

Lincoln®

Consistency You Can Count On

Lincoln Aperion 24 Impinger® Conveyor Oven

Parts Manual For 60 Hz

Models:

1624, 2024, 2424, 2824

Gas and Electric



Original Document

Document #: LIN_EOGO_P_24APERION_DOM_4607940 Rev 1 – 11/25

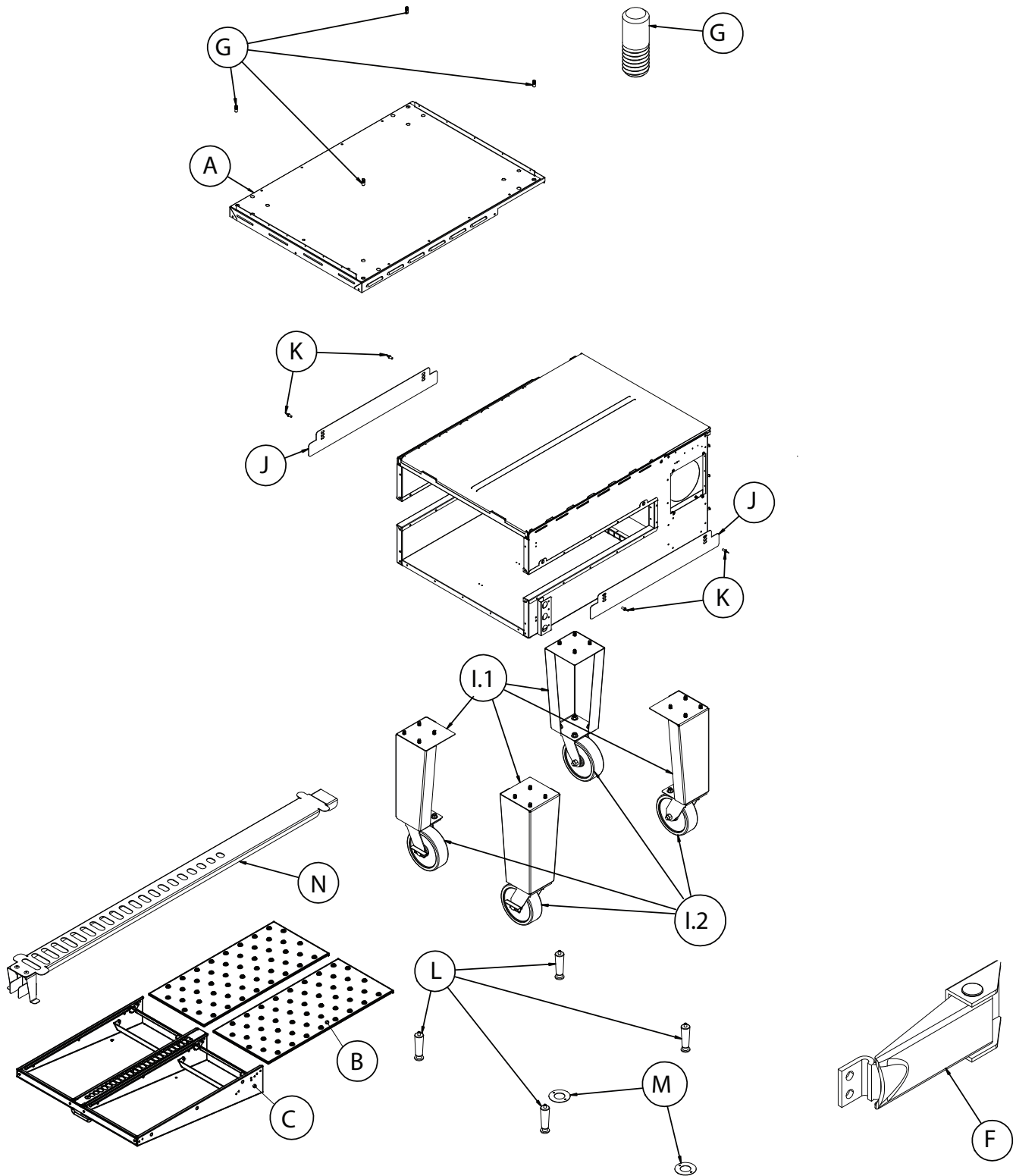


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Contents

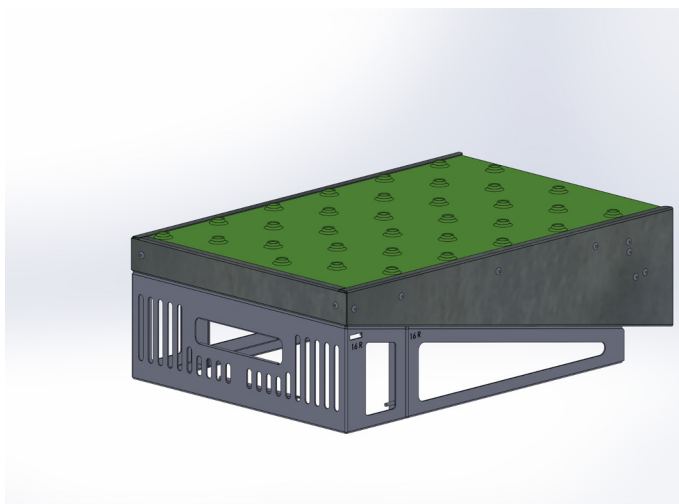
MAIN CAVITY	4
ELEMENT & BLOWER HOUSING ASSEMBLY	6
RIGHT CONTROL BOX - ELECTRIC & GAS.....	8
SERVICE PANEL - ELECTRIC.....	10
SERVICE PANEL - GAS	12
COMPONENT PANEL - ELECTRIC & GAS.....	14
LEFT CONTROL BOX - ELECTRIC	16
LEFT CONTROL BOX - GAS.....	17
BURNER ASSEMBLY	18
GAS TRAIN ASSEMBLY.....	20
DOOR ASSEMBLY - SOLID	22
DOOR ASSEMBLY WITH WINDOW	24
ACCESS WINDOW GLASS.....	25
CONVEYOR ASSEMBLY - SOLID BELT	26
CONVEYOR ASSEMBLY - SPLIT BELT	28
ACCESSORY KITS.....	30

MAIN CAVITY

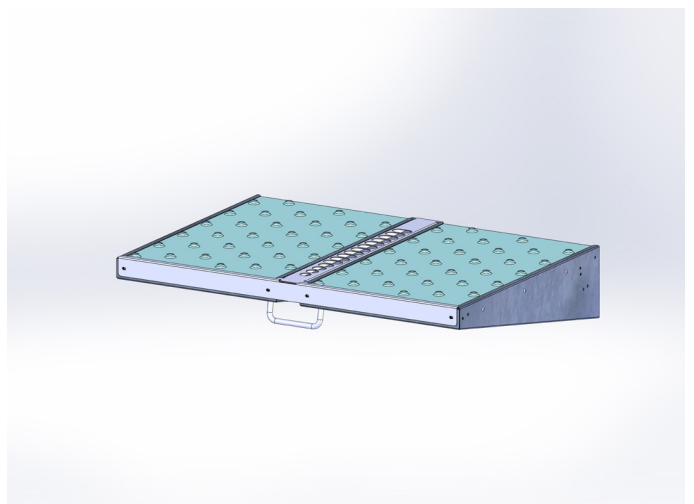


MAIN CAVITY

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	TOP COVER	4608576	4609331	4608493	4610145
B	FINGER JET PLATE	4608541	4609226	4604975	4609189
C	FINGER HOUSING ASSEMBLY (for models using the finger type A)	CK4608543	CK4609223	CK4605326	CK4609191
	FINGER HOUSING ASSEMBLY (for models using the finger type B)	CK4612806	CK4612807	CK4612808	CK4612809
F	LATCH AND CATCH	369501			
G	PARTIALLY THREADED ROD - IMPERIAL (for models using the finger type A)	4606203			
	PARTIALLY THREADED ROD - METRIC (for models using the finger type B)	4612651			
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 - IMPERIAL (for models using the finger type A)	369211			
	THUMB SCREW - METRIC (for models using the finger type B)	4612805			
L	LEG, 4 IN - IMPERIAL	369461			
M	MOUNTING RING KIT	369451			
N	CENTER AIR RETURN BRACKET ASSEMBLY (for models using the finger type A)	CK4608548	CK4610238	CK4606343	CK4609442
NOT SHOWN	RESTRAINING KIT (for models using the finger type A)	4601483	4601483	4601483	4601483
	RESTRAINING KIT (for models using the finger type B)	4612644	4612644	4612644	4612644

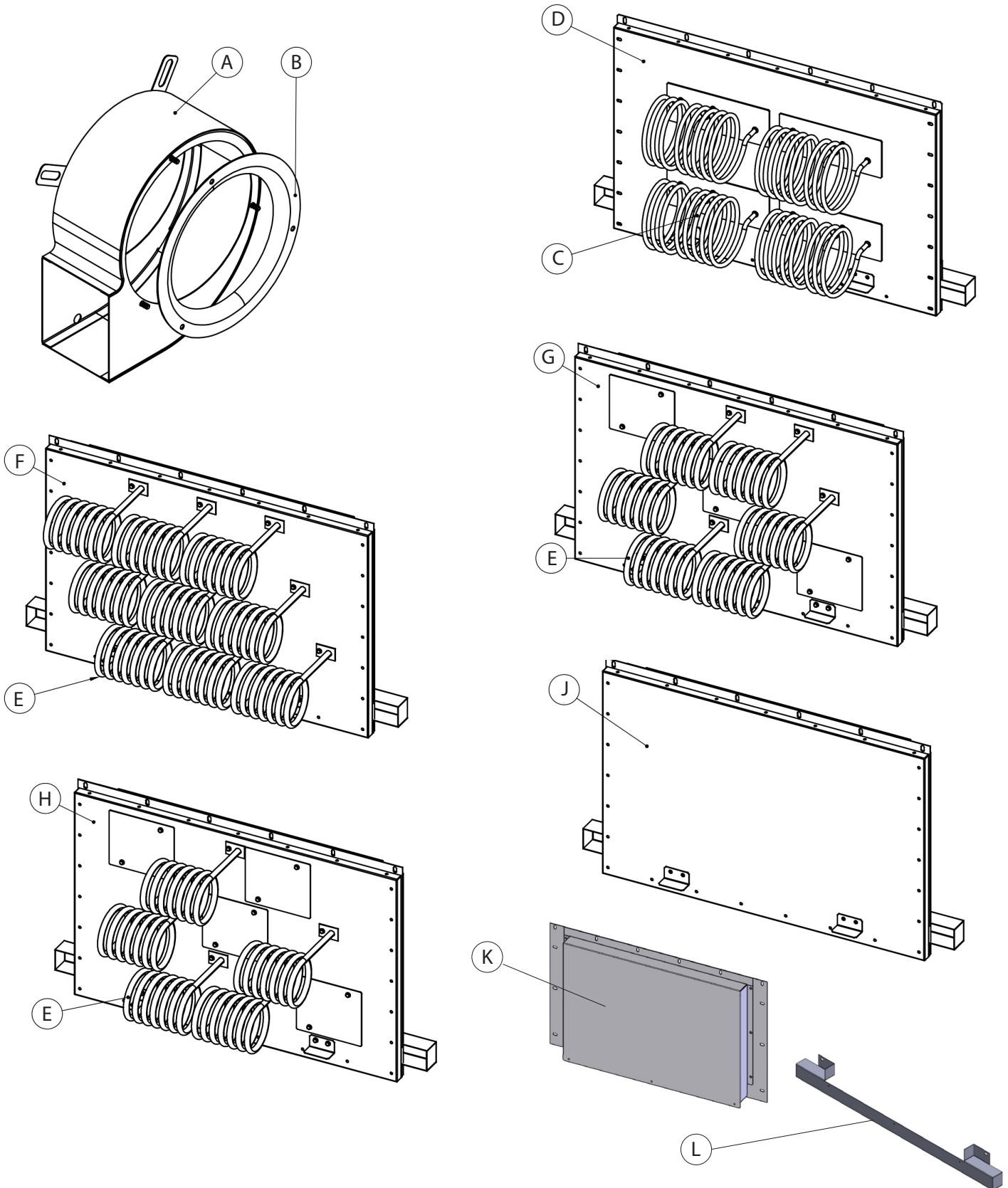


FINGER TYPE A



FINGER TYPE B

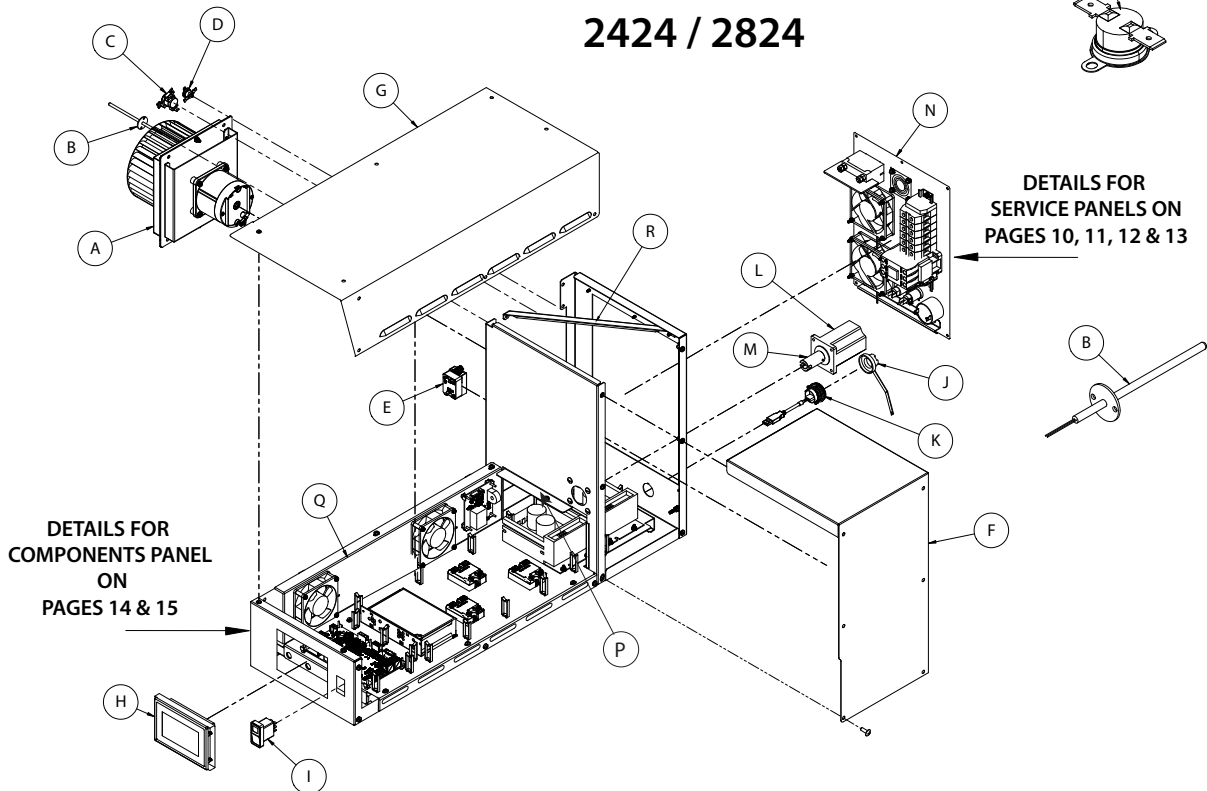
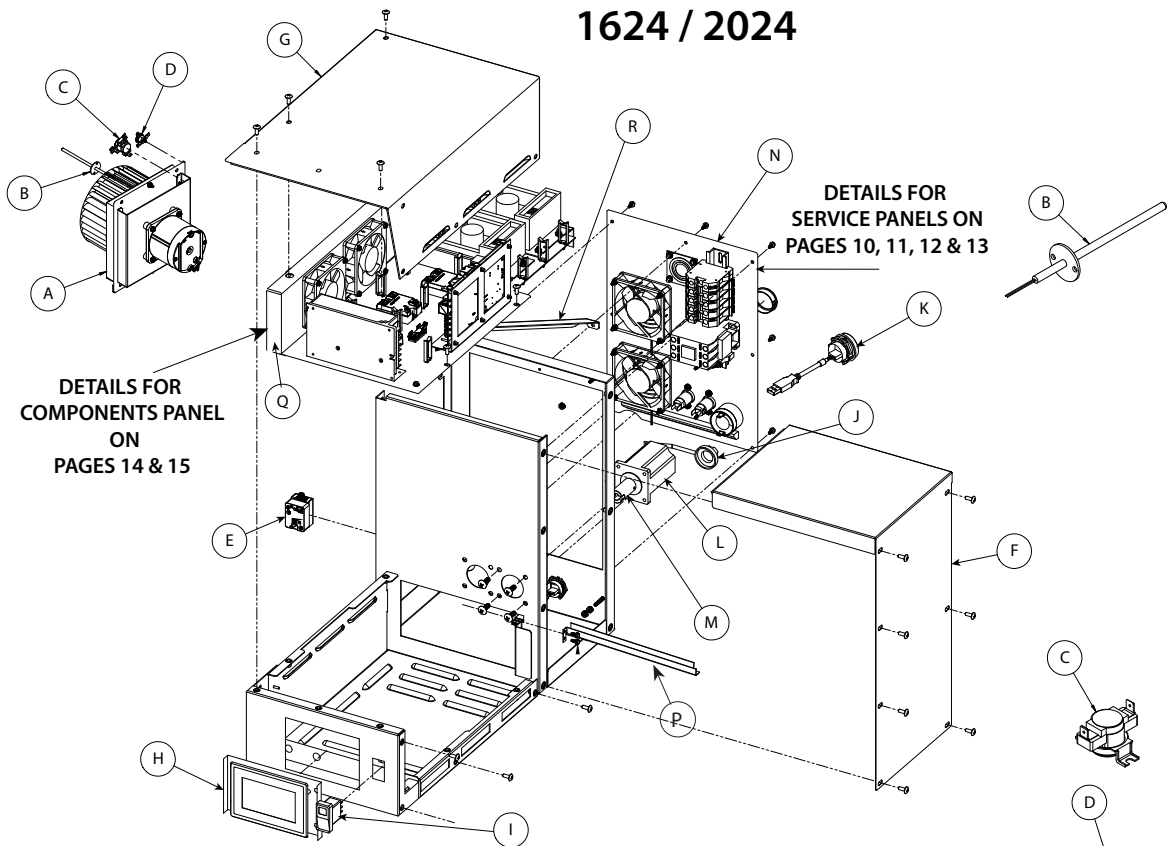
ELEMENT BLOWER & HOUSING ASSEMBLY



ELEMENT BLOWER & HOUSING ASSEMBLY

LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
A	BLOWER HOUSING	4605392			
B	BLOWER INLET CONE	4605621			
C	HEATING ELEMENT, 208V, 6000W FOR 2424E-000X	4605710			
D	REAR WALL ASSEMBLY, ELECTRIC MODELS FOR 2424E-000X (INCLUDES HEATING ELEMENTS)	CK4607637			
E	HEATING ELEMENT, 240V, 2000W for 1624/2024/2424/2824-XXX	4609707			
F	REAR WALL ASSEMBLY 9 HEATING ELEMENTS, ELECTRIC MODELS for 1624/2024/2424/2824-XXX (INCLUDES HEATING ELEMENTS)	CK4610278			
G	REAR WALL ASSEMBLY 6 HEATING ELEMENTS, ELECTRIC MODELS for 1624/2024/2424/2824-XXX (INCLUDES HEATING ELEMENTS)	CK4610279			
H	REAR WALL ASSEMBLY 5 HEATING ELEMENTS, ELECTRIC MODEL for 1624/2024/2424/2824-XXX (INCLUDES HEATING ELEMENTS)	CK4610282			
J	REAR WALL ASSEMBLY, GAS MODELS	CK4607546			
K	REAR WALL ASSEMBLY COVER APERION	CK4613529			
L	WIRE CHANNEL	4611743			

RIGHT CONTROL BOX - ELECTRIC & GAS

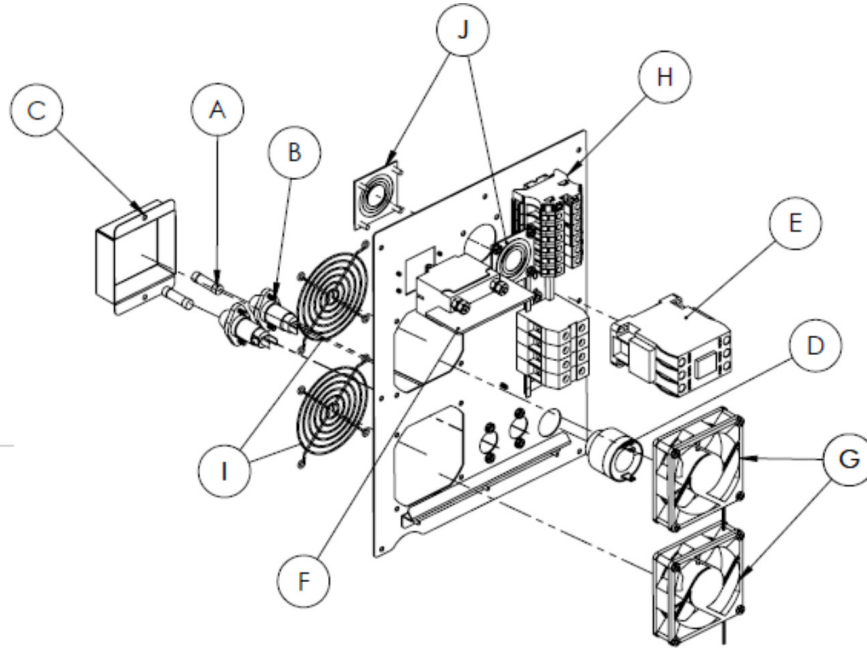


RIGHT CONTROL BOX - ELECTRIC & GAS

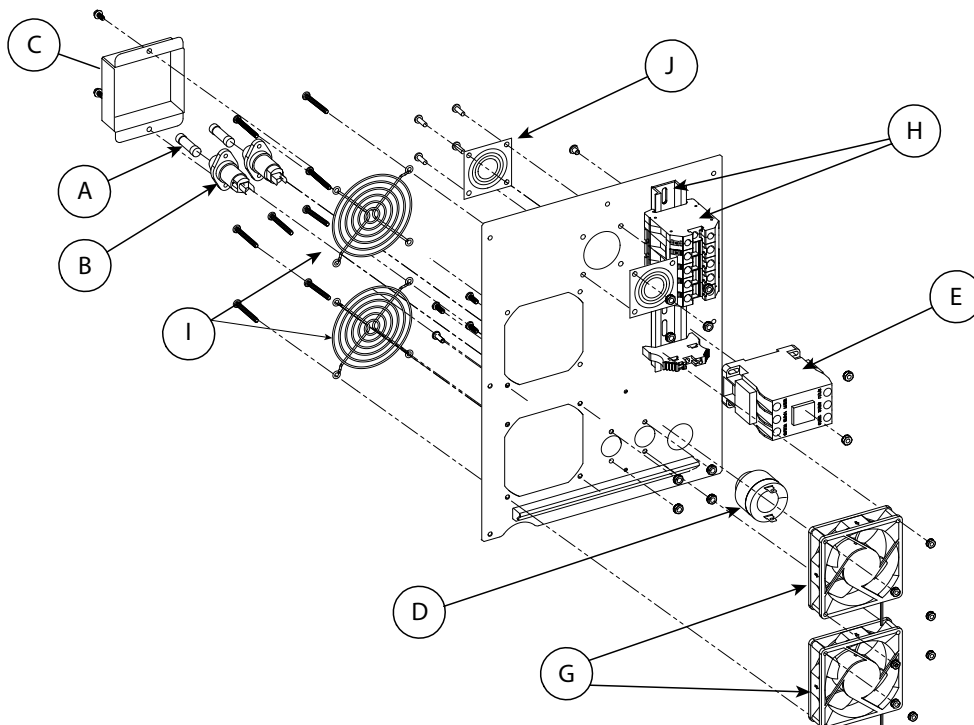
LETTER	DESCRIPTION	MODELS			
		1624	2024	2424	2824
		PART NUMBERS			
A	FAN MOTOR ASSEMBLY	CK4605340			
B	THERMOCOUPLE	4603578			
C	THERMOSTAT COOLING FAN	369507			
D	THERMAL DISCONNECT	4605622			
E	HIGH LIMIT THERMOSTAT CAPILLARY	4607695			
F	COVER, SIDE, CORNER, CTRL BOX	4605019			
G	COVER, L-SHAPE, CTRL ELEC BOX	4608562	4609293	4608449	4609220
H	COMMON 4.3" UI, ASSEMBLY (INCLUDES MOUNTING BRACKET AND BEZEL SEAL)	CK4609353 (non-ventless models) or CK4611280 (ventless models)			
I	MAIN POWER SWITCH	4600614			
J	USB SEALING CAP	4532043			
K	USB PANEL MOUNT	4532040			
L	CONVEYOR MOTOR (INCLUDES COUPLING)	CK4605922			
M	COUPLING SLEEVE (INCLUDES SET SCREW)	CK4605921			
M1	SET SCREW (FOR COUPLING)	369978			
N	SERVICE PANEL ASSEMBLY	SEE SERVICE PANEL PAGE 10-13			
P	DRIP TRAY APERION	4608739			
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	HI-LIMIT MOUNTING BRACKET	4610121			
NOT SHOWN	USB EXTENSION	4610286		4607876	
DOM ELECTRIC WIRE HARNESS					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610220		2424E-000X: 4605293 ALL OTHERS: 4610257	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS), 3 PHASE MODELS	FOR 2424E-000X: 4605294 ALL OTHERS: 4610258			
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS), 1 PHASE MODELS	4610284			
NOT SHOWN	REAR WIRE HARNESS	4605295			
NOT SHOWN	HEATING ELEMENTS WIRING HARNESS	FOR 2424E-000X: N/A XX24-SXX (3 PHASE): 4610287 XX24-LXX (3 PHASE): 4610288 XX24-LXX (1 PHASE): 4610289			
DOM GAS WIRE HARNESS					
NOT SHOWN	CONTROL BOX WIRING HARNESS	4610492		4610491	
NOT SHOWN	RIGHT TOWER WIRING HARNESS (BACK HARNESS)	4608357			
NOT SHOWN	REAR WIRING HARNESS	4605295			
NOT SHOWN	LEFT TOWER WIRING HARNESS	4608358			

SERVICE PANEL - ELECTRIC

SERVICE PANEL - ELECTRIC FOR 2424E-0006



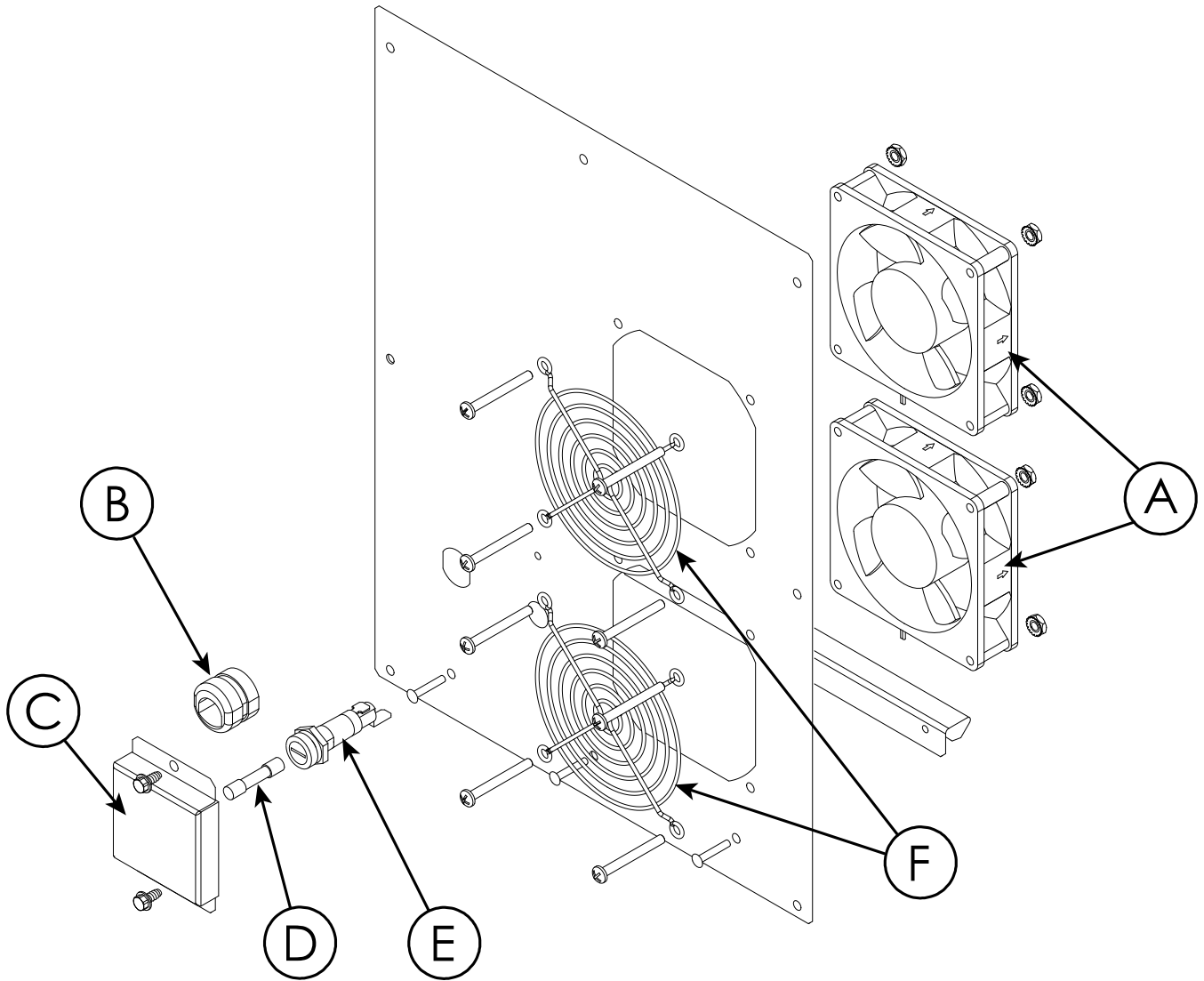
SERVICE PANEL - ELECTRIC FOR (1624, 2024, 2424, 2824-XXX)



SERVICE PANEL - ELECTRIC

LETTER	DESCRIPTION	PART NUMBER
A	FUSE, 10 AMP CARTRIDGE	369166
B	FUSE HOLDER 15A 300V	369129
C	COVER FUSE	10001365
D	ALARM, 240V	4607019
E	CONTACTOR, 40 A	370739
F	CIRCUIT BREAKER 2 POLE 30A (ONLY FOR 2424E-006)	2688801
G	COOLING FAN, 24DC	4608567
H	TERMINAL BLOCK 10 (ONLY FOR 2424E-006)	4607855
	TERMINAL BLOCK 5, FOR (16/20/24/28)24-XXX	4609840
I	FAN GUARD	4604757
J	KNOCK OUT PLATE	G1053-3-8

SERVICE PANEL - GAS

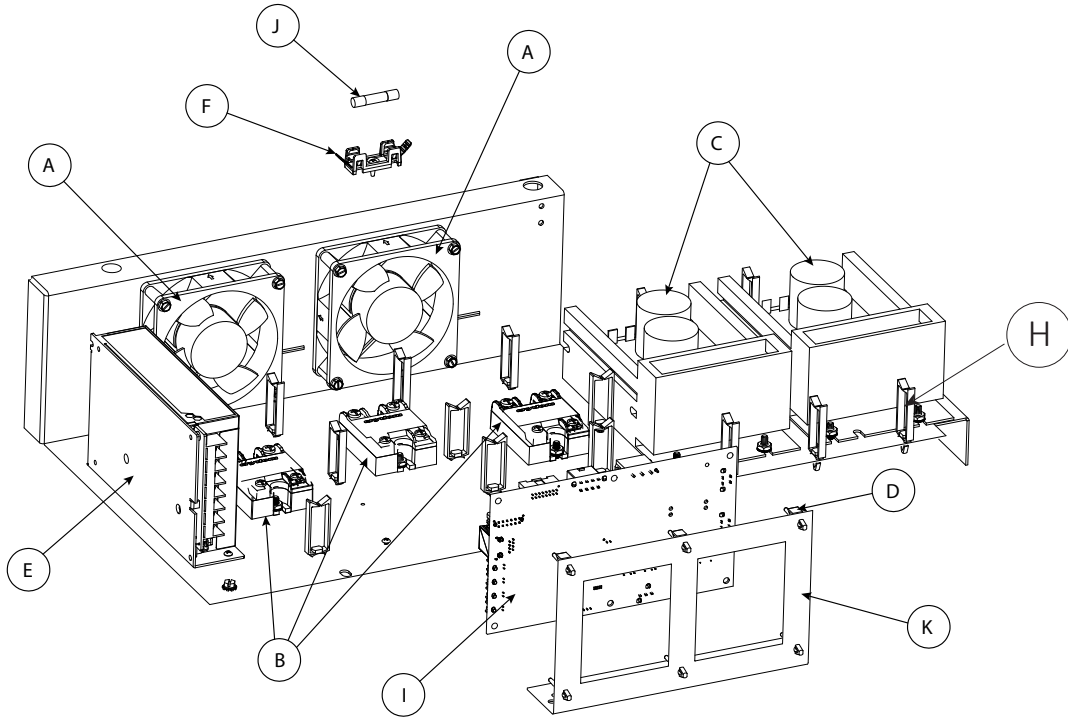


SERVICE PANEL - GAS

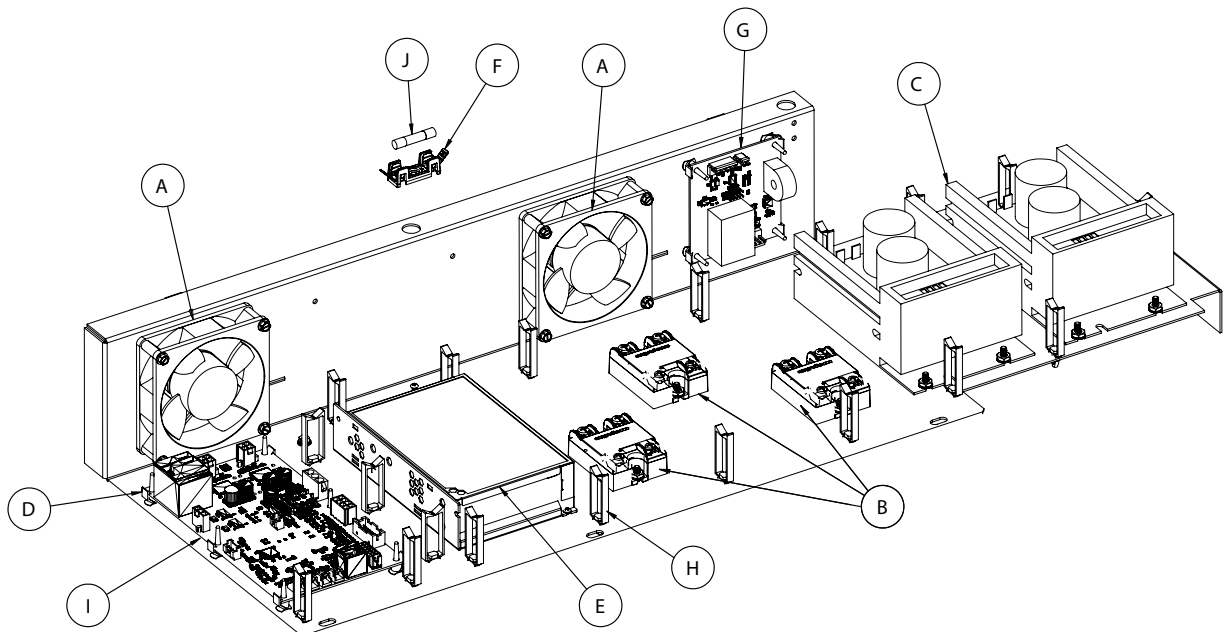
LETTER	DESCRIPTION	PART NUMBER
A	COOLING FAN, 24VDC	4608567
B	STRAIN RELIEF, SR 7N-2	4070505
C	FUSE COVER APERION	4609334
D	FUSE TIME DELAY 15A	4605328
E	FUSE HOLDER, HTB-361	370342
F	FAN GUARD	4604757
NOT SHOWN	POWER CORD W/PLUG 2"	369537

COMPONENT PANEL - ELECTRIC & GAS

1624 / 2024



2424 / 2824

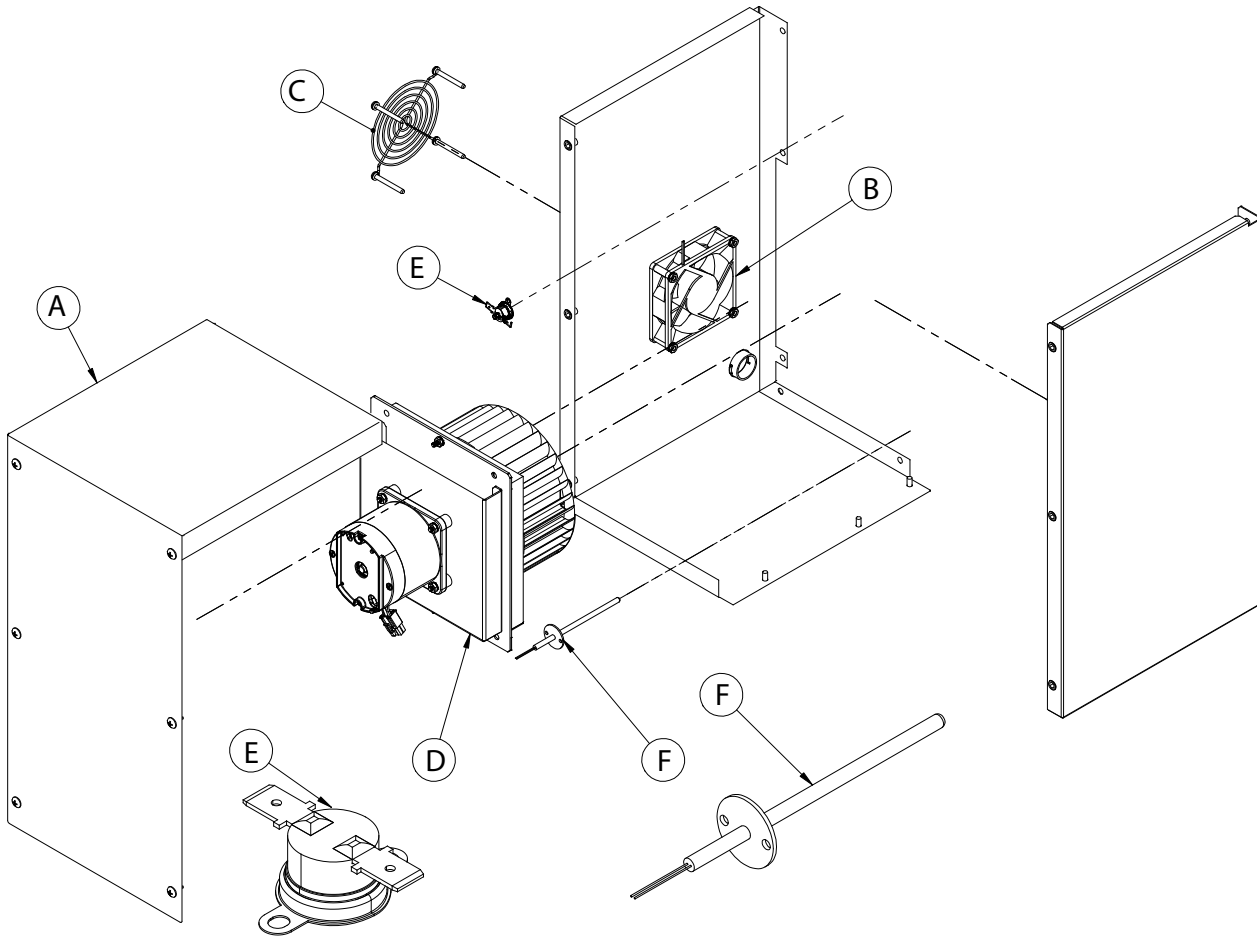


COMPONENT PANEL - ELECTRIC & GAS

LETTER	DESCRIPTION	PART NUMBER
A	COOLING FAN, 24VDC	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
H	WIRE SADDLE	4600840
I	I/O BOARD LINCOLN	CK4609352
J	FUSE, 4A 600V	4606033
K	I/O SUPPORT BRACKET	4607165
NOT SHOWN	BLOWER MOTOR CHOKE	4607696
NOT SHOWN	TERMINATION RESISTOR 120 OHM	4608140

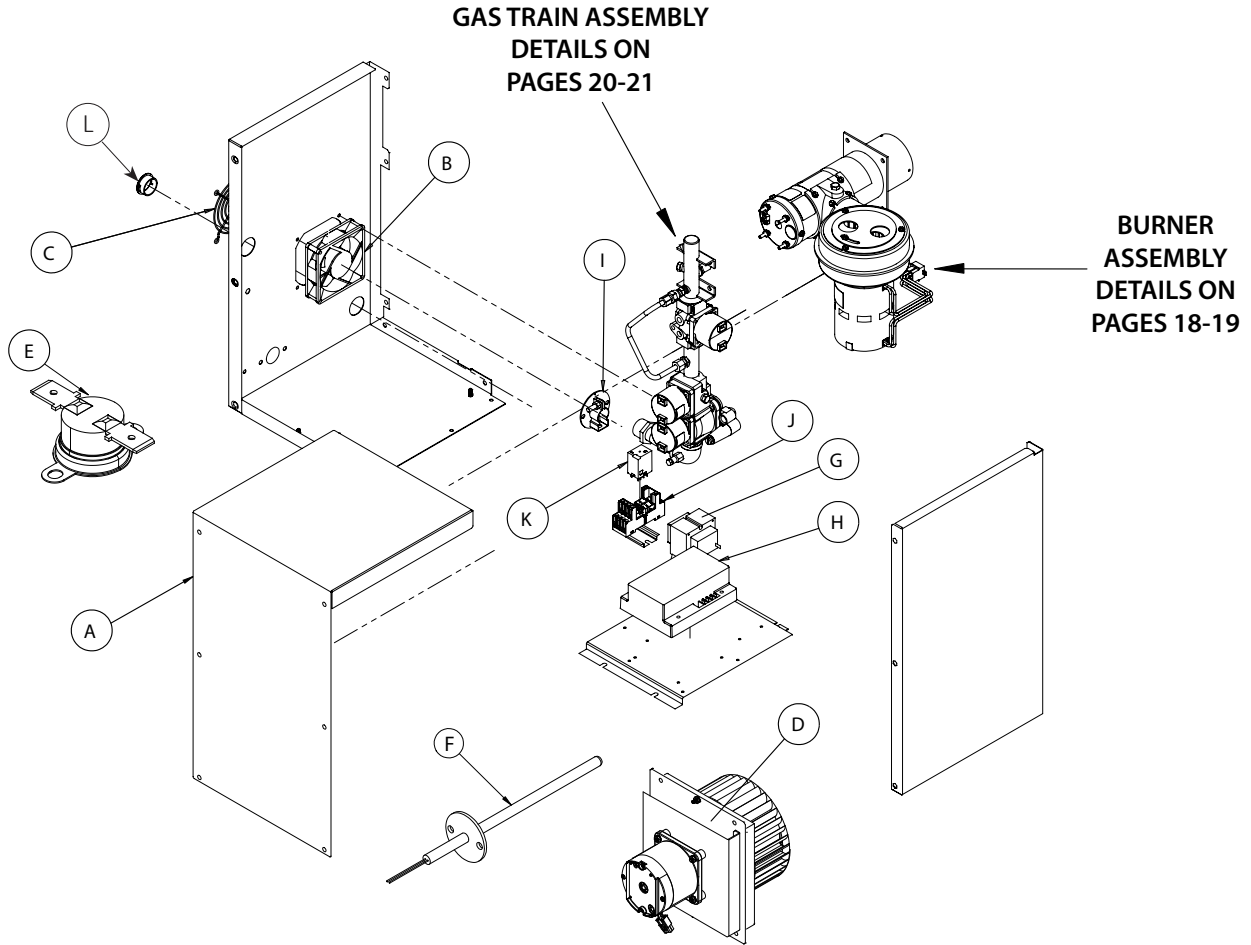
LETTER	PART NUMBER	DESCRIPTION	QTY NEEDED PER MODEL			
			1624	2024	2424	2824
NOT SHOWN	4607498	ETHERNET PATCH CORD (FOR ALL MODELS)	1	1	1	1
NOT SHOWN	4610285	ETHERNET PATCH CORD, ANGLED	1	1	1	1

LEFT CONTROL BOX - ELECTRIC



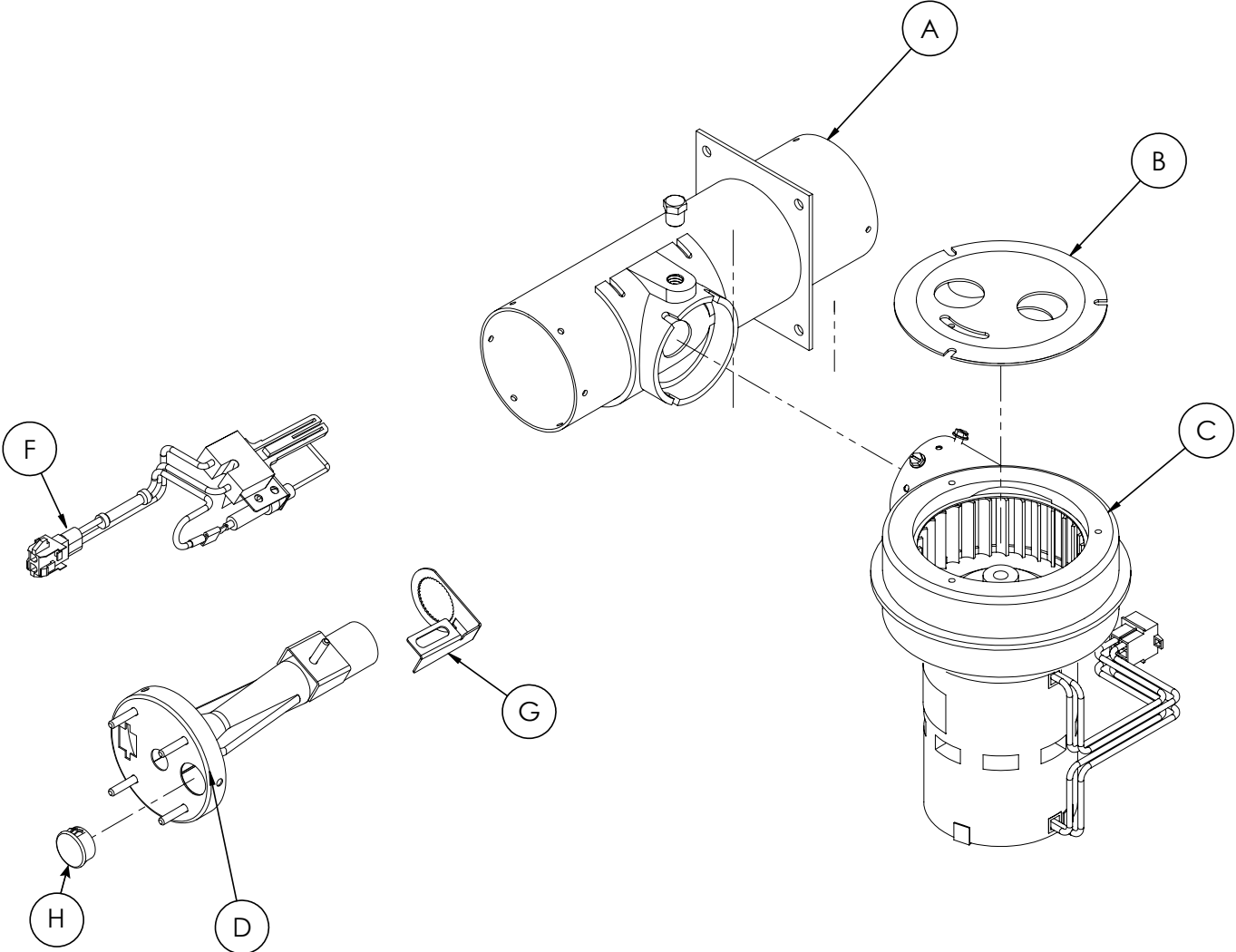
LETTER	DESCRIPTION	PART NUMBER
A	COVER SIDE CORNER, CONTROL BOX (FOR 2424E-0001/0002/0003/0004/0005)	4606217
	COVER SIDE CORNER, CONTROL BOX (FOR 1624/2024/2424/2824-XXX)	4611295
B	COOLING FAN, 24VDC, 2424	4608567
C	GUARD, FAN	4604757
D	FAN MOTOR ASSEMBLY	CK4605340
E	THERMAL DISCONNECT	4605622
F	THERMOCOUPLE	4603578

LEFT CONTROL BOX - GAS



LETTER	DESCRIPTION	PART NUMBER
A	COVER, SIDE, CORNER CONTROL BOX	4611295
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
L	PLUG BUTTON 1.125	2401009
NOT SHOWN	GAS SHUT-OFF VALVE	369081

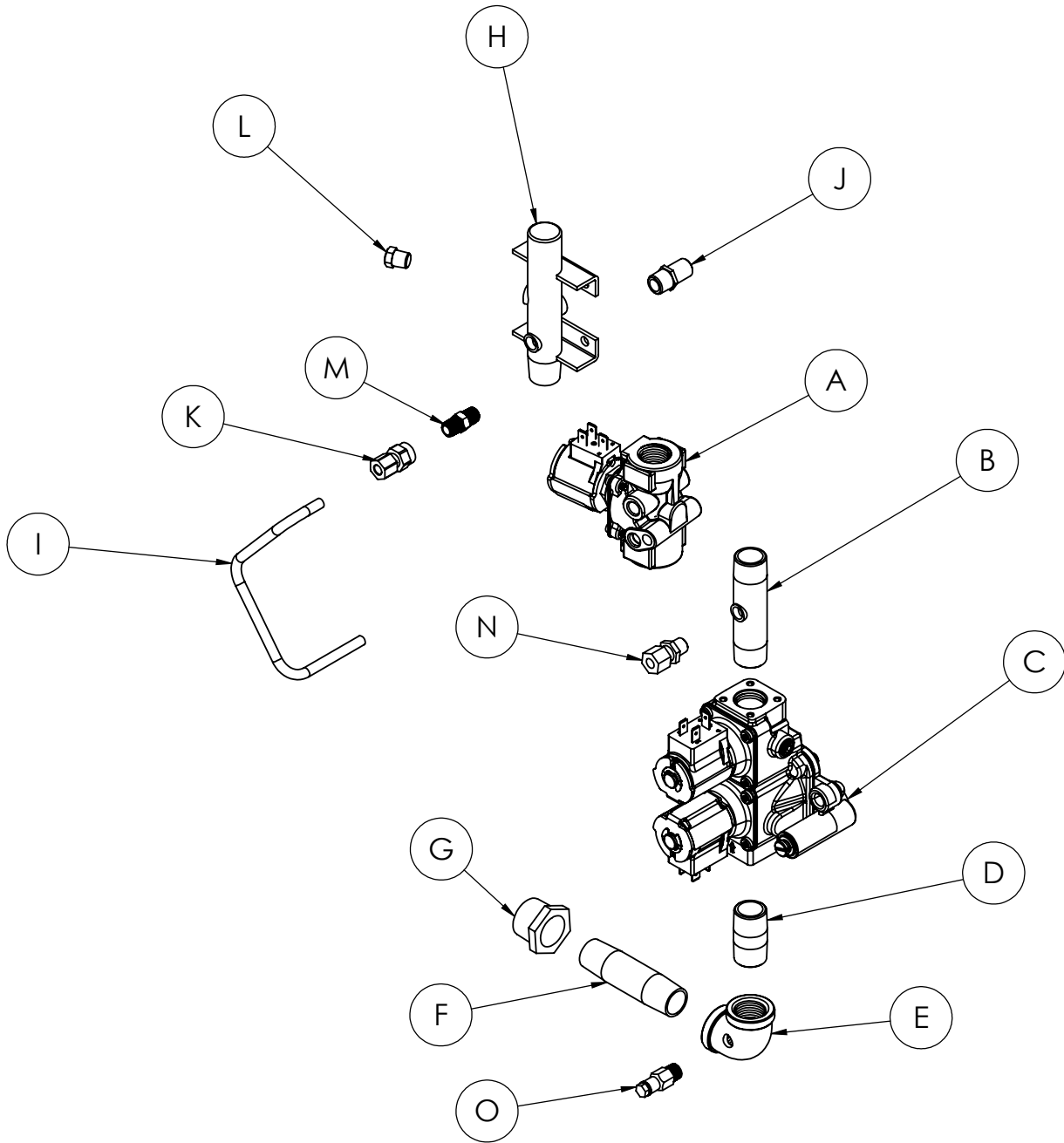
BURNER ASSEMBLY



BURNER ASSEMBLY

LETTER	DESCRIPTION	NATURAL GAS	PROPANE
A	BURNER TUBE ASSEMBLY	4608646	
B	AIR SHUTTER, BURNER	369401	
C	BLOWER MOTOR ASSY DOMESTIC	4071242	
D	VENTURI HOT	369658	369938
F	HOT SURFACE IGNITOR	369552	
G	VENTURI RING BRACKET	4608261	
H	SNAP BUSH HEYCO WP-750	390131	

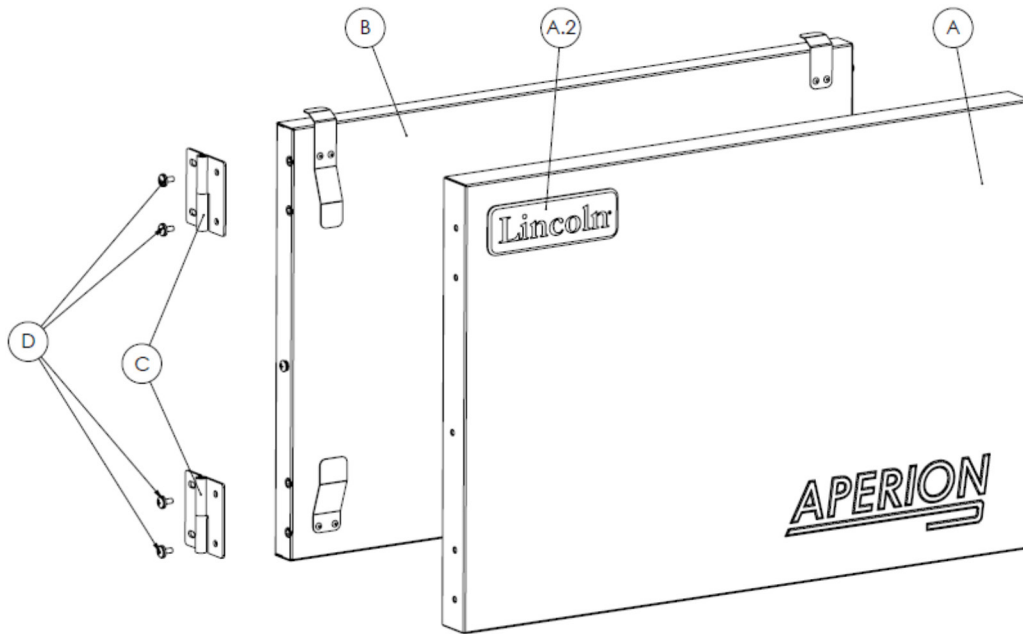
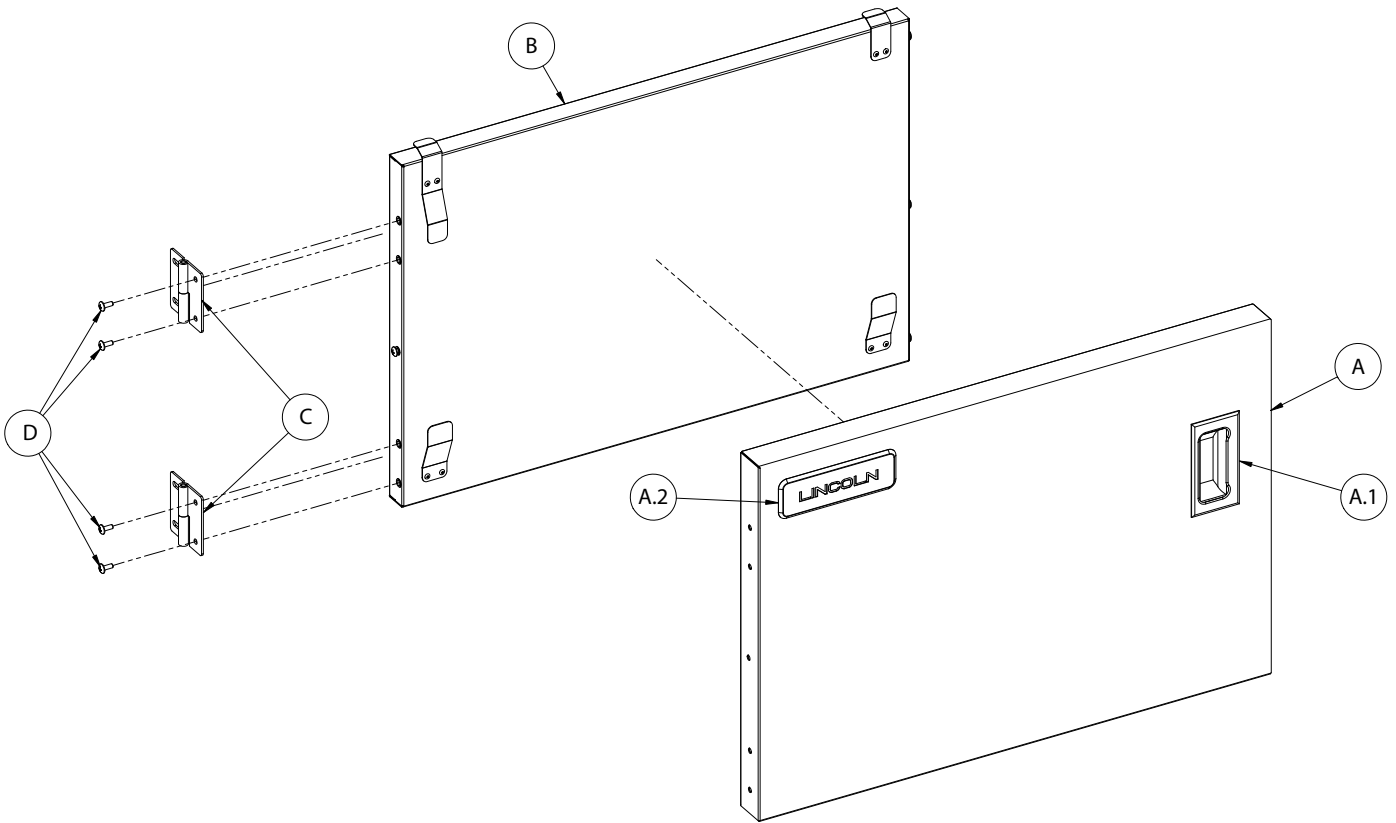
GAS TRAIN ASSEMBLY



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	2614013	
G	REDUCER NPT 3/4M – 1/2F EXPORT IMPINGER OVENS	369971	
H	ORIFICE MANIFOLD PGCD	4070523	
I	TUBE BYPASS	4606242	
J	MAIN ORIFICE	369757	369758
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	02251-1	
NOT SHOWN	BULK HEAD ASSEMBLY	371539	
NOT SHOWN	CONVERSION KIT: NATURAL GAS TO PROPANE	4610264	
NOT SHOWN	CONVERSION KIT: PROPANE TO NATURAL GAS	4610265	

DOOR ASSEMBLY - SOLID



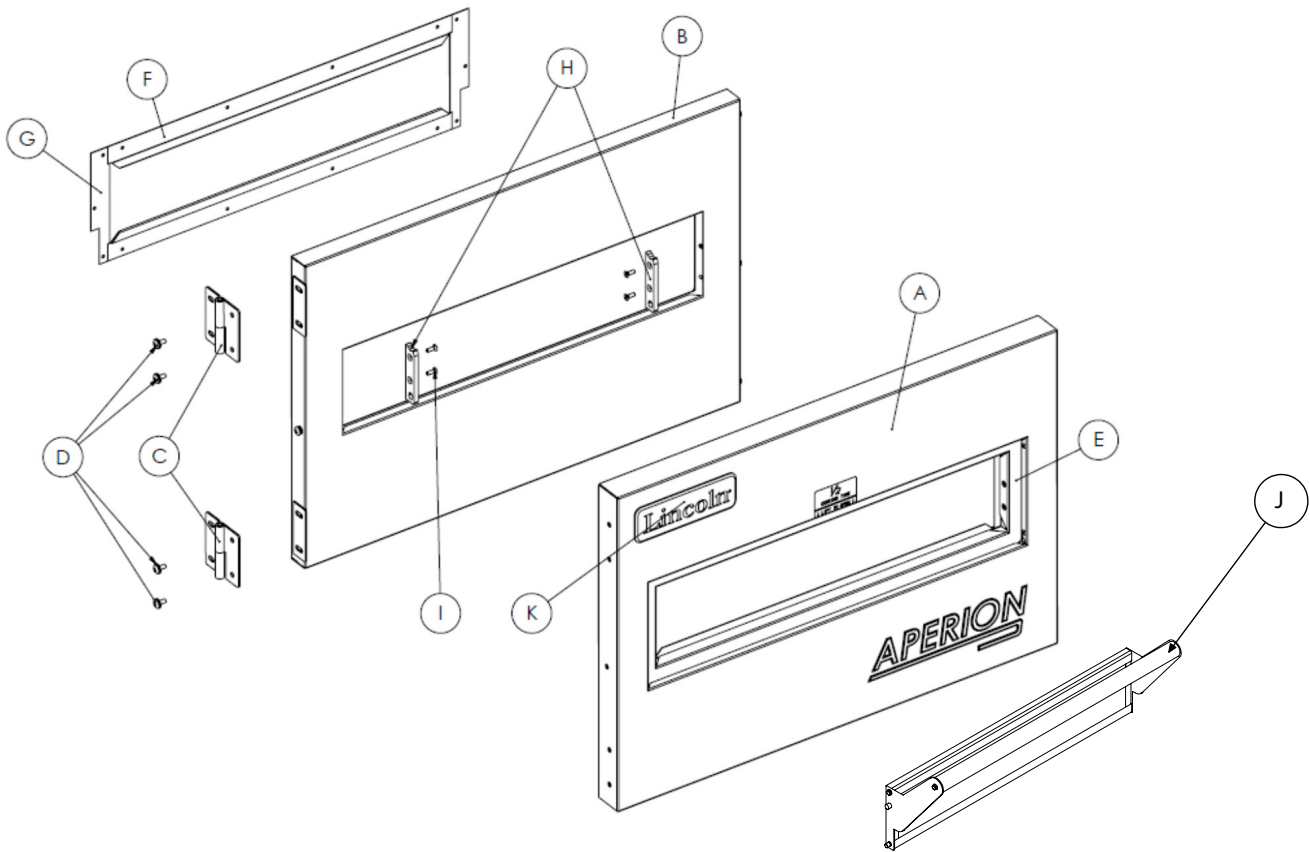
DOOR ASSEMBLY - SOLID

LETTER	DESCRIPTION	PART NUMBER
A*	COVER, OUTER DOOR 2424, FOR ALL 2424E/G-000X SERVICE KIT - COVER OUTER DOOR 2424, FOR (16/20/24/28)24-XXX	CK4605377 CK4610200
A.1	HANDLE DOOR LIFTOFF SST WITH #10 NUTS (FOR THE DOORS WITHOUT THE "APERION" EMBOSS")	08108
A.2	NAMEPLATE IMPINGER	370016
B	SERVICE KIT - DOOR SUB-ASSEMBLY, FOR ALL 2424E/G-000X SERVICE KIT - DOOR SUB-ASSEMBLY, FOR (16/20/24/28)24-XXX	CK4605374 CK4610199
C	DOOR HINGE	4605861
D	#10-24 X 1/2IN PHILLIPS	8003128
NOT SHOWN	LATCH AND CATCH	369501
FULL ASS'Y	DOOR ASS'Y SOLID FOR 2424E/G-000X	CK4605373
	DOOR ASS'Y SOLID FOR 1624,2024,2424,2824-XXXX	371551

***NOTE:**

- THE DOORS FOR 2424E/G-000X HAVE THE UPPER HINGE LOCATED 3" BELOW THE TOP OF THE DOOR
- THE DOORS FOR (16/20/24/28)24-XXX HAVE THE UPPER HINGE LOCATED 1-3/8" BELOW THE TOP OF THE DOOR

DOOR ASSEMBLY WITH WINDOW

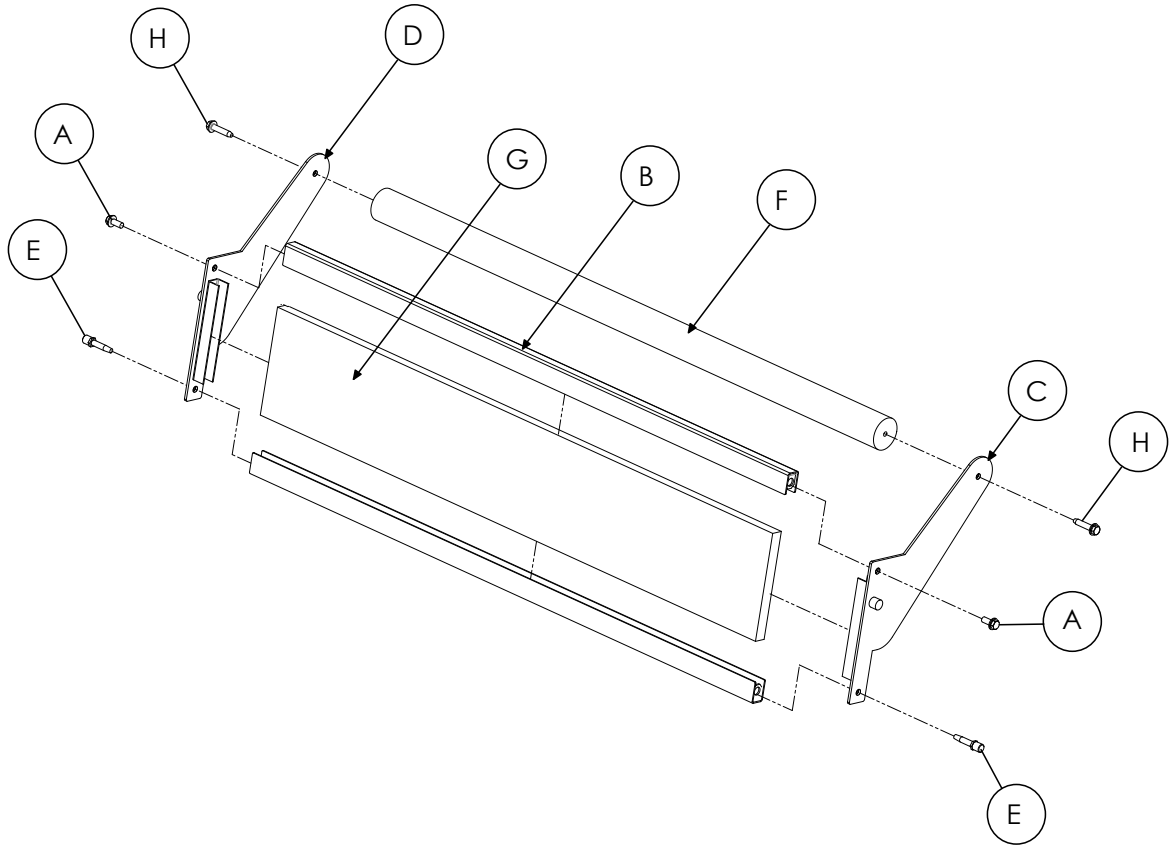


LETTER	DESCRIPTION	PART NUMBER
A*	COVER OUTER DOOR, WINDOW - FOR 2424E/G-000X	4611182
	COVER OUTER DOOR, WINDOW - FOR 1624, 2024, 2424, 2824-XXXX	4609460
B	INSIDE DOOR ASSEMBLY, WINDOW - FOR 2424E/G-000X	4611179
	INSIDE DOOR ASSEMBLY, WINDOW - FOR 1624, 2024, 2424, 2824-XXXX	CK4609458
C	DOOR HINGE	4605861
D	#10-24x1/2IN 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 DETAILS NEXT PAGE)	371558
K	NAMEPLATE IMPINGER	370016
NOT SHOWN	LATCH & CATCH	369501
FULL ASS'Y	DOOR ASSEMBLY, WINDOW - FOR 2424E/G-000X	CK4611178
	DOOR ASSEMBLY, WINDOW - FOR 1624, 2024, 2424, 2824-XXXX	371552

***NOTE:**

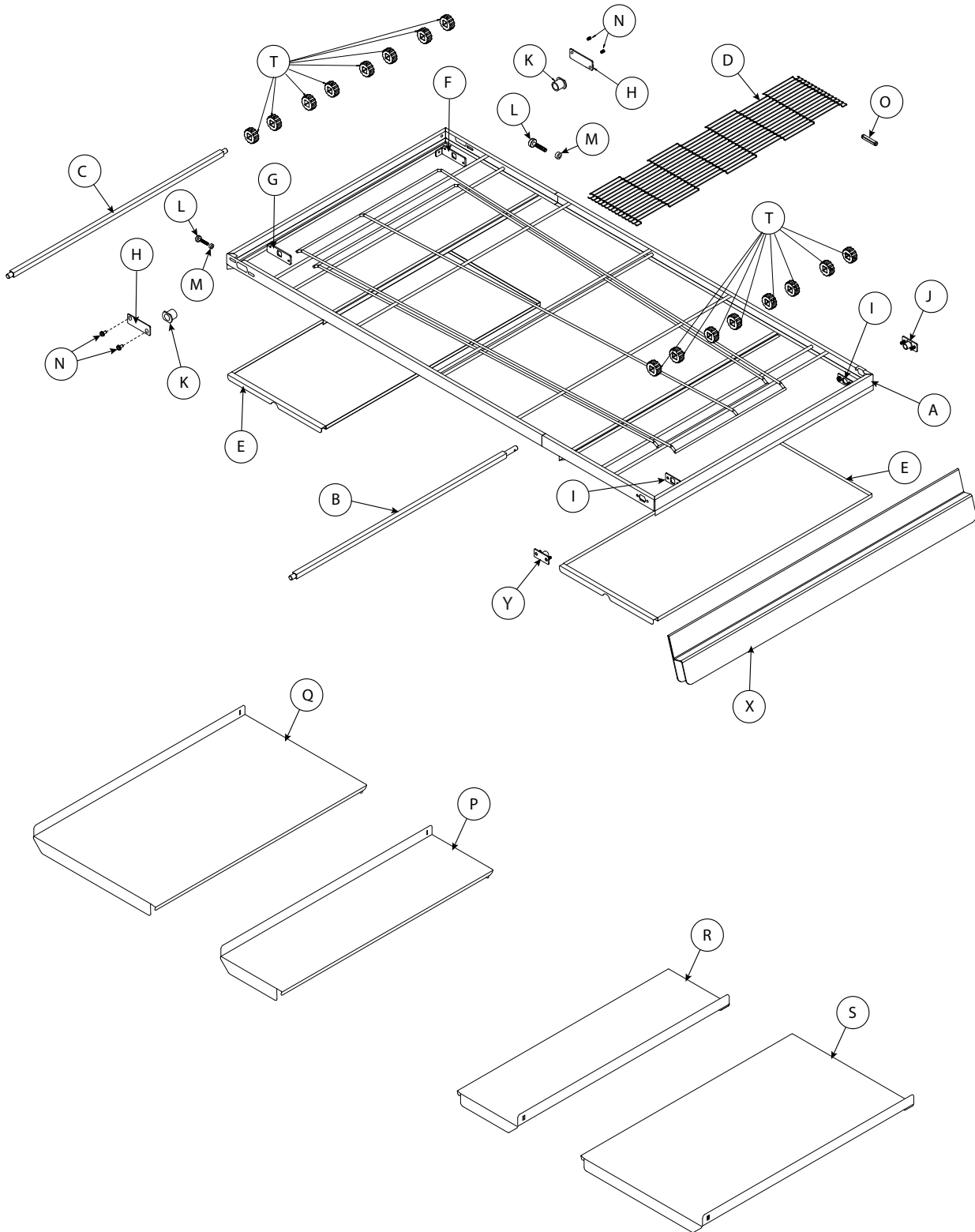
- THE DOORS FOR 2424E/G-000X HAVE THE UPPER HINGE LOCATED 3" BELOW THE TOP OF THE DOOR
- THE DOORS FOR (16/20/24/28)24-XXX HAVE THE UPPER HINGE LOCATED 1-3/8" BELOW THE TOP OF THE DOOR

ACCESS WINDOW GLASS



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
NOT SHOWN	WINDOW RETAINER	4609534
	ACCESS DOOR ASS'Y COMPLETE	371558

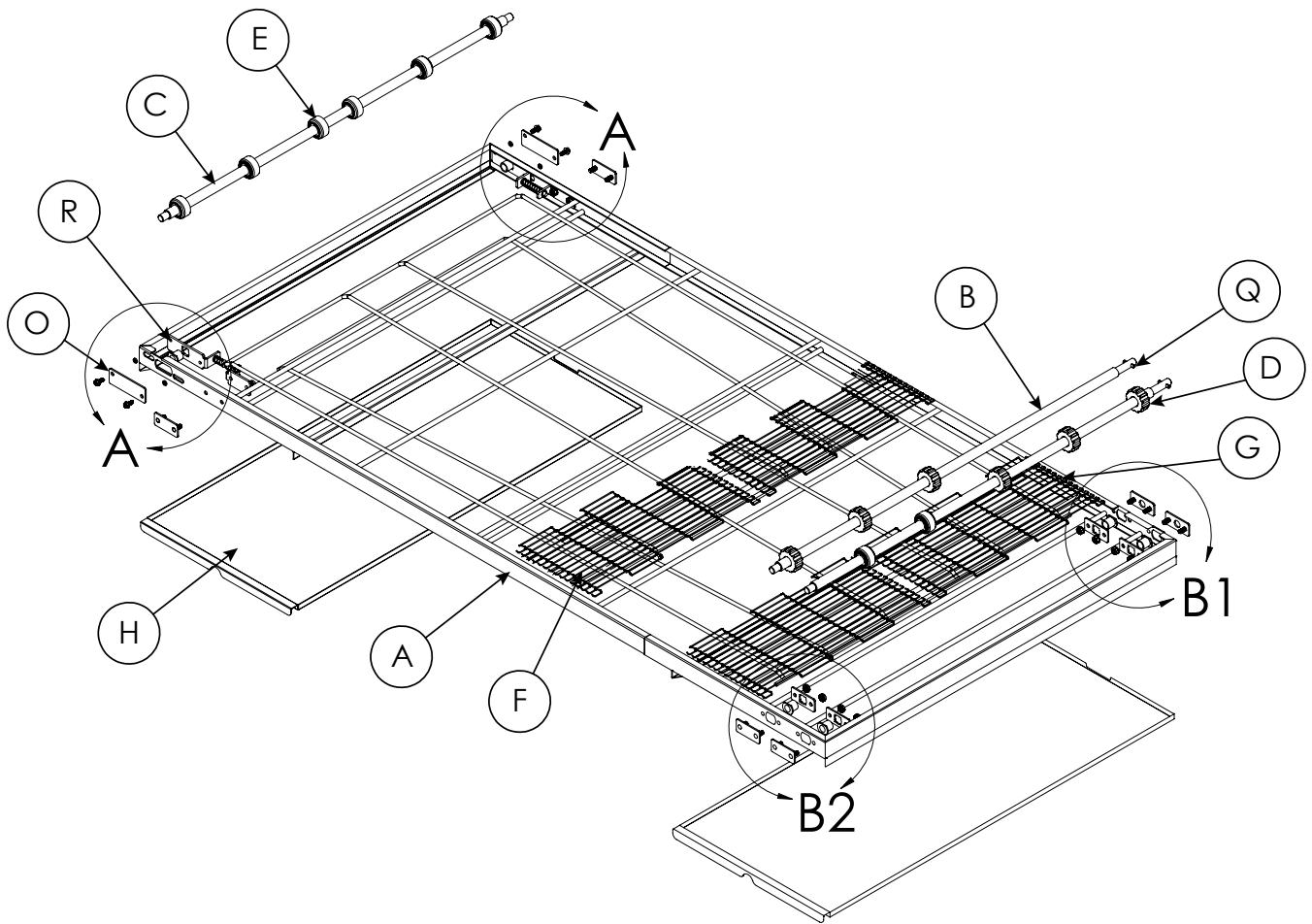
CONVEYOR ASSEMBLY - SOLID BELT



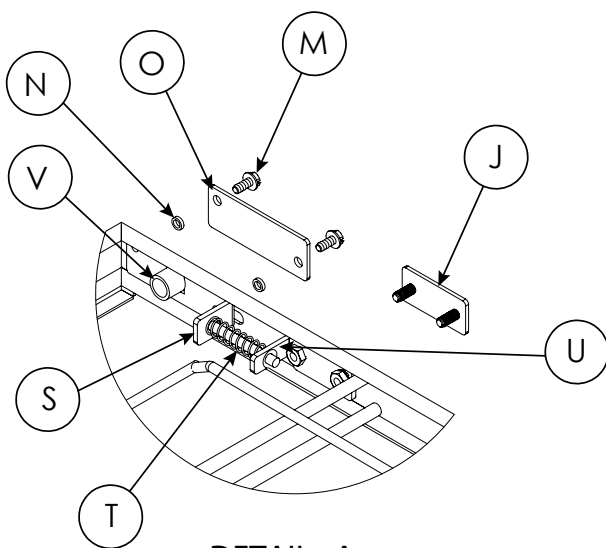
CONVEYOR ASSEMBLY - SOLID BELT

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			
X	PAN STOP	4609378	4609378	4609373	4609373
Y	STUD PLATE	4605751			
NOT SHOWN	SPLICE CLIP, .050 DIA WIRE	4608570	4609319	4608265	4609314

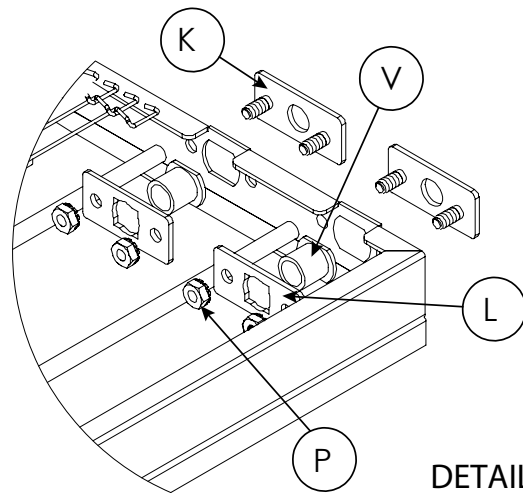
CONVEYOR ASSEMBLY - SPLIT BELT



FOR B2, USE
ITEM J INSTEAD OF K



DETAIL : A



DETAIL : B1

CONVEYOR ASSEMBLY - SPLIT BELT

LETTER	DESCRIPTION	PART NUMBER		
		2424 50/50	2424 30/70	2824 40/60
	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 PLATE	4605751		
K	STUD PLATE W/HOLES	4605749		
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 ENTRY 6"	L2406		L2806
NOT SHOWN	TRAY ENTRY 12"	L2412		L2812
NOT SHOWN	TRAY EXIT 6"	L2407		L2807
NOT SHOWN	TRAY EXIT 12"	L2413		L2813
NOT SHOWN	PAN STOP	4609373		
NOT SHOWN	SPLICE CLIP, .050 DIA WIRE	4608570		

ACCESSORY KITS

KIT	CONTENTS	MODELS			
		1624	2024	2424	2824
		PART NUMBER			
COUNTERTOP INSTALLATION, SINGLE	SHORT LEGS (4" / 102 mm)	L4612502			
COUNTERTOP INSTALLATION, DOUBLE STACKING	SHORT LEGS (4" / 102 mm)	L4612502			
FLOOR INSTALLATION, SINGLE	TALL LEGS, 6" CASTERS W/BRAKES, ADJUSTABLE RESTRAINING CABLE	L4612503			
FLOOR INSTALLATION, DOUBLE STACKING	TALL LEGS, 6" CASTERS W/BRAKES, ADJUSTABLE RESTRAINING CABLE	L4612503			
FLOOR INSTALLATION, TRIPLE STACKING	6" CASTERS W/BRAKES, ADJUSTABLE RESTRAINING CABLE, HEAT SHIELDS	L4612504			
CONVERSION: NATURAL GAS TO PROPANE	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL, SPRING KIT	4610264			
CONVERSION: PROPANE TO NATURAL GAS	VENTURI, BYPASS ORIFICE, MAIN ORIFICE, CONVERSION LABEL, SPRING KIT	4610265			

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