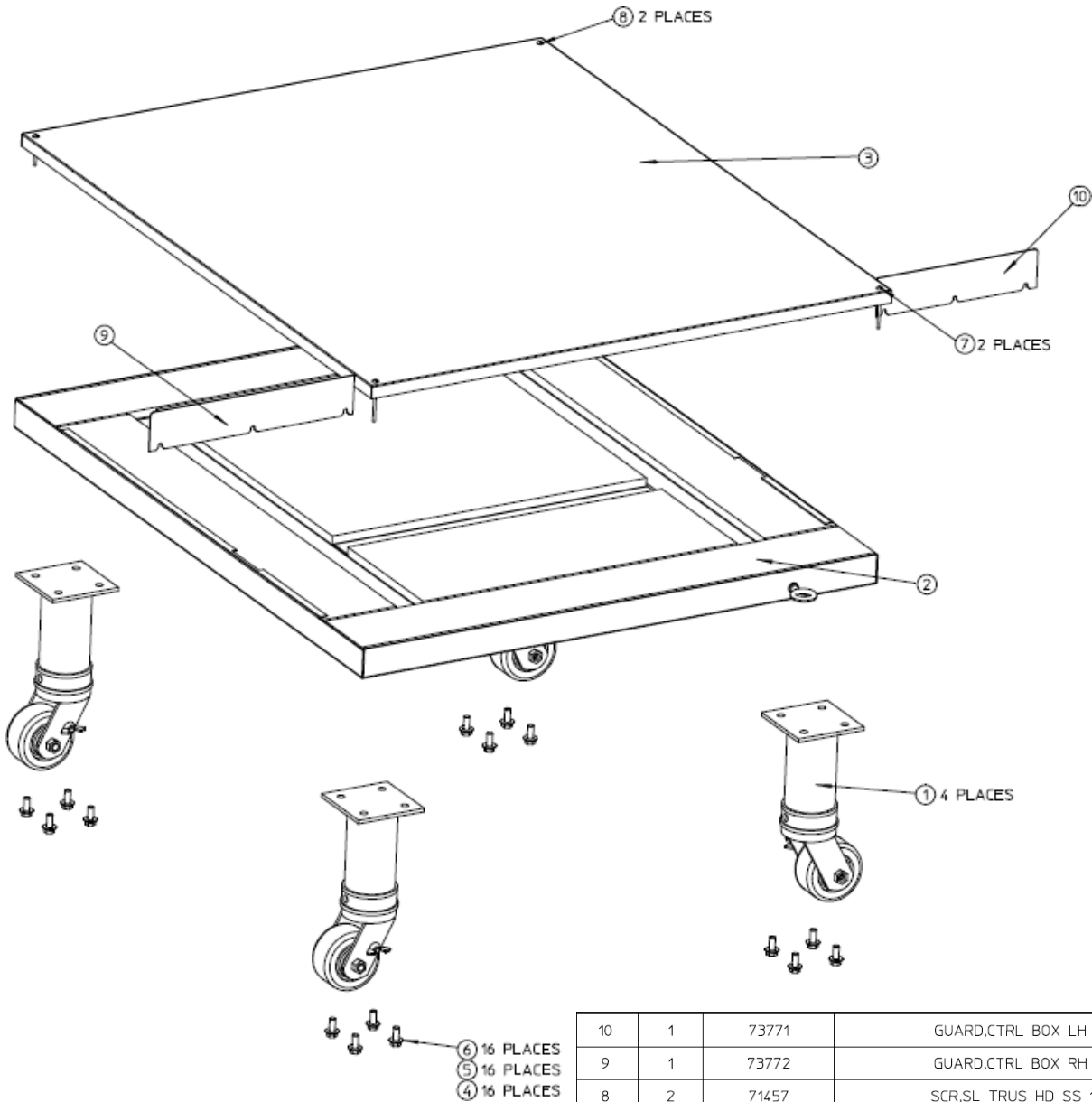


**B. P/N: 71687 – SINGLE OVEN BASE & TOP KIT**



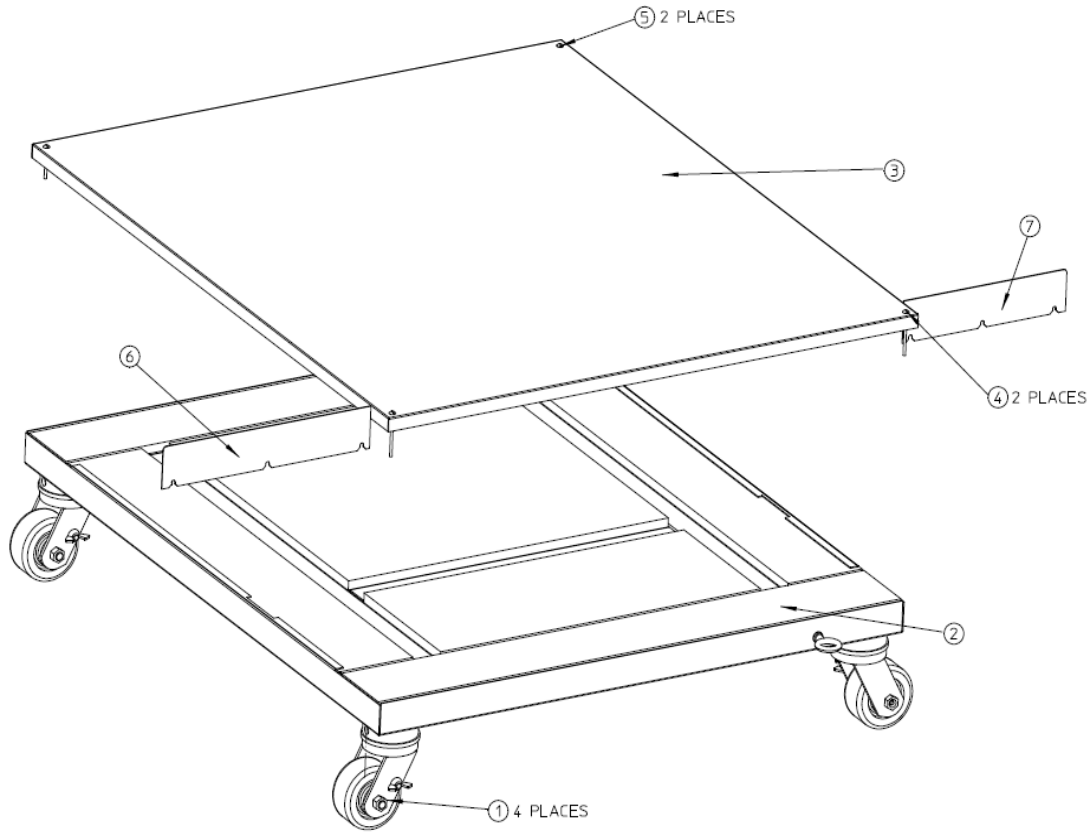
|      |     |            |                               |
|------|-----|------------|-------------------------------|
| 10   | 1   | 73771      | GUARD,CTRL BOX LH FILLER      |
| 9    | 1   | 73772      | GUARD,CTRL BOX RH FILLER      |
| 8    | 2   | 71457      | SCR,SL TRUS HD SS 10-32X2     |
| 7    | 2   | 73543      | SCR,SL TRUS HD SS 10-32X2,75" |
| 6    | 16  | 2000531    | SCR,CAP HX HD 3/8-16X1 NP     |
| 5    | 16  | 21416-0001 | WASHER,FLAT SS 3/8            |
| 4    | 16  | 21422-0001 | WASHER,LOCK SPLIT 3/8 ZP      |
| 3    | 1   | 72655      | COVER,TOP PS638               |
| 2    | 1   | 71688      | ASSY,BASE PS638               |
| 1    | 4   | 66948      | LEG,15" COMMON TUBE           |
| ITEM | QTY | PART NO.   | DESCRIPTION                   |

C. P/N: 73754 – DOUBLE OVEN BASE & TOP KIT



|      |     |            |                               |
|------|-----|------------|-------------------------------|
| 10   | 1   | 73771      | GUARD,CTRL BOX LH FILLER      |
| 9    | 1   | 73772      | GUARD,CTRL BOX RH FILLER      |
| 8    | 2   | 71457      | SCR,SL TRUS HD SS 10-32X2     |
| 7    | 2   | 73543      | SCR,SL TRUS HD SS 10-32X2.75" |
| 6    | 16  | 2000531    | SCR,CAP HX HD 3/8-16X1 NP     |
| 5    | 16  | 21416-0001 | WASHER,FLAT SS 3/8            |
| 4    | 16  | 21422-0001 | WASHER,LOCK SPLIT 3/8 ZP      |
| 3    | 1   | 72655      | COVER,TOP PS638               |
| 2    | 1   | 71688      | ASSY,BASE PS638               |
| 1    | 4   | 66946      | LEG,6" COMMON TUBE            |
| ITEM | QTY | PART NO.   | DESCRIPTION                   |

**D. P/N: 73556 – TRIPLE OVEN BASE & TOP KIT**



|      |     |          |                               |
|------|-----|----------|-------------------------------|
| 7    | 1   | 73771    | GUARD,CTRL BOX LH FILLER      |
| 6    | 1   | 73772    | GUARD,CTRL BOX RH FILLER      |
| 5    | 2   | 71457    | SCR,SL TRUS HD SS 10-32X2     |
| 4    | 2   | 73543    | SCR,SL TRUS HD SS 10-32X2.75" |
| 3    | 1   | 72655    | COVER,TOP PS638               |
| 2    | 1   | 71688    | ASSY,BASE PS638               |
| 1    | 4   | 74319    | CASTER,STUD W/BRAKE 4" WHEEL  |
| ITEM | QTY | PART NO. | DESCRIPTION                   |

### III. PS638 OVEN LAYOUTS

#### A. Single Oven

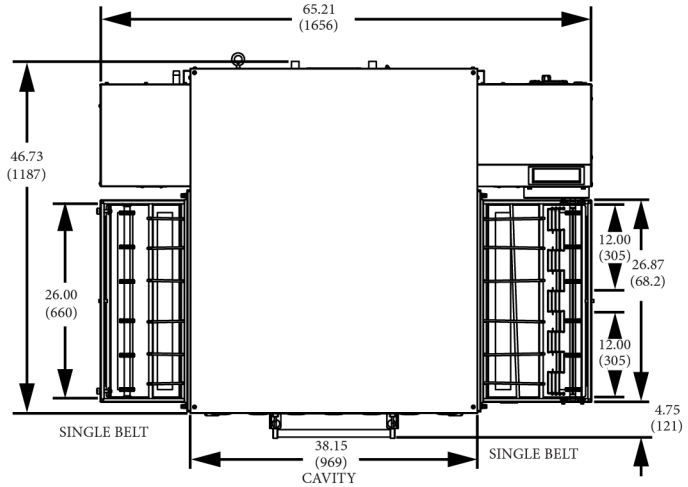


## Electrically Heated Conveyor Oven

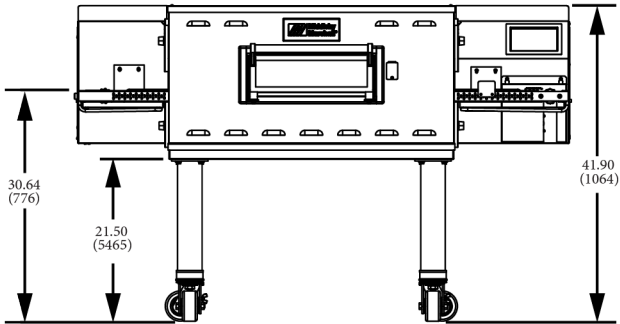
NOTE: Height dimensions are shown for standard leg extensions. Customer-specific leg extensions will affect these dimensions.

NOTE: All units are shown with casters. CE-approved ovens use 6"/152mm adjustable feet instead of casters

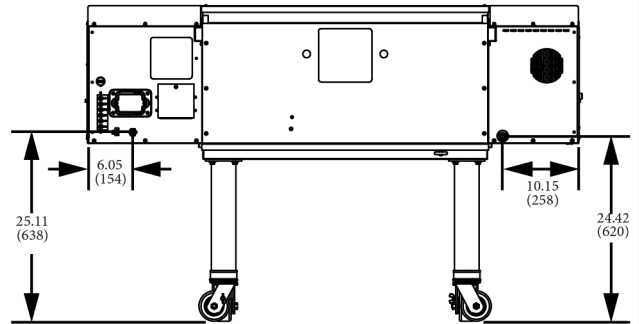
# PS638E-1



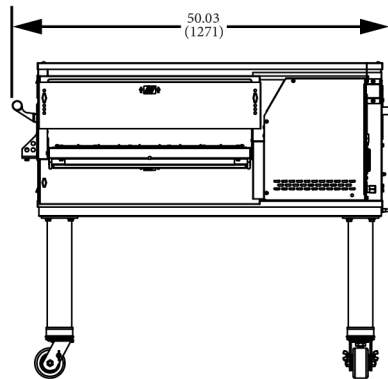
**TOP VIEW**



**FRONT VIEW**



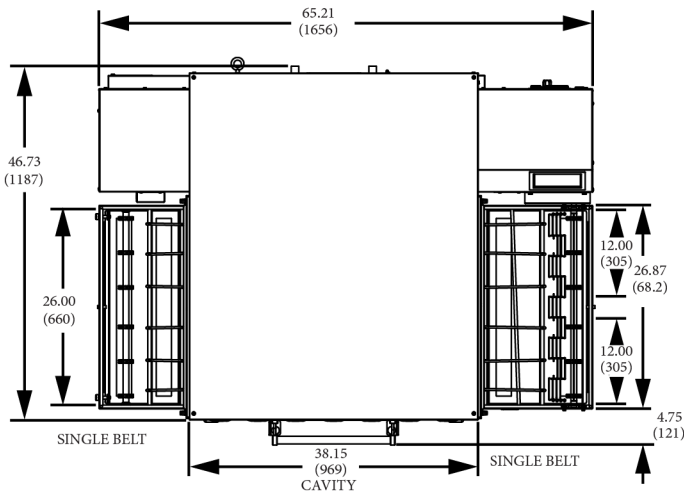
**BACK VIEW**



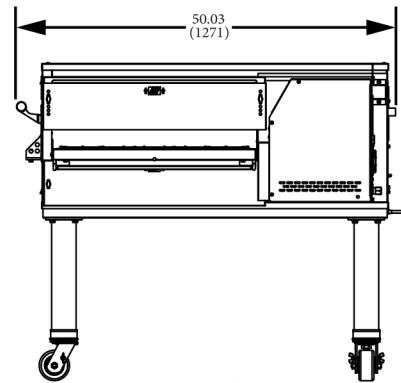
**SIDE VIEW**

NOTE: Drawings show ovens equipped with casters.

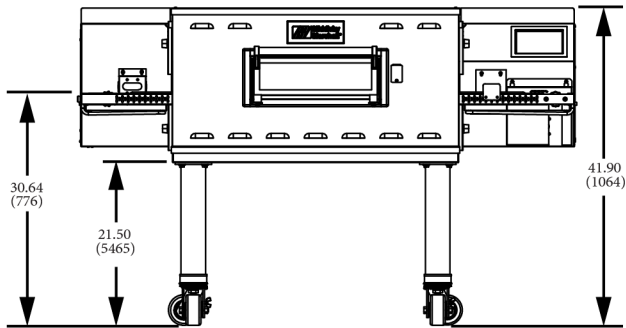
**PS638G Single Oven**



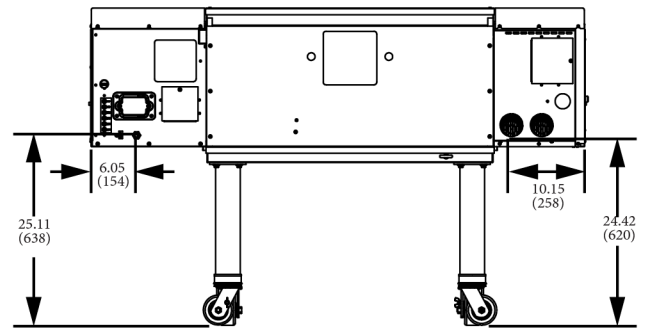
**TOP VIEW**



**SIDE VIEW**



**FRONT VIEW**



**BACK VIEW**

B. Double and Triple Oven

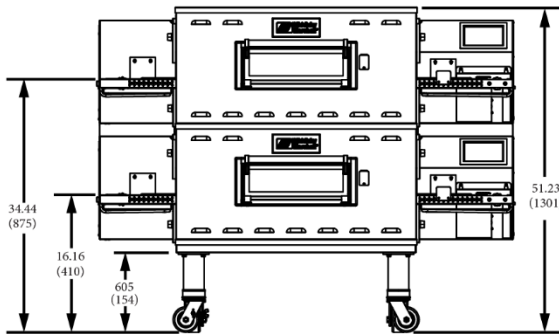


**Electrically Heated Conveyor Oven**

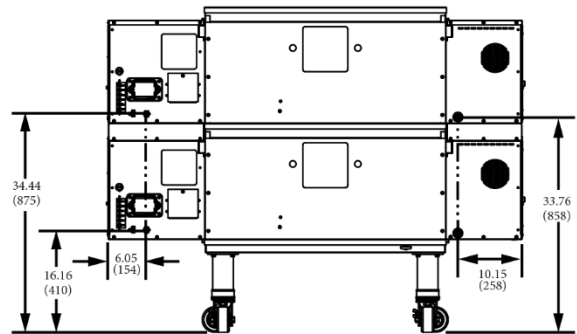
NOTE: Height dimensions are shown for standard leg extensions. Customer-specific leg extensions will affect these dimensions.

NOTE: All units are shown with casters. CE-approved ovens use 6"/152mm adjustable feet instead of casters

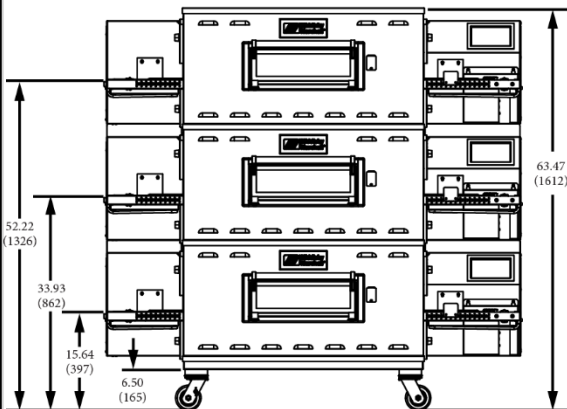
**PS638E-2**



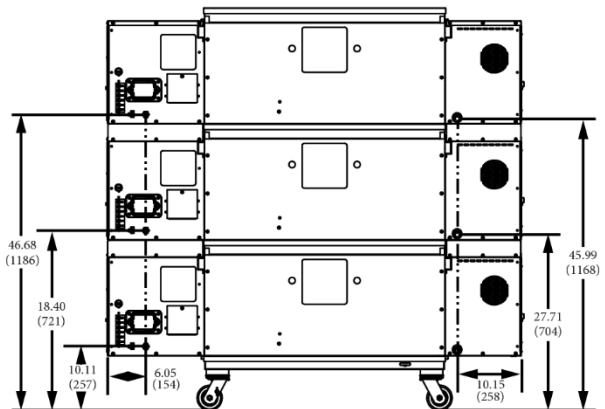
**FRONT VIEW**



**BACK VIEW**

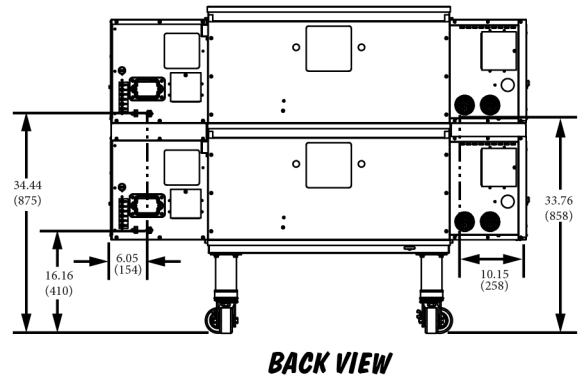
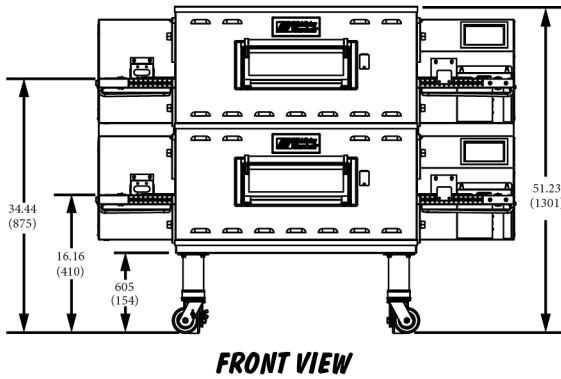


**FRONT VIEW**

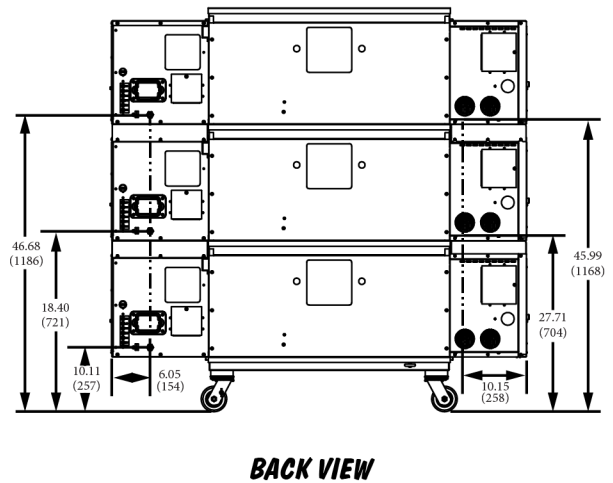
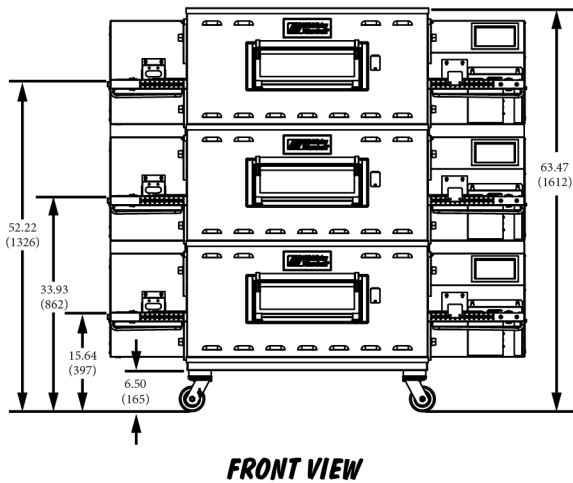


**BACK VIEW**

**PS638-2 Double Oven**



**PS638-3 Triple Oven**





## IV. VENTILATION SYSTEM

### IMPORTANT

Where national or local codes require the installation of fire suppression equipment or other supplementary equipment, **DO NOT** mount the equipment directly to the oven.

MOUNTING SUCH EQUIPMENT ON THE OVEN MAY:

- VOID AGENCY CERTIFICATIONS
- RESTRICT SERVICE ACCESS
- LEAD TO INCREASED SERVICE EXPENSES FOR THE OWNER

#### A. Requirements

**CAUTION:** Gas oven installations REQUIRE a mechanically driven ventilation system with electrical air sensing control.

A mechanically driven ventilation system is **STRONGLY RECOMMENDED** for electric oven installations.

**PROPER VENTILATION OF THE OVEN IS THE RESPONSIBILITY OF THE OWNER.**

#### B. Recommendations

NOTE THAT THE HOOD DIMENSIONS SHOWN IN FIGURE 2-5 ARE RECOMMENDATIONS ONLY. LOCAL, NATIONAL, AND INTERNATIONAL CODES MUST BE FOLLOWED WHEN INSTALLING THE VENTILATION SYSTEM. ANY APPLICABLE CODES SUPERSEDE THE RECOMMENDATIONS SHOWN IN THIS MANUAL. IN AUSTRALIA, COMPLIANCE TO REGULATIONS AS/NZS 5601 IS MANDATORY.

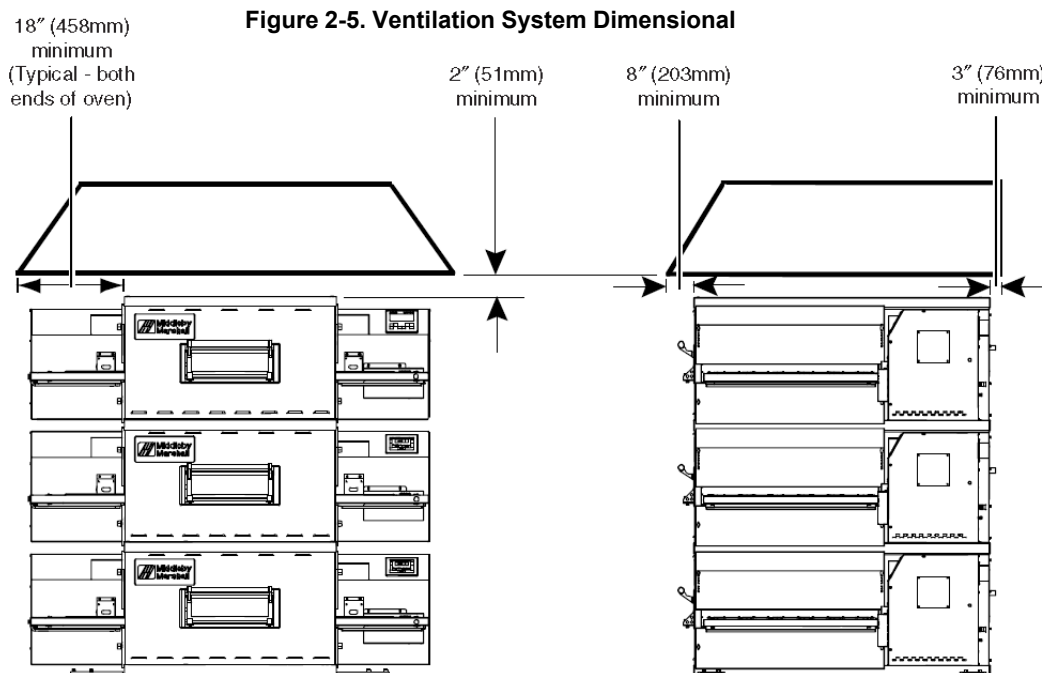
The rate of air flow exhausted through the ventilation system may vary depending upon the oven configuration and hood design. Consult the hood manufacturer or ventilation engineer for these specifications.

To avoid negative pressure condition in the kitchen area, return air must be brought back to replenish the air that was exhausted. A negative pressure in the kitchen can cause heat related problems to the oven components as if there was no ventilation at all. The best method of supplying return air is through the heating, ventilation and air conditioning (HVAC) systems. Through the HVAC system, the air can be temperature-controlled for summer and winter. Return air can also be brought in directly from outside the building, but detrimental effects can result from extreme seasonal hot and cold temperatures from the outdoors.

**NOTE:** Return air from the mechanically driven system must not blow at the opening of the baking chamber. Poor oven baking performance will result.

#### C. Other Ventilation Concerns

1. Special locations, conditions, or problems may require the services of a ventilation engineer or specialist.
2. Inadequate ventilation can inhibit oven performance.
3. It is recommended that the ventilation system and ductwork be checked at prevailing intervals as specified by the hood manufacturer and/or HVAC engineer or specialist.



## V. ASSEMBLY

### A. Top Panel and Base Pad Assembly

1. Install the four leg extensions onto the base pad using the 3/8"-16 x 1" screws, 3/8" flat washers and 3/8" lock washers supplied in the Base Pad Kit. See Figure 2-6. Install the spring clip for the oven restraining cable to the hole in the bottom middle of the base pad, see Oven Base & Top Kit drawings (pages 5-7). This clip will attach to the restraint cable that keeps the oven from moving too far when installed on casters.
2. Install one caster or one adjustable 6" leg onto each leg extension and tighten securely in place.
3. Install the lower oven cavity onto the base pad. See Figure 2-7.
4. For single ovens ONLY:

Install the top panel using the screws included in the Base Pad Kit, as shown in Figure 2-8. Then, skip ahead to Part C, Restraint Cable Installation.

For double or triple ovens:

Continue to Part B, Stacking. Note that the top panel should NOT be installed for double and triple ovens until after stacking the oven cavities.

Fig 2-6. Leg Extension and Caster Installation

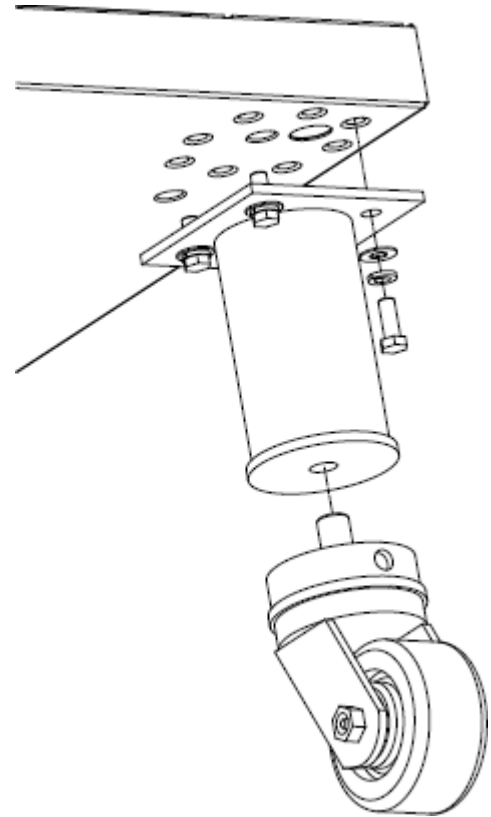


Figure 2-7. Base Pad Installation

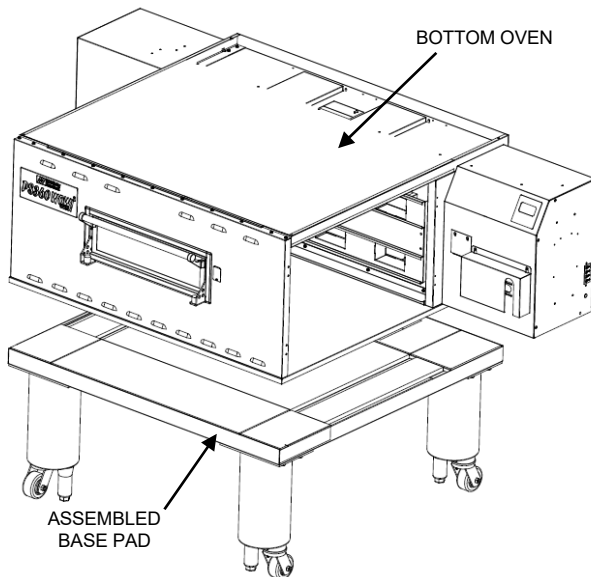
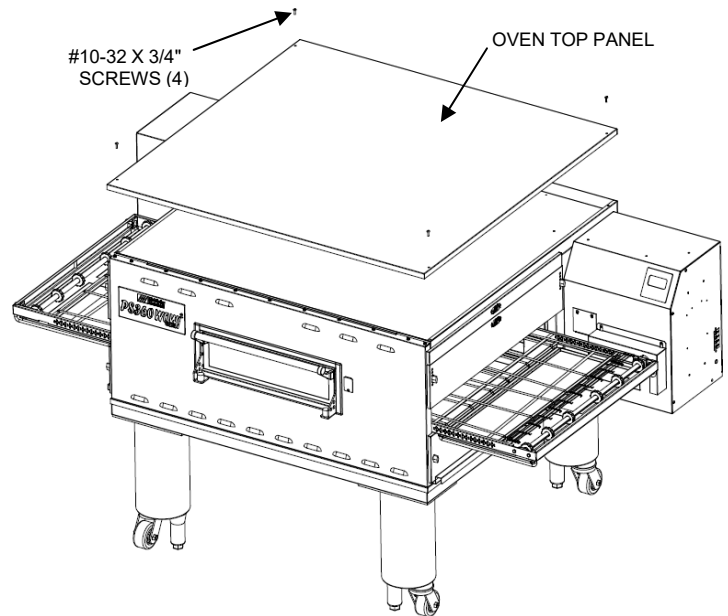


Figure 2-8. Top Panel Installation



**NOTE:** DO NOT install top panel onto double or triple ovens until AFTER stacking the oven cavities. See Part B, Stacking.

**B. Stacking**

For single ovens, skip ahead to Part C, Restraint Cable Installation.

**IMPORTANT**

Middleby Marshall STRONGLY RECOMMENDS that the PS638-WOW oven cavities be stacked by AUTHORIZED PERSONNEL.

Contact your Middleby Marshall Authorized Service Company for complete stacking instructions.

1. Stack an oven cavity on top of the lower oven. Check the following:
  - Insulation is installed on the lower oven top.
  - All four sides of the lower lip (on the bottom edge of the oven cavity) overlap the top of the lower oven.
  - The oven is level.
  - The oven is firmly seated, and the top insulation layer is installed smoothly and fully covering the metal panel. See Figure 2-9.
2. For triple ovens, repeat Step 1 to install the top oven cavity.
3. Install the top panel using the screws included in the base pad kit, as shown in Figure 2-10.

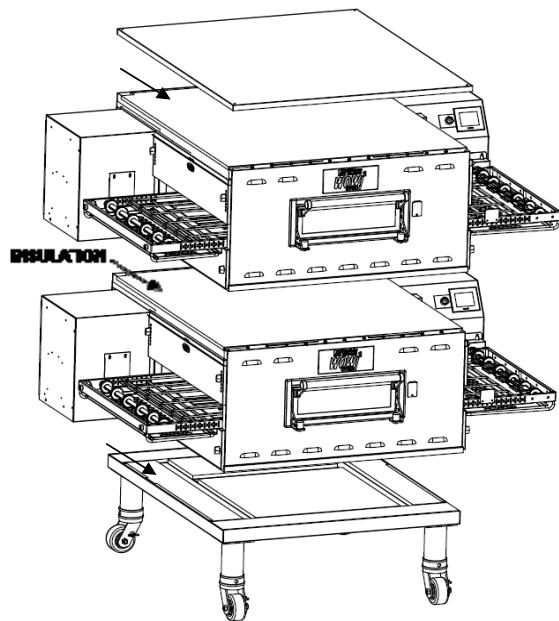
**C. Restraint Cable Installation**

Because the oven is equipped with casters, a restraint cable assembly must be installed to limit the movement of the appliance without depending upon the connector and the quick disconnect device or its associated piping. One end of the cable is anchored to the snap clip on the underside of the base pad while the other is anchored to the wall. See Figure 2-11.

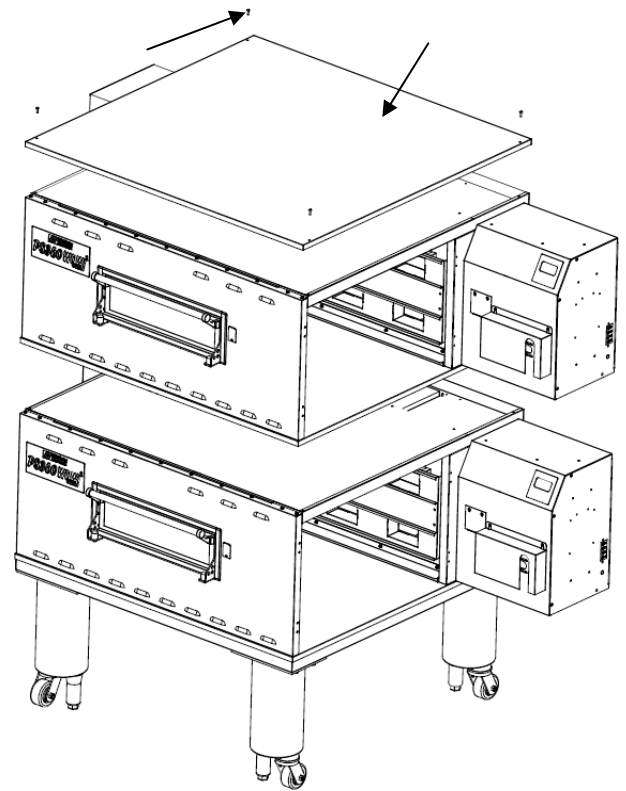
After connecting the restraint cable, move the oven to its final location. Lock the two front casters.

The restraint cable is connected to the spring snap located at the back-center of the base underside. The 3/4" eyebolt must be anchored to the wall or floor to attach the other end of the restraint cable.

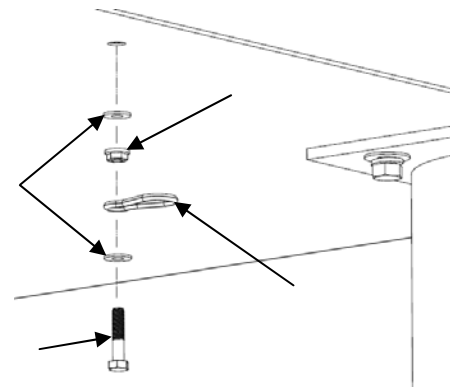
**Figure 2-10. Top Panel Installation**



**Figure 2-9. Stacking**



**Figure 2-11. Installing the Restraint Cable**



### D. Conveyor Installation

1. Unfold the conveyor as shown in Figure 2-12. Then begin to slide the conveyor into the end of the oven. The conveyor can only be installed from the side of the oven where the drive motors are located.
2. Continue moving the conveyor into the oven until the frame protrudes equally from each end of the oven. Check that the crumb tray supports located on the underside of the conveyor frame rest firmly against the lower end plugs, as shown in Figure 2-13.
3. When the conveyor is positioned properly, check for freedom of movement of the conveyor belt by pulling it for about 2 to 3 feet (0.6 to 1.0 m) with your fingers. The drive and idler shafts must rotate smoothly, and the belt must move freely without rubbing on the inside of the oven. If not, then re-align the belting.
4. Check the tension of the conveyor belt as shown in Figure 2-14. The belt should lift about 1" (25 mm). **DO NOT OVER TIGHTEN THE CONVEYOR BELT.**

**NOTE:** If necessary, the belt tension can be adjusted by turning the conveyor adjustment screws, located at the idler (non-control) end of the conveyor. See Figure 2-14.

Figure 2-12. Conveyor Installation

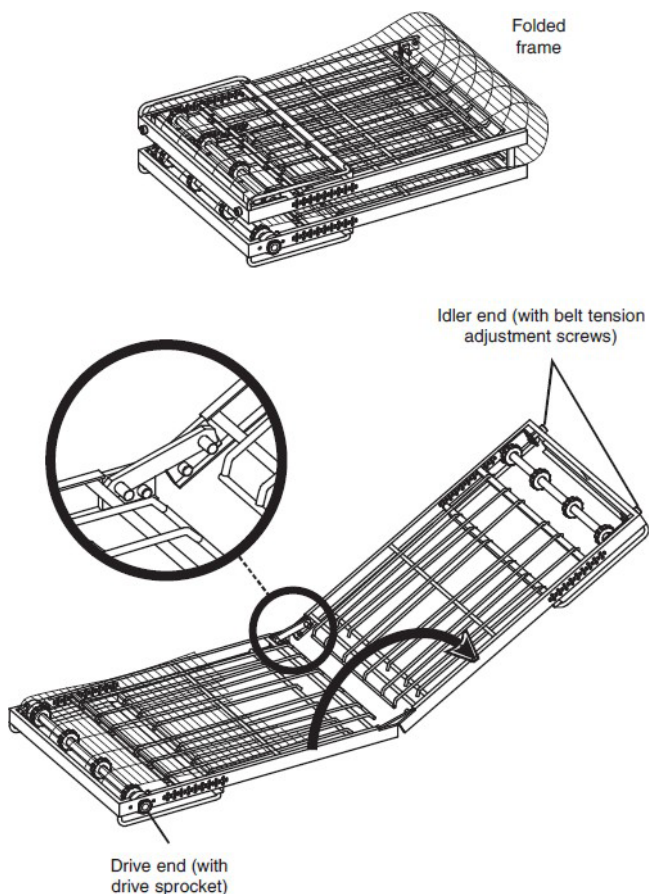


Figure 2-13

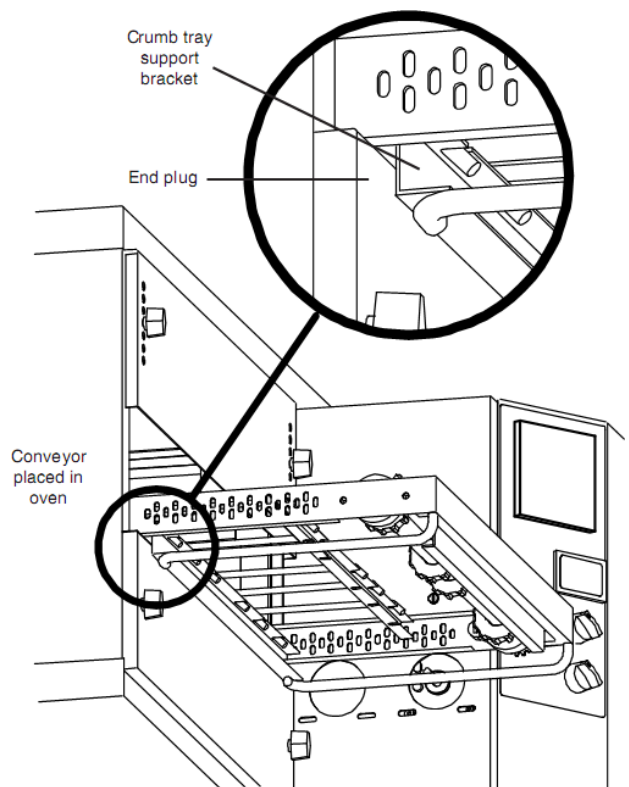
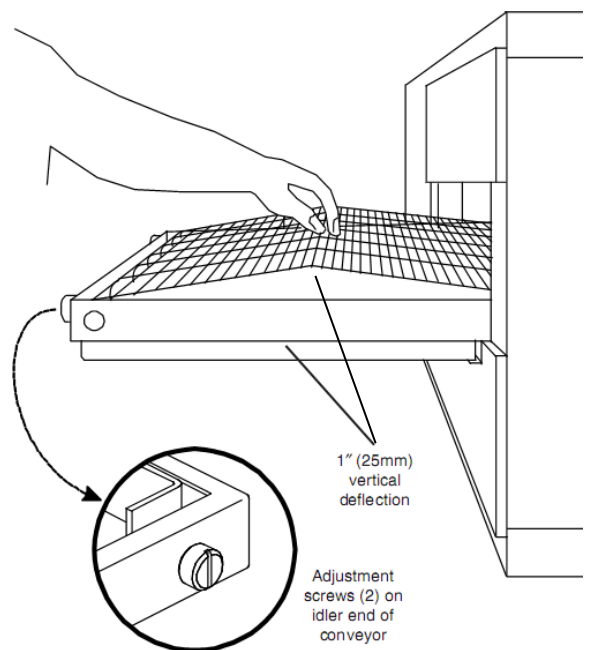
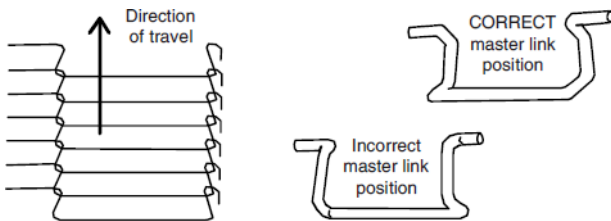


Figure 2-14. Conveyor Belt Tension



5. If it is necessary to add or remove conveyor links to achieve the correct tension, OR if it is necessary to reverse the conveyor belt for correct orientation, the belt will need to be removed from the conveyor frame. If this is necessary, perform the following procedure:
  - Remove the conveyor assembly from the oven and place it flat on the floor.
  - Remove the master links using long-nose pliers. Then, roll up the belt along the length of the conveyor frame.
  - Add or remove belt links as necessary to achieve the correct belt tension.
  - Replace the belt on the conveyor frame. Check that the conveyor belt links are oriented as shown in Figure 2-15, and that the smooth side of the conveyor belt faces UP.
  - Connect the inside master links. Check that the links are oriented as shown in Figure 2-15.
  - Connect the outside master links. Note that the outside master links each have an open hook on one side. This hook aligns with the hooks along the sides of the other conveyor links. See Figure 2-15.
  - Replace the conveyor into the oven.

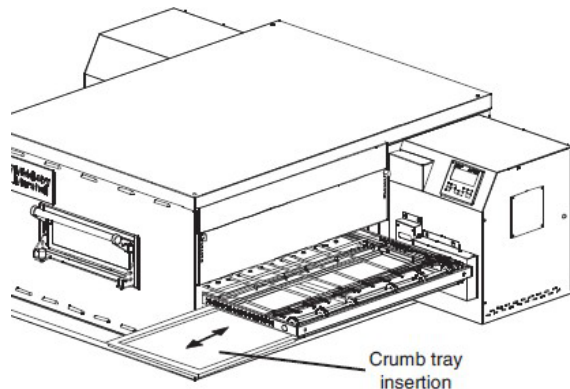
**Figure 2-15. Conveyor and Master Link orientation**



### E. Final Assembly

1. Install the crumb trays underneath the conveyor as shown in Figure 2-16.

**Figure 2-16. Crumb Trays**



**CAUTION:**



*Shock hazard in compartment's electrical filters is electrically alive.*

## VI. ELECTRICAL SUPPLY

**CAUTION:**

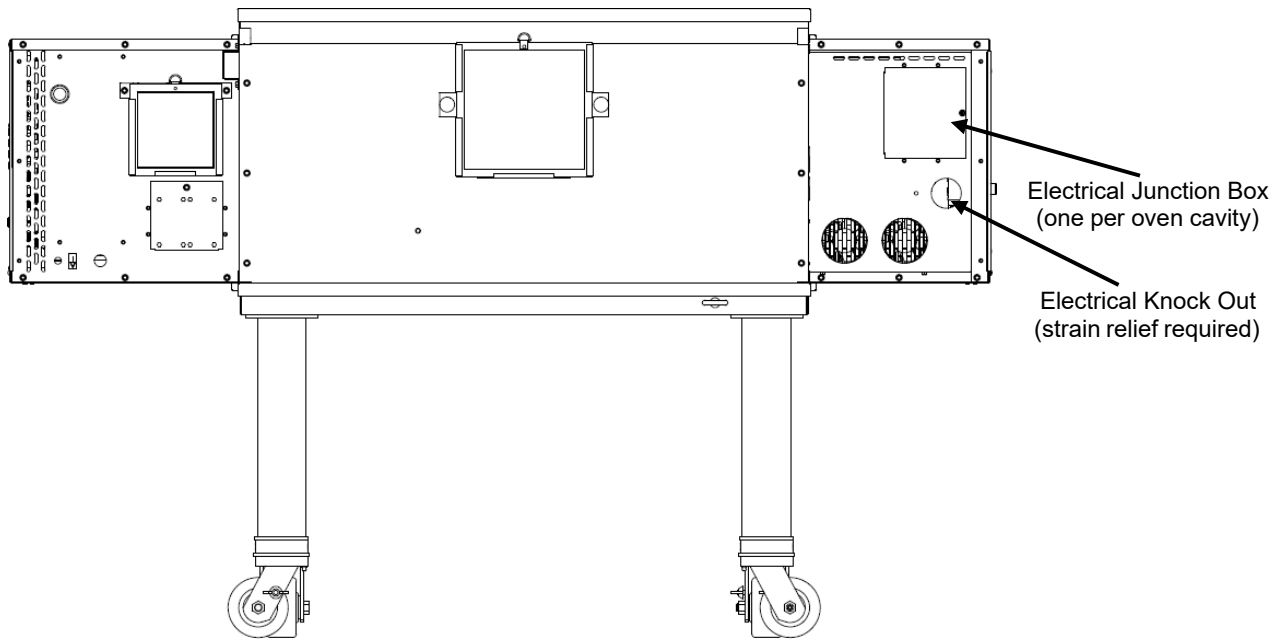


**Authorized Installation Personnel normally accomplish the connections for the ventilation system, electric supply, and gas supply, as arranged by the customer. Following these connections, the Factory-Authorized Installer can perform the initial startup of the oven.**

**NOTE:** The electric supply installation must satisfy the requirements of the appropriate statutory authority such as the National Electrical Code, CSA C22.2; the Australian Code AG601; or other applicable regulations.

**NOTE:** The electric supply connection must meet all national and local electrical code requirements.

**Figure 2-17. Utility Connections Locations for Electrically Heated Oven**



Check the oven serial plate before making any electric supply connections. Electric supply connections must agree with data on the oven serial plate. The location of the serial plate is shown in Figure 1-1 (in Section 1, Description).

A fused disconnect switch or a main circuit breaker (customer furnished) **MUST** be installed in the electric supply line for each oven cavity. It is recommended that the switch/circuit breaker have Lockout/Tagout capability.

The supply conductors must be of the size and material (copper) recommended. Refer to the wiring diagram inside the machinery compartment of the oven. Electrical specifications are also listed on the oven's serial plate and in Table 1-3, Electrical Specifications (in Section 1, Description).

The oven requires a ground connection to the oven ground screw. For gas ovens, the screw is located in the electrical junction box (see Figure 2-17). If necessary, have the electrician supply the ground wire. Do **NOT** use the wiring conduit or other piping for ground connections.

Incoming electrical power lines are fed through the strain-relief fitting, shown in Figure 2-17. The electrical supply connections are made inside the electrical junction box. The power lines then connect to the oven circuits through safety switches located inside the machinery compartment and each blower motor compartment. These switches interrupt electrical power to the oven when the Machinery Compartment Access Panel is opened, OR when the rear panel is removed.

### Connection

Refer to the wiring diagram inside the machinery compartment of the oven to determine the correct connections for the electrical supply lines. Connect the supply as indicated on the wiring diagram.

**CAUTION:** *The terms of the oven's warranty require all start-ups, conversions and service work to be performed by a Middleby Marshall Authorized Service Company.*



Power requirements for electrically heated ovens are usually 208-240 VAC, 3-phase, 4-wire (3 hot, 1 ground), although ovens built for export can have power requirements of 380 VAC and 480 VAC. (These ovens have a 5-wire system.) A 2" (51 mm) diameter cutout/hole in the back of the machinery compartment provides access for the electrical supply connections. Using flexible cable(s) for the electrical power supply conductors requires a 2" (51 mm) strain-relief fitting (not furnished) to enable safe access to the terminal block from which oven power is distributed.

The supply conductors must be of the size and material (copper) recommended to provide the current required; (refer to the data plate for the ampere specifications). The electric current rating for each conductor supplying a PS640E-Series Oven must comply to local and national codes.

Typical specifications for each PS638E-Series Oven are 208V or 240V, 3-phase, 4-wire, 60-ampere, 34.4 kW. A PS638E Series Double Oven installation would require two 60-ampere service connections, one for each oven; the 34.4 kW power consumption also doubles for such an installation to 68.8 kW.

The 208V or 240 VAC electrically heated oven uses two legs of the supplied power to provide 208V or 240 VAC power for the oven control circuitry.

**ELECTRIC SUPPLY TO BE PROVIDED BY CUSTOMER**

**WARNING**  
DO NOT USE CONDUIT FOR GROUND CONNECTION.

**CAUTION**  
IT IS RECOMMENDED THAT THE OVEN BE PLACED UNDER A VENTILATION HOOD FOR ADEQUATE AIR SUPPLY AND VENTILATION.

ELECTRIC SUPPLY TO BE PROVIDED BY CUSTOMER

#### CIRCUIT BREAKER

Separate circuit breaker with lockout/tagout electrical shutoff for each oven. Wire each oven separately. 80 Amp circuit breaker for 208 / 70 Amp circuit breaker for 240V, or 50 Amp circuit breaker for 380-480V.

#### ELECTRICAL SPECIFICATIONS

**DOMESTIC:** 208V main blower motors and elements, 3 Phase, 63 Amp draw, 50/60 Hz, 208-240V control circuit, 3 pole, 4 wire system per oven (3 hot, 1 ground).

**Do NOT** use conduit for ground.

-or-

2. **DOMESTIC:** 240V main blower motors and elements, 3 Phase, 54 Amp draw, 50/60 Hz, 208-240V control circuit, 3 pole, 4 wire system per oven (3 hot, 1 ground).

**Do NOT** use conduit for ground.

-or-

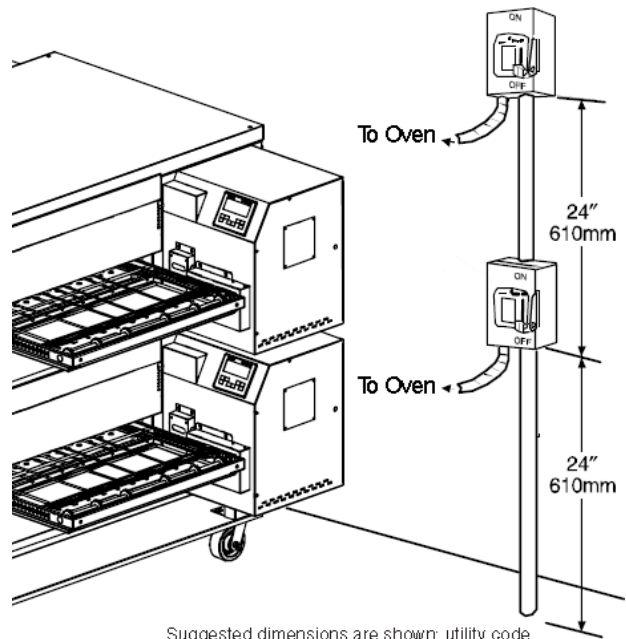
**EXPORT:** 20.25 kW 380V elements, 3 Phase, 38 Amp draw, 50/60 Hz, 208-240V control circuit and main blower motor, 4 pole, 5 wire system per oven (3 hot, 1 neutral, 1 ground).

**Do NOT** use conduit for ground.

-or-

**EXPORT:** 18 kW 380V elements, 3 Phase, 37.4 Amp draw, 50/60 Hz, 208-240V control circuit and main blower motor, 4 pole, 5 wire system per oven (3 hot, 1 neutral, 1 ground).

**Do NOT** use conduit for ground.



Suggested dimensions are shown; utility code requirements supersede any factors shown.

#### Typical PS638-Series Oven Installation

#### ELECTRICAL RATING

22.0 kW/hr for 208/240V

20.25 kW/hr for 380V

18 kW/hr for 380V

#### SUPPLY WIRE

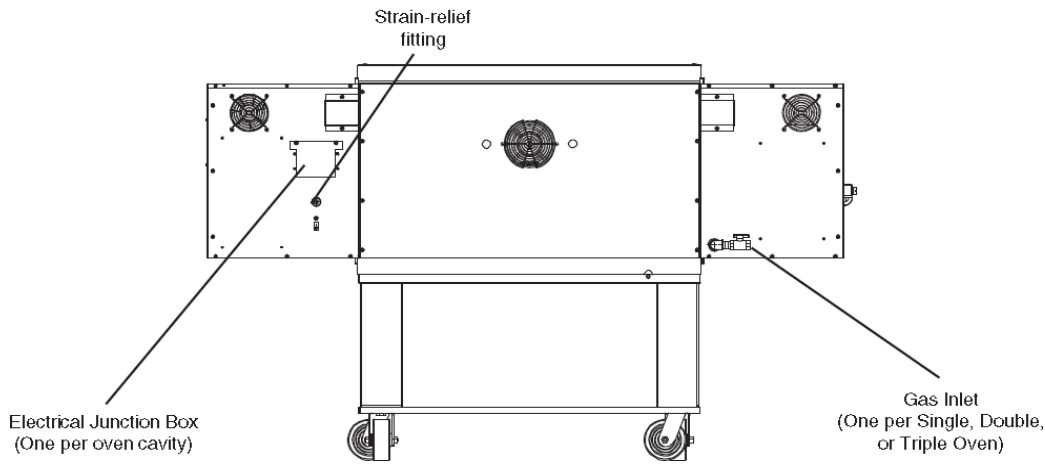
Supply wire size must be in accordance with the National Electrical Code (current edition) and must be in compliance with local codes.

**NOTE:** The electrical terminal connection marked "MP" located inside the control compartment is designated for the blue (neutral) wire to the oven. See the electrical wiring diagram/schematics in Section 5 of this manual.

#### SUGGESTED

If space permits, service should be located near the control console end of the oven(s) to allow convenient access to safety switches.

Figure 2-17. Utility Connection Locations for Gas Ovens



## VII. GAS SUPPLY

**CAUTION:** DURING PRESSURE TESTING NOTE ALL OF THE FOLLOWING:



1. The oven and its individual shutoff valve must be disconnected from the gas supply piping system during any pressure testing of that system at test pressure in excess of 1/2 psi (3.45 kPa).
2. The oven must be isolated from the gas supply piping system by closing its individual manual shutoff during any pressure testing of the gas supply piping system at test pressure equal to or less than 1/2 psi (3.45 kPa).
3. If incoming pressure is over 14" W.C. (35 mbar), a separate regulator **MUST** be installed in the line **BEFORE** the individual shutoff valve for the oven.

**CAUTION:** To prevent damage to the control valve regulator during initial turn-on of gas, it is very important to open the manual shutoff valve very slowly.



After the initial gas turn-on, the manual shutoff valve must remain open, except during pressure testing as outlined in the above steps or when necessary, during service maintenance.

### A. Gas Utility Rough-In Recommendations

The following system specifications are **STRONGLY RECOMMENDED**. Deviating from these recommendations may affect the baking performance of the oven.

#### Gas Meter

- One or two cavities: 425 CFH meter
- Three oven cavities: 630 CFH meter

#### Gas Line

- **DEDICATED GAS LINE** from the gas meter to the oven
- 1-1/2" (38.1 mm) pipe for Natural gas
- 1-1/2" (38.1 mm) pipe for Propane gas
- Maximum length: 200' (61 m). Each 90° elbow equals seven additional feet (2.13 m) of pipe.

### B. Connection

Check the oven's gas supply requirements before making the gas utility connections. Gas supply requirements are listed on the oven's serial plate and in Table 1-4. Gas Orifice and Pressure Specifications (in Section 1, Description).

Check the serial plate to determine the type of gas (Propane or Natural) to be used with the oven.

Refer to the instructions in the gas hose package (included in the Installation Kit) before connecting the gas line. One gas line connection method is shown in Figure 2-18; however, compliance with the applicable standards and regulations is mandatory.

Inlet and regulated gas pressure readings can be taken using a digital tube manometer at the tap location shown in Figure 2-19. Figure 2-19 shows the burner assembly and Figure 2-21 shows the gas valve.

**NOTE:** The installation must conform with local codes or in the absence of local codes, to the National Fuel Gas Code, ANSI Z223.1, latest edition.

Certain safety code requirements exist for the installation of gas ovens; refer to the beginning of Section 2 for a list of the installation standards. In addition, because the oven is equipped with casters, the gas line connection shall be made with a connector that complies with the Standard for Connectors for Movable Gas Appliances, ANSI Z21.69/CSA 6.16 (in U.S.A.), as well as a quick-disconnect device that complies with the Standard for Quick-Disconnect Devices for Use With Gas Fuel, ANSI Z21.41/CSA 6.9 (in U.S.A.).

### C. Gas Conversion

Where permitted by local and national codes, it is possible to convert ovens from natural gas to propane or from propane to natural gas. Use the appropriate Middleby Gas Conversion Kit for the specific oven model.

**CAUTION:** The terms of the oven's warranty require all startups, conversions, and service work to be performed by a Middleby Authorized ServiceAgent.





### D. PS638G Propane/ULPG Conversion

Three items must be changed to change the oven to operate on ULPG (See Addendum for ULPG Conversion Kit # 74072)

1. Replace main orifices.
2. Replace the by-pass orifice
3. Adjust main gas regulator.

Disconnect the manifold union closest to the main burner, and remove the manifold assembly (four screws). Slide out the manifold assembly (leaving the ignition and sense wires connected). Replace the main orifices on the manifold assemblies with the ULPG orifices, and replace the manifold assembly. Reconnect the union.

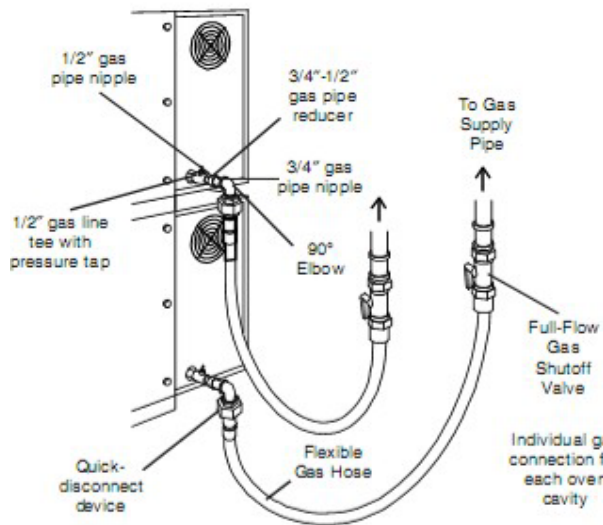
Loosen the by-pass tube fitting to replace the by-pass orifice, tighten the tube fitting with the ULPG orifice inside accordingly.

Remove the seal cap on the regulator and rotate the adjustment screw in the clockwise direction to increase the regulated pressure to 6" W.C. (1.49 kPa) at the manifold.

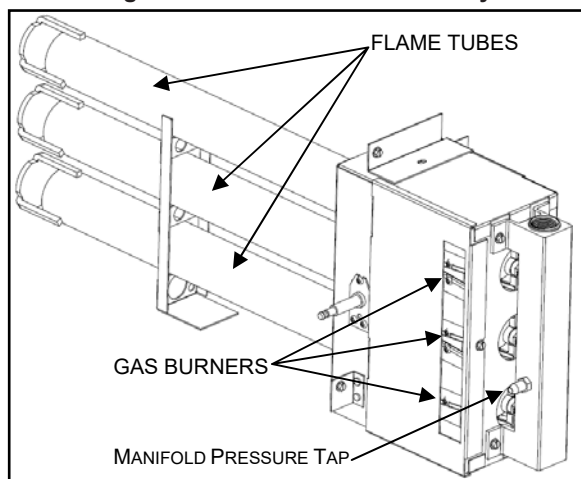
### E. Adjusting the Maximum Pressure Setting

If maximum rate pressure needs adjustment, follow instruction in Section VIII. PS638G GAS SPECIFICATIONS

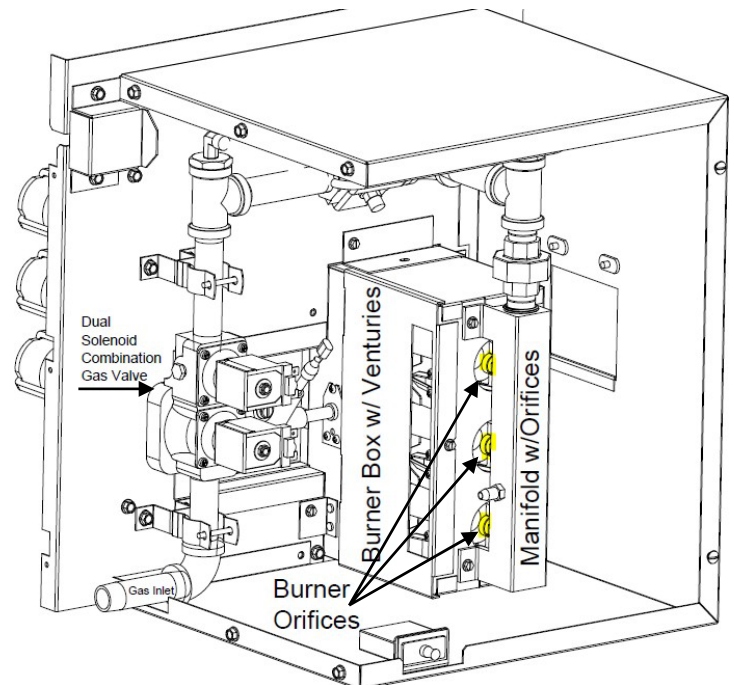
**Figure 2-18. Flexible Gas Hose Installation**



**Figure 2-19. Gas Burner Assembly**



**Figure 2-20. Burner Components**



### F. Checkout

After any adjustment, set appliance in operation and observe through a component cycle to ensure that burner system components function correctly.

**NOTE:** The installer **MUST** verify oven operation prior to putting oven into service.

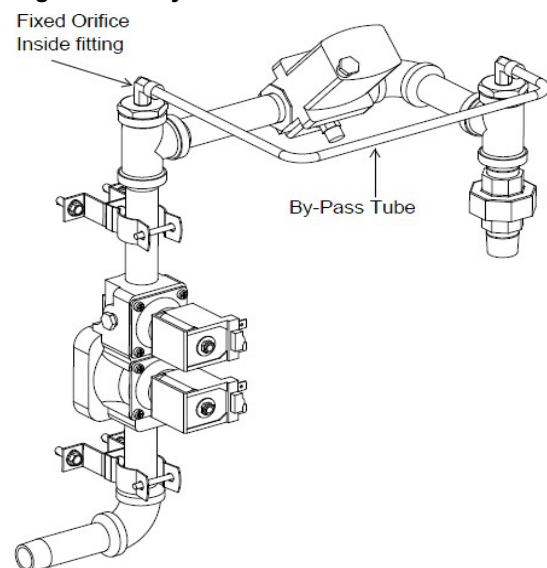
### G. Maintenance

It is recommended to check yearly the minimum and the maximum setting and readjust them if necessary.

### H. Gas Train with Orificed By-Pass

For the Gas Trains that contain the Maxitrol Modulation Valve and a mushroom spud orifice inside the by-pass tube, no adjustments are required for the minimum pressure setting.

**Figure 2-21. By-Pass Tube and Orifice Location**



## VIII. PS638G GAS SPECIFICATIONS

### A. Natural Gas

Maximum Gas Input Rate: 89,000 BTU/Hr (26.1 kW) Incoming Gas Pressure Required: 6-8" W.C. (1.5 KPa-2.0 KPa) (14.9-19.9 mbar)

Burner Gas Manifold Pressure: 3.5" W.C. (0.87 KPa) (8.7 mbar)

Main Injector Size (3X): #39 drill (0.0995") (2.527 mm) / Marked #39 on injector

Bypass Injector Diameter: #49 drill (0.073") (1.854 mm)

### B. Propane Gas

Maximum Gas Input Rate: 89,000 BTU/Hr (26.1 kW) Incoming Gas Pressure Required: 11-14" W.C. (2.7 KPa-3.5 KPa) (27.4-34.9 mbar)

Burner Gas Manifold Pressure: 6.0" W.C. (1.5 KPa) (14.9 mbar)

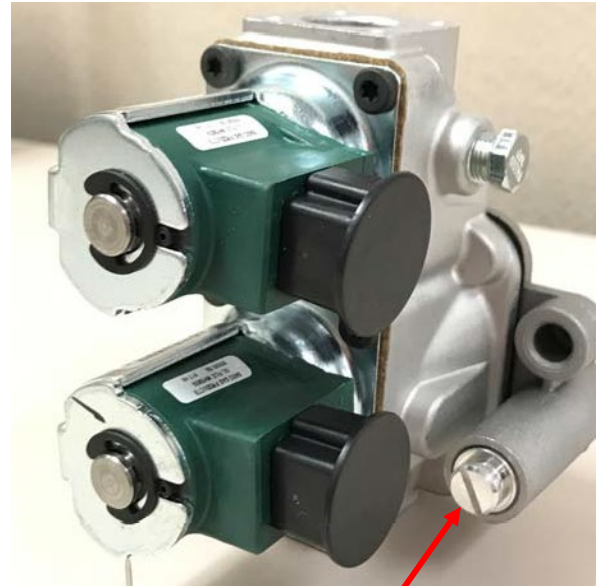
Main Injector Size (3X): 1.75 mm (0.0689") / Marked 1.75 on injector

Bypass Injector Diameter: #55 drill (0.052") (1.321 mm)

### C. NATURAL GAS PRESSURE ADJUSTMENT [Factory Pre-Set]



1. Turn the gas supply to the oven OFF. Open the tap screw in the MANIFOLD PRESSURE TAP fitting one full turn. Connect a silicone tube between the manifold pressure tap and a digital manometer. ZERO the digital manometer before performing the next step.
2. Locate the cap covering the pressure regulator adjusting screw on the combination gas control valve. Remove the cap to expose the pressure adjustment screw. Turn the gas to the oven on and start the oven.



Regulator Cap

3. Set the oven temperature to 550°F (288°C) and allow the oven to heat to 300°F (149°C). With the HEAT percentage on the user interface showing 100%, check the gas manifold pressure. For natural gas the pressure should read 3.5" W.C. (0.95 KPa, 8.7 mbar). To make any adjustments use either a 5/16" wide (7.9 mm) flat blade screwdriver or a T40 Torx bit is required.
4. If the measured gas pressure is higher than the required gas pressure setting, then turn the pressure adjustment screw counter-clockwise to decrease the gas pressure to the desired setting.
5. If the measured gas pressure is lower than the required gas pressure setting, then turn the gas pressure adjustment screw clockwise to increase the gas pressure to the desired setting.
6. Replace the cap removed in Step 2 back onto the combination gas control valve and tighten.
7. Turn the oven off. Turn off the gas supply to the oven. Remove the silicone tube from the manifold pressure tap. Turn the screw in the manifold pressure tap to the closed position. Make sure the screw is tightened securely. DO NOT OVER TIGHTEN.
8. Turn on the gas supply to the oven.
9. The oven is now ready for operation.

### D. GAS CONVERSION

Where permitted by local and national codes, it is possible to convert ovens from natural gas to propane/ULPG or from ULPG to natural gas. Use the appropriate Middleby Gas Conversion Kit for the specific oven model.

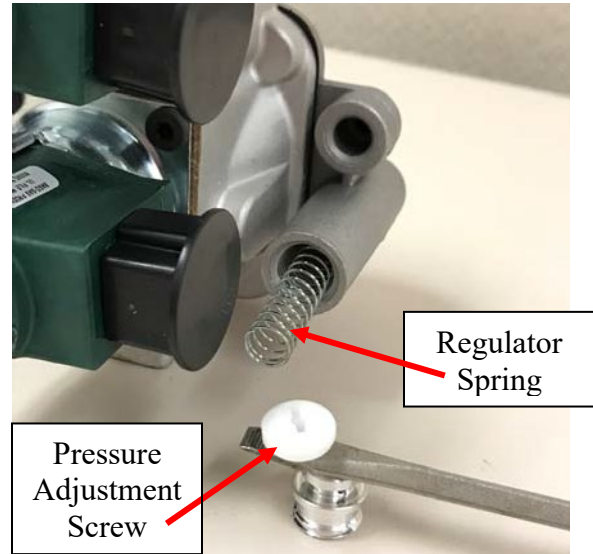
**CAUTION:** The terms of the oven's warranty require all start-ups, conversions and service work to be performed by a Middleby Authorized Service Agent.

### E. ULPG Orifice Conversion Procedure

1. Disconnect the gas supply to the oven.
2. Disconnect the manifold union closest to the gas burner manifold.
3. Remove the four screws securing the burner manifold assembly to the burner box (retain these screws they will be needed for reassembly).
4. Remove the burner manifold from the burner box.
5. Remove the existing main burner orifices and replace them with the main orifices supplied in the Middleby propane/ULPG kit. (1.75 mm)
6. Replace the burner manifold into the burner box and secure the burner manifold to the burner box with the four screws removed in Step 3 above.
7. Tighten the union connection that was loosened in Step 2 above.
8. (For Steps 8-11, See page 20, Figure 2-21: *ByPass Tube and Orifice Location drawing*)
9. Remove the two compression nuts on the 1/4" (6.35 mm) diameter aluminum tubing. Inside of the 1/4" (6.35 mm) diameter tubing (Located in the tee above the union) will be a small orifice.
10. Remove the by-pass orifice from the 1/4" (6.35 mm) diameter tube.
11. Insert the by-pass orifice from the Middleby propane conversion kit (#55 drill, 0.052" diameter, 1.321 mm) into the same position in the 1/4" (6.35 mm) diameter tube where the previous orifice was removed.
12. Reconnect the 1/4" (6.35 mm) tubing with the compression nuts that were removed in Step 8 above.

### F. ULPG Pressure Adjustment

1. Locate the cap covering the pressure regulator adjusting screw on the combination gas control valve.
2. Remove the cap to expose the pressure adjustment screw.



3. Using a 5/16" wide (7.9 mm) flat blade screwdriver (or a T40 Torx if available) remove the pressure adjuster screw by turning counter-clockwise.
4. If the measured gas pressure is higher than the required gas pressure setting, turn the pressure adjustment screw counter-clockwise to decrease the gas pressure to the desired setting.
5. If the measured gas pressure is lower than the required gas pressure setting, turn the gas pressure adjustment screw clockwise to increase the gas pressure to the desired setting.
6. Set the gas manifold pressure to 6" W.C. (1.5 kPa, 14.9 mbar) for Propane/ULPG.
7. Replace the cap removed in Step 2 back onto the combination gas control valve and tighten.
8. Turn the oven off. Turn off the gas supply to the oven. Remove the silicone tube from the manifold pressure tap. Turn the screw in the manifold pressure tap to the closed position. Make sure the screw is tightened securely. DO NOT OVER TIGHTEN.
9. Turn on the gas supply to the oven.
10. The oven is now ready for operation.

## SECTION 3 – OPERATION

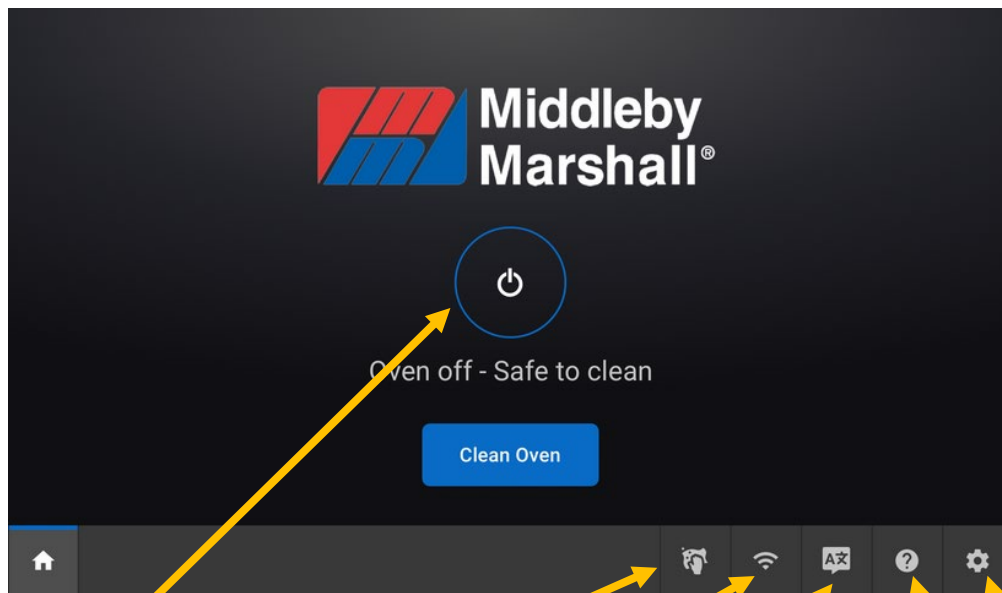
### I. DESCRIPTION OF CONTROLS – User Interface

The PS638 oven control performs a variety of functions, including:

- Temperature control
- Belt speed control
- Blower speed setting
- Energy management
- Oven diagnostics and system testing
- Conveyor speed calibration (Service use only)

The oven control will have power delivered to it and initialize when the oven is connected to the power supply. Upon initialization, the control will display a splash screen consisting of a white background with MIDDLEBY MARSHALL text. The application will then load, showing the main off splash screen.

#### A. Standby/Splash Screen



**POWER BUTTON:**

Press to initiate oven startup.

**CLEAN SCREEN:** Locks screen for 5 seconds to allow screen cleaning.

**WIFI:** Displays WiFi Status (if WiFi is connected).

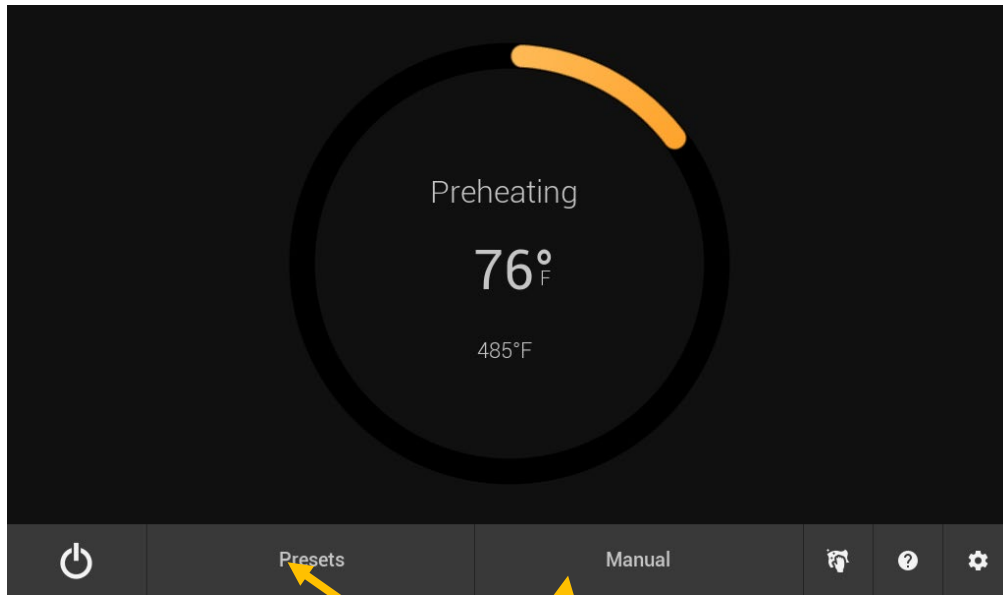
**LANGUAGE:** Allows language selection (if enabled).

**HELP:** Shows help documents.

**SETTINGS:** Allows access to settings for Managers and Service Agents

### B. Preheat Screen

Displays preheat status, allows access to oven settings by selecting PRESETS or MANUAL tab and shows preheat progress.



PRESETS: Press to switch to presets screen.

MANUAL: Press to switch to manual cooking screen.

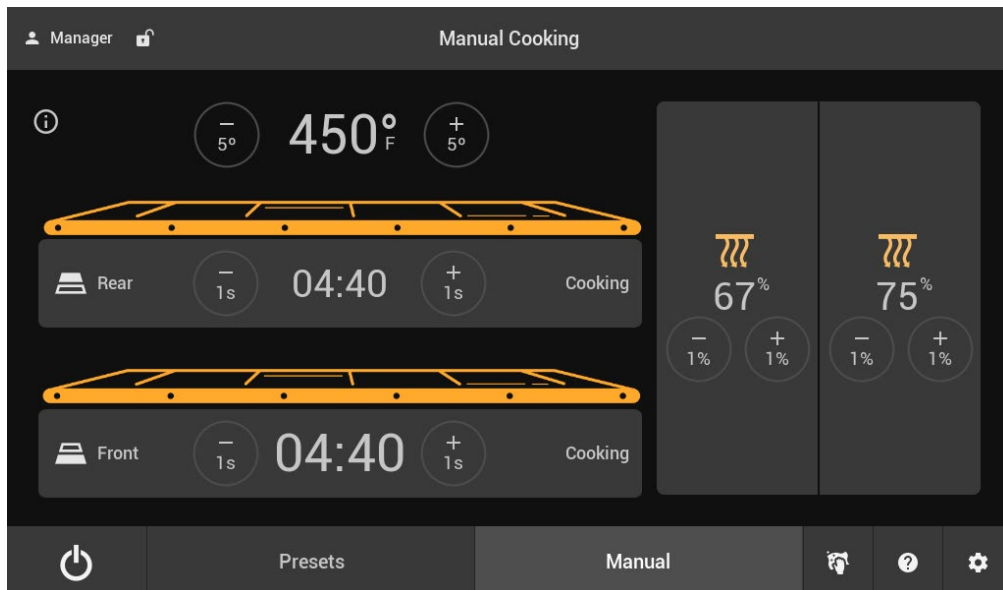
### C. Manual Cooking

In this screen you can change:

Temperature in 5 degree intervals between 300°F and 600°F

Belt times in 1 second intervals

When logged in as manager, blower speed by 1 percent intervals between 25% and 100%.



#### D. Preset Cooking

This screen allows the application of presets.

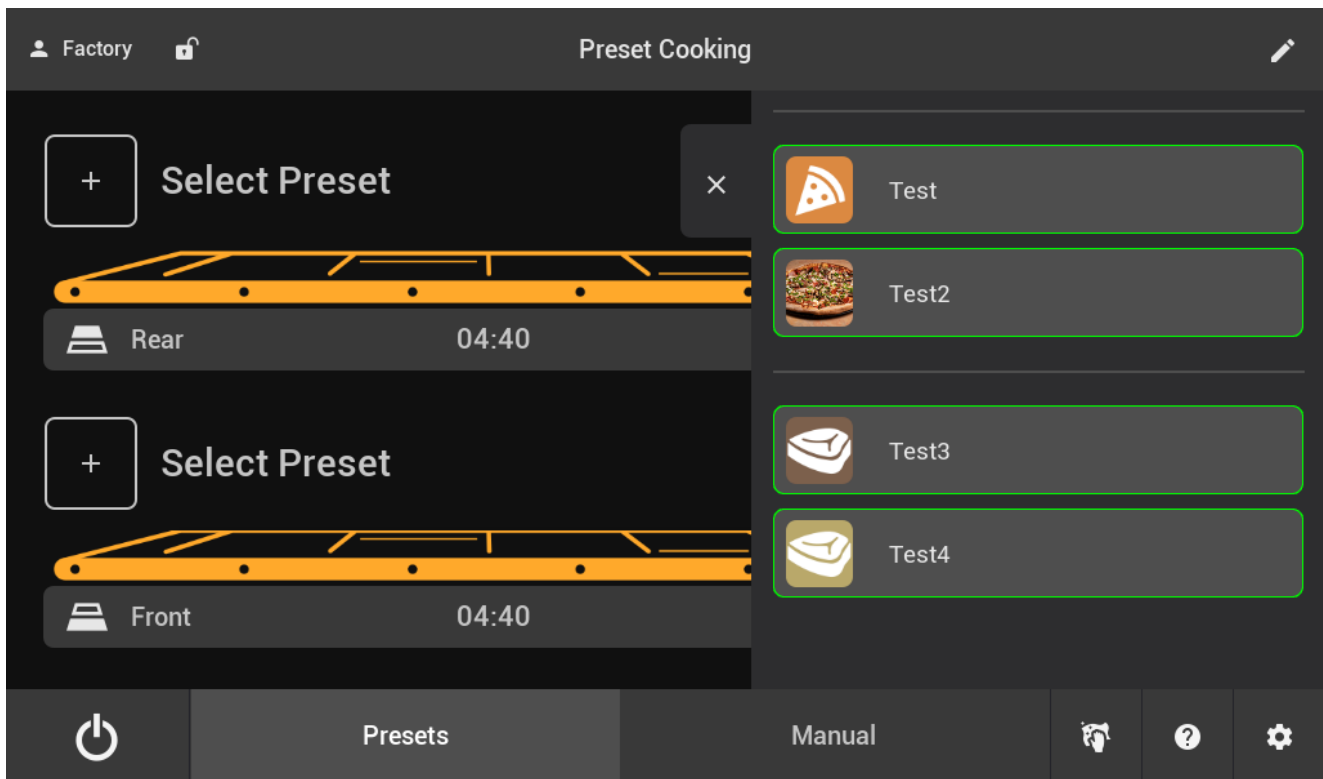
Presets may be created and edited by pressing the pencil icon in the top right of the screen. Alternatively, they may be accessed in the manager section of the settings screens.

Each preset contains three settings: Temperature, blower percentage, and a single belt time.

A preset must be applied to each belt in the oven. For single belt ovens, a single preset is applied. For split belt ovens, two presets must be applied, but the presets must have matching cavity settings (temperature and blower percent settings). The same preset can be applied to both belts.

To apply a preset to a belt, press the “plus” button above the desired belt and a list of available presets will be shown on the right side of the control. Presets that match the current cavity settings will be grouped together at the top of the list and shown in green. Other presets will also be grouped based on common cavity settings and will be shown in orange.

If a preset is selected that does not match the current cavity settings, a warning will appear on screen. You may either “Cancel” the selection or “Continue” to accept the new cavity settings. If the cavity settings are changed, any presets that are not compatible will be de-selected.



When selecting a preset, presets that match the current cavity settings will be at the top and outlined in green. Other presets will be highlighted in orange. Attempting to apply a preset that does not match the current cavity settings will show a warning. Accepting the warning will apply the preset and de-select the preset from the other belt. The user may switch to the manual screen and change settings, which will de-select the presets as well. Presets may be created and edited with the pencil icon, or in the manager section of the settings screens.

## II. NORMAL OPERATION

### A. Daily Start-up Procedure

To start the oven, press the power button. The display will transition to the preheat screen. The blower will begin and the blower proving switch will engage, permitting the heat circuit relay to engage. The gas ignition module will begin its cycle and ignite the burner.

### B. Adjusting the Temperature – Manual Mode

To adjust the set temperature, press the “+5” or “-5” button next to the set temperature to adjust the temperature in five degree increments (in Celsius, the temperature increment is one degree). Larger adjustments can be made by pressing and holding the desired button.

### C. Adjusting the Belt Time – Manual Mode

To adjust the belt time, press the “+1” or “-1” button next to the belt time to adjust the time in one second increments. Larger adjustments can be made by pressing and holding the desired button.

### D. Adjusting Settings – Preset Mode

To adjust the oven settings, a preset must be applied to each belt. If there are no presets that match the desired oven settings, a preset must be created, or manual mode must be used.

### E. Daily Shutdown Procedure (Turning the Oven Off)

To turn the oven OFF, press and hold the power button for ~1 second. This will bring up a confirmation dialogue. Press “Cancel” to return to the previous mode or press “Confirm” to proceed. If the oven is below 200°F cool down temperature, then the display will return to the STANDBY screen. If the oven is above 200°F, the display will show “COOLDOWN” and the blowers will run at a preset cool down speed until the oven temperature falls below 200°F at which point the oven will go to the STANDBY mode. If the sleep mode timer is enabled, the screen will enter sleep mode after a set period of time. In sleep mode, the screen will dim. The oven will stay in this condition until it is started again, with no outputs energized.

## 11. PROGRAMMING INSTRUCTIONS (MANAGER MODE)

### A. Changing Baking Blower Speeds (Manual)

To change the ENTRANCE and/or EXIT blower speeds in manual mode:

1. Enter the SETTINGS page by pressing the gear icon in the bottom right corner of the screen.
2. Log in as manager (default passcode 8648) and return to the MANUAL screen.
3. The blowers will now have + and – buttons next to them. Press and hold the desired button until the desired blower speeds are set.

### B. Changing Energy Mode Status

The photoeye operation can be overridden and baking mode can be continually engaged by disabling the energy mode. Energy use will be considerably higher without the energy saving mode.

Enter the SETTINGS screen and log in as manager. Under the “General” settings screen, scroll down to the “Photoeye Enabled” entry. Press the button to the right of the entry to disable the photoeye. The selector will change from green to grey.

### C. System Setup

Additional system settings can be modified in the settings screen, accessed from the gear icon in the bottom right. Without logging in, only oven details are visible. After logging in as manager, there are four categories available: General, Belt Settings, Blower Settings, and Oven Details.

#### General Settings Options

- Audio Feedback Enabled: Enables audio feedback, especially for alerts.
- Beep on Button Press: Enables a beep when a button is pressed (audio feedback must be enabled).
- Language: Allows language selection.
- Language Icon View: Inserts a language icon in the bottom row that can be used to change the language.
- Display Brightness: Change the brightness of the screen.
- Date/Time: Set the date and time for improved oven monitoring.
- Sleep Mode Timer Enabled: Enables sleep mode (dimmed screen in Standby).
- Sleep Mode Timer: Change the amount of time the oven remains in Standby before sleep mode is enabled.
- Photoeye Enabled: Enables or disables the photoeye. If the photoeye is disabled, the blowers will run at “bake” speeds at all times.
- Photoeye Delay: Determines how long the photoeye must be broken before the bake mode is triggered.
- Temperature Units: Switch between Fahrenheit and Celsius.
- Operating Temperature: Allows restricting the operating temperature between the defaults of 300°F-600°F.
- Temperature Display Timeout: Determines how long “actuals” will be displayed when the info button is pressed. Set to “0” to disable actual temperature display.
- Manager Passcode: Allows the manager to customize the manager passcode.

#### Belt Settings Options

- Tweak Speed Percentage: Speed up or slow down the belt speed by up to 15% to fix small discrepancies in timing due to belt age

## Blower Settings

- Blower Status: See blower speed (if rotation sensor equipped) and status of sensor (open/closed).
- Cooldown HZ: Set blower speeds during cooldown. Higher speeds produce more noise and use more power but cool down the oven faster.

## Oven Details

- View oven details such as customer name, oven serial number, and software versions.

## D. Energy Management Information

The PS638 oven reduces energy usage in two ways over most competitive ovens:

Modulating gas control (Energy Management System)

BAKING / IDLE mode control (Energy Saving Mode)

The modulating gas valve within the oven controls pressure of the delivered gas to the burners to increase or reduce the energy input as needed to maintain temperature instead of cycling a gas valve on and off. This is a most efficient and accurate way of controlling the temperature and eliminates the heat losses associated with the ON/OFF cycling control.

The PS638 oven, like other Middleby ovens, has an idle mode that places the blower at a reduced speed during non-baking periods. Reducing the blower speed reduces the volume of air requiring heating and thus reduces energy usage during these non-baking times. A photoeye sensor at the entrance side of the baking chamber detects when food is placed on the belt and brings the oven up to the higher (baking) blower speed, increasing the amount of convection / impingement air needed to cook products faster. When the product passes the photoeye, the controller begins a preset timed period that ensures the product will pass fully through the oven before the oven returns to the IDLE mode. With this energy management system, the oven provides the increased convection / impingement heat transfer into the products needed for fast, even baking, without the energy penalty during non-baking times. This functionality is fully automatic and requires no user interaction.



**NOTES:**

## SECTION 4 - MAINTENANCE

### WARNING

Before ANY cleaning or servicing of the oven, perform the following procedure:

1. Switch off the oven and allow it to cool. Do NOT service the oven while it is warm.
2. Turn off the electric supply circuit breaker(s) and disconnect the electric supply to the oven.
3. If it is necessary to move a gas oven for cleaning or servicing, disconnect the gas supply before moving the oven.

When all cleaning and servicing is complete:

1. If the oven was moved for servicing, return the oven to its original location.
2. If the restraint cable was disconnected to clean or service the oven, reconnect it at this time.
3. Reconnect the gas supply.
4. Reconnect the electrical supply.
5. Turn on the full-flow gas safety valve. Test the gas line connections for leaks using approved leak test substance or thick soap suds.
6. Turn on the electric supply circuit breaker(s).
7. Perform the normal startup procedure.

### WARNING

Possibility of injury from moving parts and electrical shock exists in this oven. Switch off and lockout/tagout the electric supply BEFORE beginning to disassemble, clean, or service any oven. Never disassemble or clean an oven with the BLOWER switch or any other circuit of the oven switched on.

### CAUTION

NEVER use a water hose or pressurized steam-cleaning equipment when cleaning this oven. To avoid saturating the oven insulation, DO NOT use excessive amounts of water. DO NOT use a caustic oven cleaner, which can damage the bake chamber surfaces.

### NOTE

ANY replacement parts that require access to the interior of the oven may ONLY be replaced by a Middleby Marshall Authorized Service Agent. It is also strongly recommended that the 3-Month Maintenance and 6-Month Maintenance procedures in this section be performed ONLY by a Middleby Marshall Authorized Service Agent.

### I. MAINTENANCE – DAILY

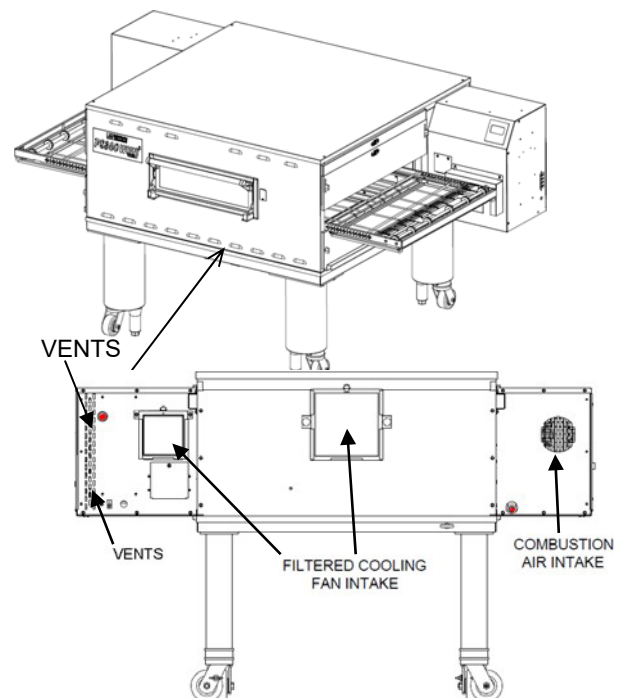
- A. Check that the oven is cool and the power is disconnected, as described in the warning at the beginning of this section.
- B. Clean ALL of the cooling fan grills and vent openings with a stiff nylon brush. Refer to Figure 4-1 for the location of the grills and vents.
- C. Clean the outside of the oven with a soft cloth and mild detergent.
- D. Check that all cooling fans are operating properly.

**CAUTION:** If a cooling fan is not operating correctly, it must be replaced IMMEDIATELY. Operating the oven without adequate cooling can seriously damage the oven's internal components



- E. Clean the conveyor belts with a stiff nylon brush. This is more easily accomplished by allowing the conveyor to run while you stand at the exit end of the conveyor and brush the crumbs off the conveyor as it moves.
- F. Remove and clean the crumb trays. If necessary, refer to Figure 2-16 (In Section 2, Installation) when replacing the crumb trays into the oven.
- G. Clean the window in place.

Figure 4-1. Cooling Vents and Grills



## II. MAINTENANCE – MONTHLY

NOTE: When removing the conveyor, refer to Figure 2-12 (in Section 2, Installation).

- A. Check that the oven is cool and the power is disconnected as described in the warning at the beginning of this section.
- B. Remove the crumb trays from the oven.
- C. Lift the drive end of the conveyor slightly and push it forward into the oven. This removes the tension from the drive chain. Remove the drive chain from the conveyor sprocket.
- D. Slide the conveyor out of the oven, folding at as it is removed.
- E. Remove the end plugs from the oven. The end plugs are shown in Figure 1-1 (in Section 1, Description).
- F. Slide the air fingers and blank plates out of the oven, as shown in Figure 4-2. AS EACH FINGER OR PLATE IS REMOVED, WRITE A "LOCATION CODE" ON IT WITH A MARKER to make sure it can be reinstalled correctly.

Example of markings:

Top Row →    **T1**   **T2**   **T3**   **T4**  
 Bottom Row → **B1**   **B2**   **B3**   **B4**

- G. Disassemble the air fingers as shown in Figure 4-3. AS EACH FINGER IS DISASSEMBLED, WRITE THE "LOCATION CODE" FOR THE FINGER ON ALL THREE OF ITS PIECES. This will help to correctly reassemble the air fingers.

**CAUTION:** *Incorrect reassembly of the air fingers will change the baking properties of the oven.*



- H. Clean the air finger components and the interior of the baking chamber using a vacuum cleaner and a damp cloth. Refer to the boxed warnings at the beginning of this section for cleaning precautions.
- I. Reassemble the air fingers. Then replace them in the oven, using the "location codes" as a guide.
- J. Replace the end plugs on the oven.
- K. Reassemble the conveyor into the oven. If the drive sprocket was removed when installing the conveyor, replace it at this time.
- L. Reattach the drive chain.
- M. Check the tension of the conveyor belt as shown in Figure 2-14 (in Section 2, Installation). The belt should lift 1" (25.4 mm) DO NOT OVERTIGHTEN THE CONVEYOR BELT. If necessary, the belt tension can be adjusted by turning the conveyor adjustment screws, located at the idler (left) end of the conveyor
- N. Replace the crumb trays.

Figure 4-2. Removing Air Fingers and Plates

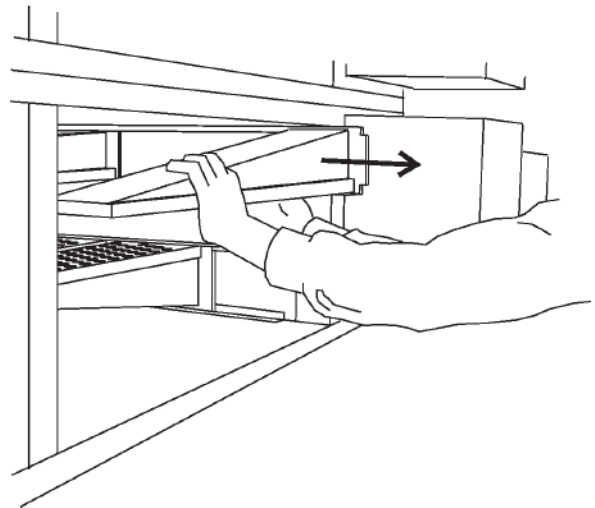
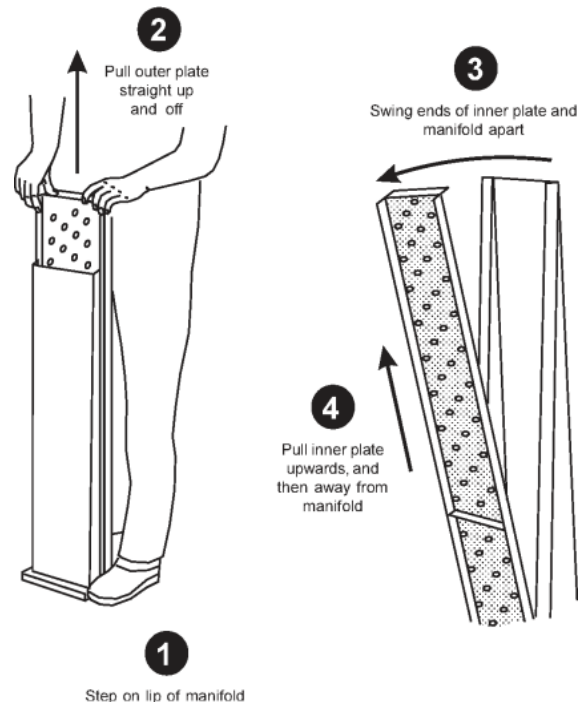
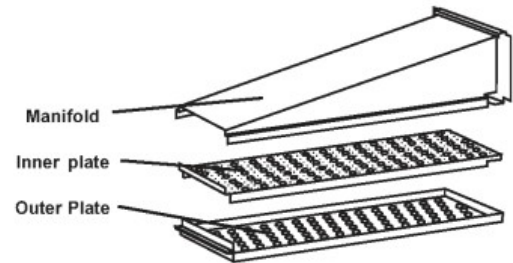


Figure 4-3. Disassembling the Air Fingers



### III. MAINTENANCE – EVERY 6 MONTHS

- A. The Six-Month Maintenance should be carried out by a qualified Middleby authorized service agent or by Middleby authorized personnel.
- B. Check that the oven is cool and the power is disconnected, as described in the warning at the beginning of this section.
- C. For gas ovens, inspect and clean the burner nozzle and the spark electrode assembly.
- D. Vacuum all of the blower mounts and their surrounding compartments using a shop vacuum.
- E. Tighten all electrical terminal screws
- F. Check the conveyor drive shaft bushings and spacers. Replace the components if they are worn.
- G. Split Belt Disassembly and Cleaning
  1. Refer to Part D, Conveyor Installation, in the Installation section of this manual. Then, remove the following components from the oven:
    - Conveyor end stop
    - Crumb trays
    - Chain cover
    - Drive chains
    - End plugs
    - Conveyor assembly
  2. Remove the master links from each conveyor belt. Then, roll the belts up along the length of the conveyor to remove them from the frame.
  3. Remove the two conveyor adjustment screws from the idler end of the conveyor frame, as shown in Figure 4-4.
  4. Remove the idler shaft assembly from the conveyor.
  5. Pull apart the two sections of the idler shaft.
  6. Clean the shafts thoroughly using a rag. Lubricate both the extended shaft and the interior of the hollow shaft using a light food-grade lubricant. DO NOT lubricate the shafts using WD-40 or a similar product. This can cause the shafts to wear rapidly.
  7. Before reassembling the shafts into the conveyor frame, check that they are oriented properly.
  8. Reassemble the idler shaft into the conveyor. Make sure that the bronze washer is in place between the two sections of the shaft. See Figure 4-4.
  9. Replace the conveyor adjustment screws as shown in Figure 4-4. To allow the conveyor belt to be reinstalled later, do not tighten the screws at this time.
  10. Loosen the set screw on both of the conveyor drive sprockets. Remove the sprockets from the shaft.
  11. Check the conveyor configuration as follows:

**High-speed conveyors** are equipped with large flange bearings at both ends of the shaft, as shown in Figure 4-5. For these conveyors, remove the two screws that hold each bearing to the conveyor frame. With the screws removed, lift the end of the shaft at the front of the oven, and pull the entire assembly free of the conveyor frame.

**Standard conveyors** are equipped with bronze bushings mounted on spacers at both ends of the shaft, as shown in Figure 4-5. For these conveyors, remove the two screws that hold the bracket to the conveyor frame. With the screws removed, lift the end of the shaft at the front of the oven and pull the entire assembly free of the conveyor frame. The brackets will be removed along with the drive shaft assembly.
  12. Disassemble and lubricate the two sections of the drive shaft as described for the idler shaft, Step 6.
  13. Before reassembling the shafts into the conveyor frame, check that they are oriented properly.
  14. Reassemble the drive shaft into the conveyor. Make sure that the bronze washer is in place between the two sections of the shaft. See Figure 4-6.
  15. Replace the drive sprockets. Reassemble the belts and master links onto the conveyor.
  16. Reinstall the end plugs and conveyor onto the oven. Reattach the drive chains. Replace the chain cover.
  17. Check the tension of the conveyor belt as shown in Figure 2-14 (in Section 2, Installation). The belt should lift about 1" (25 mm). If necessary, adjust the belt tension by turning the conveyor adjustment screws.
  18. Replace all components onto the oven.

Figure 4-4. Disassembling the Idler Shaft

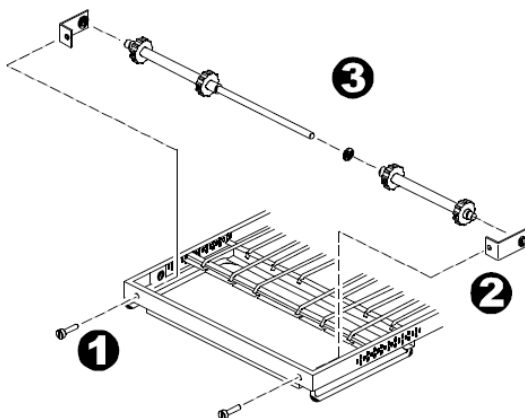


Figure 4-5. Drive Shaft Configurations

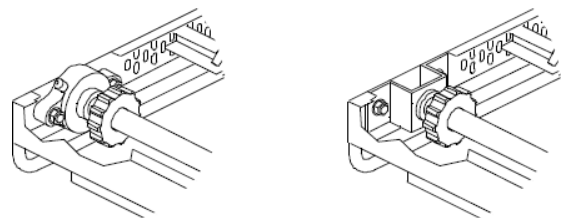
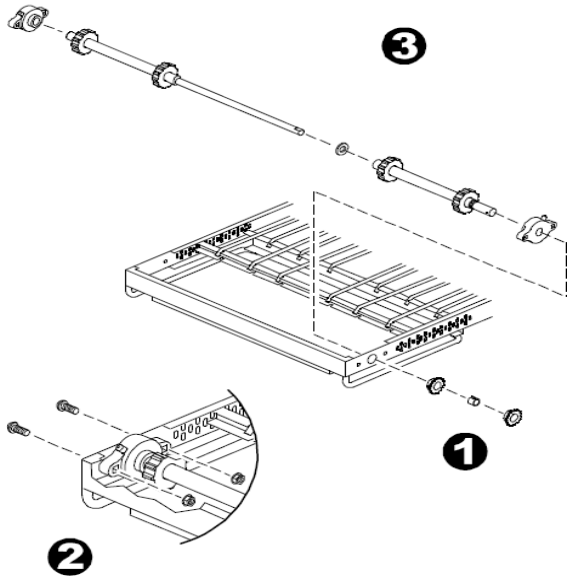
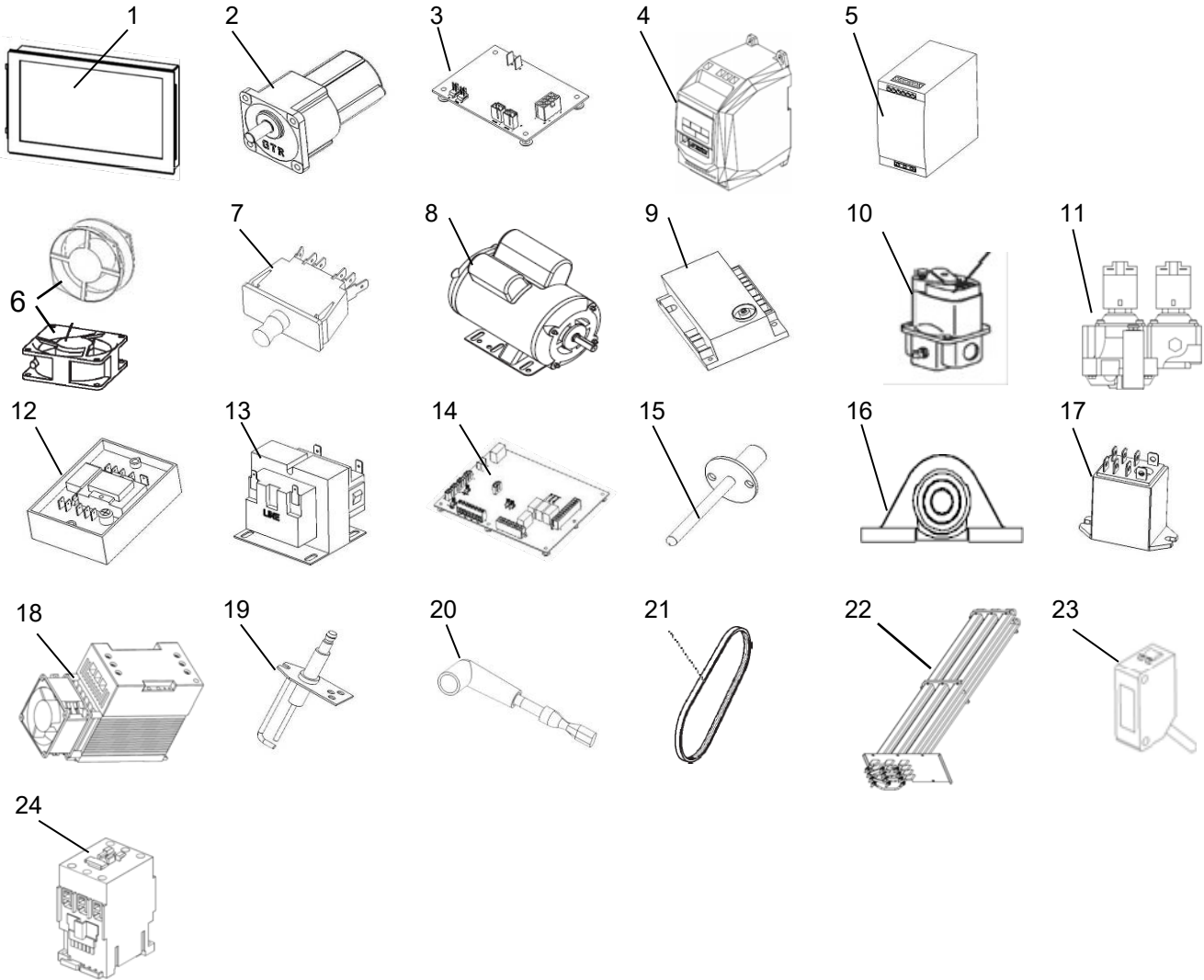


Figure 4-6. Disassembling the drive shaft



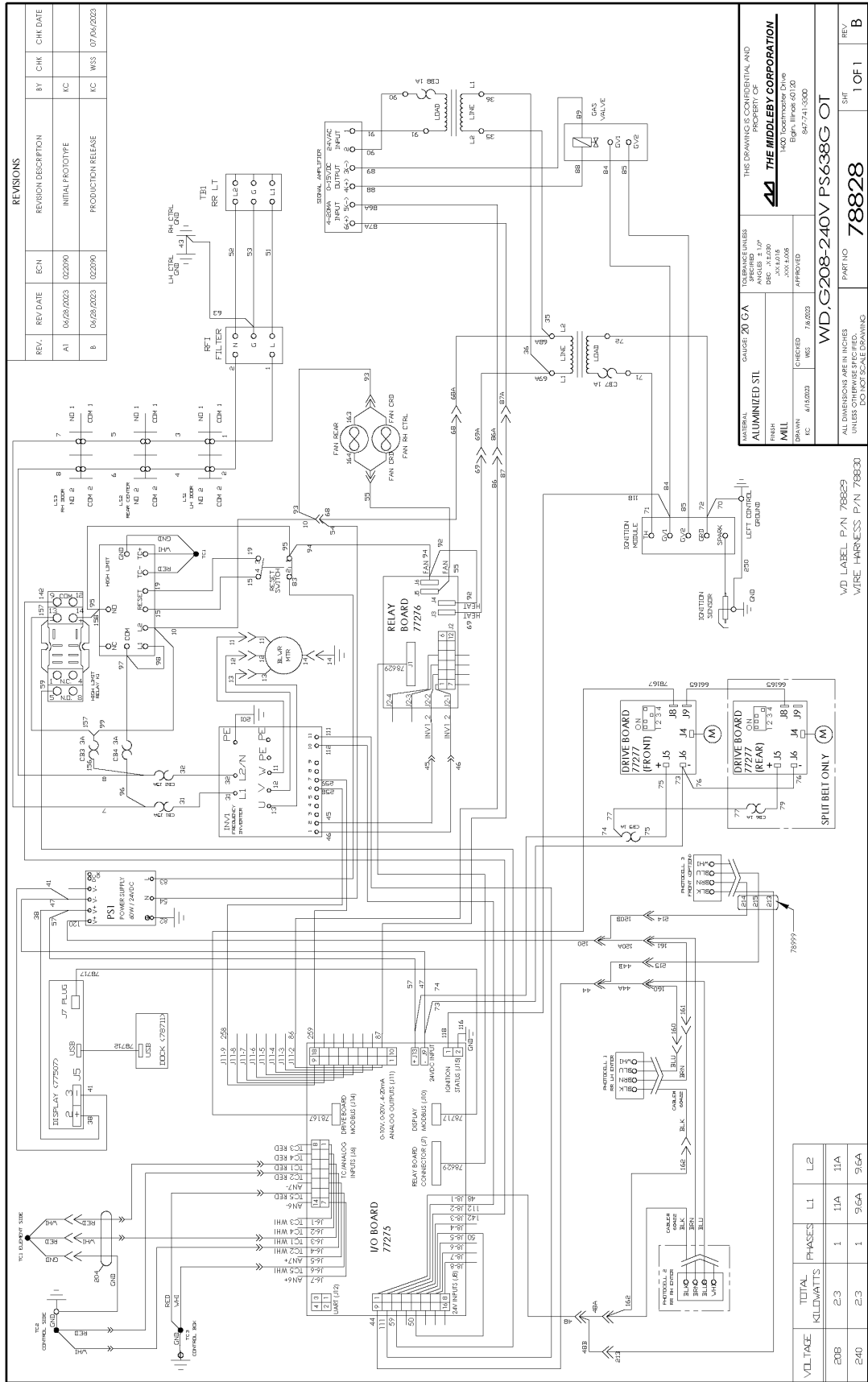
#### IV. PS638E & G OVEN KEY SPARE PARTS



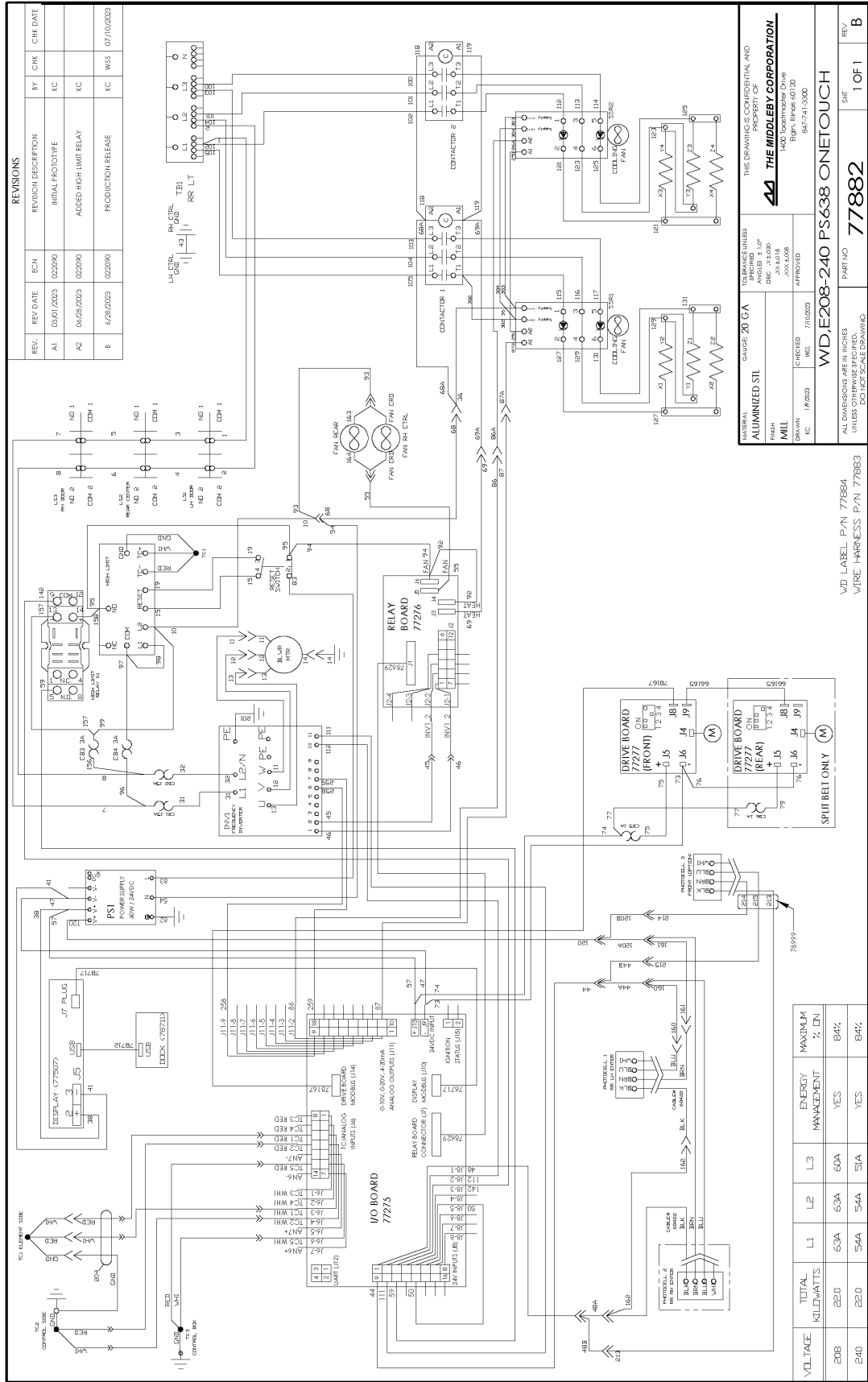
## V. PS638E & G OVEN KEY SPARE PARTS

| ITEM | QTY | P/N         | DESCRIPTION                                     |
|------|-----|-------------|-------------------------------------------------|
| 1    | 1   | 77507       | Digital Display, Programmed                     |
| 2    | 1   | 74106       | Motor, Conveyor Drive (74106)                   |
| 3    | 1   | 77277       | Conveyor Control Board                          |
| 4    | 1   | 74097       | VFD Inverter, 2 HP (230 VAC Input)              |
| 5    | 1   | 76979       | Power Supply, 24 VDC, 60W                       |
| 6a   | 1   | 36451       | Small Cooling Fan for Right Control Compartment |
| 6b   | 1   | 97525       | Large Cooling Fan for Center Rear of Oven       |
| n/s  | 1   | 77174       | Small Cooling Fan Filter (5" square)            |
| n/s  | 1   | 77553       | Large Cooling Fan Filter (6.5" square)          |
| 7    | 2   | 63909/63910 | Door Switches, Interlock / Momentary            |
| 8    | 1   | 57288       | Blower Motor, 2 HP                              |
| 9    | 1   | 62285       | Ignition Module (Gas Only)                      |
| 10   | 1   | 59450       | Maxitrol Modulating Gas Valve (Gas Only)        |
| 11   | 1   | 59465       | Dual Solenoid Combination Valve (Gas Only)      |
| 12   | 1   | 33983       | Hi Limit Thermostat                             |
| n/s  | 1   | 78814       | High Limit Reset Button                         |
| 13   | 1   | 32108       | Transformer, 240 primary / 24 secondary         |
| 14a  | 1   | 77275       | I/O Board                                       |
| 14b  | 1   | 77276       | Relay Board                                     |
| 15   | 1   | 33984       | Thermocouple (3 per oven)                       |
| 16   | 1   | 64106       | Bearing, Dodge 5/8                              |
| 17   | 1   | 60952       | Relay, DPDT 208-240 VAC Coil                    |
| 18a  | 2   | 76289       | 208/240V SS Power Controllers                   |
| 18b  | 1   | 76289       | 380/416V SS Power Controllers                   |
| 19   | 1   | 71037       | Single Rod Igniter                              |
| 20   | 1   | 62282       | Ignition Cable                                  |
| n/s  | 2   | 71815       | Blower Shaft                                    |
| 21   | 1   | 50517       | Serpentine Blower Belt                          |
| 22a  | 1   | 60750       | Heater, 27 kW, 208 VAC Specific                 |
| 22b  | 1   | 74125       | Heater, 27 kW, 240 VAC Specific                 |
| 22c  | 1   | 68661       | Heater, 18 kW, 380 VAC Specific                 |
| 22c  | 1   | 73656       | Heater, 27 kW, 380 VAC Specific                 |
| 23   | 1   | 72209       | Photoeye (optional)                             |
| n/s  | 1   | 74316       | Photoeye Lens (optional)                        |
| 24   | 1   | 44549       | Contactactor (Electric Only)                    |

# SECTION 5 - WIRING DIAGRAMS



# Electric Schematics



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THE MIDDLEBY CORPORATION  
847-741-3000

ALUMINIZED STL  
Gauge: 20 GA  
FINISH: MILL  
DRAWN: J.P.2023  
CHECKED: J.P.2023  
APPROVED: J.P.2023

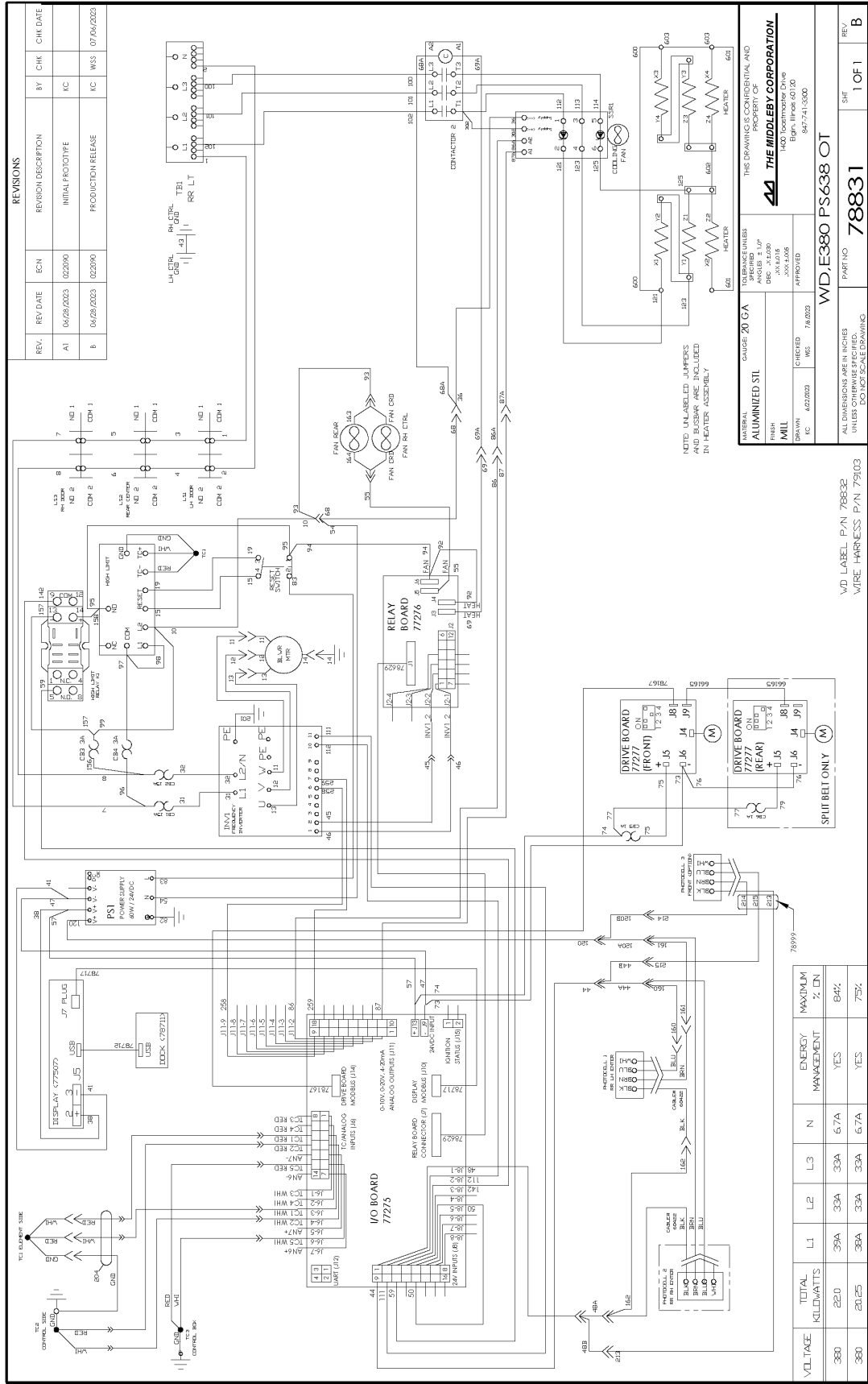
THIS DRAWING IS UNLESS SPECIFIED ANGLES: 1/8" UNLESS OTHERWISE SPECIFIED

WD.E208-240 PS638 ONETOUCH  
PART NO: 77882  
SHEET: 1 OF 1  
REV: B

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.  
DO NOT SCALE DRAWING

| VOLTAGE | TOTAL KILOWATTS | L1  | L2  | L3  | ENERGY MANAGEMENT | MAXIMUM % ON |
|---------|-----------------|-----|-----|-----|-------------------|--------------|
| 208     | 22.0            | 63A | 63A | 60A | YES               | 84%          |
| 240     | 22.0            | 54A | 54A | 51A | YES               | 84%          |





**REVISIONS**

| REV. | REV. DATE  | ECH    | REVISION DESCRIPTION | BY | CHK | CHK DATE   |
|------|------------|--------|----------------------|----|-----|------------|
| A1   | 06/29/2023 | 022090 | INITIAL PROTOTYPE    | MC |     |            |
| B    | 06/29/2023 | 022090 | PRODUCTION RELEASE   | MC | WSS | 07/06/2023 |

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**THE MIDDLEBURY CORPORATION**  
 1000 MIDDLEBURY BLVD  
 BRATTLEBORO, VT 05743  
 802.741.5000

GAUGE 20 GA  
 TUBING: SILEX  
 SPECIES: 2 1/2" P  
 APPROX: 1/4" DIA  
 DIM: .0005  
 .0010  
 .0015  
 .0020  
 .0025  
 .0030  
 .0035  
 .0040  
 .0045  
 .0050  
 .0055  
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 .0090  
 .0095  
 .0100

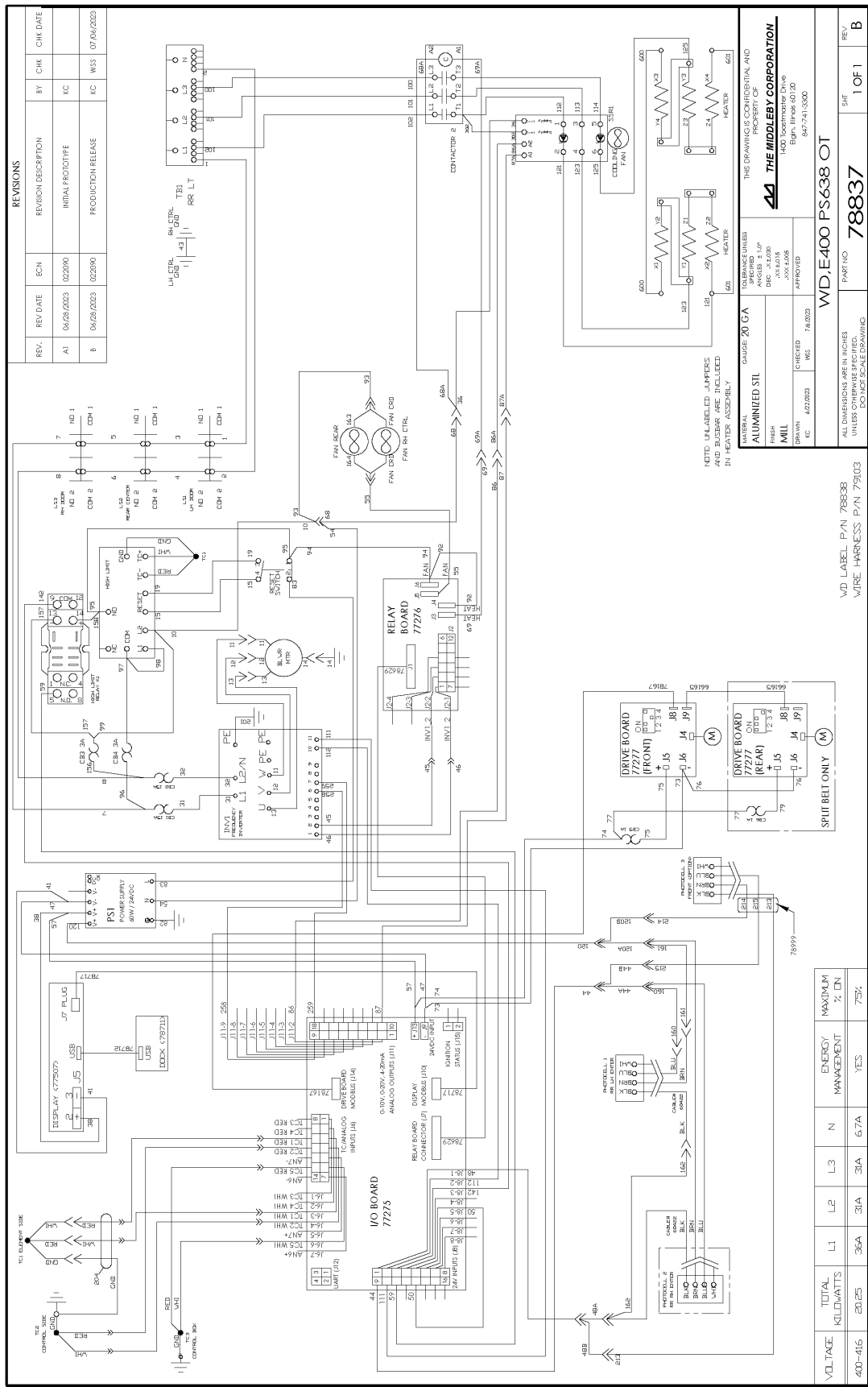
ALUMINIZED SIL  
 DRAWN: J.C. 4/27/2023  
 CHECKED: J.W. 5/1/2023  
 APPROVED: J.W. 5/1/2023

WIRE HARNESS P/N 79103  
 PART NO: **78831**  
 W/D: E380 PS638 OT

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. DO NOT SCALE DRAWING.

| VOLTAGE | TOTAL KILOWATTS | L1  | L2  | L3  | N    | ENERGY MANAGEMENT | MAXIMUM % CN |
|---------|-----------------|-----|-----|-----|------|-------------------|--------------|
| 380     | 25.0            | 39A | 33A | 33A | 6.7A | YES               | B4;          |
| 380     | 20.25           | 38A | 33A | 33A | 6.7A | YES               | 75%;         |





**REVISIONS**

| REV. | REV. DATE  | ECH    | REVISION DESCRIPTION | BY | CHK | CHK DATE   |
|------|------------|--------|----------------------|----|-----|------------|
| A1   | 06/29/2023 | 022090 | INITIAL PROTOTYPE    | MC |     |            |
| B    | 06/29/2023 | 022090 | PRODUCTION RELEASE   | MC | WSS | 07/06/2023 |

**THE MIDDLEBURY CORPORATION**  
 1000 MIDDLEBURY AVENUE  
 MIDDLEBURY, VT 05753  
 TEL: 802.243.1211 FAX: 802.243.1212  
 WWW.MIDDLEBURYCORP.COM

**ALUMINIZED SIL**  
 TYPING: GAUGE 20 GA  
 SPECIES: 2 1/2" X 3 1/2" X .015  
 FINISH: MILL  
 DRAWN: J.C. 4/27/2023  
 CHECKED: J.M. 5/1/2023  
 APPROVED: J.M. 5/1/2023

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| VOLTAGE | TOTAL KILOWATTS | ENERGY MANAGEMENT | L1  | L2  | L3   | N    | MAXIMUM % CN |
|---------|-----------------|-------------------|-----|-----|------|------|--------------|
| 400-415 | 20.25           | YES               | 36A | 31A | 6.7A | 5.7A | 75%          |

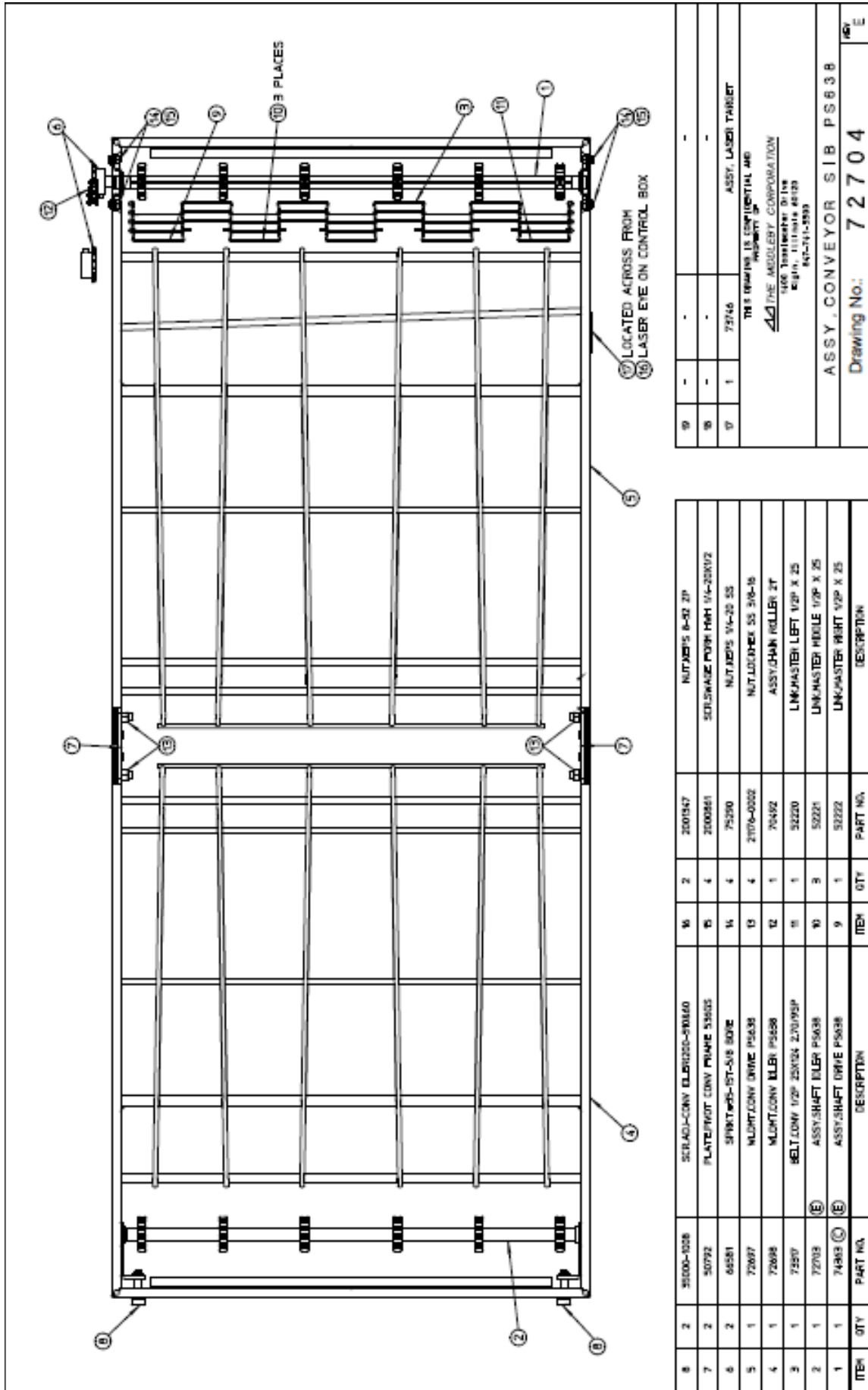
WD LABEL P/N 78838  
 WIRE HARNESS P/N 79103

WD-E400 PS638 OT  
**78837**

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. DO NOT SCALE DRAWING.

REV. 1 OF 1

# SECTION 6 - ASSEMBLY DRAWINGS



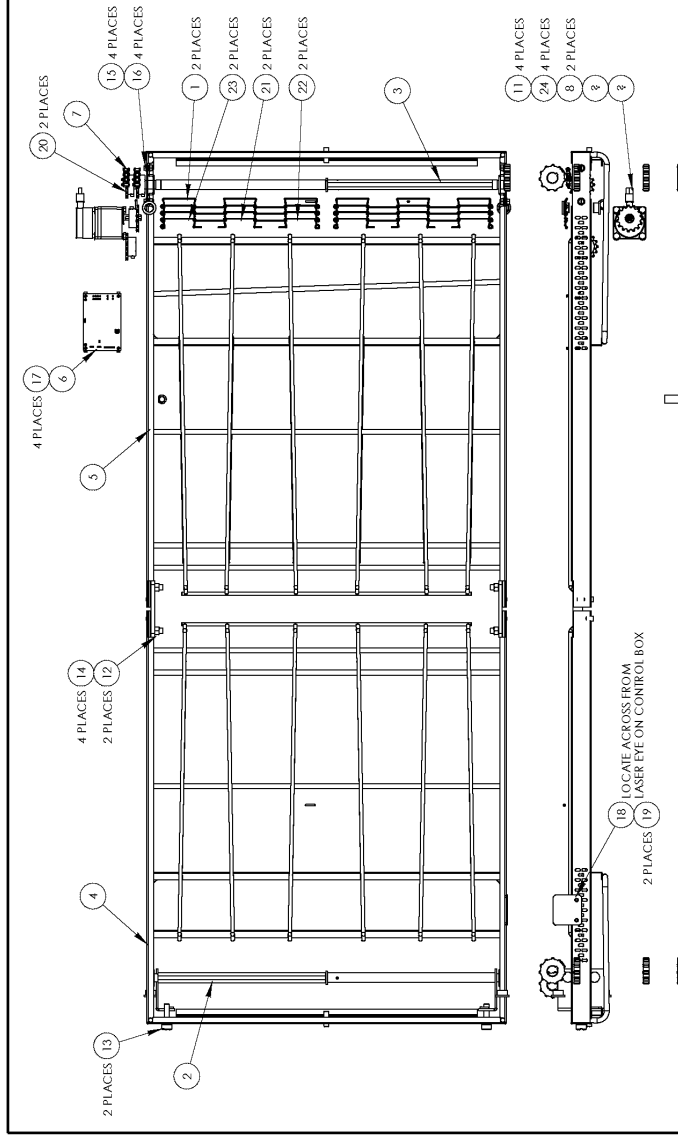
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| 8    | 2   | 9500-1028 | SCRAP-CONV ELB 180220-30060   | 16   | 2   | 200147    | NUT/MS 8-32 ZP                |
| 7    | 2   | 5072      | PLATE/FTOT CONV PLATE 33625   | 15   | 4   | 200861    | SCR-SWAGE PDRR FMH 1/4-20X1/2 |
| 6    | 2   | 66581     | SPRKT/MS-157-5/8 30R2         | 14   | 4   | 75290     | NUT/MS 1/4-20 SS              |
| 5    | 1   | 72697     | MOUNT/CONV DRIVE PS638        | 13   | 4   | 2105-0022 | NUT/LOCKER SS 3/8-16          |
| 4    | 1   | 72698     | MOUNT/CONV ELBR PS638         | 12   | 1   | 76492     | ASSY/SHAK ROLLER 2T           |
| 3    | 1   | 72597     | BELT/CONV 1/2" 25X125 27019SP | 11   | 1   | 52220     | LINK/MASTER LFT 1/2" X 25     |
| 2    | 1   | 72703     | ASSY/SHAFT ELBR PS638         | 10   | 3   | 52221     | LINK/MASTER MIDDLE 1/2" X 25  |
| 1    | 1   | 74383 (E) | ASSY/SHAFT DRIVE PS638        | 9    | 1   | 52222     | LINK/MASTER RHT 1/2" X 25     |

|    |   |       |                    |
|----|---|-------|--------------------|
| 19 | - | -     | -                  |
| 18 | - | -     | -                  |
| 17 | 1 | 73746 | ASSY. LASER TARGET |

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 1400 TWINLAKES BLVD  
 KENILWORTH, ILLINOIS 60139  
 847-741-5593

ASSY. CONVEYOR SIB PS638  
 Drawing No.: **72704** (REV) E

| REVISIONS |            |        |                      |    |     |            |
|-----------|------------|--------|----------------------|----|-----|------------|
| REV.      | REV. DATE  | ECH    | REVISION DESCRIPTION | BY | CHK | CHK DATE   |
| A1        | 06/29/2023 | 022090 | INITIAL PROTOTYPE    | IC |     |            |
| B         | 6/29/2023  | 022090 | PRODUCTION RELEASE   | IC | WSS | 07/06/2023 |



| ITEM NO. | QTY. | PART NUMBER | DESCRIPTION                   | ITEM NO. | QTY. | PART NUMBER | DESCRIPTION                              |
|----------|------|-------------|-------------------------------|----------|------|-------------|------------------------------------------|
| 13       | 2    | 35000-1008  | SCR ADJ CONV IDLER 200-510&40 | 26       | 1    | 78869       | WI RESET SPIT BELT ONE TOUCH (NOT SHOWN) |
| 12       | 2    | 50292       | PLATE PIVOT CONV FRAME 53&65  | 25       | 1    | 66165       | CABLE MTR BD 7" P5&6 (NOT SHOWN)         |
| 11       | 4    | 55486       | SCR HEX HEAD 1/4-20X 3/4 SS   | 24       | 4    | 21424-0002  | WASHER LOCK SS 1/4                       |
| 10       | 1    | 74106       | MOTOR GEAR 1200 23W           | 23       | 2    | 73957       | LINK MASTER RIGHT 1/2P X12 CC            |
| 9        | 1    | 68878       | ADAPTER MOTOR SHAFT           | 22       | 2    | 73956       | LINK MASTER LEFT 1/2P X12 CC             |
| 8        | 2    | 66581       | SPRKT #35-15F-5/8 BORE        | 21       | 2    | 52135       | LINK MASTER MIDDLE 1/2P X 12             |
| 7        | 2    | 70492       | ASSY CHAIN ROLLER 21"         | 20       | 2    | 74226       | SPRKT #35-15F-5/8 BORE                   |
| 6        | 1    | 77277       | BOARD DRIVE                   | 19       | 2    | 2001347     | NUT KEPS 8-32 ZP                         |
| 5        | 1    | 72697       | WDMT CONV DRIVE P5&38         | 18       | 1    | 73746       | ASSY LASER TARGET                        |
| 4        | 1    | 72698       | WDMT CONV IDLER P5&38         | 17       | 4    | 74901       | STAND OFF PCS 8 NYLON                    |
| 3        | 1    | 74376       | ASSY SHAFT DRIVE SPB P5&38    | 16       | 4    | 2000861     | SCR SWAGE FORM HWHL 1/4-20X 1/2          |
| 2        | 1    | 72803       | ASSY SHAFT IDLER SPB P5&38    | 15       | 4    | 75290       | NUT KEPS 1/4-20 SS                       |
| 1        | 2    | 73313       | BELT CONV WIRE SS 1/2P 12X126 | 14       | 4    | 21174-0002  | NUT LOCK HEX SS 3/8x16                   |

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DRAWN: JG 5/01/2023  
 CHECKED: JG 5/16/2023  
 APPROVED: JG 5/16/2023

THE MIDDLEBY CORPORATION  
 HEADQUARTERS: 10000 W. 110TH AVE., SUITE 1218  
 BENTON HARBOR, MI 49018  
 800.741.3000

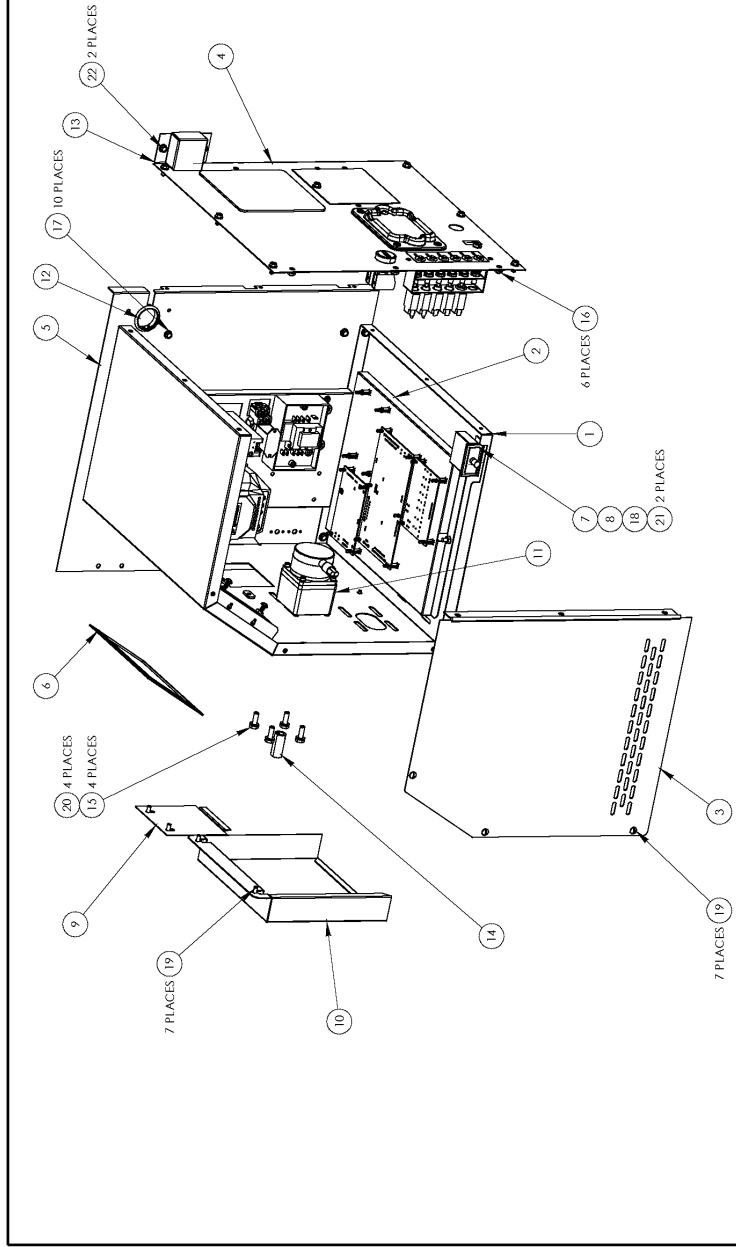
ASSY CONVEYOR 13/13 X 38 OT

PART NO: 78872

SHT: 1 OF 1

REV: B

| REV. | REV DATE   | ECN    | REVISION DESCRIPTION   | BY | CHK | CHK DATE   |
|------|------------|--------|------------------------|----|-----|------------|
| A1   | 1/9/2023   |        | INITIAL PROTOTYPE      | KC |     |            |
| A2   | 06/29/2023 | 022090 | UPDATED PER COMPONENTS | KC |     | ...        |
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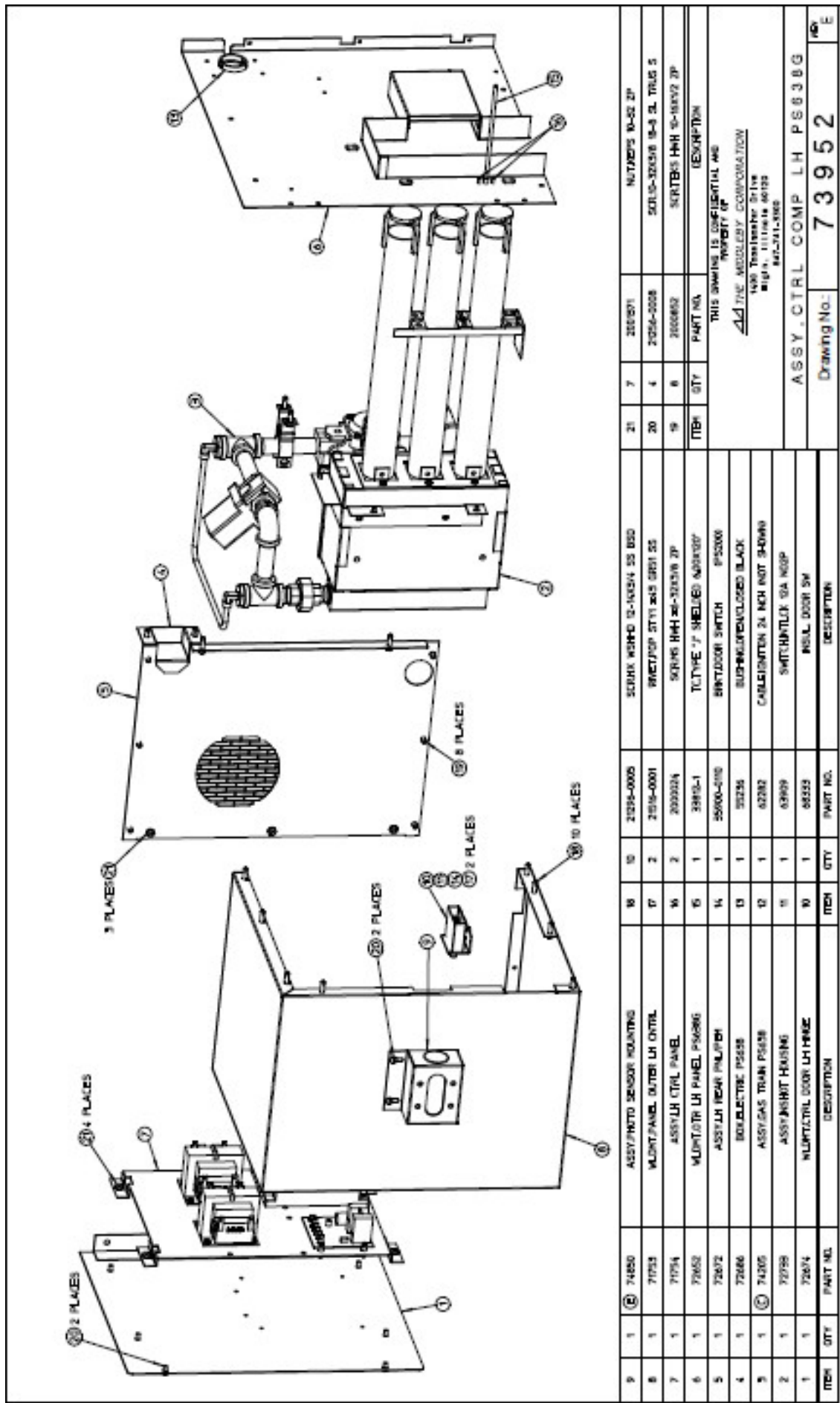
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| 11       | 1    | 74106       | MOTOR, GEAR 1:200 23W    | 22       | 2    | 2000832     | SCR. IREX HWH 10-16X1/2 ZP     |
| 10       | 1    | 71749       | COVER, CONV CHAIN PS638  | 21       | 2    | 21516-001   | RIVET, POP STYI #43 GR51 SS    |
| 9        | 1    | 61161       | COVER, PHOTOEYE          | 20       | 4    | 21426-002   | WASHER, LOCK, SS 1/4           |
| 8        | 1    | 68333       | INSUL, DOOR SW           | 19       | 7    | 21256-008   | SCR. 10-32X3/8 18-8 SL TRUS S  |
| 7        | 1    | 63909       | SWITCH, INTICK 12A NO2P  | 18       | 1    | 35900-0110  | BRKT, DOOR SWITCH (PS200)      |
| 6        | 1    | 77764       | BEZEL, MUII              | 17       | 10   | 21296-0005  | SCR. HX WSHHD 12-14X3/4 SS BSD |
| 5        | 1    | 77898       | ASSY, OUTER PLATE RH/FEM | 16       | 6    | 2001371     | NUT, KEPS 10-32 ZP             |
| 4        | 1    | 78760       | ASSY, CTRL REAR BOX      | 15       | 4    | 55466       | SCR. HEX HEAD 1/4-20X 3/4 SS   |
| 3        | 1    | 77779       | WID, M, CTRL DOOR RH     | 14       | 1    | 65818       | ADAPTER, MOTOR SHAFT           |
| 2        | 1    | 77870       | ASSY, COMP MITG PLT      | 13       | 1    | 72486       | BOX, ELECTRIC PS638            |
| 1        | 1    | 78770       | ASSY, CTRL BOX/ONE TOUCH | 12       | 1    | 55236       | BUSHING, OPEN/CLOSED BLACK     |

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 10000 W. WISCONSIN AVE  
 MILWAUKEE, WI 53226-1600  
 847.741.5000

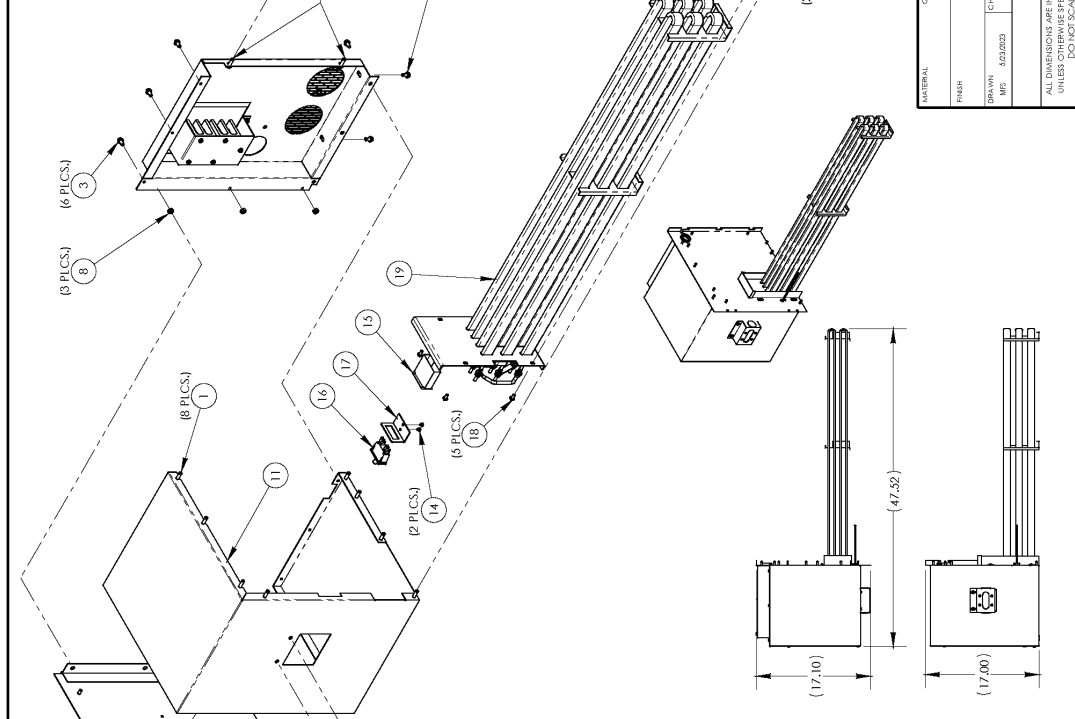
GAUGE: 1/16" (20)  
 CHECKED: JAC  
 DATE: 7/10/2023  
 APPROVED:

MATERIAL: FINISH: DRAWN: JC 1/9/2023  
 TITLE: ASSY, CTRL COMP RH  
 PART NO: 77758  
 SHEET: 1 OF 1  
 REV: B



| ITEM                                         | QTY | PART NO.  | DESCRIPTION               | ITEM | QTY | PART NO.  | DESCRIPTION                   |
|----------------------------------------------|-----|-----------|---------------------------|------|-----|-----------|-------------------------------|
| 9                                            | 1   | 74850     | ASST/INTD SENSOR MOUNTING | 18   | 10  | 2025-0005 | SCRNK WING 12-1/2X14 SS BDD   |
| 8                                            | 1   | 71753     | MOUNT/PANEL OUTER LH CTRL | 17   | 2   | 2159-0001 | BRCT/POP STY1 2X15 SSB1 SS    |
| 7                                            | 1   | 71754     | ASST/LH CTRL PANEL        | 16   | 2   | 2000024   | SCRNS HH 26-20X18 ZP          |
| 6                                            | 1   | 72652     | MOUNT/OTR LH PANEL P56286 | 15   | 1   | 3810-1    | T/LTYPE "J" SHELBG A000107    |
| 5                                            | 1   | 72672     | ASST/LH REAR PAL/PTH      | 14   | 1   | 25000-010 | BRKT/DOOR SWITCH P52000       |
| 4                                            | 1   | 72666     | SOLELECTR P5628           | 13   | 1   | 50226     | SUB-INFLUENCEDS BLACK         |
| 3                                            | 1   | 74205     | ASST/GAS TRAM P5628       | 12   | 1   | 62282     | CABLE/TWIST 24 NCR NUT 3-40W8 |
| 2                                            | 1   | 72758     | ASST/MSMT HAUSNG          | 11   | 1   | 62909     | SWT/INTLCK 25A NOSP           |
| 1                                            | 1   | 72674     | MOUNT/CTRL DOOR LH HINGE  | 10   | 1   | 68333     | MSL DOOR SW                   |
| ITEM                                         | QTY | PART NO.  | DESCRIPTION               | ITEM | QTY | PART NO.  | DESCRIPTION                   |
| 21                                           | 7   | 202871    |                           | 20   | 4   | 2026-0028 | SCRUS-20X18 9-8 SL TRUS S     |
| 20                                           | 4   | 2026-0028 |                           | 19   | 6   | 2000852   | SCRTRBS HH 9-18X12 ZP         |
| 19                                           | 6   | 2000852   |                           | ITEM | QTY | PART NO.  | DESCRIPTION                   |
| THIS DRAWING IS CONFIDENTIAL AND PROPERTY OF |     |           |                           |      |     |           |                               |
| ADD THE MODEL/IDY COMPARATION                |     |           |                           |      |     |           |                               |
| 1490 Transducer Drive                        |     |           |                           |      |     |           |                               |
| High, Illinois 60138                         |     |           |                           |      |     |           |                               |
| 847-241-5000                                 |     |           |                           |      |     |           |                               |
| ASSY. CTRL COMP LH P5638G                    |     |           |                           |      |     |           |                               |
| Drawing No.:                                 |     |           |                           |      |     | 73952     |                               |
|                                              |     |           |                           |      |     | E         |                               |

| REVISIONS |            |                   |     |
|-----------|------------|-------------------|-----|
| REV.      | REV. DATE  | BY                | CHK |
| A1        | 06/25/2023 | IC2090            | IC  |
|           |            | INITIAL PROTOTYPE |     |



| ITEM NO. | QTY. | PART NUMBER | DESCRIPTION                    |
|----------|------|-------------|--------------------------------|
| 19       | 1    | 74124       | ELEMENT HTG 208V 2TRW          |
| 18       | 5    | 44661       | SCR.REG HWH B-32X3/8 NP        |
| 17       | 1    | 35900-0110  | BRKT.DOR SWICH (F5200)         |
| 16       | 1    | 63909       | SWICH.INTLCK 12A NO2P          |
| 15       | 1    | 68333       | INSUL.DOR SW                   |
| 14       | 2    | 21516-0001  | RIVEL.POP STY1 #43 GR31 SS     |
| 13       | 1    | 33812-1     | TC.TYPE "J" SHIELDED 6.00X120" |
| 12       | 2    | 2000024     | SCR.MS HWH #6-32X3/8 ZP        |
| 11       | 1    | 71753       | WID.MT.PANEL OUTER LH CNTRL    |
| 10       | 1    | 53256       | BUSHING-OPEN/CLOSED BLACK      |
| 9        | 1    | 78202       | ASSY CTRL COMP 208-380 FS2638  |
| 8        | 3    | 2001371     | NUT KEFS 10-32 ZP              |
| 7        | 1    | 72674       | WID.MT CTRL DOR LH HINGE       |
| 6        | 4    | 21256-0008  | SCR.10-32X3/8 18-8 SI TRUS S   |
| 5        | 1    | 76889       | ASSY.PHOTO SENSOR MOUNTING     |
| 4        | 1    | 73638       | WID.MT P1 CTR LH               |
| 3        | 8    | 2000852     | SCR.1EKS HWH 10-16X1/2 ZP      |
| 2        | 1    | 73652       | ASSY CTRL BACK LH              |
| 1        | 12   | 21296-0005  | SCR.HX WSHHD 12-14X3/4 SS BSD  |

| MATERIAL |      | FINISH   |      | GUAGE    |      | TOLERANCES UNLESS SPECIFIED |      | THE DRAWING IS CONFIDENTIAL AND NOT TO BE REPRODUCED WITHOUT THE WRITTEN PERMISSION OF THE MIDDLEBY CORPORATION |      |
|----------|------|----------|------|----------|------|-----------------------------|------|-----------------------------------------------------------------------------------------------------------------|------|
|          |      |          |      |          |      |                             |      |                                                                                                                 |      |
| APPROVED | DATE | APPROVED | DATE | APPROVED | DATE | APPROVED                    | DATE | APPROVED                                                                                                        | DATE |
|          |      |          |      |          |      |                             |      |                                                                                                                 |      |

ASSY\_CTRL LH 208V  
PART NO 78851

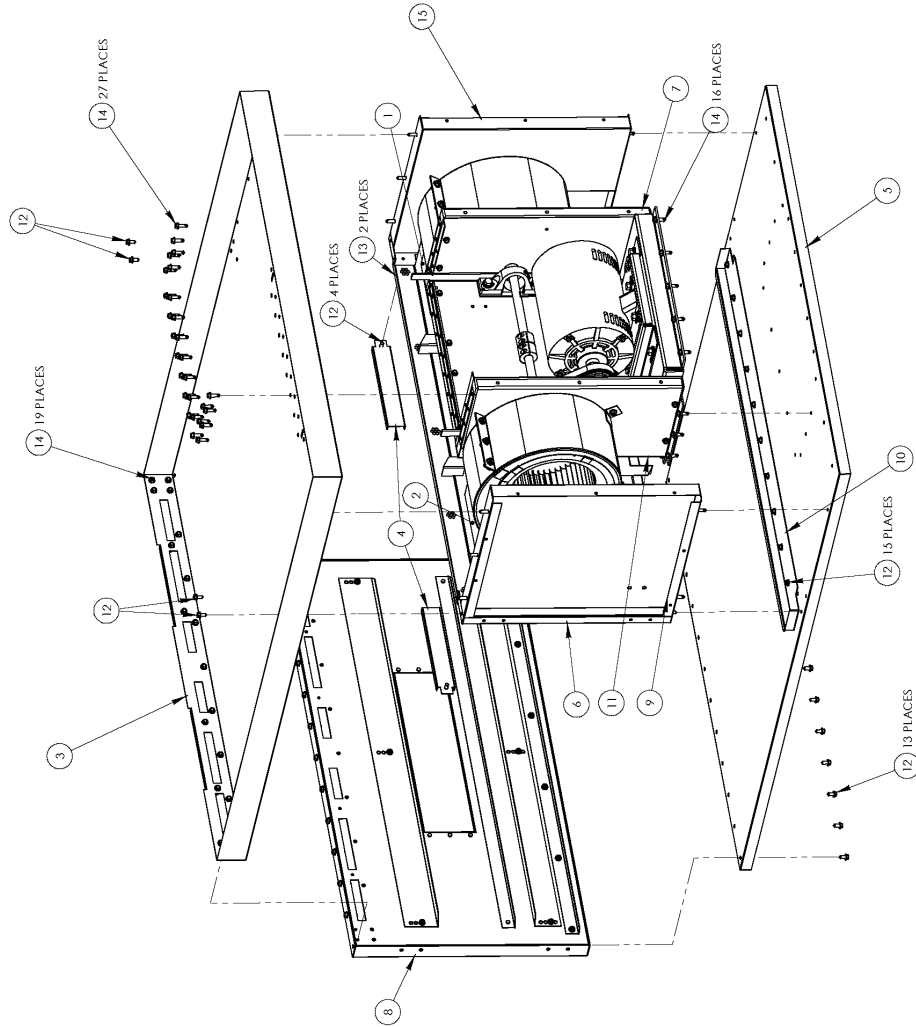
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. DO NOT SCALE DRAWING

REV 1 OF 1

SHF A1



| REVISIONS |            |        |                       |
|-----------|------------|--------|-----------------------|
| REV.      | REV. DATE  | ECN    | BY   CHK   CHG DATE   |
| A1        | 07/06/2023 | 022090 | MC   MC               |
| B         | 7/6/2023   | 022090 | MC   WSS   07/06/2023 |



| ITEM NO. | QTY. | PART NUMBER | DESCRIPTION                     |
|----------|------|-------------|---------------------------------|
| 15       | 1    | 72675       | PLATE, INNER IS, PS638          |
| 14       | 74   | 21296-0005  | SCR, HX W/SHD 12-14X3/4 SS BSD  |
| 13       | 2    | 73232       | SCREEN, PLENUM, PS638           |
| 12       | 36   | 50281       | SCR # 12X 1/2 SL HX W/HD TFS 7C |
| 11       | 1    | 73229       | DEFLECTOR, BURNER TUBE PS638    |
| 10       | 1    | 73195       | CHANNEL, DRIP PAN REAR          |
| 9        | 1    | 72667       | PLATE, INNER RS, PS638          |
| 8        | 1    | 73133       | ASSY, FRONT PANEL W/WND         |
| 7        | 1    | 79122       | ASSY, BURNER, MIG               |
| 6        | 1    | 73148       | WID, MT, PLENUM                 |
| 5        | 1    | 73196       | PANEL, OVEN BOTTOM, PS638       |
| 4        | 2    | 73875       | PLATE, PLENUM, SCREEN BLOCK     |
| 3        | 1    | 73100       | ROOF, PS638                     |
| 2        | 1    | 73101       | PLATE, HEAT REFLECTOR, PS638    |
| 1        | 1    | 73102       | PLATE, HEAT REFLECTOR, PS638    |

|                |  |                                                                                                                            |                   |
|----------------|--|----------------------------------------------------------------------------------------------------------------------------|-------------------|
| MATERIAL       |  | GUAGE                                                                                                                      |                   |
| FINISH         |  | TOLERANCES UNLESS SPECIFIED: ±.10"                                                                                         |                   |
| DRAWN: JG/2023 |  | CHECKED: JG/2023                                                                                                           | APPROVED: JG/2023 |
| DATE: 7/6/2023 |  | THE DRAWING IS CONFIDENTIAL AND NOT TO BE REPRODUCED OR COPIED WITHOUT THE WRITTEN PERMISSION OF THE MIDDLEBY CORPORATION. |                   |
| PART NO: 79123 |  | SHEET 1 OF 1                                                                                                               |                   |
| REV: B         |  | REV: B                                                                                                                     |                   |

## **WARNING**

**Improper installation, adjustment, alteration, service or maintenance can cause property damage, injury or death. Read the installation, operating and maintenance instructions thoroughly before installing or servicing this equipment.**

## **NOTICE**

ALL parts replacement and appliance servicing should be performed by Your Middleby Marshall Authorized Service Agent. Service that is performed by parties other than Your Middleby Marshall Authorized Service Agent may void your warranty.

## **NOTICE**

Using any parts other than genuine Middleby Marshall factory manufactured parts relieves the manufacturer of all warranty and liability.

## **NOTICE**

Middleby Marshall reserves the right to change specifications at any time.

# **CFESA**

**Commercial Food Equipment Service Association**

Middleby is proud to support the Commercial Food Equipment Service Association (CFESA). We recognize and applaud CFESA's ongoing efforts to improve the quality of technical service in the industry.

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