

Flux Ovens

Operating Instructions

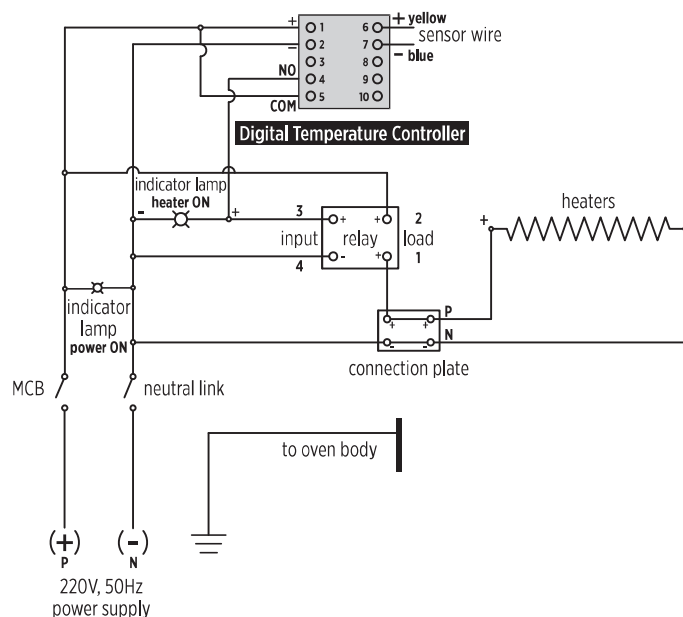
Type 250FX Flux Holding & Rebaking Oven

- Modern design for easy retrieval
- 250 lb. flux capacity



Part No.	Description	Temperature Range	Chamber Size	Capacity (for granular flux)	Weight	Dimensions
Type 250FX						
1201920	220V AC at 3000 watts	100° - 750°F (38° - 399°C) digital temperature controller	3.5 cu feet (0.10 cu m)	250 lb (113 kg)	200 lb (90 kg)	39" x 31" x 49" (99 cm x 78.7 cm x 124.5 cm)

Wiring



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Product Information

! CAUTION

- Never keep the oven in a wet area or on a wet floor.
- Do not touch oven surface with unprotected hands. Always use safety gloves.
- Disconnect the supply when oven is not in use.

Working Instructions

1. Fill the welding flux within the suggested capacity. For best results, leave space in the chamber for moisture to escape easily.
2. Connect the plug to the power source.
3. Switch the supply on. Indicator light will glow.
4. A tolerance of +/- 10% between thermostat knob setting and actual temperature is normal.

Operating Instructions for Digital Temperature Controller

1. Press and hold the first button (Item 1, Figure 1).
2. To decrease the temperature setting: While holding down the first button (Item 1), press the down arrow button (Item 2).
3. To increase the temperature setting: While holding down the first button (Item 1), press the up arrow button (Item 3).
4. Release all buttons when temperature is set.

Two temperatures will be displayed, one on top representing the current temperature in red and one on bottom representing the set temperature in green on digital temperature controller (DTC).

When set temperature is reached, it cuts off automatically. After a 1-2 degree drop, the oven switches on again.

Indicator light next to "R" (Item 4) will glow red when heater is on.

Figure 1



Quality Testing

This oven has been tested by heating it to the product's rated temperature for four hours before being approved by a quality inspector. The inside of the oven may become dull or yellow in color due to this testing. This is how this type of oven would look inside after it has been turned on.

i Guide to Electrode & Flux Stabilization

Eliminate expensive rework and protect welding profits!

This guide explains proper storage and oven holding temperatures:

- Recondition/rebake procedures for electrode coatings exposed to moisture are included.
- Remove electrodes from cardboard containers before placing in ovens.
- Electrode coatings should not be exposed to the re-baking temperature without first being reconditioned at a lower temperature. Failure to do so may result in breakdown of electrode coatings. After re-baking, lower temperature to holding level until reissued.

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Warranty

Phoenix Ovens International LLC warrants its products against defects in material and workmanship. The company will, at its discretion, repair or replace any properly installed Phoenix International manufactured product which fails under normal operating conditions within one year from date of receipt. Contact the factory for return authorization before returning the product to Phoenix International freight prepaid. If our inspection confirms that the product is defective under terms of this warranty, it will be repaired/replaced and returned freight prepaid.

This warranty applies only to products sold by Phoenix International, Inc. and specifically excludes installation or de-installation labor, transportation or equipment of another manufacturer used in conjunction with Phoenix International products. No other warranty, expressed or implied, exists beyond this warranty declaration.

Phoenix constantly strives to improve its products and therefore reserves the right to change design, materials and specifications without notice.

