PK Kiln Addendum

CHANGES TO KM1227PK & KM1231PK

There have been some slight modifications made to the KM1227PK and KM1231PK models since the last revision of the KM owners manual.

Added 3 fuses to the relay circuit for added safety.

Replaced screw on element connectors with more convenient element busbar system.

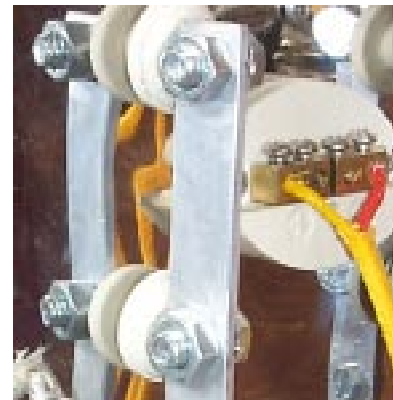Changed style of feeder wire pole blocks for easier maintenace

These changes have effected the following sections of the KM Operating Manual

Unacking and Moving PK Kilns (pg. 46)

Error Messages (pg. 40)

Wiring Diagrams (pgs. 48-49)

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PK KILN ADDENDUM CONTINUED

Disassembling KM1227PK and KM1231PK Kiln Sections

Caution: Before disassembling any PK kiln, be sure to turn off power to the kiln by throwing the circuit breaker or removing the fuse on its circuit. Do not restore power to the kiln until it is fully reassembled.

Note: The mercury relays in the switch box must be operated only with the switch box in a normal, vertical orientation.

To disassemble the kiln

1   Remove the screws from the left side of the control box.

2   Swing the control box open.

3   Remove the screws holding the feeder wires to the two pole blocks on the heat baffle. There are three sets with two feeder wires going into each set.

4   Remove the thermocouple wires from the thermocouple terminal strip on the baffle. They are attached with slide on connectors and should be pulled straight off. Pulling at an angle can damage the connector.

5   Lift the box up and set it aside.

6   Unfasten draw pull catches and lift sections apart using the handles.
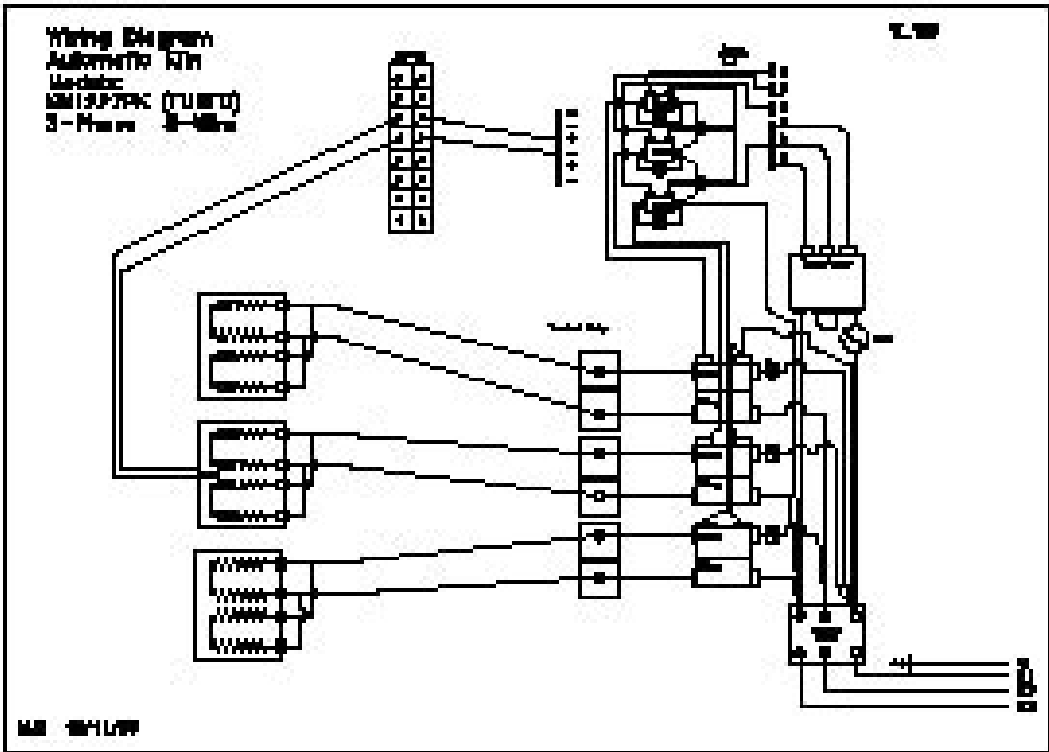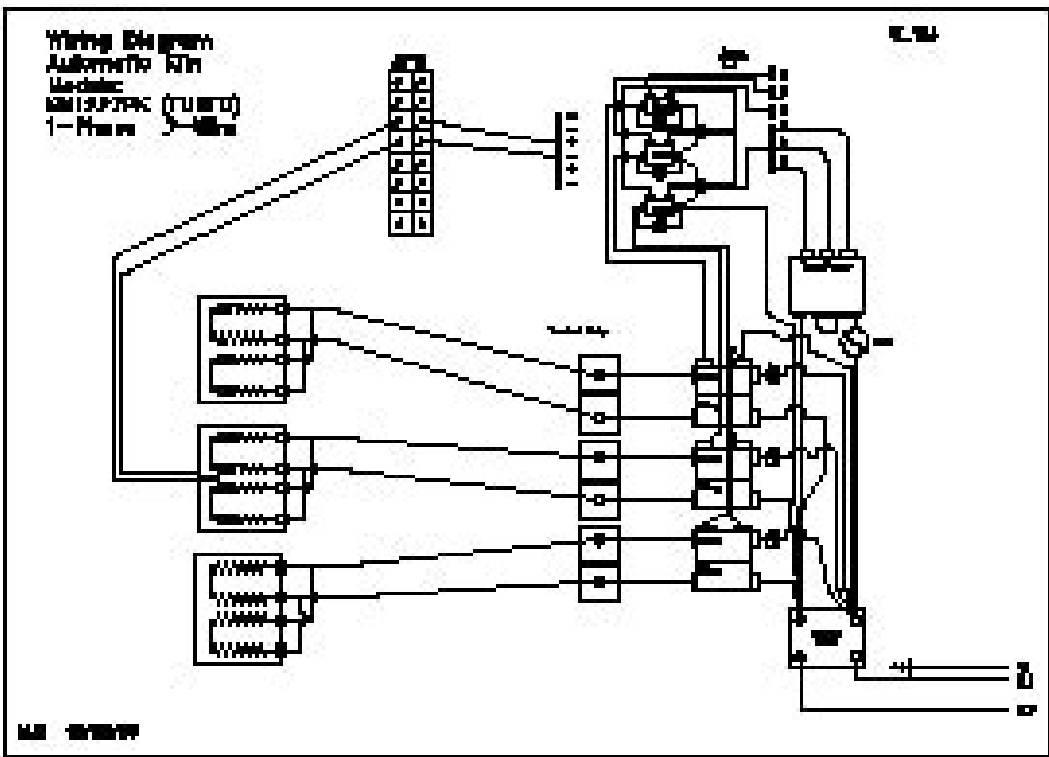
To reassemble PK kilns:

1   Stack the sections in original sequence and secure the draw pull catches..

2   Place the control box on its hinges.

3   Reattach the feeder wires to their corresponding block. Make sure the connection is very tight to avoid electrical problems.

5   Reattach the thermocouple wires in correct order.

6   Reattach the screws which secure the control box to the kiln jacket.

Error Messages

A blown fuse could cause the following errors:

Error 1
Error 2
Error 5
Error 8

ADDENDUM

PK KILN ADDENDUM CONTINUED

PK KILN ADDENDUM CONTINUED

Wiring Diagram
Automatic Kiln
Modsic
KM1331PK (TURN)
1-Phase 3-Wire

Wiring Diagram
Automatic Kiln
Modsic
KM1331PK (TURN)
3-Phase 3-Wire

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