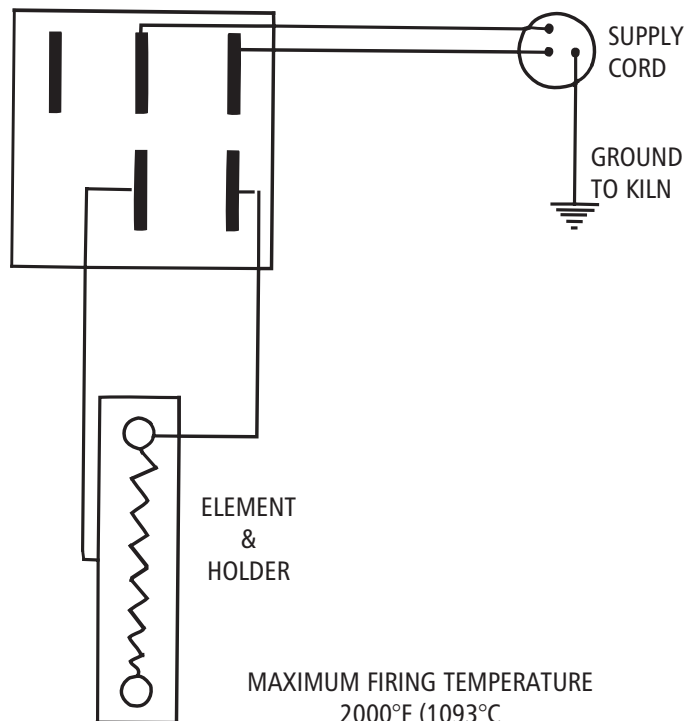
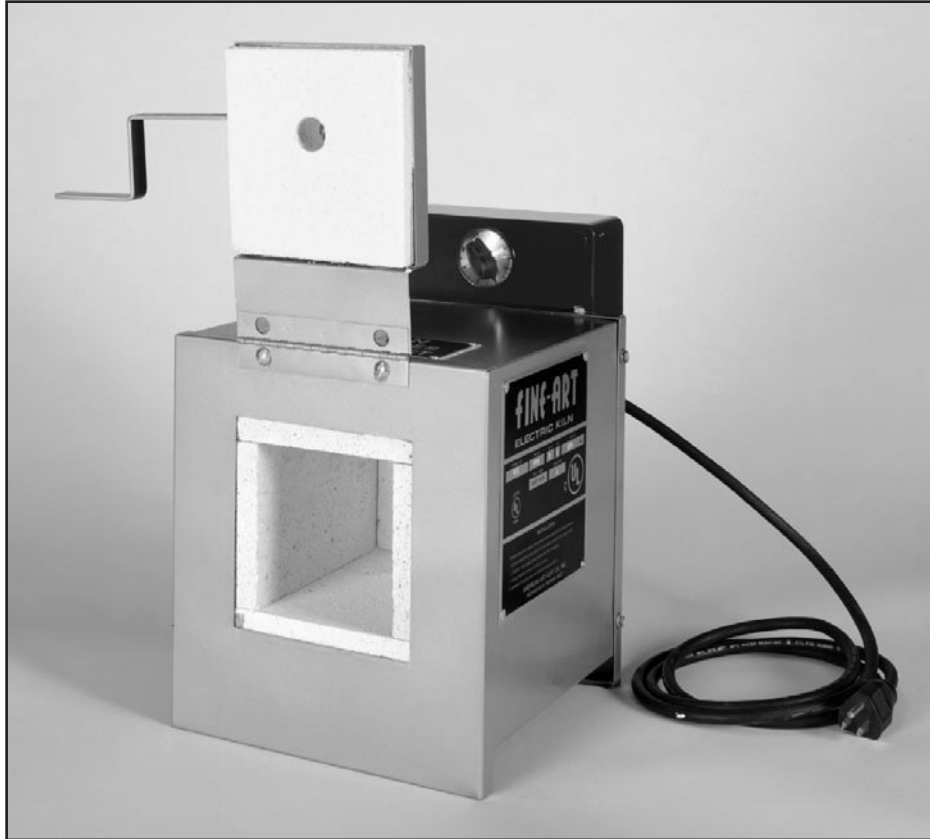


AMACO[®] Metal Enameling Kiln MK-4

110-120 Volts AC, Single Phase



AMACO® METAL ENAMELING KILN NO. MK-4

INSTALLATION

This kiln is equipped with a 15 amp supply cord and plug. A 110-120 volt, 8 amp outlet is required.

FIRING INSTRUCTIONS

Most metal enameling is done at a temperature of approximately 1500°F (815°C), allowing for some drop in temperature when the kiln door is opened to place in work. To prepare the kiln for enameling, turn the control switch to "Hi."

Set the Infinite control knob as follows to maintain the temperature indicated (the use of a pyrometer is also recommended):

Switch on #2 door closed	Kiln holds at 600°F
Switch on #3 door closed	Kiln holds at 975°F
Switch on #3½ door closed	Kiln holds at 1100°F
Switch on #4 door closed	Kiln holds at 1450°F
Switch on #4½ door closed	Kiln holds at 1460°F
Switch on #5 door closed	Kiln holds at 1550°F
Switch on #5½ door closed	Kiln holds at 1650°F
Switch on high door closed	Kiln holds at 2140°F
Switch on high started 7 a.m.	By 9:25 a.m. temperature will be 1750°F;
	By 9:30 a.m.—2100°F;
	By 3:20 p.m.—holding at 2140°F

The maximum recommended temperature is 2000°F.

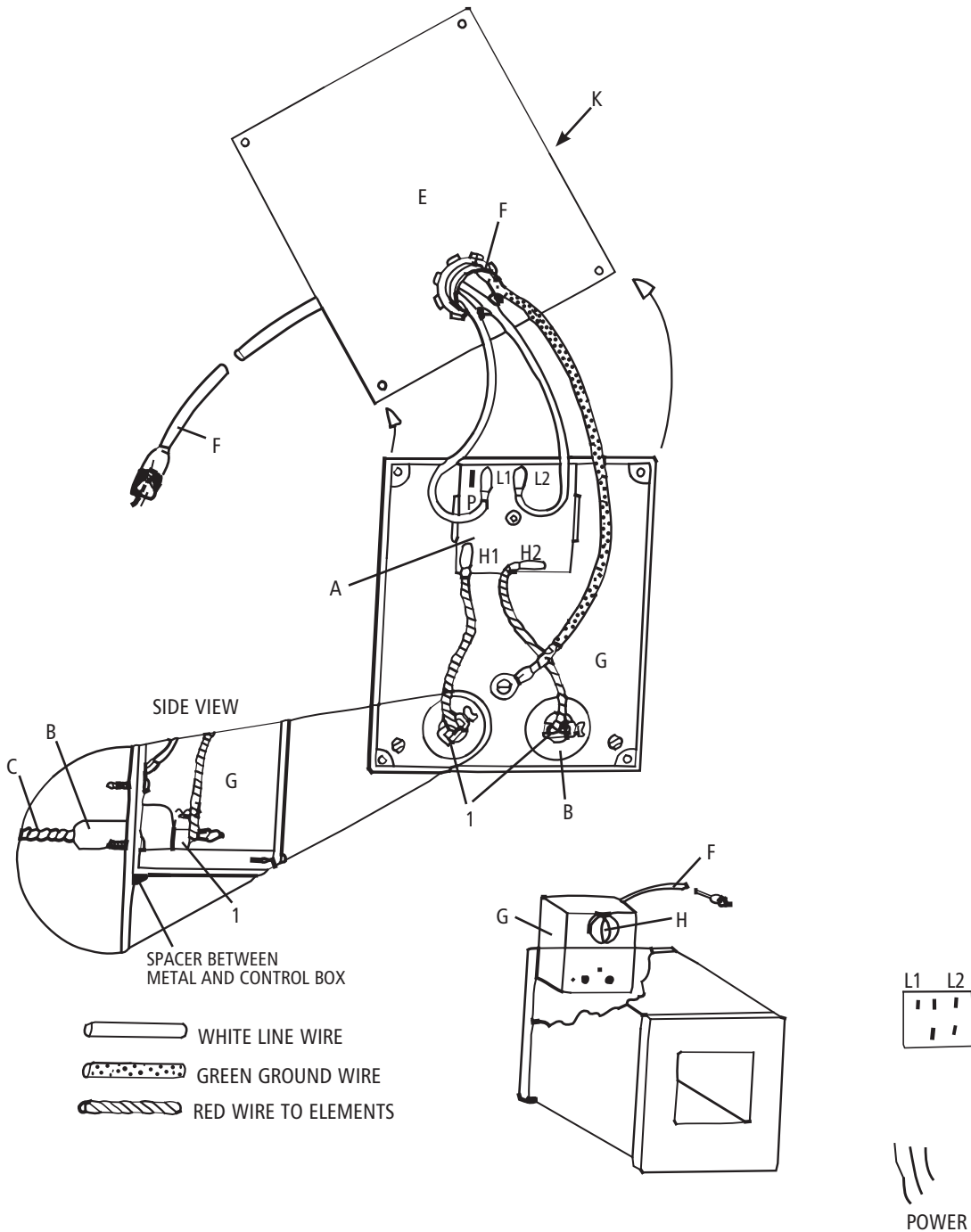
The kiln may be used for firing small clay pieces placed in cold kiln and fired as in any pottery kiln.

TESTING FOR DEFECTIVE ELEMENTS

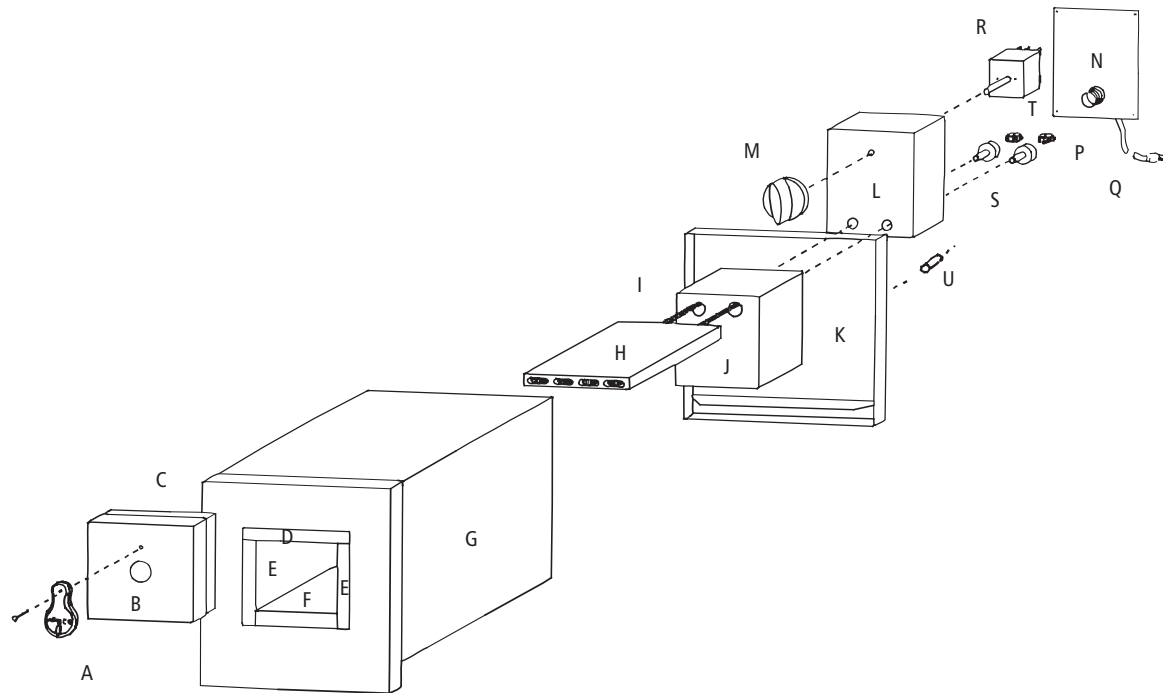
1. DISCONNECT KILN FROM RECEPTACLE! This safety measure MUST be followed.
2. Turn control switch to "Off" position. Remove metal protective guard on back of kiln. Element terminal wires will be exposed as they protrude from the wall of kiln. The wiring diagram indicates the position of these terminals as viewed from the rear of the kiln. Plug in test lamp (see page 7 in #2 Repair Manual). Contact terminals 1 and 2 with lamp leads. If lamp lights, element is good.

HEATING ELEMENT REPLACEMENT

When a broken coil is found, both coil and holder must be removed from the kiln. Always work on one coil at a time to avoid confusion. Disconnect element terminal wires from jumper wires. This will free the element assembly so it can be pulled through the back of the kiln. Remove the damaged coil from the holder and inspect the holder. Any foreign material in the holder that will contact the new coil will cause early coil failure. If the channels are clean, the holder need not be replaced—a new coil is then strung through the channels of the holder. Push the assembly back into place, carefully threading the twisted terminal wires through the porcelain insulator running through the back wall of the kiln. The terminals should be cut off, leaving only enough wire to reconnect the jumper wire. Ensure a very tight connection between the terminal and jumper wire by tightening the connector screw.



- A Infinite Control Switch 110V
- B Insulator
- C Element
- D 1/2" Straight Connector
- E Cover
- F 6' SJO 14-3 Power Supply Cord
- G Control Box
- H Switch Knob
- I Terminal Lug #10NPW
- J Need Ground Wire to Back Metal Plate Cover (Switch Box Cover)
- K Box Cover Control



REPLACEMENT PARTS LIST AMACO® METAL ENAMELING KILN MK-4

Detail No.	Part No.	Description	Parts/Kiln
A	29025C	Peephole Cover	1 ea.
B/G/K	*	Shell Complete	1 set
C	28909G	Brick; Door	1 ea.
D/F	28906K	Brick; Top/Bottom	1 ea.
E	28905H	Brick; Side	2 ea.
H	28919M	Holder, Element	1 ea.
I	28902T	Element, 120V	1 ea.
J	28904F	Brick; Back	1 ea.
L	22257B	Control Box	1 ea.
M	28128E	Infinite Control Knob, 120V	1 ea.
N	*	Cover Control Box	1 ea.
P	28930Y	Connector 1/2" Straight	1 ea.
Q	29970L	Supply Cord	1 ea.
R	28067B	Switch; Infinite 120V	1 ea.
S	28069D	Insulator, PT-12	2 ea.
T	28071F	Terminal Lug #10NPW	2 ea.
U	29930M	Spacer; 1/2"	2 ea.

* Special Order Item. Allow extra time for shipment.



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