

# K-MPO

# Installation Instructions

# Repair Parts List



Henkel, Inc.  
P.O. Box 1322  
Hammond, LA  
70404

(985) 345-2171

[www.keenovens.com](http://www.keenovens.com)



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**Model K-MPO Oven  
Installation Instructions & Repair Parts List**

One Year Limited Warranty

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Henkel, Inc. warrants its products against defects in material and workmanship. Henkel, Inc. will either repair or replace without charge any properly installed product which fails under normal operating conditions within one year from date of installation, provided it is returned to our factory, transportation prepaid, and our inspection determined it to be defective under the terms of this warranty. The warranty covers only equipment manufactured by Henkel, Inc., and does not extend to transportation, installation, or replacement charges at the buyers' facility; nor does it apply to any other equipment of another manufacturer used in conjunctions with Henkel, Inc. equipment. No other warranty, expressed or implies exists beyond that included in this statement.  
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**Keen Ovens**

**Model K-MPO**

**SPECIFICATIONS**

Electrode Capacity	600 lbs.
Volts	120 & 240 Volts
Watts	2000 W
Thermostat	Dial Adjustable 150°F - 550°F
Insulation	2" TIW
Interior Dimensions	27" X 20.5" X 40"
Net Weight	300 lbs.
Shipping Weight	335 lbs.
Shipping Dimensions	29.5" X 32.5" X 55"
Spooled Wire 12"	6 spools
36" Filler Material	eight 10lb. Tubes
Flat Shelf for 2 lb. spools or powder	

## Recommended Spare Parts

**When it is critical to have continuous operation of this unit;  
we suggest having the following spare parts on hand:**

**Heating Element  
Power Cord  
Thermostat**

## General Information

The K-MPO is a holding type oven designed to store flux coated electrodes, 12” diameter wire spools, 2 lb. spools, powders, and 36 “ filler material. The ovens operate at an optimum temperature to prevent contamination.

## Operation

Remove wooden crating material from upper portion of oven. Pallet material is removed by leaning oven slightly forward and backward and removing bolts from under side using an adjustable or socket wrench. When oven is free from pallet, place bolts back into oven legs for leveling. Oven should be leveled with slight tilt to the back.

Locate oven in an area free of flammable material and near appropriate electrical source.

## Safety Precautions

Read all instructions completely before attempting to operate this unit.

**\*\*\* SAVE THESE SAFETY INSTRUCTIONS \*\*\***

To reduce the risk of electrical shock, fire, or personal injury follow the guidelines below:

- Before connecting unit to a power source, be sure the voltage supplied is the same as that specified on the nameplate of the unit.
- Check outlet to ensure proper grounding of the electrical cable. Have a licensed electrician check the A/C power outlet if you are not sure.
- Use this unit for its intended purpose as described by literature.
- Make sure power cord is located so that it will not be stepped on, tripped over, or otherwise subjected to stress of heat, oil, or sharp edges. Do not close doors on the cord.
- To reduce the risk of damage to the electric plug and cord, disconnect by plug rather than by the cord.
- Do not use this unit if cord or plug is in poor condition. If it has been exposed to weather or immersed in water, have a qualified serviceman inspect and replace parts as necessary.

- **WARNING! NEVER HANDLE PLUG, CORD, OR UNIT WITH WET HANDS OR WHILE STANDING IN WATER.**
- Use special care when moving heavily loaded units.
- Do not store combustible material on or around the unit.
- Do not operate this unit empty.
- When using the unit at a distance where an extension cord becomes necessary, a 3-conductor grounding cord of adequate size must be used for safety, and to prevent loss of power and overheating. Use only a UL listed extension cord suitable for outdoor use. Make certain wire size is large enough for A/C amperage rating of unit.

## Operation

Load oven with desired amount of consumables. To turn on the unit, simply plug the power cord into an appropriate single phase A/C source and adjust thermostat to desired setting. (Check nameplate for voltage.) Unit will not heat to capacity without appropriate voltage.

The ovens are supplied with a 6' UL listed type S.J. cord. However, the plug is not supplied due to the many different receptical configurations in the field. When attaching the plug to the power cord, be sure the plug is an approved component and is rated for the proper voltage and amperage. All units meet electrical code requirements when used with a grounding plug and a grounded receptical.

**\*\*CAUTION! DO NOT USE ON D/C POWER SUPPLY!\*\***

## Venting

The model K-MPO oven is vented through two screened plugs at the rear of the oven.

## Temperature Setting

The thermostat is adjustable from 150°F (37.8° C) to 550°F (287.8° C). Turn thermostat knob to desired temperature by aligning with red line on chrome bezel. Pilot light indicates when power is supplied to the heating elements. The thermostat is accurate to  $\pm 25^{\circ}$  F (14° C) at the sensor. Temperature variance is minimal throughout the oven due to the heat exchanging qualities of the Keen shelving system.

## Guide to Storage

See the enclosed guide to storage. This guide may be used in the absence of storage information from the electrode manufacturer. In critical situations, contact your electrode manufacturer.

## Scheduled Maintenance

The manufacturer recommends that the unit be unloaded and cleaned of debris and dust every six months. It is also recommended that a temperature probe be placed inside the unit and the thermostat calibration checked at this time.

## Troubleshooting

The Keen oven model K-MPO requires a minimal amount of electrical knowledge to repair if necessary.

### IF OVEN FAILS TO OPERATE – NO HEAT

1. Check power source.
2. Check power cord continuity. Replace cord assembly if faulty.
3. If pilot light glows, voltage is being supplied by elements. Check elements. Check element continuity. If defective, replace.
4. If thermostat cannot be heard clicking on and off when dial is rotated, and if pilot light fails to operate, replace thermostat.

### IF OVEN OVERHEATS

If oven fails to cycle on and off and reaches temperatures above 550° F, thermostat is faulty and needs replacing.

### IF OVEN OPERATES BUT FAILS TO REACH TEMPERATURE

1. Check nameplate for proper voltage. Check voltage at outlet. The 240-volt ovens will operate on 120 volts, but will not reach optimum temperature.
2. If voltage is correct, check element continuity. The K-MPO has two 1000-watt elements. IF one element checks badly, it is suggested to replace both elements at this time and save remaining element for emergency spare.

NOTE: If oven operates but interior temperature varies widely from thermostat setting, see calibration instructions.

## Corrective Maintenance

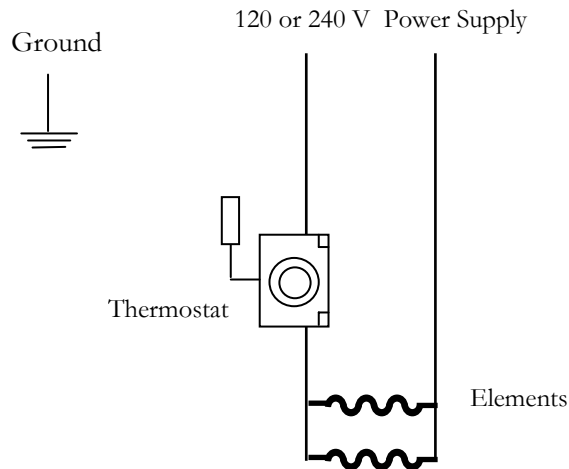
### CHANGING THE HEATING ELEMENT

1. Disconnect power source.
2. Remove back cover and insulation.
3. Remove element leads from terminals.
4. From interior of oven, unscrew element brackets and remove elements from oven.
5. Install new elements and rewire as per wiring diagram.
6. Replace insulation back cover.

## CHANGING THE THERMOSTAT

1. Disconnect from the power source.
2. Remove cover plate from control box and disconnect wire connectors from thermostat leads.
3. Remove thermostat knob and chrome bezel. Knob is secured by recessed set screw.
4. From the inside of the oven, remove sensing tube from holder. Thermostat may now be removed and sensing tube pulled through side wall of oven.
5. Remove leads from old thermostat and place on new, being sure leads are screwed securely in place.
6. To replace thermostat, uncoil an adequate length of the sensing tube to reach holder. Insert sensing tube through oven wall and place in holder.
7. Place thermostat in control box and loosely fasten chrome bezel in place with red indicating light in upward position. Place knob on thermostat stem and adjust bezel so that knob turns freely. Remove knob and secure bezel. Replace knob and tighten set screw.
8. Reconnect electrical leads as per wiring diagram being sure all connections are secure and insulated. Replace control box cover.

K-MPO Wiring Diagram  
120 & 240 V 2000 W



## THERMOSTAT CALIBRATION & ADJUSTMENT

1. Turn on unit. Set control dial at desired temperature.
2. Allow control to cycle at least three times and observe temperature at middle of fourth cycle.
3. If calibration is required, carefully remove dial knob. Do not turn shaft.
4. Turn calibration screw in center of dial shaft. (Turning set screw clockwise decreases temperature. Turning set screw counter-clockwise increases temperature.)
5. Allow unit to cycle three times and observe temperature at middle of fourth cycle. Readjust calibration screw if necessary.
6. Replace dial knob.

## Model K-MPO Repair Parts List

ITEM #	QUANTITY	DESCRIPTION	PART NUMBER
1	1	Shelf Assembly	////////
2	1	Door Pull	430102
3	4	Leveling Bolts	400109
4	2	Draw Pull Catches	430106
5	1	Handy Box	301033
6	1	Pilot Light	301085
7	1	Thermostat	301038
8	2	Heating Elements	120V 301023
			240V 301026
			480V 301029
9	1	Power Cord & Strain Relief	120V 301015 & 301042
			240V 301018 & 301043
			480V 301094 & 301049
10	2	Vent Plugs	490108
11	////////	Door	////////
12	////////	Element Cover	////////
13	////////	Back Cover	////////
14	////////	Name Plate	450103

\*\* Please state model number and serial number and specify voltage and wattage when ordering repair parts, spare parts, or accessory parts. All necessary attaching hardware is supplied with each part ordered. (Item numbers refer to pictorial drawings below for repair parts.)

