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KLB

## A BIG KILN That Operates on Little Energy

- Firing chamber is 16" (40.6 cm) square x 6" (15 cm) deep.
- Kiln walls and lid are fabricated using Kaiser Lee Board.
- Unit Runs on a standard household 110V / 15Amp outlet.

The Kaiser Lee Board Kiln manufactured by AIM Kiln has been on the market since March 2007 and that means it has had extensive 'real use testing' for more than 1 year. This kiln has the deepest inside firing chamber of any kiln currently available that can plug into a standard 110V / 15Amp household outlet. The inside chamber measures 16" x 16" x 6" (40.6 x 40.6 x 15 cm). It is built in 3 sections, the bottom, the center (with the heating elements) and the lid - similar to the AIM Hot Box kiln. This gives the opportunity to place a KLB kiln shelf directly on the kiln bottom then place the kiln center section on the KLB shelf, enabling use of the full 6 inches (15 cm) in height for your projects.



The kiln lid does not have any heating coils and that also means no loss of kiln space. In other kilns this may be a concern but the heat reflective property of the KL-Board provides the even heat distribution needed for big pieces of glass. Superior insulation value equals low cost firings - currently running at less than 50 cents per regular full fuse firing (at 2008 Lee County FL electricity costs). When you combine this kiln's power saving advantage with the option to full fuse and shape your glass with KL-Board molds you will save even more energy.



## Preparing a New KLB Kiln Before the Initial firing

We know that Kaiser Lee Board does cast off some dust. To prevent the dust falling from the lid and sides we recommend a coating of Hot Fire kiln wash using a solution of 5 parts water and 1 part Hot Fire powder (be very careful to avoid getting kiln wash on the heating coils). While you're at it you may also want to use a sanding block to smooth down the KLB kiln shelf and Hot Fire kiln wash it as well (be sure to 'cure-fire' all kiln washed components to ensure all the moisture is gone). Unlike kiln wash on ceramic molds, where the kiln wash flakes off after a few firings, Hot Fire kiln wash on KL-Board is bonded permanently. (Note: Do not use Primo Primer for this, as it turns to dust after every firing.) We never recommend full fusing on a KLB shelf or mold that has been kiln washed - since kiln wash may stick to your glass and the board in turn sticks to the kiln wash. Always place an additional release, like Kiln-Liner or dry kiln wash powder, between your glass and a kiln washed mold or shelf.

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# Fuse and Slump in ONE FIRING using a KLB Mold and Kiln



# KLB

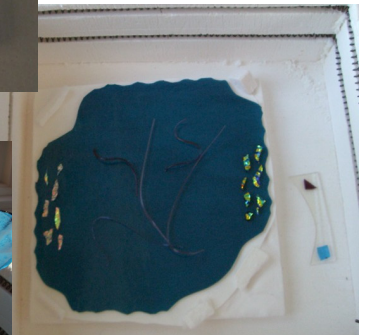
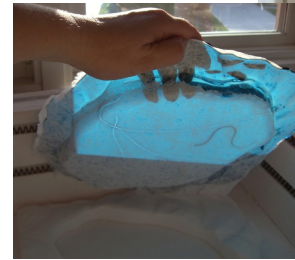
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Here's a quick and fun project to get you started with your KLB Kiln. First be sure to prepare your kiln by following the simple steps outlined on the other side of this flyer.

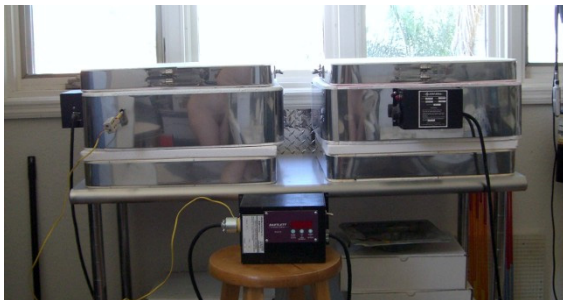
Use any size KL-Board you want (as long as it fits inside your kiln chamber) and cut an opening in the center following any shape you desire, the only limitation is you must leave a minimum 1 1/2" (3.8 cm) wide frame all around. If you like, you could carve a design into the top surface board that will create a texture on your finished slump project (see photo at right). Next cut a piece of fusing glass at least 1" (2.5 cm) larger on all sides than the opening, but not so large that it overhangs the mold. Now cut a piece of release paper slightly larger than your glass, place it on top of the mold and place your clean glass on top of the release paper.

Finally add the decorative touches, using fusing compatible glass, stringers, powders and/or frit. During the firing the smaller decorative pieces will tack fuse to the base glass and hold their position before the glass begins to slump. The thin release paper will droop down with the glass and turn to dust, preventing the glass from sticking to either the mold or the kiln shelf.

Place your 'All-In-One Firing' project in your kiln, close the lid and program the controller using the following firing schedule: Set the **first segment** to ramp up at 600°F/333°C per hour to 1000°F/538°C and hold for 10 minutes. The **second segment** will ramp up AFAP (as fast as possible) to 1460°F/793°C and hold for 10 min (some kilns may need a bit more time for the slump to be perfect, be sure to observe your work by opening the kiln a crack to take a look). Set the **third segment** to ramp down AFAP to 960°F (515°C) and hold for 30 minutes. The **fourth segment** is a ramp down at 300°F/165°C per hour to 700°F/370°C and hold for 5 minutes (this ramp down and hold is a safety measure for colder regions). Finally set the controller to turn the kiln off and let it cool down on its own with the lid tightly close to room temperature.



## DIGITAL CONTROLLER



Most fusing kilns have their digital controller built into the kiln, creating one unit. The KLB kilns use a stand-alone digital controller called a Field Kit. Simply plug the Field Kit into a 110V / 15Amp outlet then plug the kiln into the controller and insert the thermocouple into the hole provided in the side of the kiln. Now set the digital controller to follow the desired firing schedule and you set to fire. Incidentally, the digital Field Kit works with any 110 Volt kiln.

Please visit [www.kaiserlee.com](http://www.kaiserlee.com) to download and print our easy to understand instruction sheet for programming either the Bartlett or the Orton digital Field Kit controllers.

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