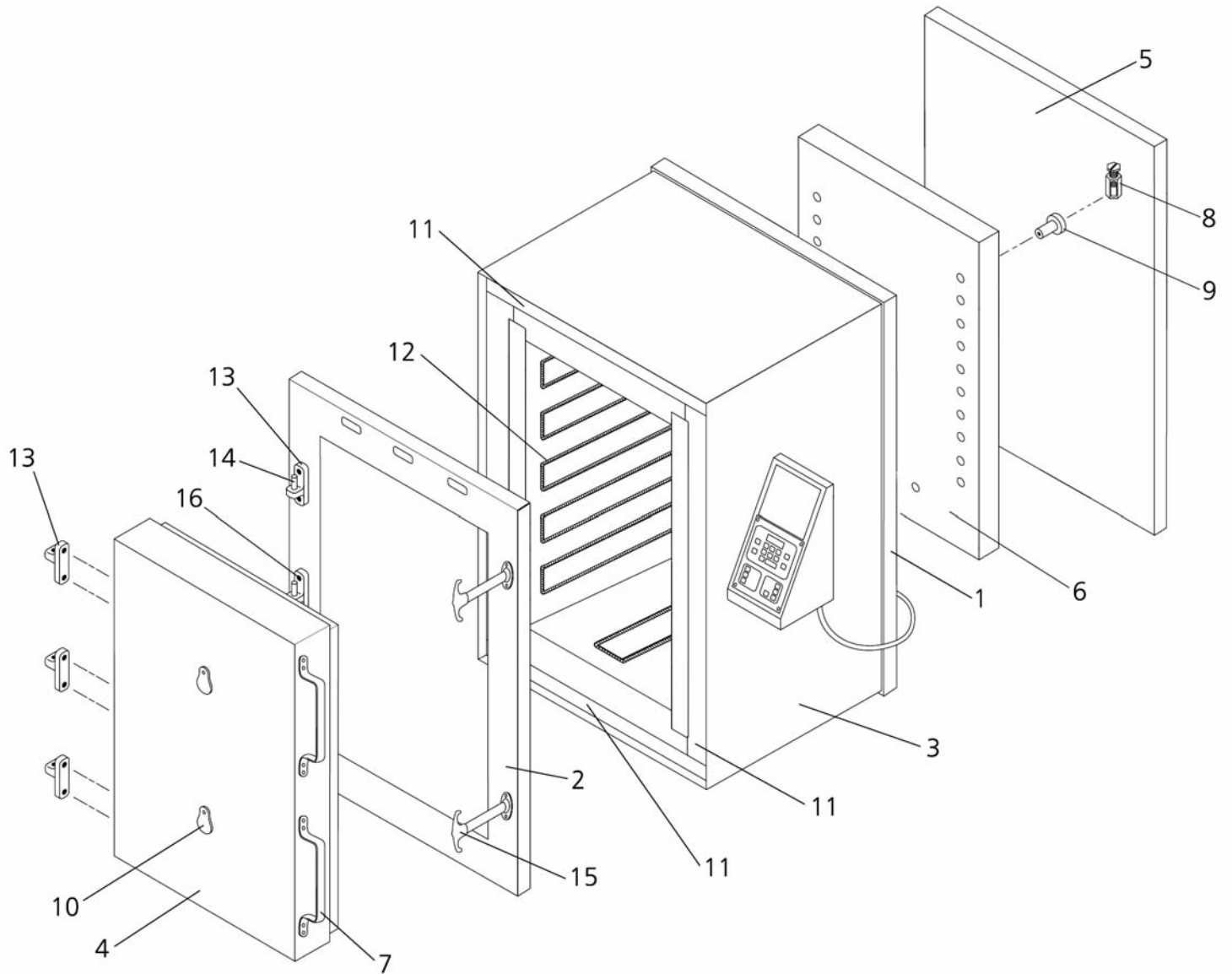


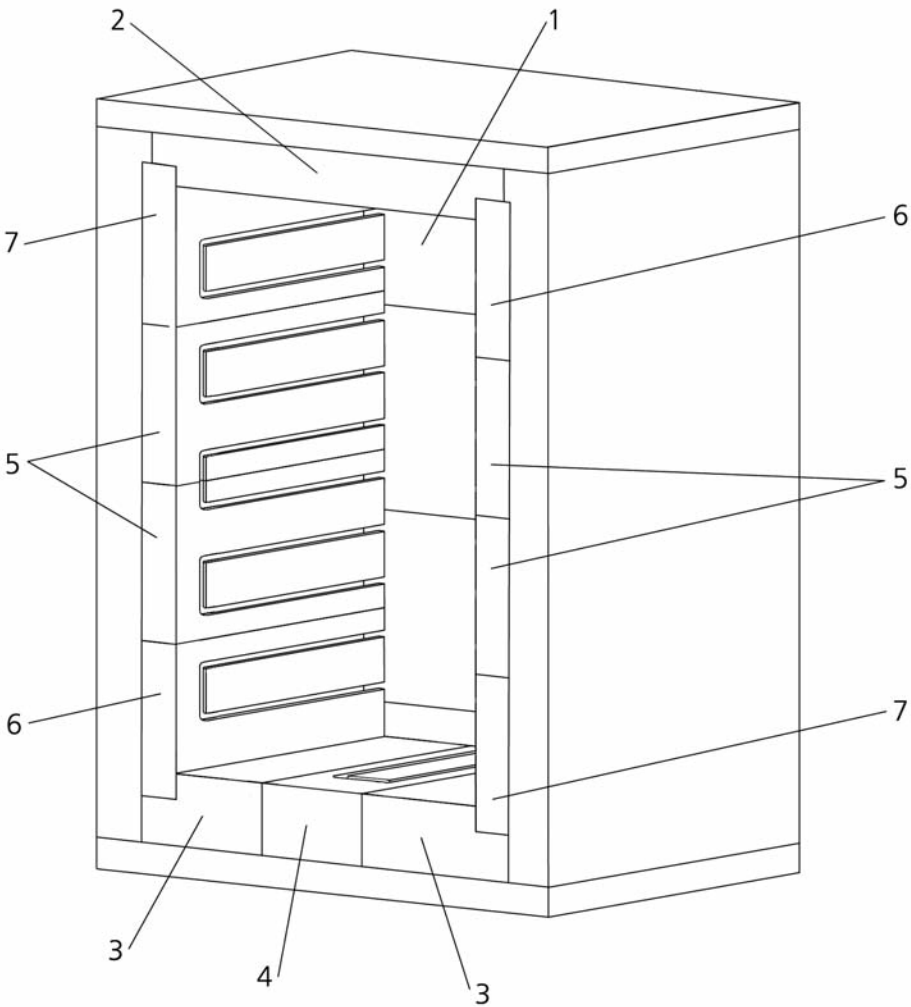
AMACO® High Fire Electric Kiln AH-25

208 or 220-240 Volts AC, Single and Three Phase



See page 2 for replacement parts list that corresponds to the numbers on this drawing.

BRICK LAYOUT AH-25



Detail No.	Part No.	Description	No. PER KILN
1	28001A	Brick, Back	4
2	28002B	Brick, Top, 3", milled ends, double groove	1
3	28005E	Brick, Bottom, milled, no groove	2
4	28007G	Brick, Bottom, double groove	1
5	28008L	Brick, Side, three groove	4
6	28011H	Brick, Side, upper right/lower left	2
7	28018R	Brick, Side, upper left/lower right	2



6060 Guion Road, Indianapolis, Indiana 46254
(800) 374-1600 • Fax (317) 248-9300 • www.amaco.com

REPLACEMENT PARTS LIST
AMACO® HIGH TEMPERATURE KILN
AH-25

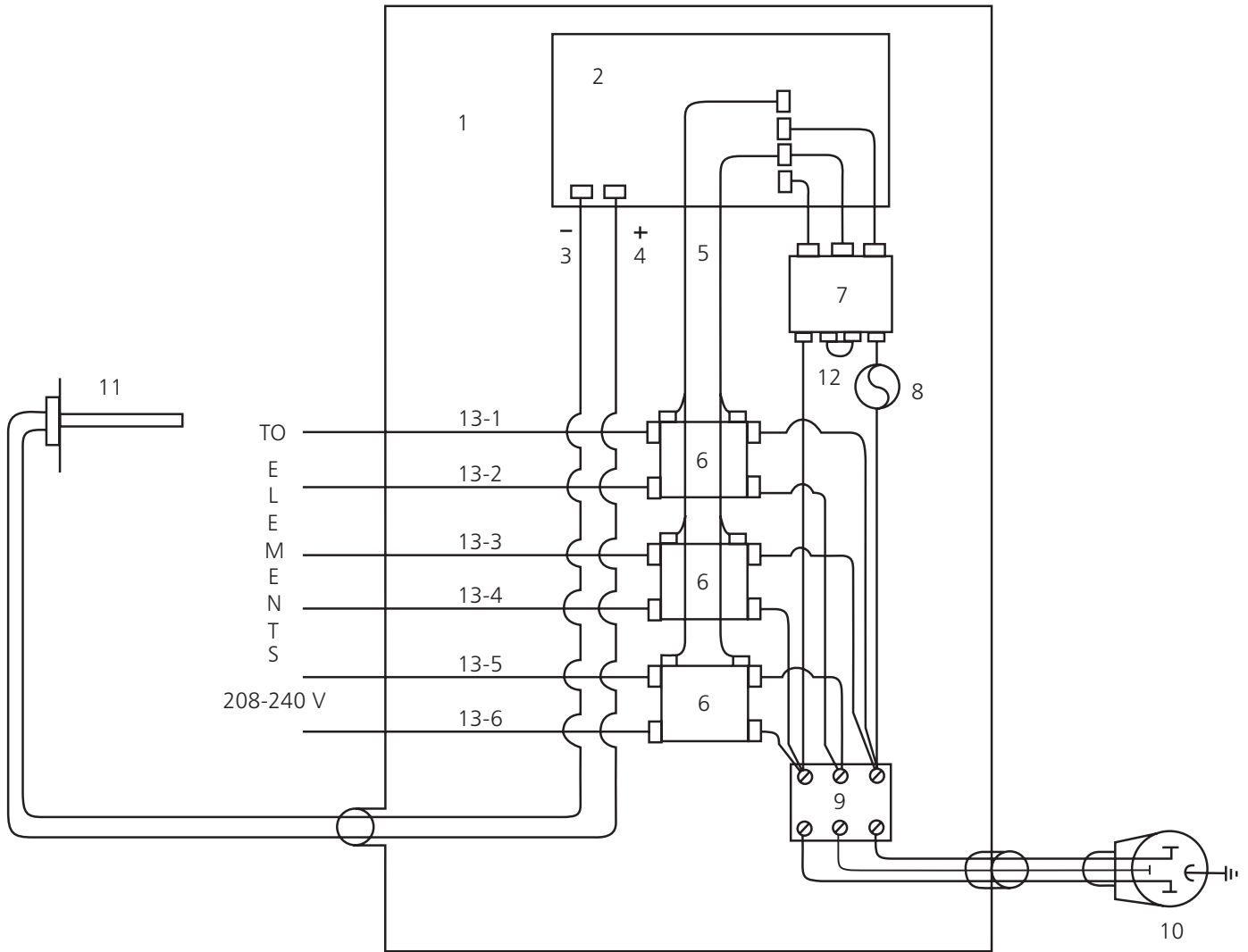
Detail No.	Part No.	Description	No. PER KILN
1	*	Back Frame	
2	*	Front Frame	1 set
3	*	Shell	
4	28274K	Door complete, no hardware	1
5	*	Terminal Guard, back	1
6	29785G	CEM-Fil (back panel)	1
7	28129H	Door Handle	2
8	28071F	Terminal Lug, #10-NPW	24
9	28034M	Insulator, P-3580	24
10	29025C	Peephole cover	2
11	28272H	Insulation, Top	1 set
11	28268D	Insulation, Sides	2 sets
11	28271G	Insulation, Bottom	1 set
11	28262J	Insulation, Back	1 set
12	28644M	Element Coil, 208V, Single Phase	12
12	28647S	Element Coil, 208V, Three Phase	12
12	28645P	Element Coil, 240V, Single Phase	12
12	28648T	Element Coil, 240V, Three Phase	12
13	28073H	Hinge, Door	6
14	28072G	Hinge, Pin	3
15	28153X	Latch, Door	2
	29958G	Kiln-Vent, Kiln Mount 115V, 1.1 amp	1
16	+	Hinge Bolts (self-tapping)	12

* Special Order Item. Allow extra time for shipment.

+ Standard Hardware/Electrical Item available locally.

Prices available upon request

SELECT FIRE™ Automatic Kilns 3 Relay Three Phase



- | | | | |
|---|--------------------------------------|----|-----------------------------|
| 1 | Select Fire™ Master Panel | 8 | Fuse |
| 2 | Select Fire™ Electronic Control Unit | 9 | Terminal Block |
| 3 | Red Wire | 10 | 208/240V Plug |
| 4 | Yellow Wire | 11 | Thermocouple |
| 5 | Control Signal Wire | 12 | Jumper Wire for Transformer |
| 6 | Relay | 13 | Wires to Terminal Strip (6) |
| 7 | Transformer | | |

General Information

The AMACO® AH-25 High Fire Kiln has a maximum attainable temperature of Cone 8 (2320°F, 1271°C). The average fast-fire time required for this kiln to reach 1950°F (1066°C) is 7 to 8 hours. The AH-25 is equipped with the Select Fire™ Computer Control for precise control, convenience, and consistent results firing after firing. During every firing, pyrometric cones should be placed in the kiln so that they can be viewed through the peephole (s).

This booklet contains a wiring diagram for the AH-25 kiln, Select Fire™ Controller (single and three phase) and a parts list with accompanying drawing for the AH-25 and Select Fire™. Before installing the kiln, consult these diagrams for recommendations on electric service, fuses, etc.

Also included with this booklet is an AMACO® Electric Kilns Installation/Operation/Maintenance manual, which includes important information about selecting a location for your kiln, firing guidelines, and do-it-yourself instructions for replacing elements, plus complete programming and operating instructions for the Select Fire™ Controller.

Testing For Defective Elements and Improper Heating

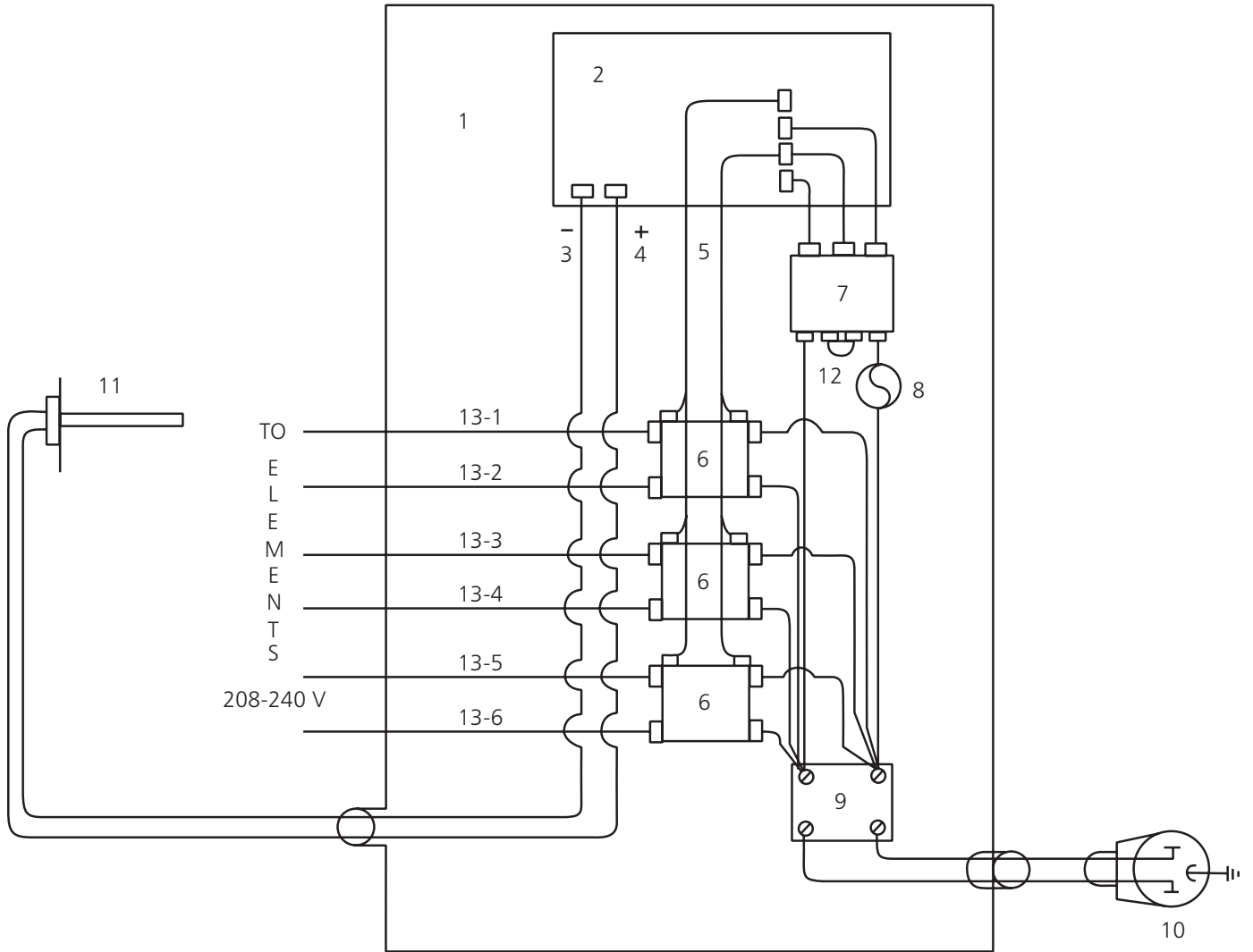
Use the diagram below, the AH-25 Wiring Diagram, along with the information found in the Installation/Operation/Maintenance manual to safely inspect and replace elements. The diagram below indicates the position of the coil terminal wires as viewed from the rear of the kiln. Plug in test lamp and touch lamp leads to terminals 1 and 2. If lamp lights, the circuit is good. Proceed with the other coils, connecting 3 and 4, 5 and 6, etc. Any connections where lamp fails to light will indicate a defective coil.

AH-25 Specifications

(single and three phase)

Voltage	208 or 220-240V AC only
Amp Rating	34 amps (208V, 3 phase) 39 amps (240V, 3 phase) 45 amps (208/240V 1 phase)
Kilowatt Rating	10.8 to 7.7
Firing Speed Control	Select Fire™ Computer Control
Maximum Temperature	Cone 8 (2320°F, 1271°C)
Firing Chamber Dimensions (W x D x H)	20" x 20 1/2 x 29 1/2"
Firing Chamber Area	7 cu. ft.
Exterior Dimensions (W x D x H)	46 1/2" x 37 1/2" x 66"
Elements	12
Shipping Weight	750 lbs.

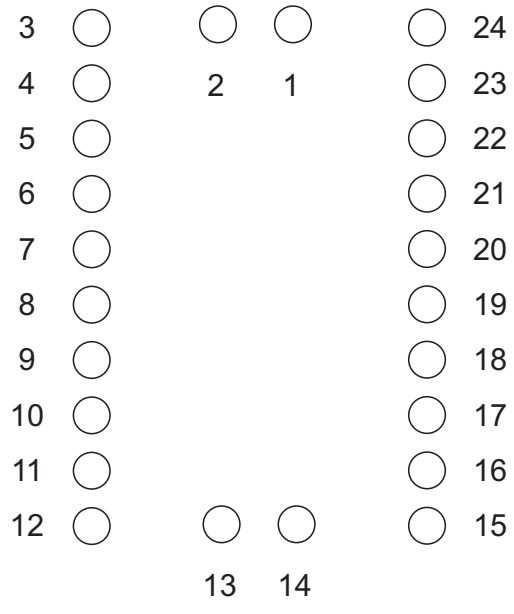
SELECT FIRE™ Automatic Kilns 3 Relay Single Phase



- | | | | |
|---|--------------------------------------|----|-----------------------------|
| 1 | Select Fire™ Master Panel | 8 | Fuse |
| 2 | Select Fire™ Electronic Control Unit | 9 | Terminal Block |
| 3 | Red Wire | 10 | 208/240V Plug |
| 4 | Yellow Wire | 11 | Thermocouple |
| 5 | Control Signal Wire | 12 | Jumper Wire for Transformer |
| 6 | Relay | 13 | Wires to Terminal Strip (6) |
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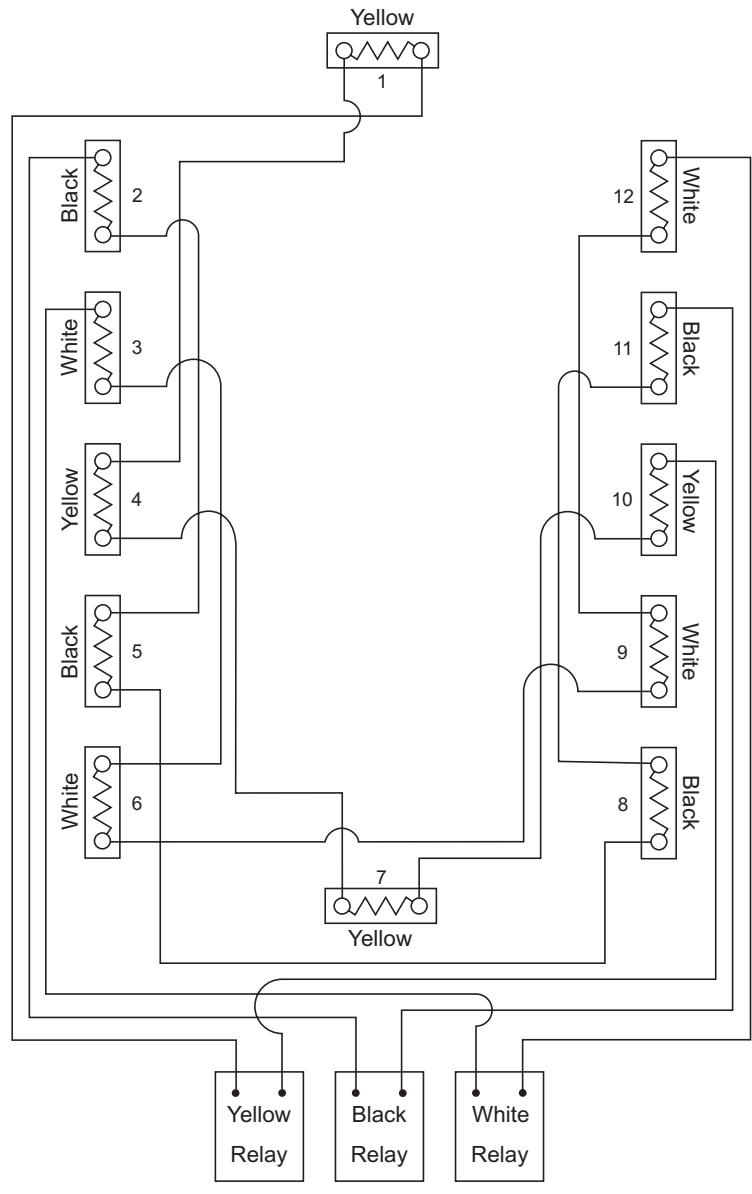
AH-25 Testing Diagram

Element terminals, Rear View



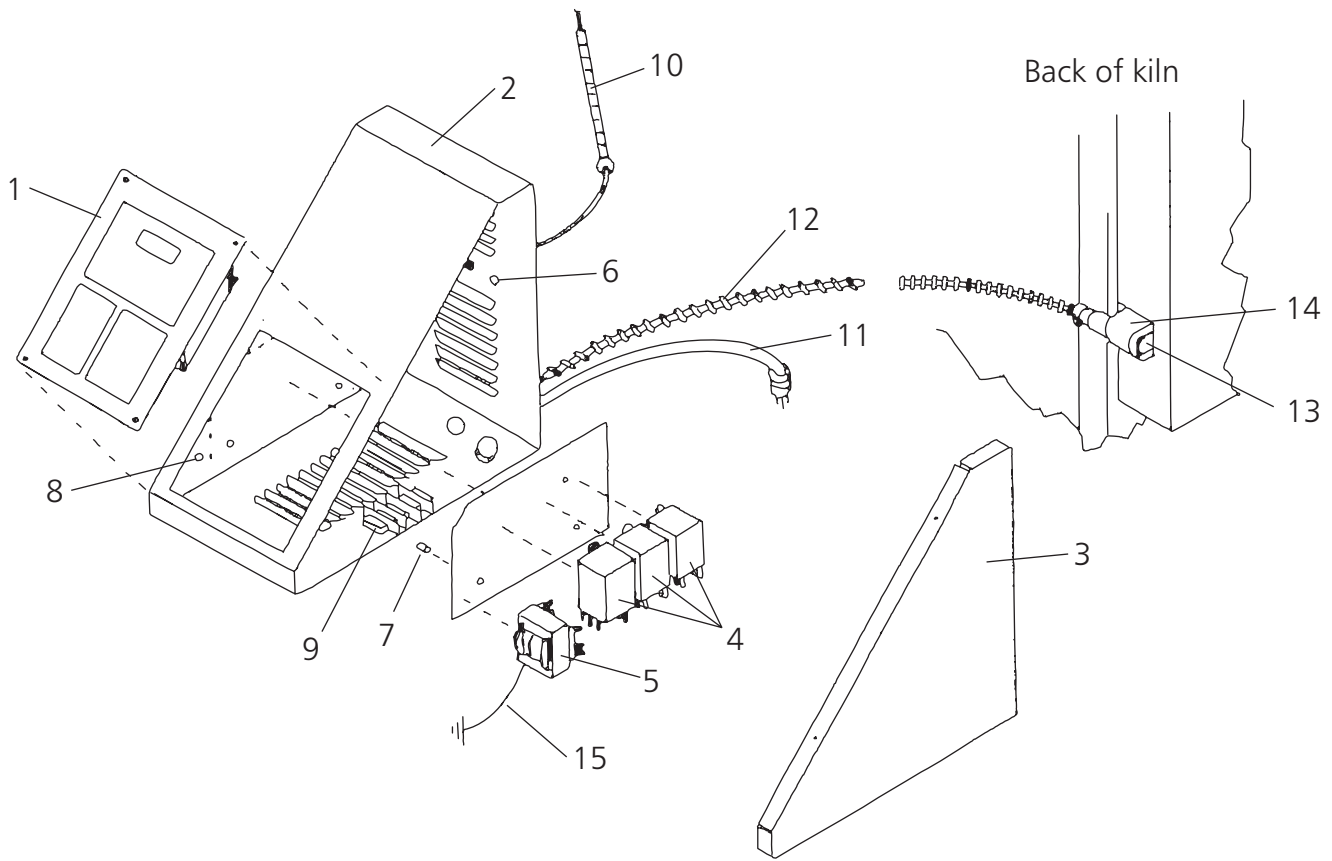
AH-25

208 or 220-240 volts AC
Single and Three Phase



REPLACEMENT PARTS LIST

SELECT FIRE™ COMPUTER CONTROL



1	24250P	Select Fire Control	1
2	*	Select Fire Control Box	1
3	*	Select Fire Control Box Cover	1
4	24276H	Relays	3
5	24278K	Transformer	1
6	22134W	Fuse Holder	1
7	*	3/16" spacer	3
8	*	5/8" spacer	3
9	27749M	Terminal Block, 60 amp	1
10	28845T	Thermocouple, 72" long lead wire	1
11	27759A	Power cord with plug, single phase	1
11	28674D	Power cord with plug, three phase	1
12	*	Power to coils	1
13	28418L	Conduit Fitting	1
14	28419M	Conduit Cover	1
15	*	Ground (14 gauge wire)	1

*Special order item. Allow extra time for shipment.