Lincoln®

Consistency You Can Count On

Lincoln Aperion 24 Impinger® Conveyor Oven

Parts Manual
For 50 Hz

Models:
1624, 2024, 2424, 2824
Gas and Electric

Original Document
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ALI GROUP

WELBILT an ALI Group Company

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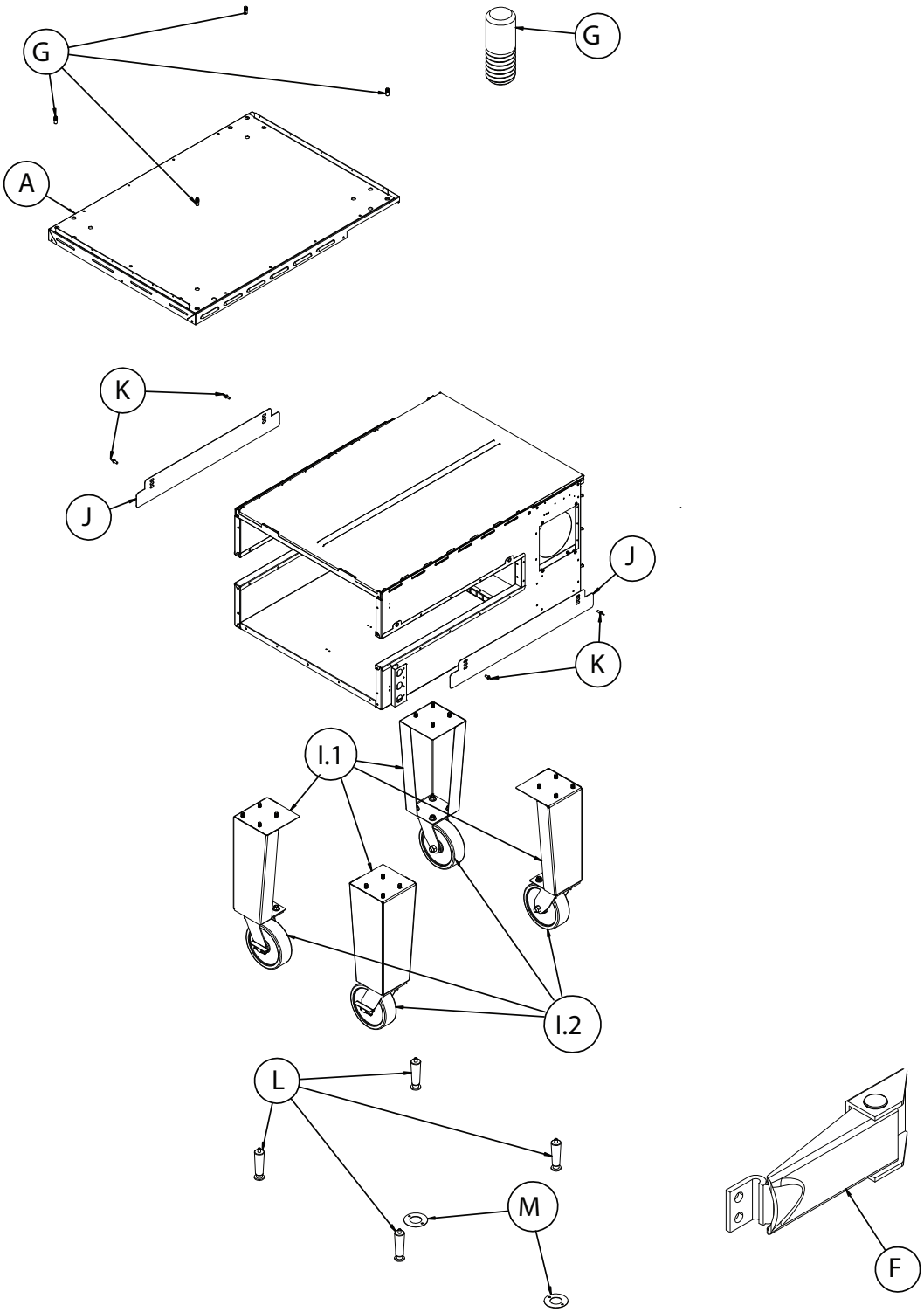
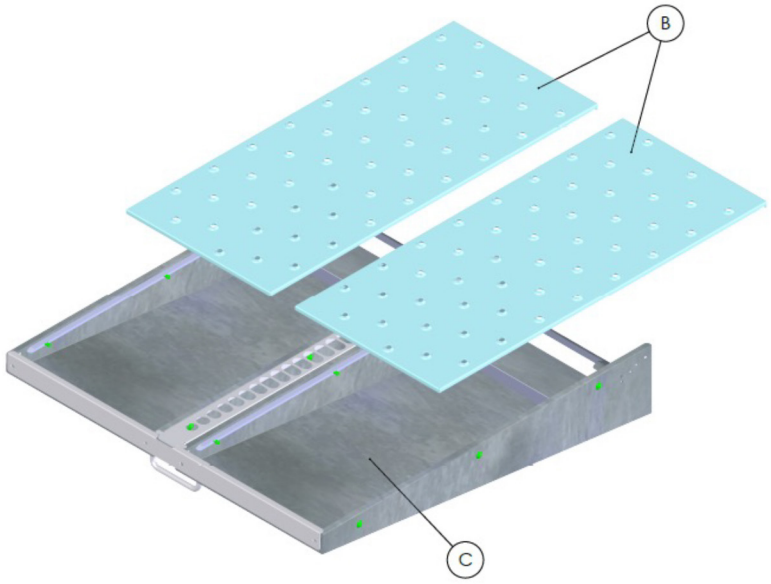
MAIN CAVITY

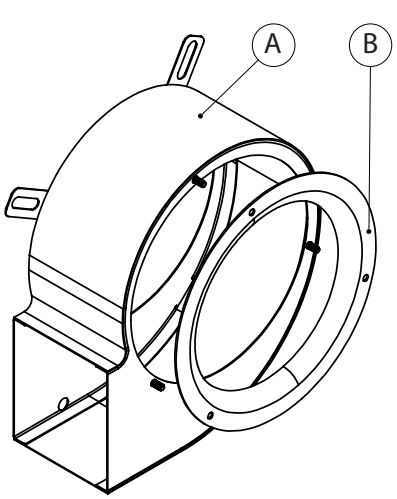


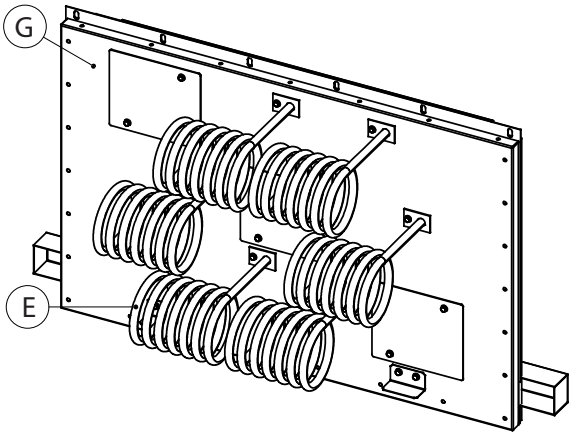
MAIN CAVITY

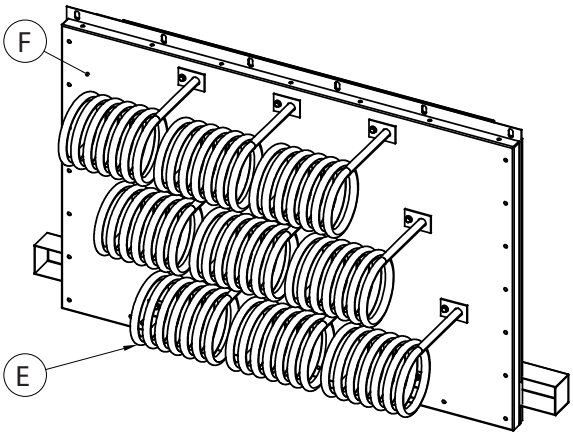
LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	TOP COVER - STACKING KIT	4608576	4609331	4608493	4610145
B	FINGER JET PLATE	4608541	4609226	4604975	4609189
C	FINGER HOUSING ASSEMBLY	CK4612806	CK4612807	CK4612808	CK4612809
F	LATCH AND CATCH	369501			
G	PARTIALLY THREADED ROD - METRIC	4612651			
I.1	LEG	369328			
I.2	CASTER	369030			
J	BAFFLE	4610203	4610211	4610195	4610207
K	THUMB SCREW - METRIC	4612805			
L	LEG, 100 MM - METRIC	4612643			
M	MOUNTING RING	369451			

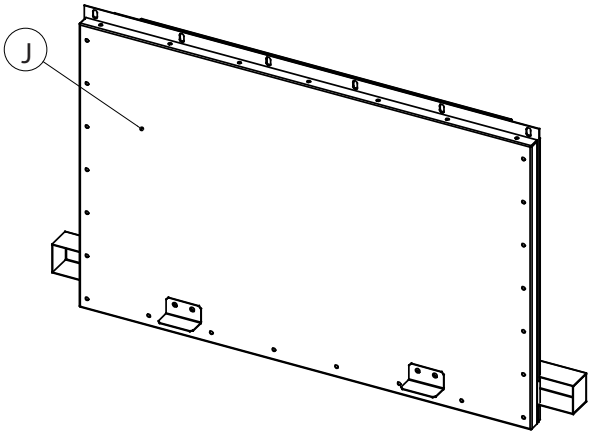


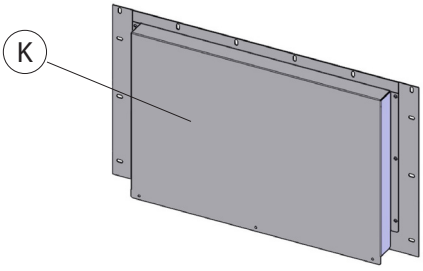
ELEMENT & BLOWER HOUSING ASSEMBLY

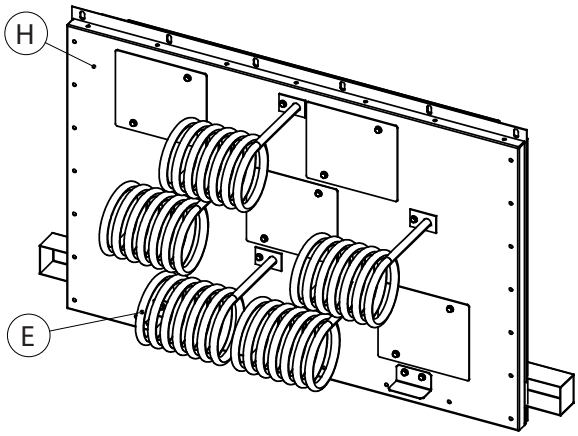


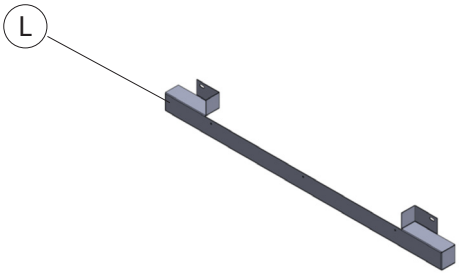








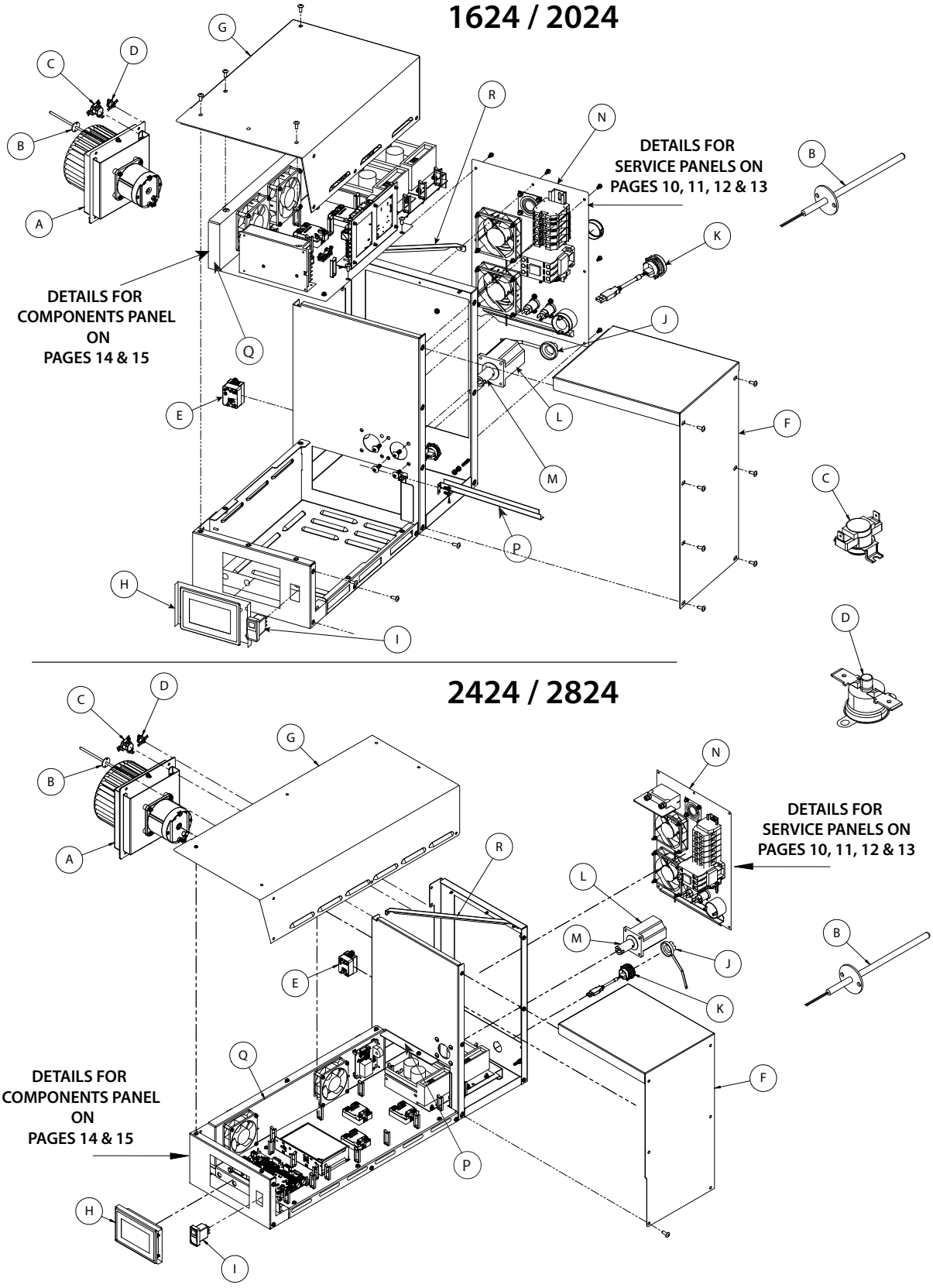




ELEMENT & BLOWER HOUSING ASSEMBLY

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	BLOWER HOUSING	4605392			
B	BLOWER INLET CONE	4605621			
E	HEATING ELEMENT, 240V, 2000W	4609707			
F	REAR WALL ASSEMBLY 9 HEATING ELEMENTS, ELECTRIC MODELS (INCLUDES HEATING ELEMENTS)	CK4610278			
G	REAR WALL ASSEMBLY 6 HEATING ELEMENTS, ELECTRIC MODELS (INCLUDES HEATING ELEMENTS)	CK4610279			
H	REAR WALL ASSEMBLY 5 HEATING ELEMENTS, ELECTRIC MODELS (INCLUDES HEATING ELEMENTS)	CK4610282			
J	REAR WALL ASSEMBLY, GAS MODELS	CK4607546			
K	REAR WALL ASSEMBLY COVER APERION	CK4613529			
L	WIRE CHANNEL	4611743			

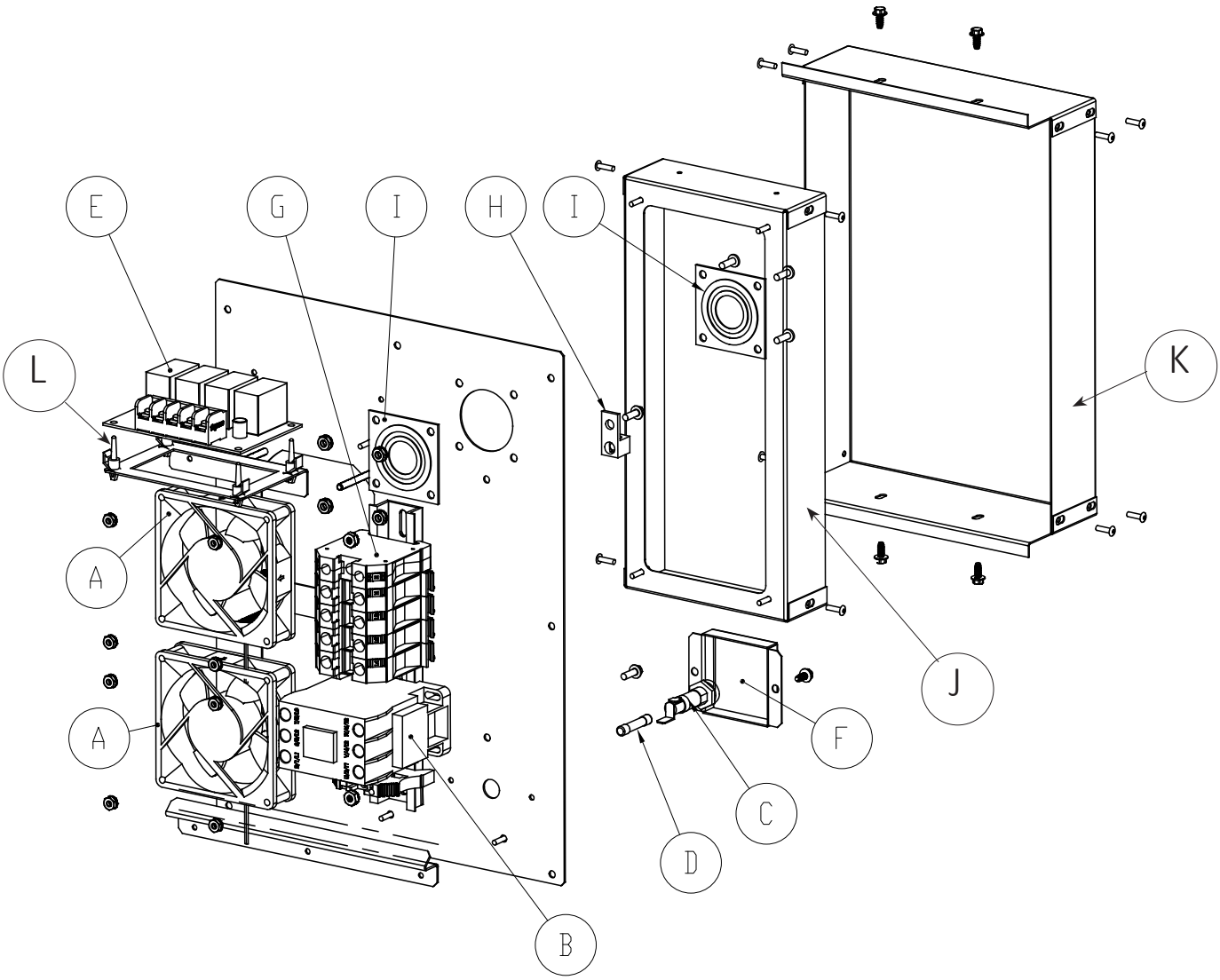
RIGHT CONTROL BOX - ELECTRIC & GAS



RIGHT CONTROL BOX - ELECTRIC & GAS

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBERS			
A	FAN MOTOR ASSEMBLY	CK4605340			
B	THERMOCOUPLE	4603578			
C	THERMOSTAT COOLING FAN	369507			
D	THERMAL DISCONNECT	4605622			
E	HIGH LIMIT THERMOSTAT CAPILLARY	4607695			
F	COVER, SIDE, CORNER, CTRL BOX	4605019			
G	COVER, L-SHAPE, CTRL ELEC BOX	4608562	4609293	4608449	4609220
H	COMMON 4.3" UI, ASSEMBLY INCLUDES MOUNTING BRACKET AND BEZEL SEAL	CK4609353 (non-ventless models) or CK4611280 (ventless models)			
I	MAIN POWER SWITCH	4600614			
J	USB SEALING CAP	4532043			
K	USB PANEL MOUNT	4532040			
L	CONVEYOR MOTOR (INCLUDES COUPLING)	CK4605922			
M	COUPLING SLEEVE (INCLUDES SET SCREW)	CK4605921			
N	SERVICE PANEL ASSEMBLY	SEE SERVICE PANEL PAGE 10-13			
P	DRIP TRAY APERION	4608739			
Q	COMPONENT PANEL ASSEMBLY	SEE COMPONENT PANEL PAGE 14-15			
R	CORNER BRACE	4606621			
NOT SHOWN	ETHERNET PATCH CORD (UI TO I/O BOARD)	4607498			
NOT SHOWN	HI-LIMIT MOUNTING BRACKET	4610121			
NOT SHOWN	USB EXTENSION	4610286		4607876	
EXPORT ELECTRIC WIRE HARNESS					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610220		4610257	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS), 3 PHASE MODELS	4611077			
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS), 1 PHASE MODELS	4611099			
NOT SHOWN	REAR WIRE HARNESS	4605295			
NOT SHOWN	HEATING ELEMENTS WIRING HARNESS	XX24-SXX (3 PHASE): 4610287 XX24-LXX (3 PHASE): 4610288 XX24-LXX (1 PHASE): 4610289			
EXPORT GAS WIRE HARNESS					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610492		4610491	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS)	4612717			
NOT SHOWN	REAR WIRING HARNESS	4609804			
NOT SHOWN	LEFT TOWER WIRING HARNESS	4609785			

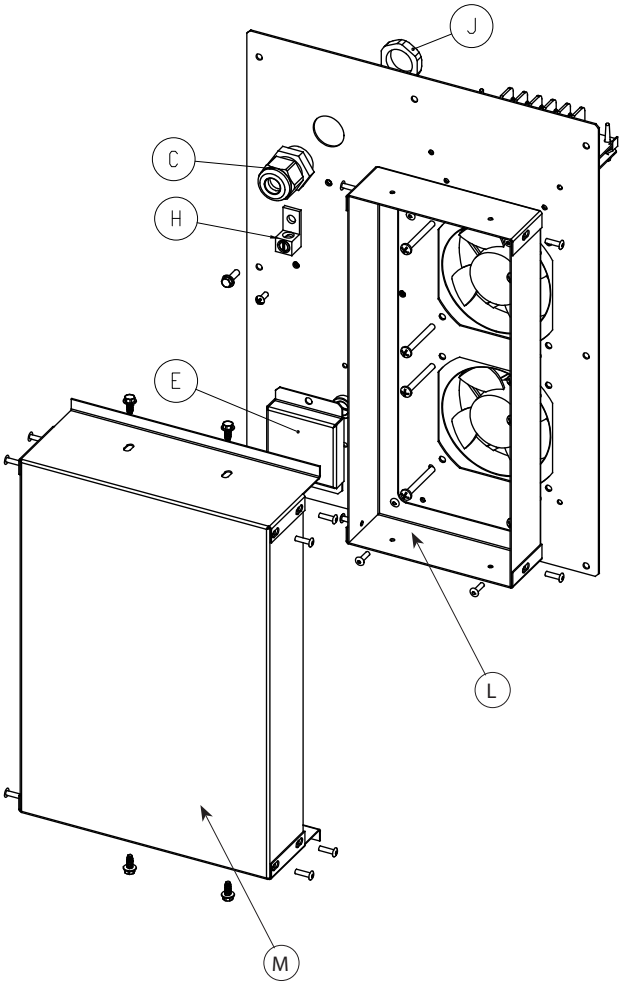
SERVICE PANEL - ELECTRIC

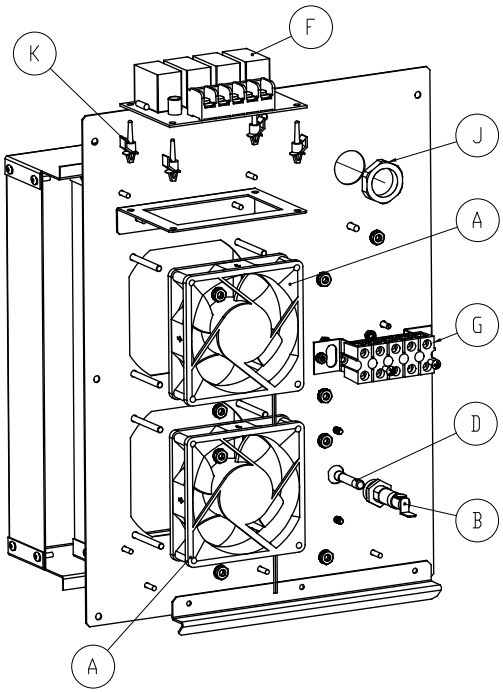


SERVICE PANEL - ELECTRIC

LETTER	DESCRIPTION	PART NUMBERS
A	COOLING FAN 24 VDC	4608567
B	CONTACTOR	370739
C	FUSE HOLDER	357107
D	FUSE 10A	369014
E	EMC FILTER 3 PHASE	4603121
F	FUSE COVER	4609334
G	TERMINAL BLOCK 5 (INCLUDING RAIL)	4609840
H	GROUND LUG	370364
I	KNOCK OUT PLATE	G1053-3-8
J	IPX COVER INNER	4611026
K	IPX COVER OUTER	4611027
L	STAND-OFF MALE, SNAP IN	369856

SERVICE PANEL - GAS



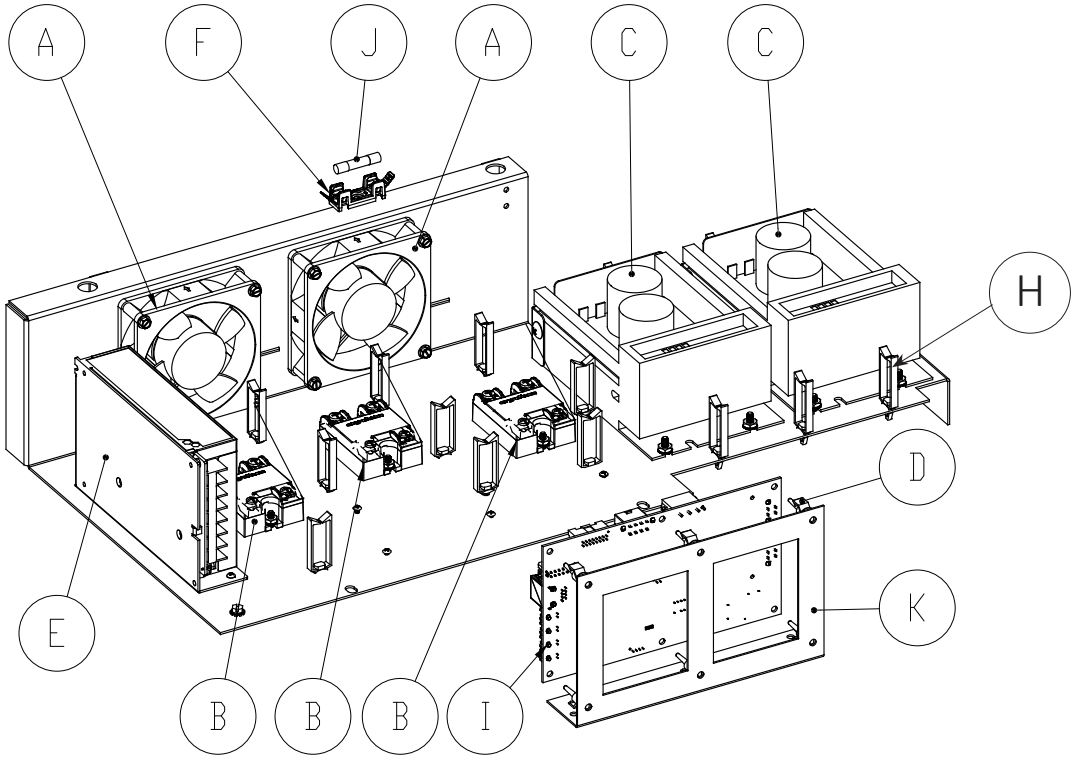


SERVICE PANEL - GAS

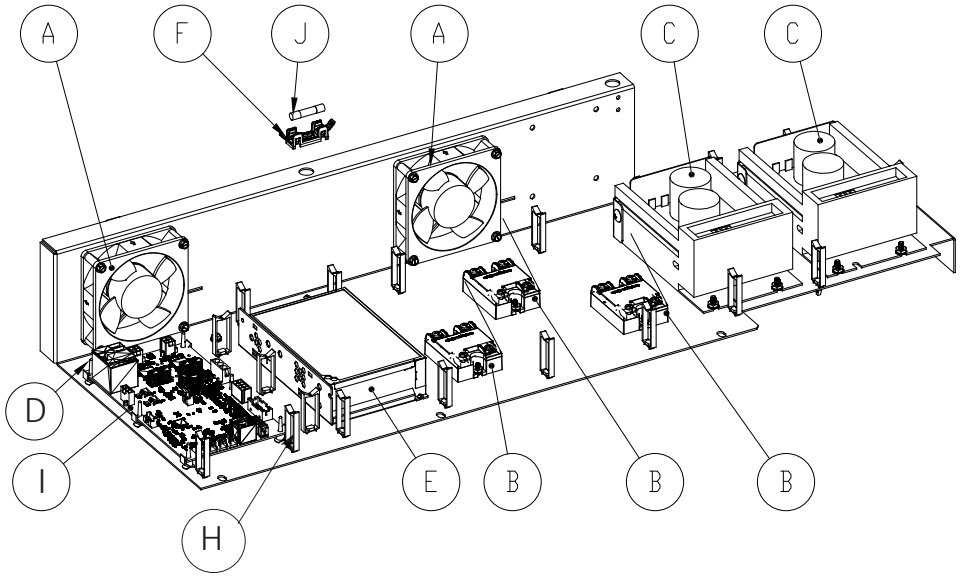
LETTER	DESCRIPTION	PART NUMBERS
A	COOLING FAN 24 VDC	4608567
B	FUSE HOLDER	357107
C	STRAIN RELIEF DOME NUT	4070543
D	FUSE 10A	369014
E	FUSE COVER	4609334
F	EMC FILTER 3 PHASE	4603121
G	TERMINAL BLOCK 5 POLE	370117
H	GROUNG LUG	370364
J	NUT LOCK	4070549
K	STAND-OFF MALE SNAP-IN	369856
L	IPX COVER INNER	4611026
M	IPX COVER OUTER	4611027

COMPONENT PANEL - ELECTRIC & GAS

1624 / 2024



2424 / 2824

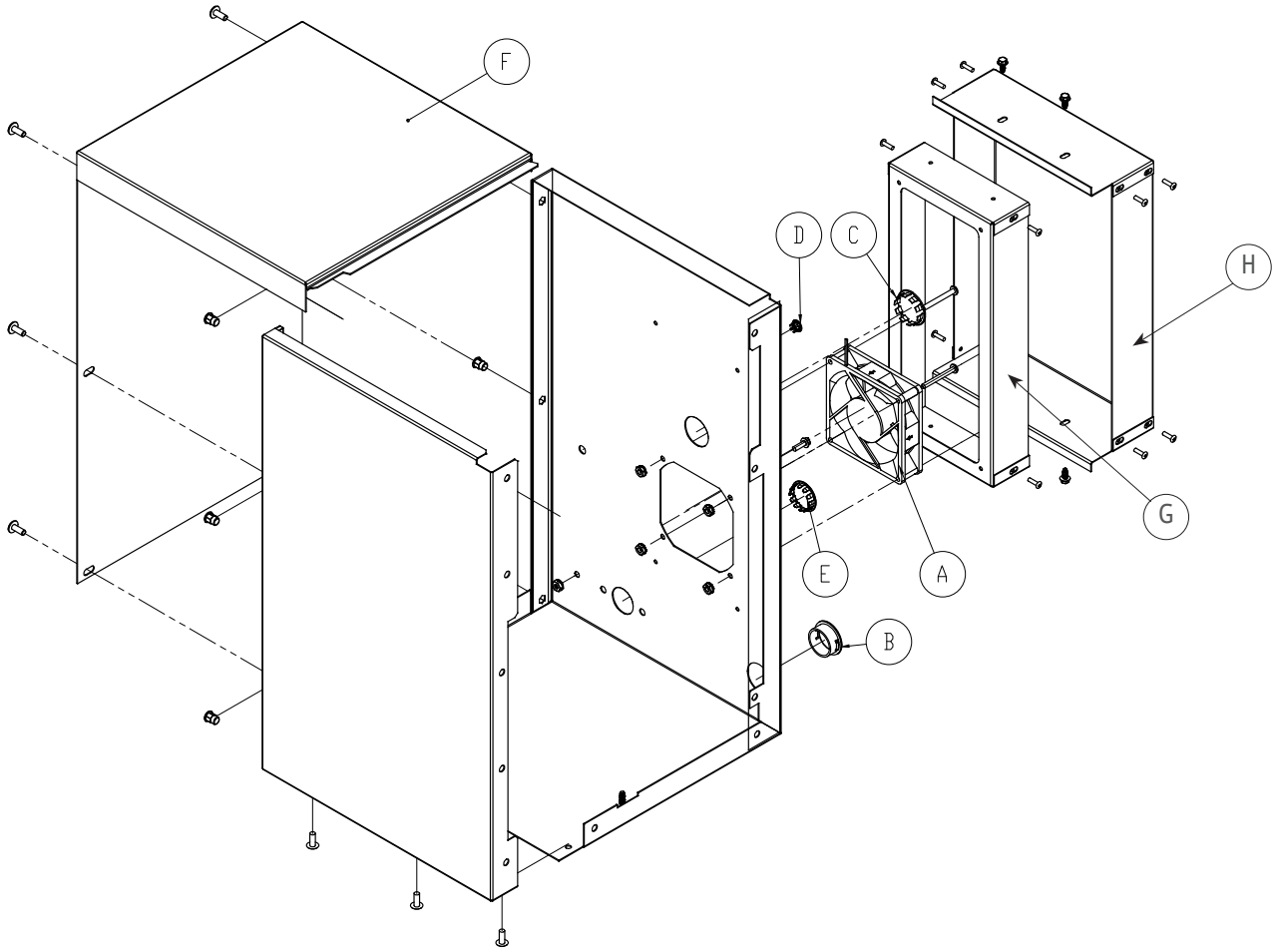


COMPONENT PANEL - ELECTRIC & GAS

LETTER	DESCRIPTION	PART NUMBER
A	COOLING FAN, 24VDC	4608567
B	SSR, 50A, 1 POLE (3 PC.FOR ELECTRIC; 1 PC. FOR GAS)	4605506
C	BLOWER MOTOR DRIVER	4605923
D	STANDOFF, MALE SNAP-IN	369856
E	POWER SUPPLY	4604751
F	FUSE BLOCK, 20A 600V, CHASSIS MOUNT	2320700
H	WIRE SADDLE	4600840
I	I/O BOARD LINCOLN	CK4609352
J	FUSE, 4A 600V	4606033
K	I/O SUPPORT BRACKET	4607165
NOT SHOWN	TERMINATION RESISTOR 120 OHM	4608140

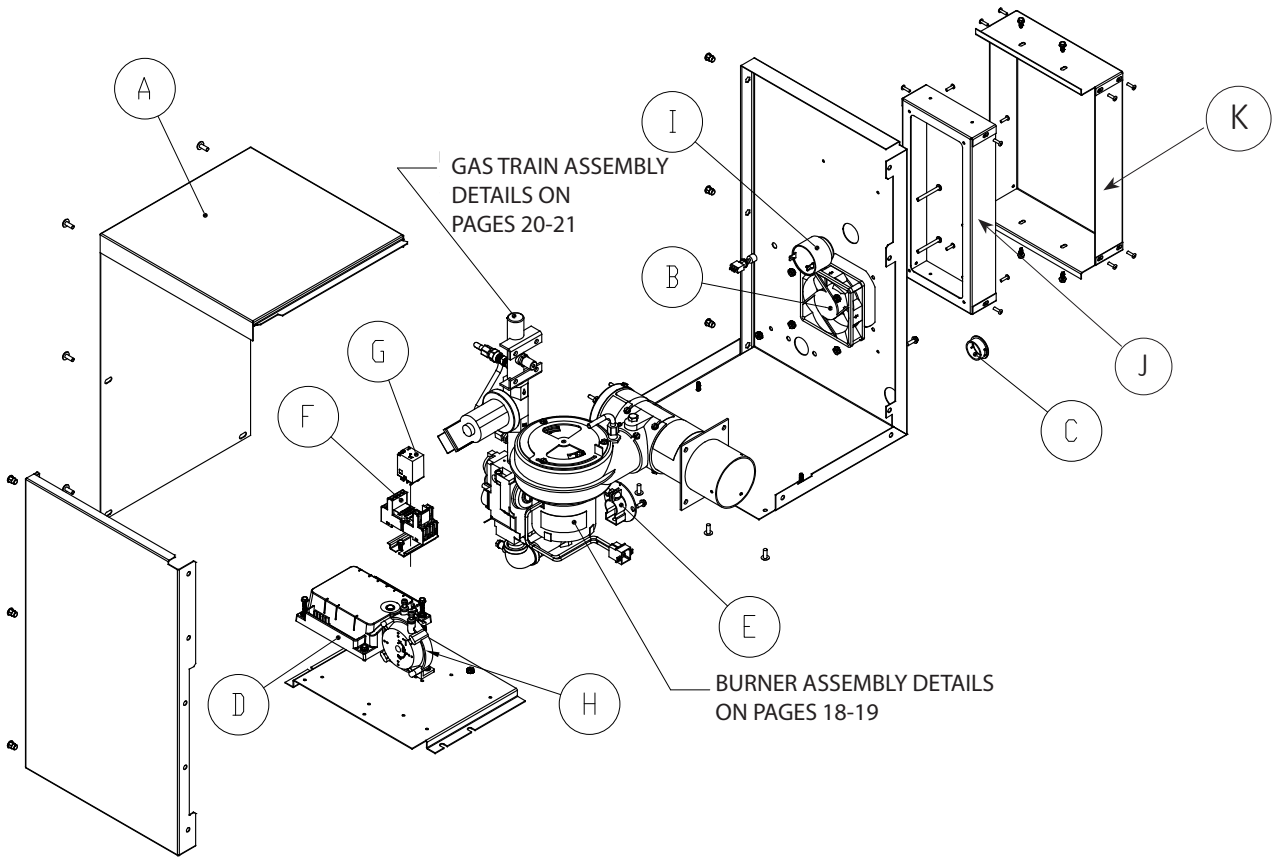
LETTER	PART NUMBER	DESCRIPTION	QTY NEEDED PER MODEL			
			1624	2024	2424	2824
NOT SHOWN	4607498	ETHERNET PATCH CORD (FOR ALL MODELS)	1	1	1	1
NOT SHOWN	4610285	ETHERNET PATCH CORD, ANGLED	1	1	1	1

LEFT CONTROL BOX - ELECTRIC



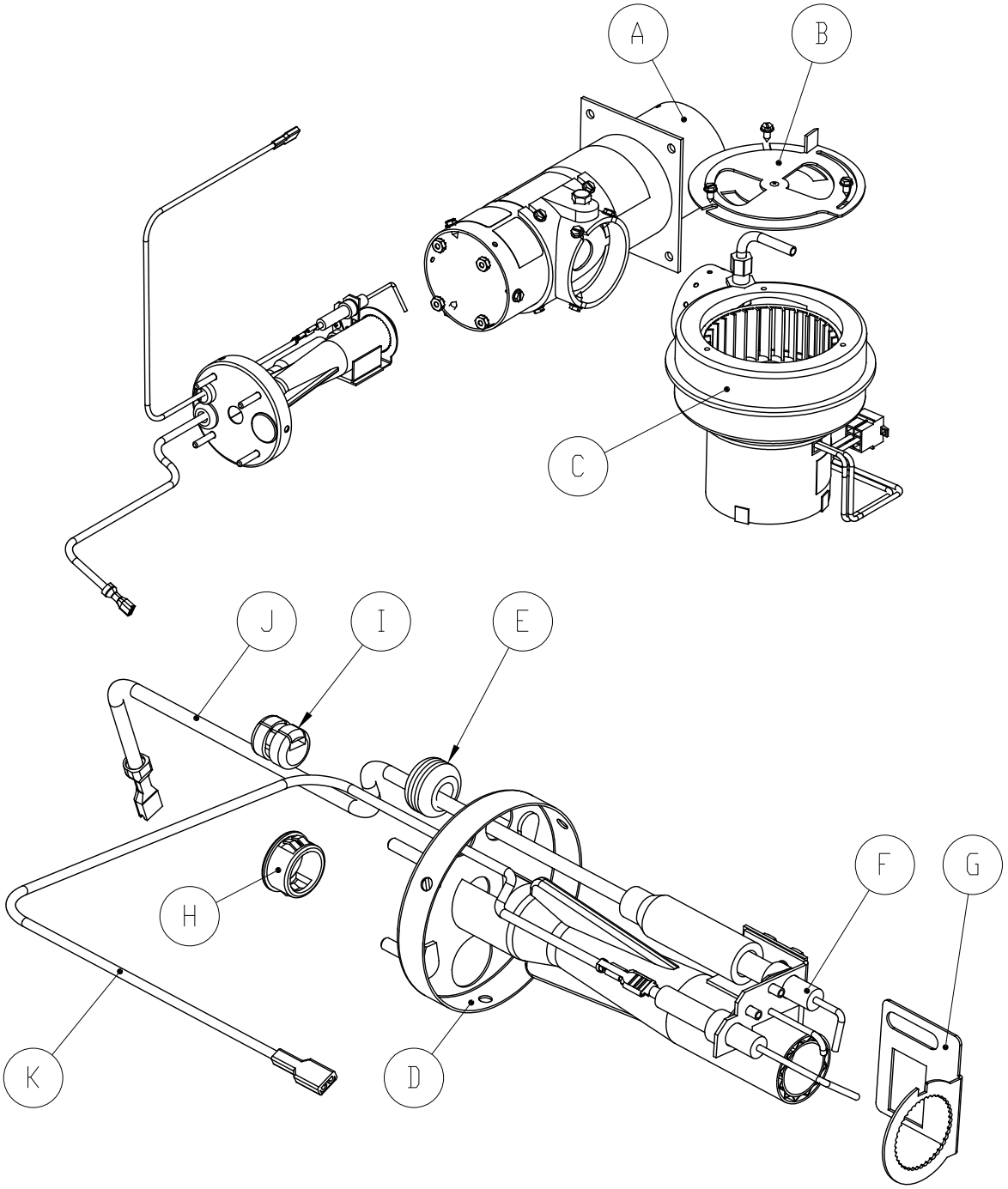
LETTER	DESCRIPTION	PART NUMBERS
A	COOLING FAN 24 VDC	4611295
B	SNAP BUSHING 1.125"	4070132
C	PLUG BUTTON 1.125"	2401009
D	PLUG BUTON 0.312"	370349
E	PLUG BUTON 1.000"	1473304
F	SIDE COVER LH SIDE CONTROL BOX	4611295
G	IPX COVER INNER	4611026
H	IPX COVER OUTER	4611027

LEFT CONTROL BOX - GAS



LETTER	DESCRIPTION	PART NUMBERS
A	SIDE COVER LH SIDE CONTROL BOX	4611295
B	COOLING FAN 24 VDC	4608567
C	SNAP BUSHING 1.125"	4070132
D	IGNITION MODULE, TECHRITE	4604018
E	BULK HEAD ASSEMBLY	371539
F	RELAY BASE	4608479
G	RELAY - DPDT 10A, 220-240VAC COIL	4609315
H	AIRSWITCH	370673
I	ALARM, 240V	369579
J	IPX COVER INNER	4611026
K	IPX COVER OUTER	4611027

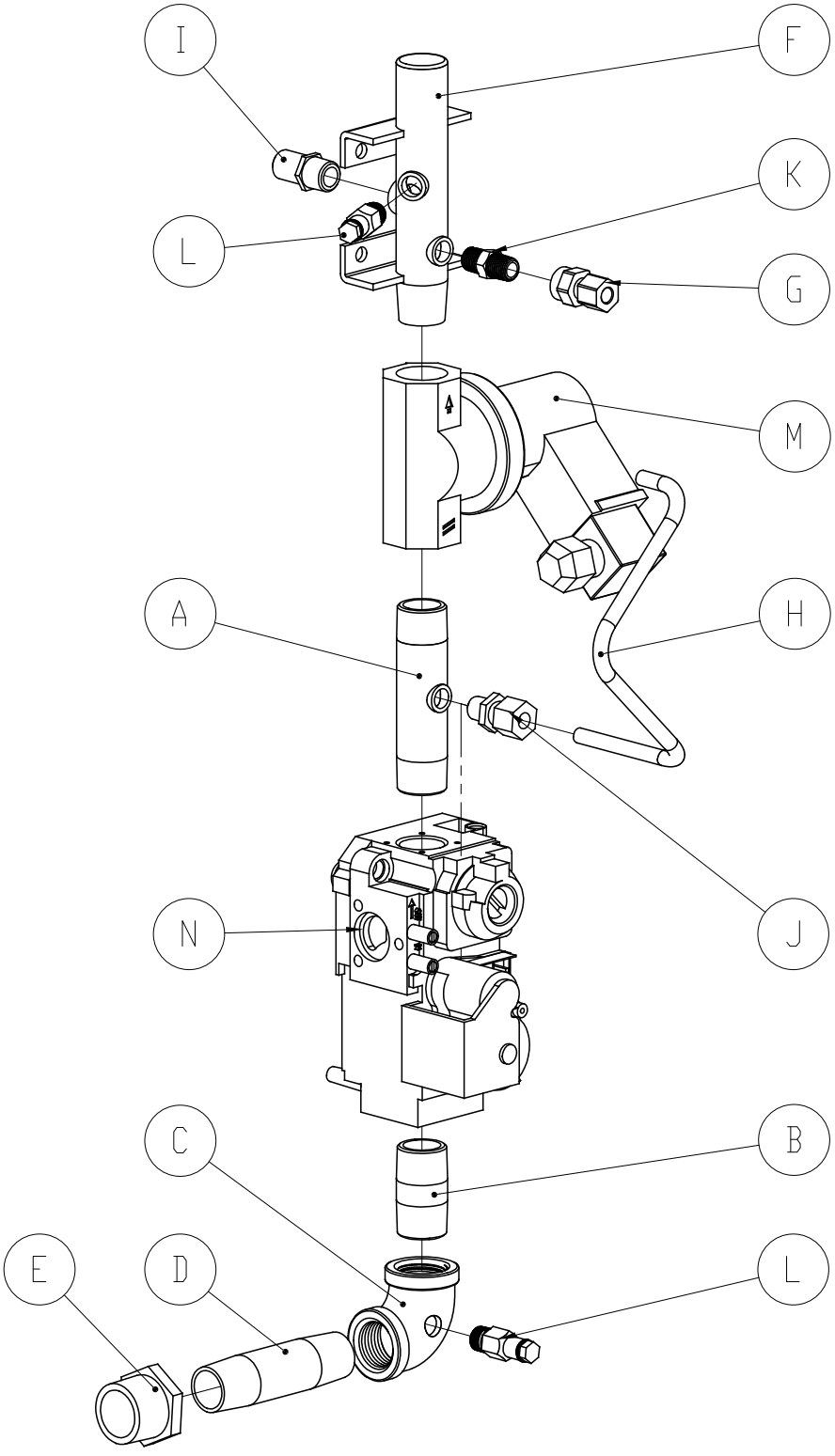
BURNER ASSEMBLY



BURNER ASSEMBLY

LETTER	DESCRIPTION	PART NUMBER	
		NATURAL GAS	PROPANE
A	BURNER TUBE ASSEMBLY	4608646	
B	AIR SHUTTER ASSEMBLY	11010005747	
C	BLOWER MOTOR ASSEMBLY	4612707	
D	VENTURI ASSEMBLY	11010005732	11010005729
E	GROMMET	11010005759	
F	SPARK IGNITOR AND FLAME SENSOR ASSEMBLY	4603797	
G	RING BRACKET VENTURI	4603783	
H	SITE GLASS	390131	
I	BUSHING HEYCO 1167	4071223	
J	IGNITOR CABLE	11010005771	
K	FLAME SENSOR CABLE	4071207	

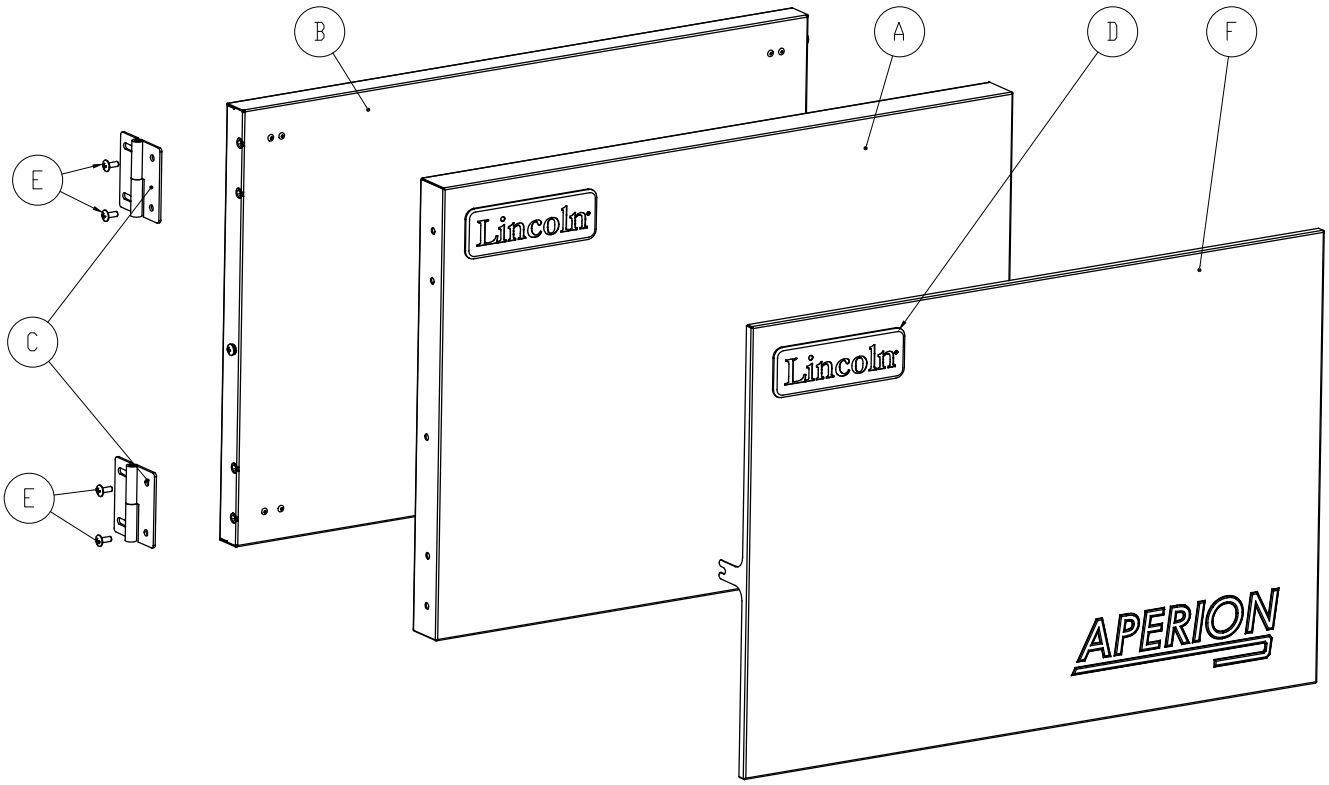
GAS TRAIN ASSEMBLY



GAS TRAIN ASSEMBLY

LETTER	DESCRIPTION	PART NUMBER	
		NATURAL GAS	PROPANE
A	NIPPLE 1/2 NPT X 3 E-FLOW	G01477-13	
B	NIPPLE 1/2 NPT X 1-1/2 E-FLOW	369979	
C	ELBOW 1/2 NPT 90 B.I. E-FLOW	369559	
D	NIPPLE 1/2 NPT X 3	369970	
E	REDUCER NPT 3/4M - 1/2FIMPINGER OVENS	369971	
F	ORIFICE MANIFOLD PGCD	369577	
G	CONNECTOR FEMALE 1/4 TUBE X 1/8 NPT	369577	
H	TUBE BYPASS	4612702	
I	MAIN ORIFICE	369757	369758
J	COMPRESSION FITTING 1/4 OD TUBING X 1/8 NPT	2601109	
K	BYPASS ORIFICE	4607570	369557
L	PRESSURE TEST SPIGOT	02251-1	
M	VALVE 85294101 THERMOSTATICALLY CONTROLLED	370186	
N	VALVE VK4115 A 1000	370400	
NOT SHOWN	BULK HEAD ASSEMBLY	371539	

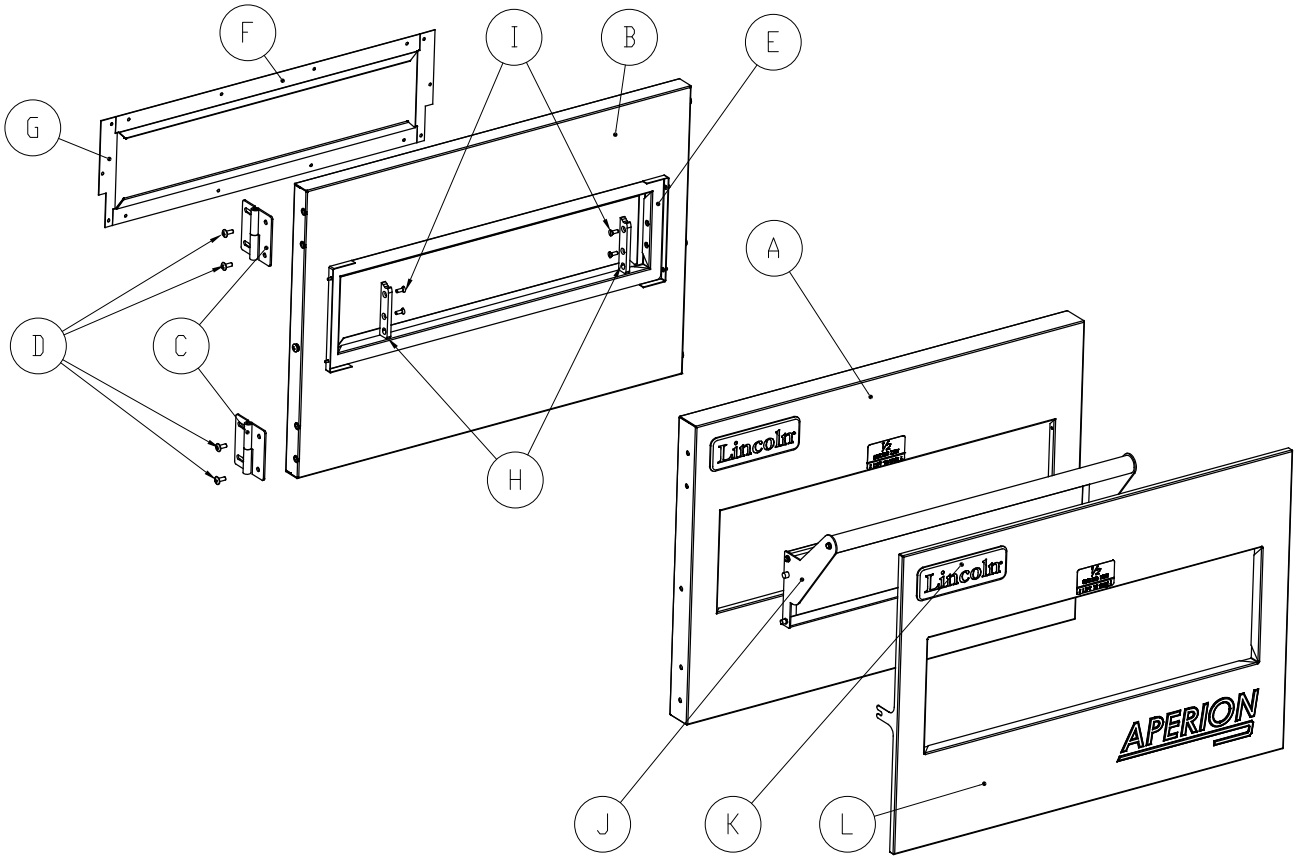
DOOR ASSEMBLY - SOLID



DOOR ASSEMBLY - SOLID

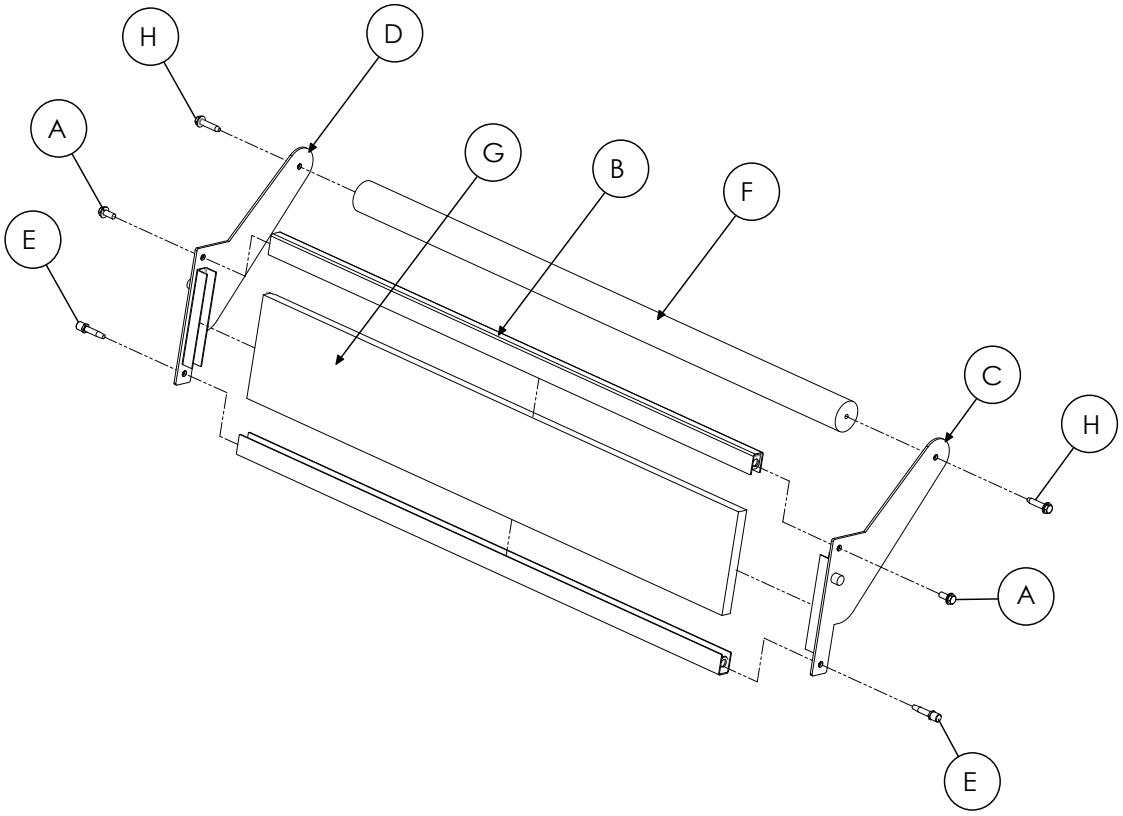
LETTER	DESCRIPTION	PART NUMBER
A	SERVICE KIT - COVER OUTER DOOR 2424	CK4610200
B	SERVICE KIT – DOOR SUBASSEMBLY	CK4610199
C	DOOR HINGE	4605861
D	NAMEPLATE IMPINGER	370016
E	#10-24x1/2IN PHILLIPS	8003128
F	COOL TOUCH PANEL, SOLID DOOR	4611796
NOT SHOWN	LATCH AND CATCH	369501
FULL ASS'Y	DOOR ASS'Y SOLID	371553

DOOR ASSEMBLY WITH WINDOW



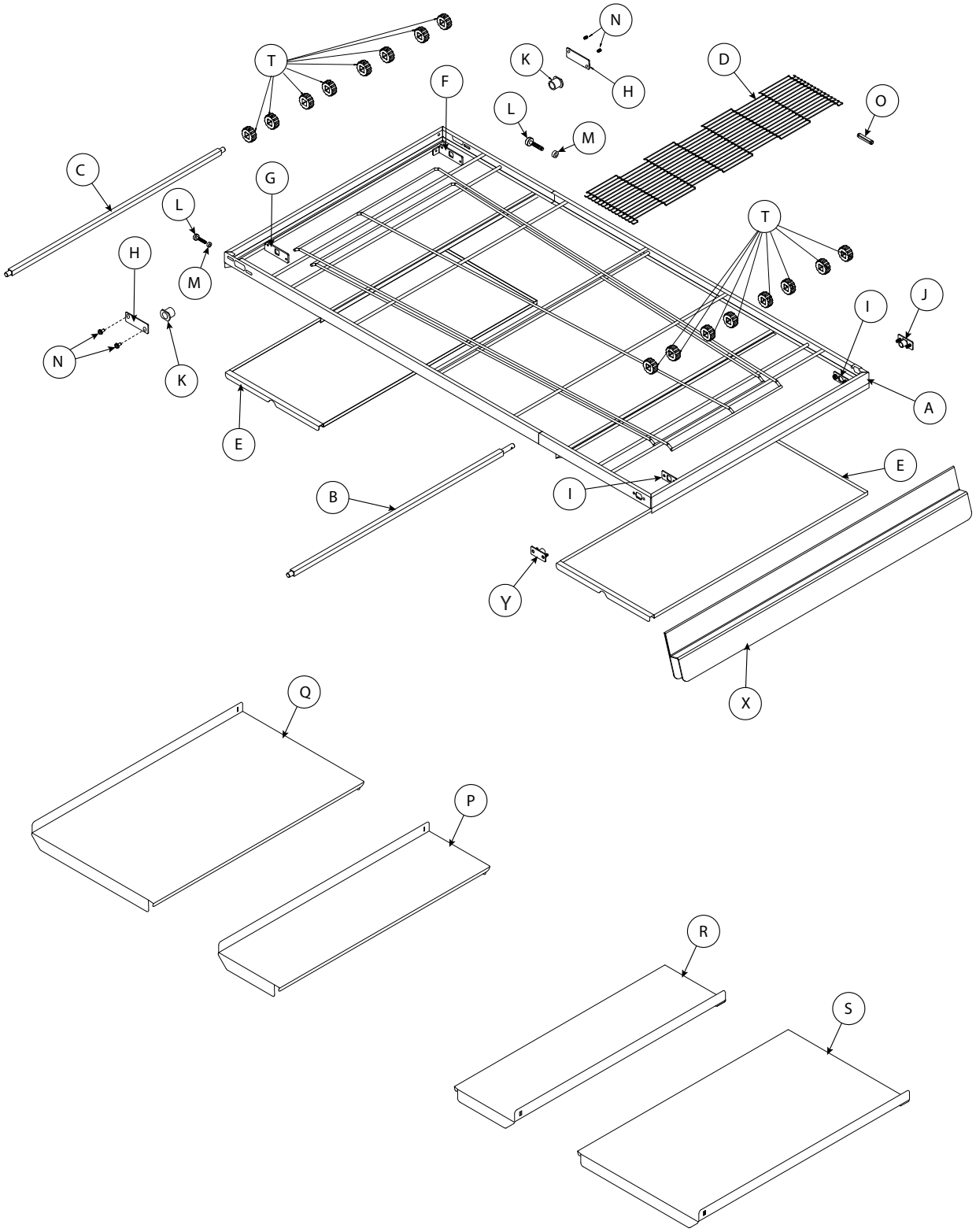
LETTER	DESCRIPTION	PART NUMBER
A	COVER OUTER DOOR, WINDOW	4609460
B	INSIDE DOOR ASSEMBLY, WINDOW	CK4609458
C	DOOR HINGE	4605861
D	#10-24x1/2IN PHILLIPS	8003128
E	ACCESS FRAME ASSEMBLY, APERION	4609463
F	ACCESS WINDOW RETAINER, APERION	4609476
G	ACCESS WINDOW SEAL, APERION	4609535
H	WINDOW RETAINER, APERION	4609534
I	SCR FHW/PAT#8-32X3/8	369931
J	ACCESS WINDOW COMPLETE (SEE DETAILS NEXT PAGE)	371558
K	NAMEPLATE IMPINGER	370016
L	COOL TOUCH PANEL, WINDOW DOOR	4611843
NOT SHOWN	LATCH AND CATCH	369501
FULL ASS'Y	DOOR ASS'Y WINDOW	371554

ACCESS WINDOW GLASS



LETTER	DESCRIPTION	PART NUMBER
A	SCREW #8-32 x 3/8 HEX HD SERR FLANGE	371143
B	ACCESS DOOR FRAME ASSEMBLY	371144
C	BRACKET ASSEMBLY LH ACCESS DOOR	371140
D	BRACKET ASSEMBLY RH ACCESS DOOR	371141
E	DOWEL THREAD, ACCESS DOOR	370725
F	DOWEL, ACCESS DOOR	371142
G	ACCESS DOOR GLASS	370723
H	SCREW #8-32 x 3/4-B; S/S	370722
NOT SHOWN	WINDOW RETAINER	4609534
	ACCESS DOOR ASS'Y COMPLETE	371558

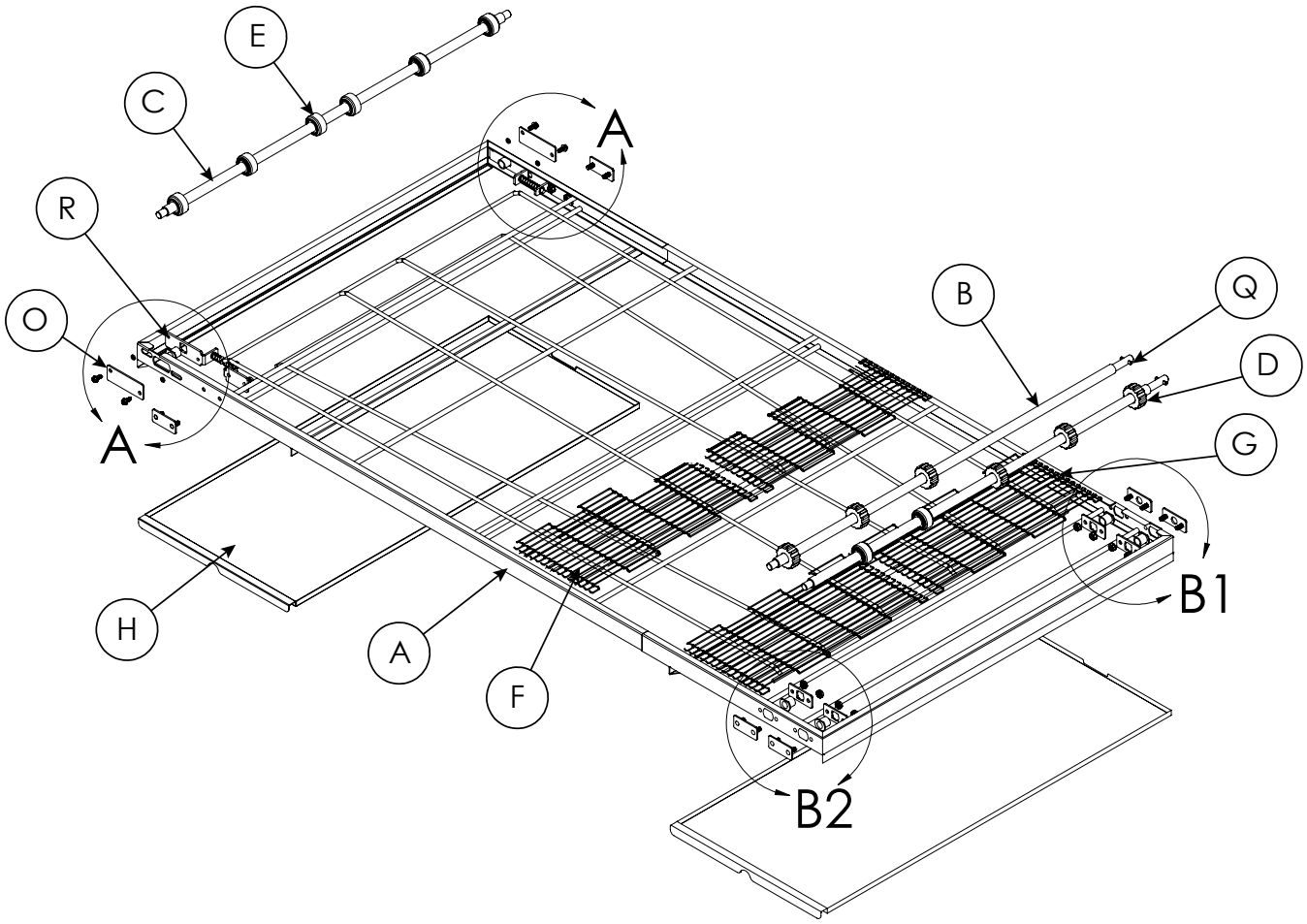
CONVEYOR ASSEMBLY - SOLID BELT

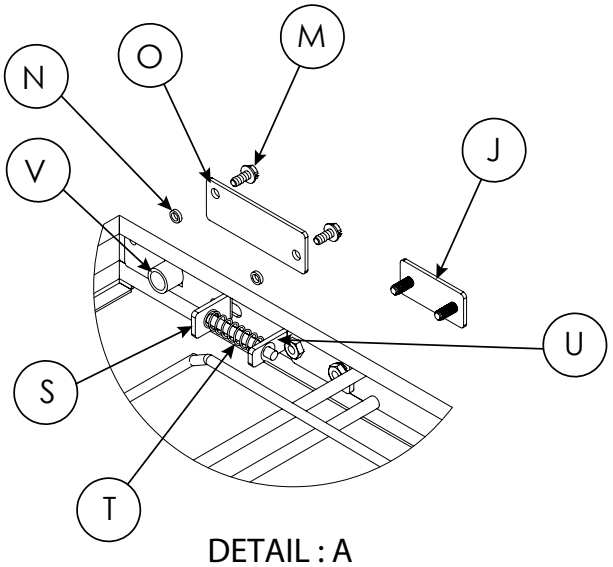


CONVEYOR ASSEMBLY - SOLID BELT

LETTER	DESCRIPTION	PART NUMBER			
		1624	2024	2424	2824
	COMPLETE CONVEYOR ASSEMBLY	4608516	4609245	4605743	4609277
A	FRAME ASSY	4608509	4609246	4605386	4609278
B	DRIVE SHAFT	4608512	4609260	4605747	4609311
C	IDLE SHAFT	4608510	4609258	4605748	4609295
D	BELT, CONVEYOR	4608514	4609261	4605744	4609288
E	CRUMB TRAY	4608515	4609255	4605384	4609298
F	BRACKET ADJ LH	4605920			
G	BRACKET ADJ RH	4605757			
H	BRACKET, ADJUST CLAMP	4605756			
I	BRACKET, BUSHING I.S.	4605753			
J	ASSEMBLY BRACKET BUSHING	4605749			
K	BUSHING, FLANGED	4605752			
L	10-32 X 1 KNURLED HEAD THUMB SCREW SS	4605754			
M	SPACER 3/8 D x 5/32 L	4605755			
N	10-32 X 3/8 FLANGE SCREW	4605772			
O	SLOTTED SPRING PIN	4605773			
P	TRAY ENTRY 6″	L1606	L2006	L2406	L2806
Q	TRAY ENTRY 12″	L1612	L2012	L2412	L2812
R	TRAY EXIT 6″	L1607	L2007	L2407	L2807
S	TRAY EXIT 12″	L1613	L2013	L2413	L2813
T	SPROCKET 12 TOOTH	369515			
X	PAN STOP	4609378	4609378	4609373	4609373
Y	STUD PLATE	4605751			
NOT SHOWN	SPLICE CLIP, .050 DIA WIRE	4608570	4609319	4608265	4609314

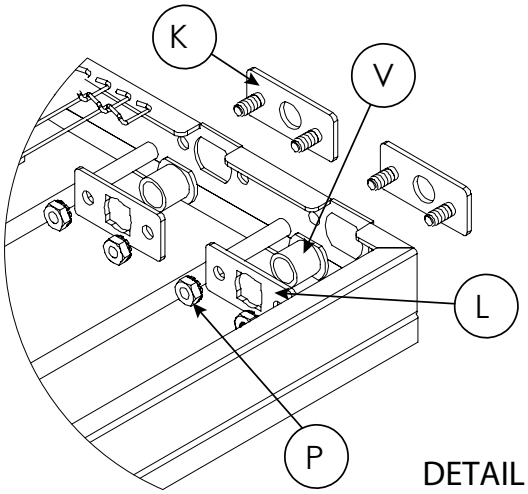
CONVEYOR ASSEMBLY - SPLIT BELT





DETAIL : A

FOR B2, USE
ITEM J INSTEAD OF K



DETAIL : B1

CONVEYOR ASSEMBLY - SPLIT BELT

LETTER	DESCRIPTION	PART NUMBER		
		2424 50/50	2424 30/70	2824 40/60
	COMPLETE CONVEYOR ASSEMBLY	4610740	4610720	4610749
A	FRAME ASSY	4610404	4610709	4610563
B	DRIVE SHAFT, FRONT / REAR	4610712		4610756
C	IDLE SHAFT	4610713		4610757
D	SPROCKET 12 TOOTH 1/2 BORE	4610714		
E	IDLE ROUND SPROCKET	4610715		
F	BELT, CONVEYOR FRONT	4610409	4610711	4610409
G	BELT, CONVEYOR REAR	4610409	4608514	
H	CRUMB TRAY	4605384		4609298
J	STUD PLATE	4605751		
K	STUD PLATE W/HOLES	4605749		
L	PLATE BUSHING DRIVE SHAFT	4605753		
M	#8-32 x 3/8 HEX HD SCR W/SLOT DRIVE	4610729		
N	0.166 x 1/4 x 1/16 SS SPACER	4610730		
O	COVER PLATE IDLER SHAFT	4605756		
P	#10-32 HEX KEPS NUT	F715		
Q	SLOTTED SPRING PIN	4605773		
R	BRACKET BELT ADJUSTER RH	4610482		
S	BRACKET BELT ADJUSTER LH	4610484		
T	SPRING BELT ADJUSTER	4610486		
U	BRACKET SPRING STOP	4610487		
V	FLANGED SLEEVE BEARING MODIFIED	4605752		
NOT SHOWN	IDLE SPROCKET BUSHING	4610716		
NOT SHOWN	TRAY ENTRY 6″	L2406		L2806
NOT SHOWN	TRAY ENTRY 12″	L2412		L2812
NOT SHOWN	TRAY EXIT 6″	L2407		L2807
NOT SHOWN	TRAY EXIT 12″	L2413		L2813
NOT SHOWN	PAN STOP	4609373		
NOT SHOWN	SPLICE CLIP, .050 DIA WIRE	4608570		

ACCESSORY KITS

KIT	CONTENTS	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
COUNTERTOP INSTALLATION, SINGLE	SHORT LEGS (4" / 102 mm)	L4612502			
COUNTERTOP INSTALLATION, DOUBLE STACKING	SHORT LEGS (4" / 102 mm), HEAT SHIELDS	L4612652			
FLOOR INSTALLATION, SINGLE	TALL LEGS, 6" CASTERS W/BRAKES, ADJUSBLE RESTRAINING CABLE	L4612503			
FLOOR INSTALLATION, DOUBLE STACKING	TALL LEGS, 6" CASTERS W/BRAKES, ADJUSBLE RESTRAINING CABLE, HEAT SHIELDS	L4612653			
1624/2024 FLOOR INSTALLATION, TRIPLE STACKING	FRAME STAND, 6" CASTERS W/BRAKES, ADJUSBLE RESTRAINING CABLE, HEAT SHIELDS	L4612505			
2424/2824 FLOOR INSTALLATION, TRIPLE STACKING	6" CASTERS W/BRAKES, ADJUSBLE RESTRAINING CABLE, HEAT SHIELDS	L4612504			
CONVERSION: NATURAL GAS TO PROPANE	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL, SPRING KIT	4610264			
CONVERSION: PROPANE TO NATURAL GAS	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL, SPRING KIT	4610265			

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