



# Phase Conversions

## THE KM1227 / KM1027 CONVERSION PARTS:

### 3-Phase to 1-Phase Conversion

1. 6 gauge power cord with ring tongue connectors and plug end.
2. 1-phase terminal block
3. 1-phase strain relief (hole for power cord must be enlarged to 1 5/16")
4. 1-set primary harness wires (connects terminal block to relays) consisting of:
  - a. Six 14 gauge wires, eight inches long with push on connectors
  - b. two 18 gauge transformer wires twelve inches long with push on connectors

### 1-Phase to 3-Phase Conversion

1. 3-phase power cord with plug end and 10 gauge wires
2. 3-phase terminal block
3. 3-phase strain relief with two large and two small reducing washers. (hole for power cord must be reduced from 1 5/16" to 0.812").
4. 1-set primary harness wires (connects terminal block to relays) consisting of:
  - a. Six 14 gauge wires, eight inches long with push on connectors
  - b. two 18 gauge transformer wires twelve inches long with push on connectors

### 3-Phase to 1-Phase Conversion

1. 6 gauge power cord with ring tongue connectors and plug end
  2. 1-phase strain relief (hole for power cord must be enlarged to 1 5/16")
  3. 1-set primary harness wires (connects porcelain block to all switches, timer, and pilot light) conversion
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1. 3-phase power cord with plug end.
  2. Crimp connectors for 3 phase wires
  3. Insulating cover for crimp connectors
  4. Pilot cord with 4 prong plug.
  5. 3 phase contactor box.
  5. 3-phase strain relief with two large and two small reducing washers. (hole for power cord must be reduced from 1 5/16" to 0.812").
  6. 1-set primary harness wires (connects phase wires to switches).

Element replacement guidelines for all phase conversions. (3 to 1, 1 to 3, KM or KS kilns)

240 v. to 240v..... No element change is necessary.

240 v. to 208 v..... All elements must be changed.

208 v. to 240 v..... All elements must be changed.

208 v. to 208 v..... Center elements must be changed