

Specifications of XPO™ ultra low NOx burners

Packaged versions (PB)

Typical burner data											
Fuel: natural gas at 15°C with 10.9 kWh/Nm ³ HHV - sg = 0.6 [1]											
Combustion air: 15°C - 21% O ₂ - 50% humidity - sg = 1.0 [1]											
Stated pressures are indicative. Actual pressures are a function of air humidity, altitude, type of fuel and gas quality.											
		XPO 1 PB 2 XPO 1 PB 4		XPO 2 PB 2 XPO 2 PB 4		XPO 3 PB 2 XPO 3 PB 4		XPO 4 PB 4		XPO 5 PB 4	
		15% excess air	30% excess air	15% excess air	30% excess air	15% excess air	30% excess air	15% excess air	30% excess air	15% excess air	30% excess air
Maximum burner capacity [4]	kW	351	293	688	615	966	878	1464	1318	1932	1757
Minimum burner capacity [2]	kW	88	88	173	173	193	193	293	293	293	293
Turndown ratio [3]		4:1	3.3:1	4:1	3.6:1	5:1	4.5:1	5:1	4.5:1	6.6:1	6:1
Maximum air flow	m ³ /h	374	352	732	739	1028	1055	1558	1582	2042	2098
Advised pilot capacity	kW	17	17	23	23	29	29	29	29	29	29
Advised pilot pressure [6]	mbar	5	5	10	10	15	15	22	22	22	22
Fan horsepower		1	1	3	3	5	5	7.5	7.5	7.5	7.5
Blast tube OD	mm	152	152	152	152	152	152	203	203	203	203
Air pressure [5] [6]	mbar	22	16	35	35	37	30	40	40	39	39
Air pressure minimum [3] [5]	mbar	1.25 - 2.5	1.25 - 2.5	1.25 - 2.5	1.25 - 2.5	1.25 - 2.5	1.25 - 2.5	1.7	1.7	1.25	1.25
Gas pressure [5] [6]	mbar	22	16	35	34	37	30	40	40	37	36
Fire tube size (inside diameter)	mm	355 to 457		406 to 560		457 to 610		560 to 812		560 to 864	

[1] sg (specific gravity) = relative density to air (density air = 1.293 kg/Nm³)

[2] Minimum burner capacity will be affected by fuel and applications parameters (heat flux).

[3] Will vary depending on the application heat flux. Lower heat flux (<3631 kW/m²) will result with lower turndown ratios and increase in minimum air pressure.

[4] Capacity displayed assumes blower operation on 60Hz electrical supply. Gross output will be reduced by 17% if operated on 50Hz. Fuel and air pressure should be reduced by 30% while motor power will reduce 40% with 50Hz operation. Turndown ratio will be reduced in kind with minimum capacity remaining fixed.

[5] Measured as differential to chamber port.

[6] Measured with scanner cooling air valve closed.

Note: For proper burner adjustment, MAXON advises the use of an oxygen content meter. Optimal oxygen level in the exhaust stack should read between 3 and 6 vol. % dry when measured with burner operating at maximum capacity firing rate.

External blower versions (EB)

Typical burner data					
Fuel: natural gas at 15°C with 10.9 kWh/Nm ³ HHV - sg = 0.6 [1]					
Combustion air: 15°C - 21% O ₂ - 50% humidity - sg = 1.0 [1]					
Stated pressures are indicative. Actual pressures are a function of air humidity, altitude, type of fuel and gas quality.					
		XPO 3 EB 2 XPO 3 EB 4		XPO 5 EB 4	
		15% excess air	30% excess air	15% excess air	30% excess air
Maximum burner capacity [4]	kW	1318	1230	2577	2342
Minimum burner capacity [2]	kW	220	220	439	439
Turndown ratio [3]		6:1	5.6:1	5.9:1	5.3:1
Maximum air flow	m ³ /h	1402	1478	2718	2798
Advised pilot capacity	kW	29	29	29	29
Advised pilot pressure [6]	mbar	15	15	20	20
Blast tube OD	mm	152	152	203	203
Air pressure [5] [6]	mbar	80	80	67	67
Air pressure minimum [3] [5]	mbar	1.25 - 2.5	1.25 - 2.5	1.7	1.7
Gas pressure [5] [6]	mbar	90	85	69	68
Fire tube size (inside diameter)	mm	406 to 711		559 to 914	

[1] sg (specific gravity) = relative density to air (density air = 1.293 kg/Nm³)

[2] Minimum burner capacity will be affected by fuel and applications parameters (heat flux).

[3] Will vary depending on the application heat flux. Lower heat flux (<3631 kW/m²) will result with lower turndown ratios and increase in minimum air pressure.

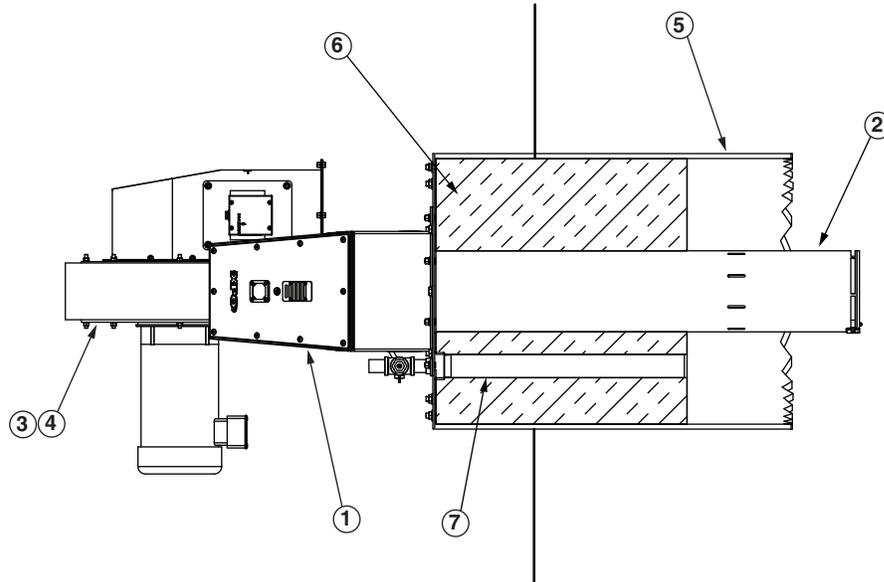
[4] Capacity displayed assumes blower operation on 60Hz electrical supply. Gross output will be reduced by 17% if operated on 50Hz. Fuel and air pressure should be reduced by 30% while motor power will reduce 40% with 50Hz operation. Turndown ratio will be reduced in kind with minimum capacity remaining fixed.

[5] Measured as differential to chamber port.

[6] Measured with scanner cooling air valve closed.

Note: For proper burner adjustment, MAXON advises the use of an oxygen content meter. Optimal oxygen level in the exhaust stack should read between 3 and 6 vol. % dry when measured with burner operating at maximum capacity firing rate.

Materials of construction



Item number	Burner part	Material
1	Burner housing	1010 steel (1.1121)
2	Blast tube	304 stainless steel (1.4301)
3	Fan case	1010 steel (1.1121)
4	Fan impeller (inside fan case)	Aluminum
5	Fire tube (customer supplied)	Stainless steel (recommended)
6	Insulation (customer supplied)	Soft insulation material 1090°C temperature rating
7	2 inch guide tube (customer supplied)	Stainless steel (recommended)

Selection criteria

Application details

XPO™ burners can be used in all indirect fire tube liquid backed solution heater applications. They combine flexibility and stability with low NOx emissions.

Process temperature

The XPO™ burner is engineered for installation in moderate temperature (less than 870°C), liquid backed fire tubes. Protect the burner from high temperatures during a burner stop (purge to avoid back flow of hot process air).

Piloting and ignition

All XPO™ burners are equipped with an independent pilot design. Pilots shall be used only for ignition of the main flame (interrupted). Use of a standing (continuous) pilot is not recommended. Use minimally 5000 V/200 VA ignition transformers for sparking of the spark ignitor.

Start the burner at low fire setting only. Direct spark ignition of standard XPO™ burners is possible. Locate one pilot gas valve as close as possible to the pilot burner gas inlet to have fast ignition of the pilot burner.

Typical ignition sequence

- Pre-purge of burner and installation, according to the applicable codes and the installation's requirements.
- Combustion air control valve shall be in the minimum position to allow minimum combustion air flow to the burner.
- Pre-ignition (typically 2 seconds sparking in air).
- Open pilot gas and continue to spark the ignitor (typically 5 seconds).
- Stop sparking, continue to power the pilot gas valves and start flame check. Trip burner if no flame from here on.
- Check pilot flame stability (typically 5 seconds to prove stable pilot).
- Open main gas valves and allow enough time to have main gas in the burner (typically 5 seconds + time required to have main gas in the burner).
- Close the pilot gas valves.
- Release to modulation (allow modulation of the burner).

Above sequence shall be completed to include all required safety checks during the start-up of the burner (process and burner safeties).

Ratio control

Accurate air/fuel ratio control can be accomplished with MAXON SMARTLINK® or Honeywell ControlLink™ actuators. Precise ratio control will yield optimal emissions and efficiency performance.

Flame supervision

XPO™ burner flames shall be supervised by the use of a UV or IR scanner.

Piping

Follow all applicable codes including regional codes, local directives, standards and recommendations of your insurance carrier when designing and installing XPO™ burners. Installation should only be undertaken by qualified gas contractors licensed for any regional or local requirements.

Piping weight should be independently supported. Do not use the burner as a piping support or hang weight from the burner's flange connections.

Fuels

XPO™ burners are designed for firing of clean fuel gases such as natural gas or LPG.

Expected emissions

The XPO™ burner will achieve ultra low NOx emissions while operating at 30% excess air level. The burner provides higher combustion efficiency and lower emissions without the use of expensive FGR or exotic/fragile materials.

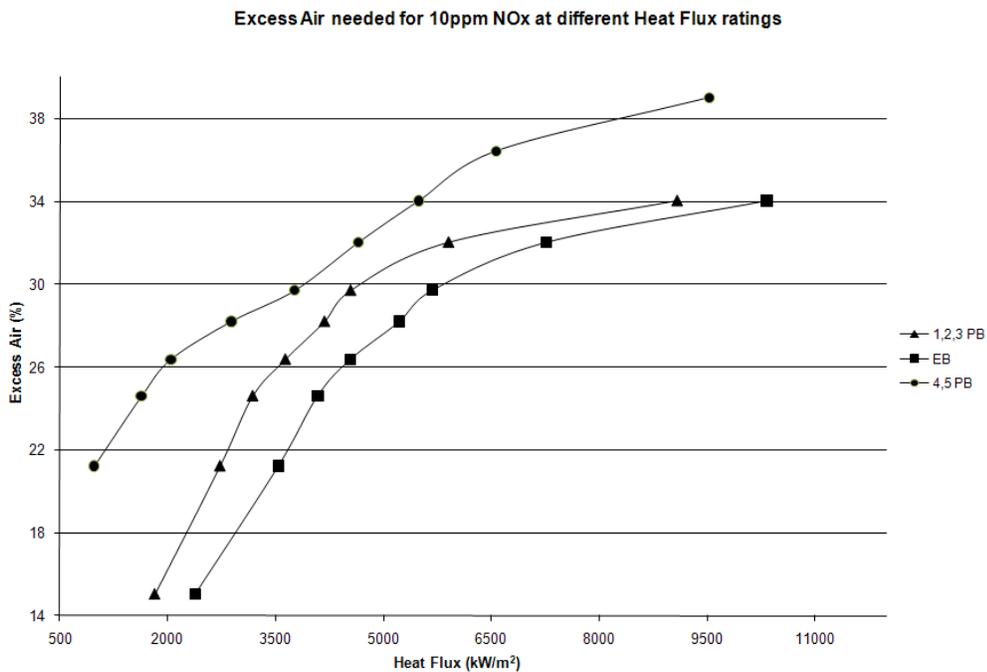
Exact emissions performance may vary in your application. Contact MAXON for information on installation-specific estimates and guaranteed values. No guarantee of emissions is intended or implied without specific, written guarantee from MAXON.

Fire tube sizing

See the table below for ideal fire tube size. The burner should be sized within the range of the suggested heat flux. For best emission performance, the burner should be fired into a fire tube with the lowest suggested heat flux.

Heat flux = Burner input / fire tube area

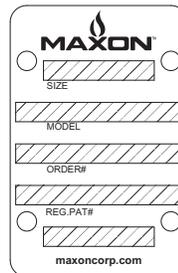
Burner input kW	Burner size	Heat flux	Fire tube size (iD)											
			14 inch	16 inch	18 inch	20 inch	22 inch	24 inch	26 inch	28 inch	30 inch	32 inch	34 inch	36 inch
293	XPO 1 PB	kW/m ²	2950	2270	1770									
586	XPO 2 PB			4500	3590	2900	2400							
878	XPO 3 PB				5360	4300	3590	2990						
1244	XPO 3 EB			9580	7580	6130	5080	4270	3630	3130				
1318	XPO 4 PB						5360	4500	3860	3300	2900	2540		
1757	XPO 5 PB						7170	6040	5130	4400	3860	3400	2990	
2342	XPO 5 EB						9530	8040	6860	5900	5130	4490	4000	3590



Below 3631 kW/m² burner turndown will be limited to <3 to 1.

Intelligent model numbers

A coded model number is provided on the nameplate of all XPO™ burners to provide a simple method to identify the configuration of the product. This model number ensures accuracy in identifying your product, ordering replacement parts or communicating capabilities.



Burner series	Size	Blower options	Blast tube length	Voltage	Control method	Flame detection	Air pressure switch	Actuator	Mounting flange gasket	Air valve position	Air actuator position
XPO	1	PB	2	1	B	3	N	Y	Y	L	T

Burner series

XPO

Size

- 1 = Blast tube #1
- 2 = Blast tube #2
- 3 = Blast tube #3
- 4 = Blast tube #4
- 5 = Blast tube #5

Blower options

PB = packaged burner (blower included)
EB = external blower (blower not included)

Blast tube length

- 2 = 610 mm
- 4 = 1220 mm [3]

Voltage

- 1 = 230/460/3/60
- 2 = 575/3/60 [2]
- 3 = 115/230/1/60 [1]
- * = for external blowers (N/A)

Control method

- B = SMARTLINK MRV
- C = Honeywell ControLink
- * = for external blowers

Flame detection

- 3 = Standard UV scanner provision
- 4 = Hazardous location UV scanner provision

Air pressure switch

- A = Antunes
- H = Honeywell
- N = None

Actuator

- Y = included with burner
- N = Not included
- * = external blowers

Mounting flange gasket

- Y = included with burner
- N = not included

Air valve position

- L = Left hand
- R = Right hand

Air actuator position

- B = Bottom of air valve
- T = Top of air valve

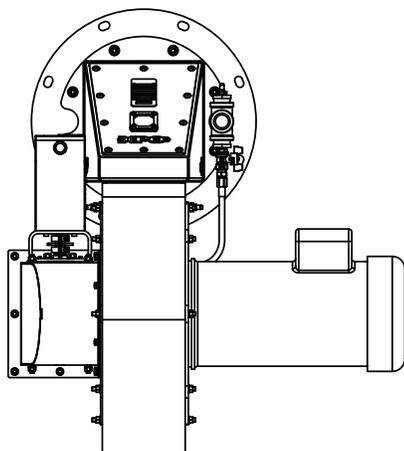
[1] Only choice available for size #1, #2 and #3 blast tubes

[2] Only available in size #1

[3] Only choice available for size #4 and #5 blast tubes

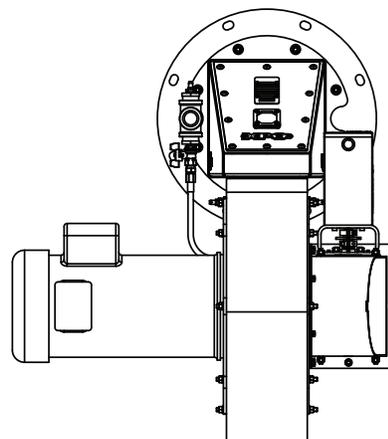
Air valve and air actuator positions

XPO™ burners may be ordered with your choice of air valve position and air actuator position as shown below. The drawings below depict XPO™ burners with MAXON SMARTLINK® actuators.



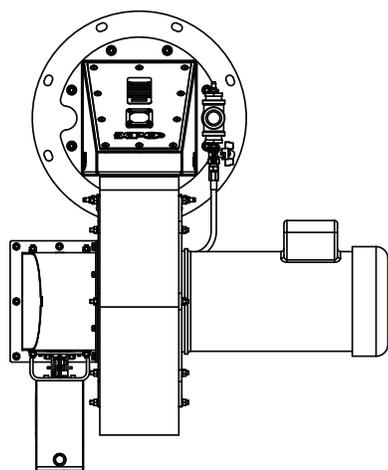
Air valve position: (L) left hand
Actuator position: (T) top of air valve

Actuator rotation for configuration shown above	
SMARTLINK® actuator	Counter-clockwise
General purpose actuator	Clockwise



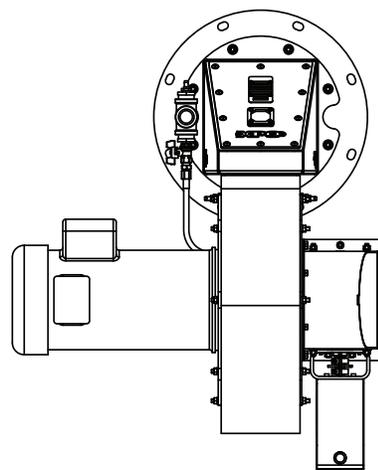
Air valve position: (R) right hand
Actuator position: (T) top of air valve

Actuator rotation for configuration shown above	
SMARTLINK® actuator	Clockwise
General purpose actuator	Counter-clockwise



Air valve position: (L) left hand
Actuator position: (B) bottom of air valve

Actuator rotation for configuration shown above	
SMARTLINK® actuator	Clockwise
General purpose actuator	Counter-clockwise

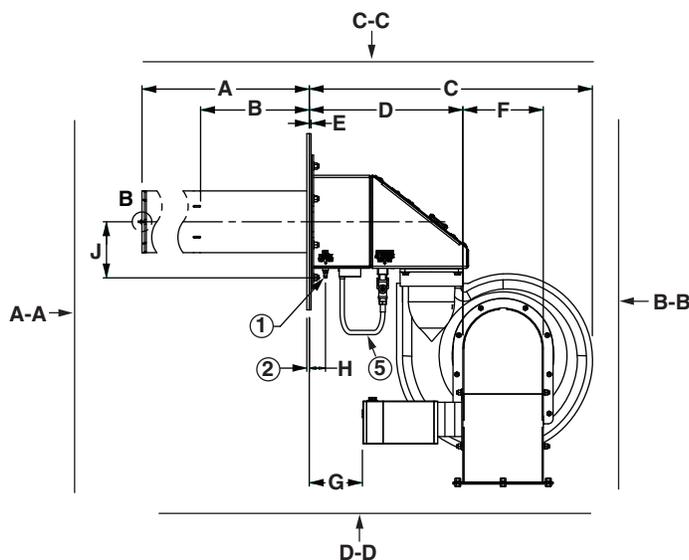


Air valve position: (R) right hand
Actuator position: (B) bottom of air valve

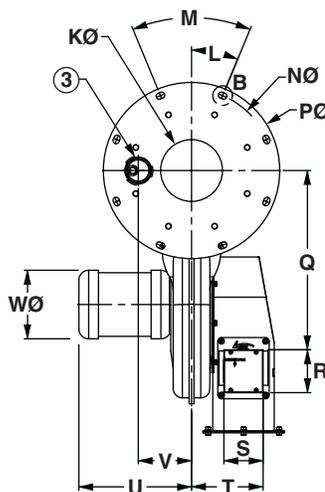
Actuator rotation for configuration shown above	
SMARTLINK® actuator	Counter-clockwise
General purpose actuator	Clockwise

Dimensions

XPO™ 1 PB (packaged) burner



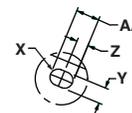
View A-A



Detail A



Detail B



- 1) Gas pressure test port
- 2) 6 mm optional oven wall gasket
- 3) 2" NPT scanner port coupling
- 4) .15" ± .050" ceramic
- 5) Scanner cooling air flex line

Dimensions in mm unless stated otherwise

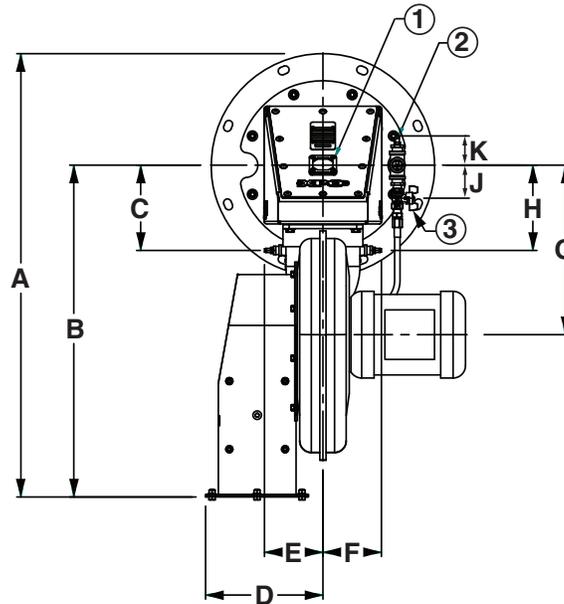
Burner size	A	B	C	D	E	F	G	H	J	K Ø	L	M
XPO 1 PB 2	592	282	734	398	5	208	138	42	146	160	22.5°	45°
XPO 1 PB 4	1145	848										

Burner size	N Ø	P Ø	Q	R	S	T	U	V	W Ø	X	Y	Z	AA
XPO 1 PB 2	420	457	465	111	102	185	292	138	178	8	16	11	23
XPO 1 PB 4													

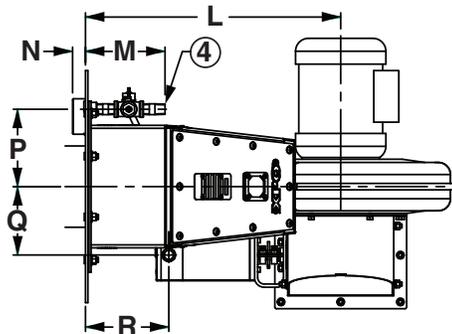
XPO™ 1 PB (packaged) burner

- 1) Observation window
- 2) Chamber pressure test port
- 3) Scanner cooling air valve
- 4) 1" NPT scanner port
- 5) Combustion air pressure test port
- 6) 1/2" NPT S-O ignition wire connection
- 7) Main gas inlet 1-1/2" NPT
- 8) 3/8" NPT pilot gas connection
- 9) Pilot gas pressure test port

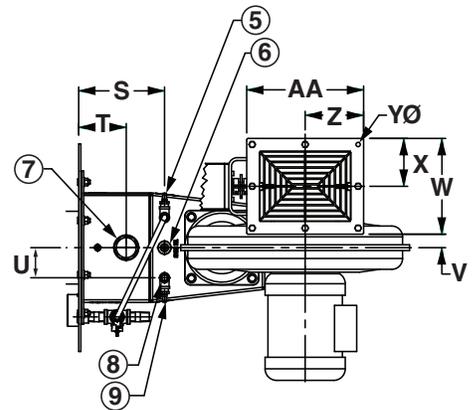
View B-B



View C-C



View D-D

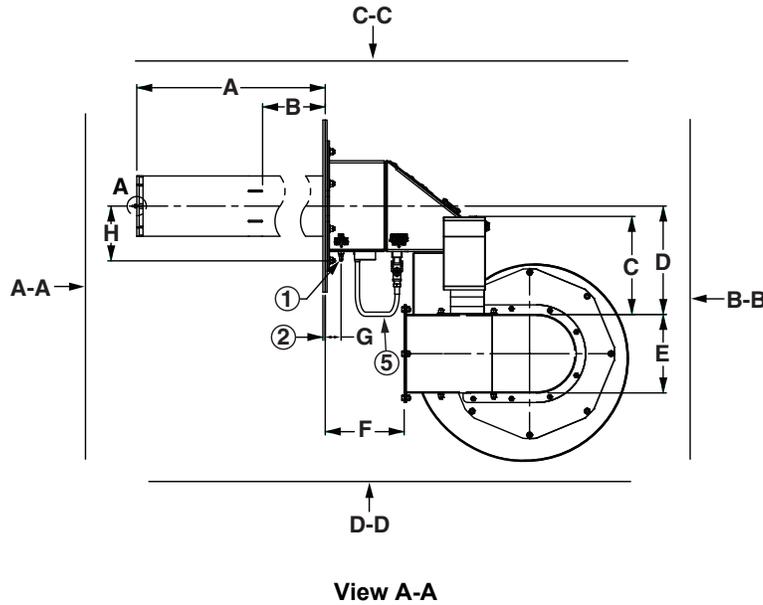


Dimensions in mm unless stated otherwise													
Burner size	A	B	C	D	E	F	G	H	J	K	L	M	N
XPO 1 PB	909	680	175	240	120	120	348	175	68	60	502	156	25

Burner size	P	Q	R	S	T	U	V	W	X	YØ	Z	AA
XPO 1 PB	152	135	164	190	105	66	30	210	105	10	130	260

XPO™ 2 & 3 PB (packaged) burner

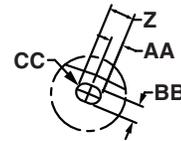
- 1) Gas pressure test port
- 2) 6 mm optional oven wall gasket
- 3) 2" NPT scanner port coupling
- 4) .15" ± .050 ceramic
- 5) Scanner cooling air flex line



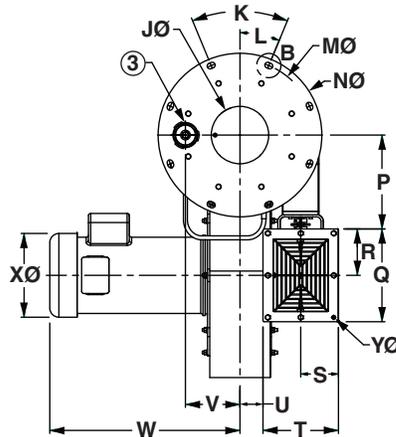
Detail A



Detail B



View A-A



Dimensions in mm unless stated otherwise

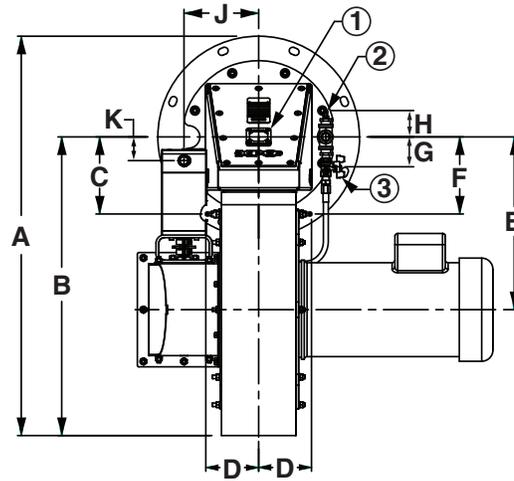
Burner size	A	B	C	D	E	F	G	H	J Ø	K	L	M Ø	N Ø	P
XPO 2 PB 2	592	269	262	288	208	210	42	146	160	45°	22.5°	420	457	262
XPO 2 PB 4	1146	838												
XPO 3 PB 2	592	259												
XPO 3 PB 4	1146	810												

Burner size	Q	R	S	T	U	V	W	X Ø	Y	Z	AA	BB	CC
XPO 2 PB	259	130	105	210	64	152	444	218	10	23	11	16	8
XPO 3 PB							530	234					

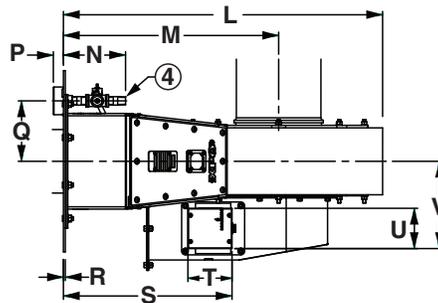
XPO™ 2 & 3 PB (packaged) burner

- 1) Observation window
- 2) Chamber pressure test port
- 3) Scanner cooling air valve
- 4) 1" NPT scanner port
- 5) Combustion air pressure test port
- 6) 1/2" NPT S-O ignition wire connection
- 7) Main gas inlet 1-1/2" NPT
- 8) 3/8" NPT pilot gas connection
- 9) Pilot gas pressure test port

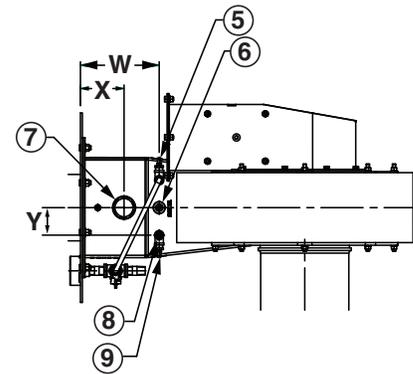
View B-B



View C-C



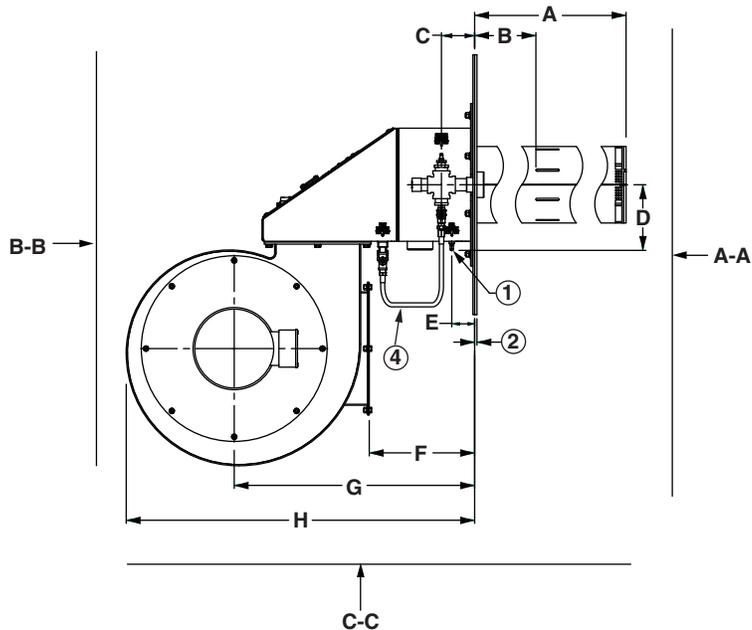
View D-D



Dimensions in mm unless stated otherwise												
Burner size	A	B	C	D	E	F	G	H	J	K	L	M
XPO 2 PB	906	678	175	120	392	175	68	60	170	54	805	542
XPO 3 PB												

Burner size	N	P	Q	R	S	T	U	V	W	X	Y
XPO 2 PB	156	25	152	5	424	111	102	220	190	105	66
XPO 3 PB											

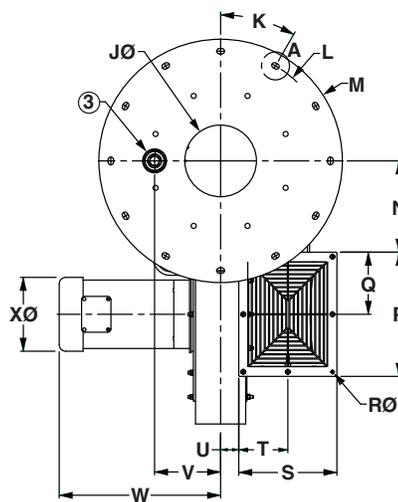
XPO™ 4 & 5 PB (packaged) burner



- 1) Gas pressure test port
- 2) 6 mm optional oven wall gasket
- 3) 2" NPT scanner port coupling
- 4) Scanner cooling air flex line

View A-A

Detail A



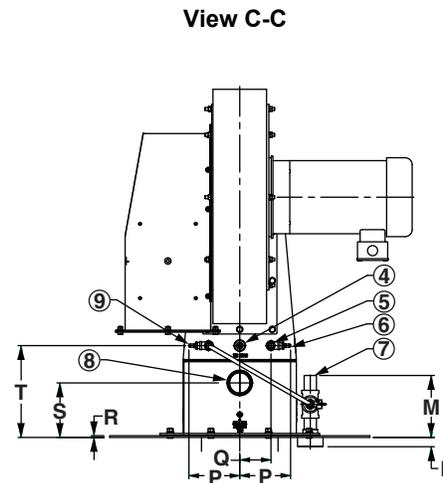
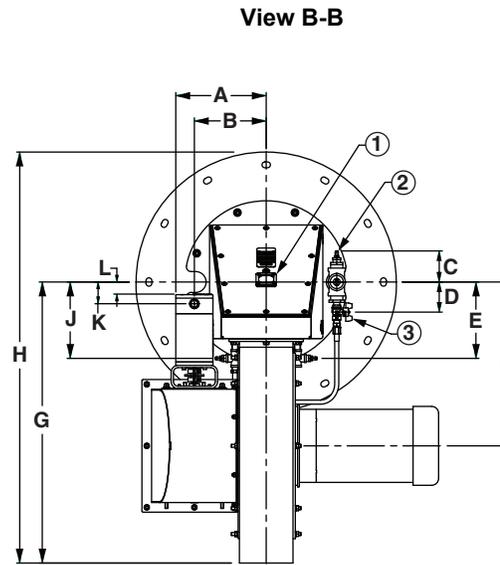
Dimensions in mm unless stated otherwise

Burner size	A	B	C	D	E	F	G	H	J Ø	K	L Ø	M	N
XPO 4 PB	1096	756	90	180	62	288	657	952	209	30°	641	711	267
XPO 5 PB		736											

Burner size	P	Q	R Ø	S	T	U	V	W	X Ø	Y	Z	AA	BB
XPO 4 PB	363	181	10	286	144	53	193	471	216	8	23	11	16
XPO 5 PB													

XPO™ 4 & 5 PB (packaged) burner

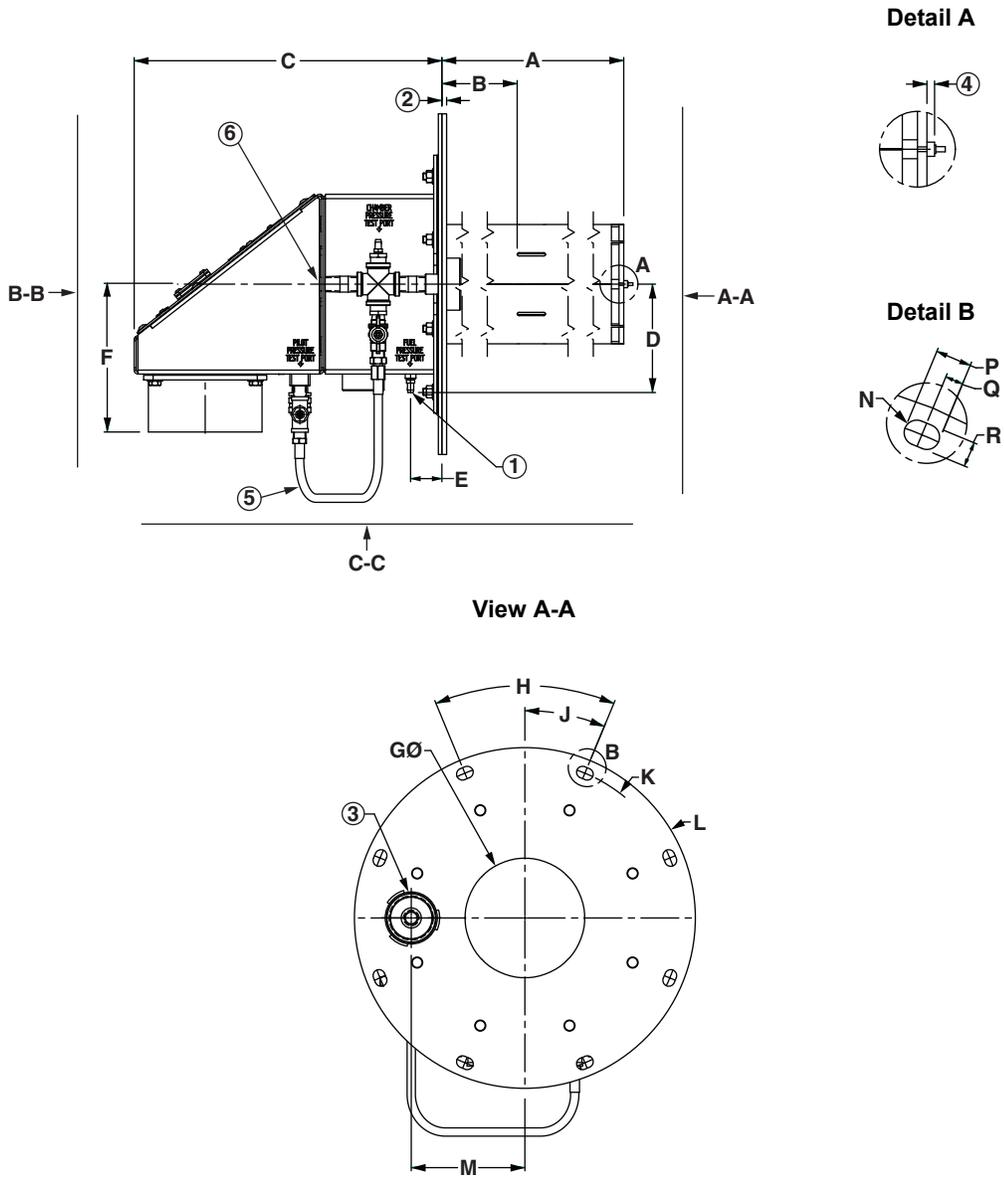
- 1) Observation window
- 2) Chamber pressure test port
- 3) Scanner cooling air valve
- 4) 1/2" NPT S-O ignition wire connection
- 5) 3/8" NPT pilot gas connection
- 6) Pilot gas pressure test port
- 7) 1" NPT scanner port
- 8) 2" NPT main gas inlet
- 9) Combustion air pressure test port



Dimensions in mm unless stated otherwise									
Burner size	A	B	C	D	E	F	G	H	J
XPO 4 PB	247	196	85	82	209	448	769	1125	209
XPO 5 PB									

Burner size	K	L	M	N	P	Q	R	S	T
XPO 4 PB	59	33	170	25	139	85	5	149	251
XPO 5 PB									

XPO™ 3 EB (external blower) burner



- 1) Gas pressure test port
- 2) 6 mm optional oven wall gasket
- 3) 2" NPT scanner port coupling
- 4) .15" ± .050 ceramic
- 5) Scanner cooling air flex line
- 6) 1" NPT scanner port

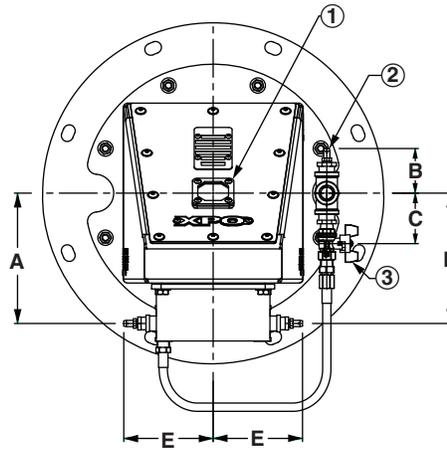
Dimensions in mm unless stated otherwise								
Burner size	A	B	C	D	E	F	G Ø	H
XPO 3 EB 2	591	259	412	145	42	200	160	45°
XPO 3 EB 4	1146	810						

Burner size	J	K	L	M	N	P	Q	R
XPO 3 EB 2	22.5°	420	457	152	8	23	11	16
XPO 3 EB 4								

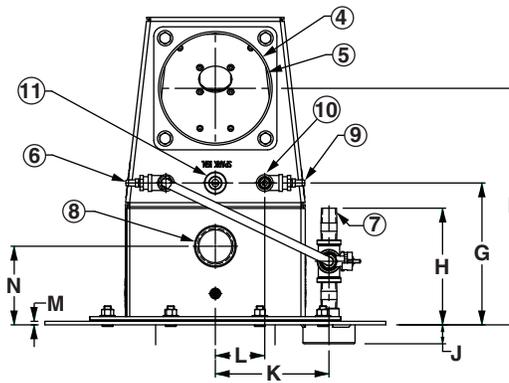
XPO™ 3 EB (external blower) burner

- 1) Observation window
- 2) Chamber pressure test port
- 3) Scanner cooling air valve
- 4) Ø 152 mm outside combustion air inlet
- 5) Ø 147 mm inside combustion air inlet
- 6) Combustion air pressure test port
- 7) 1" NPT scanner port
- 8) Main gas inlet 1-1/2" NPT
- 9) Pilot gas pressure test port
- 10) 3/8" NPT pilot gas connection
- 11) 1/2" NPT S-O ignition wire connector

View B-B



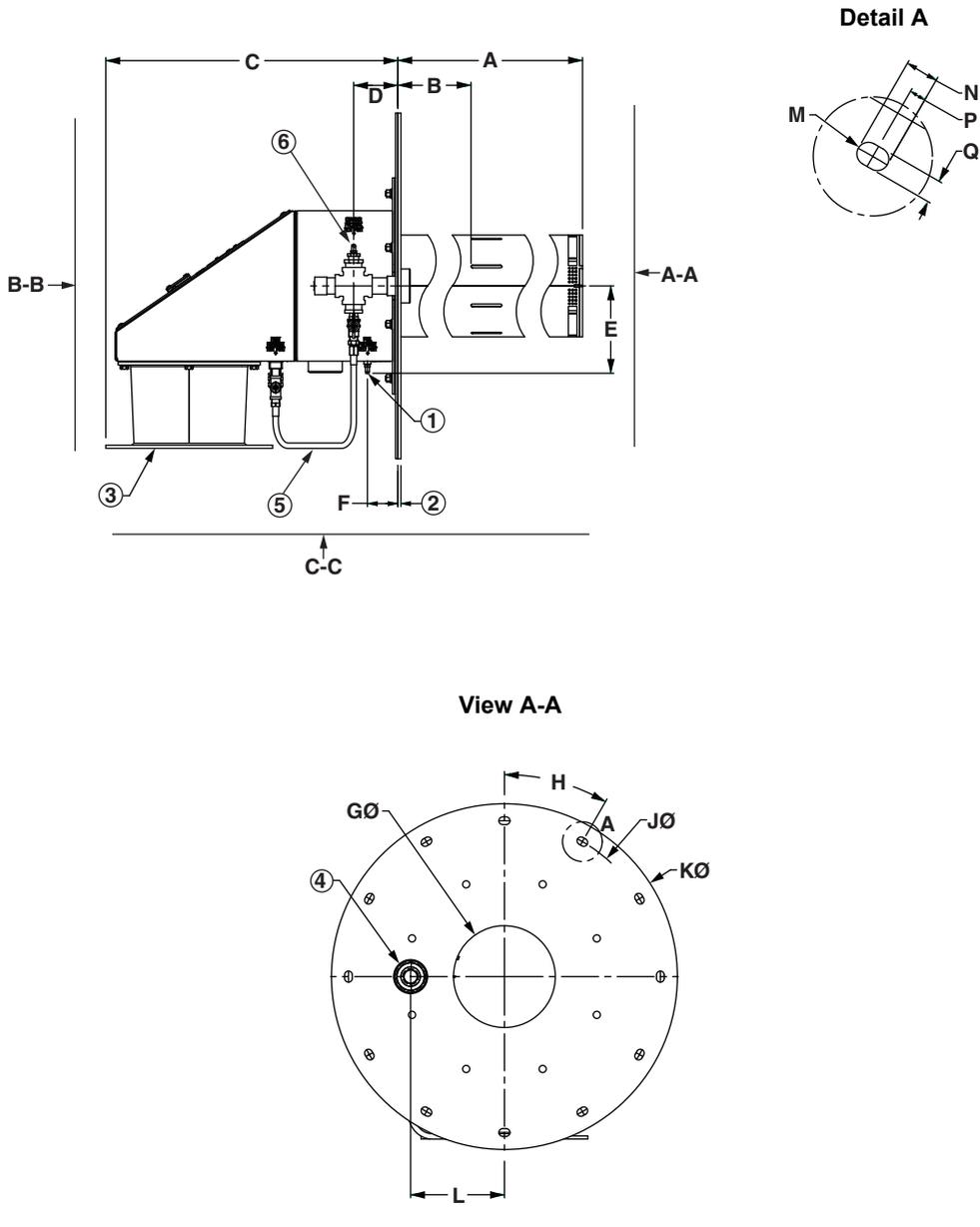
View C-C



Dimensions in mm unless stated otherwise							
Burner size	A	B	C	D	E	F	G
XPO 3 EB 2	175	60	68	175	120	318	190
XPO 3 EB 4							

Burner size	H	J	K	L	M	N
XPO 3 EB 2	156	25	152	66	5	105
XPO 3 EB 4						

XPO™ 5 EB (external blower) burner



- 1) Gas pressure test port
- 2) 6 mm optional oven wall gasket
- 3) Combustion air inlet
- 4) 2" NPT scanner port coupling
- 5) Scanner cooling air flex line
- 6) Chamber pressure test port

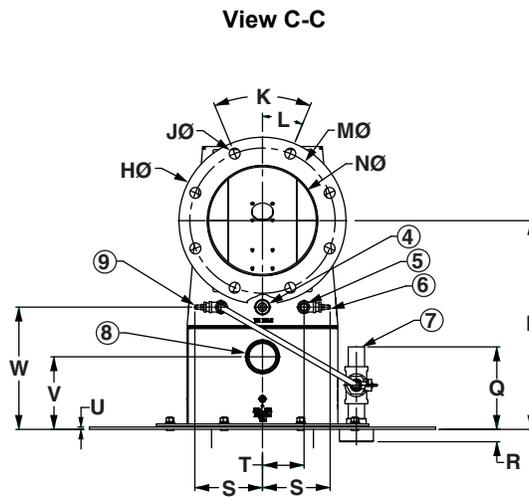
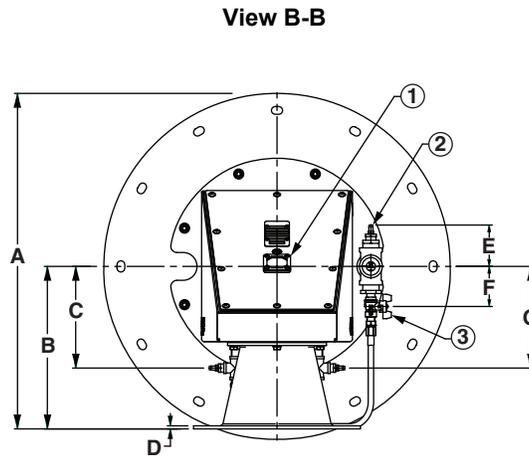
Dimensions in mm unless stated otherwise

Burner size	A	B	C	D	E	F	G Ø	H
XPO 5 EB	1096	737	600	91	180	62	209	30°

Burner size	J Ø	K Ø	L	M	N	P	Q
XPO 5 EB	641	711	193	8	23	11	16

XPO™ 5 EB (external blower) burner

- 1) Observation window
- 2) Chamber pressure test port
- 3) Scanner cooling air valve
- 4) 1/2" NPT S-O ignition wire connector
- 5) 3/8" NPT pilot gas connection
- 6) Pilot gas pressure test port
- 7) 1" NPT scanner port
- 8) Main gas inlet 2" NPT
- 9) Combustion air pressure test port

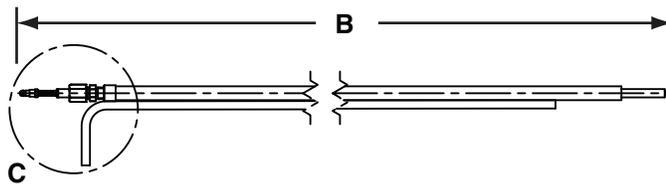


Dimensions in mm unless stated otherwise											
Burner size	A	B	C	D	E	F	G	H Ø	J Ø	K	L
XPO 5 EB	690	334	209	6	85	82	209	343	22	45°	22.5°

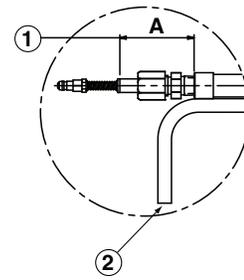
Burner size	M Ø	N Ø	P	Q	R	S	T	U	V	W
XPO 5 EB	298	221	429	170	25	139	85	5	149	251

Spark ignitor pilot tube assembly for sizes XPO 1, 2 and 3

- 1) Spark ignitor set-up dimension
- 2) 3/8" pilot gas tubing



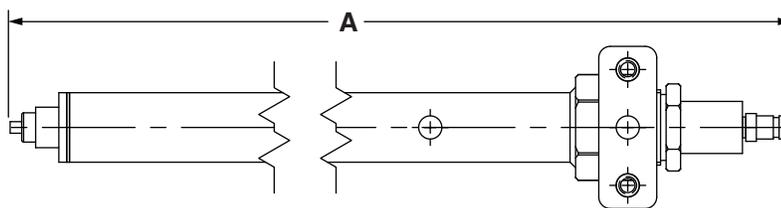
Detail C



Dimensions in mm unless stated otherwise		
Burner size	A	B
XPO 1 PB 2	52	866
XPO 2 PB 2		
XPO 3 PB 2		
XPO 3 EB 2		
XPO 1 PB 4	52	1422
XPO 2 PB 4		
XPO 3 PB 4		
XPO 3 EB 4		

Note: Valid for burners shipped prior to 8/12/2012.

Spark ignitor for sizes XPO 1, 2, 3, 4 & 5



Dimensions in mm unless stated otherwise	
Burner size	A
XPO 1 PB 2	818
XPO 2 PB 2	
XPO 3 PB 2	
XPO 3 EB 2	
XPO 1 PB 4	1375
XPO 2 PB 4	
XPO 3 PB 4	
XPO 3 EB 4	
XPO 4 PB 4	
XPO 5 PB 4	
XPO 5 EB 4	

Installation and operating instructions for XPO™ burners

Application requirements

View port

A view port to observe burner flame is helpful to inspect flame aspect. Locate the view port downstream of the flame, looking back to the burner. Make sure the complete flame can be evaluated.

Support burner air and gas piping

The XPO™ burner shall not be used as support for the piping to the burner. Gas and air piping shall be supported in such a way that no additional loads will be created on the burner.

Burner mounting flange loads

Check burner weight and reinforce burner mounting flange or combustion chamber/furnace back wall if necessary to take complete burner weight.

Installation instructions

Storage of XPO™ burners

XPO™ burners shall be stored dry (inside).

Handling of XPO™ burners

Handle burners with care during unpacking, transport, lifting and installation. Use proper equipment. Any impact on the burner could result in damage.

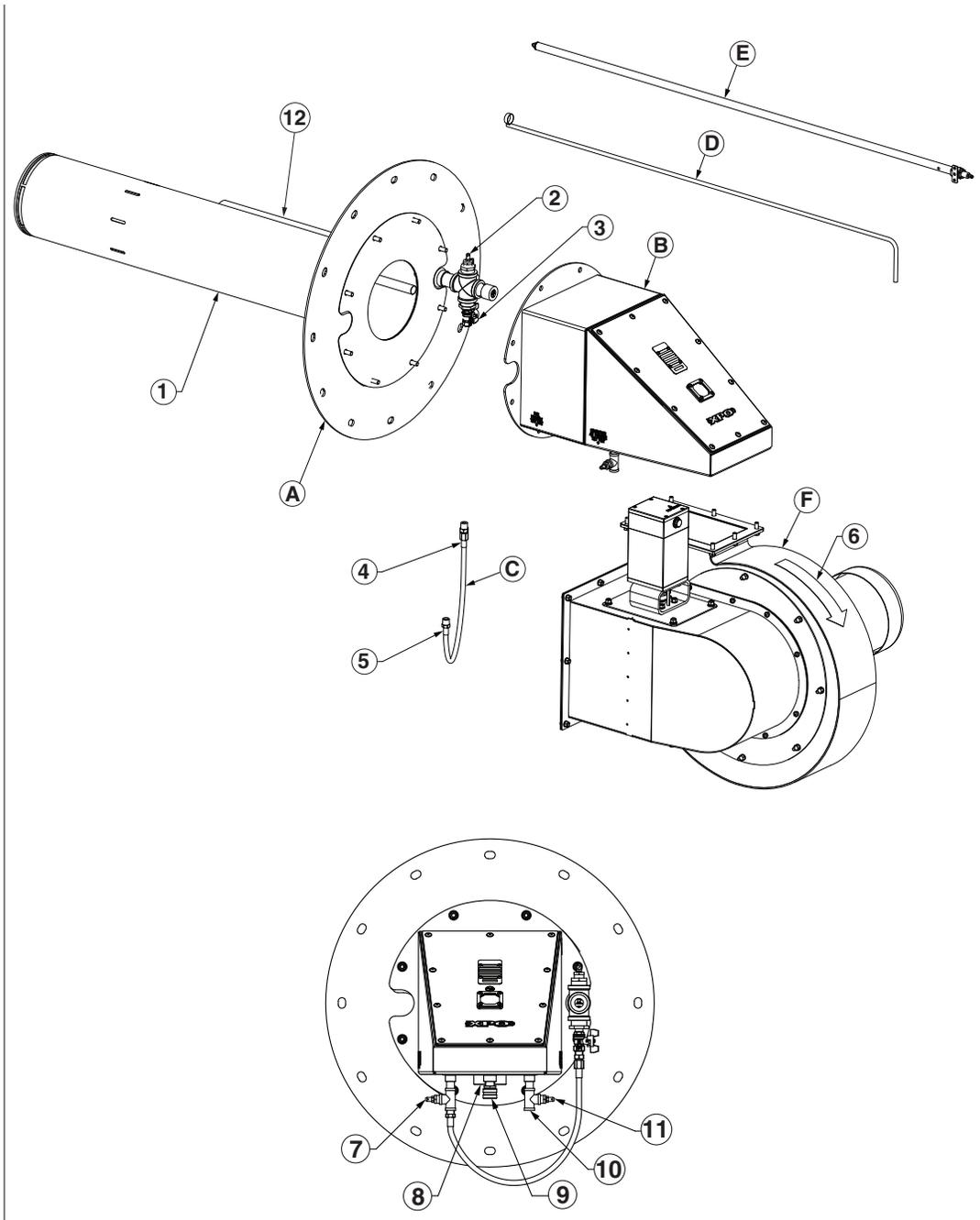
Packaged burners will be shipped with blowers, blast tubes and fuel valves removed. Burner requires assembly prior to installation.

The following components will be included in the shipping carton:

- Housing and manifold assembly
- Blower and air valve assembly (packaged versions only)
- Fuel valve assembly
- Blast tube assembly
- Scanner cooling air flex hose

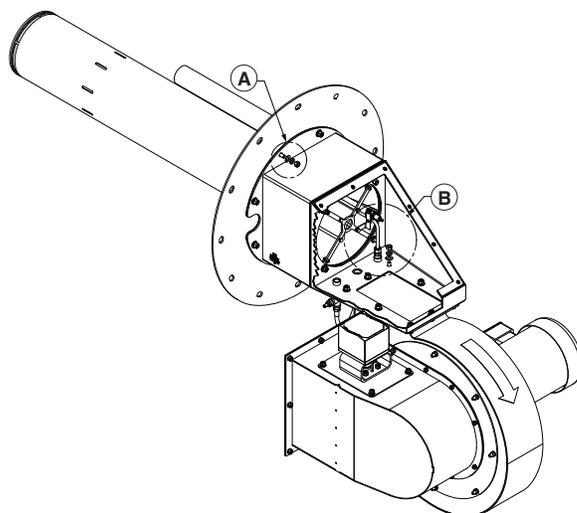
Assemble burner components using the diagrams on the following pages as a guide.

- 1) Blast tube (insulation not shown)
- 2) Chamber pressure test connection
- 3) Scanner cooling air valve
- 4) Attach swivel end of flex hose to scanner cooling air valve
- 5) Attach fixed end of flex hose to combustion air pressure connection
- 6) Impeller rotation
- 7) Combustion air test connection
- 8) Main fuel inlet
- 9) Ignition wire S-O cord connector
- 10) Pilot gas inlet
- 11) Pilot gas test connection
- 12) Customer-supplied scanner tube

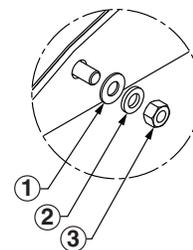


- Insulate and install blast tube assembly (A) according to catalog instructions.
- Attach housing and manifold assembly (B) to blast tube assembly (A).
- Pipe fuel line and control valve to burner assembly.
- Pipe pilot gas line and connect ignition wire to manifold assembly (B).
- Connect cooling air flex hose (C) from housing (B) to blast tube's scanner cooling air valve.
- Attach blower and air valve assembly (F) for packaged burners or EB adapter for external blower.
- Install ignitor (E) and pilot gas line (D) according to the instructions on the following page.

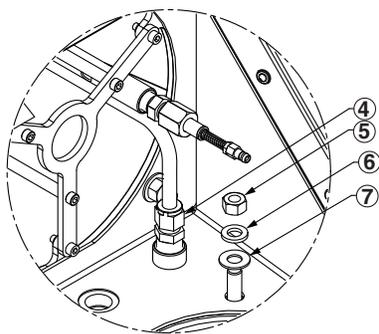
- 1) 3/8" flat washer
- 2) 3/8" split lock washer
- 3) 3/8" -16 nut
- 4) Pilot gas tube nut
- 5) 3/8" -16 nut
- 6) 3/8" split lock washer
- 7) 3/8" flat washer
- 8) Pilot gas tubing
- 9) Ignitor
- 10) Two 10-24 ignitor screws
- 11) Spark ignitor bracket
- 12) 10-24 socket head cap screw



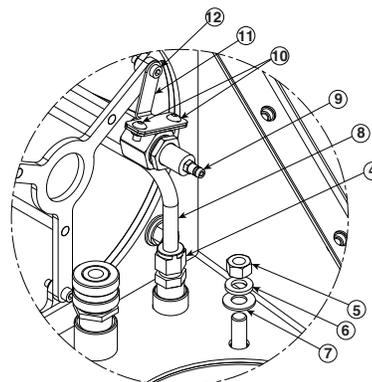
Detail A



Detail B1



Detail B2



Detail B1 - For Sizes XPO 1-3 (Shipped prior to 8/12/2012):

- Insert spark ignitor into blast tube's ignitor tube. (Mixing disc and tripod assembly inside manifold may need to be rotated for clearance.)
- Connect pilot tube to manifold.
- Confirm spark ignitor set-up dimension as shown in catalog literature.
- Tighten all hardware, noting that O-ring must be present between nut and ceramic and the spark ignitor nut needs only be hand tight plus 1/4 turn to prevent cracking ceramic.
- Connect ignition wire to spark ignitor.

Detail B2 - For Sizes XPO 1-3 (Shipped after 8/12/2012) and XPO 4 & 5:

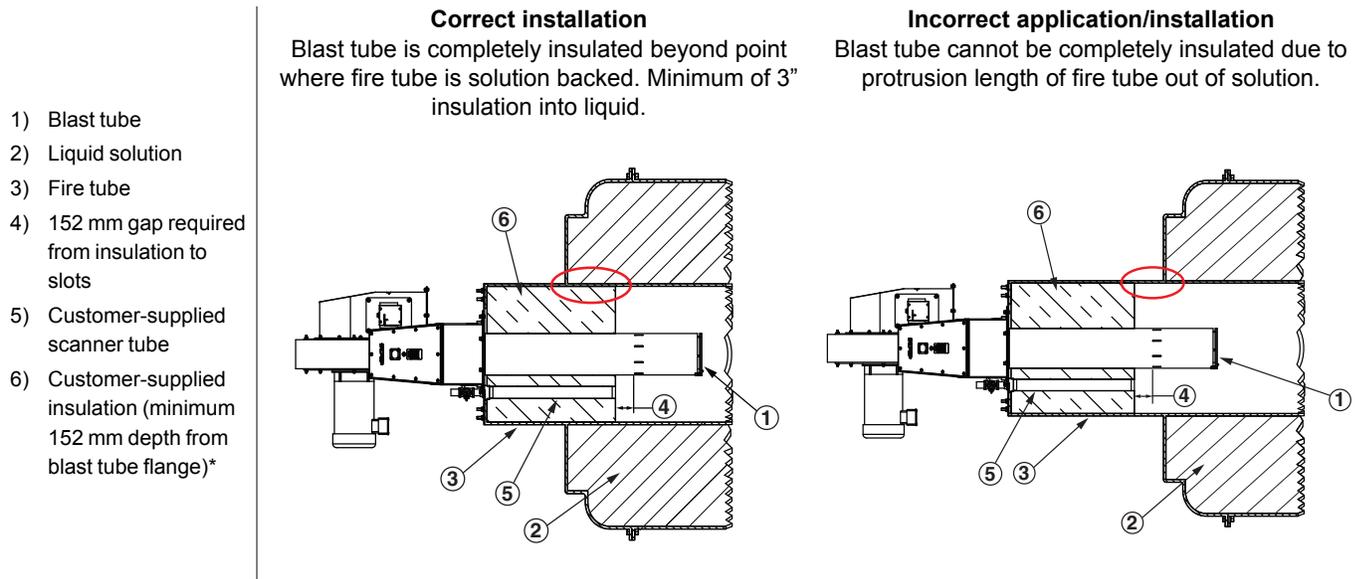
- Remove acorn nut from mixing disc portion of manifold assembly.
- Slide pilot gas tube ring over blast tube's ignitor tube.
- Connect pilot tubing to manifold.
- Insert spark ignitor into blast tube ignitor tube and shoulder spark ignitor into blast tube disc.
- Attach spark ignitor bracket using acorn nut previously removed.
- Tighten the two ignitor bracket screws.
- Tighten all hardware.
- Connect ignition wire to spark ignitor.

Flange the burner to the installation

Bolt the burner to the installation's burner mounting flange. Use proper gasketing. Tighten the flange bolting with correct torque. Retighten all bolts after first firing and regularly after commissioning.

All non-liquid cooled surfaces must be insulated as shown in burner mounting diagram. **Area(s) between fire tube wall and outside of burner blast tube must be completely filled with insulation as shown below.** Customer-supplied scanner tube must not extend beyond the blast tube insulation.

Burner mounting



*Recommended insulation properties: minimum density of 16 kg/m³ or greater with minimum thermal conductivity of 12 W/m.K at 980°C.

Follow all applicable codes including regional codes, local directives, standards and recommendations of your insurance carrier when designing and installing XPO™ burners. Installation should only be undertaken by qualified gas contractors licensed for any regional or local requirements.

Piping weight should be independently supported. Do not use the burner as a piping support or hang weight from the burner's flange connections.

XPO™ burners should be used in liquid backed applications. All non-liquid cooled surfaces must be insulated as shown above.

Both packaged (PB) and external blower (EB) versions include two different choices for blast tube length. A 610 mm or 1220 mm long blast tube is available. Blast tube length should be selected based on the wall penetration depth or non-liquid cooled portion of fire tube.

Start-up instructions for XPO™ burners

Instructions provided by the company or individual responsible for the manufacture and/or overall installation of a complete system incorporating MAXON burners take precedence over the installation and operating instructions provided by MAXON. If any of the instructions provided by MAXON are in conflict with local codes or regulations, please contact MAXON before initial start-up of equipment.



Read the combustion system manual carefully before initiating the start-up and adjustment procedure. Verify that all of the equipment associated with and necessary to the safe operation of the burner system has been installed correctly, that all pre-commissioning checks have been carried out successfully and that all safety-related aspects of the installation are properly addressed.

Initial adjustment and light-off should be undertaken only by a trained commissioning engineer.

Do not operate the burner without the burner cover and observation window securely attached and sealed to the burner air housing.

Checks during and after start-up

During and after start-up, check the integrity of the system. Check all bolted connections after first firing (first time on temperature) and retighten if necessary.

Pilot ignition

Before ignition of the pilot, adjust the combustion air to the minimum burner air flow. Pilot will not ignite if too high an air flow exists. Set pilot gas flow to the correct value before pilot ignition attempt.

Main burner ignition

Set correct gas flow for burner minimum capacity before attempt of main burner ignition. After ignition of main burner, allow some time on minimum capacity to allow the burner parts to heat up slowly.

Adjust air/gas ratio, set maximum capacity

Once the main flame is ignited, adjust air/gas ratio of the burner to have the required combustion quality and slowly increase capacity. Do not increase capacity too fast to avoid damage to burner parts or furnace due to excessive temperature gradient. Stack O₂ should be used to do final set-up of air/fuel ratio.

Maintenance and inspection instructions

Safety requirements

Regular inspection, testing and recalibration of combustion equipment according to the installation manual is an integral part of its safety. Inspection activities and frequencies shall be carried out as specified in the installation manual.

Visual inspections

Regular visual inspection of all connections (air and gas piping to the burner, bolting of the burner to the furnace) and burner flame size and aspect are essential.

Spare parts

Keep local stock of spark ignitor. It is not recommended to keep local stock of other burner parts. Consult installation manual for burner spare parts and system accessories.