



# 350 LB (159 KG) CAPACITY ELECTRODE STABILIZING OVEN



## MODELS:

**350**

**350-E**

**350-220**

**350-220-S**

## PARTS LIST & OPERATING INSTRUCTIONS

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## **SAFETY INSTRUCTIONS**

Although the Gullco Model 350 series of Electrode Stabilizing Ovens are manufactured for safe and dependable operation, it is impossible to anticipate those combinations of circumstances, which could result in an accident. An operator of this equipment is cautioned to always practice "**Safety First**" during each phase of setup, operation and maintenance.

Read and understand the whole operation manual before operating or performing service of this equipment. Become familiar with the ovens operation, applications and limitations. Keep the operation manual in a clean and readily available location.

A careless operator invites troubles, and failure to follow safety practices may cause serious injury or even death. Important safety precautions are given in the following:

### **Electrical Shock Prevention**

- Do not use this equipment in damp or wet locations.
- Do not expose this equipment to rain.
- Never carry this equipment by the power cord or pull the power cord to disconnect from the receptacle.
- Keep the power cord from heat, oil and sharp edges.
- Inspect the power cord periodically and replace if damaged.
- Inspect the secureness of the power cord periodically and repair if loose.
- Disconnect the power cord when not in use.
- Disconnect the power cord **positively** to prevent electrical shock before repair and service of the equipment.

### **Bodily Injury Prevention**

- Do not stack Model 350 Ovens higher than four ovens.
- Wear suitably rated thermal gloves, aprons, etc., when handling the oven or contents after the oven has been energized.

**IMPORTANT!** BEFORE CONNECTION: ENSURE THAT SUPPLY VOLTAGE MATCHES THAT SHOWN ON THE PRODUCT LABEL/RATING PLATE

NOTE Other important safety instructions are given elsewhere in this manual. Make sure that you read, understand and follow all such instructions.

**ALL THE SAFE PRACTICES AND PRECAUTIONS MAY NOT BE GIVEN IN WRITING. SOME ARE BASED ON COMMON SENSE, BUT OTHERS MAY REQUIRE TECHNICAL BACKGROUND TO EXPLAIN.**

## SPECIFICATIONS

MODEL	350	350-E	350-220	350-220-S
VOLTAGE	115 VAC, 1 $\phi$ , 50/60 HZ	115 VAC, 1 $\phi$ , 50/60 HZ	230 VAC, 1 $\phi$ , 50/60 HZ	230 VAC, 1 $\phi$ , 50/60 HZ
LINE CORD	NORTH AMERICAN	EUROPEAN	EUROPEAN	AUSTRALIAN
AC PLUG	NORTH AMERICAN	NONE	NONE	AUSTRALIAN
WATTAGE	1500 WATTS			
CAPACITY	350 LB / 159 KG			
APPROXIMATE TEMPERATURE RANGE	100 - 550°F 38 - 288°C			
WEIGHT	105 LB / 47.6 KG			
EXTERNAL DIMENSIONS	H-22", W-22", D-24½" H-559mm, W-559mm, D-622mm			
INTERNAL DIMENSIONS	H-14", W-16", D-19" H-355mm, W-406mm, D-482mm			

## GENERAL DESCRIPTION

The Model 350 series of ovens are 350 lb (159 kg) capacity electrode stabilizing ovens used to maintain welding electrodes in their dry state or to dry electrodes which have absorbed moisture. The Model 350 is operated on single phase power with heat being supplied by a single element. The ovens are normally located in a central storage area. They are complete with recessed controls, removable shelves, full insulation pilot light and a heating system incorporating a low watt density element. Temperature is thermostatically controlled. Nesting feet and sockets ensure safe, easy stacking of up to four ovens.

Ensure adequate free space is provided around the ovens for safe loading and unloading of the electrodes. Users should exercise caution when loading and unloading the oven. Certain parts of the oven and the electrodes may reach temperatures exceeding 550° F (288°C). All exposed body parts must be protected against accidental contact with hot materials. Safety glasses, gloves, overalls, and protective footwear must be worn when using the oven. Hot electrodes must be unloaded into a suitable container capable of withstanding the heat and of containing the load safely.

To minimize the risk of electrical shock the Model 350 range of ovens should not be exposed to rain or placed in a wet location. Liquids should not be placed in the oven. The oven should be connected to a suitable, fused power supply using a recognised connector. The oven must be properly earth grounded. To minimise the risk of fire do not place food, beverages or other combustible items in the oven.

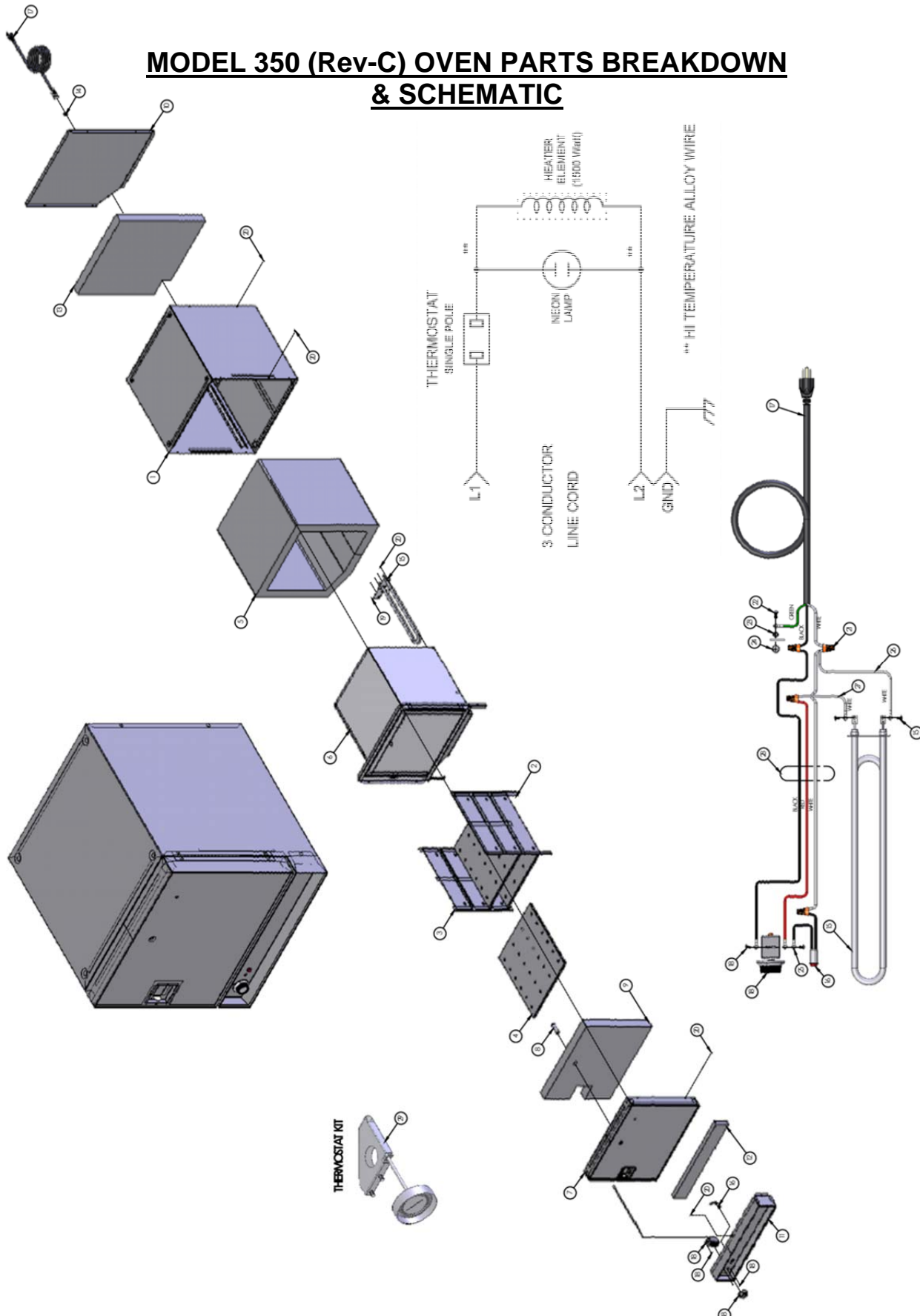
## USING THE OVEN

The oven is loaded and unloaded via the front door. Avoid contact with hot surfaces during this operating. The load should be distributed securely and evenly within the oven to ensure even heating. The shelves may be removed to accommodate larger loads if required.

## MODEL 350 (Rev-C) OVEN PARTS BREAKDOWN

ITEM	PART NO.	DESCRIPTION	350	350-E	350-220	350-220-S
	350 OVEN SHELL	350 OVEN SHELL (INCLUDES ITEMS 1-11)				
1	GOV-35-001	OVEN COVER	1	1	1	1
2	GOV-35-058	RIGHT SIDE RACK	1	1	1	1
3	GOV-35-057	LEFT SIDE RACK	1	1	1	1
4	GOV-35-045	INNER PAN	3	3	3	3
5	GOV-35-060	INNER INSULATION	1	1	1	1
6	GOV-35-005	INNER SHELL ASSEMBLY	1	1	1	1
7	GOV-35-002	OVEN DOOR ASSEMBLY	1	1	1	1
8	GOV-35-056	SPACER	1	1	1	1
9	GOV-35-065	DOOR INSULATION	1	1	1	1
10	GOV-35-013	BACK COVER	1	1	1	1
11	GOV-35-071	CONTROL PANEL WELDS	1	1	1	1
12	GOV-35-068	CONTROL PANEL INSULATION	1	1	1	1
13	GOV-35-063	REAR PANEL INSULATION	1	1	1	1
14	GK-148-005	STRAIN RELIEF, HEYCO #6P3-4	1	1	1	1
15	1015	115V HEATER ELEMENT	1	1		
	1020	230V HEATER ELEMENT (220V, 1500W)			1	1
16	1010-A1	PILOT LIGHT 115V	1	1		
	2010-A1	PILOT LIGHT 230V			1	1
17	350-LC	POWER CORD- NORTH AMERICAN 115V ONLY	1			
	350-LC-220	POWER CORD - EUROPEAN 115V OR 230V		1	1	
	10-LC-S	POWER CORD - AUSTRALIAN 230V ONLY				1
18	EA-5	THERMOSTAT	1	1	1	1
19	GOV-35-074	ELEMENT COVER PLATE	1	1	1	1
20	GK-112-140	#10-32x1/2 ROUND TRUSS HEAD STS	19	19	19	19
21	GK-151-008	WIRE NUT	4	4	4	4
22	GK-112-065	10-32 x 3/8" ROUND HEAD SCREW	1	1	1	1
23	GK-129-012	#10 STAR WASHER	1	1	1	1
24	GK-135-057	10-32UNC STAR LOCK NUT	1	1	1	1
25	GK-156-008	#10 RING TERMINAL	1	1	1	1
26	GOV-35-066	ELEMENT WIRE ASSEMBLY (LONG)	1	1	1	1
27	GOV-35-062	ELEMENT WIRE ASSEMBLY (SHORT)	1	1	1	1
28	GOV-35-004	350 OVEN WIRING HARNESS	1	1	1	1
29	T-23	THERMOMETER KIT (OPTIONAL)	1	1	1	1

# MODEL 350 (Rev-C) OVEN PARTS BREAKDOWN & SCHEMATIC



## **REVISIONS LIST**

February, 2016

Overall      General revisions to the manual format. Removal of references to 350A and inclusion of the 350-E, 350-220 & 350-220-S.

### **ADDITIONAL NOTES**

Specifications and products are subject to change without notice.  
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Only use genuine/authorized replacement parts.



# GULLCO



LINEAR or RADIAL  
HIGH DEPOSIT RATE  
QUICK SETUP TIME

## KAT<sup>®</sup> OSCILLATOR

- Motorized weld center line adjustment
- Motorized stroke width
- Oscillation speed control
- Store up to 10 welding programs



PORTABLE PLATE EDGE  
BEVELLING MACHINE  
QUICK SETUP TIME

## KBM<sup>®</sup>

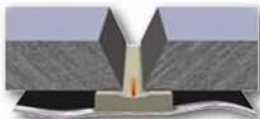
- Produce clean bevels with no thermal distortion
- Bevels angles 22° to 55° (other angles available)
- Hydraulic and Adjustable undercarriages available
- Bevels Mild Steel, Stainless Steel, and Aluminium
- Reduce cost and save time by minimising defects and poor fit up



ONE SIDED WELDING  
X-RAY QUALITY BEADS  
HIGH DEPOSIT RATE

## KATBAK<sup>®</sup> CERAMIC WELD BACKING

- Eliminate Defects And Rework
- Eliminate Costly Unnecessary Gouging And Grinding
- Sizes 1/4" (6.3 mm) to 2" (51 mm)
- Special Sizes And Configurations Available



PORTABLE AND COMPACT  
INCREASE EFFICIENCY  
MORE ARC ON TIME

## MOGGY<sup>®</sup> FILLET WELD CARRIAGE

- Single or Dual Torch Models
- Magnet or Non Magnetic Base
- Continuous or Stitch Welding Models
- Fillet, Lap, Butt and Dual Torch Welding

