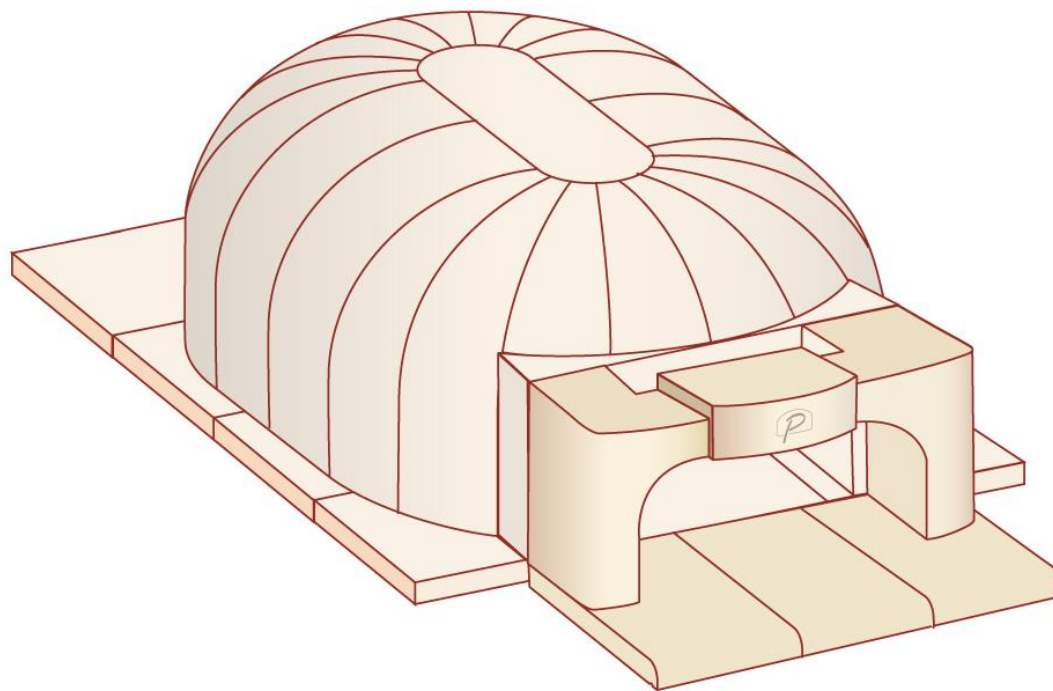


LIBERTE RANGE

Model 66x99

ASSEMBLY INSTRUCTIONS



OVEN PARTS LIST

	Modèle 66	Modèle 66x99	Modèle 83	Modèle 100
Basic Formula				
Refractory terracotta tiles 33x33x6cm – white color	9	12	16	20
Refractory terracotta tiles 33x16,5x6cm – white color	0	0	0	5
Refractory terracotta shleve board 36x21,3cm – stone color	3	3	3	3
Oven-entry	1	1	1	1
Pillar	2	2	2	2
Pediment	1	1	1	1
Conical voussoir	12	12	12	12
Small voussoir	4	4	4	4
Straight voussoir	0	4	4	8
Keystone	1	1	1	1 in 2 parts
Smoke adaptor Ø180 mm + Hardware	1	1	1	1
Refractory mortar for the oven dome - bags 25kg	2	2	2	3
Grog to place under the tiles - bags 25kg	2	2	3	4
Metal pins to fix the iron wire around the oven dome	2	2	2	2
Insulated door	1	1	1	1
Oven peel	1	1	1	1
Assembly instructions	1	1	1	1
Warranty	1	1	1	1
Complete Formula Grog				
Basic Formula				
+ Grog to insulate the oven dome - bags 25kg	13	20	20	24
+ essential accessories kit (1 laser thermometer+1 brush +1 scraper+1 wood peel)	1	1	1	1
+ Refractory Insulating Blanket - roll 3m ² - thickness 13mm	1	1	1	1
Complete Formula Blanket				
Basic Formula				
+ Refractory Insulating Blanket - roll 3m ² - thickness 38mm	1	1	1	2
+ essential accessories kit (1 laser thermometer+1 brush +1 scraper+1 wood peel)	1	1	1	1
+ Chicken fence roll	1	1	1	1
+ Vermiculite (100 litres bag)	1	2	2	2
+ Refractory cement (25kg Bag)	1	2	2	2

TOOLS

- Spirit level
- Tape measure
- Spatula
- Trowel
- Rubber Mallet
- Jack
- Wood spacer
- Iron wire
- Drill
- Gloves

FOREWORD

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.

THE KEY STAGES OF ASSEMBLY

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

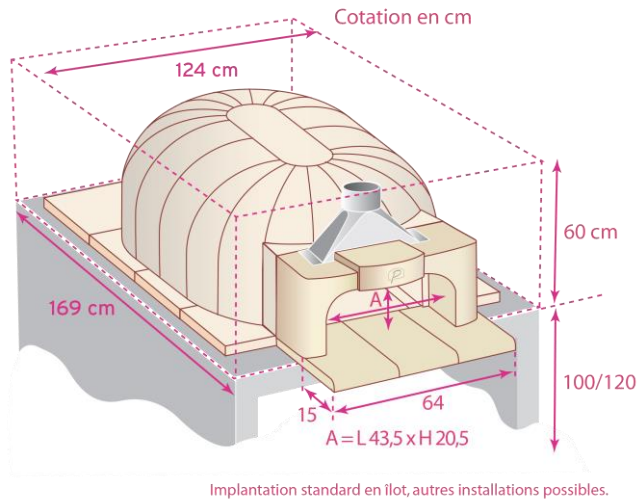
To prevent moisture and rainwater from getting into the pipe, you'll need to fit a rain cap on the top of the stack.

STEP 1 : Choose the final shape of the oven

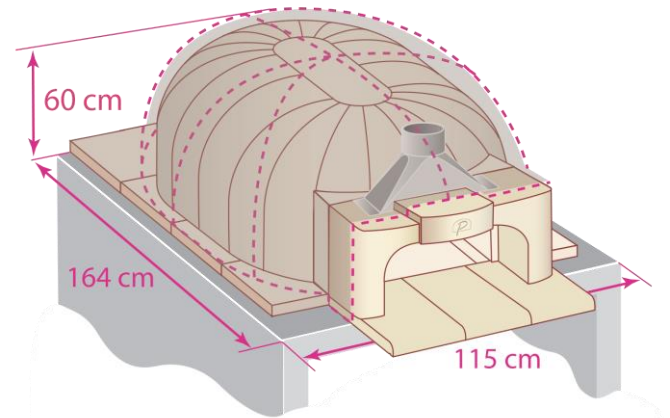
There are 2 kinds of shape for the oven : CUBIC and ROUNDED.

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.

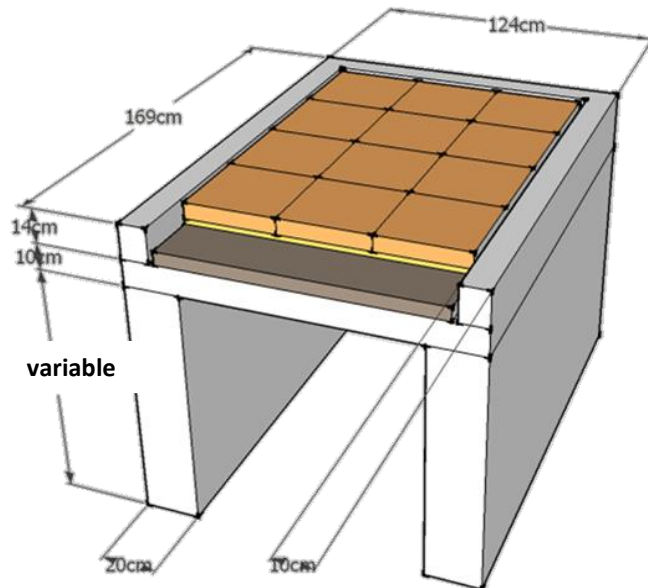
The oven floor is generally between 100 and 120 cm high, depending on the user's height and comfort requirements.

To calculate the pillars' height, subtract 24 cm to the oven floor height :

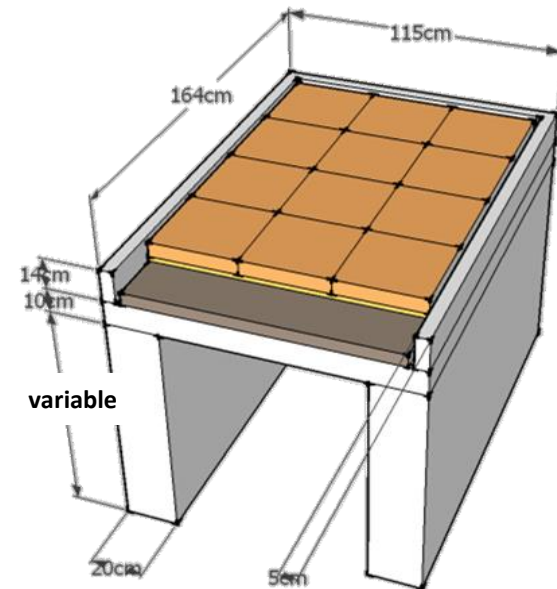
- the oven tiles : 6 cm thick
- the grog insulation under the oven tiles (included with the oven) : 3 cm thick
- The insulating plates (not provided with the oven) : 5 cm thick
- Reinforced concrete slab: 10 cm thick

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

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

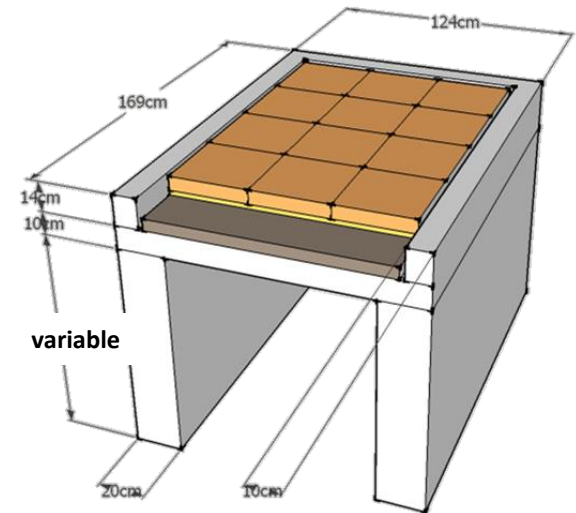
Warning:

These dimensions are minimum for a simple standard installation.

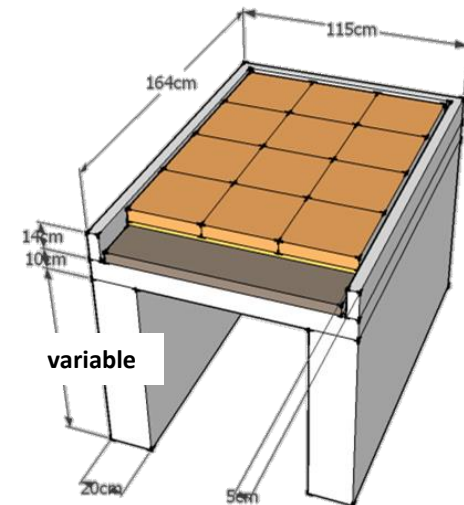
These dimensions are calculated with specific materials.

If you make any changes, you will have to calculate the dimensions of your base in terms of your choices.

Cubic shape



Rounded shape



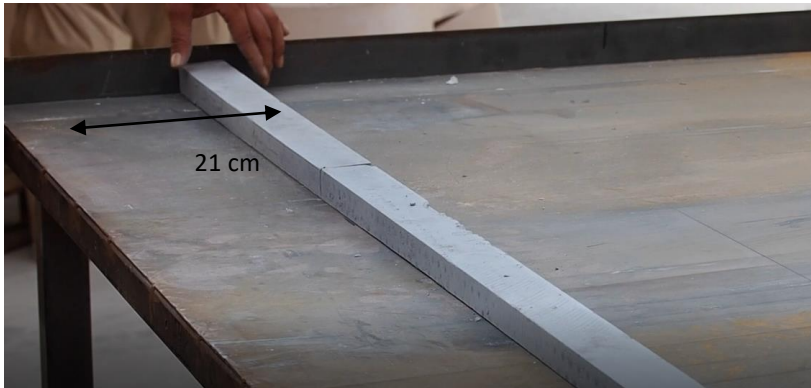
STEP 3 : Insulating the base

Warning : The photos are matching the model 83. For the model 66x99, there are only 3 tiles/row but the process is exactly the same.

Once you have built the base :

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 3 cm. Level.



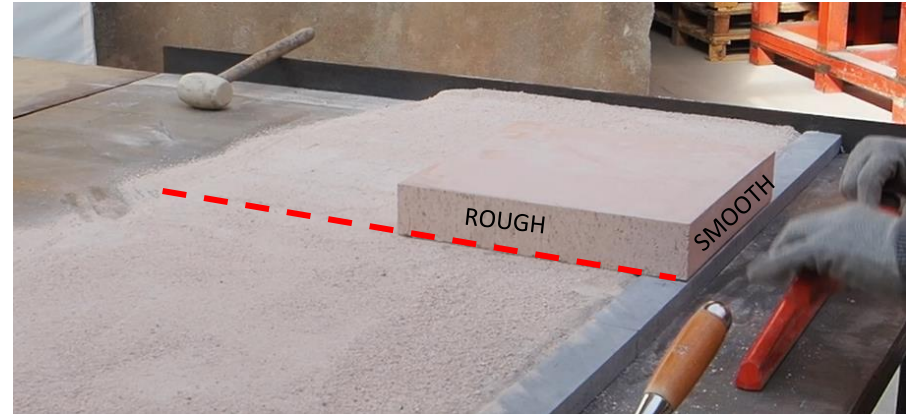
STEP 4 : Assembling the oven floor

Consult
the video

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.

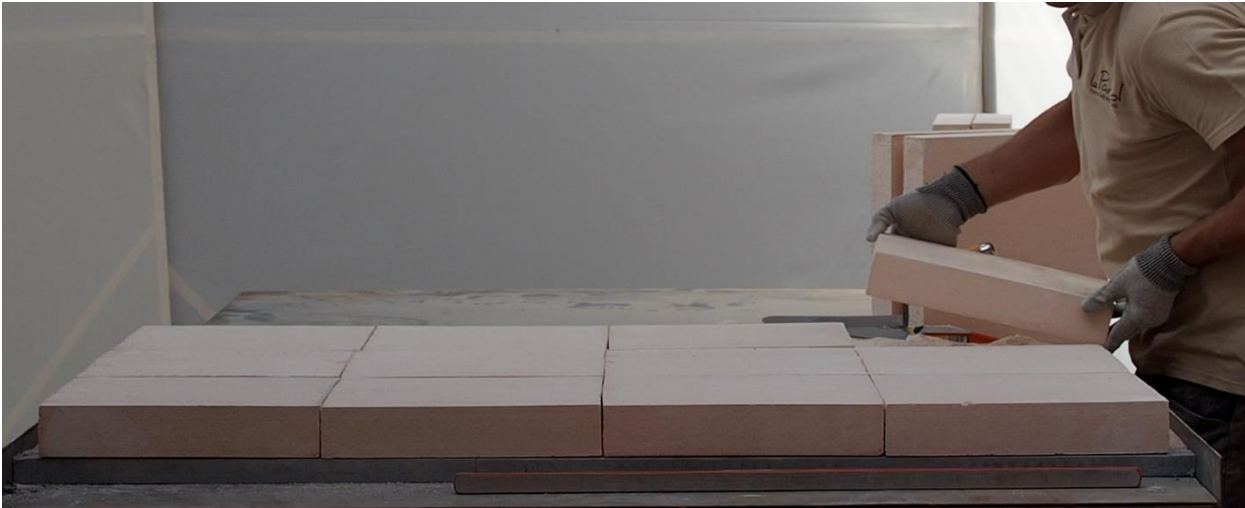
Place the second tile to the left of the axis.



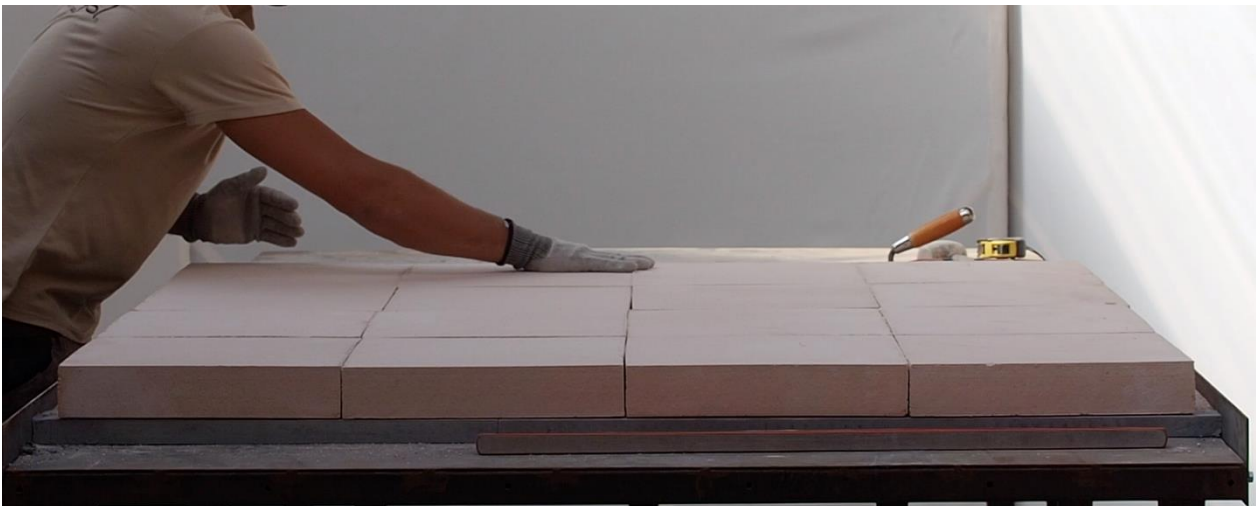
STEP 4 : Assembling the oven floor

Consult
the video

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

**Consult
the video**

Warning :

In this step, some photos are matching the model 83 and some others the model 66x99. The assembly instructions are still the same, the process is not changing.

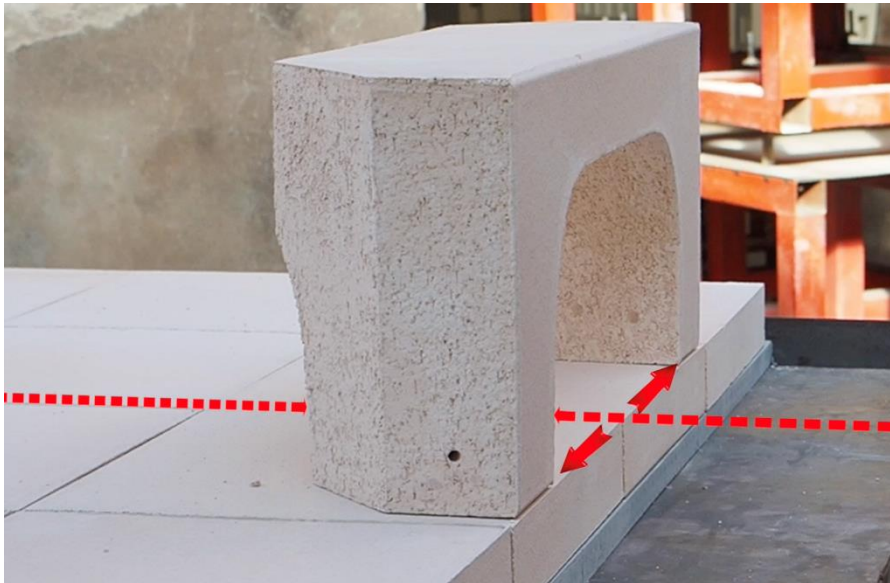
In the same way, the shape of the key stone is different but the process is the same.



Phase 1 : Placing the oven entry

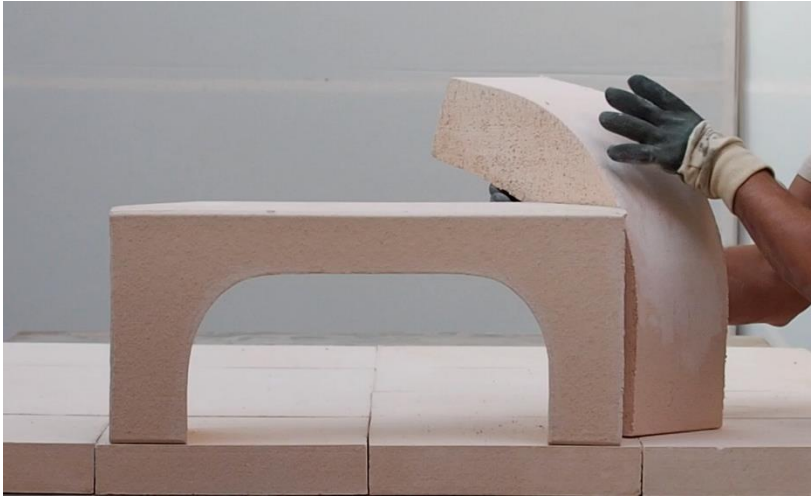
Consult
the video

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 conical voussoir on each side of the oven entry
Wedge the 2 voussoirs in position.



Firstly, adjust their inner faces to that of the oven entry.

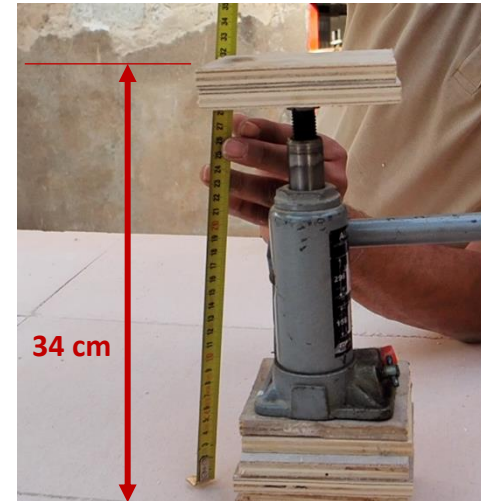
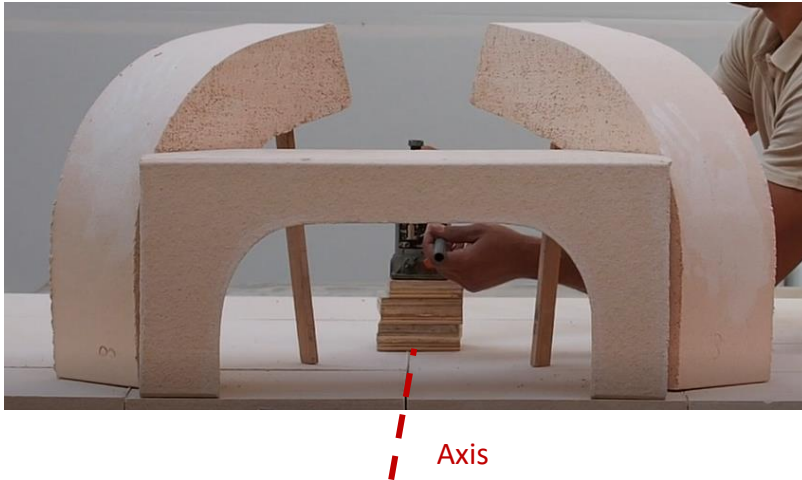
It is possible that we move a little bit these voussoirs later in the assembling.



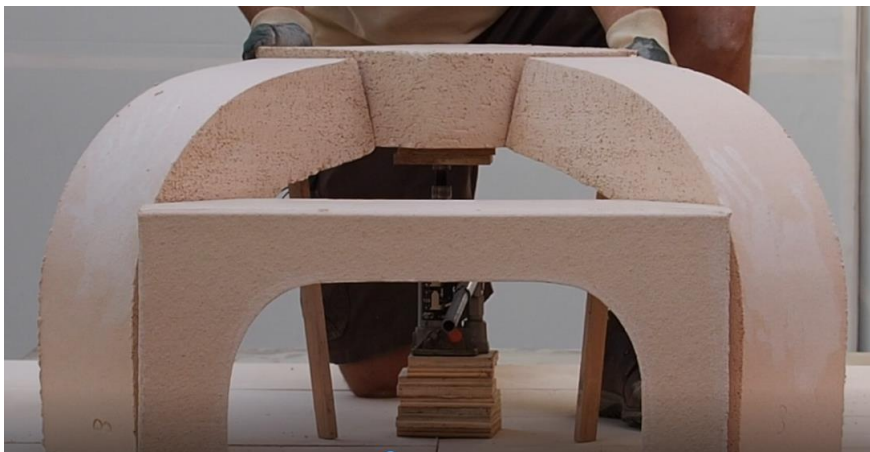
Phase 3 : Placing the keystone

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.



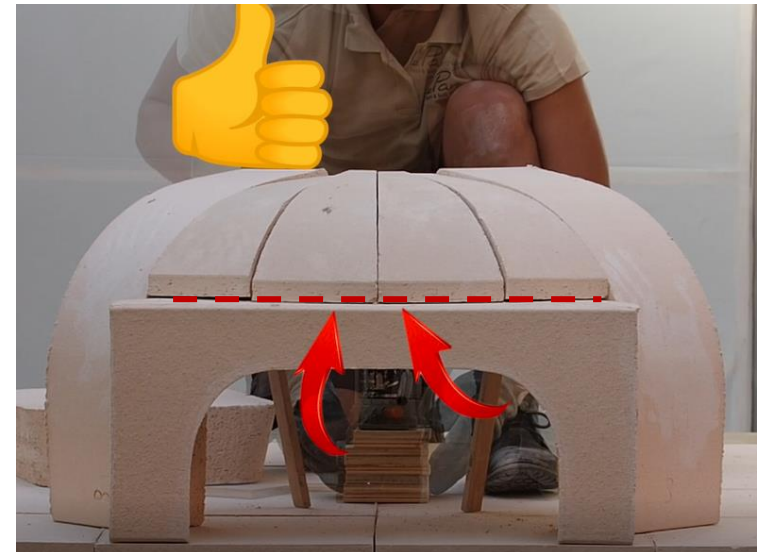
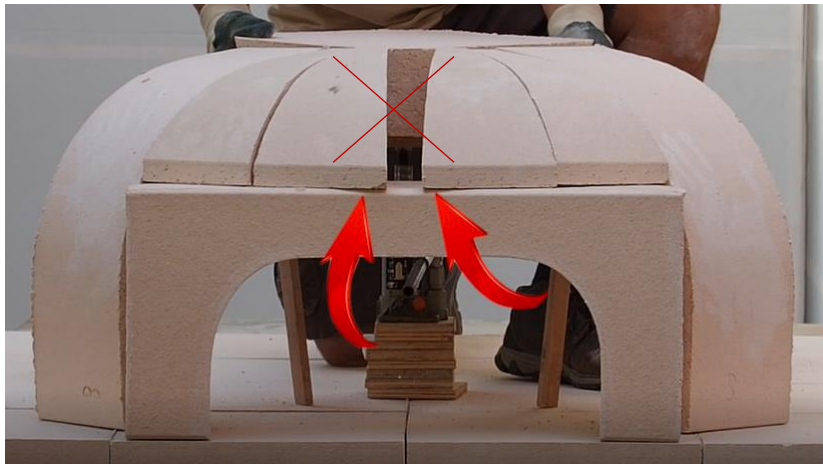
Phase 4 : Place the 4 small voussoirs

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 :

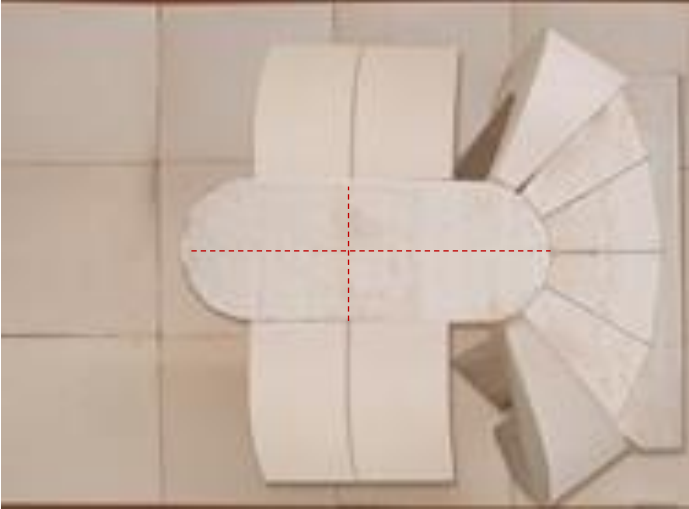
- Remove the keystone of the jack.
- Push a little bit the 2 straight voussoirs inside the oven and push back the 4 small voussoirs so that they go past the entry no more.
- Replace the keystone on the jack. Level.



Phase 5 : Place the 4 straight voussoirs

Consultez
la vidéo tuto

Place the 4 straight voussoirs (**non conical**) like on the photo. Spot the Bottom of the voussoir thanks to the letter **B** marked on it. 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

Consult
the video

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

Consult
the video

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

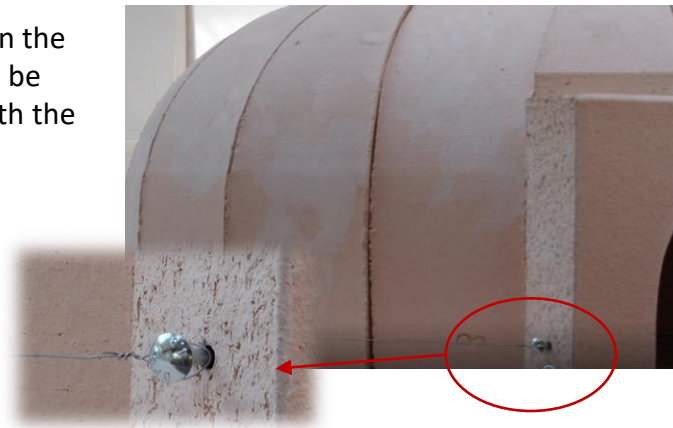
Divide uniformly the gaps between the pieces.

Check to have an hamonious 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

Consult
the video

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

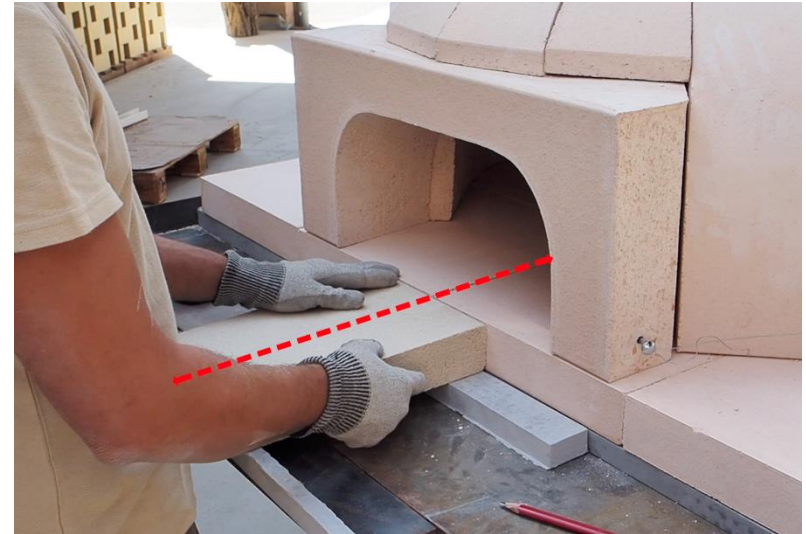
*On the photo, little wedges are used to place the shelves boards **BUT, in reality**, you have to do a mortar and seal the shelves on the base.*

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.

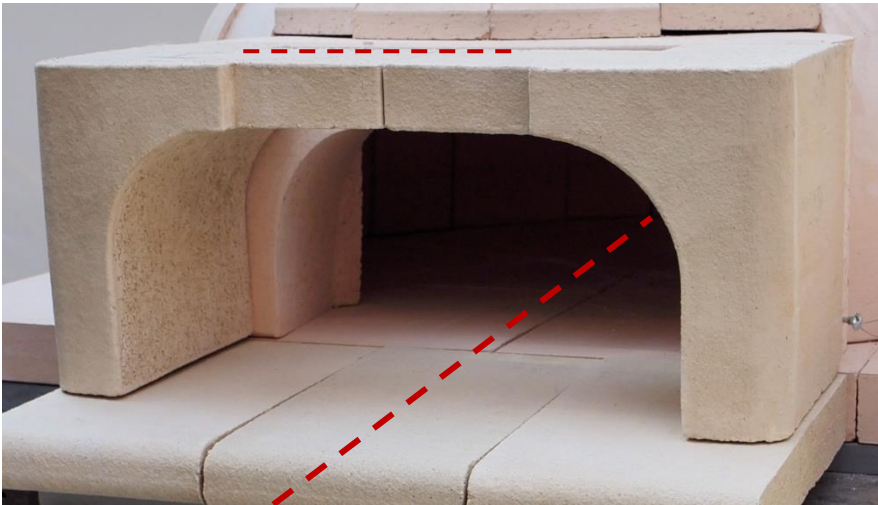
Leave to dry for 24 hours

Phase 8 : Placing the frontage

Consult
the video



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

[View
the video](#)

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

[View
the video](#)

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

Insulation with blanket : Leave to dry 24h

Insulation with grog : 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 techniques are different according to the insulation materials : Grog or Blanket.

You have chosen insulation with GROG

The provided materials for the insulation are :

- Blanket thickness 13 mm
- Grog bags 25 kg

Please go to pages 28 to 31

You have chosen insulation with BLANKET

The provided materials for the insulation are :

- Blanket thickness 38 mm
- Chicken fence
- Refractory cement bags + vermiculite bags

Please go to pages 32 to 35

Insulation with Grog

Insulating the dome with GROG

Step 1/ Place the blanket

Cover the dome with refractory blanket thickness 13 mm « without humping ».

Advice : cut triangles in the blanket.

If you have too much blanket, you can put the rest of it above the grog – see step 3



Insulating the dome with GROG

Step 2/ 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

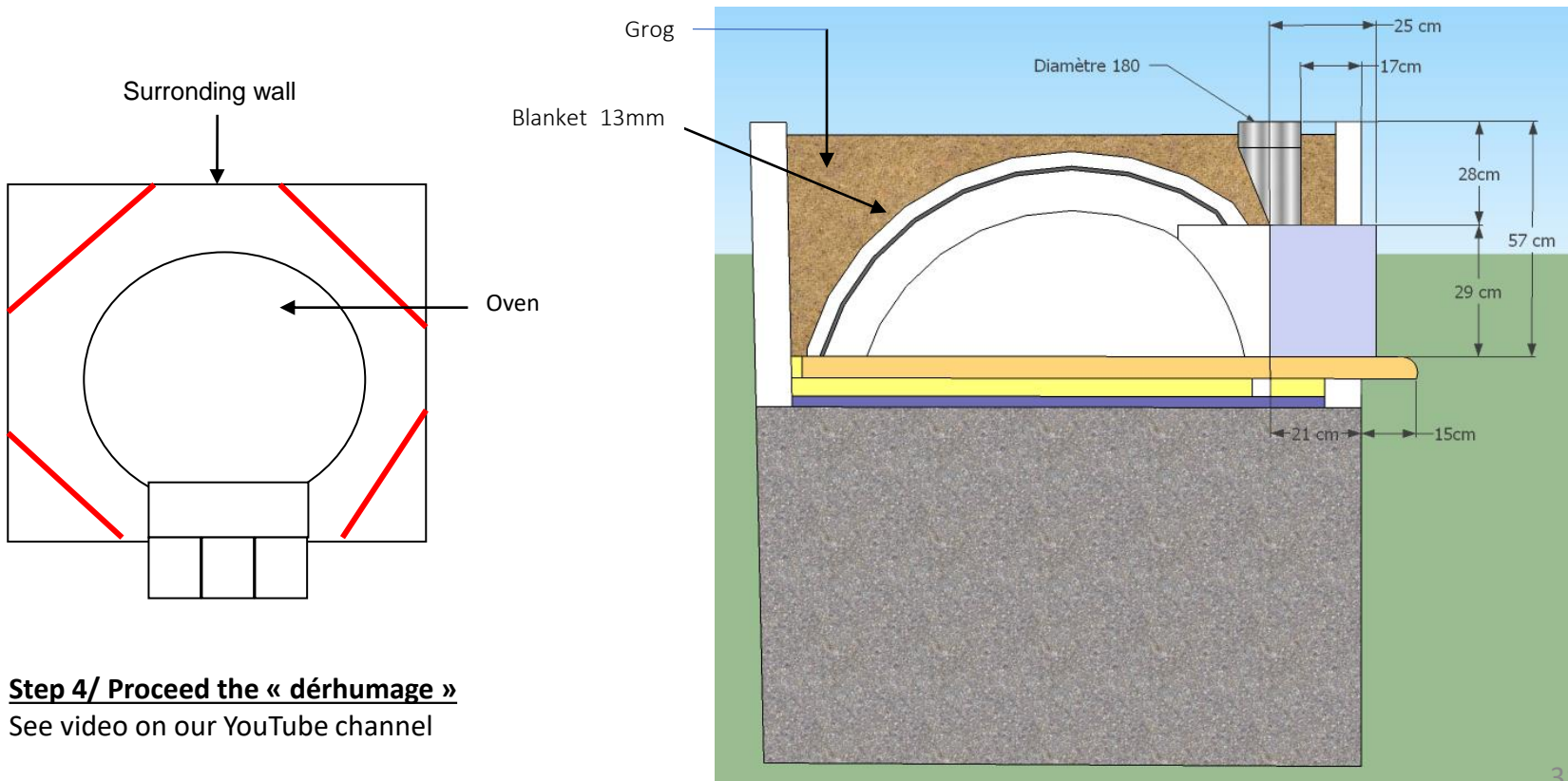
Insulating the dome with GROG

Step 3/ Place the GROG

Once the blanket and the 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.



Step 4/ Proceed the « dérhumage »

See video on our YouTube channel

Insulation with Blanket

Insulating the dome with BLANKET

Consult
the vidéo

1/ Place the blanket thick 38 mm

Recover the dome with refractory blanket « without humping ».

Advice : cut triangles in the blanket (see videos)



2/ Place a chicken fence (provided)

Recover with chicken fence / frame (same method as the blanket).



Insulating the dome with BLANKET

Consult
the vidéo

3/ Applying a refractory Mix : refractory cement + vermiculite + water:

Recover all the dome 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 3 or 4 cm thick and smooth
- Leave to dry 2 weeks
- Proceed the « dérhumage » : see the video on our YouTube channel



Insulating the dome with BLANKET

For the final shape and finishing touches

- If you want a rounded shape:
 - Use the oven during 1 or 2 month before making the veneer
 - During this period, the oven will dilate. If small cracks appear, don't worry; they will be filled by the finishes.
 - For the veneer : painting, mozaic, coating, ...
- If you want a cubic shape :
 - 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.**



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**