

OPERATOR'S HANDBOOK
WOODBURNING /GASWORKING
PROFESSIONAL OVEN "VESUVIO" MOD. GR



VALORIANI 
fornace in Reggello dal 1890

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Furnace VALORIANI In 1900



1.0 DESCRIPTION

2.1 CREDITS

First of all, we wish to thank you for selecting a professional oven of the "VESUVIO" line and we congratulate you on your choice.

Our company has manufactured refractory items and PREFABRICATED ovens for over 50 years in our premises located in Reggello, close to Florence. All items produced spring from an idea that Mr. SILVIO VALORIANI had right after World Word II for bread baking.

The concept immediately met the favour of the Italian people and proved to be the winning card of the company. Thanks to their easy assembly, installation and use, these ovens are used to cook many traditional dishes, such as lasagne, roasts, baked pasta, besides of course bread and PIZZA

The special design of the vault in refractory *cotto* perfectly matches the cooking surface made up of elements in REFRACTORY COTTO.

This way our ovens offer the same – or even improved, we may add – features of old wood-fired ovens, which were built with refractory bricks laid down following a special design according to ancient building techniques, whose origins are lost in the mists of time.

Massimo Valoriani



GENERAL WARNINGS

Attention:

- The present handbook is an integral and substantial part of the oven and must be kept available to the operators for any eventual consultation.
- Before carrying out any operation, read carefully the information contained in the handbook, with reference to safety, installation, use and maintenance.
- The oven must be used only for the use for which it has been conceived (baking of pizza, bread, cakes, roasts and so on...)
- The installation of the chimney flue must be conform to the regulations in force in your own country and carried out by authorized personnel and must guarantee the extraction rate required for the model and size of the oven.
- All the local regulations , included the ones referred to the National, European and International norms, must be respected during the oven's installation.
- In case of repair, it is necessary to use always original spare parts.
- The Manufacturer declines any responsibility for direct and indirect damages caused by a wrong installation, bad maintenance, infringement, improper use and non-observance of the norms and indications contained in the present handbook.



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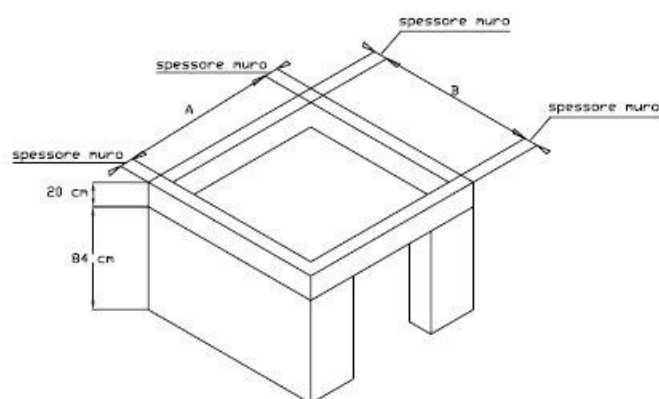
PART A

SUGGESTIONS FOR THE ARRANGEMENT OF THE SUPPORT FLOOR

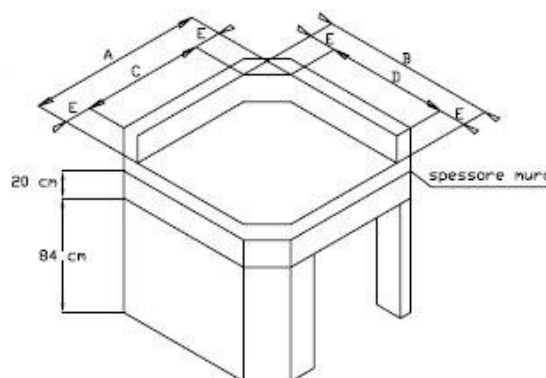
- Build a solid base according to the size of the oven. Concerning the sizes and shapes you can take a hint from the data and drawings quoted in the figure and schedule 1.1
- As building material, we suggest to use hollow tiles, while we strongly discourage the use of reinforced concrete which could take the heat away from the oven.
- We remind you to check with a level the perfect levelling of the base you are building.

Please find some examples of insulation's floors:

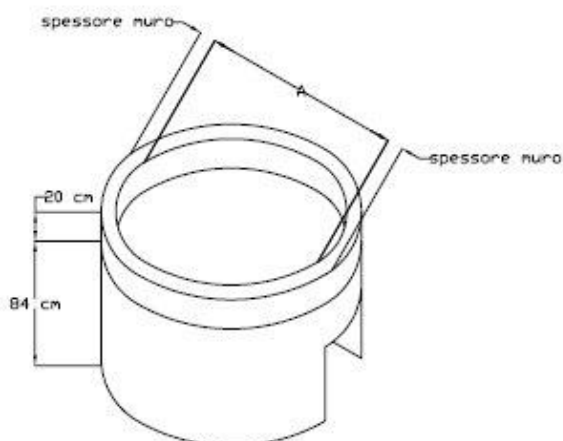
Standard
base
suitable for
all the ovens



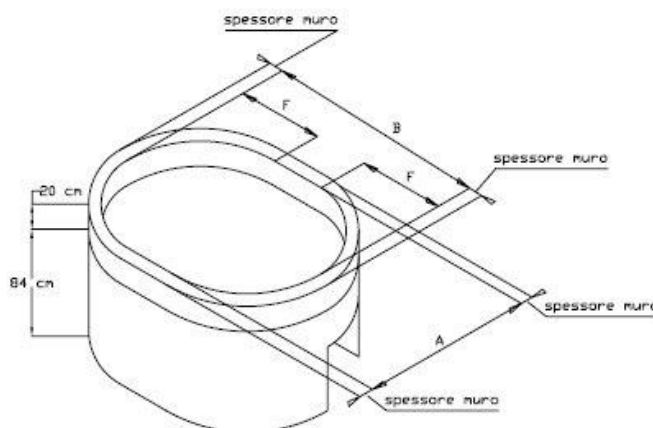
Small
base
suitable
for all the
ovens
in
case
of very
small



Round
base
suitable for
the ovens:
90-100-
120-140-
180.



Round base
Suitable for
Ovens:
120x160
140x160
140x180

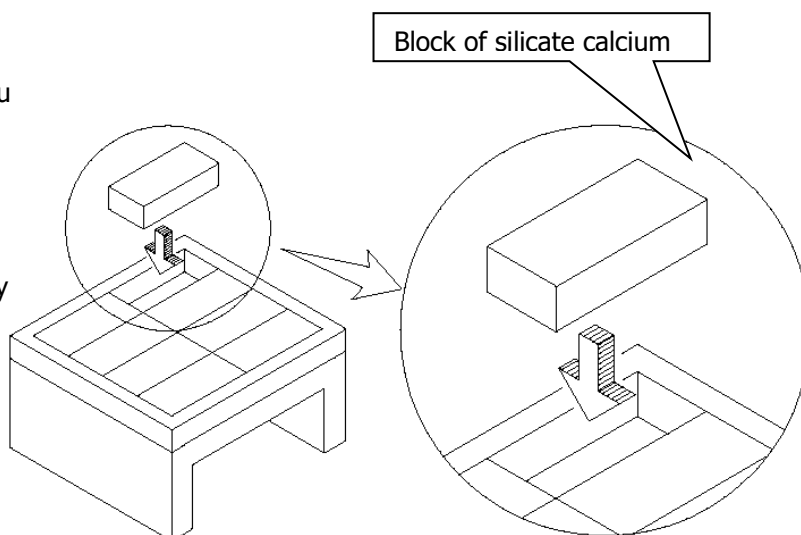


TO THE MEASURES INDICATED IN FIGURE AND SCHEDULE 1.1. ADD THE THICKNESS OF THE CURTAIN WALLS

FIGURE AND SCHEDULE 1.1	A	B	C	D	E	F	Load of the base
Oven 90	130	120	85	85	22	\	1500 Kg
Oven 100	140	140	85	60	27	\	2000 Kg
Oven 120	160	160	100	100	30	\	2400 Kg
Oven 140	180	180	150	150	30	\	2600 Kg
Oven 120x160	160	200	\	\	\	40	2600 Kg
Oven 140x160	180	200	\	\	\	50	2800 Kg
Oven 160	200	200	\	\	\	\	3000 Kg
Oven 140x180	180	220	\	\	\	50	3000 Kg
Oven 180	220	220	\	\	\	50	3400 Kg

For security reasons, please calculate at least 1000 Kg more as load capacity of the base

- Fill carefully the tank with blocks of cellular silicate calcium, so to create a solid and uniform layer; pay attention not to leave empty spaces and check that the base does not move. **Do not mason the blocks but squash them carefully, so that they result firmly fixed one another.**
- We remind you that you can shape the silicate blocks by using a normal saw.
- Carefully check that the floor built is perfectly horizontal and does not present any disconnectedness. Should you correct possible unevenness you can use wood rasps to rasp carefully the base.
- Once completed the base, brush it carefully in order to remove dusts and any residuals. Please pay attention not to dampen the insulation floor.



* NOTE: The silicate calcium can be supplied by our company, as it is part of our "insulation kit"



IMPORTANT

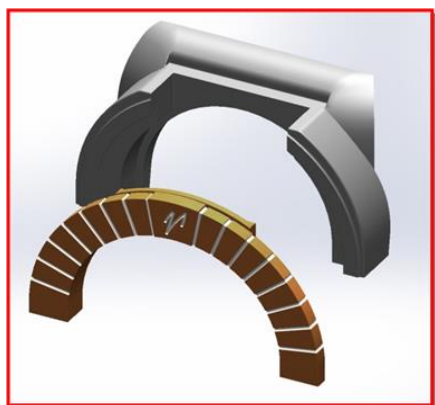
PAY ALWAYS THE MAXIMUM ATTENTION WHILE CARRYING OUT OF THE OPERATIONS DESCRIBED; THE CORRECT BUILDING OF A GOOD INSULATION BASE IS FUNDAMENTAL FOR THE GOOD WORKING AND DURATION OF THE OVEN.

REFRATTARI VALORIANI DOES NOT ASSUME ANY RESPONSIBILITY OF CHECK OR INSPECTION OF THE OPERATIONS DESCRIBED IN THIS HANDBOOK.

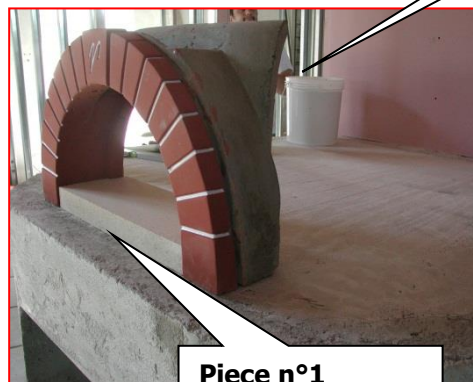
Part B: **ASSEMBLING OF THE OVEN'S BODY**

To assembly the oven GR 90 is it necessary to follow specific instructions of the appendix at the end of the manual

THE PROFESSIONAL OVEN "VESUVIO GR" CAN BE EASILY ASSEMBLED IN A FEW HOURS. FOLLOW THE DESCRIBED STEPS REFERRING TO THE SCHEME (SEE PART C) ACCORDING TO THE OVEN'S SIZE.



The mouth element is made of 2 joint pieces, that must be coupled before placing it on the base



A

Piece n°1



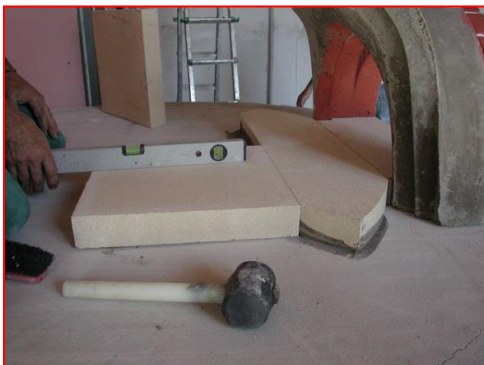
- 1) Couple the two pieces of the arch by matching the joints. Do not use any kind of mortar or glue for the matching
- 2) Place the mouth elements figured with letter A
- 3) Place piece N. 1 without gluing it. It is important to pay attention to the right positioning of this first element, as the rest of the assemble will be consequent to that
- 4) Place the sections of the refractory cotto floor on the basis of the sequence indicated in the scheme part C, for the relevant oven's size

- 5) Use the ready for use VALORIANI VALPLAST mortar for a thickness of maximum 3 mm, this helps to compensate the possible difference in height of the insulation base



- 6) Beat the sections with a rubber hammer to perfectly level the floor, always check with a level

- 7) Remove possible leftovers and dust before placing another floor's section



- 8) Always verify the lining of the sections during the assembly

- 9) Please check an example of an assembled floor



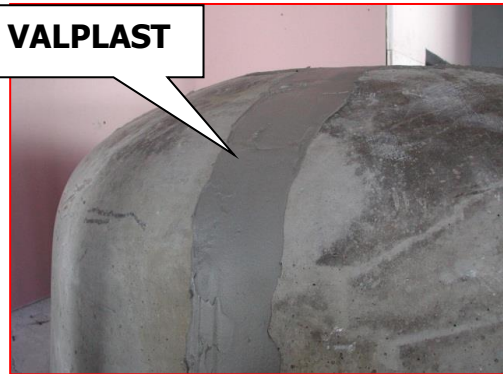


WARNING: To place dome's sections, the operator may need to step on the just posed floor. In this case we suggest to place some wood planks on the floor, so to distribute the weight and not to compromise its levelling.

10) Dry place the dome's sections in the order indicated in scheme part C, for the relevant oven's size

11) The dome's sections must be plastered **only on the outside**, with the ready for use plastic refractory mortar VALORIANI VALPAST

VALPAST



Flue manifold



12) Before placing the flue manifold, put some VALORIANI VALPAST mortar on the frame to create the sealing. The holes in the two lateral flanges allow to insert metal plug of 8 mm diameter, after drilling the oven's mouth (part A)

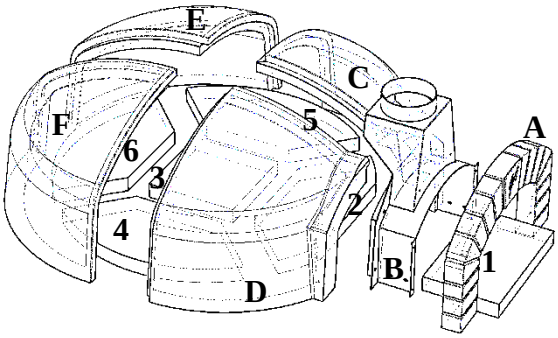
IMPORTANT

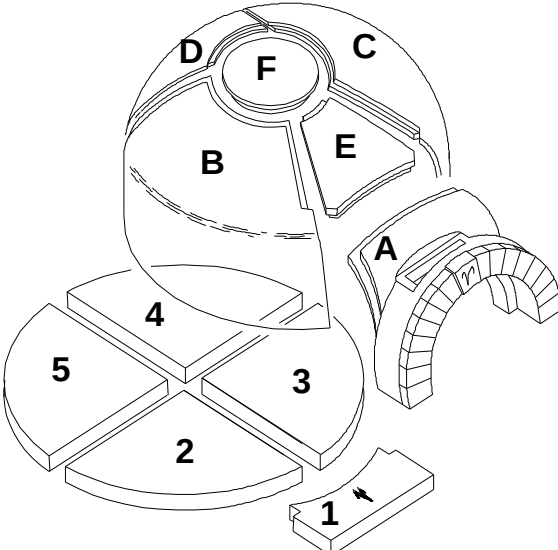
WITH REFERENCE TO THE CHIMNEY FLUE, IT MUST BE INSTALLED FROM QUALIFIED PERSONNEL IN CONFORMITY WITH THE LOCAL NORMS

THE OUTLET DIAMETER OF THE FLUE MANIFOLD IS 20 CM

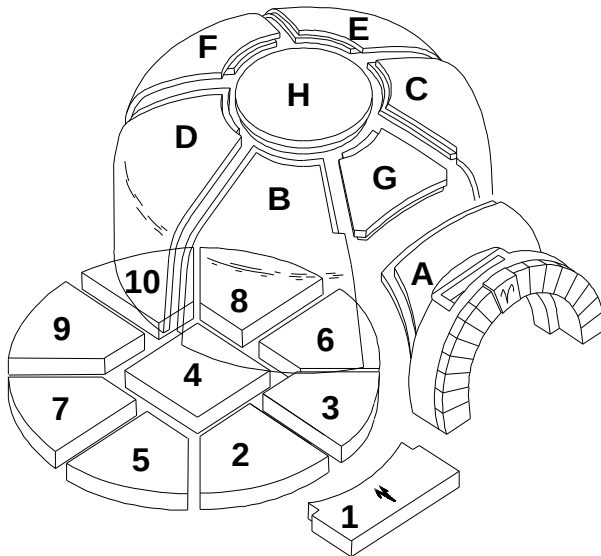
PART C

ASSEMBLING OF THE FLOOR AND DOME

GR 90 	<u>CHECK APPENDIX AT PAG 28</u> Dry place the dome section in the following order: - Pull together the laterals B and C to the element A - Pull together the back element E - Pull together the back element F - Verify the proper positioning of the crown sections - Put some Valplast to create a perfect sealing
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GR 100 	Dry place the dome section in the following order: - Pull together the laterals B and C to the element A - Put on top the element E - Pull together the back element D - Before placing the top component F, verify the proper positioning of the crown sections - Put some Valplast to create a perfect sealing, then place the key element F
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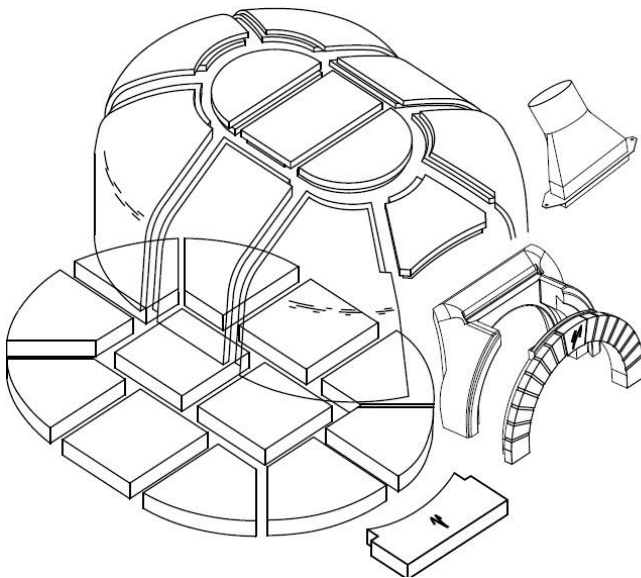
GR 120



Dry place the dome section in the following order:

- Pull together the laterals B and C to the element A
- Put on top the element G
- Pull together the remaining laterals D and E
- Pull together the back element F
- Before placing the top element H, verify the proper positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key element H

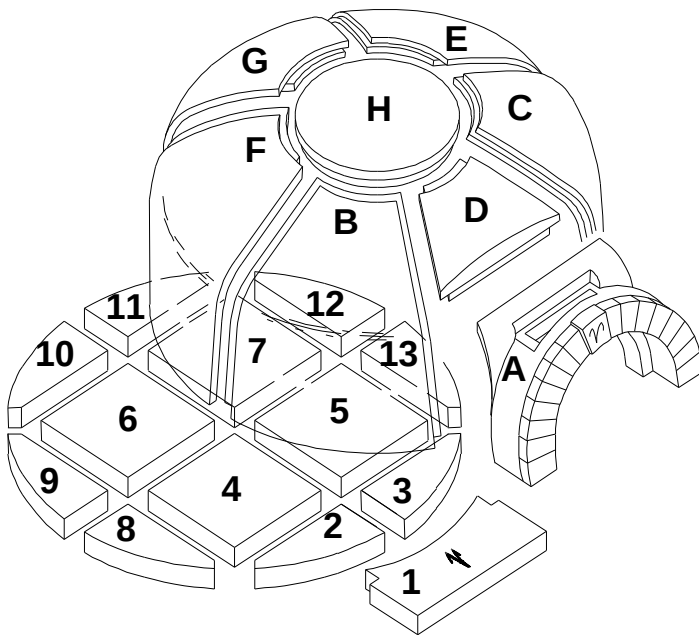
GR 120x160



Dry place the dome sections in the following order:

- Pull together the lateral B and C the element A
- Put on top the element D
- Pull together the remaining lateral elements E-F-G-H
- Pull together the back element I
- Before placing the top elements L-M-N, verify the positioning the crown sections
- Put some Valplast to create a perfect sealing, then place the key elements L-M-N

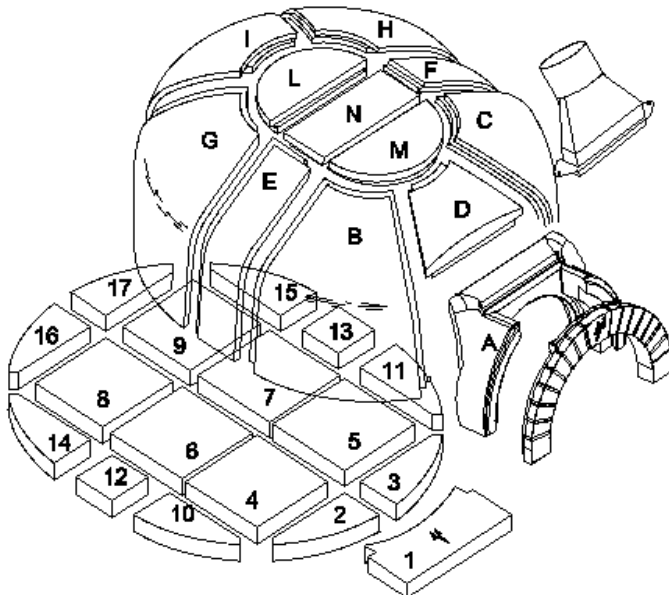
GR140



Dry place the dome sections in the following order:

- Pull together the laterals B and C to the element A
- Put on top the element D
- Pull together the remaining elements E and F
- Pull together the back element G
- Before placing the top element H, verify the positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key element H

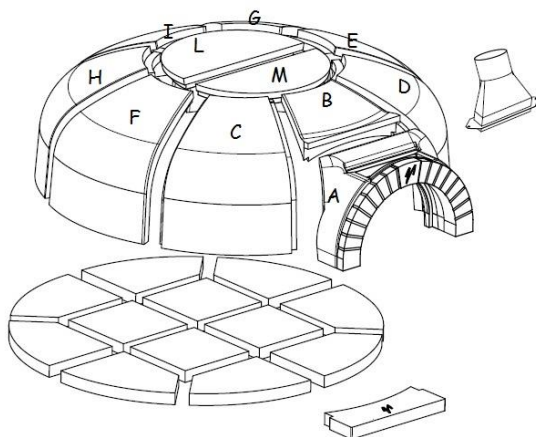
GR 140x160



Dry place the dome sections in the following order:

- Pull together the laterals B and C to the element A
- Put on top the element D
- Pull together the remaining elements E-F-G-H
- Pull together the back element I
- Before placing the top elements L-M-N, verify the positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key elements L-M-N

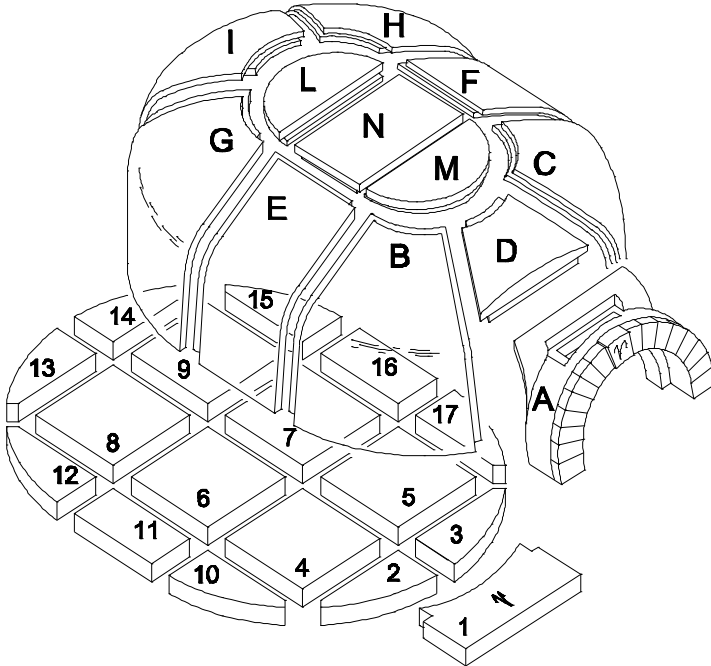
GR 160



Dry place the dome sections in the following order:

- Pull together the laterals C e D to the element A
- Pull on top the element B
- Pull together the elements E-F-G-H
- Pull together the back element I
- Before placing the top elements L-M, verify the positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key elements L-M.

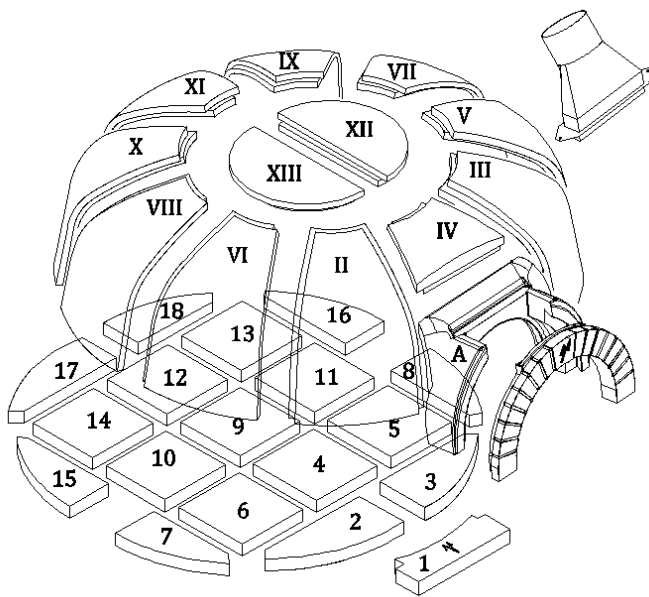
GR 140x180



Dry place the dome sections in the following order:

- Pull together the laterals B and C to the element A
- Put on top the element D
- Pull together the remaining elements E-F-G-H
- Pull together the back element I
- Before placing the top elements L-M-N, verify the positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key elements L-M-N

GR 180



Dry place the dome's sections in the following order:

- Pull together the laterals II and III to the element A
- Put on top the element IV
- Pull together the remaining elements V-VI-VII-VIII-IX-X
- Pull together the back element XI
- Before placing the top elements XII-XIII, verify the positioning of the crown sections
- Put some Valplast to create a perfect sealing, then place the key elements XII-XIII

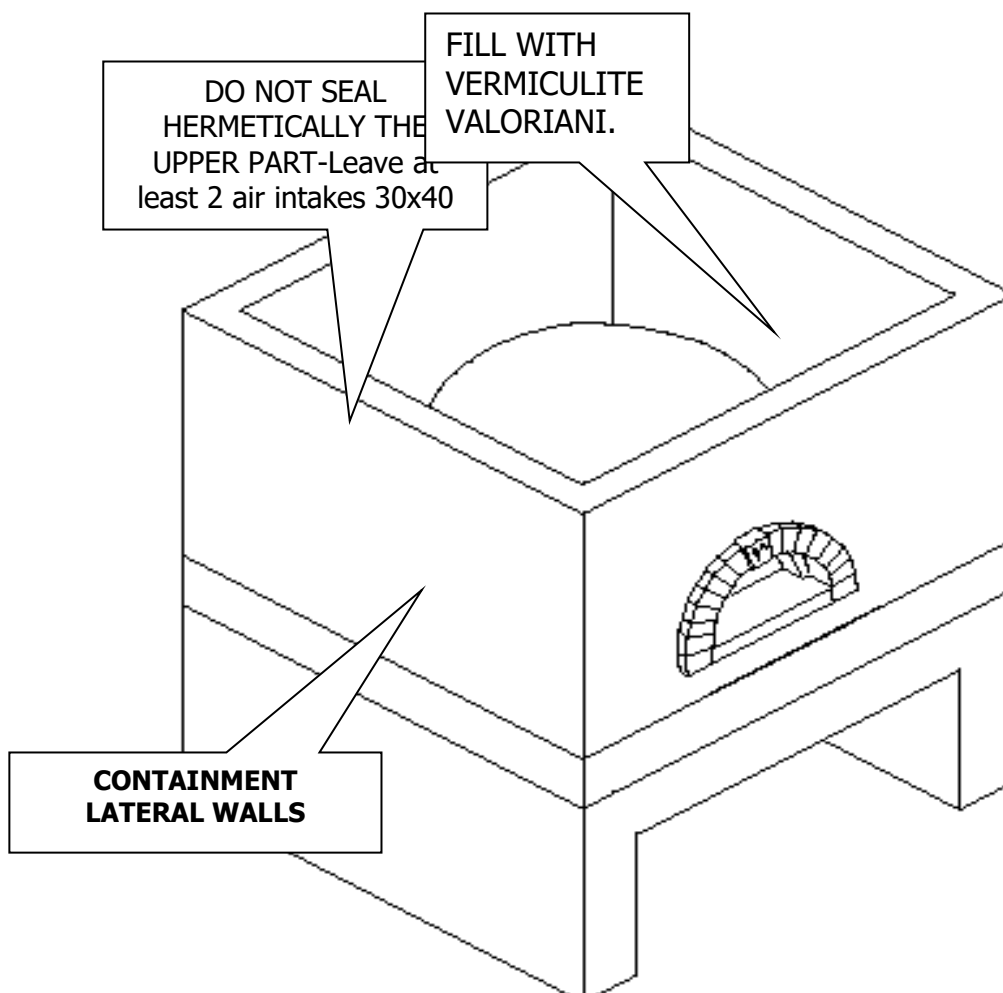


IMPORTANT

BETWEEN THE FLOOR AND CROWN SECTIONS IT IS DELIBERATELY LEFT A SMALL CHANNEL THAT WILL BE THEN FILLED DURING THE USE OF THE OVEN WITH COMMON ASH. THE CHANNEL HAS THE FUNCTION TO LET A THERMAL DILATATION TO THE FLOOR.

PART D – UPPER INSULATION OF THE OVEN

- 13) Once finished the dome sealing, wrap the oven with two layers of ceramic fibre certified (supplied in the “insulation kit”)
- 14) Build the containment walls of the oven. We suggest to use as building material hollow tiles. We remind that no weight must load on the oven’s arch
- 15) Fill the walls of aluminium silicate not kneaded (vermiculite) for about 25 cm thickness on the oven previously wrapped in ceramic fibre. In lack of this material, use expanded clay in medium grains.
- 16) In the upper part of the containment walls, it is necessary to provide two openings (vent air grills) to allow the air circulation, so that the oven can discharge the moisture





PART E - OVEN FIRING

When the oven is new, it contains residual moisture, that should not turn into steam during the drying of the oven. THEREFORE, IT IS FUNDAMENTAL to start very carefully with the first curing in order to avoid the above-mentioned effect, which could create cracks to the handwork. **For THE FIRST FIRING**, which has to be carried out gradually and constantly for 1-week days, you **MUST** proceed as follows:

IN CASE OF AN EXTENDED INACTIVITY OF THE OVEN, PROCEED WITH A SLOW RELIGHTING FOR ABOUT 24/36 HOURS

- 1) Light a small fire in the central part of the oven.
- 2) Keep an even inside temperature of about 100/150 °C constantly for the first two days
- 3) Raise of 50 C from the third day, for each day (and keep it constant for all the day until the total dehumidification of the handwork)

IMPORTANT

LITTLE AND EVENTUAL CRACKS INSIDE THE CROWN'S ELEMENTS ARE PERFECTLY NORMAL AND ARE DUE TO THE THERMAL EXPANSION OF THESE ONES TO THE HIGH TEMPERATURES. SUCH CRACKS DO NOT COMPROMISE IN ANY WAY THE WORKING OF THE OVEN, ON THE CONTRARY, THEY ARE SYMPTOMS OF A VERY GOOD DEHUMIDIFICATION OF THE HANDWORK.

IMPORTANT

THE OVEN'S CROWN MUST NOT BE FIXED BUT THERE MUST BE BETWEEN THEM A THERMAL EXPANSION JOINT, IN ORDER TO LEAVE A RIGHT DEGREE OF MOBILITY, TO COMPENSATE THE THERMAL EXPANSIONS. THIS JOINT MAY INCREASE OR DECREASE DURING THE OVEN'S LIFE, BECAUSE OF THE THERMAL EXPANSION, THESE MOVEMENTS ARE PERFECTLY NORMAL AND DO NOT COMPROMISE AT ALL THE PERFORMANCES OR STABILITY OF THE OVEN.

IMPORTANT

IMPORTANT

WE RECOMMEND TO FOLLOW CAREFULLY WHAT ABOVE INDICATED, SINCE THE ALMOST TOTALITY OF THE CRACKS ON THE CROWN'S ELEMENTS OCCUR DUE TO A TOO FAST DRYING.

PART F – FIRE POSITIONING AND WOOD USE – GAS INDICATIONS

With a normal oven's utilisation, the fire should be positioned sideways; as the part most exposed to the fire will suffer consequently the most thermal expansions and the most wear during the years.



We recommend to alternate the fire from the right side to the left side and vice-versa; in this way you will obtain a constant balance for the structure and surely a better yield in time.

We suggest to use thin, light and dry wood, to make easier the fire's lighting and a better initial heating.

Successively, in order to have an optimum yield with a low wood consumption, we suggest to use heavier and thicker wood (Oak - Beech – Oliva in trunks long cm 30-40)

We discourage the use of resinous wood (Pine - Spruce) because it transmits a particular and not suitable odour; we don't suggest also the use of Poplar - Birch because of its high residual of carbonic particles.

Do not use any other kind of fuel, such as coal, charcoal slack, petrol's, and so on.

The wood put into the oven must NEVER be beaten against the crown because at high temperatures some damages to the structure may occur.



PART G – GAS FIRED GR

FIRST FIRING VALORIANI GR GAS

- ❑ Switch the burner on and set the minimum flame mode
- ❑ Keep CONSTANT the previous settings for 6-8 hours consecutive for the first two days
- ❑ The third day set the burner on automatic mode setting the set point at 200°C keeping it on for 6-8 hours consecutive.
- ❑ The fourth day keep the automatic mode of the burner setting the set point at 250 °C keeping it on for 6-8 hours consecutive.
- ❑ From the fifth day you can set the set point of the gas burner at the desired operating temperature and carry out the first baking tests.

IMPORTANT

LITTLE AND EVENTUAL CRACKS INSIDE THE CROWN'S ELEMENTS ARE PERFECTLY NORMAL AND ARE DUE TO THE THERMAL EXPANSION OF THESE ONES TO THE HIGH TEMPERATURES. SUCH CRACKS DO NOT COMPROMISE IN ANY WAY THE WORKING OF THE OVEN, ON THE CONTRARY, THEY ARE SYMPTOMS OF A VERY GOOD DEHUMIDIFICATION OF THE HANDWORK.

IMPORTANT

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IMPORTANT

IN CASE OF AN EXTENDED INACTIVITY OF THE OVEN, PROCEED WITH A SLOW RELIGHTING FOR ABOUT 24/36 HOURS

IMPORTANT

WE RECOMMEND TO FOLLOW CAREFULLY WHAT ABOVE INDICATED, SINCE THE ALMOST TOTALITY OF THE CRACKS ON THE CROWN'S ELEMENTS OCCUR DUE TO A TOO FAST DRYING.

IMPORTANT

EVEN IF THE OVEN IS DELIVERED IN WHITE COLOUR WE SUGGEST NOT TO CARRY OUT ANY OUTSIDE COVERING, **DURING THE FIRST MONTH OF WORKING OF THE OVEN** (PAINTS, TILES AND SO ON...) SINCE, BECAUSE OF ITS FEATURES OF TRANSPIRATION WHICH MAKE IT UNIQUE IN ITS WAY, ANY COVERING ON THE CROWN'S SURFACE WOULD NOT ALLOW THE NORMAL DISCHARGE OF THE MOISTURE, WITH CONSEQUENT FORMATION OF BUBBLES. THEREFORE, DURING THE FIRST 30 DAYS OF WORKING THE VENATIONS THAT WILL APPEAR ON THE UPPER INSULATION ARE PERFECTLY NORMAL AND DO NOT DAMAGE AT ALL THE GOOD WORKING OF THE OVEN.

IMPORTANT

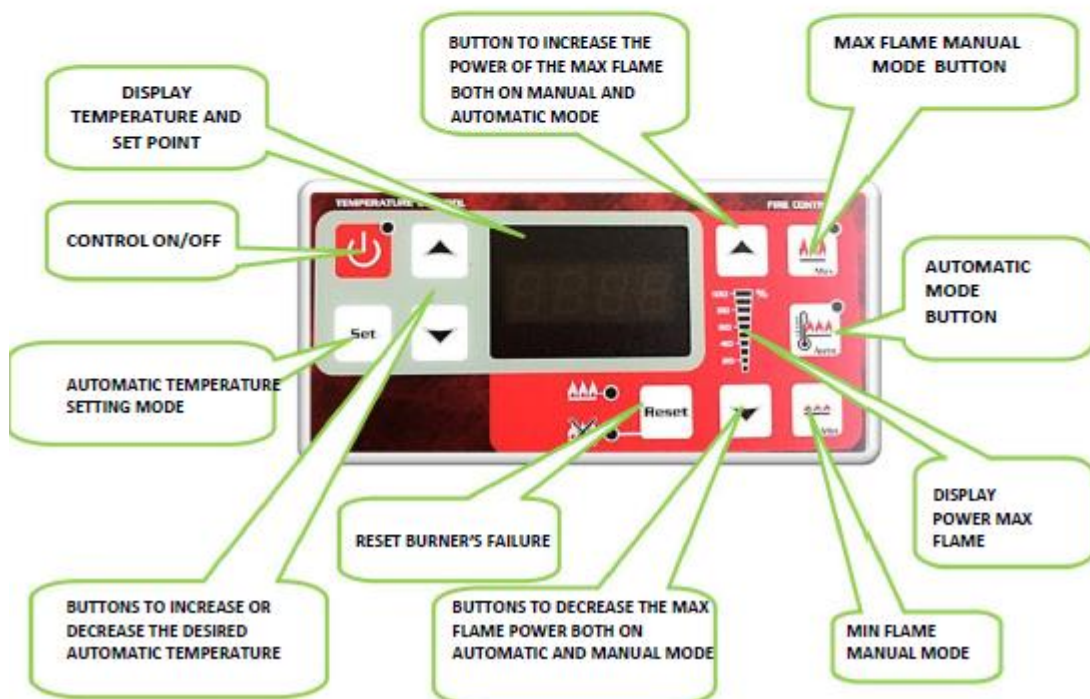
DO NOT KEEP IN THE HEAT SPREADING AREAS OR IN FIRE RISK AREAS ANY FLAMMABLE MATERIAL.
PLEASE RESPECT ALL EXISTING NORMS ABOUT THE FUEL STOCKING.

7.3 CONTROL BOX COMMANDS DESCRIPTION

Figure A: Control box



Figure B: burner's controls overview





INSTALLATION OF THE GAS BURNER

The New Generation SPITFIRE GOLD burner belongs to the category of equipment designed to the professional hospitality, including communities, the complex of the touristic and catering –hotels sector, big restaurants chain opens to the public and private ones with, as well as to the category of gas ovens, burners, warm air flow generators, boilers with potential not exceeding 35 kW.

The OVEN complete with the BURNER SPITFIRE GOLD is considered an OVEN FOR COOKING OF FOOD WITH GAS-BURNER, and as such must be installed in appropriated places in respect of the regulations in force.

To regulate the installation reference will be made to rules **UNI-CIG 8723 / UNI-CIG 7129 / UNI-CIG 9615**, including subsequent changes or local rules in force.

The UNI-CIG 8723 allows the installation of the full equipment OVEN FOR COOKING OF FOOD WITH GAS BURNER with the exhaust of combustion smokes under hood intake. For this type it is mandatory to strictly abide by the provisions of the legislation.

The Client must make sure that a professionally qualified technician checks the correct natural draught of the chimney flue and shall also perform an analysis of combustion fumes with the oven in operation.

Data:

- Limit temperatures for the gas burner operation 10°C ----+50°C
- Power supply 230 V. 50 Hz. The equipment works with voltage 115V. 50/60 Hz.
- The intake pressure shall be within 18 -25 mbar= 0.26-0.36 psi with methane gas
- The intake pressure shall be within 20 -45 mbar= 0.29-0.72 psi with propane gas LPG
- The supply pipe shall be proportional to the power of the chosen gas burner and to the route that it has to follow from the gas supply site until the gas burner.
- The connection between the supply pipe and the burner shall be carried out with gas pipe not less than $\varnothing 1/2''$.

Any pipe of smaller size will compromise the good operation of the burner.

The maximum potential of the burner GOLD 29 SPITFIRE is 29,0 kW (with gas G25.1-G25-G20-G30)

The maximum potential of the burner GOLD 34 SPITFIRE is 32,0 kW (with gas G25.1) and 34 kW (with gas G25-G20-G30)

The burner can be used with all gas types, methane, propane, L.P.G. (All gas) by making the necessary adjustments.

If it is planned to close/customize the stand of the oven, it is necessary to provide proper air vent to allow the combustion air flow necessary to the gas burner, besides openings to allow maintenance.

We recommend to refer to the manual of installation use and maintenance equipped with the burner



CONNECTION TO THE CHIMNEY FLUE

- ② The connection to the flue shall comply with the regulations in force and shall be installed by qualified personnel
- ② The chimney flue must own the necessary requirements of the regulations in force in the country of installation of the oven
- ② The chimney flue must guarantee the extraction rates required by the dimension of the oven, see table A
- ② The equivalent air volume evacuated by the flue, must be re-inserted inside the room through outside openings or equivalent systems.

TABLE A

Oven dimension	Required flow rate Nm ³ /h
Ø 100	220/240
Ø 120	250/270
Ø 120x160	270/290
Ø 140	270/290
Ø 160	290/310
Ø 140x160	280/300
Ø 140x180	290/310
Ø 180	320/340

IMPORTANT

THE CHIMNEY FLUE MUST BE INSTALLED BY QUALIFIED PERSONNEL IN CONFORMITY WITH THE REGULATIONS IN FORCE

ALWAYS PROVIDE FOR THE AIR REINSTATEMENT NECESSARY TO THE COMBUSTION AND TO THE SMOKES EVACUATION, AS PROVIDED BY THE REGULATIONS IN FORCE ON THIS MATTER, THROUGH OPENINGS TO THE OUTSIDE (VENTILATION GRILLS).

WHEN THE OVEN IS INSTALLED IN ROOMS WHERE THERE IS THE PRESENCE OF FORCED SUCTION SYSTEMS (SUCKED HOODS OF THE KITCHENS) YOU SHOULD TAKE APPROPRIATE MEASURES TO AVOID CREATING DEPRESSION INSIDE THE ROOM WHICH WOULD COMPROMISE THE CORRECT OPERATION OF THE OVEN



WARNINGS

- ✓ All the local regulations, included the ones referred to the National Norms, European Norms and International Norms must be observed during the installation.
- ✓ Do not use the oven as incinerator or in any other way different than the one for which it has been conceived.
- ✓ Do not use fuel different than the ones suggested
- ✓ Do not use liquid fuels.
- ✓ The oven and in particular way some outside surfaces, when it's operating it reaches high temperatures to the touch, handle with care to avoid burns.
- ✓ Do not carry out any not authorized changes.
- ✓ Use only original spare parts recommended by the producer.

PART H BAKING TIMES

The baking times for pizza are very variable; normally from 1 to 3 minutes and depends on the kind of dough, the inside temperature used by every single pizza maker and many other features. One of the most important strong point of the VALORIANI GR is the UNIFORMITY of baking capacity with every working condition and temperature of use.

The perfect balance between the dome and the floor, made of a special refractory "COTTO ", allows an optimal baking also at high temperature (over 400 degrees) avoiding that the pizza sticks or burns in its lower part.

PART I - CLEANING AND MAINTENANCE

We suggest to use the proper brass brushes for the inside cleaning of the oven, that you can easily find on the marked or can be provided by Refrattari Valoriani s.r.l.



WARNINGS

- ✓ Do not beat the shovel on the baking surface in order to avoid damages.
- ✓ Do not use wet rags or other materials containing moisture.
- ✓ Never throw water inside the structure, it is important to avoid strong thermal shocks that could damage the handwork.
- ✓ Do not use salt inside the oven.

9.1 MAINTENANCE

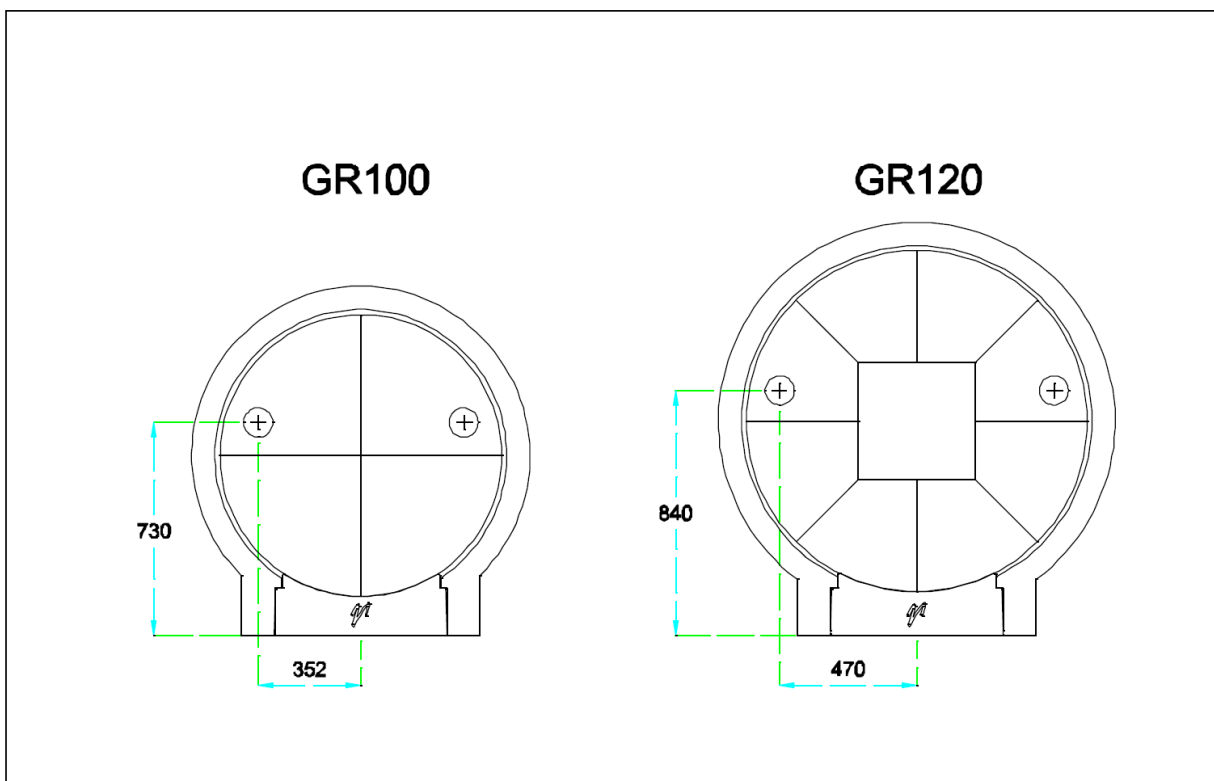
Every extraordinary maintenance operation must be carried out by qualified personnel.

THE PROFESSIONAL OVENS VALORIANI HAVE BEEN DESIGNED FOR THE BAKING OF THE PIZZA, BREAD, CAKES ETC. THEREFORE REFRATTARI VALORIANI S.R.L. DECLINES ANY RESPONSIBILITY FOR UTILIZATIONS AND MODES OF APPLICATION DIFFERENT THAN THE ABOVE-DESCRIBED ONES.

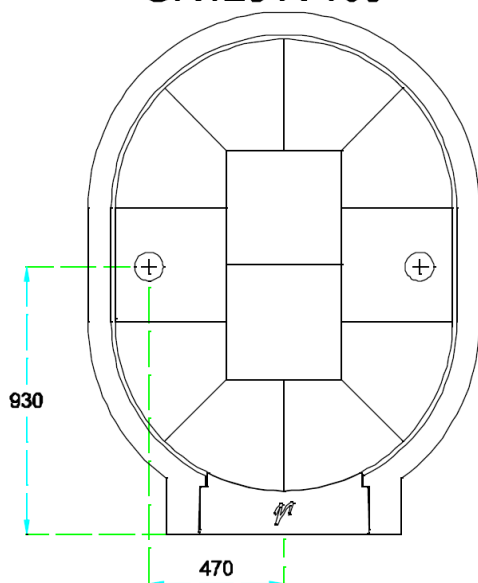
IT IS NOTED THAT BUILDING WORKS AND CONSTRUCTION WORKS IN GENERAL, SHOULD BE EVENTUALLY CARRIED OUT BY THE CUSTOMER AND AT HIS CHARGES, UNDER HIS FULL AND EXCLUSIVE RESPONSIBILITY, BY AN ADMINISTRATIVE, CIVIL AND PENAL ASPECT. THE CUSTOMER UNDERTAKES AND GUARANTEES, STARTING FROM NOW, TO DETECT REFRATTARI VALORIANI S.R.L. FREE FROM ANY AND ALL NEGATIVE CONSEQUENCES SHOULD ARISE CAUSED BY EVENTUAL ADMINISTRATIVE, URBAN PLANNING AND PENAL BREACHES, BY WARRANTING TO FACE ALL THE EVENTUAL EXPENSES, PENALTIES INCURRED AS A RESULT TO THE BREACHES COMMITTED BY THE CUSTOMER.

PART L - PREDISPOSITION FOR GAS BURNER

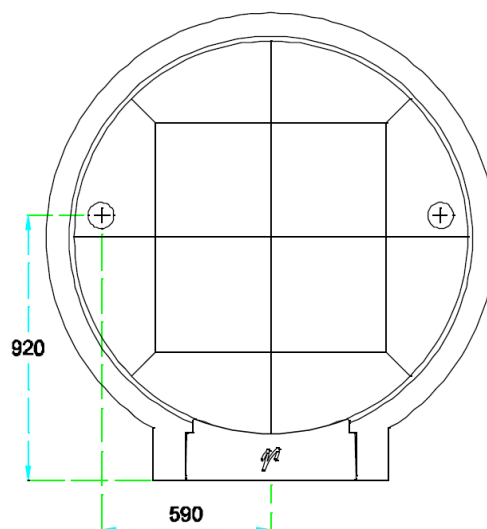
- For the predisposition of the electronic, automatic, pumped air gas burner carry out a hole of 100mm diameter (or different if using another gas burner) in the base described in the "part A "of the operator's handbook, by observing the distances indicated which change depending on the model (see following pictures)
- Carry out the same hole also in the silicate calcium blocks of the insulation floor.
- During the building of the cooking floor, besides paying attention to the positioning of the particular 1 (part B of the operator's handbook), it is necessary to make coincide the hole carried out in the insulation floor with the hole on the refractory cooking floor, therefore we suggest to do a positioning test without using mortar Valplast, in order to find out the right position and then proceed with the final assembly as described in the part "B " of the operator's hand book.



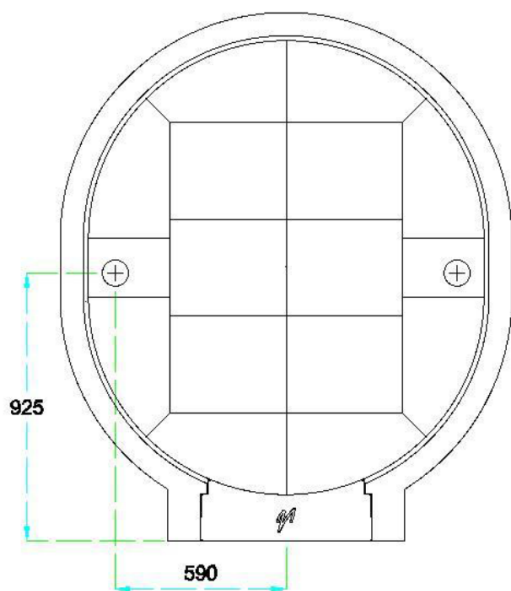
GR120 X 160



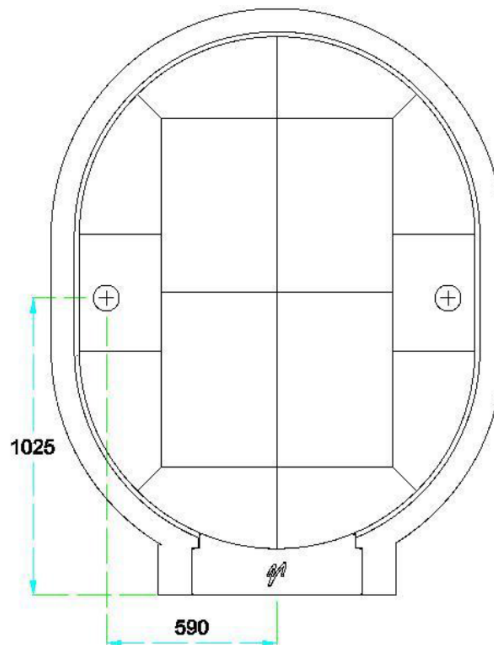
GR140



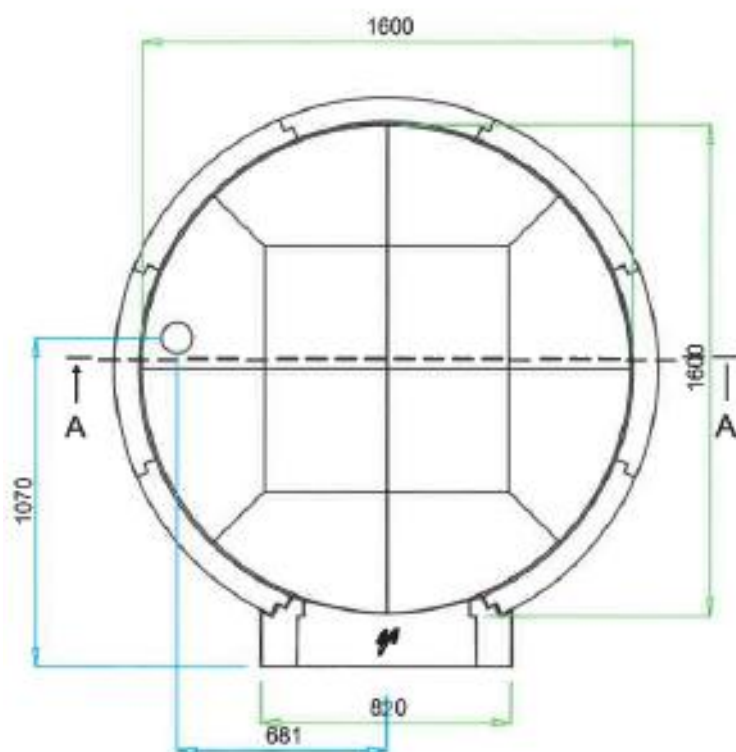
GR140 X 160



GR140 X 180

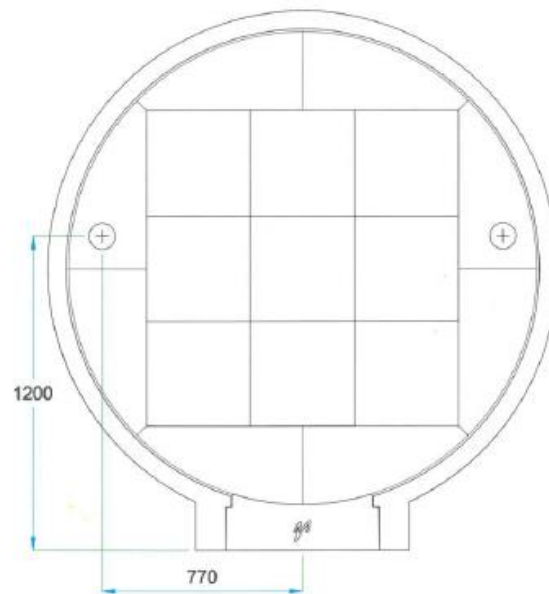


GR 160





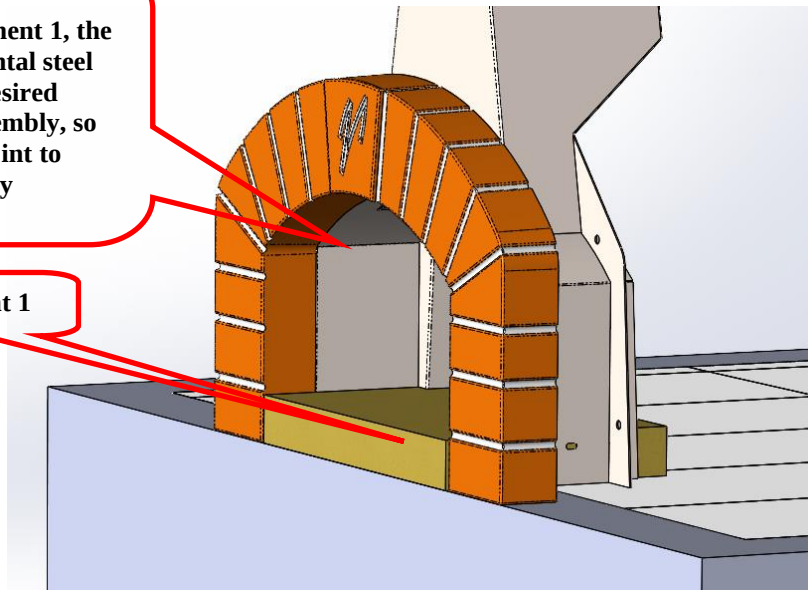
GR 180



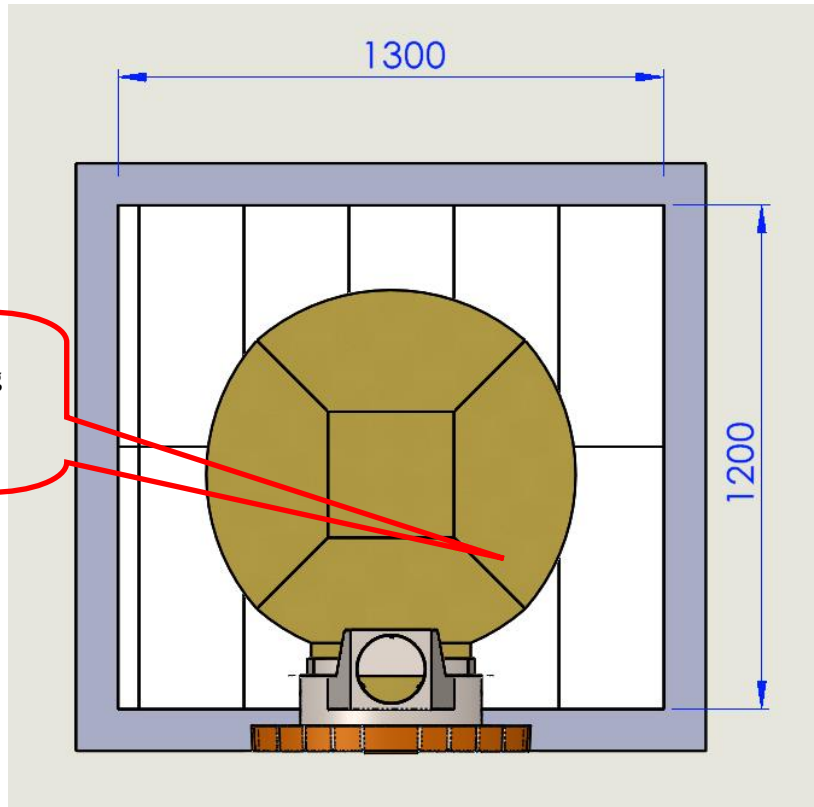
PART M: APPENDIX GR 90

Place the component 1, the arch and the frontal steel opening in the desired point for the assembly, so to fix an exact point to start the assembly

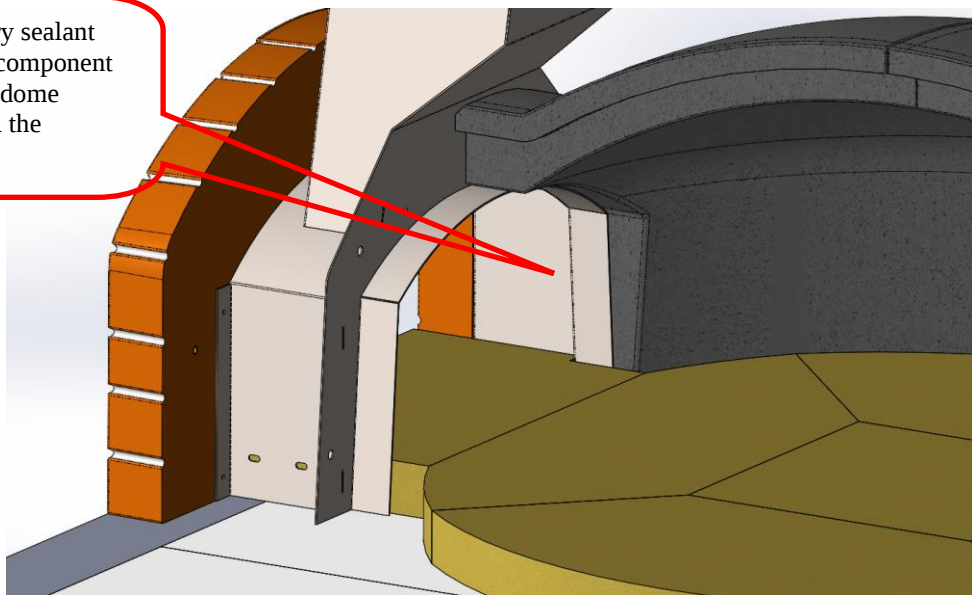
Component 1



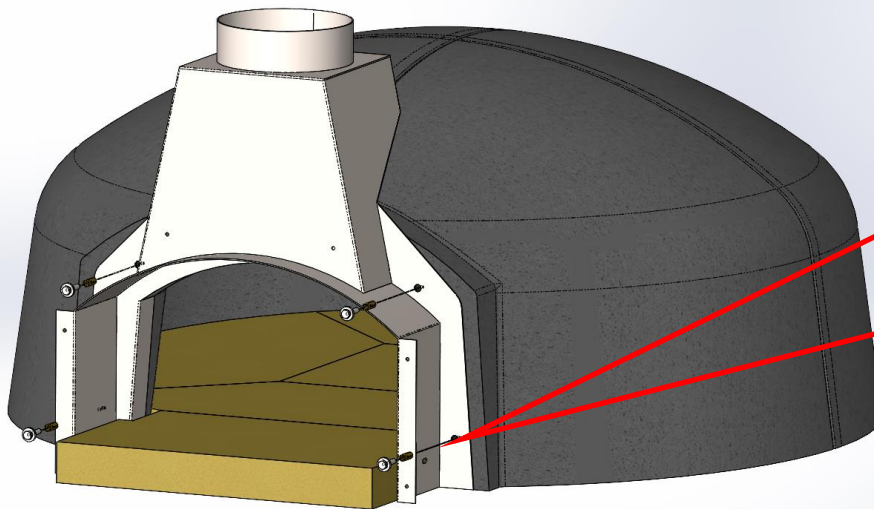
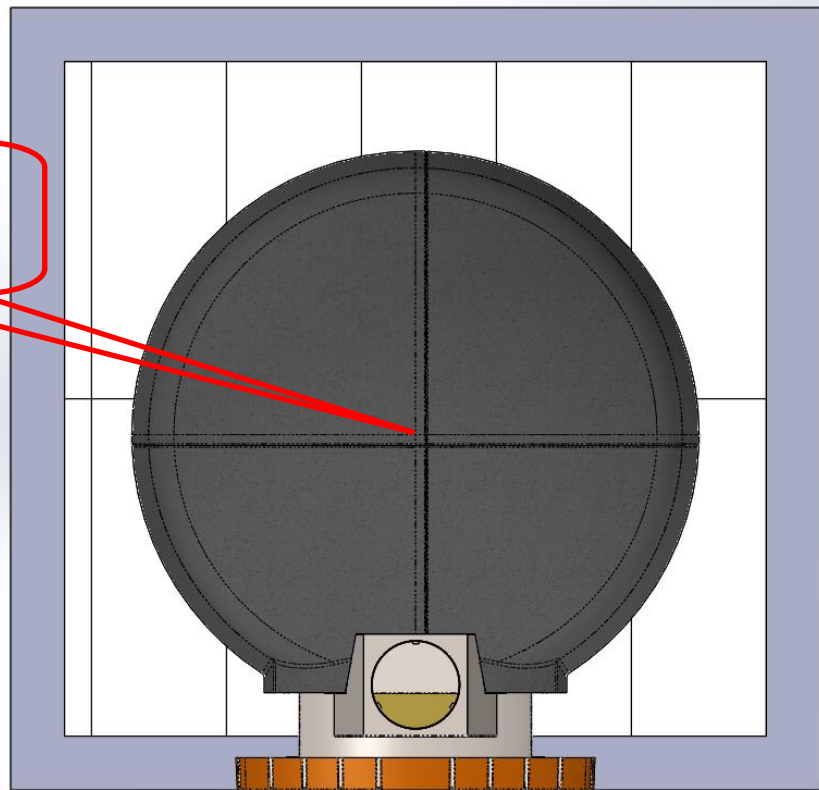
Proceed by placing and levelling the baking floor, as described in the general instructions



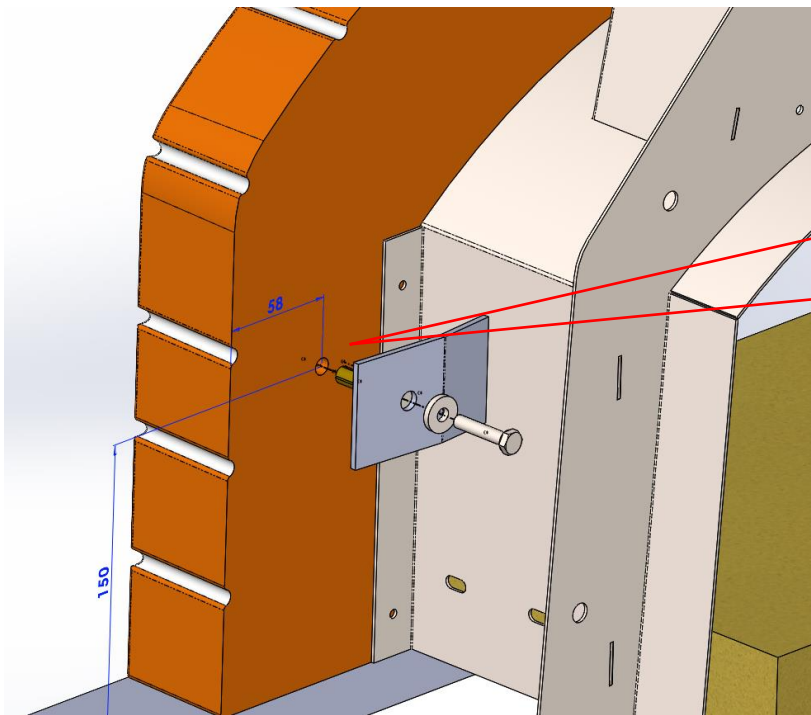
Put some refractory sealant between the steel component and the refractory dome sections, so to seal the connection.



Proceed by placing the dome sections and sealing them externally with the refractory mortar



After removing the external arch, make a hole in the refractory with a drill for concrete Ø 8, in correspondence of the 4 holes already made in the steel component. Insert the metallic nags with the relevant screws and washers, to block the steel component to the oven dome



Make a hole with drill for concrete Ø 8 in the refractory of the external arch, insert the expansion bolts in the arch, with the relevant brackets, screws and washers block the external arch to the steel component