

# Assembly Instructions



## Alfa Refrattari Professional / Commercial Pizza Ovens

1

Construct two supporting walls approximately 75 cm high in order to obtain an over base at approximately 110 cm.

2

Construct a 15 cm slab made from reinforced concrete.

3

Construct a 15 cm floor with cement blocks or light concrete made from expansive clay or vermiculite.

4

After wetting the concrete blocks, spread a thin layer of Refrax mortar with a toothed trowel and arrange the parts that compose the oven cooking floor.

5

Wet the junctions of the oven floor pieces and mortar them with Refrax, being careful to keep the mortar slightly lower than the level of the oven floor, to avoid having it become dislodged by the pizza peels. The space between the oven floor and the oven walls should be left unfilled!

6

After mounting the oven dome and arch, check that the various pieces have been assembled properly

7

After wetting the abutments of the dome pieces, apply a layer of Refrax of 5 cm. For additional thermal inertia, apply an additional layer of Refrax across the entire dome of approximately 6 cm. For larger ovens it is necessary to place a light metal net within the Refrax layer.

8

After applying the layer of Refrax mortar, continue with the isolation of the oven by spreading at least one layer of ceramic fiber around the dome. We recommend at least one layer of ceramic fiber of approx 2-4 cm, followed by 10-15 cm of vermiculite, expansive clay and/or heat resistant rockwool.

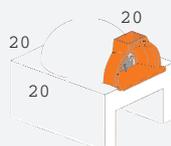
9

In order to maintain the visually spherical form of the dome, cast 3-4 cm of sand and cement around the ceramic fiber isolation, after having already created a metal net in the desired shape of the dome.

10

If the oven is going to be placed outdoors, it will be necessary to protect it from rain and humidity.

SEZIONI MINIME DI CANNA FUMARIA (in caso di installazione interna)						
altezza canna fumaria	maggiore di mt9	maggiore di mt8	maggiore di mt5	maggiore di mt4,5	maggiore di mt3,5	maggiore di mt2,5
altezza canna fumaria a sez. circolare	Ø cm 15	Ø cm 18	Ø cm 20	Ø cm 22	Ø cm 25	Ø cm 30



### Warning!

When determining the size of the supporting structure, remember to leave approximately 20 cm of clearance space between the oven sides and the surrounding walls. Be sure to leave enough space for the oven arch in front of the oven.

## RECOMMENDATION FOR FIRST USE OF ALFA Refrattari OVENS



### WARNING!

Before beginning to use your Alfa Refrattari oven, wait at least **5 days** after assembling it. Begin by making small fires which last approximately one hour each, until the internal humidity of the oven is completely dried out (around 20 liters of water for a medium sized oven!). During this time, try not to let the temperature of the oven exceed 100 °C, because when the water becomes steam, it's size can increase and damage the oven.

### Ecological Combustion

Alfa Refrattari ovens use combustible wood and make use of the natural flavors they impart on food giving them unmistakable tastes. Both small branches and larger pieces of wood, which have the advantage of staying lit for longer periods of time, can be used.

### Starting a Fire

Prepare a batch of dry wood inside the oven, near the oven mouth, lighting it from below, keeping in mind that the fire should be continuous. Slowly, as the initial wood burns, add larger pieces of wood to the fire. After a few minutes, when the volume of the fire has increased and become active, you can move the embers to one side of the oven. Add additional wood to the fire as needed, being sure never to let the fire extinguish. Keep the fire active for 50 minutes. If you require a particular homogeneity and intensity of heat, this may be regulated through use of the oven door. By keeping the oven door slightly closed, the heat of the combustion will penetrate the oven's refractory materials more deeply.

### Cooking

After an hour has passed since the fire has been started, the fire will become lazy and the oven will become white. This is a sign that the oven is ready to begin making pizzas. For prolonged use, add additional wood from time to time to keep the flame going.

## CONTROLLING PERFORMANCE OF YOUR ALFA REFRATTARI OVEN

If the oven begins to smoke

- Check to make sure the wood is not humid and therefore not combustible.
- Ensure that the fire was made with live flame, gradually increased but constant, in order to avoid incomplete combustion.
- Double check the placement of the flue exit and ensure there is a proper ventilation shaft for the smoke to exit from.

If the oven does not heat properly

- Check that the fire is placed on the side of the oven away from the oven mouth.
- Make a fire with approximately 40-50 minutes of blazing flame.
- Do not use incombustible wood.
- Add additional wood to the fire gradually.
- If the temperature of the external walls of the oven and underneath the oven floor are higher than 40° C / 104° F, it is likely that the insulation of the oven is insufficient and needs to be reinforced.

If the oven cools down too quickly

- The cause could be either from the first starting or starting the oven after a long period of inactivity.
- Verify that the external insulation of the oven. It should be warm but not exceedingly hot.
- Avoid making a small or fast fire that would not heat the oven to capacity.
- Verify that water and/or humidity have not infiltrated the oven.
- If flames come out of the oven mouth, partially close the oven door.

Don't be concerned if the refractory develops microveins

- It is natural for refractory to develop small microveins after continuous use. These microveins are a characteristic of refractory materials and are necessary for the thermic dilation, and they function as normal junctures would.
- ALFA Refrattari does not reply to questions regarding microveins, cracks, or breaks in the refractory, because this is an intrinsic characteristic of refractory material itself.

Keep in mind that...

- The air that feed the combustion of the oven enters through the lower part of the oven mouth.
- After adding wood to the fire, expect additional smoke, which should exit from the upper part of the oven mouth towards the flue.

## IMPROVING OVEN PERFORMANCE

### Using gas or pellets?

Is wood a problem because of lack of storage space? Alfa Refrattari can add additional combustaible capacities to your oven. Easy installation of the gas diffusor Alfa Easy Alfa pellet burned is simple. Contact us to find out more.

### Is the oven cooking floor worn down?

Its natural that after thousands of pizzas, the oven cooking floor may be slightly eroded or worn down.

This is not a problem for somebody who wants the most from their oven, and Alfa Refrattari with more than 30 years of experience in the production fo refractory materials can assist you to remake your oven floor to perfection.

### Is the oven mouth damaged?

Sometimes oven mouths made in brick, after years of heavy use, can open up in such a way as to danager the oven mouth in refractory. Alfa Refrattari can help with this as well. For more information, please see our website.

### Does the lose heat?

Many functioning pizza ovens have been installed by contractors without the intimate knowledge needed to properly make a pizza oven. Usually, these kinds of ovens don't have adequate insulation. The symptoms of this problem are usually verifiable when the oven floor becomes cold too quickly and the sides of the oven radiate extra heat into the surrounding space, neighboring houses, and or physical contact with the oven is usally hot. Alfa Refrattari can assist to help resolve this annoying problem by providing additional insulating refractory materials to ensure no heat lost.

### Does the oven use too much wood?

Usually, with a few small modifications, it is possible to make the oven consume less wood and still function properly. Alfa Refrattari is available to help you determine what additional modifications may be needed.

