



23293

# Powder Coating Curing Oven



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# Specification

## Product Description

This oven is used in the production process of powder curing. Place the powder coated work piece inside the oven to achieve a perfectly coated finish. With 2 shelves and 2 rails per shelf, there's plenty of room for hanging your powder coated metal work to cure.

This product can be wired onto a 32AMP plug.

We at Monster Group UK understand that it is a new and exciting purchase, and although it is tempting to get stuck in, please CAREFULLY read the instructions and safe working practices before you start using the machine.

**Please Note: The T-Mech Powder Coating Oven is designed to be used by a competent person. It should not be used or stored in wet or damp conditions. Personal Protective Equipment (PPE) must be worn by the operator of this equipment.**

**Please refer to and read Safety Advice, Safe Working Practice to ensure prevention of injury or damage to the device before starting.**

## Technical Information

Voltage:	240V- 1ph- 50Hz
Power:	6.25kW
Rock wool insulation:	120mm thick
Warm Up Time:	30-45 minutes (180-250°C)
Temperature Stability:	< ±1°C
Temperature Range:	0-250°C

Includes a soak control system and an 8 segment ramp.

## Product Specifics

External Measurements: 1040mm L x 1040mm W x 1640mm H

Internal Measurements: 800mm L x 800mm W x 1400mm H

Door: 800mm W x 1400mm H

Weight: 395kg

# Specification

## Monster Guarantee

If you wish to return a product in perfect working order, we provide a 30 day returns policy as long as the item is unopened and in a resalable condition.

A 12 month warranty applies to all of our electrical products; we will cover labour, parts and delivery charges. Our policy is to try and repair the item before arranging an exchange or refund.

If for any reason a part is missing please get in touch with us within 7 days on receipt of your order. You can contact our friendly and helpful Customer Support Team via email or call. For full terms and conditions contact our Support Department via the details on the Contact Us page.

## Product Features

Temperature Control - including Soak Controls

On/Off Light

Working Light

Alarm

Lock

On/Off Switch

Emergency Stop



# Safety Advice



## Safe Working Practice

Please read through the safe working practice to ensure prevention of injury or damage to the device.

This oven must be installed on a dry and level solid ground.

The area must be clean and well ventilated.

Do not install in a damp environment or in an area with high humidity.

Do not install outdoors or in an area without sufficient cover.

Do not install in an area exposed to flammable or corrosive gases.

The ambient temperature of the area must be between 0 and 40°C.

The oven should be installed at least 1 metre away from any wall in order to provide sufficient ventilation.

Entering the oven whilst it is turned on WILL cause death or serious injury. DO NOT enter the oven.

It is advised that you do not operate the oven on your own. Have at least 2 people working with it.

Even with 2 people working with the oven we recommend carrying out 15 minute interval checks to the working area to ensure that the personnel and environment are safe.

You must wear a tyvek suit or appropriate coveralls to protect your skin, as the powder material/paint can cause irritation. Check individual safety recommendations of product you are using.

You must wear gloves and sufficient eye protection at all times, as the powder material/paint can cause irritation. Check individual safety recommendations of product you are using.

You must wear a dust mask at all times whilst using and working around the oven.

# Safety Advice



## Safe Working Practice

Please read through the safe working practice to ensure prevention of injury or damage to the device.

Make sure the work piece can fit in the oven prior to turning the oven on and coating the piece.

Do not use the powder curing oven for food. The fumes from the powder coating can be toxic. Each time the oven gets turned on, the paint's fumes get reintroduced. Make sure you wear a dust mask.

Make sure the work piece has properly cooled before handling.

Make sure the door is securely closed before curing begins, this will prevent the hot air from injuring the operator.

When servicing, you must turn off the power supply.

The maximum furnace temperature is 250°C, over-temperature use is strictly prohibited.

Do not put fingers through the vents on the oven as the elements can be hot.

When the oven is not in use, ensure that it is correctly turned off and allowed to cool sufficiently before closing up the vented area. The key should be turned to the locked position and then safely locked away. It is recommended that only authorised personnel have access to the key. You will receive 2 keys for the lock with your oven so we recommend that you keep the spare in a safe place.

# User Guide

## General Powder Coating

1. Powder Coating should be undertaken by an experienced and competent person. This is in no way an exhaustive and complete guide of how to Powder Coat/Cure.
2. You should wear a Tyvek suit/coveralls and gloves to protect your hands and skin. Eye protection should be worn at all times. A dust mask will protect you from inhaling any paint, as electrostatic paint can dry out your skin and cause irritation.
3. Determine the type of material you are going to powder coat and select a suitable powder for the finish.
4. Dismantle all threaded or lubricated interfaces before you begin, including anything you don't want coated. The powder coat you apply will adhere to everything on your rig, this will make clamps, bolts and nuts useless after blasting. A high temperature masking tape can be placed on the parts you don't want powder coated, and it can be left on while in the oven, but it will need to be removed quickly afterwards.
5. Clean the base metal thoroughly. Remove any rust or debris from the metal.
6. Apply the powder to the object to be powder coated. This is done using a spray gun or a compressed air sprayer which charges the powder material so that it sticks to the base metal object receiving the coating. After applying the powder, be careful not to brush or blow on the powder coat, as the powder could fall off and leave you with a less precise finish.
7. Cure the metal at an appropriate temperature for the powder material you are using. Normally the object is heated to 175 to 190°C (350 to 375°F) for about 10 to 15 minutes, and allowed to cool. The curing oven raises the product mass and coated material to a specified temperature for a set time.

# User Guide

## Operation Instructions

1. Place the work piece on the rails and shut the door. Make sure the door is securely closed using the handle.
2. With the key in the lock position the oven will be OFF.
3. Turn the key into the ON Position. The Red power light will light up.
4. Turn the power switch to ON on the control panel. The Green power light will light up and the display screen on the temperature control will turn on.
5. The temperature and time you need to cure will depend on the item and its thickness.
6. Allow the work piece to cool before handling. You will need high temperature gloves and a suit to remove the part from the oven.

### PLEASE NOTE:

When the oven is not in use, ensure that it is correctly turned off and allowed to cool sufficiently before closing up the vented area. The key should be turned to the locked position and then safely locked away. It is recommended that only authorised personnel have access to the key.

# User Guide

## Operation Instructions

### Temperature Display Operation Instructions

#### General

Press the Left arrow to open programing menu

Press and hold the Up arrow to stop the program

Press and hold the Down arrow to run the program

When any changes are made to the program you must stop the program by pressing the Up arrow and then press the Down arrow for the change to take affect.

This will now restart the program from the beginning.

C is the program temp in C – you can program up to 99 different temps  
T- a positive value is time in minutes, a negative value is the corresponding program – e.g-4 would put the program to C004.

#### To set a constant temperature -

e.g 160 C press left to enter program menu.

Set C001 to 160 – set T001 to 0.

#### To set a Ramp - Example below -

To set a ramp 160 to 170 over 15 minutes and then hold at 170 you should enter-

C001 = 160

T001 = 15

C002 = 170

T002 = 0

# User Guide

## Operation Instructions

### **To set a Step - Example below -**

To set a 15 minute ramp from 160 to 170 followed by a step to 180 and hold at 180 you should enter the following-

C001 = 160

T001 = 15

C002 = 170

T002 = -3

C003 = 180

C003 = -0

### **To set a Soak - Example Below -**

To set a 15 minute ramp from 160 to 170 followed by 15 minute soak followed by 10 minute ramp back to 160 and hold you should enter the below-

C001 = 160

T001 = 15

C002 = 170

T002 = 15

C003 = 170

T003 = 15

C004 = 160

C004 = 0

# User Guide

## Operation Instructions

### EXAMPLE

To create the graph below follow these settings.

C001 = 160

T001 = 10

C002 = 170

T002 = 10

C003 = 170

T003 = -4

C004 = 180

T004 = 10

C005 = 180

T005 = 10

C006 = 190

T006 = 10

C007 = 190

T007 = 20

C008 = 175

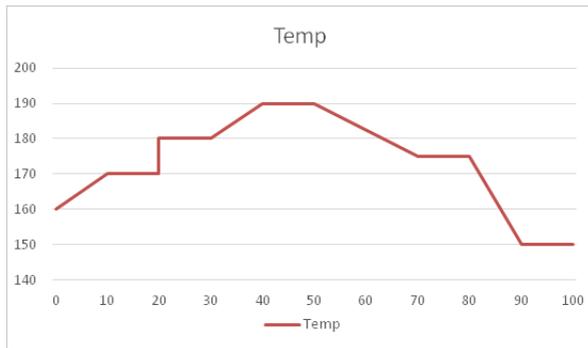
T008 = 10

C009 = 175

T009 = 10

C010 = 150

C015 = 0



This can be manipulated to your own required times and temperatures.



# Troubleshooting

## Resolution Guide

Please read through the guide below if you have any issues or faults with your device. The information covers and resolves the majority of frequently asked questions.

**Q: There are parts missing from my order.**

A: If there appears to be any part missing from your package contact our Customer Support team via the details on the Contact Us page within 7 days of receipt.

**Q: The oven will not turn on.**

A: The power supply may not meet the requirements of the specification. Check that you have the correct power supply, and that it is supplying the correct voltage. Check that the power cord plug has not become loose.

**Q: The switch is not on but the temperature keeps rising in the oven.**

A: The heating AC contactor may be bonded together. You will need to replace the AC contactor. Seek professional advice if unsure.

**Q: The temperature is unusually high.**

A: The thermcouple may not be working and may need to be replaced. However the work piece may not be placed in the oven correctly or the door may not be shut tight. You can easily move the work piece, but make sure the machine is turned off first, as when closing the door.

**Q: There appears to be an electrical fault.**

A: Do not touch or tamper with any of the wires or components. Repair or maintenance of inside the control box should only be carried out by skilled electricians.

For all other issues please contact our Customer Support department via the details on the Contact page.

# Contact Us

## Sales Department

For information regarding this device or other products from our Monster divisions please use the following details below.

Tel: 01347 878888

Email: [hello@monstershop.co.uk](mailto:hello@monstershop.co.uk)

## Support Department

For queries about this device, warranty, returns or reporting faults please use the following details below.

Tel: 01347 878887

Email: [help@monstershop.co.uk](mailto:help@monstershop.co.uk)

## Website

To view our product range and fantastic offers in the Monster Chef division please visit our website

[www.monstershop.co.uk](http://www.monstershop.co.uk)

## Address

To visit our office Monster House and view our products, send postal correspondence or return items our address is provided below.

Monster House, Alan Farnaby Way, Sheriff Hutton  
Industrial Estate, Sheriff Hutton, York YO60 6PG



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