

## SET-UP AND SYNCHRONIZATION OF THE LINAK ACTUATORS:

The actuators are installed and synchronized on the oven when it is built.

### **Caution Notes:**

The following process is used for two or three actuators on the same oven, and is required only after replacement of an actuator or control box, or if an actuator is out of adjustment.

1. ***Do not turn the spindle while the actuator is plugged into the actuator control box.*** This will send erroneous pulses to the control box causing misalignment and possible damage to the system. For initial factory set-up or field replacement, the spindle may be turned no more than three revolutions to align the clevis pin hole to the bracket. This must only be done when the actuator is unplugged from the control box.
2. Do not unplug the actuator from the control box during operation or in an attempt to adjust or synchronize the actuators. This will cause misalignment resulting in possible damage to the system.
3. Raising or lowering one side of the heat zone more than the prescribed distance may cause structural damage to the system

## TWO ACTUATOR SYSTEM

The following initialization procedure applies to a two actuator system and requires two people to complete it:

1. With the bonnet in the down position and the actuators properly connected mechanically and electrically, raise the heat zone no more than 1".
2. Disconnect the power to the control box by shutting off the circuit breaker (F52) for at least 5 seconds.
3. On the operator control panel, turn the Hood selector switch to the DOWN position and hold while reconnecting the main power to the actuator control box. Listen for a buzzing sound coming from the control box. At this point the hood selector switch will activate the LEFT actuator and lower the heat zone on that side.
4. Keep the hood selector switch engaged making sure the left actuator pulls the main heat zone down tightly against the lower channel, then release the hood selector switch.
5. Disconnect the power to the control box again by shutting off circuit breaker (F52) for at least 5 seconds

6. On the operator control panel, and turn the hood selector switch to the UP position and hold while reconnecting the main power to the actuator control box. Listen for a buzzing sound coming from the control box. At this point, the hood selector switch has been used to activate the RIGHT actuator causing it to raise the heat zone on that side. Once you notice the right side rising slightly, immediately turn the selector switch to the DOWN position and lower the heat zone completely. **Caution:** Moving the heat zone any more than the prescribed distance may cause structural damage to the system.

7. Keep the hood selector switch engaged making sure the right actuator pulls the main heat zone down tight against the lower channel, and then release the hood selector switch.

8. Disconnect the power to the actuator control box again by shutting off circuit breaker (F52) for at least 5 seconds. The initialization process is now complete.

### **THREE ACTUATOR SYSTEM**

The following initialization procedure applies to a three actuator system and requires two people to complete it:

1. With the bonnet in the down position and the actuators properly connected mechanically and electrically, raise the heat zone no more than 1”.

2. Disconnect the power to the control box by shutting off the F52 circuit breaker for at least 5 seconds

3. On the operator control panel, turn the hood selector switch to the UP position while reconnecting the main power to the actuator control box. Listen for the buzzing sound coming from the control box. At this point turn the hood selector switch to the DOWN position; this will activate all three actuators to the DOWN position.

4. Keep the hood selector switch engaged making sure that each actuator pulls the main heat zone down tightly against the lower channel, then release the hood selector switch.

5. Disconnect the power to the control box again by shutting off the F52 circuit breaker for at least 5 seconds. The initialization process is now complete.

### **Periodic Inspection and Maintenance:**

Clean the piston rod in the fully extended position and inspect for mechanical wear or damage. Inspect the attachment points, wiring, plugs, and control box. The LINAK actuator is an enclosed unit and does not require any internal maintenance or lubrication.

### **Troubleshooting:**

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Symptom: No motor sound or movement of piston rod.

Possible Causes:

1. The actuator is not plugged securely into the control box.
  2. Blown fuse in the control box.
  3. Cable damage.
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Symptom: Movement of actuators not synchronized.

Possible Cause: Control box out of initialization.