TRANSLATION OF THE ORIGINAL INSTRUCTIONS

USE AND WARNING INSTRUCTIONS

PIZZA OVEN
mod. HELIOS

Code: OM40.xxxxx

OEM ALI GROUP S.r.l a socio unico
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FOREWORD

The Manufacturer is by no means liable for the consequences of incorrect operations performed by the user.

EDITOR'S NOTE

This documentation is expressly addressed to technicians. Therefore, information that can be easily retrieved by reading these texts and analysing the drawings may not be explained further.
The Editor is by no means liable for any information and data provided in this manual: all information included herein has been supplied, controlled and approved by the Manufacturer during review.
The Editor shall by no means be held responsible for the consequences resulting from the user's misuse.

GENERAL REMARKS

All operating, maintenance instructions and recommendations described in this manual must be respected. To achieve the best results the Manufacturing Company recommends performing regular cleaning and maintenance operations so as to maintain the system in the best conditions.
The training of the personnel in charge of operating the machine is of the utmost importance, both as regards the use and maintenance of the machine and the monitoring of all operating procedures and of all safety standards in this manual.

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Chapter 1
IDENTIFICATION

1 IDENTIFICATION

1.1 Manufacturer identification

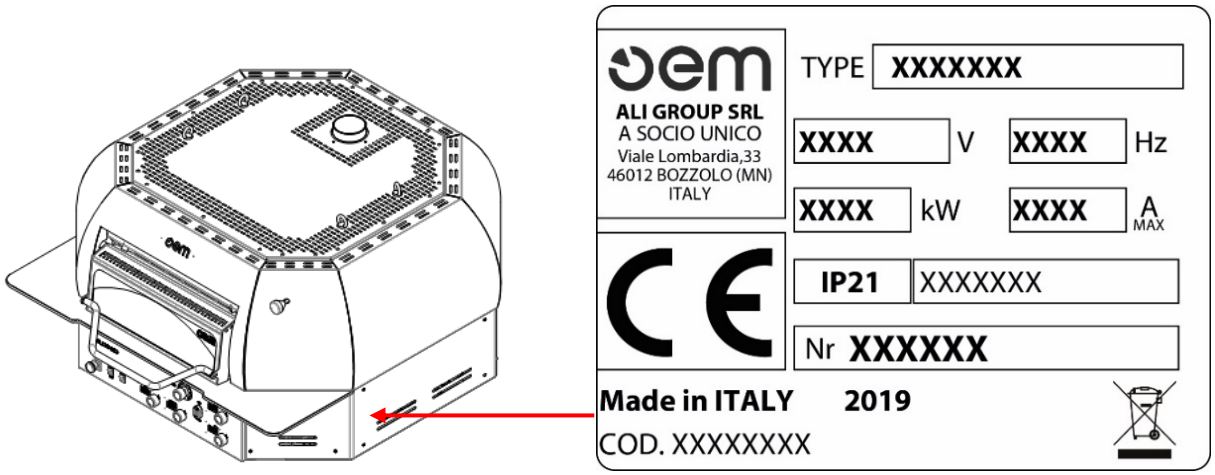
Manufacturer	**OEM ALI GROUP S.r.l. sole shareholder**
Address	**Viale Lombardia, 33** **Bozzolo (MN) - Italy** **Tel. +39 0376 910511 – Fax +39 0376 920754** **info@oemali.com - www.oemali.com**

1.2 Identification

Type	**PIZZA OVEN**
Model	**HELIOS**
Year of manufacture	**2022**

1.3 Identification label

The machine has an identification plate located on the side panel.
On the plate there are the details of the machine to be mentioned in case of need to the OEM ALI GROUP S.r.l a socio unico.



CAUTION!
It is STRICTLY PROHIBITED to remove the CE identification plate and/or replace it with other plates. Should the plate be damaged, detached or removed for accidental reasons, the customer must inform the Manufacturer.

1.4 EC Declaration of Conformity (Fac-simile)

DICHIARAZIONE UE DI CONFORMITA'

UE DECLARATION OF CONFORMITY - DECLARATION UE DE CONFORMITE –

UE KONFORMITÄTSERKLÄRUNG - DECLARACIÓN UE DE CONFORMIDAD'

OEM ALI Group S.r.l. a Socio Unico - Viale Lombardia, 33 46012
BOZZOLO (MN) Italia

Tel.: +39 0376 - 910511 - Fax: +39 0376 - 910545

Dichiara che il modello - It is hereby declared that model -Déclare que le modèle
Erklärt, daß die Maschine Modell - Declara que el modelo

HELIOS 530

Tipo - Type - Typologie - Typ - Tipo

FORNO ELETTRICO

Electric oven - Four électrique - Elektrischer öfen - Horno eléctrico

IT è conforme alle disposizioni legislative che traspongono le direttive e successivi emendamenti:

EN complies with the law provisions that transpose the directives and relevant amendments:

FR est conforme aux dispositions législatives qui transposent les directives et amendements successifs:

DE den gesetzlichen Richtlinienbestimmungen und nachfolgenden Änderungen:

ES es conforme a las disposiciones legislativas que transponen las directivas y sucesivas enmiendas:

2006/42/CE - 2014/35/UE - 2014/30/UE - 2011/65/UE

IT e inoltre dichiara che sono state applicate le seguenti norme armonizzate

EN it is also hereby declared that the following harmonized provisions have been applied

FR et en plus elle déclare que les normes suivantes ont été appliquées

DE sowie folgenden harmonisierten Normen:

ES y declara además que han sido aplicadas las siguientes normas armonizadas

IEC 60335-1 / IEC 60335-2-36 / EN 61000-3-2 / EN 61000-3-3 /

EN IEC 55014-1 / EN IEC 55014-2

1.5 Reference directives

The machine supplied by OEM ALI GROUP S.R.L A SOCIO UNICO does not belong to one of the categories of machines listed in the list covered in Annex IV of the Directive; therefore, for the purpose of the declaration of conformity of the machine to the present directive, OEM ALI GROUP S.R.L A SOCIO UNICO applies the procedure of compliance assessing with internal control on the manufacture of the machine, see attached VIII.
To certify the conformity of the machine with the provisions of the Directive, OEM ALI GROUP S.R.L A SOCIO UNICO before placing it on the market, has assessed the risks in order to verify compliance with the essential health and safety requirements provided by the Directive as well as the tests and checks provided by the applied standards of reference. The technical construction file was compiled in compliance with the contents of attachment VII of Directive 2006/42/EC and is available for inspection by the supervisory boards with reasoned request, as set forth by the legislative provisions in force.

OEM ALI GROUP S.R.L A SOCIO UNICO provides the introduction on the market of the machine by equipping it and accompanying it with:

EC Marking	
EC Declaration of Conformity	
Instructions and warnings manual	(Documentation drafted according to point 1.7.4 of Machinery Directive 2006/42/EC)

also note that the support has been designed in accordance with the following Directives:

2006/42/EC	Machinery Directive
2014/30/EU	Electromagnetic Compatibility Directive

And the following harmonised standards have been applied:

UNI EN ISO 12100:2010	Safety of machinery - General principles for design - Risk assessment and risk reduction
UNI EN ISO 13857:2008	Safety of machinery - Safety distances to prevent hazard zones being reached by upper and lower limbs.
UNI EN 349:2008	Safety of machinery - Minimum gaps to avoid crushing of parts of the human body.
UNI EN ISO 13849-1:2016	Safety of machinery - Safety-related parts of control systems - Part 1: General principles for design
UNI EN 1005-4 :2009	Safety of machinery - Human physical performance - Part 4: evaluation of working postures and movements in relation to machinery.
IEC EN 62061:2005	Safety of machinery – Functional safety of safety-related electrical, electronic and programmable electronic control systems
IEC EN 60204-1:2006	Safety of machinery - Electrical equipment of machines – general rules
IEC EN 61496-1:2005	Safety of machinery - Electro-sensitive protective equipment - Part 1: General requirements and tests
UNI EN ISO 13850:2008	Safety of machinery - Emergency stop - Principles for design
	Safety of machinery - Guards - General requirements for the design and construction of fixed and movable guards

Chapter 2
PRELIMINARY INFORMATION

2 PRELIMINARY INFORMATION

2.1 Addressees

This manual is destined to operators in charge of dealing with the machine in all the phases of its technical life. It also contains the subjects regarding the proper use of the machine, in order to maintain the functional and qualitative features of the machine unaltered over time.
All information and warnings for proper safe use are also reported.
The manual, like the EC conformity certificate, is an integral part of the machine and must always accompany it in every displacement or property transfer.
The user must keep this documentation intact and make it available for consultation during the entire lifespan of the machine.

2.2 Supply and preservation

The manual is supplied in printed and electronic format. All additional documentation will be provided annexed to this manual. This manual can be downloaded in pdf format by connecting to the site: *www.oemali.com*.

Keep this manual with the machine so that it can be easily consulted by the operator.

The manual is an integral part for the purpose of safety, therefore:

- it must be kept intact (in all its parts). Should this manual get damaged or spoilt, request a copy immediately.
- it must accompany the machine until its demolition (even if moved, sold, leased, rented, etc.);
- the attached manuals are a part of this documentation and the same recommendations/prescriptions contained in this manual apply to them.

The Manufacturer shall not be held liable for machine misuse and/or damages resulting from operations not indicated on the technical documents.

2.3 Updates

Should the machine require functional modifications or replacements, the Manufacturer is responsible for revising or updating the manual. The Manufacturer is responsible for delivering the manual update.
The user is also responsible for ensuring that, should this document be modified by the Manufacturer, only the updated manual versions are effectively present in the points of use.

2.4 Language

The original manual has been drafted in Italian.
Any translations into other languages must be done from the original instructions.
The Manufacturer shall be responsible for the information contained in the original instructions; translations into different languages cannot be fully verified, hence should an inconsistency be detected, the text in the original language must be referred to or contact our Technical Documentation Department.

2.5 Operators

Refer to the following table to establish with certainty what skills and qualifications are required of the operators in charge of the various duties (starting up, cleaning, routine maintenance):

QUALIFICATION	DEFINITION
Operator	This is the user's trained staff authorised to use the machine for production purposes, for the activities it was built and supplied for. He/She must be capable of performing all of the procedures required for good machine operation and his/her personal safety and that of other workers. Have proven experience in the correct use of this type of machines and be trained, informed and instructed thereof. Must report any anomaly to his superior in case of doubt. Note: is not authorised to perform any maintenance activity.
Maintenance engineer Mechanical	Qualified maintenance engineer able to carry out preventive/corrective maintenance activities on all the mechanical parts of the machines subject to maintenance or repairs. Qualified engineer who can access all the parts of the machine for a visual analysis, inspect the equipment status, carry out adjustments and calibrations. Qualified technician able to: • use the machine as an operator; • intervene on the mechanical elements for adjustments, maintenance and repairs; • read technical drawings and spare part-list (if present). In exceptional cases, he/she is trained to run the machine under reduced safety conditions. Where necessary, it can provide the operator with instructions for the proper use of the machine for production purposes. Note: he/she is not authorised to work on live electrical systems (if installed).
Maintenance engineer Electrical	Qualified maintenance engineer able to carry out preventive/corrective maintenance activities on all the electrical parts of the machines subject to maintenance or repairs. Qualified engineer who can access all the parts of the machine for a visual analysis, inspect the equipment status, carry out adjustments and calibrations. Qualified technician able to: • use the machine as an operator; • working on the adjustments and on the electrical systems for maintenance purposes, repairs and replacing worn parts; • reading wiring diagrams and checking the proper functional cycle. Where necessary, it can provide the operator with instructions for the proper use of the machine for production purposes. The assembly technician can work while the electrical circuits in the electrical panel, junction boxes, control appliances, etc. are live only if the technician is suitably qualified (PEI). (See standard EN50110-1).
Manufacturer's Technician	Technician qualified by the Manufacturer and/or by its distributor for complex operations, as aware of the constructive production cycle of the machine. This person intervenes in agreement with the user requests. The competences are of mechanical type.

The qualifications stated in the table on this page, compulsorily fall within a category of people defined "trained person".

TYPE	DEFINITION
Trained Person	Person informed, educated and trained on the work and on any dangers deriving from an improper use. Also knows the importance of the safety devices, the accident-prevention standards and the safe work conditions.

2.6 Symbols used in the manual

SYMBOL	DEFINITION
	Symbol used to identify important warnings for the safety of the operator and/or machine.
	Symbol used to identify particularly important information inside the manual. The information also regards the safety of personnel involved in use of the machine.

2.7 Glossary

Technical terminology or different meaning from the ordinary used in the manuals.
Below is an explanation of the terms and abbreviations used:

TERM	DEFINITION
Lifting accessories	Components or equipment not connected to the machines which allow the load to be picked up when placed between the machine and the load or on the load itself. Harnesses and their components are also considered lifting accessories.
ATEX	It comes from the words ATmosphères and EXplosibles and is the conventional name that groups two European Union (EU) Directives: • 2014/34/EU to regulate equipment and protective systems intended for use in potentially explosive atmospheres; • 99/92/CE for the health and safety of workers in explosive atmospheres or environments with risk of explosion.
Failure	Fault of various kinds that prevents normal operation of a machine, a plant, etc…
Chains, ropes or belts	Elements designed and built for lifting as integral part of machines for lifting or lifting accessories.
Damage	Any negative consequence deriving from the occurrence of the dangerous event.
P.P.E.	The term "Personal Protective Equipment" (acronym PPE) refers to items designed to safeguard the worker (operator, maintenance engineer, etc.) wearing them or however carrying them, from health and safety risks.
Breakdown	Element fully unable to perform a required function.

TERM	DEFINITION
Support	Assembly, fitted with or intended to be fitted with a drive system, consisting of linked parts or components, at least one of which moves, and which are joined together for a specific application.
Malfunction	Defective or improper operation of a machine or element when performing a specific function.
Protective measure	Measure required to achieve risk reduction, implemented: • by the designer (intrinsically safe project, guards and additional protective measures, information for use) and/or • by the user (organisation: safe operation procedures, surveillance, work permits, availability and use of additional protective equipment, use of personal protective equipment, training).
Hazard	Potential source of damage that, if not avoided, poses a risk to the safety and health of exposed persons.
Exposed person	Any person fully or in part inside a dangerous area.
Prevention	The set of provisions or measures required also according to the specific work, the experience and the technique, to avoid risks or reduce the probability of occurrence.
Protection	Defence against what may cause damage. Element placed between those who may suffer damage and what may cause it for hazards that cannot reasonably be eliminated or for risks that cannot be sufficiently reduced during design. The following are distinguished: • the active protection that the operators themselves must activate (e.g. emergency stops) and/or wear (PPE); • the passive protection that triggers even without human command.
Guard	Physical barrier, designed as part of the machine, to provide protection.
Fixed guard	Protection held in place (i.e. closed) or permanently (welded) or by means of fixing elements (screws, bolts, etc.) that do not allow removing/ opening without the aid of tools (wrenches, screwdrivers or Allen screws). Easily removable fixing systems are not permitted (e.g. plastic knobs).
Mobile guards	Guard mechanically connected to the machine structure (e.g. with hinges or guides) that can be opened without using tools.
Risk	Combination of the probability of occurrence of damage and the severity of that damage.
Residual risk	Risk remaining after taking protective and preventive measures.
Pallet truck	Mechanical device used to move loads inside warehouses, industrial environments or on external areas. The vehicle moves on rubber wheels or other, via electric or manual traction and is equipped with a pneumatic lifting system that allows only detachment of the load from the ground to allow it to move.
Intended use	Use of a machine in accordance with the information provided in the instructions for use.
Reasonably foreseeable misuse	Use of a machine in a way not intended by the designer, but which may derive from easily foreseeable human behaviour.

2.8 Personal protective equipment

When performing assembly, maintenance and/or adjustments near the machine, you must strictly comply with the general accident-prevention standards. Therefore, it is important to always use Personal Protective Equipment (P.P.E.) required for each individual operation.

Below is the full list of personal protective equipment (P.P.E.) that may be required for the different procedures:

SYMBOL	DESCRIPTION
	Obligation to use protective or insulating gloves. Indicates a requirement for personnel to wear protective or insulating gloves.
	Obligation to use protective goggles. Indicates a requirement for personnel to wear safety goggles.
	Obligation to use safety shoes. Indicates a requirement for personnel to use work-safety footwear to protect their feet.
	Obligation to use noise protection devices. Indicates a requirement for personnel to wear earmuffs or earplugs to protect hearing.
	Compulsory use of protective clothing. Indicates a requirement for personnel to wear the specific protective clothing.
	Obligation to consult the instructions manual/booklet. Indicates a requirement for personnel to consult (and understand) the instructions for use and warning of the support before working with it.

The clothing worn by individuals running the machine or performing maintenance must comply with the essential safety requisites defined by EU Reg. 2016/425 and the regulations in force in the country where it is installed.

2.9 User's areas of safety

The areas surrounding the machine are divided as follows:

TERM	DESCRIPTION
Control areas	These are the areas in which the user and other operators are able to perform, either in automatic or semi-automatic mode, the control and command operations of the machine's cyclical functions, by acting on the appropriate control panels or by execution of manual operations.
Maintenance areas / setting	These are the areas in which the mechanical maintenance engineers are able to perform maintenance or adjustment operations. These areas are considered at risk and are not accessible during the normal operation of the support. The operators must be perfectly aware of the safety warnings and of the personal protective equipment to be worn.
Dangerous areas	All spaces inside and/or around the machine where a person can be exposed to a hazard.

The dangers and risks that exist in these areas are protected, as far as possible, by guards (casings, hatches). However, when the machine is running,IT IS STRICTLY FORBIDDEN to operate within the dangerous areas as some risks may not have been completely removed.

2.10 Warranty

Warranty clauses are reported on the sales agreement.

The conditions of the commercial contract (if different) have priority over that stated in this section.

The warranty is subject to the following general conditions:

- opening of packs and installation must be carried out in the presence of the Manufacturer's authorised technicians;
- the first start-up and positive test of the machine must be carried out under the supervision of the Manufacturer's technicians; the sheet of intervention relating to the support installation and testing must be drawn up.
- the machine must be used within the limits specified in the contract and indicated in the technical documentation.
- maintenance must be carried out in the time and manner provided by the manual, using OEM ALI GROUP S.R.L A SOCIO UNICO original spare parts and entrusting the interventions to qualified personnel.

The warranty becomes void in the event of:

- failure to comply with the safety standards;
- removal or tampering with the control and safety devices (guards);
- changes to safety conditions set by the Manufacturer in the machine software management;
- improper use of the machine;
- use of the machine by untrained and/or unauthorised personnel, or non-compliance with the operators' skills, as specified in the manual;
- changes or repairs made by the user without the Manufacturer's written authorisation;
- non-compliance, partial or total, with the instructions;
- energy power supply failures (electric, compressed air, etc.);
- lack in maintenance;
- use of non-original spare parts;
- extraordinary events like floods, fires (unless caused by the machines).

Further details may be found in the commercial contract.
The conditions of the commercial contract (if different) have priority over that stated in this section.

Chapter 3
SAFETY DEVICES

3 SAFETIES

3.1 General Warnings

The user (entrepreneur or employer) must:

- carefully read this manual and gain a deep understanding of the technical specifications and controls before putting into operation the machine;
- train the operator on the use of the machine;
- check that the installation area of the device is compatible with the size and weight of the machine;
- use lifting equipment appropriate to the weight and characteristics of the piece to be lifted/moved;
- prevent the use of the machine to unauthorised personnel;
- prevent the removal of panels that protect mechanical and electrical parts during the operation of the machine;
- ensure that the purchaser's power system is equipped with an automatic release system upstream of the general machine switch and a suitable earthing system that meets accident prevention rules;
- de-energise the line where the general switch is fastened in case of interventions on it;
- maintenance protection removal operations must be carried out ONLY by specialised and authorised personnel;
- make sure that the safety devices (barriers, guards, casings, micro-switches, etc.) have not been tampered with and are working perfectly. On the contrary, they should be set-up;
- avoid removing safety devices;
- use only suitable equipment that complies with safety regulations;
- avoid tampering with the electrical, pneumatic system, or other mechanisms;
- do not leave the device unattended;
- wear clothing that complies with safety regulations;
- use ladders or lifting equipment that comply with safety standards in case of interventions on positions not directly reachable from the ground;
- ensure that there are no parts that can come into operation and/or details placed on the machine in case of maintenance;
- use appropriate PPE and tools;
- do not remove warning tags;
- prevent maintenance when the machine is ON;
- ONLY authorised personnel can perform maintenance operations;
- prevent children from playing or performing cleaning and/or maintenance on the machine;
- use the machine ONLY as described in the paragraph "CORRECT USE";
- avoid making hasty or makeshift repairs that could compromise the smooth running of the machine and the safety of the operator.

DANGER!
It is forbidden to tilt or overturn the ovens in the event of displacements or movements.

CAUTION!
Before cleaning and/or maintaining, make sure that the general switch is set to "0" - "OFF" to remove the power supply.

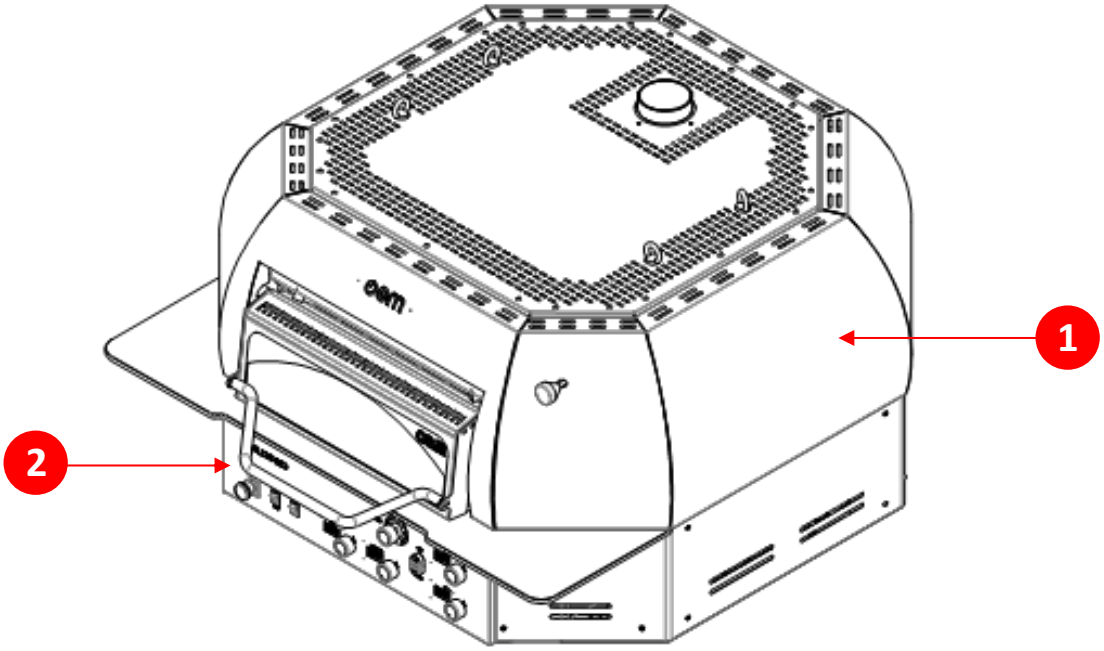
CAUTION!
When removing the plug, the operator must be able to check that the plug is indeed disconnected from any spot he/she has access to.

IMPORTANT!
Incorrect use of the machine excludes any liability by the Manufacturer.

3.2 Safety devices

The machine is provided with the safety devices described in the following table. For the position of such devices, refer to the drawing below the table.

POS.	TERM	DESCRIPTION
1	Fixed protections	The fixed protections consist of fixed perimeter guards, which are responsible for preventing access into the machine and its units through areas other than the main openings. The machine has fixed protections, placed in areas with exclusive access during maintenance and requiring specific tools for their removal.
2	Safety thermostat	Located inside the baking chamber, turns off the oven in case of over-temperature.



3.3 Noise

Noise levels have been measured in accordance with the requirements of UNI EN 11200 and UNI EN ISO 3746 standards.
During the operating cycles, the levels of exposure to noise for appointed personnel do not exceed 80 dB.

The actual noise levels of the installed machine, during operation on site in a manufacturing process differ from those detected, as the noise is influenced by factors such as:

- type and features of the site;
- other adjacent machines in operation.

It is the user's responsibility to apply the consequent preventive and protective measures, in compliance with the law of the country of installation and use of the machine.

3.4 Vibrations

The vibrations produced by the machine, depending on its method of operation, do not pose a risk to the health of the operators.

CAUTION!
An excessive vibration can only be caused by a mechanical fault that must be immediately reported and eliminated, to prevent jeopardising the safety of the machine and its operators.

3.5 Electromagnetic compatibility

The supplied machine contains electronic components subject to the Electromagnetic Compatibility Standards, affected by conducted and radiated emissions.
The values of the emissions respect the legislative requirements thanks to the use of Electromagnetic Compatibility standard components, suitable connections and the installation of filters, where required.
Therefore, the machine complies with the Electromagnetic Compatibility Standard (EMC).

CAUTION!
Any non-conforming maintenance carried out on the electric equipment or incorrect replacement of components, can jeopardise the effectiveness of the adopted solutions.

3.6 Residual risks

The machine was designed to guarantee the essential safety requirements for the operator.
Safety has been incorporated, as much as possible, into the design and construction of the machine; however, there are risks from which the operators must be protected, especially during:

- transport and installation;
- normal operation;
- adjustments and fine tuning,
- maintenance and cleaning;
- disassembly and dismantling.

Below, for each residual risk, there is a description of the area or part of the machine concerned by the risk (unless the entire support is concerned) and the procedural information on how to avoid it:

RISK	DESCRIPTION AND PROCEDURAL INFORMATION
Electrical hazard	Contact of people with live elements. Carry out cleaning/maintenance always with the machine off Only the PES/PAV electric maintenance engineer with the suitability for work under voltage under CEI 11-27, can perform extraordinary maintenance with suitable PPE.
Thermal hazard	Contact of people with elements that can cause burns, caused by contact with objects or materials with an extreme temperature
Dangers generated by materials and substances processed, used, produced or discharged from the machine	Fire or explosion hazard (due to materials, dusts, liquids, substances and gases, used or produced).
Dangers generated by materials and substances processed, used, produced or discharged from the machine	Biological (mould) and microbiological (virus or bacterial) hazards.

CAUTION!
Do not attempt to perform maintenance and cleaning without having first de-energised the system.

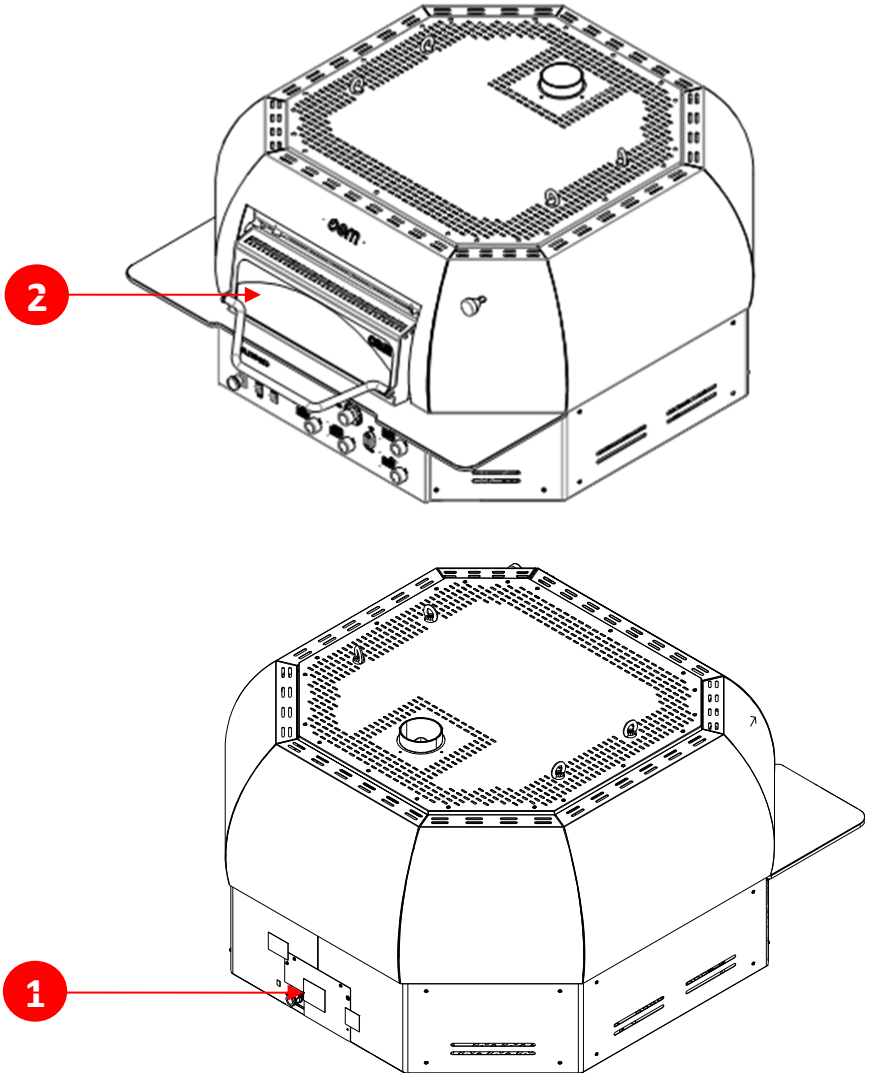
It is the responsibility of the user to:

- analyse the risks that could occur during handling and installation on site (the analyses performed on machine handling were only carried out in view of the machine characteristics);
- mark out the path of forklift trucks and/or laser guided vehicles with floor signs;
- sensitise and train personnel in charge of operations at the workstations and personnel in charge of running the machine;
- display visual safety signage in the work place once the risks inside the transit or control areas have been assessed.

3.7 Applied safety pictograms

Safety stickers and plates are applied on the machine, as shown in the table below. Refer to the picture below for positioning.

POS.	PICTOGRAM	DESCRIPTION
1		Electrical hazard!
2		High temperatures hazard



Chapter 4
DESCRIPTION

4 DESCRIPTION

4.1 Intended use (correct)

The machine in question is intended to be used for:

OPERATION	ADMITTED	NOT ADMITTED	WORK ENVIRONMENT
Baking of:	pizza focaccia bread bruschette	Any other use different from the one permitted.	Restaurant

The machine was designed to:

- satisfy the specific demands mentioned on the sales agreement;
- be used according to instructions and limitations for use set out herein.

The machine is designed and built to work safely if:

- it is used within the limits stated in the contract and in this manual;
- the usage manual procedures are followed;
- ordinary maintenance operations are performed as indicated;
- extraordinary maintenance is performed promptly, in case of need;
- safety devices are not removed and/or modified.

4.2 Reasonably foreseeable misuse

Reasonably foreseeable misuse is listed below:

- use the machine as a foothold for unsuitable components;
- use the machine to achieve greater production values than the prescribed limits;
- use the machine differently than provided in the “Intended Use (correct)” paragraph.

Any other use of the machine shall be previously authorised in writing by the Manufacturer. Without this written authorisation, the use must be considered “improper use”; therefore, the Manufacturer declines any liability for eventual damage to persons or property and deems any kind of warranty on the support void.

IMPORTANT!
Incorrect use of the machine excludes any liability by the Manufacturer.

4.3 Obligations and prohibitions

4.3.1 User obligations

The user (entrepreneur or employer) must:

- consider the abilities and conditions of the operators in relation to their health and safety;
- provide personal protective equipment appropriate to the individual procedures;
- provide approved lifting procedures and means;
- request compliance by the single workers to the company provisions and standards with regard to safety and use of the collective and personal protective equipment provided to them;
- train personnel on procedures in case of accident;
- train personnel on the residual risks present;
- train personnel on the safety devices provided for the operators;
- train personnel on the general accident-prevention rules provided by the European Directives and laws in the country of destination of the support.

Only let personnel who have read this manual and are appropriately trained to work on the machine.

4.3.2 Obligations of the personnel in charge (operators/maintenance engineers/technicians)

Personnel must:

- Carry out maintenance operations with the machine switched-off.
- Perform interventions on all components of the electrical system always with the general switch off.
- When starting the machine, make sure that there is no foreign object inside it.
- Appropriately use the protective devices provided by the employer.
- Immediately inform the employer, the manager or the person in charge, of deficiencies of the safety devices.

4.3.3 Prohibitions of the personnel in charge (operators/maintenance engineers/technicians)

In particular, personnel must not:

- use the machine improperly, that is for different uses to those indicated in paragraph “Intended Use”;
- remove or modify the safety or signalling devices without authorisation;
- carry out, upon their own initiative, operations or manoeuvres they are not in charge of or that can jeopardise their own safety and that of other workers;
- change the operation of the machine;
- modify the electric connections to exclude the internal safety devices;
- use the support if not installed according to the applicable regulations;
- use the support outside the admitted environmental conditions (consult “chapter 5”).

CAUTION!

OEM ALI GROUP S.R.L A SOCIO UNICO does not respond for damages caused by things or people when:

- the machine has been used in one of the non-permitted environments;
- the obligations and prohibitions described herein have not been complied with.

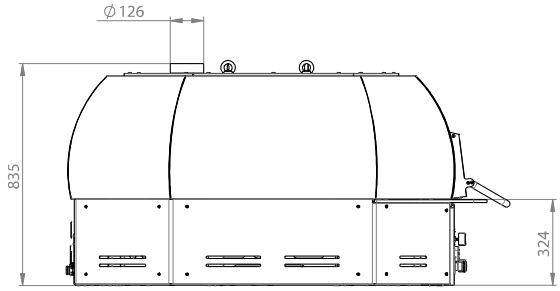
4.4 Technical data

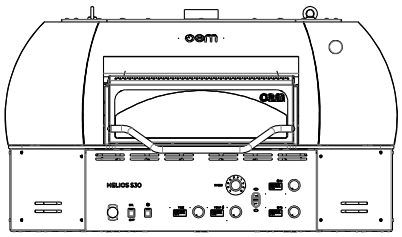
GENERAL DATA	
MODELS	HELIOS
Max temperature	530°C
n° pizzas/h Ø 33/35	60
n° pizzas/h Ø 45	24
Baking tray rotations	0-10 rpm
Baking tray dimensions	Ø 1040 mm
Door dimensions	109 mm x 650 mm
Weight	410 kg
Support weight with cell	140 kg
Support weight	65 kg
Relative humidity	10 – 80%
Cable section	5 x 4 mm^2

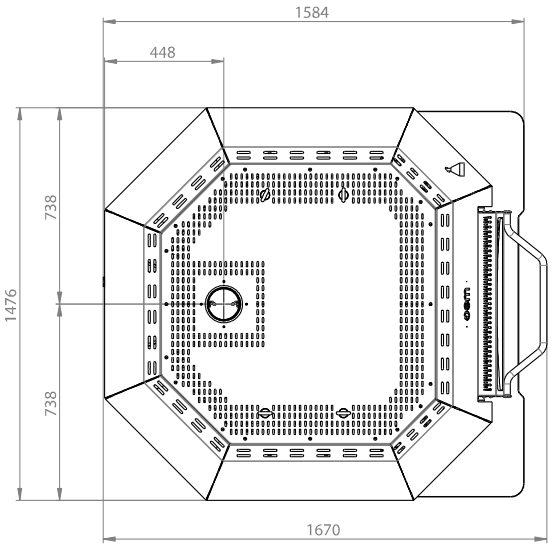
ELECTRICAL POWER SUPPLY DATA	
MODELS	HELIOS
Voltage	400 V (3~+ N + T)
Frequency	50 Hz
Absorption	28.5 A
Average consumption	10 KW/h
Higher max power	10,8 kW
Lower max power	7,5 kW
Total power	18,5 kW

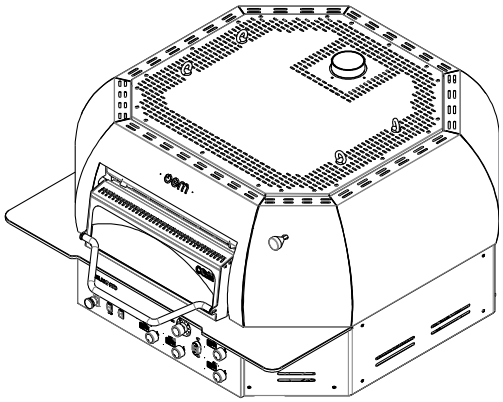
IMPORTANT!
Average consumption is calculated with the oven at 330° C and resistances at 80% upper and 20% lower.

4.5 Layout measures





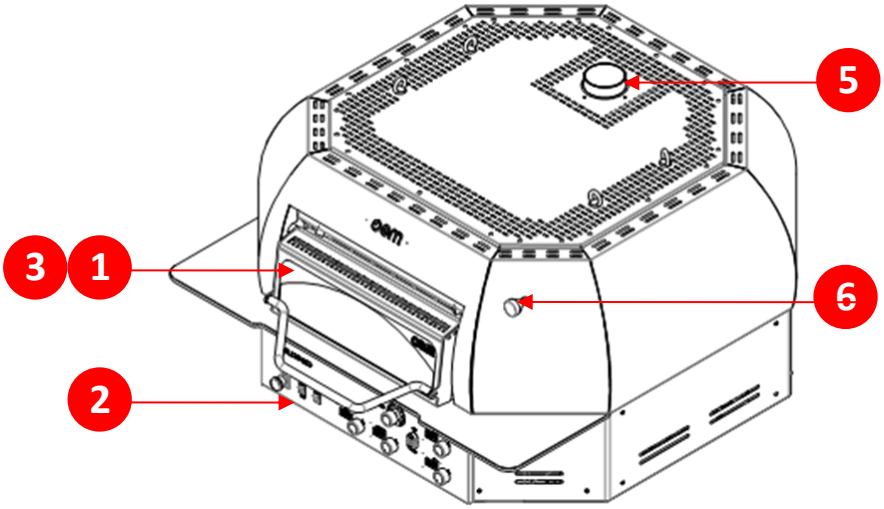


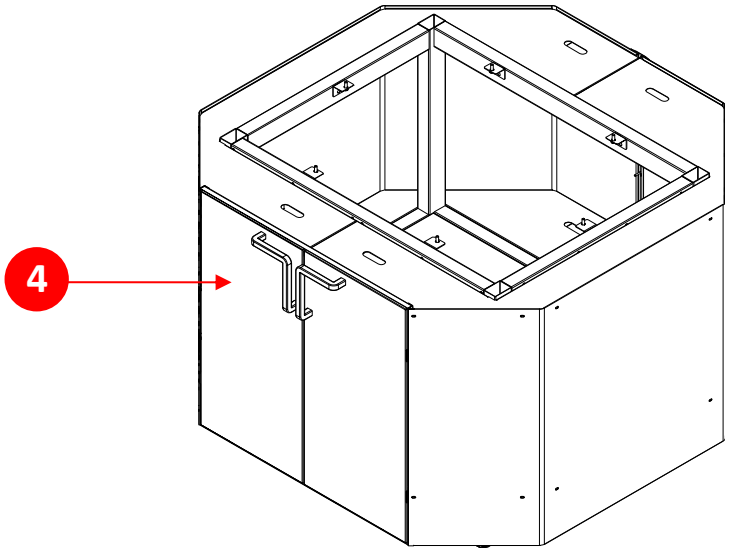


4.6 Main components

The oven is made of the following key parts:

POS.	DESCRIPTION
1	Baking chamber
2	Control panel
3	Door
4	Support (if present)
5	Chimney
6	Chimney opening knob





4.7 General description

The machine is a professional oven used for baking pizzas, focaccia bread, bruschette continuously.
The baking can be done using special pans, baking trays, or circular supports in aluminium or stainless-steel metal mesh.

The oven is designed to be placed on the top of a special support.

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Chapter 5
TRANSPORT AND INSTALLATION

5 TRANSPORT AND INSTALLATION

5.1 Introduction

IMPORTANT!
Lifting and handling must only be done by specialised and trained personnel, who are qualified to perform these activities.

During installation, OEM ALI GROUP S.R.L A SOCIO UNICO technicians must be supported by operators prepared for future maintenance and use of the machine.
The machine has been designed so that during the packaging, transport and assembly stages, a forklift truck or crane / hoist is required.

5.2 Packaging

The machine is shipped by OEM ALI GROUP S.R.L A SOCIO UNICO from the factory to the customer.

Depending on the transport distance, on the specific Customer requests and on the amount of the load will remain in the packaging, the machine is shipped as follows:

- **normal protective packaging for short and medium distances;**
- **special protective packaging for long distances.**

Shipment must be made using covered or sheeted transport means depending on the type of load.

Upon receipt of the machine, the customer must verify that there are no damages caused by the method of transport
or by the personnel in charge of the specific operations.

- **If damages are ascertained, leave the packaging in question as found and immediately request assessment of the damage by the competent shipping company, and then with a surveyor's report, inform the competent transport insurance company and the seller.**
- **If the support is delivered in a crate on wooden pallet or brackets with heat-shrink cellophane protection, first remove the packaging or any covering. Remove the screws and metal strapping to free the machine completely. Subsequently lift the machine using a forklift truck as described in the relative table and remove the pallet used for transport.**

5.2.1 Packaging removal

Proceed as follows to remove the packaging:

STEP	ACTION
1	Place the machine in its intended location.
2	Unpack the parts delivered on pallets, as follows: • remove the straps; • remove the carton; • remove the cellophane; • remove any fastening systems to the wooden platform.

IMPORTANT!
Follow the table in paragraph "Units division and weights table" to see in which and how many separate parts the machine will be transported.

For the machine handling, refer to the "Transport" paragraph.

5.2.2 Disposal of packaging

The packaging is integrating part of the supply and is not collected. This must be disposed of by the purchaser. The disposal or destruction must comply with the regulations in force in the user's country, bearing in mind the nature of the materials:

- wood for the crates;
- plastic film for the protection of the support and adhesive tape for their fastening;
- absorbing bags for the moisture.
- etc.

5.3 Transport and handling

The OEM ALI GROUP S.R.L A UNICO SOCIO, considering the ways of transport, uses appropriate packaging and fixtures to ensure integrity and storage during transport.

Upon receiving the machine, check that it has not been damaged during transport and/or handling.
Should any damage be found, it is mandatory to immediately report it to the Manufacturer.

The handling procedures described in this paragraph shall be carried out by staff trained for such operations: suitably trained personnel to safely perform loading, unloading and handling operations by means of lifting equipment and aware of accident-prevention rules.

CAUTION!
The OEM ALI GROUP S.R.L A SOCIO UNICO is not accountable for the damages, to property or to people, caused by accidents caused by non-compliance with the instructions in this manual.

5.3.1 Table of groups and weights

Follow the table below to see in which and how many separate parts the oven will be transported.

UNIT	WEIGHT	DIMENSION
HELIOS oven	410/435 kg	L = 175 mm D = 168 mm H = 1053 mm
Support	111/212 kg	L = 167 mm D = 146 mm H = 960 mm

5.3.2 Transport operations

CAUTION!
OEM ALI GROUP S.R.L A SOCIO UNICO takes no responsibility for any damage to the machine resulting from non-compliance with the instructions provided.

IMPORTANT!
The lifting personnel must be authorised and trained to use the lifting equipment and devices, and must comply with the applicable regulations for personal protection.

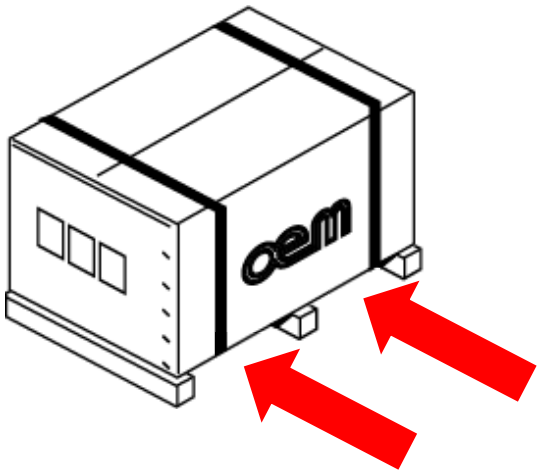
TRANSPORT WITH FORKLIFT TRUCK	
Operator qualification	Lifting equipment operator
Required PPE	
Lifting equipment	Forklift truck
Tools to be used	None

CAUTION!
Use only suitable and approved lifting means, compatible for the size and weight of the machine.

CAUTION!
Make sure nobody stops under and within the range of the lifting equipment.

To correctly perform transport with the forklift truck, follow the procedure below:

STEP	ACTION
1	Position the forks of the forklift truck under the machine's work surface.
2	Make sure that the forks come out from the rear of the load (at least 5 cm) to eliminate any risks of overturning of the transported part.
3	Lift the forks until they are touching the load. Note: if necessary, fix the load to the forks with clamps or similar devices.
4	Slowly lift the load by a few tens of centimetres and check it is stable, making sure that the load's centre of gravity is positioned in the centre of the lifting forks.
5	Tilt the upright backwards (towards the driver's seat) to facilitate the tilting moment and guarantee greater stability of the load during transport.
6	Adapt the transport speed according to the flooring and type of load, avoiding sudden manoeuvres.



TRANSPORT WITH CRANE / HOIST	
Operator qualification	Lifting equipment operator
Required PPE	
Lifting equipment	Crane / hoist
Tools to be used	Belts

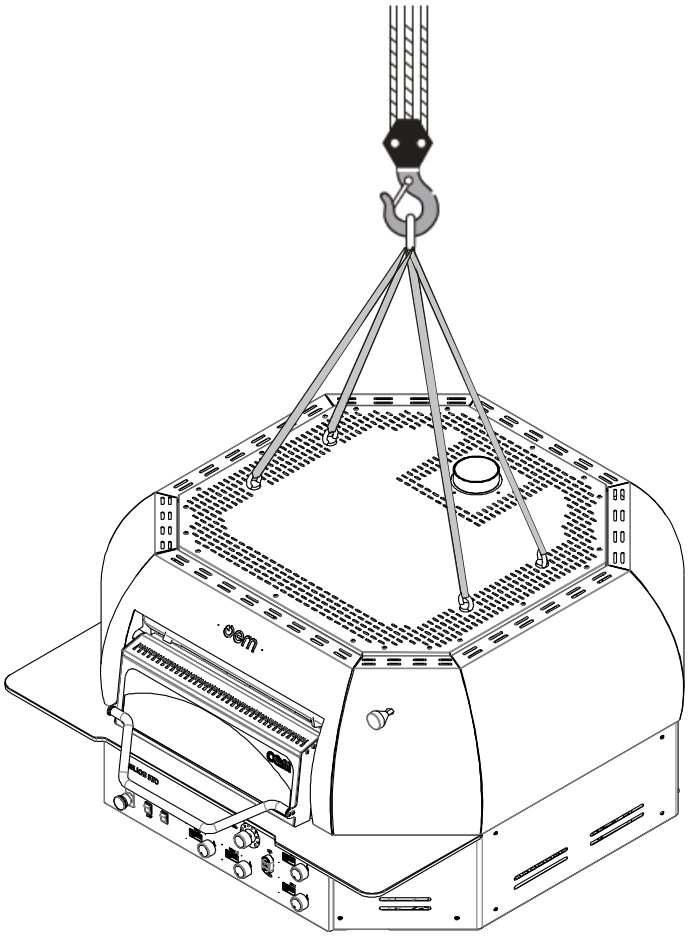
CAUTION!
Use only suitable and approved lifting means, compatible for the size and weight of the machine; do not use steel ropes to avoid damaging the body of the machine.

CAUTION!
Make sure nobody stops under and within the range of the lifting equipment.

CAUTION!
Make sure that the straps are positioned so as to have a uniform pull and in order to have a symmetrical lifting of the oven; on the contrary, the thread of the eyebolts could be damaged by the weight of the oven.

For a successfully transport by crane/hoist, follow the procedure below:

STEP	ACTION
1	Lift, slightly and alternately, the four corners of the machine and place space washers below it. Note: If necessary, use a forklift truck (see previous page).
2	Connect the lifting straps to the eyebolts tightened to the top of the machine.
3	Connect the straps to the hook of the lifting system (crane/hoist).
4	Lift the load slowly by some centimetres and check its stability, checking that it remains in a horizontal position.
5	Slowly lift, making sure that the load is not subject to oscillation or unbalance.



5.4 Installation

5.4.1 Arrangements to be made by the customer

The preparation of the following is normally borne by the Customer, except for different contractual agreements:

- premises (including building work, such as foundations or ducts if required, lighting.);
- electrical systems up to the machine power supply points, in compliance with the standards in force in the country of installation and/or required by its Manufacturer. All technical specifications requested by the manufacturer are contained in the contract of sale. The manufacturer declines any liability if the customer is unable to guarantee the technical features of the electrical system requested in the contract of sale.
- the power supply for the oven, including the earthing conductor, according to the characteristics and tolerances required and specified in this manual.
- tools and consumables required for assembly and installation;
- suitable lifting and handling equipment.

CAUTION!
The electrical power cables are charged to the customer and must be sized according to the maximum current absorbed.
Use a flexible cable under an oil-resistant sheath that should not be lighter than polychromelene or synthetic elastomer cables under equivalent sheath (designation 60245 IEC 57).

5.4.2 Permitted environmental conditions

The environment in which the machine is used is indoors, sheltered against weathering such as rain, hail, snow, fog, suspended dusts and combustible dusts. It must also be sheltered against aggressive agents such as corrosive vapours or sources of excessive heat and must not be classified an ATEX classified zone.
The use of the machine under conditions other than those listed is not allowed.
In particular, the installation and operating environment must not:

- Be exposed to corrosive fumes;
- Be exposed to excessive humidity (beyond 85%) and quick relative humidity changes (beyond 0.005 p.u./h);
- Be exposed to excessive dust;
- Be exposed to abrasive dust;
- Be exposed to oily vapours;
- Be exposed to explosive powders or gas mixtures;
- Be exposed to salty air;
- Be exposed to anomalous vibrations, collisions or blows;
- Be exposed to weather conditions beyond allowed limits or dripping;
- Be exposed to unusual transport or storage conditions;
- Be exposed to high or rapid thermal variations (beyond 5K/h);
- Presence of nuclear radiation.

The machine is designed and built to operate safely under the following environmental conditions:

Ambient temperature	15 – 35 °C
Maximum relative humidity	90 %
Installation site	Restaurant
Ambient lighting	Neon or LED light
Support tray	Any floor that can support its weight

CAUTION!
Environmental conditions different from those specified may cause severe damage to the machine.
Placing the machine in facilities that do not fulfil these requirements will cause the warranty to lapse for parts to be replaced.

IMPORTANT!
The work surface must be sufficiently lit.
If there are dark areas or differences in level on the workplace, the user must set adequate lighting devices.

The Manufacturer shall not be held liable for non-observance of the provisions specified.

5.4.3 Oven positioning

IMPORTANT!
Place the oven in a way to prevent food from being adversely affected by air currents, dust, leak-derived liquids or condensation, or aerosols.

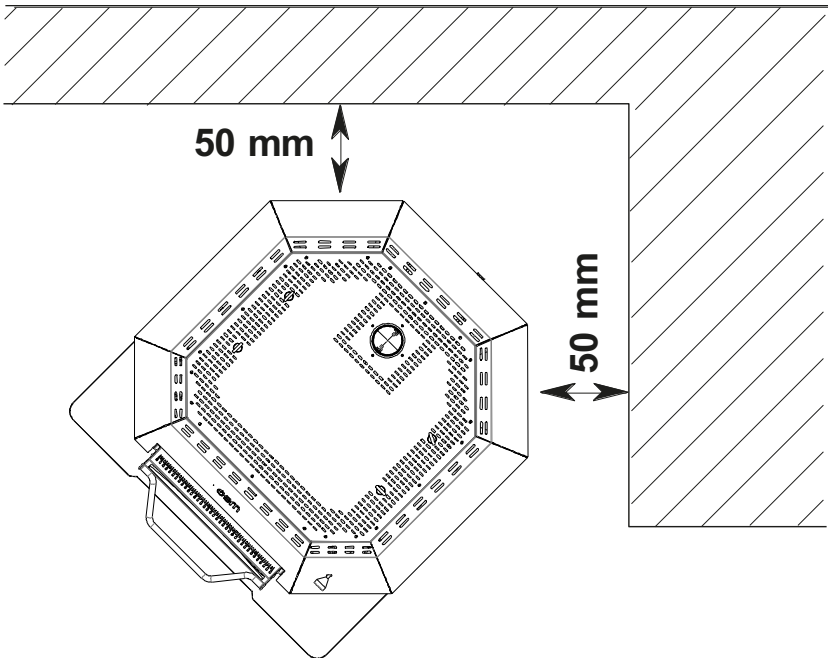
DANGER!
The oven must not be installed next to flammable walls such as furniture, partition walls, matchboard coatings, etc..

No inflammable flooring shall be utilised to install the oven on it. Under no circumstances is it permitted to store flammable objects close to the device. Fire safety conditions must be guaranteed.

IMPORTANT!
The manufacturer denies any responsibility for fires to people or things arising from non-compliance with these provisions.

For the positioning of the oven:

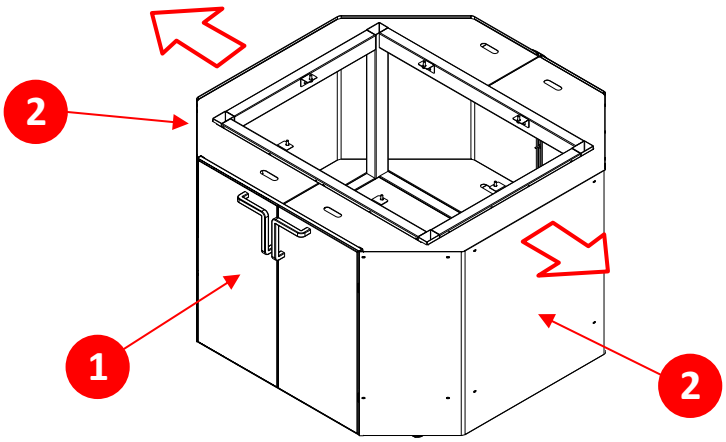
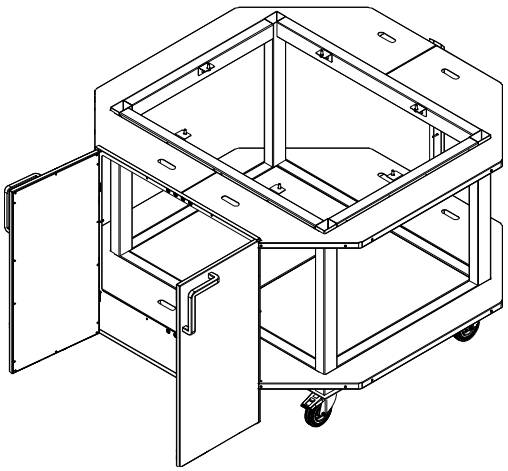
- **place the oven on the defined area in accordance with the indications shown in the figure as they indicate the minimum distances necessary for the oven to function properly.**
- **place the oven in places not subject to turbulence or draughts as they would change the good operation of the baking chamber and therefore the finished product; this significantly increases electricity consumption.**
- **secure the oven position by braking the front wheels.**



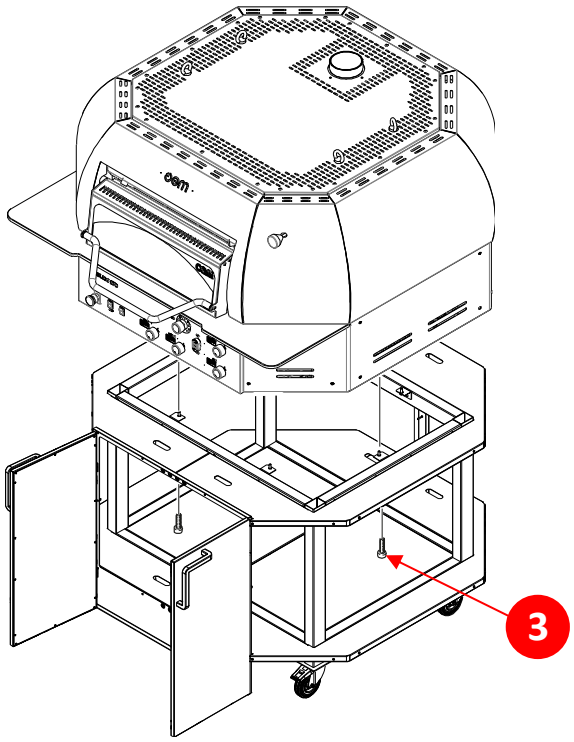
5.4.4 Oven assembly on the support

Required PPE	
Lifting equipment	Forklift truck / Crane / Hoist
Tools to be used	-

To assemble the oven on the support, perform the following procedure:

STEP	ACTION
1	Open the support doors (pos.1) and loosen the fixing screws of the side plates (pos.2).
	
2	Remove the plates.
	
3	Lift the oven as indicated in the “Transport” paragraph and place it on the bench.
4	Tighten the fixing screws (pos.3).

STEP	ACTION



5 **Reassemble the side plates.**

DANGER!
It is forbidden to tilt or overturn the ovens in case of displacements or movements.

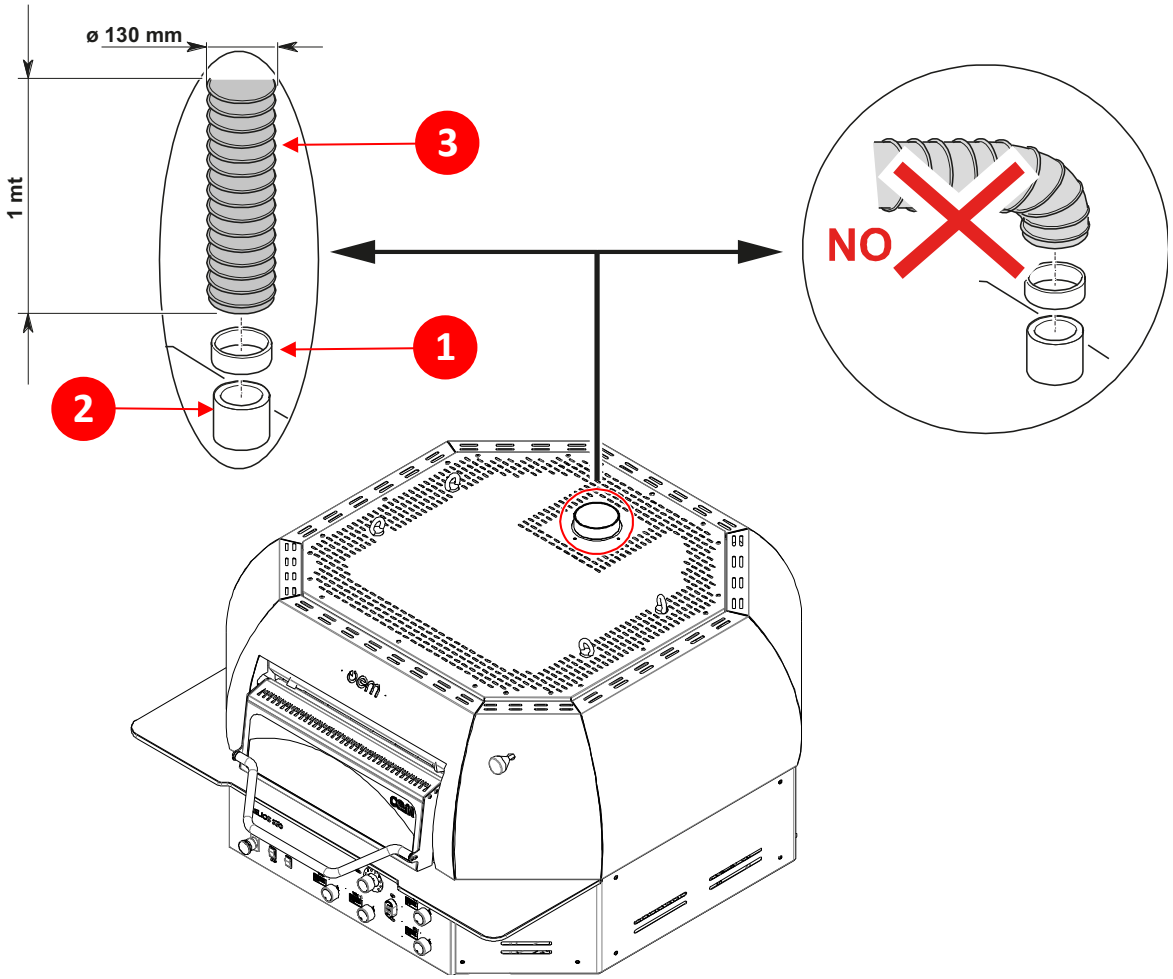
5.4.5 Chimney assembly

Required PPE	
Lifting equipment	-
Tools to be used	-

To assemble the chimney, perform the following procedure:

STEP	ACTION
1	Place the spacer (pos.1) (supplied) on the smoke outlet of the oven (pos.2).
2	Insert the flexible hose (pos.3) Ø130 mm on the spacer (pos.1), securing it with a metal clamp.

IMPORTANT!
For the correct operation of the oven, an air flow of at least 150 m^3/h must be guaranteed.



5.5 Connections

To put the machine into operation, the necessary connections to the local area network must be ensured:

- electrical connection (inclusive of earthing connection),

in compliance with the standards in force in the country of installation.

The user is in charge of ensuring the connection characteristics required.

5.5.1 Electrical connection

CAUTION!
The electrical power cables are charged to the customer and must be sized according to the maximum current absorbed.
Use a flexible cable under an oil-resistant sheath that should not be lighter than polypropylene or synthetic elastomer cables under equivalent sheath (designation 60245 IEC 57).

CAUTION!
Before making any electrical connection, it is important to check that the oven is off. Therefore, set the main switch to "0" - "OFF".

CAUTION!
Make sure the customer's power supply line has been previously isolated.

The purchaser is responsible for the conformity of the connection between machine and earthing system.

CAUTION!
Connection to the electrical mains must only be performed by specialised, authorised staff (electrical maintenance engineer).

Before setting up the electrical connection, make sure that:

- the maintenance engineer is aware of the regulations in force in the country of installation;
- the frequency and power supply voltage values of the machine correspond to the power supply network values;
- the section of the electrical cables used is adequate to the absorption;
- the electrical power supply line is adequate to support maximum oven absorption;
- the earthing of the circuit conforms with standards EN 60204-1;
- the materials used in the earthing system have adequate strength or adequate mechanical protection.

CAUTION!
Do not work with damp hands and objects.
In case of fire, do not use water on the electrical parts.

IMPORTANT!
To make the electrical connection, a cable is provided sized according to the maximum current absorbed, which must be connected to the power grid by the Customer's specialised personnel (electrician).

CAUTION!

The line cut-out switch (automatic thermo-magnetic or differential switch with a minimum contact opening of 3mm) positioned upstream of the oven, must be in an easily accessible and visible area.

IMPORTANT!

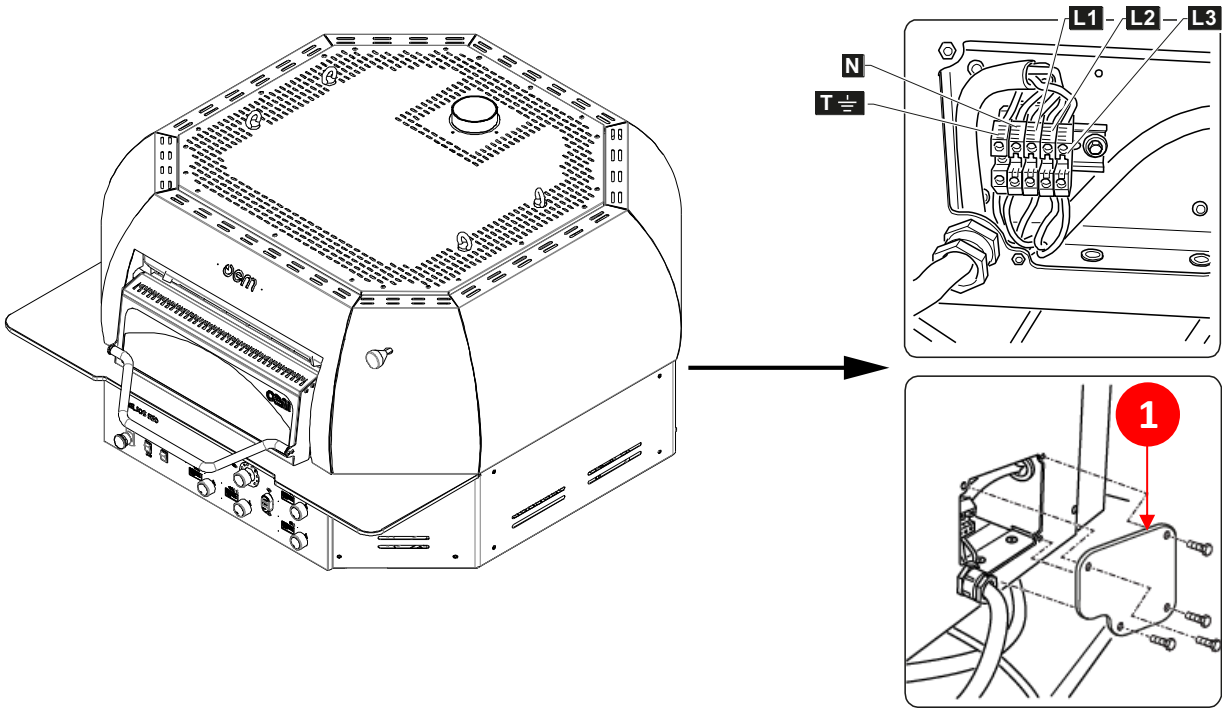
The specifications of the electric power line should correspond to the specifications of the identification plate and to those indicated in chap. 4.4 – Technical data.

5.5.2 Electrical connection of the oven

Operator qualification	Electrical maintenance engineer
Required PPE	
Lifting equipment	-
Tools to be used	Manual tools

To make the electrical connection of the oven, perform the following procedure:

STEP	ACTION
1	Remove the plate (pos.1) by loosening the dedicated screws.
2	Connect the power supply cable to the terminal block.
3	Connect the phases to clamps L1, L2 and L3, the neutral to clamp N and the earthing to clamp T.
4	Reassemble the closing plate (pos.1).



Chapter 6
CONTROLS AND USE

6 CONTROLS AND USE

The machine, during operation, does not require the continuous presence of an operator.

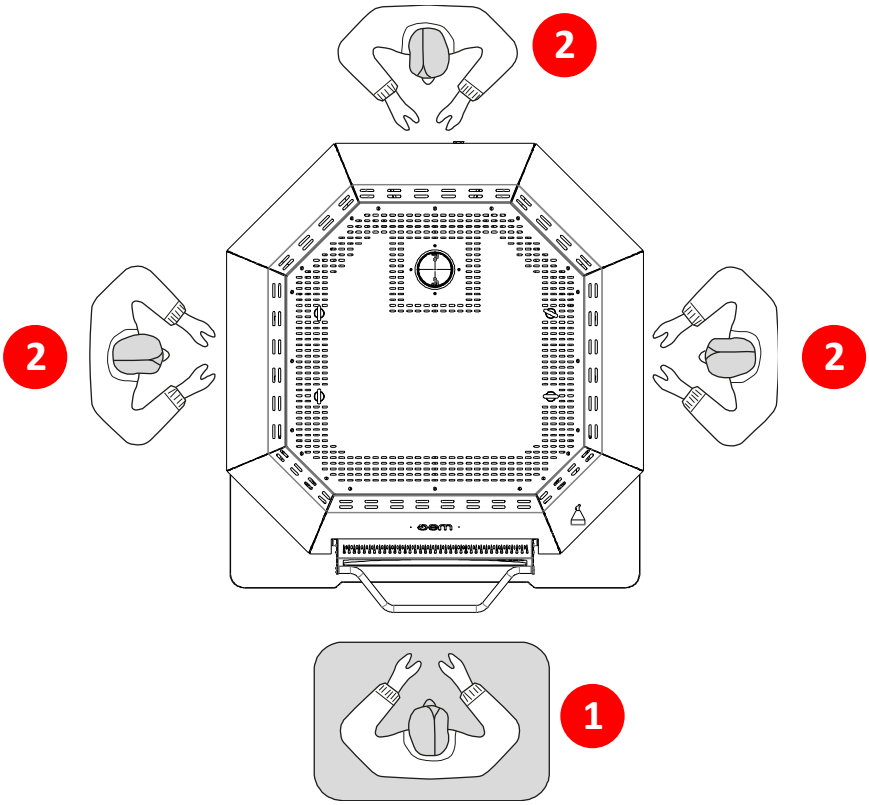
CAUTION!
Using the machine for a different purpose than intended by the Manufacturer may cause serious harm to people and/or property and/or animals.
OEM ALI GROUP S.R.L A SOCIO UNICO is not liable for damages caused by improper use of the machine.

IMPORTANT!
The control panel is not part of the area in contact with the food and therefore the appropriate precautions must be taken to AVOID the operator cross-contact with the food and controls.

6.1 Operator positioning

During operation of the oven, the operator is positioned in the following areas:

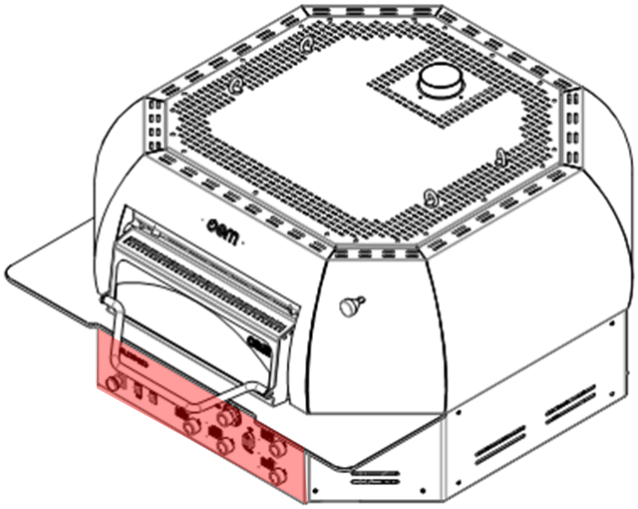
- **CONTROL AREA (pos.1): in front of the oven to insert/extract the product;**
- **MAINTENANCE/ADJUSTMENT AREA (pos.2): reserved for the maintenance engineer for maintenance operations.**



6.2 Pushbutton control panel

The buttons of the control panel are described below.

The control devices are located on the side of the product input zone.

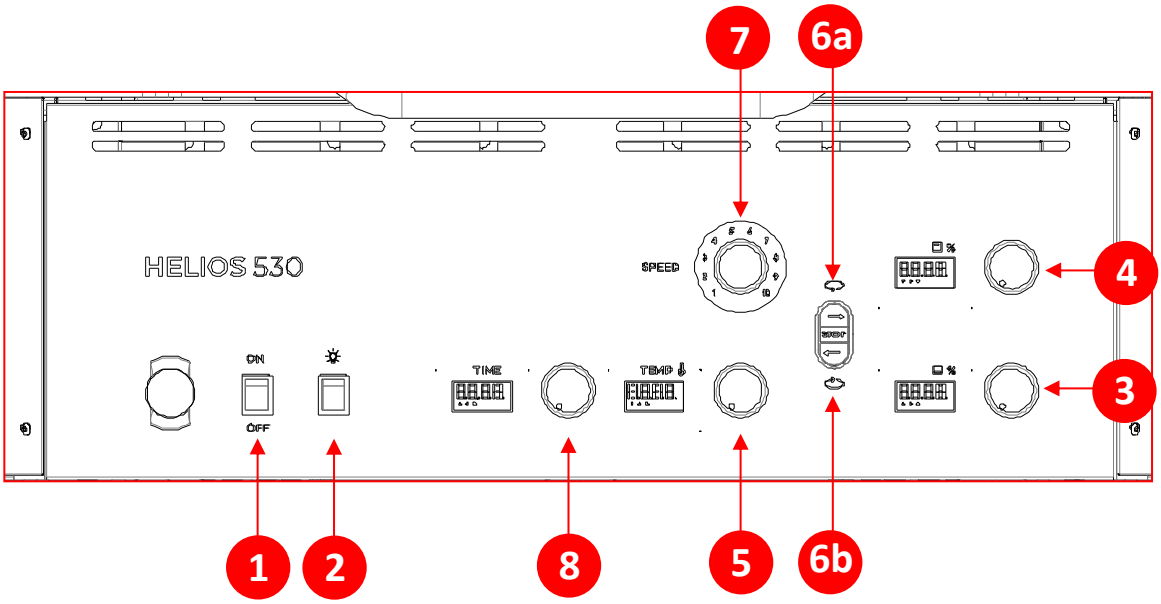


CAUTION!
The control panel is not part of the area in contact with the food and therefore the appropriate precautions must be taken to avoid the operator cross-contact with the food and controls.

6.2.1 Pushbutton control panel

The buttons of the control panel are described below.

POS.	EMERGENCY	DESCRIPTION
1	ON/OFF button	ON: oven on, activation of controls and display. OFF: oven off and controls deactivated.
2	Chamber light	Press the button to switch on/off the light inside the oven.
3	Lower resistance capacity adjustment	• Press the knob (power adjustment enabling); • rotate the knob to increase or decrease the displayed value; • press the knob again to confirm the value and exit the adjustment phase.
4	Upper resistance capacity adjustment	• Press the knob (power adjustment enabling); • rotate the knob to increase or decrease the displayed value; • press the knob again to confirm the value and exit the adjustment phase.
5	Temperature adjustment	The display indicates the real temperature, to change the set temperature: • press the knob to enable the adjustment, the display will show the previously set temperature value; • rotate the knob to increase or decrease the temperature; • press the knob again to confirm the value and exit the adjustment phase.
6a	Plate counterclockwise rotation	Press the button to activate the counterclockwise rotation of the plate. Press “STOP” to stop rotation.
6b	Plate clockwise rotation	Press the button to activate the clockwise rotation of the plate. Press “STOP” to stop rotation.
7	Plate rotation speed	Rotate the knob to adjust the plate rotation speed: • position 1: 0 rpm; • position 10: 10 rpm;
8	Timer	• Press the knob (timer adjustment enabling); • rotate the knob to increase or decrease the baking time;

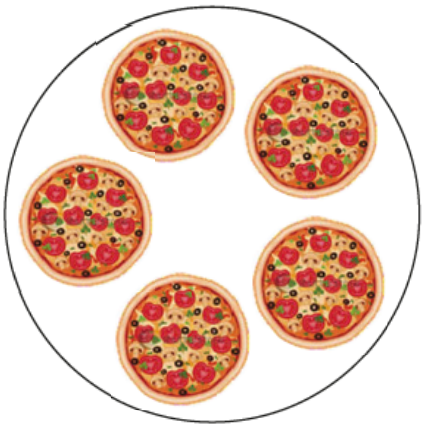


IMPORTANT!
Before reversing the rotation direction, it is necessary to always press the "STOP" button.

IMPORTANT!
The knob (pos.7), even if set to "0", still allows a minimum rotation of the plate. Press the STOP key to completely stop the plate.

6.2.2 Pizza positioning

To position the pizzas on the rotating tray, check the diameter of the pizzas to be cooked and arrange them as described below.

Pizza dimension (cm)	Number of pizzas	Picture
pizzas ø30	7	
pizzas ø35	5	
pizzas ø45	3	

6.3 Utilization procedures

6.3.1 Preliminary checks

The following checks must be performed before commissioning the machine.

- Check that the machine is positioned on a surface able to withstand their weight.
- Check that the area around the machine is free from obstructions and/or tripping hazards.
- Check that the machine has been connected to the power mains.
- Check that the power supply stages are correct.
- Check that the machine is not in "Maintenance" status.

CAUTION!
Take the product at the exit with adequate means of individual protection given the high burn risk.

CAUTION!
Always use the appropriate levers to raise/lower the moving flips, as they can reach high surface temperatures.

6.3.2 First ignition

Turn on the oven as indicated in the related paragraph (chap. 6.3.3 - Oven ignition procedure), checking the following features:

- reaching the set temperature;
- operation of various options depending on the model.

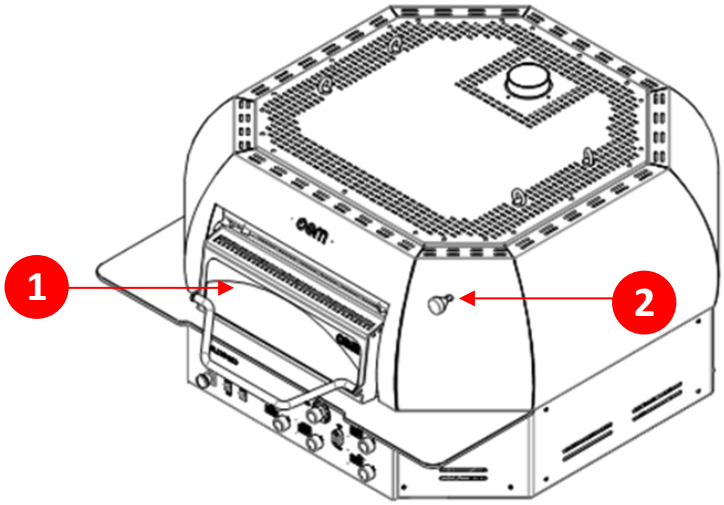
CAUTION!
Once the oven is installed, before starting it, carefully clean its inner part as well as refractory surface as explained in chap. 7 MAINTENANCE, also make sure neither foreign nor inflammable bodies are inside the oven.

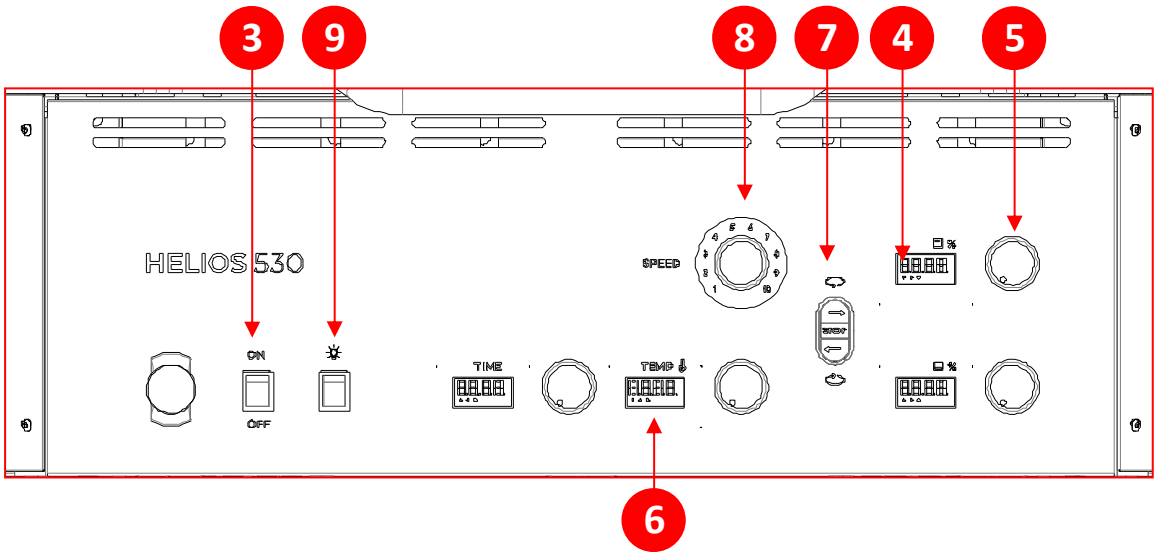
6.3.3 Oven ignition procedure

To ignite the oven, proceed as described below:

STEP	ACTION
1	Set the main switch to "ON".
2	Close the door (pos.1) and the chimney by rotating the knob (pos.2) clockwise.
2	Press the on / off key (pos.3).
3	Orange LED on (pos.4): self-diagnosis check correct and oven operational. Press the knob (pos.5) to switch off the LED.
4	To bake the pizza, see the information in chap. 6.4 - General baking rules.
5	Wait until the baking chamber reaches the set temperature indicated on the display (pos.6).
6	Start the rotation of the plate by pressing the button (pos.7) (see 6.2.1 – Control panel).
7	Set the plate rotation to minimum speed by rotating the knob (pos.8).
8	Open the door (pos.1) and insert the pizzas on the plate and then close the door.
9	Adjust the rotation speed by means of the knob (pos.8).
10	Switch on the light inside the baking chamber by means of the switch (pos.9)
11	After baking, adjust the plate rotation speed to minimum by means of the knob (pos.8).
12	Open the door and take out the pizzas.

IMPORTANT!
Do not exceed 50% of power of the lower resistances for baking pizzas on the refractory surface.





IMPORTANT!
It is recommended to turn on the oven at least an hour and a half before use to allow the correct temperature of the baking chamber to be reached.

IMPORTANT!
It is recommended to open the chimney (even only partially) during baking.

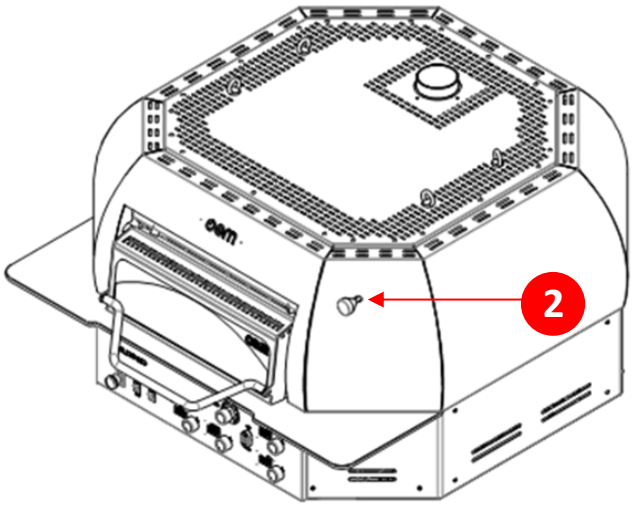
CAUTION!
Do not throw salt on the refractory surface. Do not cool the surface using a cloth moistened with cold water, only use pizza dough; these precautions avoid the deterioration of the refractory surface and, therefore, allow the pizza to be baked properly.

CAUTION!
The temperature inside the oven chamber is high, therefore, use adequate personal protective equipment when inserting and extracting the pizzas, danger of burns.

6.3.4 Shutdown procedure

To turn off the oven, proceed as follows:

STEP	ACTION
1	Press the ON/OFF button to stop the machine.
2	Completely open the chimney by means of the knob (pos.1).
2	Position the main switch ON / OFF, placed upstream of the oven, at “OFF”.



IMPORTANT!
At the end of each working day, turn off the oven.

CAUTION!
Set the main switch to “OFF” when the oven cooling fan has stopped, indicating that the baking chamber has cooled down.

6.4 General baking rules

To bake the pizza and for an optimal operation of the oven, see the rules indicated below.

6.4.1 Traditional pizza baking

Data	Description
Temperature	330°C
Resistance power	80% upper – 20% lower

6.4.2 Napoli pizza baking

Data	Description
Temperature	≥ 400°C
Resistance power	80% upper – 20% lower

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Chapter 7
MAINTENANCE

7 MAINTENANCE

CAUTION!
Perform maintenance operations when the machine is off (main switch at "0 - OFF") and completely cold.

CAUTION!
The maintenance operations must be carried out by qualified and authorised personnel.

IMPORTANT!
When removing the plug, the operator must be able to check that the plug is indeed disconnected from any spot he/she has access to.

Maintenance of the machine includes interventions (inspection, verification, check, adjustment and replacement) that become necessary following normal use.

For proper maintenance operations:

- **use only genuine spare parts, and tools which are suitable and in good conditions.**
- **respect the frequency of intervention set out in the manual for scheduled maintenance (preventive and regular maintenance). The distance (indicated in time or in working cycles) between operations has to be understood as the maximum acceptable, so it must not be exceeded; however, it can be shortened.**
- **a correct preventive maintenance requires constant attention and continuous monitoring of the machine. Promptly verify the cause of possible faults such as excessive noise, overheating, etc., and find a solution.**
- **the prompt removal of any cause of malfunction or failure prevents further damage to equipment and guarantees operators' safety.**

Maintenance personnel must be well trained and have an in-depth knowledge of safety standards; unauthorised personnel must stay outside of the work area during operations.
The machine cleaning operations must also be performed only during maintenance and with the machine stopped and de-energised.

IMPORTANT!
In case of doubt, it is forbidden to operate. Contact the Manufacturer for the necessary clarification.

CAUTION!
All kinds of repair and maintenance which are not included in this user manual can only be performed provided they have been previously authorised by OEM ALI GROUP S.R.L A SOCIO UNICO.
OEM ALI GROUP S.R.L A SOCIO UNICO shall not be held responsible for any damage to people or objects, if resulting from operations either different from those described or performed differently from what stated.

From an operational point of view, the machine maintenance operations are divided into two main categories:

Routine maintenance	**All those operations that the maintenance engineer must pre-emptively perform to guarantee the machine's proper operation over time; routine maintenance includes inspection, checks, adjustment, cleaning and lubrication.**
Extraordinary maintenance	**All the operations which must be performed by the maintenance engineer when required by the machine. Extraordinary maintenance includes service, repair, and restoration of nominal operating conditions or replacement of a faulty, defective or worn unit.**

7.1 Safety warnings

CAUTION!
When removing the plug, the operator must be able to check that the plug is indeed disconnected from any spot he/she has access to.

CAUTION!
When the machine is under maintenance, in order to prevent it from being accidentally switched on, disconnect power supply and add the following notice:
"CAUTION! MACHINE UNDER MAINTENANCE"

CAUTION!
When removing the plug, the operator must be able to check that the plug is indeed disconnected from any spot he/she has access to.

The safety precautions contained in this paragraph must always be strictly observed, during maintenance of the machine, to avoid injuries to personnel and damage to the equipment.

- **Maintenance must only be performed when the machine is switched off and de-energised.**
- **Apply specific warning signs such as: EQUIPMENT UNDER MAINTENANCE – DO NOT SUPPLY POWER, next to the machine itself.**
- **Perform the operations within your competence (Mechanical, Electrical, Hydraulic) for which you are authorised to intervene.**
- **You must be able to use the most suitable and adequate tools to identify the failure and you must be aware of the most suitable equipment to perform maintenance operations.**

7.2 Routine maintenance

When the machine is delivered to the user, it is adjusted for correct operation; nonetheless, to ensure good operation over time, it is necessary to run checks and periodic and preventive maintenance.

Routine maintenance includes inspections, checks and interventions that, in order to prevent faults, monitor:

- the mechanical conditions of the machine;
- the (electric) supply sources;
- machine cleanliness.

The following tables list a series of controls and activities that need to be carried out according to the recommended frequency.

The frequency of the ordinary maintenance activities listed here refer to normal operating conditions, i.e. that fulfil the required operating conditions.

7.2.1 Inspecting after delivery

7.2.1.1 ROUTINE MAINTENANCE TABLE

OPERATION	FREQUENCY				
	Daily	Weekly	Monthly	Six-monthly	Yearly
Visual check of machine status			X		
Check of nuts and bolts' tightening			X		
General maintenance (OEM technician)					X

IMPORTANT!
It is recommended for an OEM technician to carry out maintenance and general inspection at least once a year.

7.2.2 Cleaning

CAUTION!
The cleaning operations must be carried out only by qualified and authorised personnel.

CAUTION!
Strictly follow the regulations on washing water treatment that are in force in the country of installation.

IMPORTANT!
When removing the plug, the operator must be able to check that the plug is indeed disconnected from any spot he/she has access to.

7.2.2.1 Cleaning tables

OPERATION	FREQUENCY				
	Daily	Weekly	Monthly	Six-monthly	Yearly
External cleaning	X				
Self-cleaning cycle	X				
Refractory surface cleaning	X				

7.2.2.2 External cleaning

Use a soft moistened with water to clean the outside and the glass.

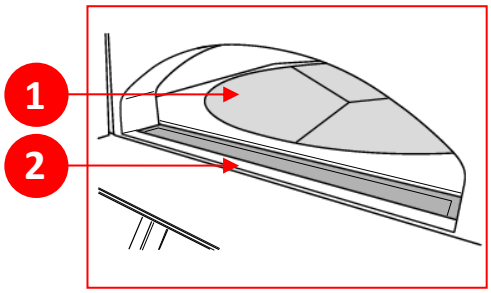
CAUTION!
To clean the oven, do NOT use metal tools such as iron scouring pads, brushes, scrapers and/or corrosive products. Do NOT use water jets.

7.2.2.3 Refractory surface cleaning

Operator qualification	Operator
Required PPE	
Tools to be used	Manual tools

To clean the refractory surface, proceed as described:

STEP	ACTION
1	Check that the oven has completely cooled down, open the door and clean the refractory surface (pos.1) with the special brush.
2	Remove the crumb tray (pos.2) and clean it with water.
3	Vacuum any pizza residues and reposition the crumb tray.



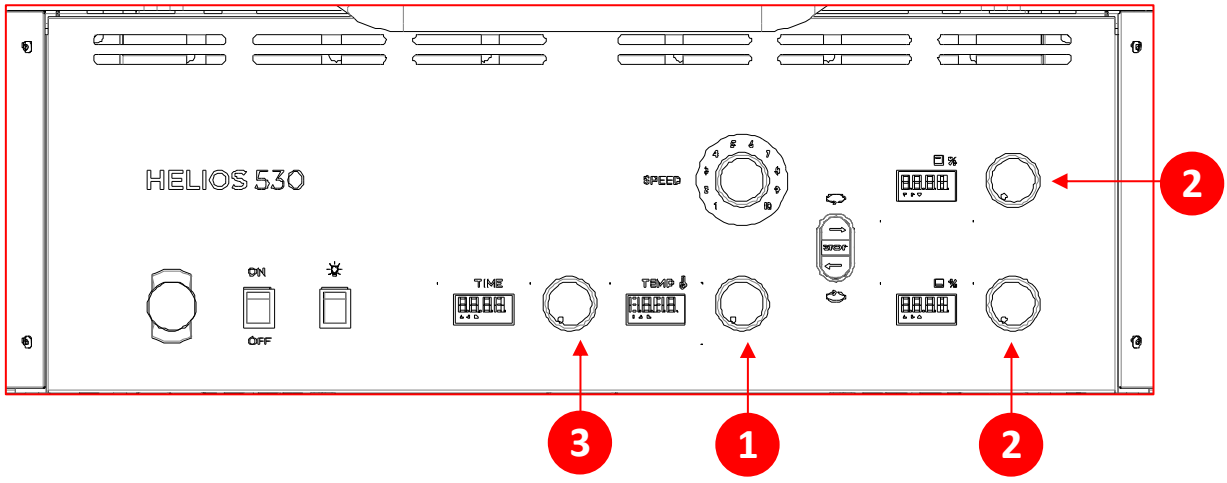
7.2.2.4 Self-cleaning cycle

The self-cleaning cycle must be carried out in the following cases:

- after using the oven for several hours;
- at the end of each working day;
- before switching the oven off.

To set the self-cleaning cycle, proceed as follows:

STEP	ACTION
1	Using the knob (pos.1), set the baking chamber temperature to 400°C.
2	Adjust the resistance power (pos.2): • upper resistance 80%; • lower resistance 100%.
3	Set the timer (pos.3) to about 20 minutes of operation.
4	Switch off the oven.



7.3 Special maintenance

CAUTION!
Extraordinary maintenance and repair of the machine are only allowed by qualified, trained and authorized technicians, employed by the manufacturer or by the authorised service centre.
These procedures require a thorough and specialist knowledge of equipment, necessary operations, related risks and correct procedures to work safely.

Should any exceptional circumstance occur, for which special maintenance is necessary, maintenance technicians shall follow this procedure:

- **check status of damaged or out-of-phase components;**
- **perform the operations described in this paragraph;**
- **if the operations to be executed are not provided for in this manual, send the Manufacturer a report of the event occurred, along with the outcome of the inspection and any comments.**

The manufacturer or the authorised service centre will consider, case by case, the situation. They will then agree with the ordinary maintenance engineers the type of procedure to be performed, choosing the most suitable solution among those listed below:

- **the Manufacturer sends his skilled technician who is trained and authorised to perform the necessary operations;**
- **or the Manufacturer authorises the user's routine maintenance engineers to perform the procedures, sending any supplementary instructions.**

CAUTION!
The spare parts to be replaces must be ordered at OEM ALI GROUP S.R.L A SOCIO UNICO If the customer does not use original spare parts or pieces authorised in writing by the Manufacturer, the latter shall not be responsible for the machine operation and the operators' safety. Authorisation and/or instructions must always be given in writing. It is forbidden to operate the machine without written permission and the manufacturer disclaims all responsibility.

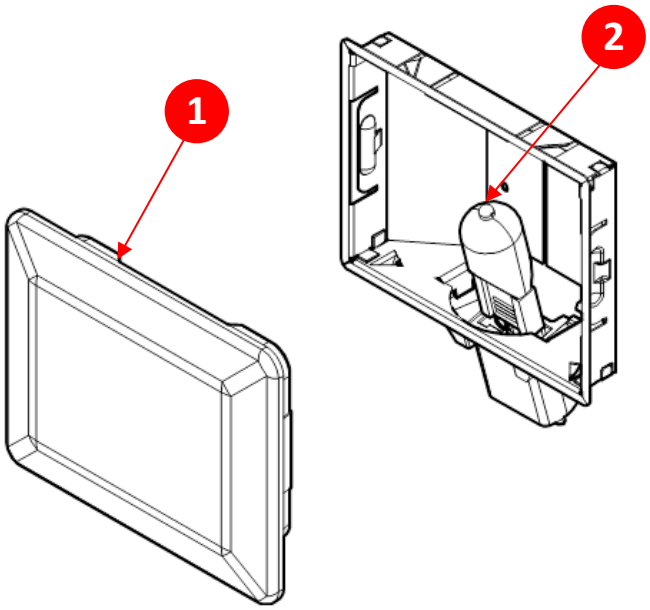
CAUTION!
In case it is necessary to perform operations of extraordinary maintenance, contact the Manufacturer.

7.3.1 Lamp replacement

Operator qualification	Electrical maintenance engineer
Required PPE	
Tools to be used	Manual tools

Proceed as described to replace the lamp:

STEP	ACTION
1	Open the oven and, using a screwdriver, force and detach the glass covering the lamp (pos.1).
2	Replace the bulb (pos.2).
3	Reassemble, checking the correct position of the gasket (if present), and insert the lamp cover glass (pos.1).



CAUTION!
This is a halogen lamp, do NOT touch with your fingers.

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Chapter 8
DECOMMISSIONING AND DISPOSAL

8 DECOMMISSIONING AND DISPOSAL

CAUTION!
Decommissioning and dismantling operations must be entrusted to personnel specialised in such activities. In particular, only those in charge of the dismantling and final waste disposal phase can perform the following activities:

- **mechanical and electric disconnection of parts according to disassembly instructions and design diagrams.**
- **take the units to the disposal centre in order to divide the different materials.**

The machine essentially consists of the following materials:

- **ferritic steel (AISI 430);**
- **steel (DD11);**
- **aluminates (DX51D + AS);**
- **plastic polyethylene material;**
- **elastomers, PTFE, graphite;**
- **electric cables with relative gaiters;**
- **etc.**

CAUTION!
The machine does not contain components or hazardous substances which require special removal procedures.

8.1 Decommissioning and storage

If the machine must not be used for a long period of time, securing it and warehousing it is required. Proceed as described:

STEP	ACTION
1	Disconnect power supply from the machine.
2	Cover the machine and store it in a place which must be under cover and not too damp.

8.2 Disposal

When you wish to dispose of the machine, secure it. Proceed as described:

STEP	ACTION
1	Disconnect power supply from the machine.
2	Proceed with dismantling, separating the components making up the machine into groups ready for differentiated disposal.

CAUTION!
To disassemble commercial parts or subcontracting material making up the equipment supplied by OEM ALI GROUP S.R.L A SOCIO UNICO, please refer to the relevant user manual supplied.

Pursuant to the 2012/19/EU "WEEE" Directive, if the purchased component/equipment is marked with the following crossed-out wheelie bin symbol, it means that the product must be collected separately from other waste at the end of its lifespan.

CAUTION!
We remind you to comply with the laws in force in the country of installation regarding machine disposal.

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Chapter 9
TROUBLESHOOTING

9 TROUBLESHOOTING

9.1 Alarms during operation

During operation, it is possible to view on the display the alarms due to the following causes.

Symbol	Description	Problem	Operator
AL1_	Temperature probe not detected	• Temperature probe malfunctioning; • Temperature probe disconnected.	OEM Technician
H-t	Electronic board high temperature	Turn off the oven and check the correct operation of the forced ventilation.	Operator

9.2 Troubleshooting

Problem	Cause	Solution
The oven does not switch on	No electrical power supply.	Check the electric connection.
	Main switch "OFF".	Make sure the main switch is on
	Electrical check of oven.	Contact the technical support service.
The pizzas are not baked uniformly	Dirty baking surface.	Clean the baking surface.
	Damaged backing surface.	Replace the surface
	Unsuitable temperature.	Adjust the oven temperature
	Insufficient smoke suction.	Check the fume exhaust and fume suction opening.
	Unsuitable surface rotation.	Adjust the rotation speed.
Oven malfunctioning	Failure to reach the set temperature.	Resistances malfunctioning, contact the technical support service.

CAUTION!
For all other troubles, do not hesitate to contact the Technical support service

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Chapter 10
ANNEXES

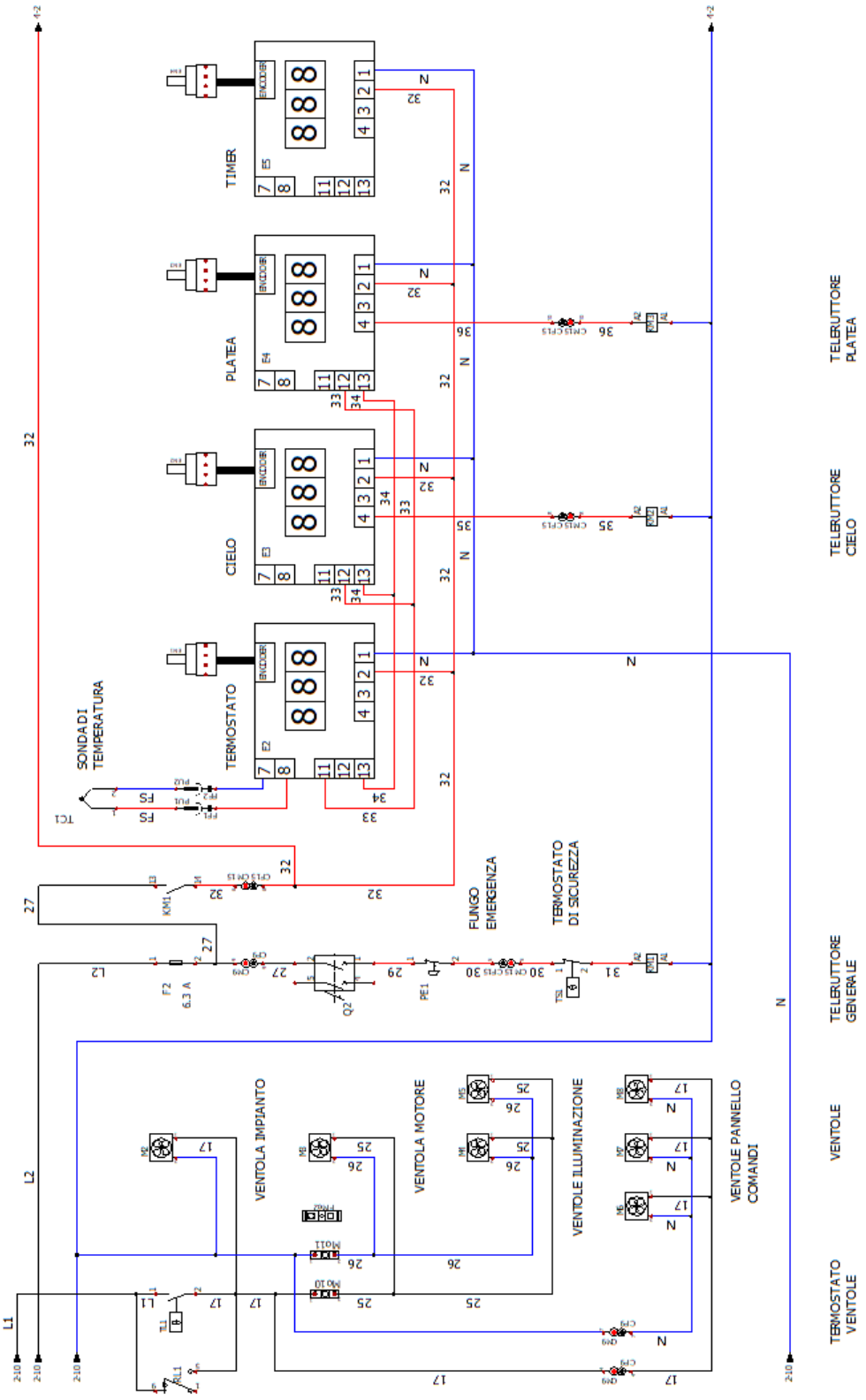
10 ANNEXES

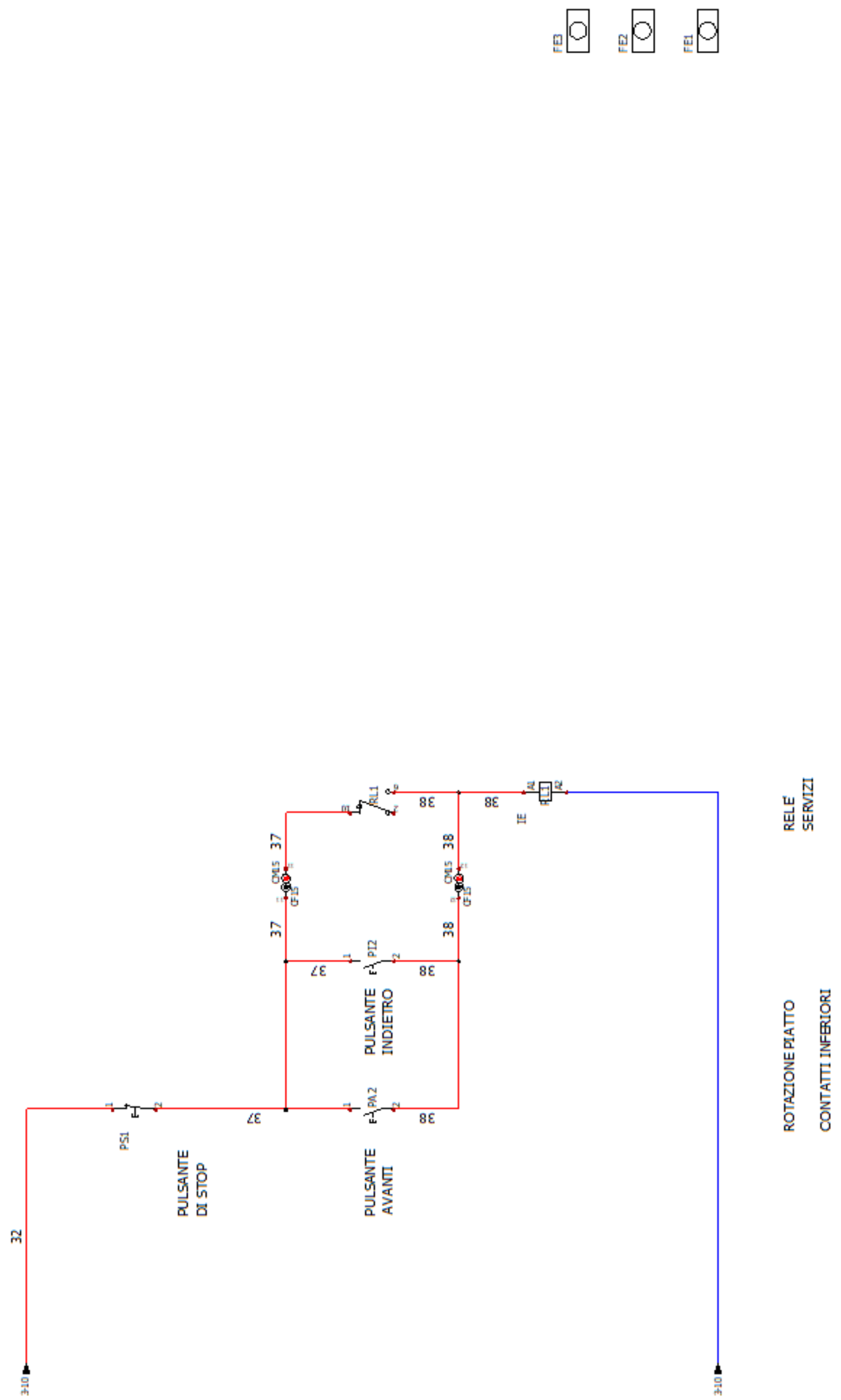
ATTACHMENT LIST	
1	WIRING DIAGRAMS
2	LIST OF ALARMS

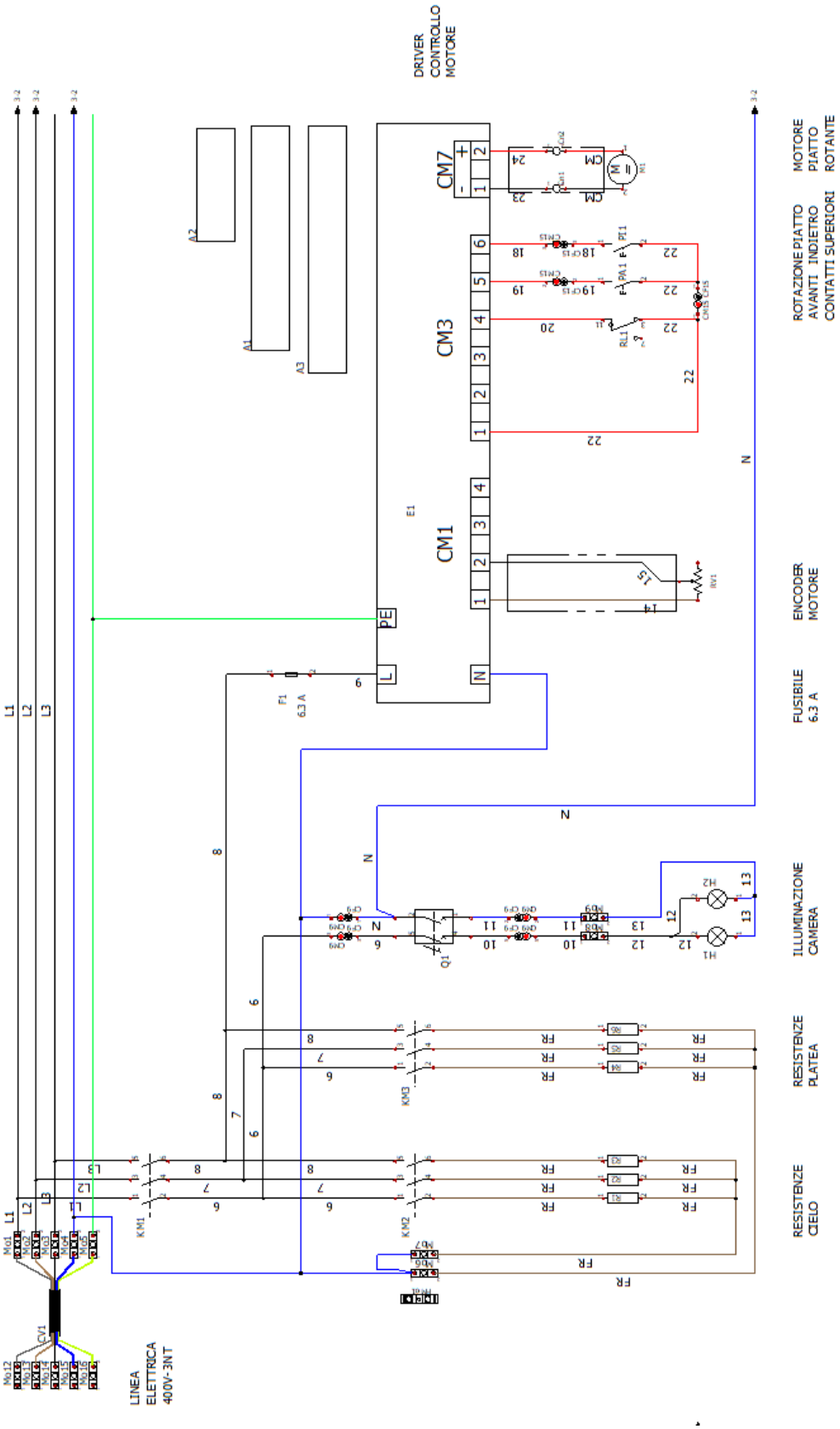
Wiring diagram key

CODE	DESCRIPTION
Cn1 - Cn2	MORSETTO / CLAMP
H1 - H2	LAMPADA CAMERA DI COTTURA / LAMP ROOM
M1	MOTORE / MOTOR
M3-M4-M5	VENTOLA / FAN
Mo12-Mo16	MORSETTO / CLAMP
R1-R6	RESISTENZA CIELO-PLATEA / UPPER-LOWER RESISTANCE
TC1	SONDA DI TEMPERATURA / TEMPERATURE PROBE
TL1	TERMOSTATO / THERMOSTAT
A1	HELIOS PANEL
A2	HELIOS ACTIVATION PLATE
CV1	POWER CABLE
E1	ELECTRONIC BOARD
F1-F2	MORSETTO FUSIBILE / CLAMP FUSE
FE1-FE3	CABLE CLAMP
FMo1-FMo2	FERMAMORSETTO / CLAMP
KM1-KM2-KM3	TELERUTTORE / CONTACTOR
M2	VENTOLA / FAN
Mo1-Mo11	MORSETTO / CLAMP
RL1	ZOCCOLO RELE' / RELAY HOOF
RL1	RELAYS
TS1	TERMOSTATO DI SICURA / SAFETY THERMOSTAT
CM9	N-LOK-M 9P
CM15	N-LOK-M 15P
A3	PANNELLO / PANNEL
E2-E3-E4-E5	EVCO UPPER/LOWER SHEET
EN1-EN2-EN3-EN4	POTENTIOMETER
M6-M7-M8	VENTOLA / FAN
PA1-PA2-PI2	CONTATTO NO / CONTACT NO
PE1	PULSANTE EMERGENZA / EMERGENCY BUTTON
PE1	CONTATTO NC / CONTACT NC
PE1	SUPPORTO/SUPPORT
PI1	CONTATTO NO / CONTACT NO
PS1	SUPPORTO/SUPPORT
PS1	CONTATTO NC / CONTACT NC
PS1	PULSANTE / BUTTON
Q1-Q2	INTERRUTTORE / SWITCH
RV1	POTENTIOMETER
CF9	N-LOK-F 9P
CF15	N-LOK-F 15P

Wiring diagram




PULSANTE
DI STOP
PULSANTE
AVANTI
PULSANTE
INDIETRO
RELE'
SERVIZI
ROTAZIONE PIATTO
CONTATTI INFERIORI


DRIVER CONTROLLO MOTORE
CM7
CM3
CM1
MOTORE PIATTO ROTANTE
ROTAZIONE PIATTO AVANTI INDIETRO CONTATTI SUPERIORI
ENCODER MOTORE
FUSIBILE 6.3 A
ILLUMINAZIONE CAMERA
RESISTENZE PLATEA
RESISTENZE CIELO
LINEA ELETTRICA 400V-3NT
L1
L2
L3
N
PE


YOUR PIZZA HUB