



Consistency You Can Count On

Lincoln Aperion 24 Impinger® Conveyor Oven

Parts Manual For 60 Hz

Models:

1624E, 2024E, 2424E, 2824E,
1624G, 2024G, 2424G, 2824G



Original Document

Document #: LIN_EOGO_P_24APERION_4607940 – 03/24

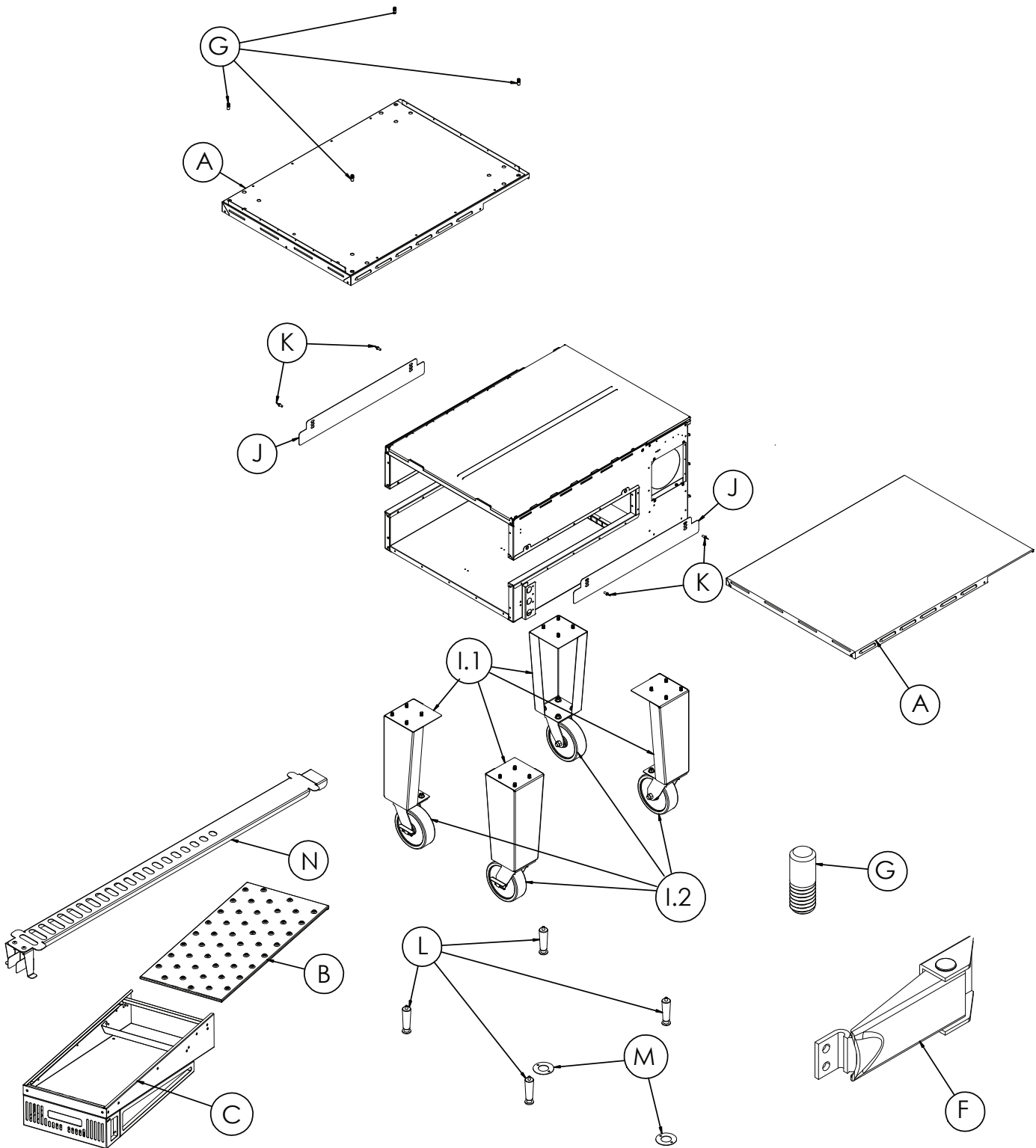


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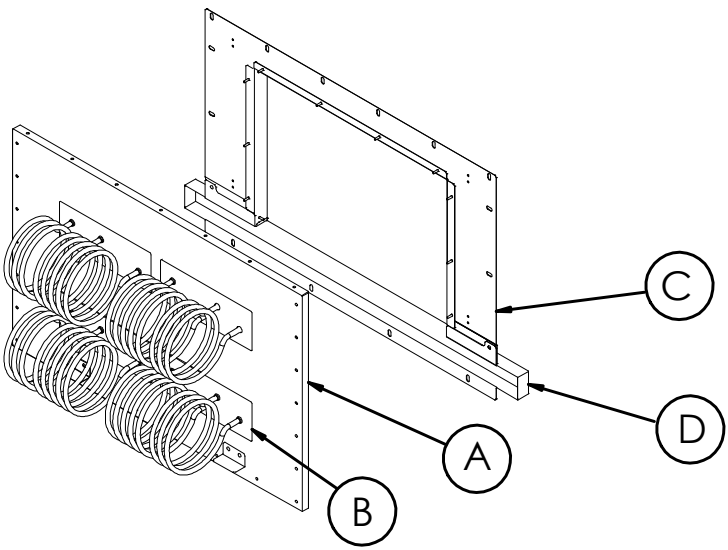
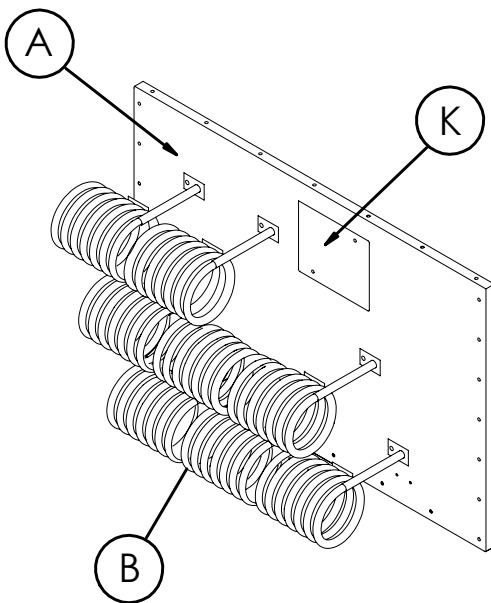
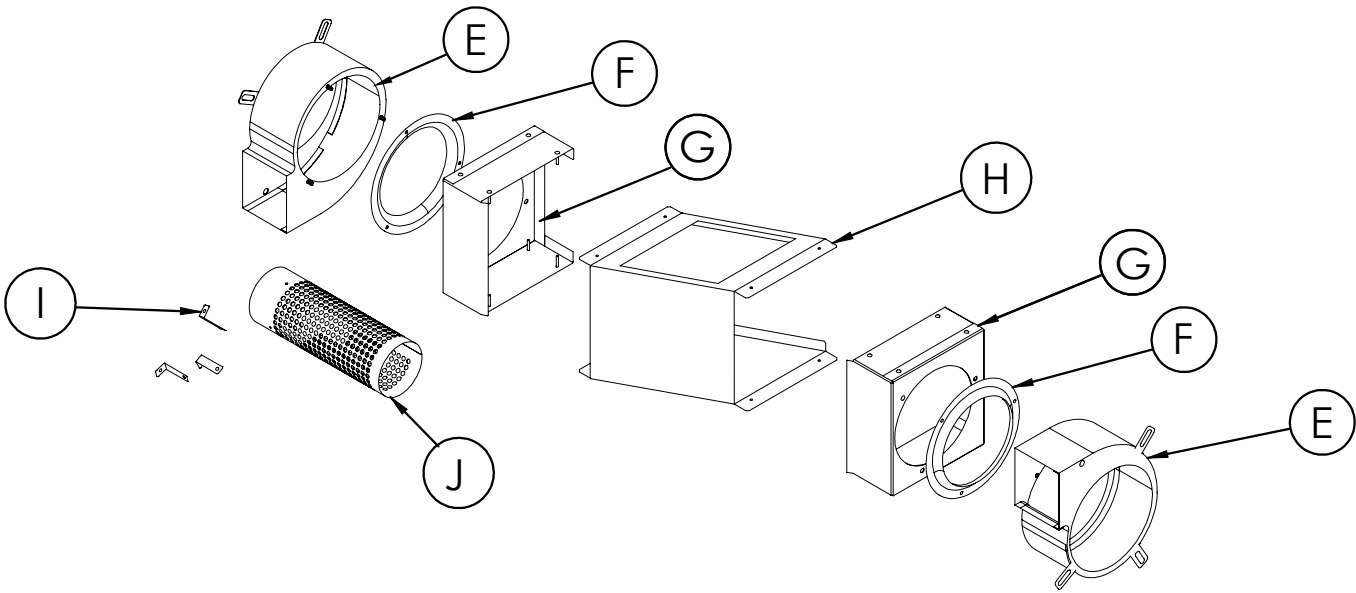
MAIN CAVITY



MAIN CAVITY

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	TOP COVER – STACKING KIT	L4608576	L4609331	L4608493	L4610145
	TOP COVER (SINGLE OR TOP COVER OPTION)	4608530	4609328	4608494	4609317
B	FINGER JET PLATE	4608541	4609226	4604975	4609189
C	FINGER HOUSING ASSEMBLY	CK4608543	CK4609223	CK4605326	CK4609191
F	LATCH & CATCH	369501			
G	PARTIAL THREADED ROD 3/8-16 X 1 LONG	4606203			
I.1	LEG	369328			
I.2	CASTER	369030			
J	BAFFLE - (FOR ALL 2424E/G-00X)	N/A	N/A	4605382	N/A
	BAFFLE - (FOR 1624, 2024, 2424, 2824 - XXX)	4610203	4610211	4610195	4610207
K	THUMB SCREW	369211			
L	LEG, 4 INCH	369461			
M	MOUNTING RING (2 RINGS AND HARDWARE)	369451			
N	CENTER AIR RETURN BRACKET ASSEMBLY	CK4608548	CK4610238	CK4606343	CK4609442

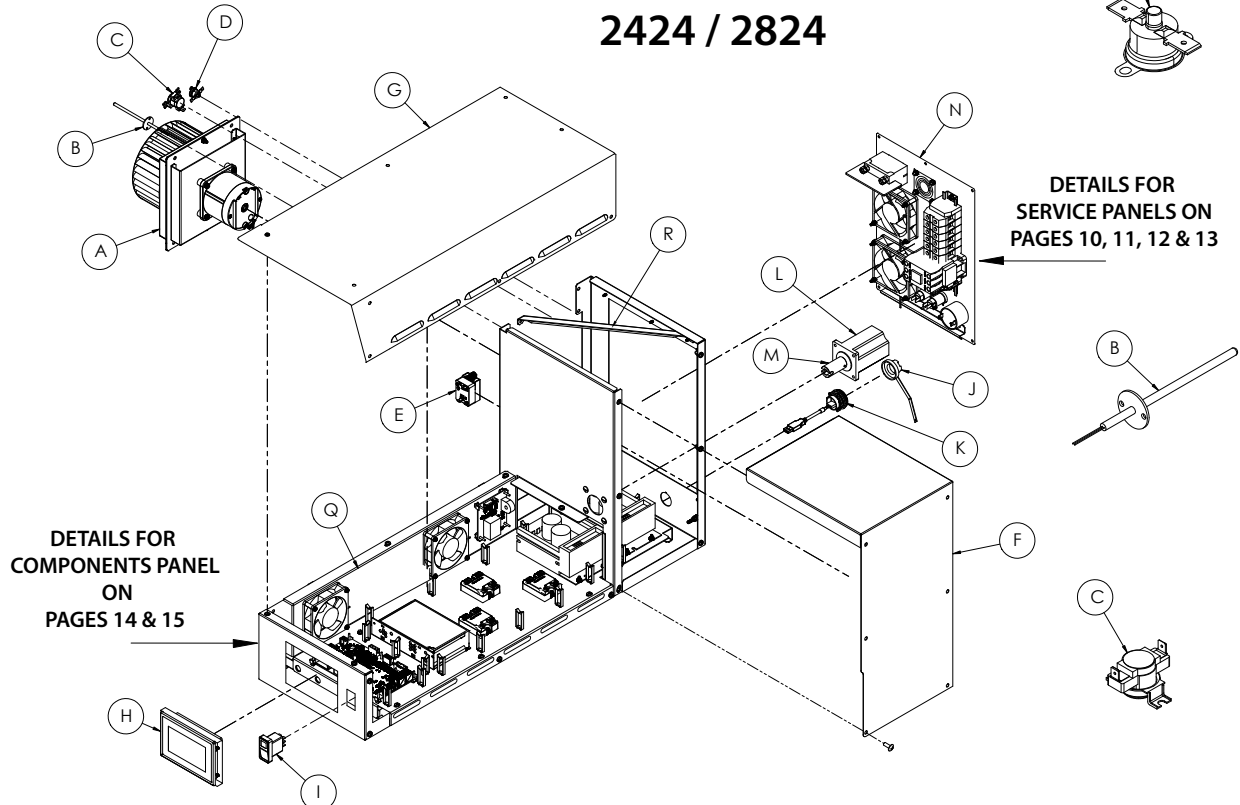
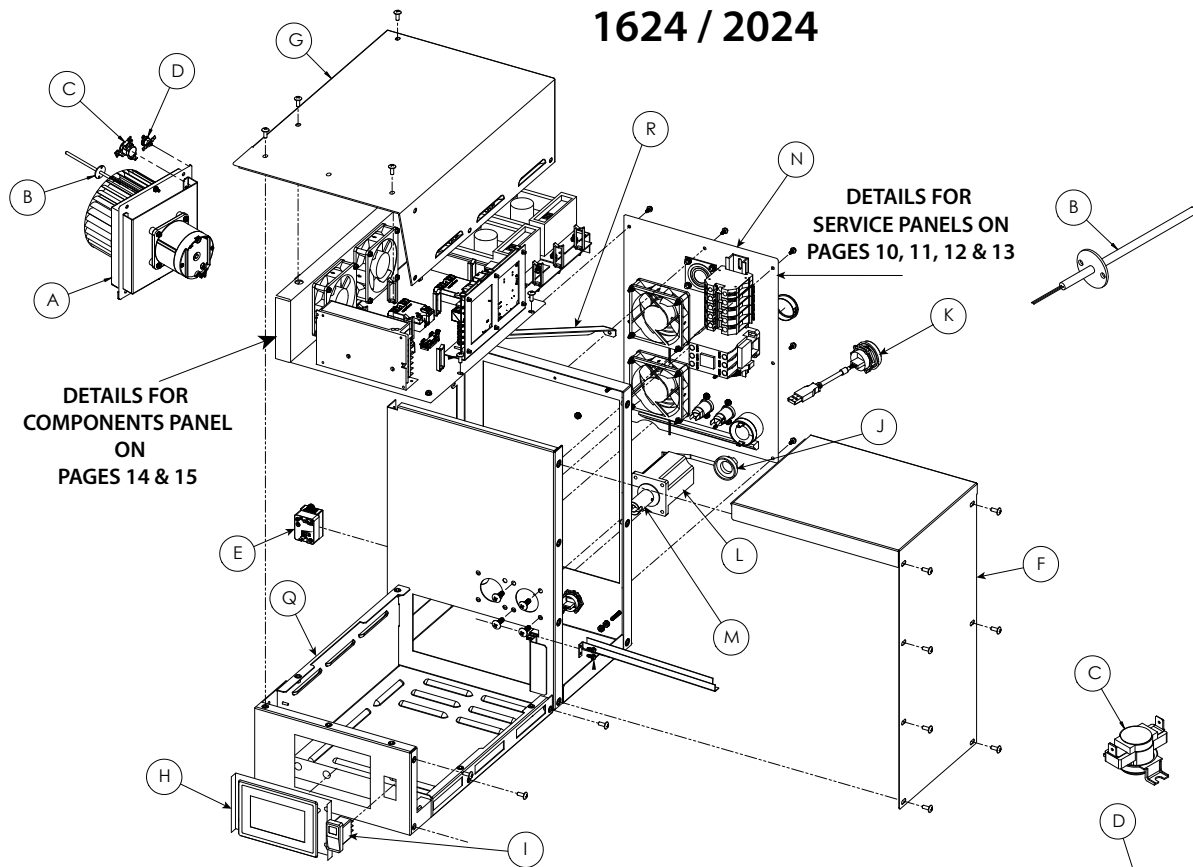
ELEMENT & HOUSING ASSEMBLY



ELEMENT & HOUSING ASSEMBLY

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	BACK PANEL (ELECTRIC)	4605710 FOR 2424E-000X 4609707 FOR (1624, 2024, 2424, 2824-XXX)			
B	ELEMENT	4605710 FOR 2424E-000X 4609707 FOR (1624, 2024, 2424, 2824-XXX)			
C	REAR COVER ASSEMBLY	CK4610274			
D	REAR COVER WIRE CHANNEL	4605264			
E	BLOWER HOUSING	4605392			
F	INLET CONE	4605621			
G	CAVITY ELEMENT BAFFLE (GAS)	4607577			
H	FUNNEL (GAS)	4607574			
I	FLAME PROTECTOR L-BRACKET (GAS)	4607573			
J	FLAME PROTECTOR (GAS)	4607563			
K	ELEMENT COVER	4609720			
NOT SHOWN	BACK PANEL (GAS)	4607547			

RIGHT CONTROL BOX - ELECTRIC & GAS

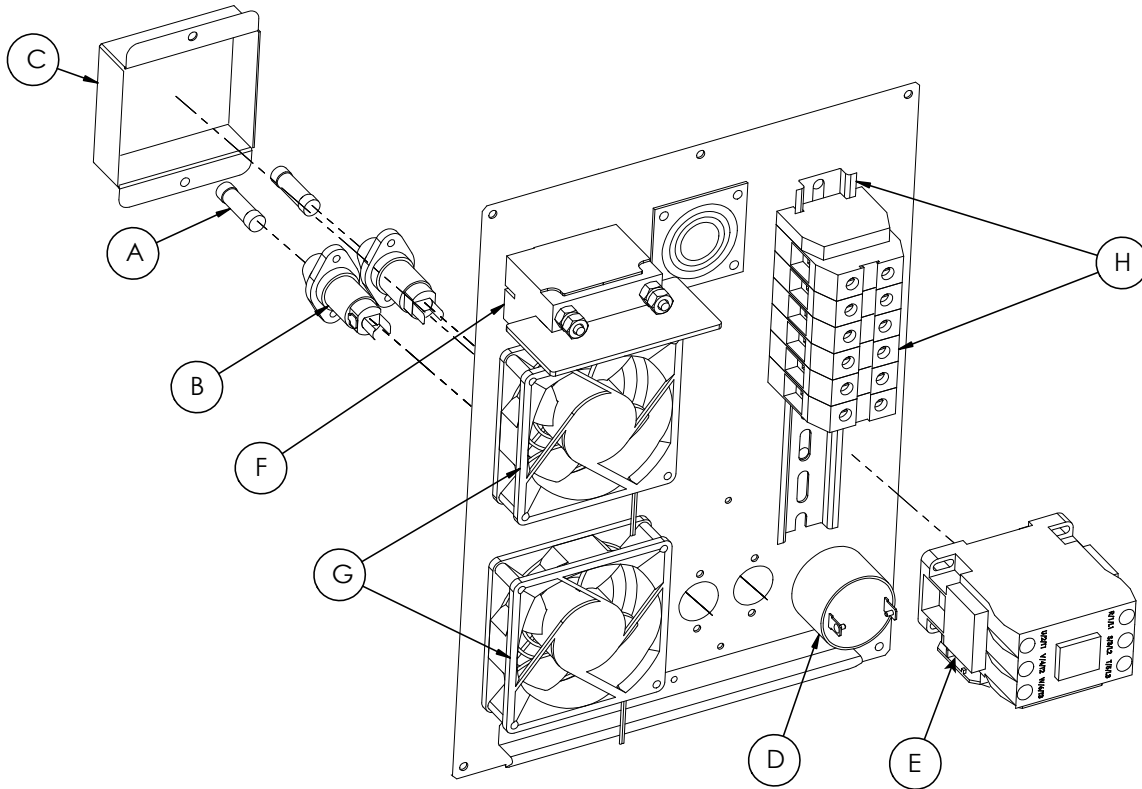


RIGHT CONTROL BOX - ELECTRIC & GAS

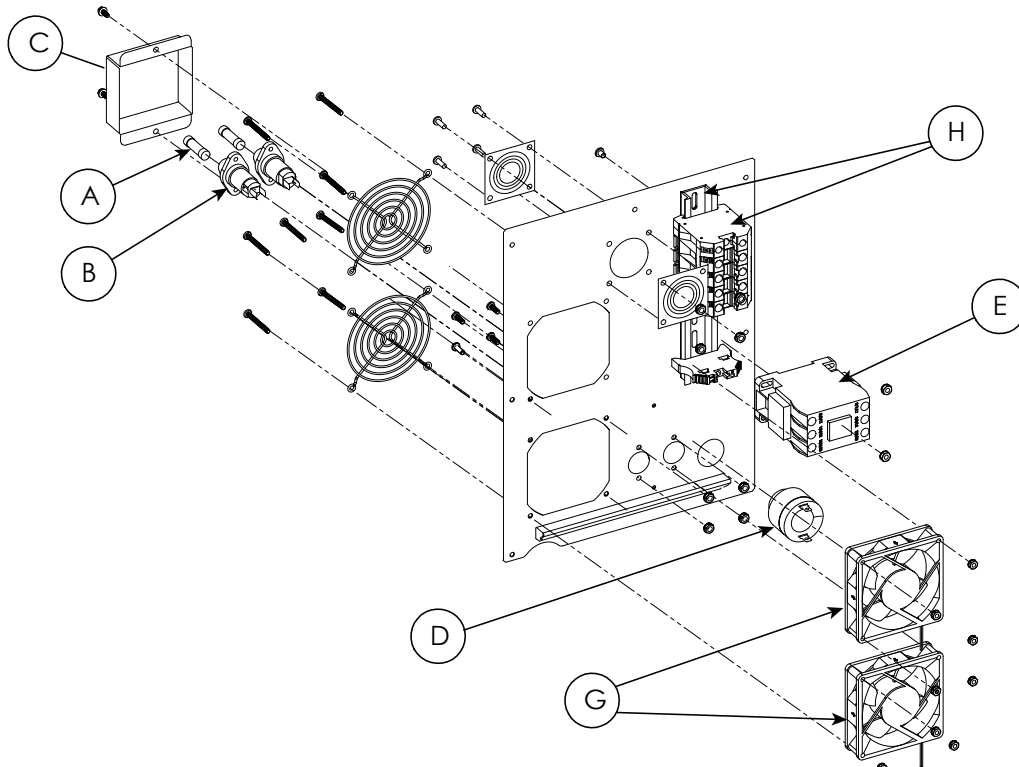
LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBERS			
A	FAN MOTOR ASSEMBLY	CK4605340			
B	THERMOCOUPLE	4603578			
C	THERMOSTAT COOLING FAN	369507			
D	THERMAL DISCONNECT	4605622			
E	HIGH LIMIT THERMOSTAT CAPILLARY	4607695			
F	COVER, SIDE, CORNER, CTRL BOX	4605019			
G	COVER, L-SHAPE, CTRL ELEC BOX	4608562	4609293	4608449	4609220
H	COMMON 4.3" UI, ASSEMBLY	CK4609353			
I	MAIN POWER SWITCH	4600614			
J	USB SEALING CAP	4532043			
K	USB PANEL MOUNT	4532040			
L	CONVEYOR MOTOR (INCLUDES COUPLER)	CK4605922			
M	COUPLING SLEEVE (INCLUDES SET SCREW)	CK4605921			
N	SERVICE PANEL ASSEMBLY	SEE SERVICE PANEL PAGE 10-13			
Q	COMPONENT PANEL ASSEMBLY	SEE COMPONENT PANEL PAGE 14-15			
R	CORNER BRACE	4606621			
NOT SHOWN	ETHERNET PATCH CORD (UI TO I/O BOARD)	4607498			
NOT SHOWN	USB EXTENSION	4610286		4607876	
DOM ELECTRIC WIRE HARNESES					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610220		2424E-000X:4605293 ALL OTHERS: 4610257	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS)	FOR 2424E-000X: 4605294 FOR (1624, 2024, 2424, 2824-XXX): 4610258			
NOT SHOWN	REAR WALL WIRING HARNESS	FOR 2424E-000X: 4605295 XX24-SXX (3 PHASE): 4610287 XX24-LXX (3 PHASE): 4610288 XX24-LXX (1 PHASE): 4610289			
DOM GAS WIRE HARNESES					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610492		2424E-000X: 4608356 (1624, 2024, 2424, 2824-XXX): 4610491	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS)	4608357			
NOT SHOWN	REAR WALL WIRING HARNESS	4605295			
NOT SHOWN	LEFT TOWER WIRING HARNESS	4608358			

SERVICE PANEL - ELECTRIC

SERVICE PANEL - ELECTRIC FOR 2424E-0006



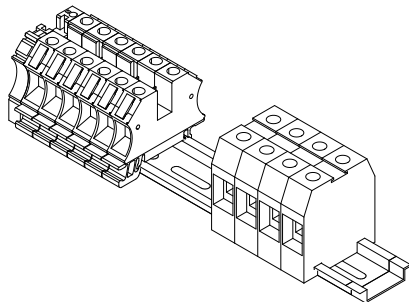
SERVICE PANEL - ELECTRIC FOR (1624, 2024, 2424, 2824-XXX)



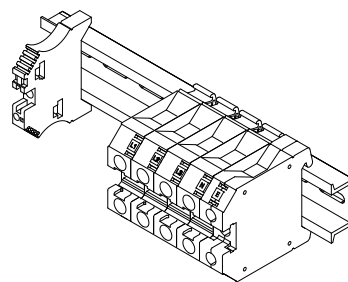
SERVICE PANEL - ELECTRIC

LETTER	DESCRIPTION	PART NUMBER
A	FUSE, 10 AMP CARTRIDGE	369166
B	FUSE HOLDER 15A 300V	369129
C	COVER FUSE 2' OVEN	10001365
D	ALARM, 240V	4607019
E	CONTACTOR, DCTI	370739
F	CIRCUIT BREAKER 2 POLE 30A (ONLY FOR 2424E-006)	2688801
G	COOLING FAN, 24DC	4604746
H	TERMINAL BLOCK 10 (ONLY FOR 2424E-006)	4607855
	TERMINAL BLOCK 5, FOR (1624, 2024, 2424, 2824-XXX)	4609840
NOT SHOWN	FAN GUARD	4604757

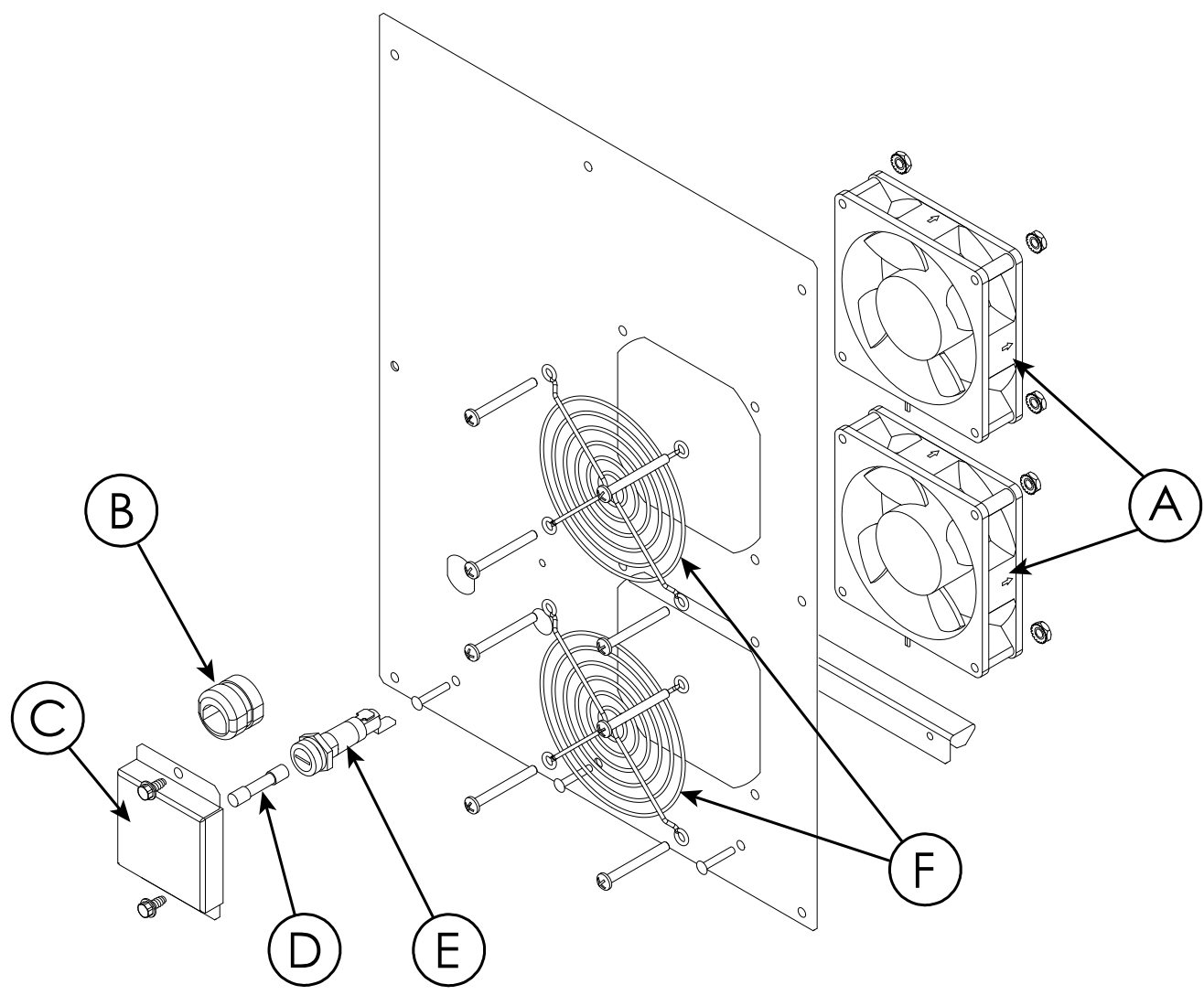
TERMINAL BLOCK 10 - 4607855



TERMINAL BLOCK 5 - 4609840



SERVICE PANEL - GAS

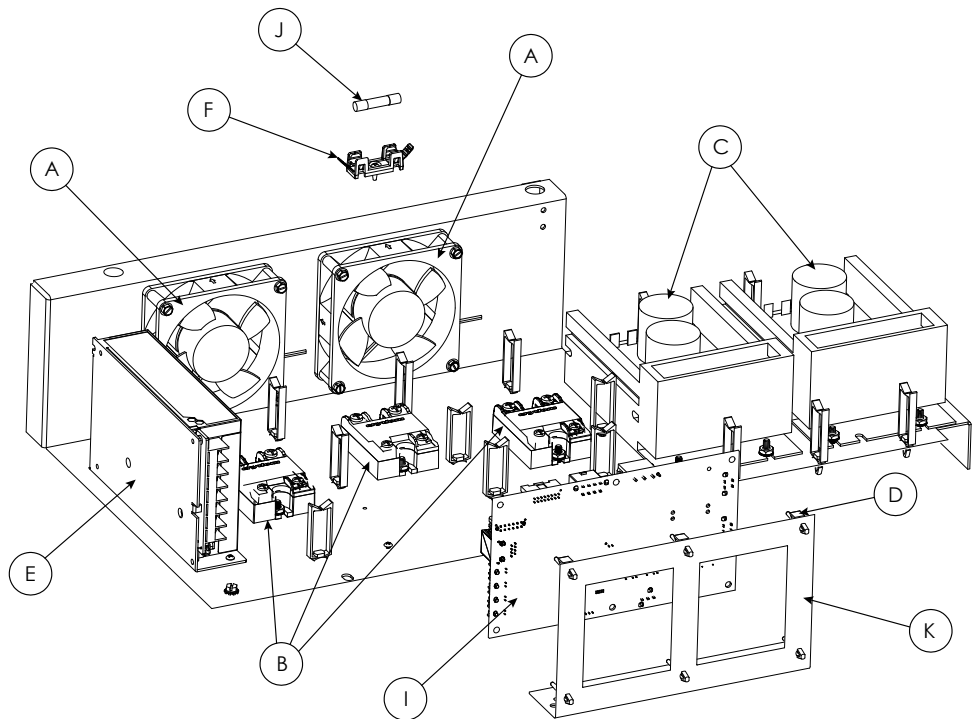


SERVICE PANEL - GAS

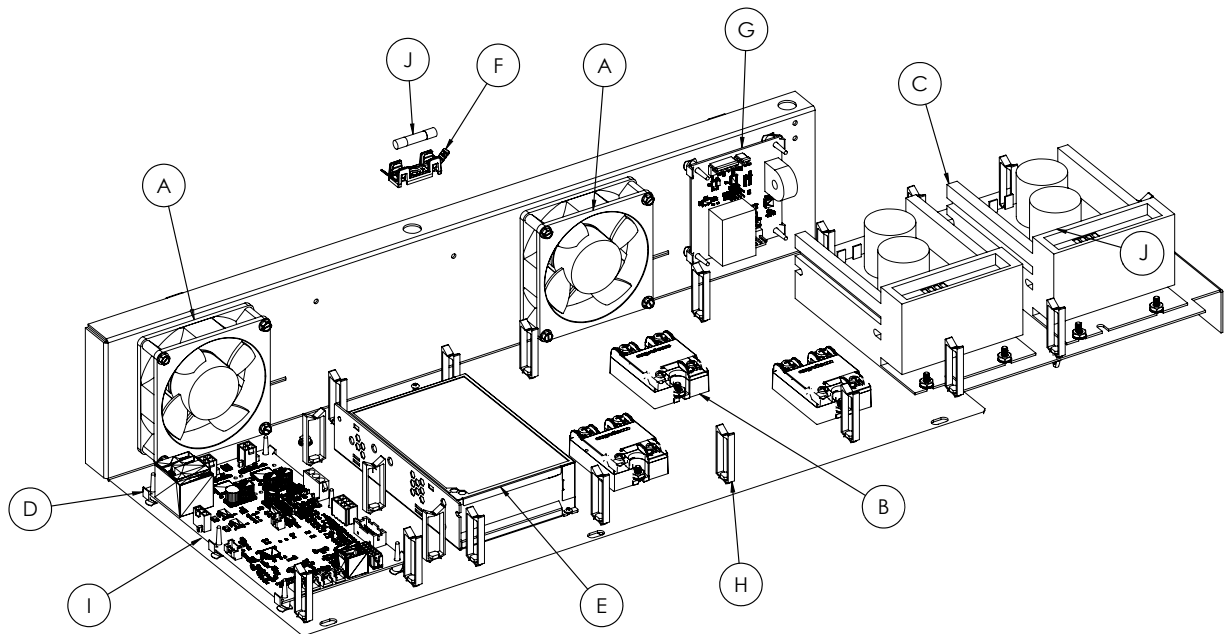
LETTER	DESCRIPTION	PART NUMBER
A	COOLING FAN, 24VDC, 2424	4608567
B	STRAIN RELIEF, SR 7N-2	4070505
C	FUSE COVER APERION	4609334
D	FUSE TIME DELAY 15A	4605328
E	FUSE HOLDER, HTB-361	4070593
F	FAN GUARD	4604757
NOT SHOWN	POWER CORD W/PLUG 2"	4020053

COMPONENT PANEL - ELECTRIC & GAS

1624 / 2024



2424 / 2824

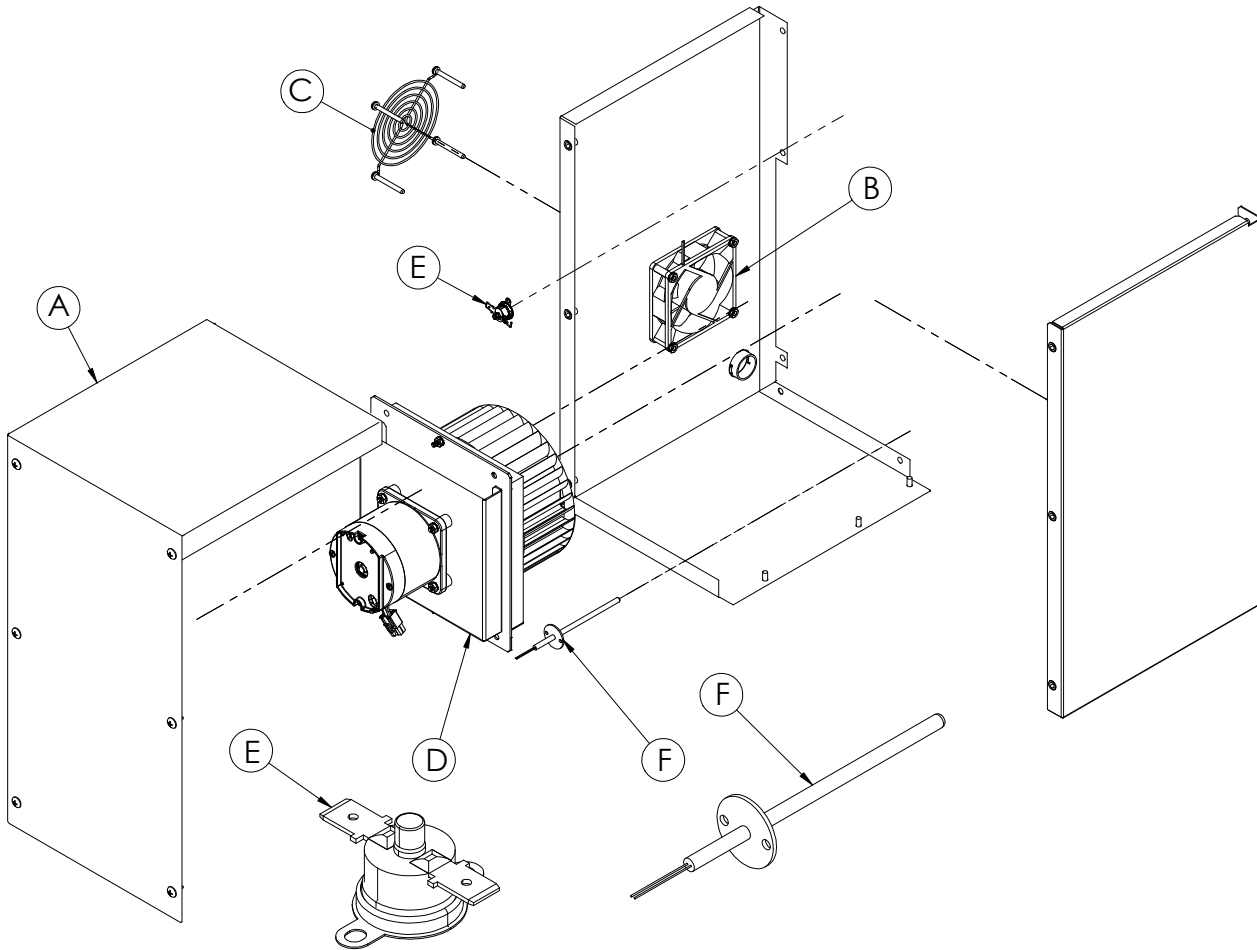


COMPONENT PANEL - ELECTRIC & GAS

LETTER	DESCRIPTION	PART NUMBER
A	COOLING FAN, 24VDC, 2424	4608567
B	SSR, 50A, 1 POLE (3 PC.FOR ELECTRIC; 1 PC. FOR GAS)	4605506
C	BLOWER MOTOR DRIVER	4605923
D	STANDOFF, MALE SNAP-IN	369856
E	POWER SUPPLY	4604751
F	FUSE BLOCK, 20A 600V, CHASSIS MOUNT	2320700
G	DUAL VOLTAGE CONTROL BOARD - 2424E-0006	4604369
I	I/O BOARD LINCOLN	CK4609352
J	FUSE, 4A 600V	4606033
K	I/O SUPPORT BRACKET	4607165
NOT SHOWN	BLOWER MOTOR CHOKE	4607696

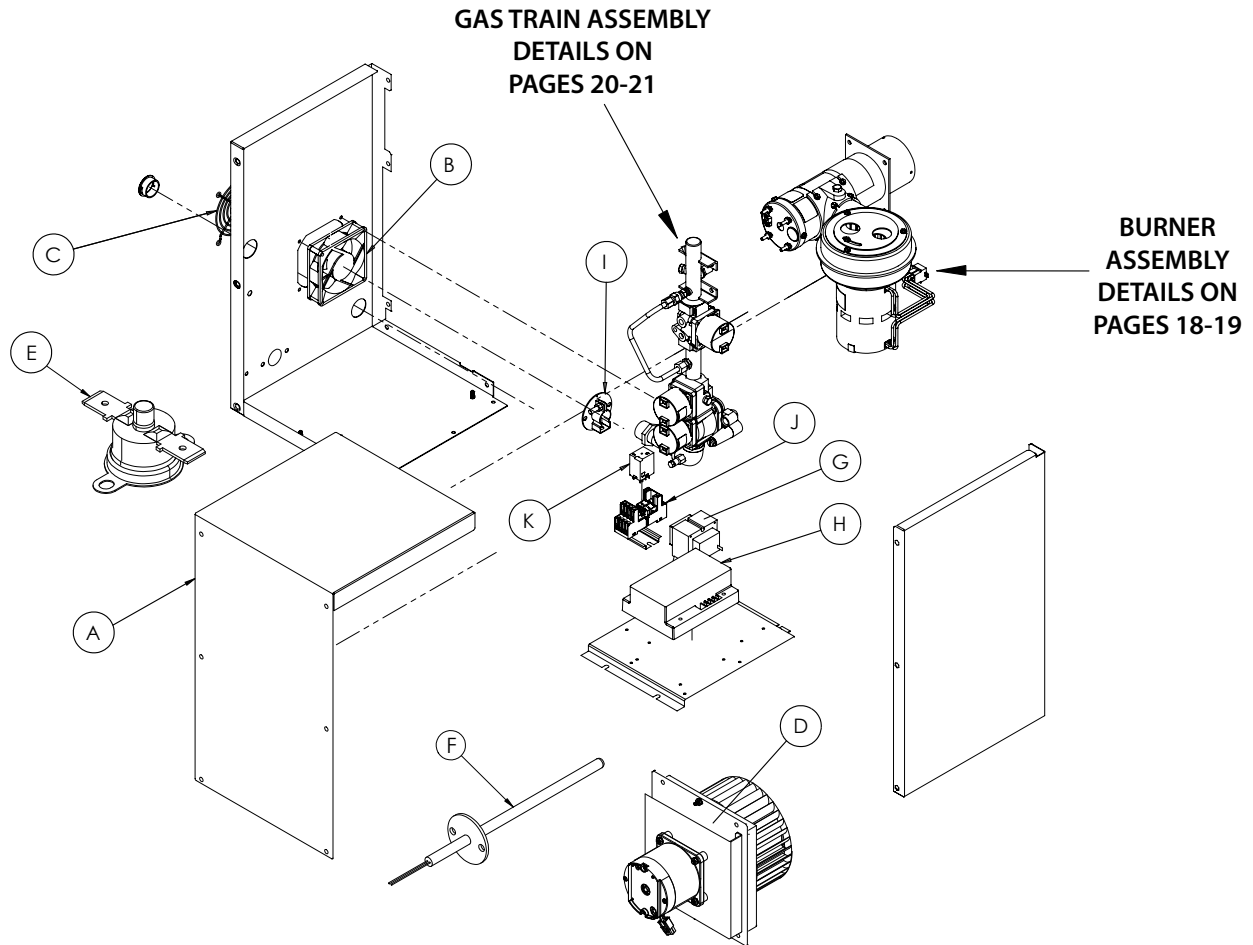
LETTER	PART NUMBER	DESCRIPTION	QTY NEEDED PER MODELS			
			1624	2024	2424	2824
NOT SHOWN	4607498	ETHERNET PATCH CORD - REGULAR	1	1	2	2
NOT SHOWN	4610285	ETHERNET PATCH CORD, ANGLED (ONLY FOR 1624-XXX AND 2024-XXXX)	1	1	0	0

LEFT CONTROL BOX - ELECTRIC



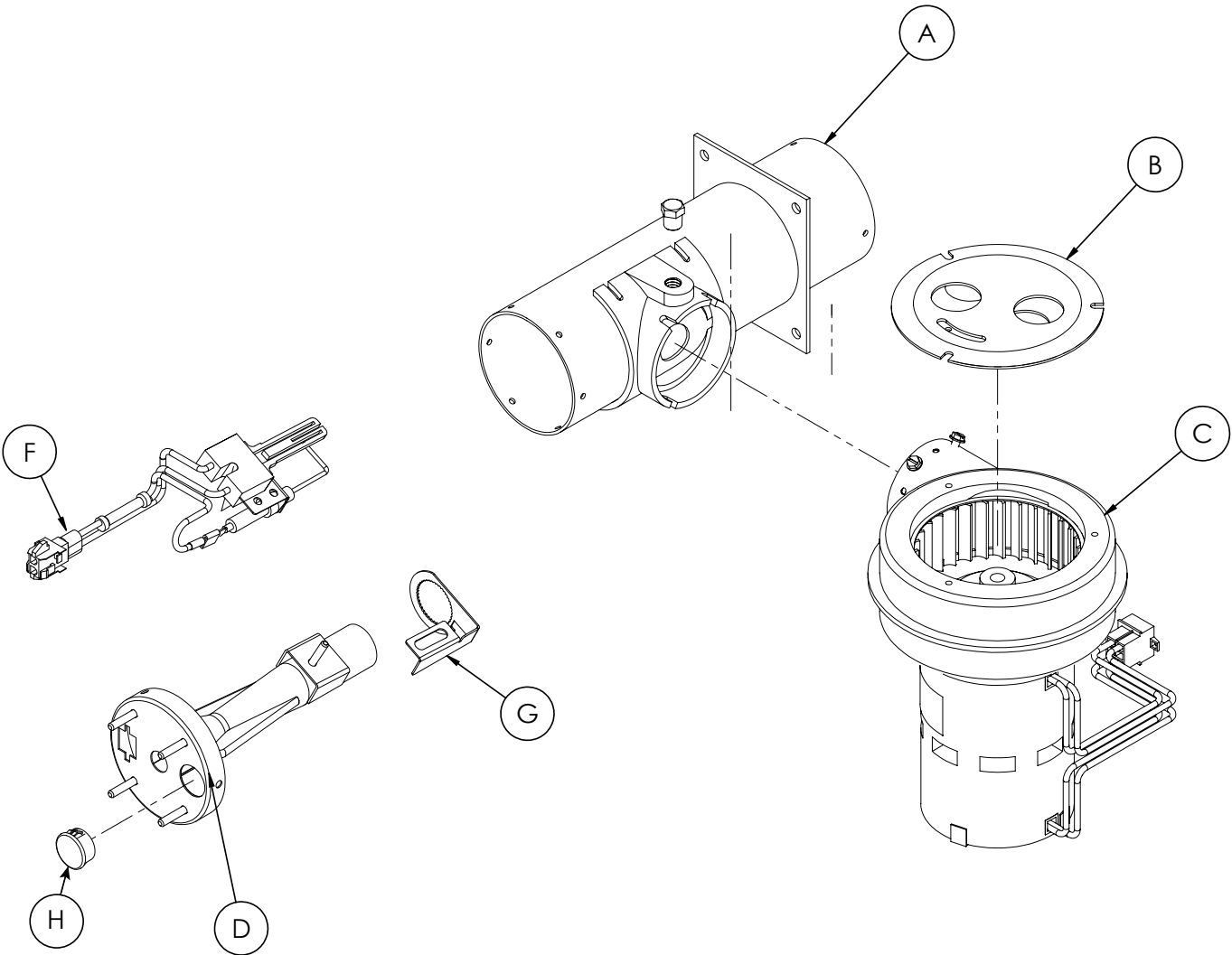
LETTER	DESCRIPTION	PART NUMBER
A	COVER, SIDE, CORNER, CONTROL BOX	4607515
B	COOLING FAN, 24VDC, 2424	4608567
C	GUARD, FAN	4604757
D	FAN MOTOR ASSEMBLY	CK4605340
E	THERMAL DISCONNECT	4605622
F	THERMOCOUPLE	4603578

LEFT CONTROL BOX - GAS



LETTER	DESCRIPTION	PART NUMBER
A	COVER, SIDE, CORNER CONTROL BOX	4607515
B	COOLING FAN, 24VDC	4608567
C	GUARD, FAN	4604757
D	FAN MOTOR ASSEMBLY	CK4605340
E	THERMAL DISCONNECT	4605622
F	THERMOCOUPLE	4603578
G	TRANSFORMER OVEN	9900250
H	IGNITOR CONTROL	369532
I	BULK HEAD ASSEMBLY	371539
J	RELAY BASE	4608479
K	RELAY - DPDT 10A, 24VAC COIL	4608478
NOT SHOWN	GAS SHUT-OFF VALVE	369081

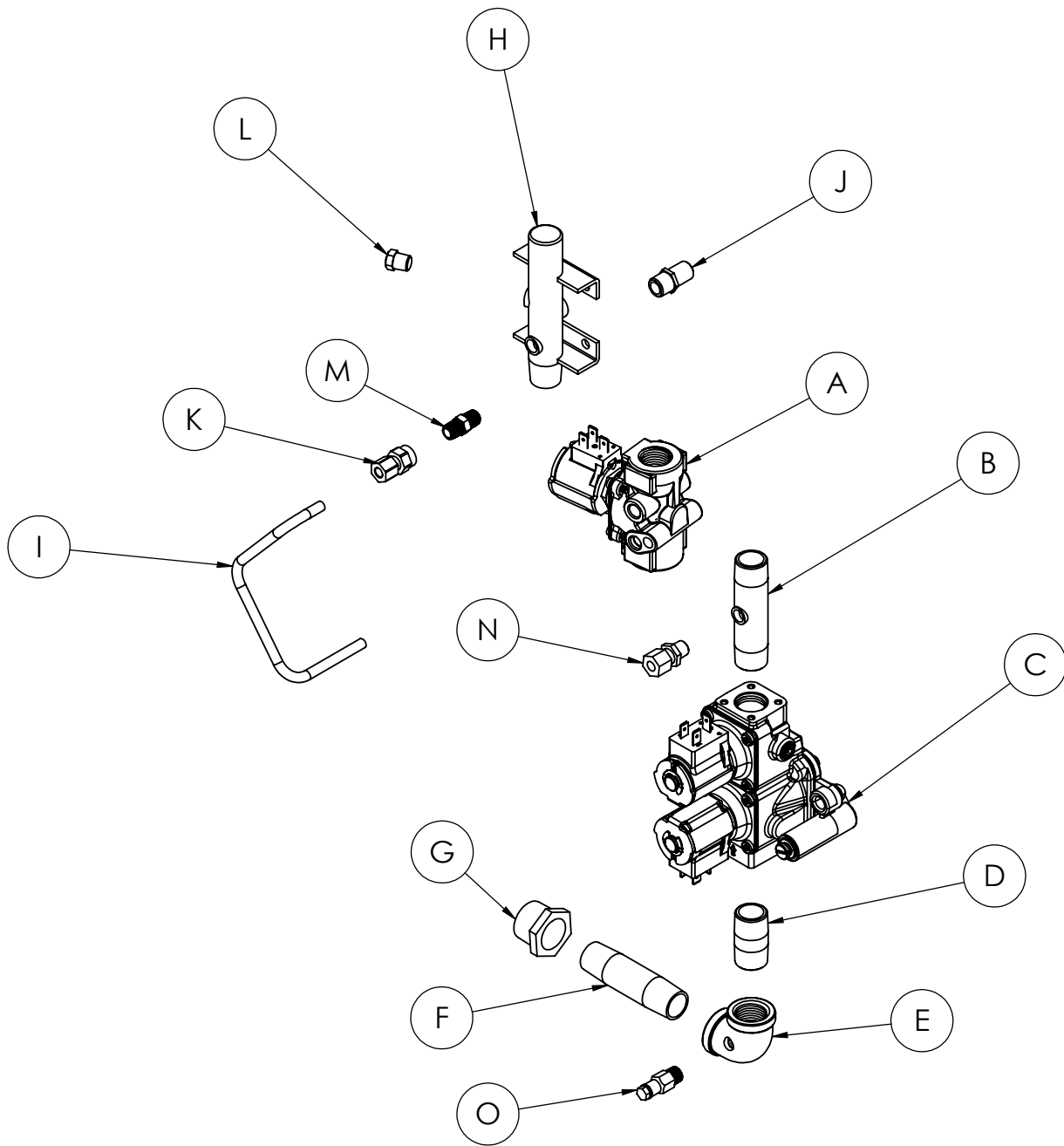
BURNER ASSEMBLY



BURNER ASSEMBLY

LETTER	DESCRIPTION	NATURAL GAS	PROPANE
A	BURNER TUBE ASSEMBLY	369662	
B	AIR SHUTTER, BURNER	369401	
C	BLOWER MOTOR ASSY DOMESTIC	4071242	
D	VENTURI HOT	4608263	4610262
F	HOT SURFACE IGNITOR	4070519	
G	VENTURI RING BRACKET	4608261	
H	SNAP BUSHING HEYCO WP-750	4071181	

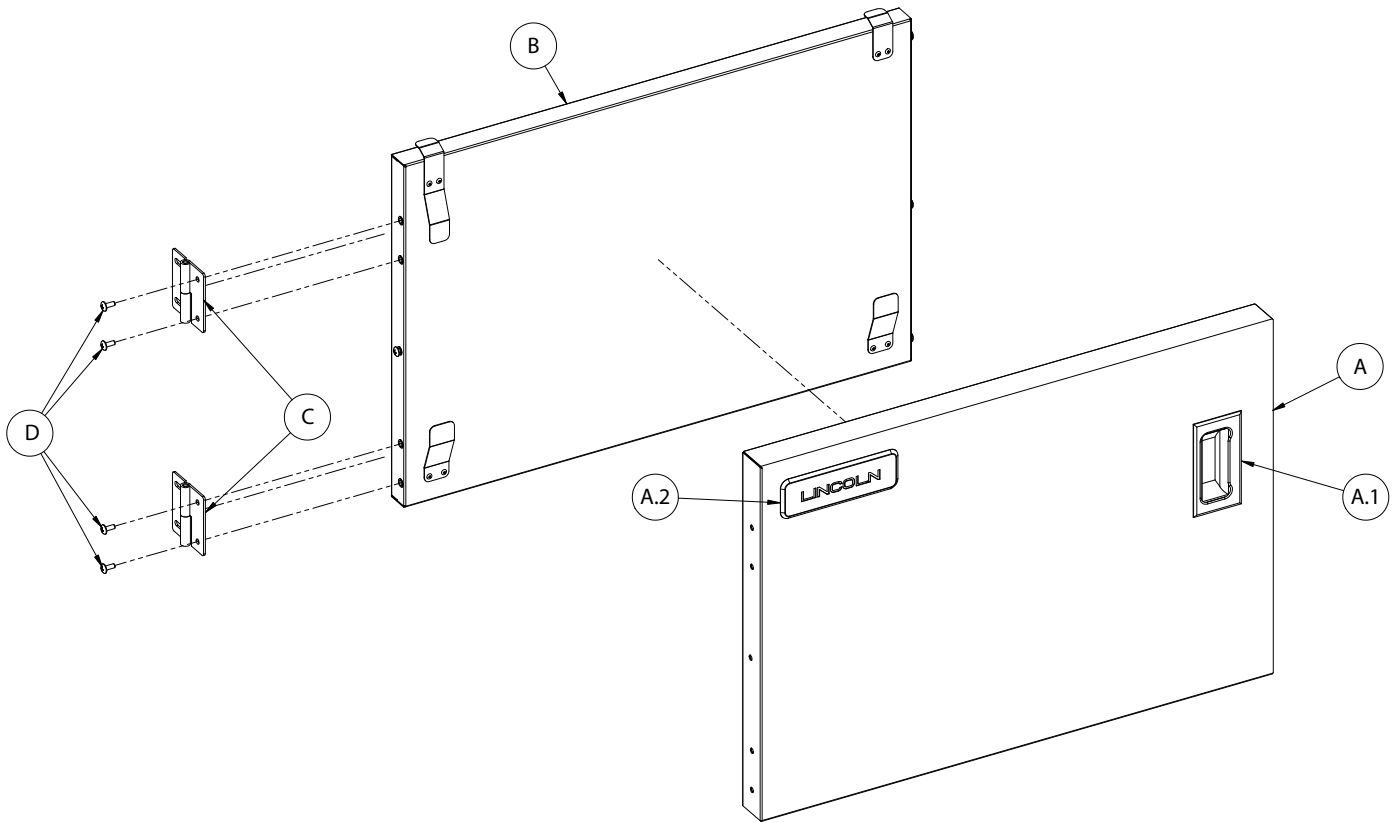
GAS TRAIN ASSEMBLY



GAS TRAIN ASSEMBLY

LETTER	DESCRIPTION	NATURAL GAS	PROPANE
A	VALVE, AUTO. L.P. /NAT H91 DA-7D	369398	
B	NIPPLE 1/2 NPT X 3 E-FLOW	G01477-13	
C	G96H JOHNSON CONTROL VALVE G96HGA-4D	369263	
D	NIPPLE B.I. 1/2 x 1-1/2	369974	
E	ELBOW 1/2 NPT 90 B.I. E-FLOW	369559	
F	NIPPLE 1/2 NPT X 3 IN	369970	
G	REDUCER NPT 3/4M – 1/2F EXPORT IMPINGER OVENS	369971	
H	ORIFICE MANIFOLD PGCD	369901	
I	TUBE BYPASS	4606242	
J	MAIN ORIFICE	369757	11010005745
K	CONNECTOR FEMALE 1/4 TUBE X 1/8 NPT	369577	
L	1/8 NPT PLUG E-FLOW OVENS	4071188	
M	BYPASS ORIFICE	4607570	369557
N	COMPRESSION FITTING 1/4 OD TUBING X 1/8 NPT	2601109	
O	PRESSURE TEST SPIGOT	02551-1	

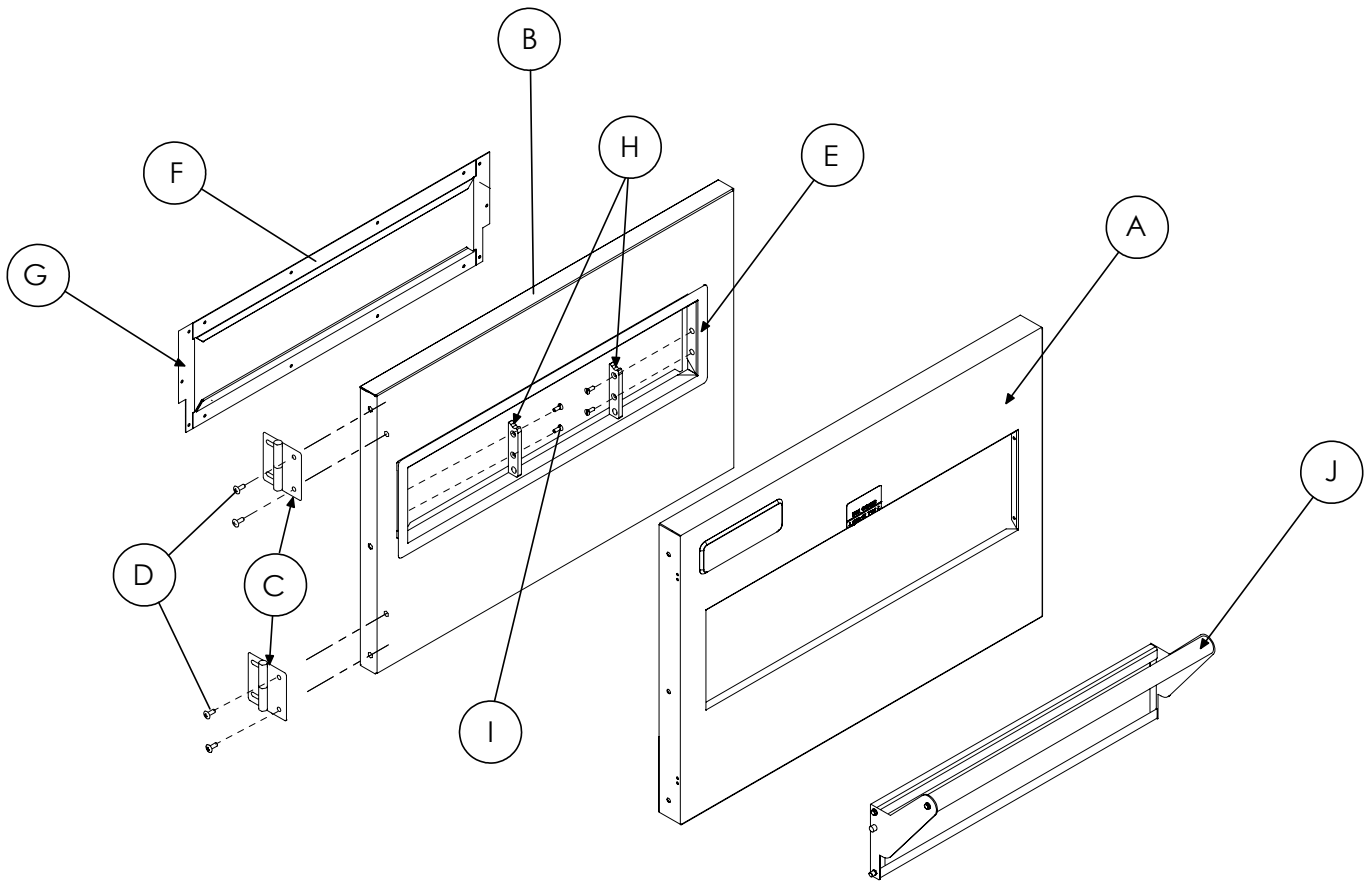
DOOR ASSEMBLY



DOOR ASSEMBLY

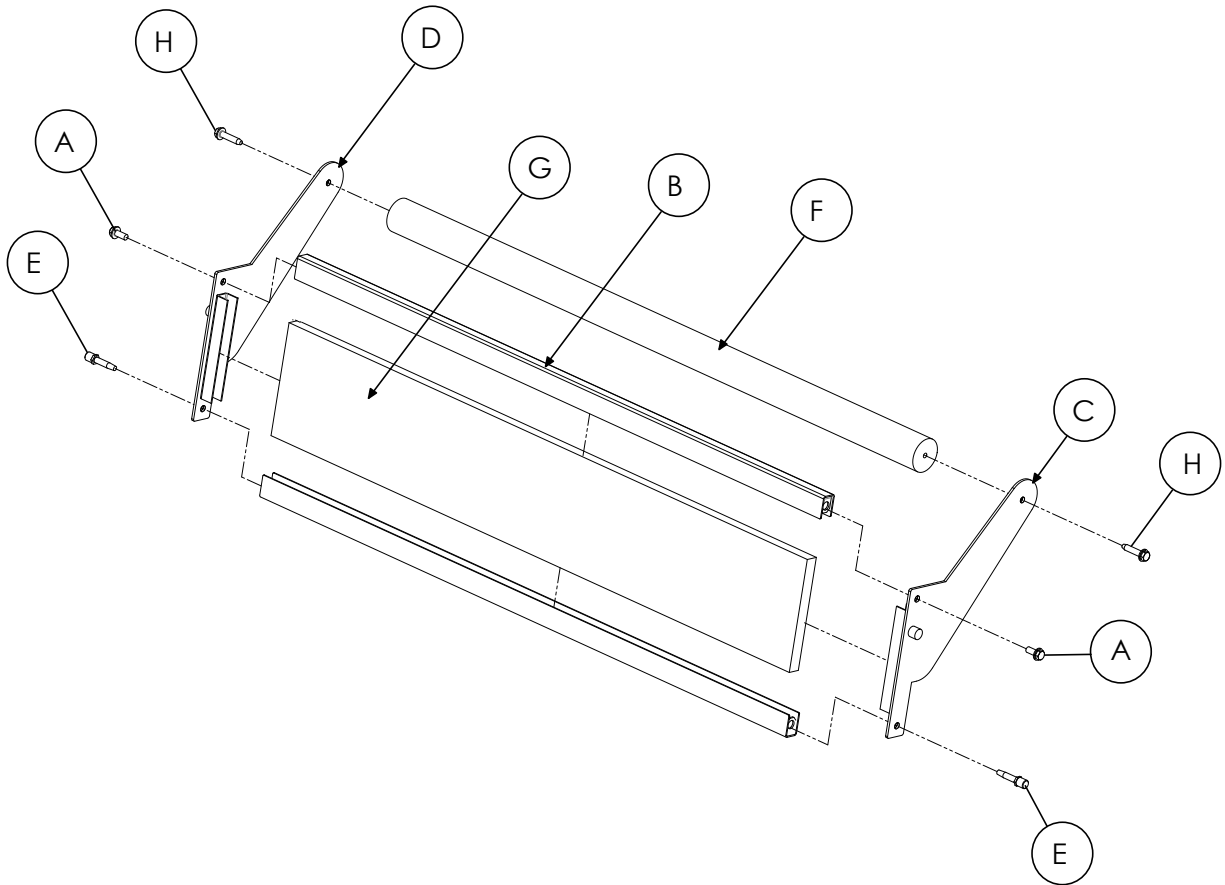
LETTER	DESCRIPTION	PART NUMBER
A	COVER, OUTER DOOR (INCLUDES A.1 AND A.2) FOR 2424E/G-000X COVER, OUTER DOOR (INCLUDES A.1 AND A.2) FOR (1624, 2024, 2424, 2824-XXXX)	CK4605377 CK4610200
A.1	HANDLE DOOR LIFTOFF SST WITH #10 NUTS	08108
A.2	NAMEPLATE IMPINGER	370016
B	DOOR SOLID FOR 2424E/G-000X DOOR SOLID FOR (1624, 2024, 2424, 2824-XXXX)	CK4605374 CK4610199
C	DOOR HINGE	4605861
D	#10-24 X 1/2IN PHILLIPS	8003128

DOOR ASSEMBLY WITH WINDOW



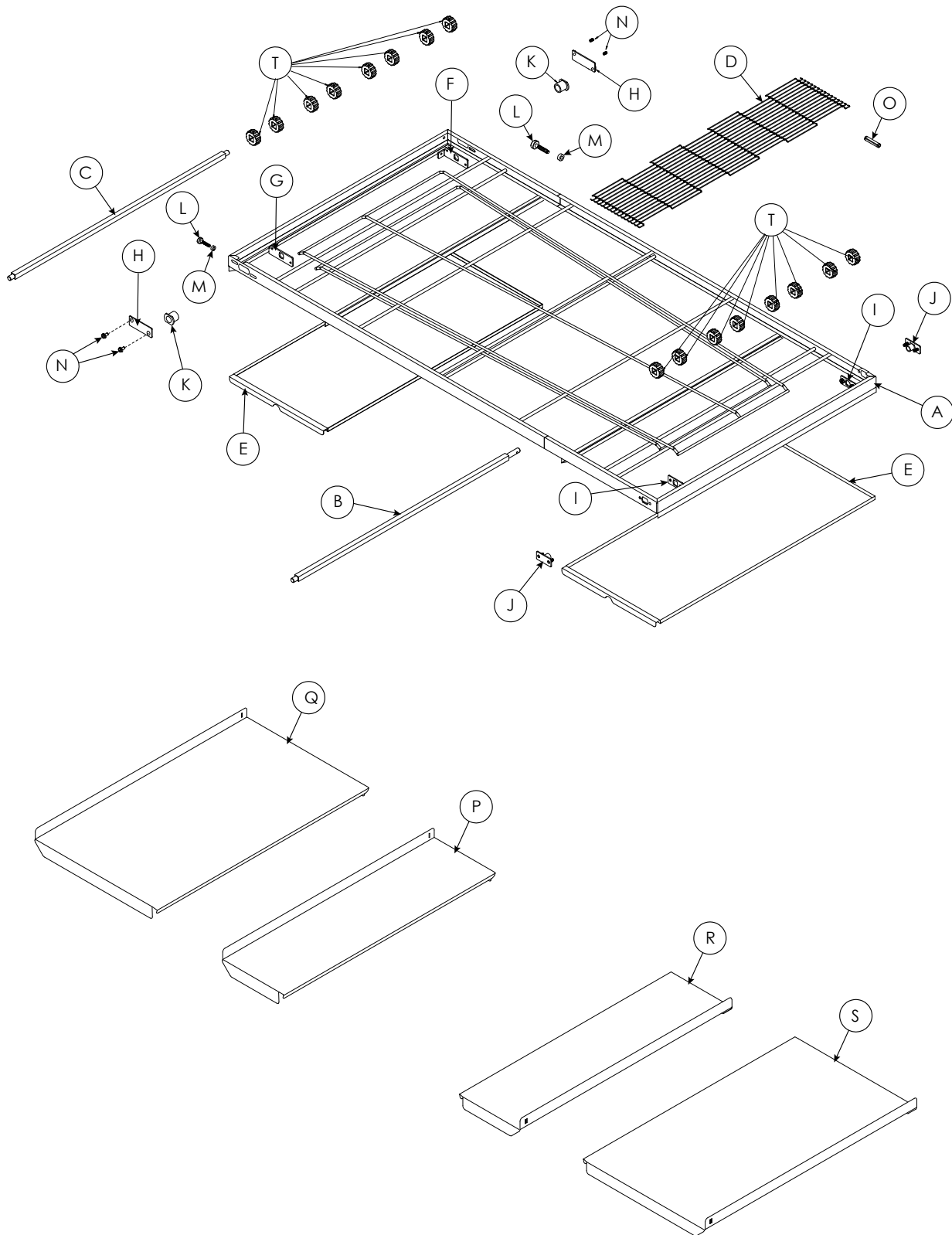
LETTER	DESCRIPTION	PART NUMBER
A	WINDOW DOOR COVER, APERION	4609460
B	INNER WINDOW DOOR, APERION	CK4609458
C	DOOR HINGE	4605861
D	#10-24 X 1/2 IN PHILLIPS	8003128
E	ACCESS FRAME ASSEMBLY, APERION	4609463
F	ACCESS WINDOW RETAINER, APERION	4609476
G	ACCESS WINDOW SEAL, APERION	4609535
H	WINDOW RETAINER, APERION	4609534
I	SCR FHW/PAT#8-32X3/8	369931
J	ACCESS WINDOW COMPLETE (SEE BREAKDOWN ON NEXT PAGE)	CK90000882

ACCESS WINDOW ASSEMBLY



LETTER	DESCRIPTION	PART NUMBER
A	SCREW #8-32 x 3/8 HEX HD SERR FLANGE	371143
B	ACCESS DOOR FRAME ASSEMBLY	371144
C	BRACKET ASSEMBLY LH ACCESS DOOR	371140
D	BRACKET ASSEMBLY RH ACCESS DOOR	371141
E	DOWEL THREAD, ACCESS DOOR	370725
F	DOWEL, ACCESS DOOR	371142
G	ACCESS DOOR GLASS	370723
H	SCREW #8-32 x 3/4-B; S/S	370722

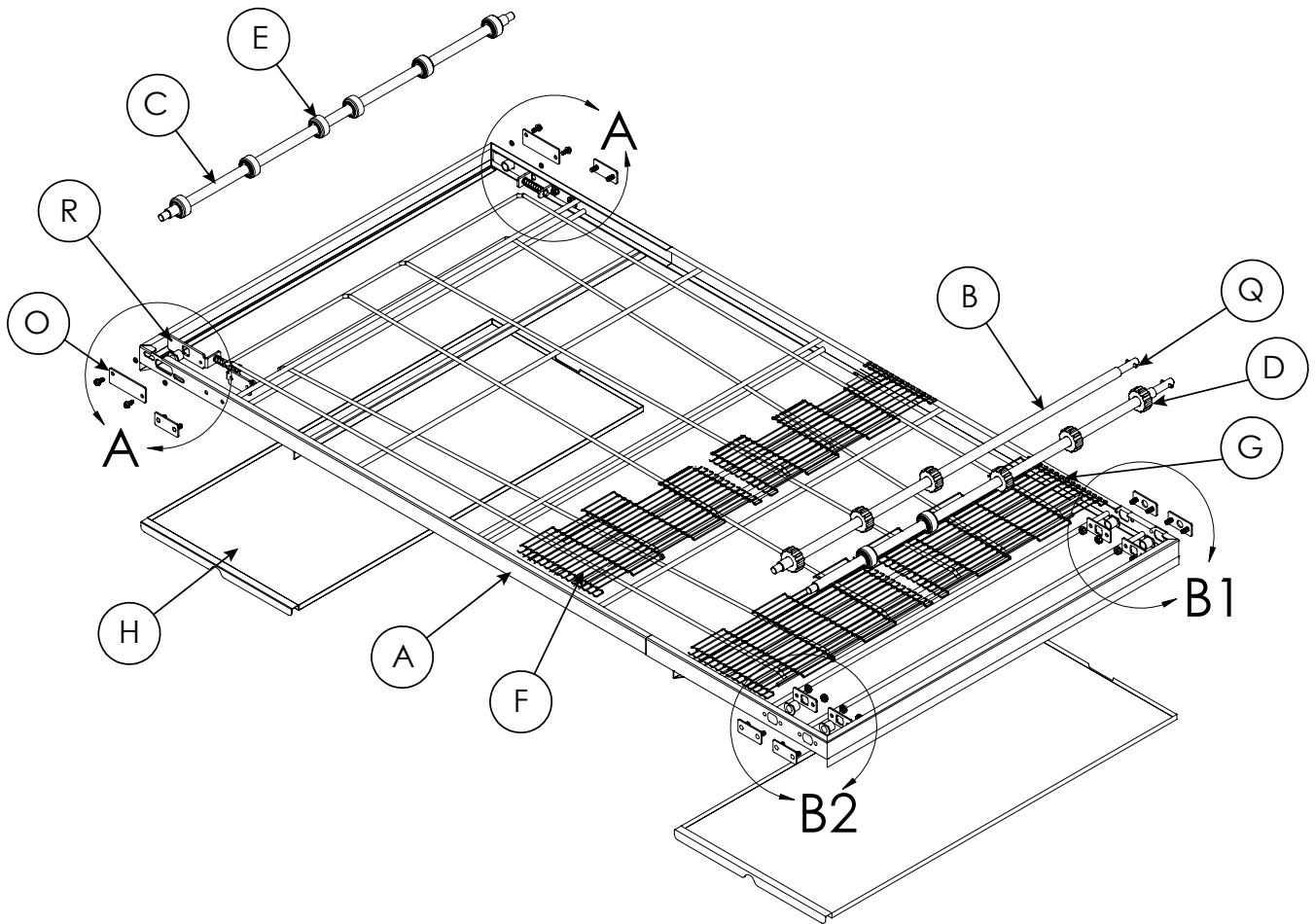
CONVEYOR ASSEMBLY - SOLID BELT



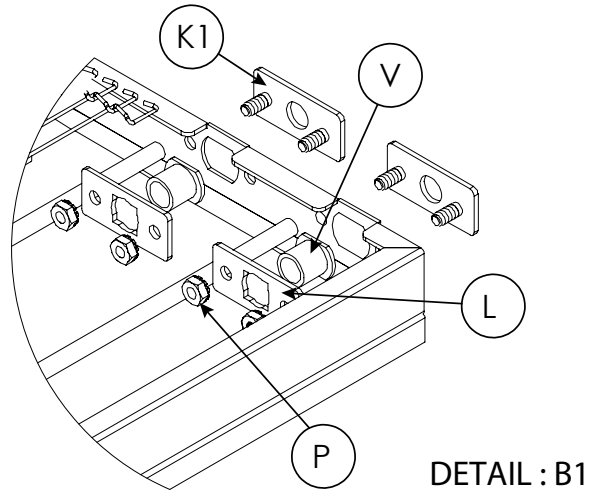
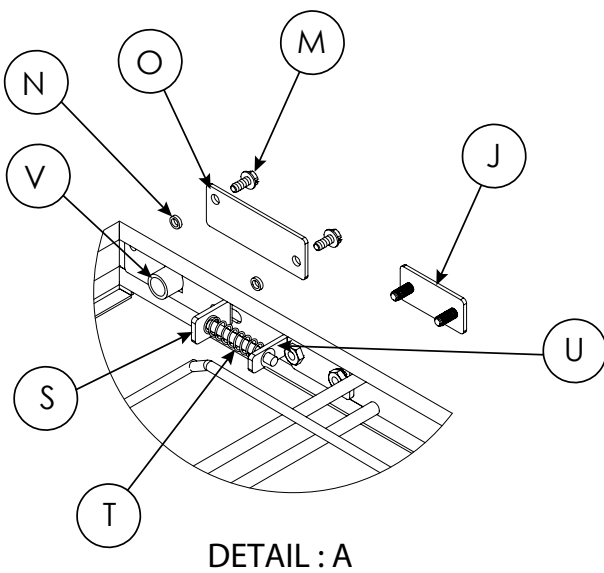
CONVEYOR ASSEMBLY - SOLID BELT

LETTER	DESCRIPTION	PART NUMBER			
		1624	2024	2424	2824
	COMPLETE CONVEYOR ASSEMBLY	4608516	4609245	4605743	4609277
A	FRAME ASSY	4608509	4609246	4605386	4609278
B	DRIVE SHAFT	4608512	4609260	4605747	4609311
C	IDLE SHAFT	4608510	4609258	4605748	4609295
D	BELT, CONVEYOR	4608514	4609261	4605744	4609288
E	CRUMB TRAY	4608515	4609255	4605384	4609298
F	BRACKET ADJ LH	4605920			
G	BRACKET ADJ RH	4605757			
H	BRACKET, ADJUST CLAMP	4605756			
I	BRACKET, BUSHING I.S.	4605753			
J	ASSEMBLY BRACKET BUSHING	4605749			
K	BUSHING, FLANGED	4605752			
L	10-32 X 1 KNURLED HEAD THUMB SCREW SS	4605754			
M	SPACER 3/8 D x 5/32 L	4605755			
N	10-32 X 3/8 FLANGE SCREW	4605772			
O	SLOTTED SPRING PIN	4605773			
P	TRAY ENTRY 6"	L1606	L2006	L2406	L2806
Q	TRAY ENTRY 12"	L1612	L2012	L2412	L2812
R	TRAY EXIT 6"	L1607	L2007	L2407	L2807
S	TRAY EXIT 12"	L1613	L2013	L2413	L2813
T	SPROCKET 12 TOOTH	369515			
NOT SHOWN	SPLICE CLIP, .050 DIA WIRE	CK4608265			

CONVEYOR ASSEMBLY - SPLIT BELT



FOR B2, USE
ITEM K2 INSTEAD OF K1



CONVEYOR ASSEMBLY - SPLIT BELT

LETTER	DESCRIPTION	PART NUMBER		
		1624	2024	2424
	COMPLETE CONVEYOR ASSEMBLY	4610740	4610720	4610749
A	FRAME ASSY	4610404	4610709	4610563
B	DRIVE SHAFT, FRONT / REAR	4610712		4610756
C	IDLE SHAFT	4610713		4610757
D	SPROCKET 12 TOOTH 1/2 BORE	4610714		
E	IDLE ROUND SPROCKET	4610715		
F	BELT, CONVEYOR FRONT	4610409	4610711	4610409
G	BELT, CONVEYOR REAR	4610409	4608514	
H	CRUMB TRAY	4605384		4609298
J	STUD STRAY	4605751		
K1	STUD PLATE W/HOLES	4605749		
K2	STUD PLATE W/O HOLES	4605751		
L	PLATE BUSHING DRIVE SHAFT	4605753		
M	#8-32 x 3/8 HEX HD SCR W/SLOT DRIVE	4610729		
N	0.166 x 1/4 x 1/16 SS SPACER	4610730		
O	COVER PLATE IDLER SHAFT	4605756		
P	#10-32 HEX KEPS NUT	F715		
Q	SLOTTED SPRING PIN	4605773		
R	BRACKET BELT ADJUSTER RH	4610482		
S	BRACKET BELT ADJUSTER LH	4610484		
T	SPRING BELT ADJUSTER	4610486		
U	BRACKET SPRING STOP	4610487		
V	FLANGED SLEEVE BEARING MODIFIED	4605752		
NOT SHOWN	IDLE SPROCKET BUSHING	4610716		
NOT SHOWN	TRAY LOADING SHORT (SEE SOLID BELT)	L2406		L2806
NOT SHOWN	TRAY LOADING LONG (SEE SOLID BELT)	L2412		L2812
NOT SHOWN	TRAY LOADING SHORT (SEE SOLID BELT)	L2407		L2807
NOT SHOWN	TRAY LOADING LONG (SEE SOLID BELT)	L2413		L2813

ACCESSORY KITS

KIT	CONTENTS	PART NUMBER			
		1624	2024	2424	2824
SINGLE, W/4" LEGS	4" LET KIT (DCTI), TOP COVER	L4610140	L4610165	L4609958	L4610153
SINGLE, TALL	TALL LEG KIT, RESTRAINING CABLE, TOP COVER	L4610137	L4610162	L4608733	L4610150
DOUBLE STACK, W/4" LEGS	4" LET KIT (DCTI), RESTRAINING CABLE TOP COVER, STACKING COVER	L4610141	L4610166	L4609959	L4610154
DOUBLE STACK, TALL	TALL LET KIT, RESTRAINING CABLE TOP COVER, STACKING COVER (W/CASTERS)	L4610138	L4610163	L4608734	L4610151
TRIPLE STACK	CASTER, RESTRAINING CABLE TOP COVER, STACKING COVER X 2	L4610139	L4610164	L4608735	L4610152
TOP COVER, STACKING KIT	TOP COVER ASSEMBLY FOR A UNIT INSTALLED BELOW ANOTHER UNIT	L4608576	L4609331	L4608493	L4610145
NATURAL TO PROPANE	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL - SPRING KIT	4610264			
PROPANE TO NATURAL	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL - SPRING KIT	4610265			

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