

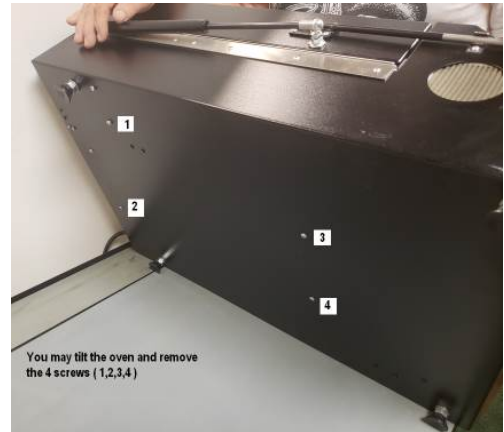
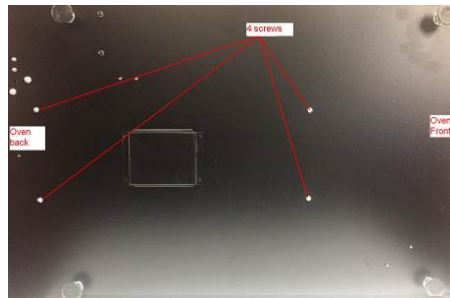
## X-Reflow306, X-Reflow306 LF-AC, X-Reflow306/S

### How to replace the heaters.

1. Turn Off the oven. Disconnect the power cable from the power outlet.



Hex key 2.5 mm  
Hex key 3 mm  
Philips screwdriver #1



2. Remove the four M4 screws holding the heating chamber to the bottom of the oven. Use a 2.5 mm hex key.



3. Remove the six M4 screws holding the mesh and remove the mesh
4. Remove the side and the front angle irons as shown below

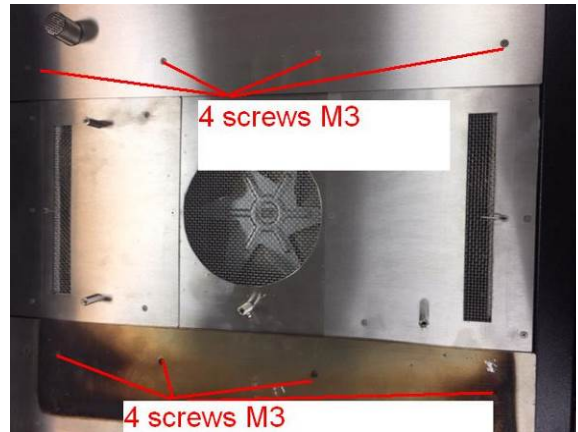


4a. Remove the angle iron held by 6 M4 screws

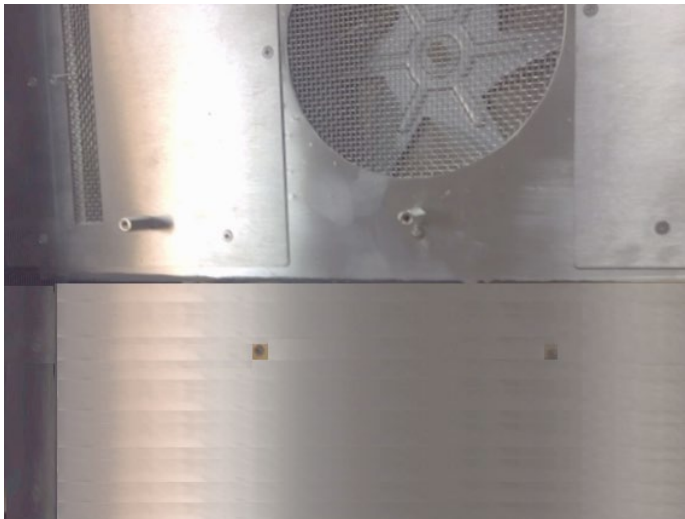


4b. Remove the front angle iron held by 5 M4 screws as shown above

5. Loosen the 8 M3 screws holding the top plates as shown below (do not remove the screws):



Screws in the top plates



5a. View of the left top plate.  
After loosening the 4 screws lift it and remove.

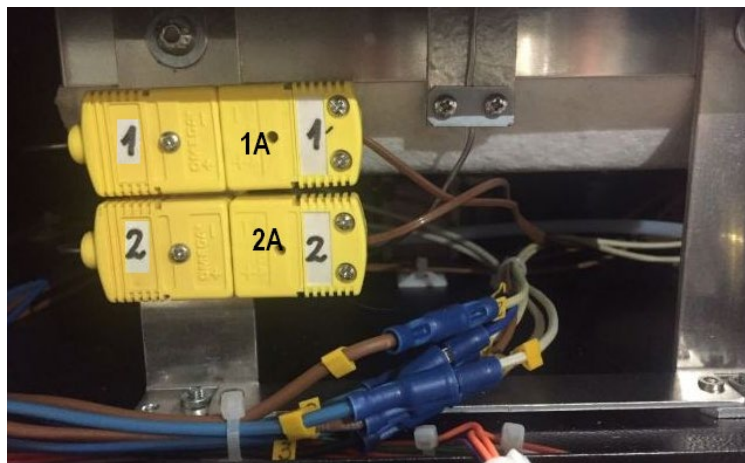


The oven with the top plate removed

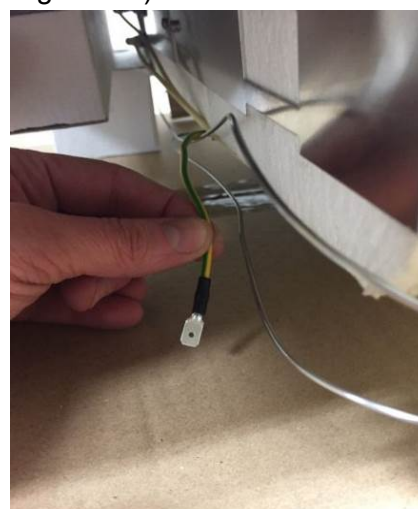


6 screws

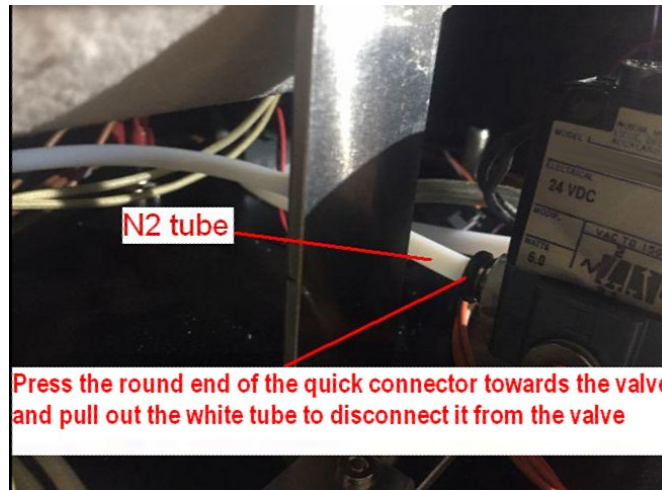
6. Remove the 6 screws using a 2.5 mm hex key and tilt down the panel without disconnecting the cables



7. Disconnect the 2 yellow thermocouple connectors (1A and 2A) and 6 blue round connectors with numbers (1 - front heater, 2 - rear heater, 3 – circulating air fan)

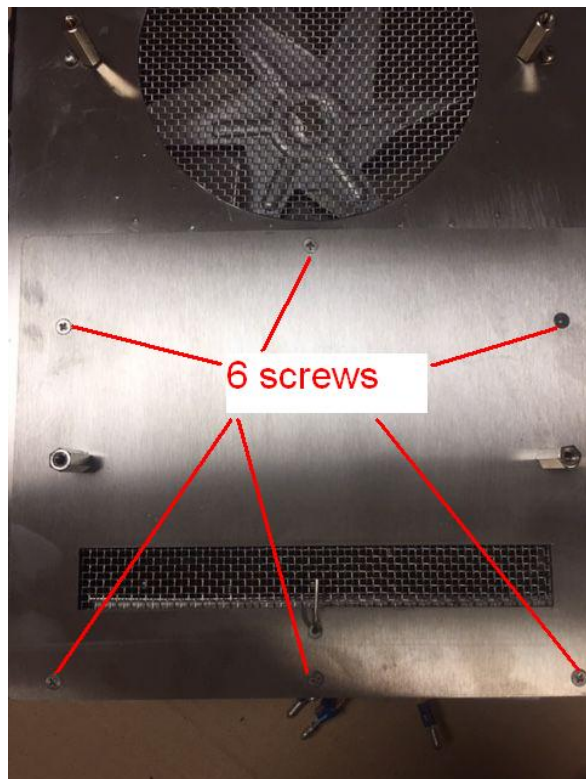


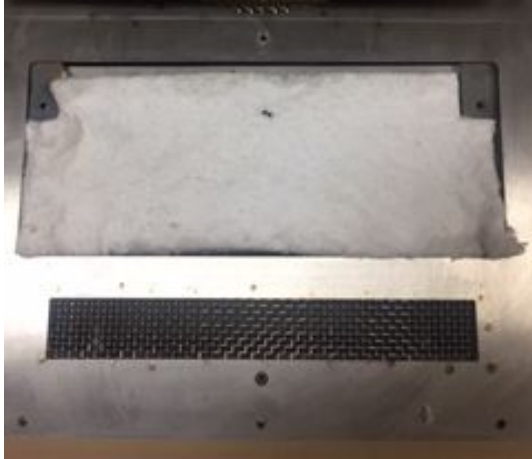
8. Disconnect the wire grounding the heating chamber



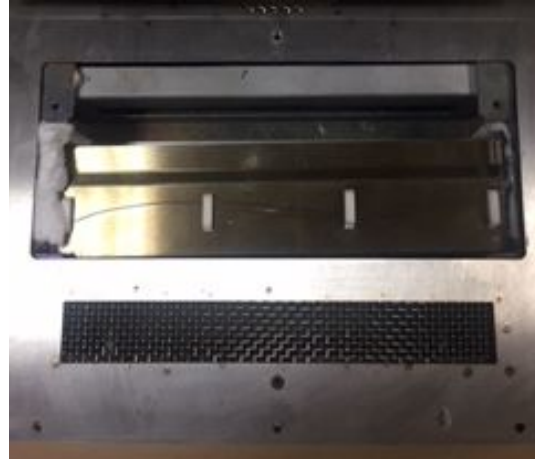
9. Disconnect the N2 tube from the N2 valve. Press and hold the quickconnector on the N2 valve to pull out the white N2 tube

10. Remove the heating chamber from the oven

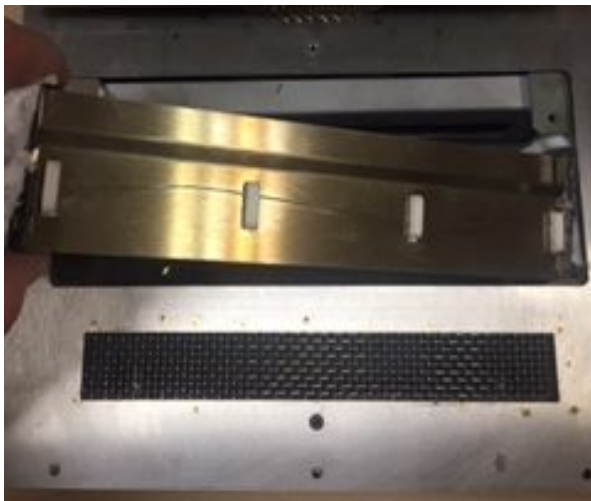




11a Remove the insulation



11b Heater view



11c. Remove the heater starting from the left side



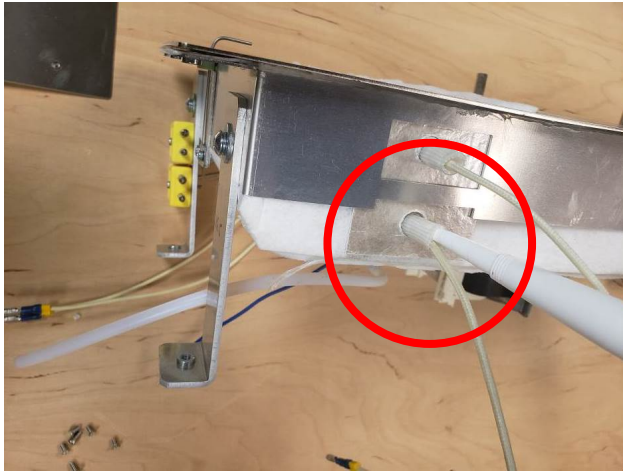
11d. Pull out the wires

11. Replacing the heaters: remove old insulation then remove the old heater by sliding it up first from the side with no wires.

12. After removing the old heater, install the new one by following the directions in reverse order starting from 11d.

Note: Use the new insulation supplied with the heaters

13. If the oven will be used with N<sub>2</sub>, seal the heating chamber before putting it back in the oven



13a. Seal inside



13b. Seal around the border

To seal, use high temperature silicon

CX-80 or similar: <https://www.bomir.com/online/categories,81,Superior-Full-Convection-Batch-Ovens-with-unmatched-features.html>

14. Install the chamber in the oven by following the preceding directions in reverse order.

Note: Make sure to connect the grounding wire and N<sub>2</sub> line tube (if applicable)