Condition:
Witness cones placed in the top, center, and bottom of kiln indicate that the whole kiln is underfiring

START

Yes

Did kiln show an Err message?

No

Check your rates of heating in the final segment of the RAMP/HOLD program. Fast rates of heating, more than 108 per hour, can cause underfiring. See Appendix 2 concerning heat work in your KM owners manual.

Yes

Did you use a CONE FIRE program?

No

Enter a hold time of 10 to 30 minutes and fire again.

Yes

Was there a HOLD time entered at the end of the CONE FIRE program?

No

Please look up the flow chart for your Err message.

Yes

Did the kiln fire more than 1 cone cooler?

No

You may need a longer hold time up to 40 minutes. See also cone fire OFFSET instructions.

Yes

Is there a broken element in the kiln? See element TEST.

No

You can OFFSET adjust your controller to fire up to 50 degrees F hotter or cooler for any cone value. Please see OFFSET instructions.

Yes

Repair element and fire again