



POWDER

Powder Coating Oven Maintenance Schedule

We want your equipment to run smoothly and efficiently for years to come! So here are some common maintenance tasks that can extend the lifespan of your oven and prevent costly downtime. Performing these scheduled, routine tasks will help prolong the life of your oven, and it will assure that your oven remains eligible for warranty coverage.

EVERY DAY

Check/Clean Oven Floors



Before using the oven, clean the interior floor by sweeping or vacuuming to remove debris and spent powder. Be sure to keep dirt away from the exhaust filters.

Check/Clean Oven Walls & Ceiling



Inspect the oven's interior and check the walls or ceiling in case they need to be cleaned by hand or vacuumed to remove debris. DO NOT use solvent-based cleaners because residue cause finish problems on your parts.

Keep a Daily Inspection Log



The owner/operator can better understand the oven's performance by keeping a log of crucial information from daily and weekly inspections. The log can also help the operator speed up the troubleshooting process and reduce downtime by logging unexpected events.

Check Incoming Gas Pressure



Before using the oven, check the analog (dial type) pressure gauge provided with the heating unit. It is mounted near the connection point where the incoming gas supply is mated to the heating unit. The incoming gas pressure should be between 10" and 14" w.c. Excessive gas pressure can cause the burner to over-fire, which is dangerous. On the other hand, insufficient gas pressure can cause oven performance issues.



ONCE EVERY WEEK

Clean Flame Rod



Carefully wipe away built-up debris using a clean cloth. DO NOT use compressed air or chemicals/detergents to clean. DO NOT overtighten!

ONCE EVERY 2 MONTHS

Clean/Check the Heat Unit Fan Belt



After disconnecting incoming power to the oven, remove the yellow belt guard to get to the belt. When checking tension, the belt should have a half-inch to a little over an inch of deflection when you press down firmly on the belt. DO NOT overtighten the belt! After tension check, look for an overly worn or damaged belt.

Clean/Inspect Exhaust Belts



After disconnecting incoming powder to the oven, check the exhaust fan belt for wear and tension. When checking tension, the belt should have about a half-inch of deflection when you press down firmly on the belt. DO NOT overtighten the belt. Ensure the belt has the recommended amount of tension and is not overly worn or damaged.

Grease Recirculation Fan Bearings



Using a high-temperature grease (rated over 400 degrees), apply a small squirt to the grease fittings above the bearings of the oven exhaust fan. Be careful not to apply too much grease to the bearings - one small pump from a grease gun every two months should be plenty.



Grease Exhaust Fan Bearings



Using a high-temperature grease (rated over 400 degrees), apply a small squirt to the grease fittings above the bearings of the oven exhaust fan. Be careful not to apply too much grease to the bearings - one small pump from a grease gun every two months should be plenty.

ONCE EVERY 3-6 MONTHS

Check Duckwork



Every few months, check the vent lines from the gas train regulators, the oven exhaust duct, and the discharge cap for blockage or leaks.

ONCE EVERY YEAR

Inspect Rope Seal Gasket



Check your oven's door gasket every few months. Replace it if it shows significant wear or is torn. Otherwise, it can be gently cleaned of dirt and powder residue. The doors should fit snugly to prevent heat loss.

Perform a Leak Test



Have a service technician perform a leak test on the oven heat unit's gas train.



Perform a Combustion Test



Have a service technician perform a combustion test on the oven heat unit and adjust as needed for best performance.

Perform a Safety Test



After your oven has been in operation for about a year, the testing done by a service technician should include a check of the high limit safety switch that shuts off the heat unit's burner if the discharge air temperature is too high, along with a test of the air proving switches used on a heating unit combustion supply fan, the heating unit recirculation fan, and the oven exhaust fan.

Check Oven Structure



Once a year, you should look over the oven structure to ensure there are no unusual gaps between panels, at seams, etc. It is possible to caulk small gaps using high-temperature caulk rated for service at 450 degrees or higher. A skilled service technician should address severe issues with the structure immediately.

Service the Heat Unit Fan/Drive & Test



Have a service technician inspect and possibly clean or replace the heat unit fan, check the bearings for excessive play or noise, make sure the motor is clean, and then test the fan for proper performance.

Service the Heat Unit Combustion Air Supply Fan/Drive & Test



Have a service technician inspect and possibly clean or replace the heating unit combustion air supply fan, check the bearings for excessive play or noise, make sure the motor is clean, and then test the fan for proper performance.



Service the Oven Exhaust Fan/Drive & Test



Have a service technician inspect and possibly clean or replace the oven exhaust fan, check the bearings for excessive play or noise, make sure the motor is clean, and then test the fan for proper performance. This test should include checking the oven exhaust duct and discharge cap for blockage or leaks.



Just scan the code and order whatever parts you may need.

By following this inspection and maintenance timeline, you'll get the best performance from your Powder-X booth. If you have questions, need advice, or want to get maintenance or repair parts, call Powder Market at (888)-358-3444. Email them at consumables@powderx.com or scan the Spare Parts QR code above.