ASSEMBLY INSTRUCTIONS
## OVEN PARTS LIST

<table>
<thead>
<tr>
<th>Part Description</th>
<th>Modèle 66</th>
<th>Modèle 66x99</th>
<th>Modèle 83</th>
<th>Modèle 100</th>
</tr>
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<tbody>
<tr>
<td><strong>Basic Formula</strong></td>
<td></td>
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<tr>
<td>Refractory terracotta tiles 33x33x6cm – white color</td>
<td>9</td>
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<td>Oven-entry</td>
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<td>Pillar</td>
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<td>Pediment</td>
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<td>Conical voussoir</td>
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<td>Small voussoir</td>
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<tr>
<td>Straight voussoir</td>
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<td>Keystone</td>
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<td>1</td>
<td>8 in 2 parts</td>
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<tr>
<td>Smoke adaptor Ø180 mm + Hardware</td>
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<td>Refractory mortar for the oven dome - bags 25kg</td>
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<tr>
<td>Grog to place under the tiles - bags 25kg</td>
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<td>Metal pins to fix the iron wire around the oven dome</td>
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<td>Insulated door</td>
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<td>Oven peel</td>
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<td>Assembly instructions</td>
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<td><strong>Complete Formula Grog</strong></td>
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<tr>
<td>Basic Formula</td>
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<tr>
<td>+ Grog to insulate the oven dome - bags 25kg</td>
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<td>17</td>
<td>18</td>
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<td>+ essential accessories kit</td>
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<td>1</td>
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<tr>
<td>(1 laser thermometer + 1 brush + 1 scraper + 1 wood peel)</td>
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<tr>
<td><strong>Complete Formula Blanket</strong></td>
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<tr>
<td>Basic Formula</td>
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</tr>
<tr>
<td>+ Refractory Insulating Blanket - roll 3m² - thickness 38mm</td>
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<td>1</td>
<td>1</td>
<td>2</td>
</tr>
<tr>
<td>+ essential accessories kit</td>
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<td>1</td>
<td>1</td>
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</tbody>
</table>
TOOLS

• Spirit level
• Tape mesure
• Spatula
• Trowel
• Rubber Mallet
• Jack
• Wood specer
• Iron wire
• Drill
• Gloves
Le Panyol ovens are made **exclusively** of Refractory White Earth, a 100% natural clay from our own quarry.

As the material is irregular by nature and the production methods are based partly on craft skills, you may find that there are gaps between the parts when it comes to assembling them. These will be filled in when you apply the refractory mortar.

These gaps allow the oven to expand.

The keystone may be slightly higher or lower than the dome of the oven.

The edges of the parts may crumble slightly if they are handled repeatedly.

**THESE DIFFERENCES WILL IN NO WAY IMPAIR THE OPERATION OF YOUR OVEN OR SHORTEN ITS LIFE**

The oven must be built under cover.
1. Choose a site for the oven

2. Build a base on which to sit the oven

3. Insulate the base

4. Assemble the oven floor – see also the video

5. Assemble the oven dome - see also the video

6. Apply the mortar

7. Insulate the oven dome

8. Connect the oven to a chimney pipe

9. Surround / decorate the oven
STEP 1 : Choosing a site

Before you start to assemble the oven, you’ll need to decide where you’re going to place it and work out exactly how much space you’ll need to install it. Check in particular that the floor can bear the weight of the finished oven (base + oven + insulation + surround + roof). The floor must be flat and should not subside under the weight of the construction.

The oven may be installed indoors or outdoors, stand-alone or incorporated into an existing building, near the pool, under a veranda or in the kitchen. A wide range of installations are possible. See our “Gallery” page on our website or ask the retailer in your region.

Outdoor Installation
The Le Panyol oven must be protected against bad weather by a roof wide enough to prevent the oven and hearth tiles from getting wet. It must be kept dry in winter as, if it absorbs water, frost would make it unusable. If the oven is stand-alone, the pipe must be approximately 1m long. However, if the oven is backed on to a wall or built into the home, the pipe must be long enough to go 40cm beyond the roof ridge (in accordance with DTU standard 24.1).

Indoor Installation
The Le Panyol oven must be connected to an existing or future-build chimney pipe, in accordance with DTU standard 24.1 (Unified Technical Document). Do not connect more than one apparatus to the same chimney pipe. The pipe should be:

• 180 mm in diameter (the stainless steel smoke adaptor supplied with the oven is 180mm in diameter)
• Made up of a maximum of 2 x 45° bends
• Removable
• With a double skin if an indoor installation

To prevent moisture and rainwater from getting into the pipe, you’ll need to fit a rain cap on the top of the stack.
STEP 1 : Choose the final shape of the oven

There are 2 kinds of shape for the oven: cubic and rounded. In terms of the shape, the insulation materials and the size of the base are different. For a rounded shape, there’s no need to build a surrounding wall and therefore the size of the base is smaller.

**Cubic shape**

**Rounded shape**
STEP 2 : Building a base to support the oven

**Foreword :**
Before building the base, it is important to define the **oven floor height** (where the fire will be laid and the cooking done). This height defines the pillars’ height of the base.
The oven floor is generally between 100 and 120 cm high, depending on the user’s height and comfort requirements.
To calculate the pillars’ height, subtract 24 cm to the oven floor height :
  * the oven tiles : 6 cm thick
  * the grog insulation under the oven tiles (included with the oven) : 3 cm thick
  * The insulating plates (not provided with the oven) : 5 cm thick
  * Reinforced concrete slab: 10 cm thick

Example : you want an oven floor height equal to 118 cm; then the pillars’ height will be equal to 118-24=94 cm

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**Dimensions of the base for a cubic shape**

**Dimensions of the base for a rounded shape**
STEP 2 : Building a base to support the oven

**Build :**
- 3 breeze-block pillars 20 cm thick
- 1 reinforced concrete slab 10 cm thick
- 1 level (14 cm) of surrounding wall on the 3 sides using Siporex-type insulation blocks 10 cm thick if cubic shape and 5 cm thick if rounded shape. This wall will stem the grog under the floor tile.

**Base width and depth**

The dimensions include:
- Dimensions of the oven
- Thickness of the insulation
- Thickness of the surrounding wall
- Surround : rendering (i.e. a few millimeters thick)

*If the surround material is much thicker (bricks, stones,), you must add this thickness to the above dimensions*

**Warning:**
These dimensions are minimum for a simple standard installation.
These dimensions are calculated with specific materials.
If you make any changes, you will have to calculate the dimensions of your base in terms of your choices.
STEP 3 : Insulating the base

Warning :
The photos are matching the model 83. For the model 66 there are only 9 tiles but the process is exactly the same.

1/ Insulate the reinforced concrete slab using dry Siporex-type insulation blocks 5 cm thick. Do not seal.

2/ Draw a line at 21 cm from the edge of the base and place siporex block 3 cm thick in order to contain the grog. Cut properly because the tiles will be put on these blocks.

Pour out one bag of grog.
First, spread with the trowel to get an homogeneous bed of grog.
Check that the thickness is between 2 and 3 cm. Level.
STEP 4 : Assembling the oven floor

The tiles must be laid against each other without sealing. Handle gently.
Draw the axis of the base and place the first tile to the right of this axis.
Warning : there is a way for the tiles. SMooth side on front and back, ROUGH side on left and right.

Check that the tile is laid flat.
If necessary, even out the differences in thickness of the tiles by placing a bit more or less grog where required.
Place the second tile to the left of the axis.
STEP 4 : Assembling the oven floor

Finish the first row. Then place the other tiles on the same process.

Once all the tiles are placed, check the level with your hand. Check that the oven floor is as flat as possible to avoid the pizza peel bumps during charging.
STEP 5 : Assembling the oven dome

Warning :
The following photos are matching the model 83. For the model 66, there are no straight (non conical) voussoirs. But the process is exactly the same. Take conical voussoirs instead of straight voussoirs.
In the same way, the shape of the key stone is not the same, but the assembly instructions are not changing.

Consult the video
Phase 1: Placing the oven entry

Centre the oven entry on the floor tiles.
Two persons are required to place this piece.
Lift it slightly rather slither it in order not to damage it.
Phase 2: Placing the first two “voussoirs” (arch stones)

Place a straight voussoir (non conical) on each side of the oven entry
Wedge the 2 voussoirs in position.

Firstly, adjust their inner faces to that of the oven entry.
It is possible that we move a little bit these voussoirs later in the assembling.
Phase 3 : Placing the keystone

Place the jack and the wood specers in the center of the oven floor and aligned with the axis. These wood specers will facilitate the withdrawal of the jack when the dome will be assembled. We will refine the position of the jack in next steps. Check that the total height of the jack is 34 cm.

Position the keystone on the jack.
Phase 4: Place the 4 small voussoirs

Place the small voussoirs on the oven entry.
These 4 pieces help you to define the good position of the keystone, that is to say the good distance between the oven entry and the keystone.
If there is too much gap between the 4 small voussoirs and if they go past the entry, it means that you have to move back the keystone. Do this:
- Remove the keystone of the jack.
- Push a little bit the 2 straight voussoirs inside the oven and push back the 4 small voussoirs so that they go past the entry no more.
- Replace the keystone on the jack. Level.
Phase 5: Place the last voussoirs

Place 2 other straight voussoirs (non conical) on the opposite side of the keystone. Match the axis of the voussoirs with the axis of the keystone.

Inside the oven, the bottom of the voussoirs must match with the bottom of the keystone. Check regularly the keystone with the spirit level.

Divide uniformly the gaps between the voussoirs so that there is not 1 cm on one side and no gap at all on the other side.
Phase 5: Place the last voussoirs

Position the conical voussoirs in the remaining spaces as below. Firstly, place them and in a second time you will do the adjustments.
Phase 6 : Final adjustment

Use a spatula. It permits to move the pieces easier by pushing or raising.

Divide uniformly the gaps between the pieces.
Check to have an harmonious oven inside. The voussoirs must be aligned on their bottom.
One people can check the inside and tell another one which piece to move.

Gaps between the voussoirs will be filled later with the mortar.

Circle the whole construction with metal wire (non included with the oven).

Remove the jack supporting the keystone and the wedges.
Phase 7 : Place the shelves boards

The shelves boards are placed at the front of the oven, extending out from the oven floor tiles and overhanging the base.

*On the photo, little wedges are used to place the shelves boards* 
**BUT, in reality, you have to do a mortar and seal the shelves on the base.**

Start with the middle shelf board (the 3 shelves boards are the same).
Mark the centre of a shelf board.
Align the centre with the centre line of the floor.
Maintain a very slight slope towards the front.

Place shelves boards 2 and 3 in the same way.
There’s no need to seal the shelves boards together.
Leave to dry for 24 hours.
Phase 8 : Placing the frontage

Place the 2 oven front pillars on the shelves boards and against the oven opening. Centre them (in relation to the centre line of the oven floor). Check that the oven door can be inserted easily and fits correctly against the oven opening.

The gaps between the different parts will be filled with mortar during the “Applying the mortar” stage.
Phase 9 : Placing the smoke adaptor

Place the smoke adaptor above the doorway, where there is a hole for evacuating smoke.

Slide the edge of the smoke adaptor under the small arch stones on the dome.

Make sure the smoke adaptor is facing the right way!
*The inclined face should be on the dome side (so that it hugs the rounded shape)*

Mark the holes with a pencil for drilling.

Remove the smoke adaptor and drill carefully (use an 8mm concrete bit without the ‘hammer’ mode)

Insert the plugs provided.

Reposition the smoke adaptor and tighten the screws.

Make sure that the edges are flat. The joint will become watertight when the mortar is applied.
Phase 10 : Placing the pediment

Centre the pediment in the space provided. Seal it in place with 2 to 3 mm of mortar. This stage must be carried out with care as the pediment will remain visible. Do not let the mortar run.
STEP 6 : Applying the mortar

The aim of applying the mortar is to consolidate the whole of the dry assembly and to fill the gaps. The mortar is hydraulic, so you’ll need to wet the dome regularly. 
*For the proportions, please refer to the instructions on the bag.*

**Phase 1 : Protect the oven dome**
Put cardboard inside the oven in case water or mortar passes between the pieces.

**Phase 2 : Fill in the spaces between the pieces**
Make a small amount of mortar with a somewhat compact texture to fill the spaces between the pieces. Start by wetting the area where you are going to apply the mortar. Trowel in all visible spaces 2 to 3 cm deep. Do not hesitate to wet regularly as soon as you see that the terracotta has absorbed the water.

**Phase 3 : Cover the entire dome**
Make a second mortar to cover the entire dome. Do not make the bag completely at once because the mortar dries very quickly. It is better to do it several times in small quantities. For this second mortar, make a texture a little more liquid. Pour the water little by little and take time to mix.
STEP 6 : Applying the mortar

Wet again the dome.
Pour the mortar over the dome and spread with a trowel over a minimum thickness of 1 cm.
Proceed like this until completely covering the dome.
Work quickly enough because the mortar dries quickly.
Finish around the smoke adaptor.

Phase 4 : Cleaning
If there are areas to clean, do it right away with a damp sponge,
before the mortar dries and stains.
Remove the cardboard from the oven.
Check that there are no smear; otherwise clean right away.

Phase 5 : Drying
Leave to dry for about 2 to 3 weeks.
The drying time varies according to where the oven is sited (indoors or outdoors),
the ambient temperature, the season, etc.
The main thing is that the mortar and the oven should be properly dry before adding the insulation.
STEP 7  : Insulating the dome

The insulation materials and the insulation techniques are different if the final shape of the oven is CUBIC or ROUNDED.

Read the next pages which concern you.

Before you fit any insulating materials, we recommend that you light a few small fires to remove any residual moisture, as this will be more difficult to get rid of once the oven is insulated.
Insulating the dome for a CUBIC oven shape

1/ Build the surrounding wall

Build the surrounding wall on the sides and back to a suitable height with siporex blocks 10 cm thick.

For the front: build a wall 7 cm thick around the doorway with a nick 25 x 3,5 cm to place the pediment. The doorway remains visible. Do not cover it.

Example of surrounding wall with bricks decoration
2/ Place the GROG
Once your flue chimney installed, shed the grog on the oven dome until it is no more visible. The number of provided bags has been studied to get a performing insulation. Advice: to prevent the grog from accumulating unnecessarily in the corners, build walls at each corner of the surrounding wall (see draw above).

To ensure that any residual moisture can be evacuated, the top of the oven should remain accessible through an access hatch.
Insulating the dome for a ROUNDED shape oven

1/ Place the blanket 38 mm
Recover the dome with refractory blanket (*Surperwool 1100°C kind*) « without humping ». Advice: cut triangles in the blanket.

2/ Place a chicken fence (non provided)
Recover with chicken fence / frame (same method as the blanket).
3/ Applying a refractory Mix: refractory cement + vermiculite + water (materials non provided)
Recover all with a refractory MIX very wet:
➢ Mix dry the refractory cement with vermiculite (1 dose cement for 3 doses vermiculite)
➢ Add water until you obtain a mix liquid enough for an applying with trowel.
Advice: make several little quantities because the mortar dries quickly
➢ Make with a trowel a coating about 2 cm thick and smooth

➢ Let the oven dry 1 week.
➢ Small fires are possible to help the drying process.
➢ When it is dry, recover the dome of your selected veneer (painting, tiles, terracotta mixing, roughcast, ...)
STEP 8 : The chimney pipe

In accordance with DTU standard 24.1 (Unified Technical Document), you must not connect more than one apparatus to the same chimney pipe.

The pipe should be:

• 180 mm in diameter (the stainless steel smoke adaptor supplied with the oven is 180mm in diameter)
• Made up of a maximum of 2 x 45° bends
• Removable
• **With a double skin if an indoor installation**

Chimney pipes, flues and connectors must be swept regularly.

We recommend that you contact a specialist in the profession (fireplace builder, heating engineer, sweep, etc.)
STEP 9 : Surround / decoration

You can use a wide range of materials to suit the style you’re looking for:
• Earthenware,
• Decorative stone
• Bricks,
• Rendering, etc.

They must be class M0 (French legislation which classifies materials according to their reaction to fire - M0 = non-combustible)

Stick the chosen material on the surrounding wall or insulated dome (if the rounded shape).

Consult the gallery on our website www.lepanyol.com