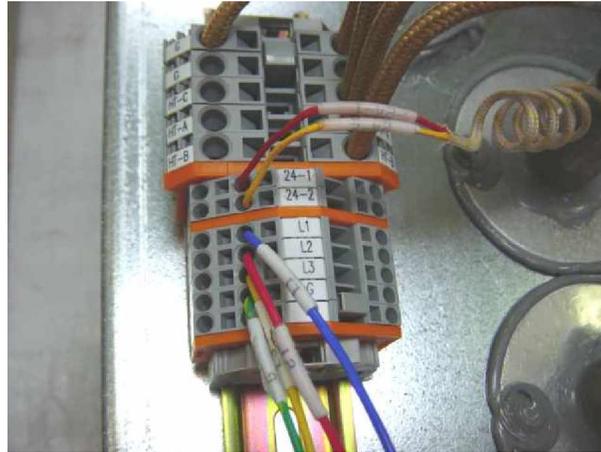Bypass Over Temperature Switches on XPM Series Ovens When Heater Panels That Do Not Support Over Temperature Switches Are Installed as Replacements.

XPM(1) and XPM2

1) Disconnect the wires for the over temperature switch from the terminal block assembly on the outside of the cell. They are in terminals 24-1 and 24-2. This is live DC voltage, so do this with the machine powered off.

XPM series ovens (terminals 24-1 / 24-2)

2) Tie up or cut the wires for the over temperature switch inside the heater cell. If the wires are to be tied up, use something that will withstand high temperatures (up to 350 degrees C) for an extended period of time (forever).

To bypass the entire over temperature switch circuit, find cable #W181 inside the electrical cabinet. It will come in from the top of the cabinet on the left end of the enclosure. Disconnect all individual conductors of that cable from the X20 terminal block assembly at the top of the electrical enclosure. This should be done with the machine powered off. When the conductors are removed, put tape over the ends and stow the cable. Install a wire jumper from terminal #2400 to terminal #24AM on the X20 terminal block (this will power the K4 relay to enable the oven to run).

XPM3

For the XPM3 ovens either follow procedure #1 above, or bypass the entire system.
To bypass the entire system the oven controller software version must be version 02.12.01 or higher. If you do not have this version, you must perform an upgrade. It is recommended that you contact Vitronics Soltec for the latest PC and controller software versions.

TO DISABLE THE OVER TEMP SWITCHES REMOVE AND ISOLATE THE "X" MARKED CONNECTIONS FROM
CONNECTOR P16 ON THE A1 BOARD TO TERMINAL STRIP X20.

REPLACE THE BLUE WIRES ON CONNECTOR P16 ON THE A1 BOARD WITH A JUMPER WIRE INSTALLED
BETWEEN P16 CONNECTOR POSITIONS 1 AND 2.

ISOLATE OR REMOVE THE BLUE WIRES LABELED 24Z1 AND 24AM THAT FORMERLY CONNECTED FROM
CONNECTOR P16 ON THE A1 BOARD TO TERMINAL STRIP X20.

2

If the oven has the Individual Cell Sensing option, the over temperature switch inputs must be removed from the microcontrollers for the option.