



KilnMaster Relay Replacement

FOR MODELS: KM1027 / KM1227 3-PHASE 208/240 VOLT

This relay replacement kit is intended to replace three relays and all the necessary relay wiring in your kiln. It is absolutely necessary to install the entire kit including all relays and wiring for proper performance. Do not re-use any of the original black wiring.

Your new relay replacement kit consists of the following items:

1. Three relays with all of the necessary harness and control wires attached
2. One relay adapter plate.

The tools necessary to install the relay replacement kit are a #2 Phillips screwdriver and a small slotted screwdriver.

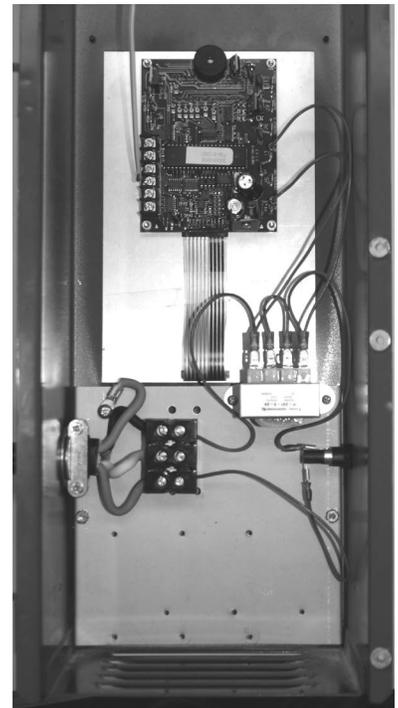
STEP-BY-STEP INSTRUCTIONS:

Before beginning the actual replacement, it is strongly recommended to read through these instructions to familiarize yourself with the following procedures.

PHOTO #1

RELAY AND WIRING REMOVAL

1. Unplug your kiln. Remove your control box from the kiln. Place the control box, face down on a flat surface. Protect the touchpad of your control box with a soft cloth or towel.
2. Remove the fiberglass lined heat baffle by removing the six sheet metal screws holding it in place. Carefully lift the heat baffle out of the control box, taking care not to stretch the attached wires on the underside.
3. Using the Phillips screwdriver, remove the six black wires attached to the heat baffle terminal strip. Save your screws. If you want to get the heat baffle entirely out of the way, remove the remaining red and yellow thermocouple wires.
4. Begin removal of the three old relays from the control box by removing the six sheet metal screws holding the relays in place. Save your screws. ALL wires, both black and red, connected to the relays will be removed. With the relays loosened, locate the 3-phase terminal block and loosen the screws holding the wires to the relays in place. Note the position of the two red wires connected to the terminal block when you remove the black relay wires. These red wires must be replaced in the same position when installing the new white wires coming from the relays. Use a gentle side to side rocking and pulling motion to remove the following wiring connectors. Remove the red connector from the top-center transformer tab. Remove the top red wire connected to the circuit board labeled output 2. Remove the double red wire on the circuit board labeled center tap. Carefully pull the relays and all attached wires out of the control box.



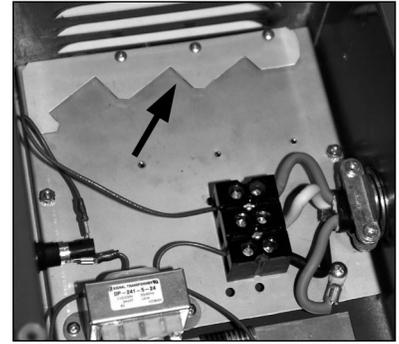
(continued)

RELAY REPLACEMENT CONTINUED

5. Refer to photo #1 to ensure that all of the relays and proper wiring have been removed.

RELAY INSTALLATION

1. Inspect the orientation of the new relays, wiring and metal adapter plate in its shipping cardboard. The relays will be installed in the control box with the same orientation. Remove the new relays, wiring and metal adapter plate from its packing material. Take care to keep the orientation of the new relays as packed to avoid twisting the wires. Locate the metal adapter plate; it will be installed first.
2. Install the metal relay adapter plate in the control box using 3 of the old relay screws. The silver colored spacers on the adapter plate should be placed directly against the metal chassis and screwed down lightly. Use the bottom set of existing holes in the metal chassis for mounting the adapter plate. Refer to photo #2 for the proper orientation of the metal adapter plate.
3. Place the 3 new relays and wiring harnesses in place on the metal chassis. Slide the bottom lip of each relay in its proper place. The plastic lip of the relays should slide underneath the top notched portion of the metal relay adapter plate.
4. Using the remaining 3 old relay screws, fasten down the remaining lips of the new relays using the existing holes in the metal chassis. Lightly tighten down all six screws holding the relays in place. Do not overtighten the screws as they may strip out.
5. Connecting the new relay wiring to the terminal block is a crucial step that must be accomplished correctly. Each relay should have two white wires with stripped ends connected to it. These wires with the stripped ends must be securely fastened into the black, 3-position terminal block. The relays will be numbered 1-6. Take the two wires numbered 1 and 3 and install them into the terminal block in the right most hole. Ensure that the existing red wire previously noted is installed also. Take the two wires numbered 2 and 5 and install them into the center hole. Take the two wires numbered 4 and 6 and install them into the remaining hole along with the existing old red wire previously noted.
6. Locate the two long red wires attached to the black relays. One wire will have a double end. Plug the wire with the double lead into the circuit board in the position labeled center tap. Plug the loose end of this wire into the top center tab of the transformer. Plug the other single long red wire into the circuit board on the tab labeled output 2.
7. Find the six, white, ten inch long wires attached to the relays. Attach these six wires to the heat baffle terminal strip using the old screws. Attach wire #1 (wires designations are labled on each relay) to position #1 on the terminal strip. Ensure that these connectors are lined up nicely and securely tightened. Refer to the numbered strip on the other side of the heat baffle for proper wire position. Reconnect the red and yellow thermocouple wire if necessary. Make sure the red thermocouple wire is connected to the negative position of the terminal strip. This would be the end (or bottom) connector on the terminal strip. It is labeled "-" on the other side.
8. All of the wiring should be connected now. Check all wiring for any loose ends or unattached connectors. Refer to the photo #3, finished wiring, if necessary to determine proper connection points. Ensure that all wiring is neatly routed around components such as the transformer. Reroute the wiring as necessary to eliminate kinks or pinch points.

**PHOTO #2**

RELAY REPLACEMENT CONTINUED

9. Reinstall the fiberglass lined heat baffle in place using the six sheet metal screws. When placing the heat baffle in place, ensure that no wiring is pinched or caught in the control box.
10. Reinstall the control box on your kiln. Ensure that all the white feeder wires are connected, that none of the tabs are loose and that the thermocouple push on connectors are connected to the proper polarity (red is negative "-"). Close the control box and secure using the six sheet metal screws.

Your installation should be complete!

11. An empty test firing of your kiln is strongly recommended before firing any valuable ware.

RELAY REPLACEMENT CONTINUED

PHOTO #3

