



USOORE36941E

United States Patent [19] Wolfe et al.

[11] E

Patent Number: **Re. 36,941**

[45] Reissued Date of Patent: **Nov. 7, 2000**

[54] **DUAL CONVEYOR OVEN**

[76] Inventors: **Ronald D. Wolfe**, 1922 Cardington, Wichita, Kans. 67212; **Dwane D. Wolfe**, 12025 Lynndale, Wichita, Kans. 67235

[21] Appl. No.: **09/353,927**

[22] Filed: **Jul. 13, 1999**

Related U.S. Patent Documents

Reissue of:

[64] Patent No.: **5,832,812**
Issued: **Nov. 10, 1998**
Appl. No.: **08/806,089**
Filed: **Feb. 25, 1997**

- [51] **Int. Cl.⁷** **A21B 1/00**; A23L 3/00; A47J 37/00; F24C 15/32
- [52] **U.S. Cl.** **99/443 C**; 99/386; 99/447; 99/476; 99/477; 126/21 A; 432/144; 432/152
- [58] **Field of Search** 99/386, 443 R, 99/443 C, 447, 476, 477, 468; 34/218, 225; 126/21 R, 21 A; 198/780, 774.3; 219/388, 400, 495; 432/144, 145, 152, 199; 426/233, 315, 506, 523

[56] References Cited

U.S. PATENT DOCUMENTS

4,389,562	6/1983	Chadoir	99/386 X
4,554,437	11/1985	Wagner et al.	219/388
4,610,886	9/1986	Buller-Colthurst	426/233
4,655,126	4/1987	Wells	99/447 X
4,717,572	1/1988	Buller-Colthurst	99/443 C

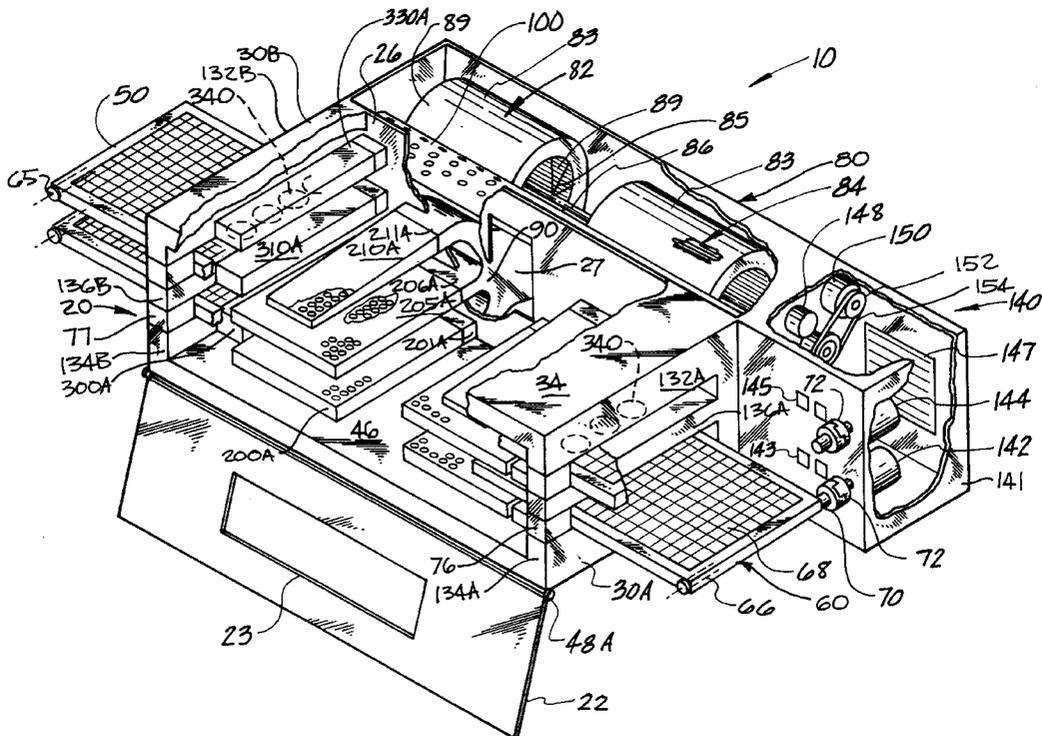
4,739,154	4/1988	Bharara et al.	219/400 X
4,884,552	12/1989	Wells et al.	99/386 X
4,951,648	8/1990	Shukla et al.	126/21 A
5,077,072	12/1991	Sieradzki	426/523
5,088,391	2/1992	Anderson	99/423
5,121,677	6/1992	Le Claire et al.	99/443 C
5,253,564	10/1993	Rosenbrock et al.	99/386 X
5,606,904	3/1997	Fabbri	99/477 X

Primary Examiner—Timothy Simone
Attorney, Agent, or Firm—Edward L. Brown, Jr.

[57] ABSTRACT

The oven of the present invention is a low profile, dual [conveyer] conveyor oven including an oven cabinet, two closely spaced [conveyers] conveyors and an air heating and circulation system. The [conveyers] conveyors and the oven cabinet are adapted so that the [conveyers] conveyors can be easily removed [from the] from the front or side of the oven cabinet. The oven cabinet houses the [conveyers] conveyors, ducts and manifolds which all can be easily removed for cleaning or other maintenance. Each of the [conveyers] conveyors include separately controlled drive motors capable of driving [the] each of [conveyers] conveyors at different speeds and in different directions. The air heating and circulation system features a transverse mounted burner tube, side mounted return air ducts, a central return air opening, common shaft mounted side fed dual centrifugal fans and hot air manifolds. The hot air manifolds are fed from the rear by the dual centrifugal fans and are adapted to surround the two closely spaced [conveyers] conveyors and supply those closely spaced [conveyers] conveyors with hot cooking air within a space having a very limited vertical dimension.

11 Claims, 2 Drawing Sheets



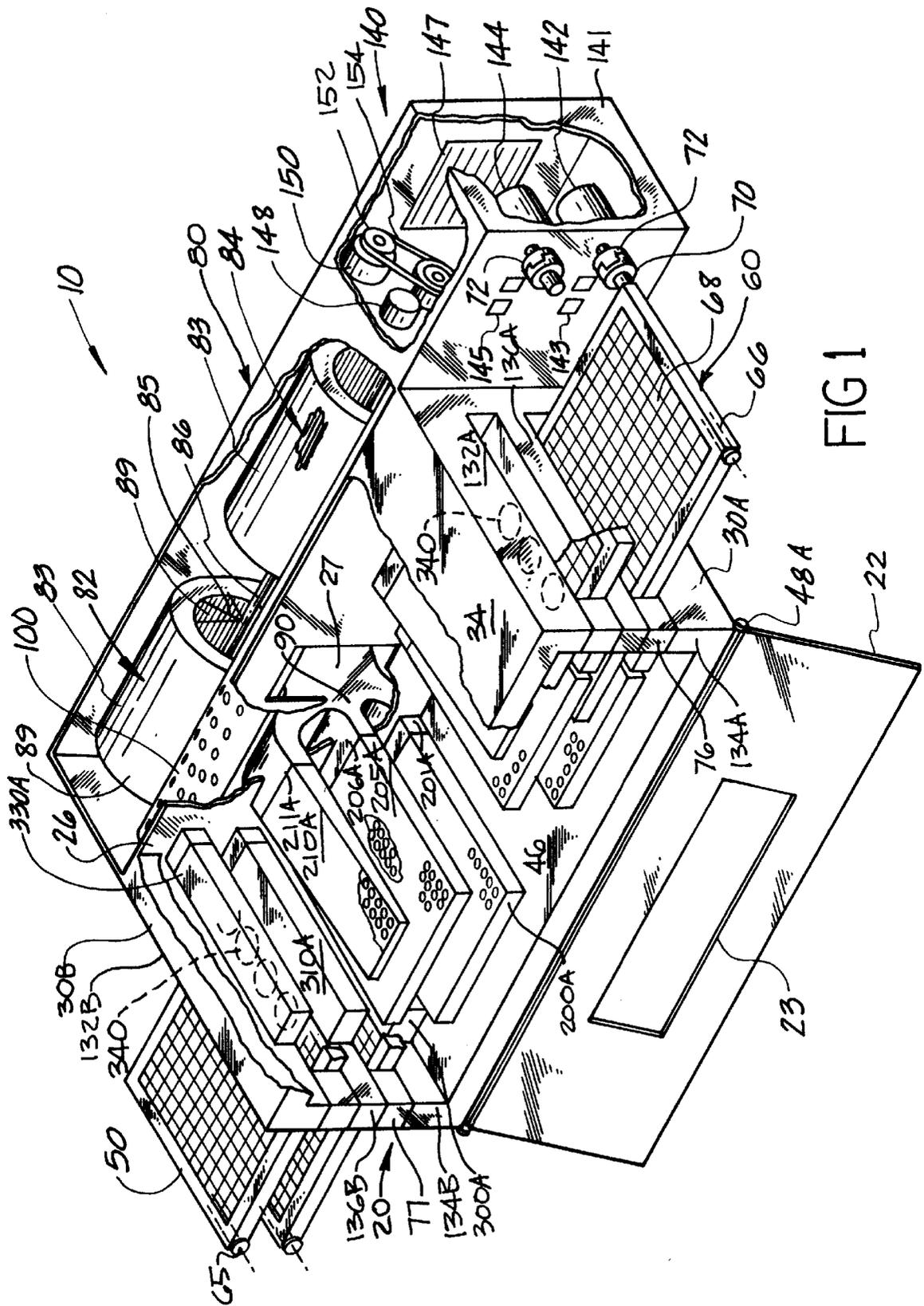
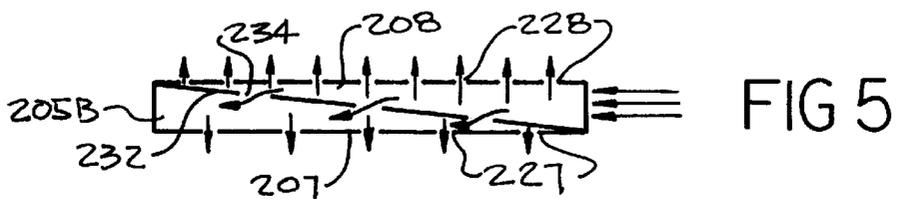
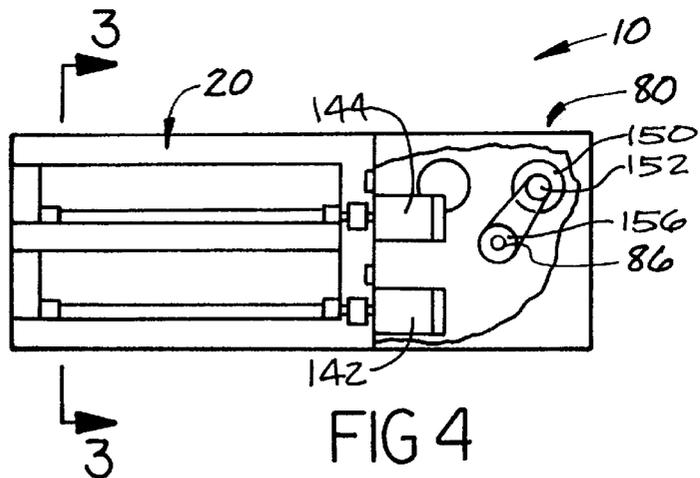
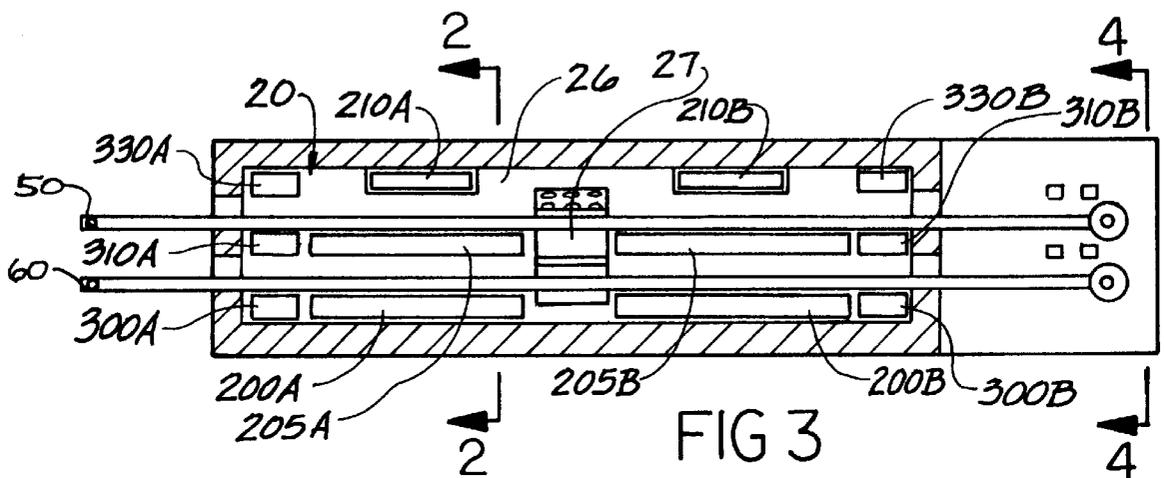
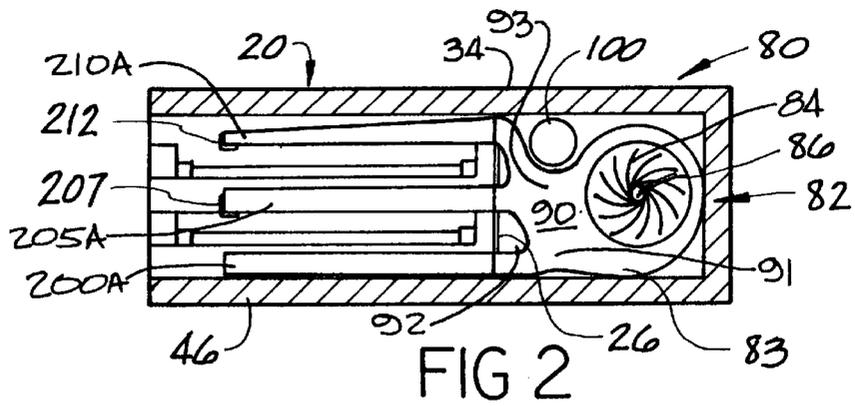


FIG 1



DUAL CONVEYOR OVEN

Matter enclosed in heavy brackets [] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

FIELD OF THE INVENTION

The present invention relates to impingement ovens. Generally, such ovens include a cabinet, a [conveyor] conveyor mounted in the cabinet for carrying food products into, through and out of the cabinet, an heater for heating cooking air such as a gas burner for heating cooking air, fans for circulating heated cooking air, manifolds for delivering a flow of heated cooking air from the heater and fans to the [conveyor] conveyor. Usually ducts or passages are provided for returning air to the air heater for reheating.

PRIOR ART

Numerous examples of forced air [conveyerized] conveyorized ovens can be found in the prior art. Generally, they include oven cabinets which carry single [conveyers] conveyors. In the prior art ovens, a [conveyor] conveyor is usually heated by air manifolds which are supplied by an axial fan situated in a fan box attached to the oven cabinet.

A dual [conveyor] conveyor oven is disclosed by Smith in U.S. Pat. No. 4,474,498. In U.S. Pat. No. 4,474,498, Smith discloses dual sets of air manifolds heating [a] two [conveyer s] conveyors within an oven cabinet. However, Smith in U.S. Pat. No. 4,474,498 discloses an impeller arrangement which draws return air from the front and exhausts vertically into adjacent air manifolds. This arrangement yields an effective dual [conveyor] conveyor oven but does not provide a dual [conveyor] conveyor oven which could also have a low profile. Further, Smith does not disclose in U.S. Pat. No. 4,474,498 [conveyers] conveyors that can be removed from the front of an oven cabinet or [conveyers] conveyors that can be separately controlled and driven.

A single [conveyor] conveyor low profile stackable oven is disclosed by Bruno, et al in U.S. Pat. No. 5,277,105. In U.S. Pat. No. 5,277,105, Bruno discloses an oven having a rear fed impeller. Bruno achieves a low profile by arranging the burner assembly across the oven cabinet generally perpendicular to the direction of the oven's [conveyor] conveyor. However, Bruno does not disclose the novel and surprising side fed centrifugal fan and manifold system found in the present invention.

The prior art also yields a number of patents disclosing [conveyor] conveyor ovens having various axial fan air manifold arrangements which have various commendable advantages and features. However, none of these prior art ovens seem to present the above described novel features and advantages found in the oven of the present invention.

BRIEF DESCRIPTION OF THE INVENTION

The present invention is directed toward a low profile dual [conveyor] conveyor impingement oven having an oven cabinet, two [conveyor] conveyor assemblies, a fan box, and a control unit. Each of the two [conveyers] conveyors are mounted in the oven cabinet so that they can convey food product in one side of the oven cabinet, through the oven cabinet and out through the other side of the oven cabinet along a common direction of movement. Each of the two [conveyers] conveyors is also driven by a separately controlled [conveyor] conveyor drive motor capable of operat-

ing over a range of speeds in either a clockwise or counter clockwise direction. The oven cabinet is adapted to allow each of the two [conveyor] conveyor assemblies to be easily removed from either side or the front of the oven cabinet. The two centrifugal fans and their common shaft are positioned parallel to the direction of movement of the [conveyers] conveyors. A burner tube for heating cooking air is located in the fan box and is also positioned parallel to the direction of movement of the [conveyers] conveyors. Also located in the fan box and positioned parallel to the direction of movement of the [conveyers] conveyors are two centrifugal fans mounted on a common shaft which is driven by a remote fan drive motor. Each centrifugal fan is adapted to draw heated cooking air in from each of their sides and expel a stream of heated cooking air into a plenum that divides to feed three hot air manifolds. The hot air manifolds are adapted to force hot cooking air up into and down onto each [conveyor] conveyor assembly. An opening in the oven cabinet between the two sets of three manifolds allows return air to flow into the fan box. Return air ducts in communication with the fan box are situated at the sides of the oven and are also used to draw return air back into the fan box. Appropriate controls and means located in a control and drive unit are provided to operate and provide gas and air to the burner tube, and provide electricity to the fan drive motor and the [conveyor] conveyor drive motors.

The oven of the present invention uses space very efficiently. Because the oven of the present invention has a pair of centrifugal fans mounted on a common drive shaft each of which supply triple hot air manifolds surrounding two [conveyor] conveyor assemblies, it is possible to provide a dual [conveyor] conveyor oven in a very compact vertical space. More particularly, the centrifugal fans of the oven of the present invention each have length to diameter ratio greater than one and are mounted parallel to the direction of movement of the [conveyor] conveyor assemblies and draw air in from either side in an intake stream that is substantially parallel to their axis of rotation and expel an exhaust stream that is generally normal to their axis of rotation. Further, the centrifugal fans of the present invention are adapted to expel a generally uniform stream of hot cooking air that can then be easily divided into three air streams to feed three manifolds. This novel and improved air flow arrangement makes it possible to uniformly supply three hot air manifolds that can in turn provide hot cooking air to the top and bottom of each of the two [conveyers] conveyors. Because the centrifugal fans have small diameters relative to their size and capacity, [because the exhaust streams from the centrifugal fans are easily diverted into the three manifolds. Therefore] a dual [conveyor] conveyor oven needing three manifolds can be accomplished in a limited vertical space. Because the dual [conveyor] conveyor oven of the present invention has such a low profile, it can then also be stacked to provide a pair of ovens having a total of four [conveyers] conveyors still within a reasonable vertical space. These advantages provide an operator with a very large amount of cooking capacity in a limited space.

The oven of the present invention also uses space very efficiently because it can be taken apart within a limited space. It has an oven cabinet that is adapted to allow each of the two [conveyor] conveyor assemblies to be easily removed from either side or the front of the oven cabinet.

The oven of the present invention can also cook food product with a high degree of versatility. Because the oven of the present invention has [conveyers] conveyors that are driven by separately controllable [conveyor] conveyor drive motors capable of rotating in different directions at different

speeds, an operator employing a pair of ovens or even a single oven enjoys the advantage of being able to cook different types of food at different rates depending on the speeds of operation of the [conveyers] conveyors.

The oven of the present invention greatly reduces the time and effort required to accomplish cleaning and maintenance operations. All of the present oven's ducts, manifolds and [conveyor] conveyor assemblies can be easily removed from the front of the oven cabinet without the use of special skills or without the use of tools of any kind.

These and other advantages of the oven of the present invention will become apparent to the skilled reader who reads the detailed description given below.

BRIEF DESCRIPTION OF THE DRAWINGS

The following detailed description refers to the attached drawings in which:

FIG. 1 is perspective view of the oven of the present invention with portions broken away;

FIG. 2 is a sectional view of the oven of the present invention taken along line 2—2 of FIG. 1;

FIG. 3 is a sectional view of the oven of the present invention taken along line 3—3 of FIG. 1;

FIG. 4 is a side elevational view of the oven of the present invention taken along line 4—4 of FIG. 1; and

FIG. 5 is a sectional view to an enlarged scale of the hot air manifold 205 taken along line 5—5 of FIG. 1.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

The oven of the present invention is shown in FIG. 1 and is generally described by reference numeral 10. Oven 10 generally includes an oven cabinet 20, [conveyor] conveyor assemblies 50 and 60, fan box 80 and a control and drive unit 140.

As is illustrated in FIG. 1, oven cabinet 20 further includes a front panel 22, a back wall 26, two side walls 30A and sidewall 30B, a top wall 34 and a bottom wall 46. As shown in FIG. 1, front panel 22 is pivotably attached to bottom wall 46 by hinges 48A and 48B. Front panel 22 could alternately be pivotably attached to top wall 34 by hinges located at its forward edge 36. Front panel 22 also includes a hatch 23 which provides partial access to the center of oven cabinet 20 during operation. Back wall 26 separates fan box 80 from the oven cabinet 20. It has a number of openings to accommodate air manifolds and return ducts as well as a return air opening 27. Side walls 30A and 30B are symmetrical. Each side wall 30A and 30B includes top cantilevered portions 132A and 132B, bottom cantilevered portions 134A and 135B and center cantilevered portions 136A and 136B. Top cantilevered portions 132A and 132B and center cantilevered portions 136A and 136B define a top pair of opposite horizontal conveyor openings 142A and 142B. Similarly, bottom cantilevered portions 134A and 134B and center cantilevered portions 136A and 136B define a bottom pair of opposite horizontal [conveyor] conveyor openings 144A and 144B. The two side walls 30A and 30B, top wall 34 and bottom wall 46 of oven cabinet 20 are generally hollow and constructed from thin stainless steel sheet which has very high strength and is very resistant to corrosion. In the preferred embodiment these walls may have internal insulating material and reinforcing members to provide strength and increase energy efficiency. In the preferred embodiment top wall 34, top cantilevered portions 132A and 132B and center cantilevered portions 136A and

136B are structurally reinforced to resist with minimal deflection any vertical bending loads resulting from the oven's own weight and the weight of an additional oven should the user wish to stack two ovens together. Because the user may wish to stack two ovens to provide a combined oven, it should be readily apparent to those skilled in the art that the above described elements of cabinet 20 be strong but also light.

[CONVEYER] CONVEYOR ASSEMBLY DETAILS

As shown in FIGS. 1 and 3, oven cabinet 20, carries an upper [conveyor] conveyor assembly 50 and a lower [conveyor] conveyor assembly 60. In the preferred embodiment of the present invention, upper [conveyor] conveyor assembly 50 and lower [conveyor] conveyor assembly 60 are substantially interchangeable. More particularly, lower [conveyor] conveyor assembly 60 comprises a frame 64 which in turn carries two rotating sprocket shafts 65 and 66. Wire mesh belt 68 defines a continuous loop around sprocket shafts 65 and 66. Frame 64 also carries a rigid wire frame (not shown) disposed between sprocket shafts 65 and 66 that further supports wire mesh belt 68. Each [conveyor] conveyor assembly has a cogged coupling 70 situated at one end of shaft 66 for engaging a corresponding cogged coupling 72. Each cogged coupling 72 is connected to a separately controllable [conveyor] conveyor drive motor 142 and 144 which are described below. Cogged couplings 70 and 72 are adapted for easy engagement and disengagement.

SUPPORT OF [CONVEYER] CONVEYOR ASSEMBLIES

As can be seen in FIG. 1, oven cabinet 20 is adapted to receive and support upper [conveyor] conveyor assembly 50 and lower [conveyor] conveyor assembly 60 either from the front or either side of oven cabinet 20. Support members 76 and 77 are fixed to [conveyor] conveyor assembly frame 64 and lower [conveyor] conveyor assembly 60 and are sized and located to fit within the gaps between center cantilevered portions 136 and adjacent top cantilevered portion 132 or adjacent bottom cantilevered portion 134. As can be further seen in FIGS. 1 and 4, similar support members 52 and 53 are attached to [conveyor] conveyor assembly 50. As illustrated in FIG. 3, [conveyor] conveyor assembly 50 and [conveyor] conveyor 60 are adapted to convey food product in through horizontal openings 142A and horizontal opening 144A, through the interior of oven cabinet 20 and out through opposite corresponding horizontal openings 142B and 144B.

AIR HEATING AND CIRCULATION SYSTEM IN GENERAL

The oven of the present invention as seen in FIG. 1 has an air heating and circulation system that includes fan box 80, a burner 148, a burner tube 100, a means for allowing spent cooking air to return to fan box 80 from oven cabinet 20 such as air return ducts 300A, 300B, 310A, 310B, 330A, 330 B and air return opening 27, centrifugal fans 82 and 84, plenums 90 for dividing hot cooking air, and hot air manifolds 200A, 200B, 205A, 205B, 210A and 210B. Fan box 80, situated behind oven cabinet 20, shares back wall 26 with oven cabinet 20. Fan box 80 is a generally air tight chamber where returning air is sucked in from air return ducts 300A, 300B, 310A, 310B, 330A, 330 B and air return opening 27. Air in box 80 is heated by burner tube 100 before entering centrifugal fans 82 and 84. Left and right

centrifugal fans **82** and **84** are mounted in fan box **80** on a common shaft **86** and are positioned and adapted to draw air into the ends along an intake stream generally parallel to common shaft **86** and to expel a substantially uniform non swirling column of air in a forward direction towards oven cabinet **20**. Two identical plenum deflector arrangements described in detail below distribute hot cooking air from left and right centrifugal fans **82** and **84** to hot air manifolds **200A**, **200B**, **205A**, **205B**, **210A** and **210B**.

HOT AIR MANIFOLD DETAILS

FIG. 1 shows how the left hot air manifolds attach to back wall **26** of oven cabinet **20**. Lower, center and upper hot air manifolds **200A**, **205A** and **210A** slide into corresponding collar joints **201A**, **206A** and **211A** that are fixed to back wall **26**. Not shown in FIGS. 1 or 2 are identical collar joints provided for the right manifolds **200B**, **205B** and **210B**. All of the hot air manifolds are generally hollow stainless steel boxes that are open at one end where they are joined to their corresponding collar joint. As shown in FIG. 2, while lower hot air manifolds **200A** rests on lower wall **46** of oven cabinet **20**, the center and upper hot air manifolds **205A** and **210A** are supported at each end opposite back wall **26** by support angles **207** and **212**. Lower manifolds **200A** and **200B**, center manifolds **205A** and **205B** and upper manifolds **210A** and **210B** are interchangeable. Accordingly, only the left manifolds need to be described in detail. As can be seen in FIG. 1, upper surface **202** of lower manifold **200A** has a pattern of air holes **203**. Center manifold **205A** has an upper surface **208** and a lower surface **207** which is shown in a cut away portion of center manifold **205A**. Upper surface **208** of center manifold **205A** has a pattern of air holes **228**. As can also be seen in the cut away portion of center manifold **205A** of FIG. 1, lower surface **207** of center manifold **205A** also has a pattern of air holes **227**.

In FIG. 5, manifold **205B** is shown in section with a flow divider plate **232** extending from one end diagonally to the other. A series of air holes **234** in divider plate **232** restricts the amount of air flowing out of the holes **227** on the bottom surface **207**, as compared with the air flowing out of the top surface holes **228** so that the top air flow is over twice the bottom air flow.

Shown in another cut away view in FIG. 1, upper manifold **210A** has a lower surface **214** having a pattern of air holes **216**. In the preferred embodiment, the hole bearing surfaces are defined by removable plates that can be removed for easy cleaning. Also in the preferred embodiment, the size of these ducts and the number of air holes in their various surfaces have been adapted so that the air flow that is directed up into the [conveyers] conveyors from the manifolds is about twice as intense as the air flow that is directed down upon the [conveyers] conveyors. This particular configuration is adapted for a specific application and it should be apparent to those skilled in the art that other manifold configurations could be used to achieve different air distribution characteristics.

RETURN AIR DUCT DETAILS

The oven of the present invention has a means for returning air from the oven cabinet back to the fan Box **80**. FIGS. 1 and 3 show six return air ducts: left and right lower return air ducts **300A** and **300B**, left and right center return air ducts **310A** and **310B** and left and right upper return air ducts **330A**, and **330B**. FIG. 1 shows how the left return air ducts attach to back wall **26** of oven cabinet **20**. Each of the return air ducts is open at both ends and, with the exception

of lower return air ducts **300A** and **300B**, have a pattern of return air return openings **340** in their lower surfaces adjacent to their ends opposite back wall **26** of oven cabinet **20**. As shown in FIG. 1, return air ducts **300A**, **310A** and **330A** terminate well before they reach the front of oven cabinet **20**. Support brackets (not shown) can be attached to adjacent side walls **132** of oven cabinet **20** to provide a means to support return air ducts **310A**, **310B**, **330A** and **330B** or in the alternative a portion of each of return air ducts **310A**, **310B**, **330A** and **330B** could be extended and adapted to rest on support angles **212** and **207** shown in FIG. 2.

MORE RETURN AIR DUCT DETAILS

In this preferred embodiment, return air ducts **300**, **310** and **330** are adapted to pull spent hot air back to fan box **80** before it escapes through [conveyer] conveyor openings **142A**, **142B**, **144A** and **144B** of oven cabinet **20**. Air return openings **340** are disposed near the end of the air return ducts **310**, **320** and **330** because the inventors have found that air exiting from manifolds **200**, **205**, and **210** tends to move in a direction away from fan box **80**. Air return openings are not placed in the upper surfaces of air return ducts **310**, **320** and **330** because splattered material would then fall into the air return ducts thus making them difficult to clean.

DETAILS OF FAN/PLENUM ARRANGEMENT

In FIG. 2, left centrifugal fan **82** includes a stationary fan housing **83** and a fan impeller **84**. Fan impeller **84** mounts to and is attached to a common drive shaft **86** by spokes **85**. Common drive shaft **86** is carried by bearings at opposite ends of fan box **80** (not shown). Stationary fan housing **83** further includes open air inlet ends **89** and a plenum portion **90**. Openings **89** at both ends of housing **83** admit heated air from fan box **80**. As can be further seen in FIG. 2, air from plenum **90** is divided into a lower channel **91** and an upper channel **93** by bull nose deflector **92**. Air from upper channel **93** feeds hot air manifolds **205** and **210** while air from lower channel **91** feeds hot air manifold **200**. Another identical plenum channel arrangement on the right side (not shown) divides hot cooking air from right centrifugal fan **84** three ways to feed hot air manifolds **200**, **205** and **210**. Burner tube **100** is situated to heat returning air and also radiantly heat fan housing **83** to thereby further heat air flowing through fan **82**. Although, the preferred embodiment of the present invention employs gas fired burner tube **100** to heat cooking air, any suitable air heating means could be employed to heat cooking air.

ADVANTAGES OF AIR HEATING AND DISTRIBUTION SYSTEM

An important advantage of the oven of the present invention is that it is a very low profile oven that has two [conveyers] conveyors which are both well supplied by forced hot cooking air. This is accomplished by using a centrifugal fan such as centrifugal fan **82** and a fan housing such as fan housing **83**. With a dual inlet centrifugal fan **82** in combination with fan housing **83** having channels **91** and **93** feeding three manifolds **200**, **205**, and **210** ample airflow can be provided to both [conveyer] conveyor assemblies **50** and **60** within a limited vertical space. This advantageous air distribution arrangement can be repeated because centrifugal fans of relatively small diameter such as fans **82** and **84** can be arranged in series on a common drive shaft such as common drive shaft **86**. This repeated triple manifold air distribution arrangement in combination with a common

drive shaft carrying at least two centrifugal fans yields an oven capable of cooking food product on two [conveyers] conveyors within a very compact vertical space.

CONTROL AND DRIVE UNIT

As shown in FIGS. 1 and 4, control and drive unit 140 includes a housing 141, a burner 148, a fan drive motor 150 and [conveyor] conveyor drive motors 142 and 144. Housing 141 is generally a sheet metal box and has vents and louvers 147 on the sides and bottom for allowing air to flow freely into and out of drive unit 140. Burner 148 is a standard gas burner and is of the type that has a means for mixing air and natural gas as well as a means for blowing the mixture through a port and into a combustion zone where the mixture burns and liberates heat. Burner 148 introduces burning gases into burner tube 100 which runs the width of fan box 80. Burner 148 is adapted to allow manual control of the gas air mixture. As is further shown in FIG. 4, fan drive motor 150 is fitted with a pulley 152. The end of drive shaft 86 carries a drive pulley 156. A fan drive belt 154 runs between motor pulley 152 and drive pulley 156 and transfers power from fan drive motor 150 to drive shaft 86. Although fan drive motor 150 runs at a substantially constant rate, the diameters of motor pulley 152 and drive pulley 156 can be varied to adjust the rotational speed of drive shaft 86. In this way, different operating conditions, such as high altitude operations can be accommodated.

[CONVEYER] CONVEYOR DRIVE SCHEME

As is also shown in FIGS. 1 and 4, control and drive unit 140 also includes a pair of [conveyor] conveyor drive motors 142 and 144. Each of the [conveyor] conveyor drive motors 142 and 144 has a cogged coupling 72 mounted on the motor shaft which each engage a corresponding releasable cogged coupling 70 associated with the [conveyor] conveyor assemblies. Each of the [conveyor] conveyor drive motors 142 and 144 is separately controlled by controls 143 and 145 respectively. Controls 143 and 145 and drive motors 142 and 144 are adapted so that each [conveyor] conveyor drive motor 142 and 144 may be independently turned on or off or independently operated over a continuous range of speeds in either a clockwise or counter clockwise direction.

It should be noted that the present invention can be adapted to create an alternative embodiment of a very low profile single [conveyor] conveyor oven. Because the diameter and speed of a centrifugal fan can be varied, it would be possible to combine small diameter centrifugal fans with plenums for feeding pairs of hot air manifolds disposed around a single [conveyor] conveyor. In this way, an extremely low profile single [conveyor] conveyor oven could be provided.

The skilled reader, in view of this specification may envision numerous modifications and variations of the above disclosed preferred embodiment. Accordingly, the reader should understand that these modifications and variations, and the equivalents thereof, are within the spirit and scope of this invention as defined by the following claims, wherein:

I claim:

1. A low profile [conveyor] conveyor oven comprising an oven cabinet, two [conveyers] conveyors, a fan box, an air heater, air return passages, two sets of manifolds and two centrifugal fans;
 - said oven cabinet adapted for supporting said [conveyers] conveyors,
 - said [conveyers] conveyors each having a direction of travel and each disposed transversely within the front of said oven cabinet one over the other;

said fan box disposed behind said oven cabinet, said heater for heating hot cooking air, said air return passages in communication with said oven cabinet and said fan box for returning air from said oven cabinet to said fan box and said heater for reheating;

said two sets of manifolds each having three hot air manifolds adapted to surround said [conveyers] conveyors and provide hot cooking air thereto; and

said centrifugal fans adapted for rotation about a generally common axis of rotation substantially parallel to said direction of travel of said [conveyers] conveyors, said centrifugal fans also having three channeled plenums for directing hot cooking air into each of said three hot air manifolds of said two sets of manifolds.

2. A low profile [conveyor] conveyor oven as set forth in claim 1 further comprising

an oven cabinet having an openable front panel and two side walls, each of said side walls having a bottom cantilevered portion a top cantilevered portion and a center cantilevered portion adapted to receive said [conveyers] conveyors from the front or either side of said oven cabinet.

3. A low profile, dual [conveyor] conveyor oven comprising an oven cabinet, two closely spaced [conveyers] conveyors and an air heating and circulation system;

each of said [conveyers] conveyors having a drive means; said oven cabinet having an openable front panel and two side walls, each of said side walls having a bottom cantilevered portion a top cantilevered portion and a center cantilevered portion adapted to receive said [conveyers] conveyors from the front or either side of said oven; and

said air heating and circulation system having a fan box, burner tube mounted in said fan box for heating hot cooking air, side mounted return air ducts and a central return air opening, at least two side fed centrifugal fans mounted on a common shaft, plenums and hot air manifolds, each of said side fed centrifugal fans adapted to draw air in along said common shaft and expel a stream of air in to each of said plenums, each of said plenums adapted to distribute hot cooking into said hot air manifolds, said hot air manifolds adapted to surround said [conveyers] conveyors and supply said [conveyers] conveyors with said hot cooking air, said hot cooking air returning through said side mounted air ducts and through said return air opening to said fan box for reheating by said burner tube.

4. The low profile, dual [conveyor] conveyor oven of claim 3 further comprising [conveyor] conveyor drive means wherein each of said [conveyers] conveyors are separately driven by a separately controlled drive motor capable of driving each of said [conveyers] conveyors at different speeds and in different directions.

5. A low profile conveyor oven for cooking a food product as it moves on a conveyor, comprising:

an oven cabinet having front and back walls, said walls with openings therein for passage of the conveyors;

at least two conveyors positioned longitudinally in the cabinet and extending through said openings;

a fan box positioned along the back wall containing heating and air circulation systems;

at least one centrifugal fan positioned in said box rotating on a shaft substantially parallel to said conveyor's direction of travel, said fan capable of drawing air through its ends said discharging a hot stream laterally toward and along said conveyors;

at least one plenum chamber connected to the fan discharge flow dividing the flow into at least three paths;
 at least hot air manifolds in said oven cabinet connected to said plenum chamber extending substantially over, under and between said conveyors supplying jets of cooking air toward both the bottom and top of the conveyors;
 return passages in said oven chamber connected to said fan box;
 an air heater in said fan box; and
 separate drive means connected to each conveyor for driving the conveyors.

6. A low profile conveyor oven as set forth in claim 5 wherein the front wall of the oven cabinet has an openable panel for removal of the conveyors and said two side walls, each have cantilevered portions open to the front wall which are adapted to receive said support said conveyors.

7. A low profile dual conveyor oven of claim 5 wherein the conveyor drive means on each conveyor are separately driven by separately controlled drive motors capable of driving each of said conveyors at different speeds and in different directions.

8. The low profile, dual conveyor oven of claim 5 wherein said air return passages include ducts mounted within said oven cabinet with outlets approximate said side wall openings.

9. A low profile conveyor oven for cooking a food product as it moves on a conveyor, comprising:
 an oven cabinet having front and back walls, side walls with openings therein for passage of a conveyor;
 at least one conveyor positioned longitudinally in the cabinet and extending through said openings;
 the front wall of the cabinet having an openable panel for removal of the conveyors and the two side walls having

cantilevered portions open to the front wall which are adapted to receive and support said conveyor.

10. A low profile conveyor oven as set forth in claim 9 including removable support members positioned between the free ends of the cantilevered portions of the side walls defining one side of the side wall openings.

11. A low profile conveyor oven for cooking a food product as it moves on a conveyor, comprising:
 an oven cabinet having front and back walls, side walls with openings therein for passage of the conveyors;
 at least one conveyor positioned longitudinally in the cabinet and extending through said openings;
 a fan box positioned along the back wall containing heating and air circulation systems;
 at least one centrifugal fan positioned in said box rotating on a shaft substantially parallel to said conveyor's direction of travel, said fan capable of drawing air through its ends and discharging a hot stream laterally toward and along said conveyor;
 at least one plenum chamber connected to the fan discharge flow dividing the flow into at least two paths;
 at least two hot air manifolds in said oven cabinet connected to said plenum chamber extending substantially over and under said conveyor supplying jets of cooking air toward both the bottom and top of the conveyor;
 return air passages in said oven cabinet connected to said fan box;
 an air heater in said fan box; and
 separate drive means connected to each conveyor for driving the conveyor.

* * * * *