

Wood-Mizer



User Manual *KD250Pro*

Wood-Mizer
World Headquarters

Wood-Mizer LLC
8180 West 10th Street
Indianapolis, IN 46214

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Getting Service

Wood-Mizer is committed to providing you with the latest technology, best quality and strongest customer service available on the market today. We continually evaluate our customers' needs to ensure we're meeting current wood-processing demands. Your comments and suggestions are welcome.

General Contact Information

Toll free phone numbers are listed below for the *continental* U.S. and Canada. See the next page for contact information for more Wood-Mizer locations.

	United States	Canada
Sales	1-800-553-0182	1-877-866-0667
Service	1-800-525-8100	1-877-866-0667
Website	www.woodmizer.com	www.woodmizer.ca
E-mail	woodmizer@woodmizer.com	oninfo@woodmizer.com

Office Hours: All times are Eastern Standard Time.

Monday - Friday	Saturday (Indianapolis Office Only)	Sunday
8 a.m. to 5 p.m.	8 a.m. to 12 p.m.	Closed

Please have your vehicle identification number and your customer number ready when you call.

Wood-Mizer will accept these methods of payment:

- Visa, Mastercard, or Discover
- COD
- Prepayment
- Net 15 (with approved credit)

Be aware that shipping and handling charges may apply. Handling charges are based on size and quantity of order. In most cases, items will ship on the day they are ordered. Second Day and Next Day shipping are available at additional cost.

If your equipment was purchased outside the United States or Canada, contact the distributor for service.

⚠️ WARNING Read through entire manual before installing, operating, or servicing this unit. Failure to follow any steps or guidelines could result in personal injury, death, destruction of property or may cause the unit to become inoperable. These are the "original Instructions for this unit." **This manual must be kept with the unit at all times.**

Safety Guidelines

Precautions

Do not operate if the unit or any of its parts:

- Have been exposed to fire.
- Have been submerged in or exposed to excessive water.
- Has significant interior or exterior damage.

If any of the above are suspected make sure to have your unit serviced by a qualified professional before continuing operation.

*The unit is rated for an ambient temp of 10-40° C, 80 RH % at a maximum 200 meters.

Electrical Grounding

The unit must be grounded.

Failure to ground the unit will result in unreliable performance or an inoperative unit. You can ground the unit by connecting the unit to a grounded metal, permanent wiring system. Make sure the unit is in accordance with national and local electrical codes. If you don't know the building codes in your area or need more information, please contact your municipal office.

*Normally airborne noise is rated at 77 dB.

⚠️ WARNING Refrigerant!

- Unit contains R-134a refrigerant under high pressure. Refrigerant must be recovered to relieve pressure before servicing.
- DO NOT use unapproved refrigerants, substitutes or additives.
- Failure to abide by these guidelines can result in death, injury and property damages.
- Contact Wood-Mizer's service department for more information on refrigerant options.

⚠️ WARNING

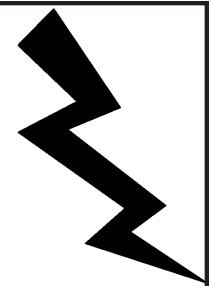
High Temperatures!



- Kiln chamber can reach internal temperatures of over 90°F. Working in these temperatures can cause heat stroke and minor burns.
- Pregnant women, children, the elderly and those with significant health issues are at higher risk of heat stroke and must be supervised in high temperatures.
- Kiln operators should check for temperature and take proper safety precautions before entering the kiln chamber.

⚠️ WARNING

Electrical Shock!

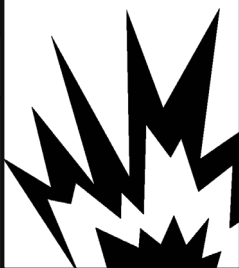


- Turn off power to unit before service.
- Make sure wires are labeled before disconnecting.
- Test unit after reconnecting wires.
- Failure to do the above could result in death or injury.

⚠️ WARNING

Explosion Hazard!

- DO NOT purge or pressurize this system with oxygen to test for leakage. Using oxygen may cause explosive reaction.



⚠️ WARNING Supervision!

- The appliance is not to be used by person (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction.
- Supervised children are not to play with the appliance.

Your Kiln

How your Dehumidification Kiln Works

Thank you for purchasing a **Wood-Mizer** DH Kiln and taking the first step towards making the lumber industry cleaner and more efficient! Years of development, innovation, and the highest quality materials have gone into building your kiln. It's our dedication to efficiency that sets **Wood-Mizer** kilns apart from the rest, making your system the best on the market.

During kiln drying, moisture from green lumber is evaporated into the air, increasing the humidity inside the chamber. The lumber can't continue to dry if the air becomes over-saturated. Therefore the moisture must be periodically removed from the chamber. In a conventional kiln, moisture would be expelled through venting. Venting causes a significant loss of heat, resulting in a waste of energy to bring the kiln back up to temperature.

Instead of venting, **Wood-Mizer** Dehumidification Kilns utilize a refrigeration system that condenses the excess moisture. This moisture is then drained off, retaining the existing heat energy. After the moisture is removed and heat is reintroduced to the dry air, it is pumped back into the kiln chamber to start the process over. Unlike conventional kilns, the heater in your **Wood-Mizer** Kiln is only used during the initial warm-up. Sometimes, temperature increases are desired during the cycle, saving you time and money. But that's not all your new kiln has to offer!

Though **Wood-Mizer** kilns don't rely on venting to remove moisture, a Vent System is supplied to add extra control of your kiln temperature. If the internal kiln temperature exceeds what's required, these vents can be opened to remove excess heat and bring the temperature back to where it needs to be.

Finally, **Wood-Mizer** offers a wide variety of upgrades and accessories to enhance your kiln drying experience. See the upgrades and accessories section on page 45 for more information. By purchasing a **Wood-Mizer** Kiln, you have the support of **Wood-Mizer's** service team, the very same professionals that built and tested your unit. Enjoy your new system!

Getting Started

Please read through carefully as some options may not apply.

Floors

A Concrete floor with insulation installed underneath is recommended for best results. However, if the kiln will be on an existing concrete floor, the insulation may be omitted. Concrete must not extend beyond the kiln walls.

Wood floors may be used but must be built to construction guidelines (see Pg 3)

Ceilings

If the kiln chamber is a freestanding outside building, the attic space must be well ventilated through the eaves. This is done to avoid any moisture buildup in this space, which will condense on the cold roof and drip onto the insulation.

An interior kiln can have the ceiling insulation open to the atmosphere.

The ceilings must be built to construction guidelines. (Pg 3)

Doors

At the front of the kiln chamber, install bay/loading doors with at least two sides hinges and a center door latch to close (recommended). Top hinged or lift-off doors are also acceptable.

At least one access door should be installed in the back of the chamber to allow dehumidifier servicing and/or lumber monitoring.

All installed doors must:

- Be built to construction guidelines. However, they may be lightened by increasing the stud spacing and using 3/8" plywood. The lighter weight will reduce the load on the hinges.
- Have a vapor barrier.
- Have gaskets wherever the door meets the kiln; this will give a good, airtight fit.
- Have a scraper-type weather strip to reduce air leakage if the door sill is not present.

- Close tightly against the gasket using turn-buckles, tarp straps, lag studs with wing nut, etc.

Remember: There will be considerable expansion and contraction during kiln use, so it is imperative to plan your kiln door construction accordingly.

While outside electronic moisture meters can be used to avoid entering the kiln during the drying cycle, Wood-Mizer strongly recommends regular checks inside the kiln to visually inspect the surface or ends for checks, mold, stain, as well as testing with a handheld meter.

Construction Guidelines

Please reference "The Chamber Plans" for more information on construction.

Step 1: Build all walls, ceilings, and floors with a 2" x 4" framework using blue or pink Styrofoam (extruded polystyrene) friction fitted between the studs.

Step 2: Cover the interior face of the studs with a 1" layer of Celotex Thermax (for better results, overlap two ½" layers).

Celotex Thermax is a foil-faced polyisocyanurate (urethane) board that is orange or yellow and is available in 4' x 8' sheets of various thicknesses. Celotex Thermax is a trade name; similar products under other names are acceptable.

Note: If you want to use spray foam insulation, only use urethane-based spray foam applied at 2.2lb/cu ft. Fiberglass is never recommended.

Step 3: Caulk joints and nail heads with a high-temperature silicone (optional: apply aluminum tape over silicone)

Step 4: Cover Thermax with one or two layers of 6 mil polyethylene, then enclose with ½" CDX or marine grade plywood.

Step 5: Coat CDX interior surface with "mobile home or metal roofing aluminum paint"

Note: Paint is an asphalt-based coating with powdered aluminum and fiber for strength, available in most hardware stores. Re-coat as necessary every year.

Step 6: Finish exterior walls to suit your tastes, but avoid galvanized steel or other ferrous sidings.

Once you have completed the construction of the kiln chamber, install the following air deflectors and baffles to control the airflow within the chamber.

Baffles and Deflectors

Do not underestimate the effect of baffling. Correct baffling will result in faster and more even drying. The benefits more than offset the extra time and effort to place the baffles correctly.

Corner deflectors: typically made of plywood, are used to help turn the airflow.

Top Baffle: A hinged baffle that falls from the fan wall to the top of the load used to compensate for different load sizes and allow for shrinkage of the board pile.

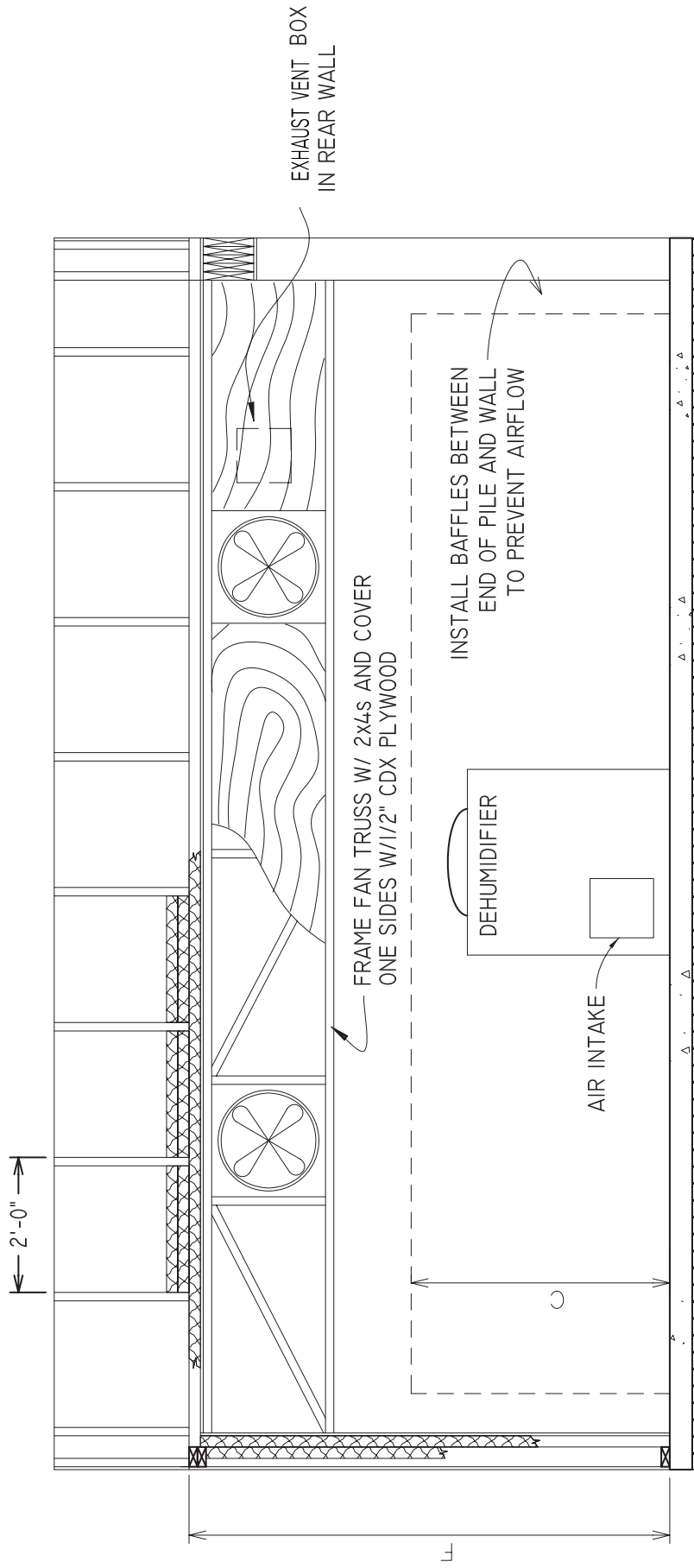
Side Baffle: A baffle that closes in the open space when the lumber does not fill the entire width. This baffle can be fixed or portable.

Please reference pg 14 for more information on deflectors and baffles.

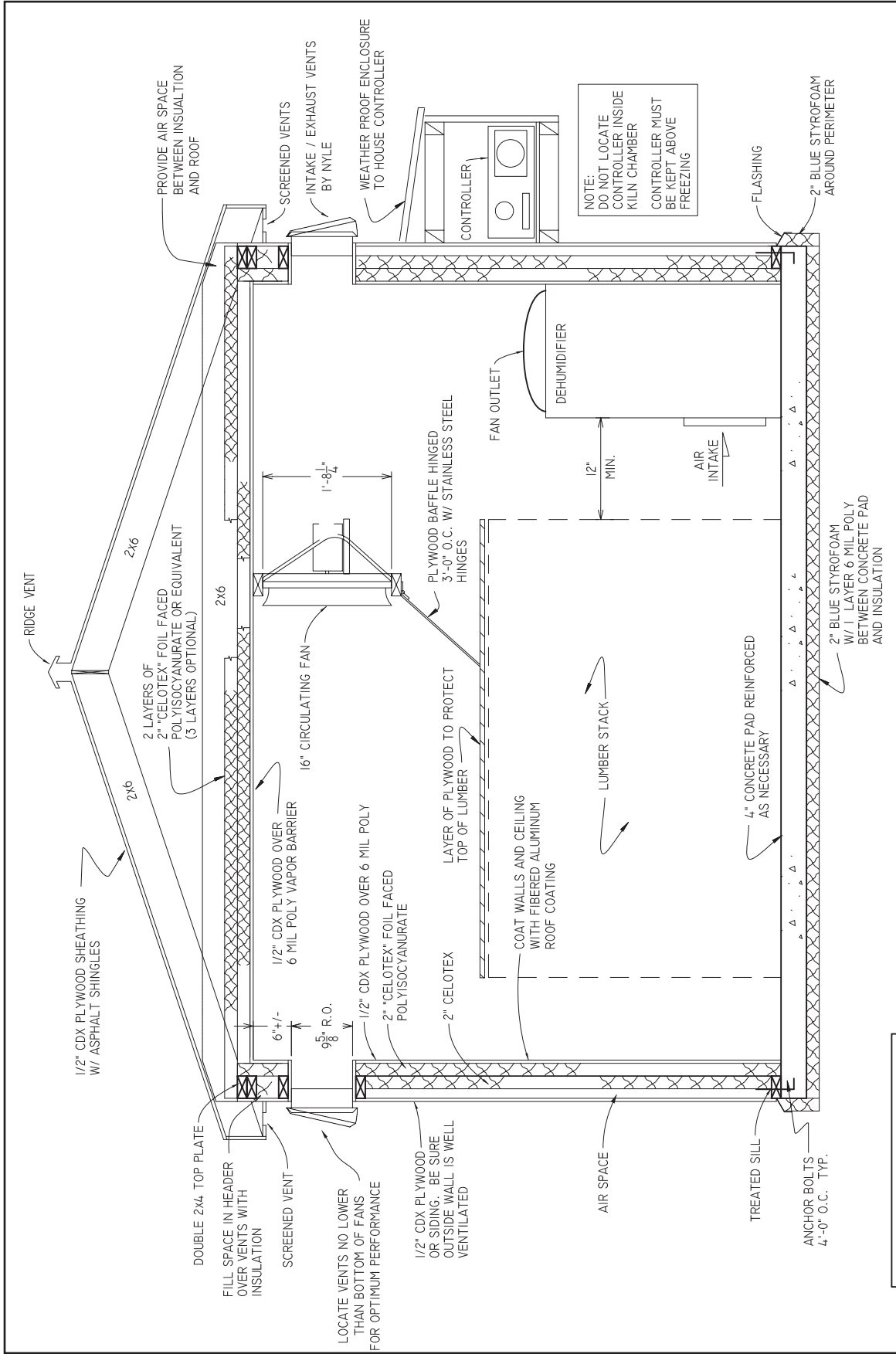
Power Vent

The Power Vent is to be secured to the inside of the kiln wall with the fan side facing the exterior.





SECTION THROUGH KILN CHAMBER C
6



NOTE:
DO NOT LOCATE
CONTROLLER INSIDE
KILN CHAMBER
CONTROLLER MUST
BE KEPT ABOVE
FREEZING

NOTE:
COAT INTERIOR OF KILN WITH
KILN COATING OR FIBERED ALUMINUM,
ASPHALT BASED METAL ROOF COATING
TO PREVENT DETERIORATION

SECTION THROUGH KILN CHAMBER D
6

Chamber Dimensions

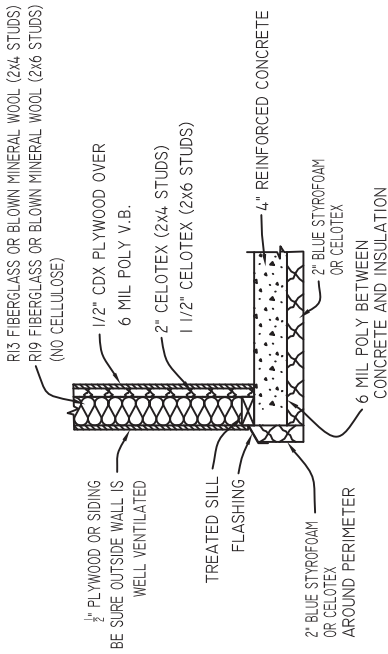
BOARD FT.	8' LUMBER										12' LUMBER										16' LUMBER													
	SIZE OF PACKAGE					SIZE OF BUILDING INSIDE					SIZE OF PACKAGE					SIZE OF BUILDING INSIDE					SIZE OF PACKAGE					SIZE OF BUILDING INSIDE								
	A	B	C	D	E	F	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES	LENGTH (FT)	WIDTH (FT)	HEIGHT (FT)	NO. OF COURSES
300	8	3	26	13	9	7	6																											
500	8	3	42	21	9	7	6	12	3	28	14	13	7	6																				
750	8	4	46	23	9	8	6	12	3	42	21	13	7	6																				
1000	8	4	62	31	9	8	8	12	3	54	27	13	7	7																				
1500								12	4	62	31	13	8	8																				
2000								12	4	82	41	13	8	10																				
2500								12	6	70	35	13	10	9																				
3000								12	6	82	41	13	10	10																				
3500																																		
4000																																		

WIDTH DIMENSIONS ARE MINIMUM ACCEPTABLE.
 COURSES BASED ON NOMINAL 1" ROUGHSAWN LUMBER ON 3/4" STICKERS.

BUILDING DIMENSIONS ARE FOR OPEN SPACE INSIDE INSULATION.

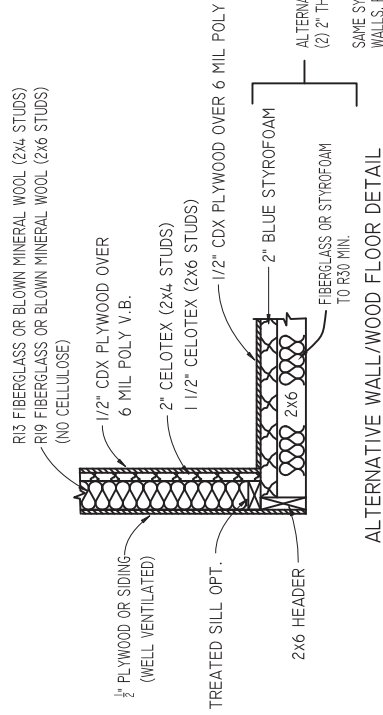
ADDITIONAL INTERIOR CLEARANCE IS REQUIRED FOR USE OF A KILN CART.

Wall Details



ALTERNATIVE WALL/CONCRETE FLOOR DETAIL

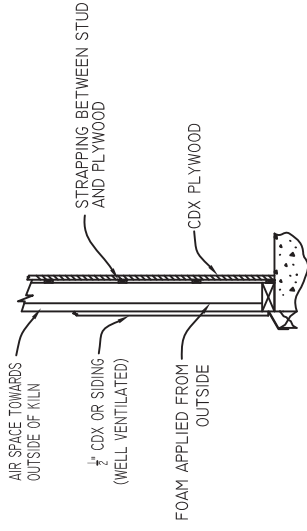
NOTE:
ALTERNATIVE CONSTRUCTION METHODS MAY BE USED IN WALLS AND CEILING.



ALTERNATIVE WALL/WOOD FLOOR DETAIL

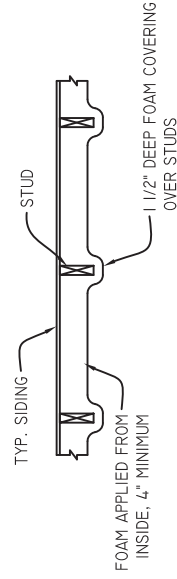
NOTE:

- 1) POLYSOCYANURATE INSULATION BOARD (CELOTEX, THERMAX, OR TUFF-R) IS STRONGLY RECOMMENDED FOR INTERIOR INSULATION SHEATHING. 1" IS SHOWN BUT THICKER IS PREFERRED ESPECIALLY IF USING FIBERGLASS OR BLOWN MINERAL WOOL INSULATION.
- 2) DO NOT USE CELLULOSE OR EXPANDED POLYSTYRENE (WHITE STYROFOAM) INSULATION IN THE DRYING KILN
- 3) ALL INTERIOR FASTENERS SHOULD BE STAINLESS STEEL.
- 4) INSTALL INTAKE/EXHAUST VENTS AT CONVENIENT ELEVATION TO ALLOW FOR MANUAL ADJUSTMENT.
- 5) POWERED VENT SYSTEM AVAILABLE. CONTACT NYLE. FIT SAME ROUGH OPENINGS.
- 6) COAT INTERIOR WALL AND CEILING SURFACES WITH FIBERED ALUMINUM ROOF COATING.



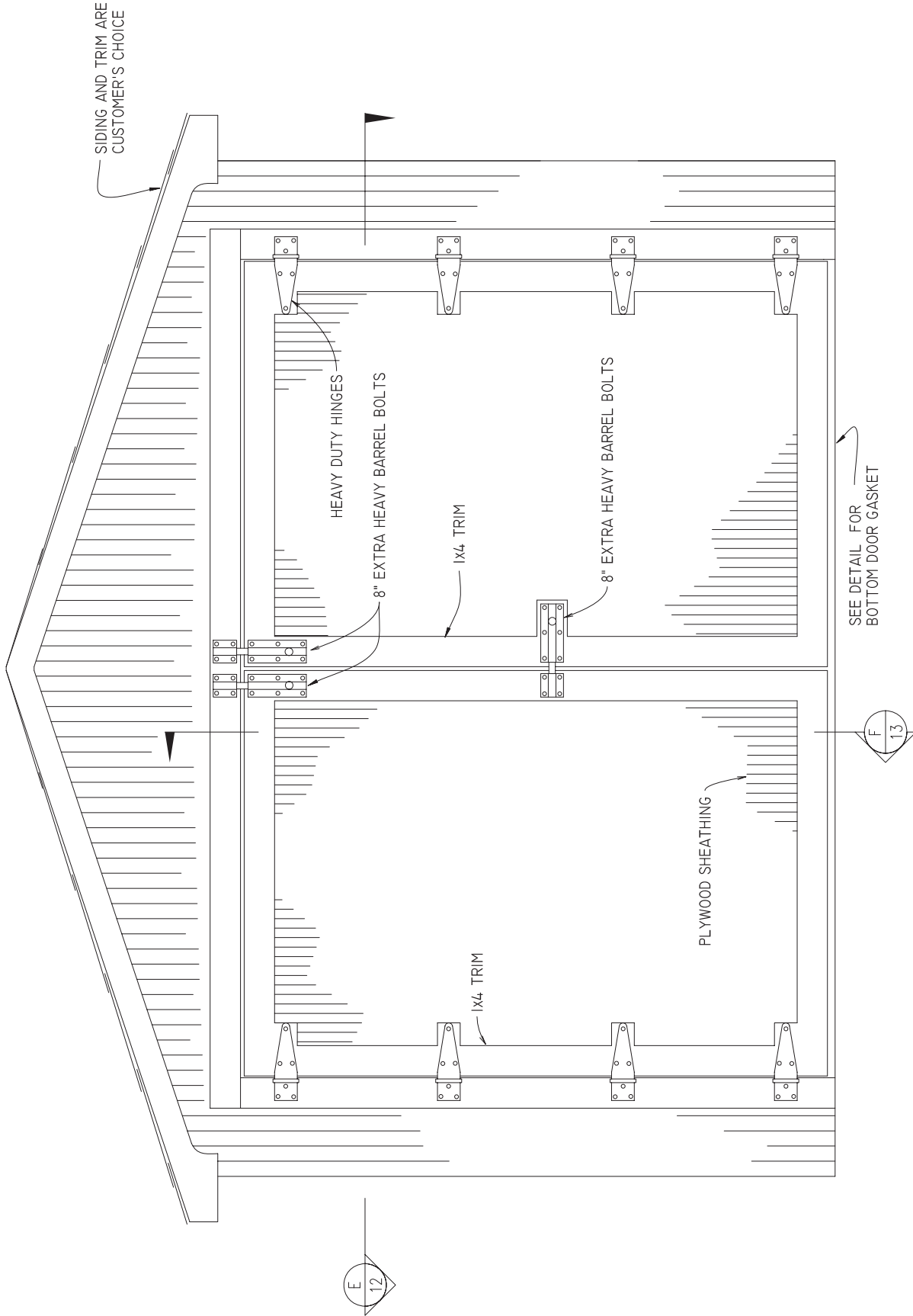
ALTERNATIVE STUD WALL SECTION
SPRAYED URETHANE FOAM

URETHANE FOAM MUST BE APPLIED IN MULTIPLE APPLICATIONS AT A MAXIMUM DEPTH OF 1 1/2" PER COAT. A MINIMUM OF 4" OF FOAM IS REQUIRED AT A DENSITY OF 2.2 LBS PER CUBIC FOOT TO MEET THE R30 INSULATION REQUIREMENT.



ALTERNATIVE STUD WALL SECTION

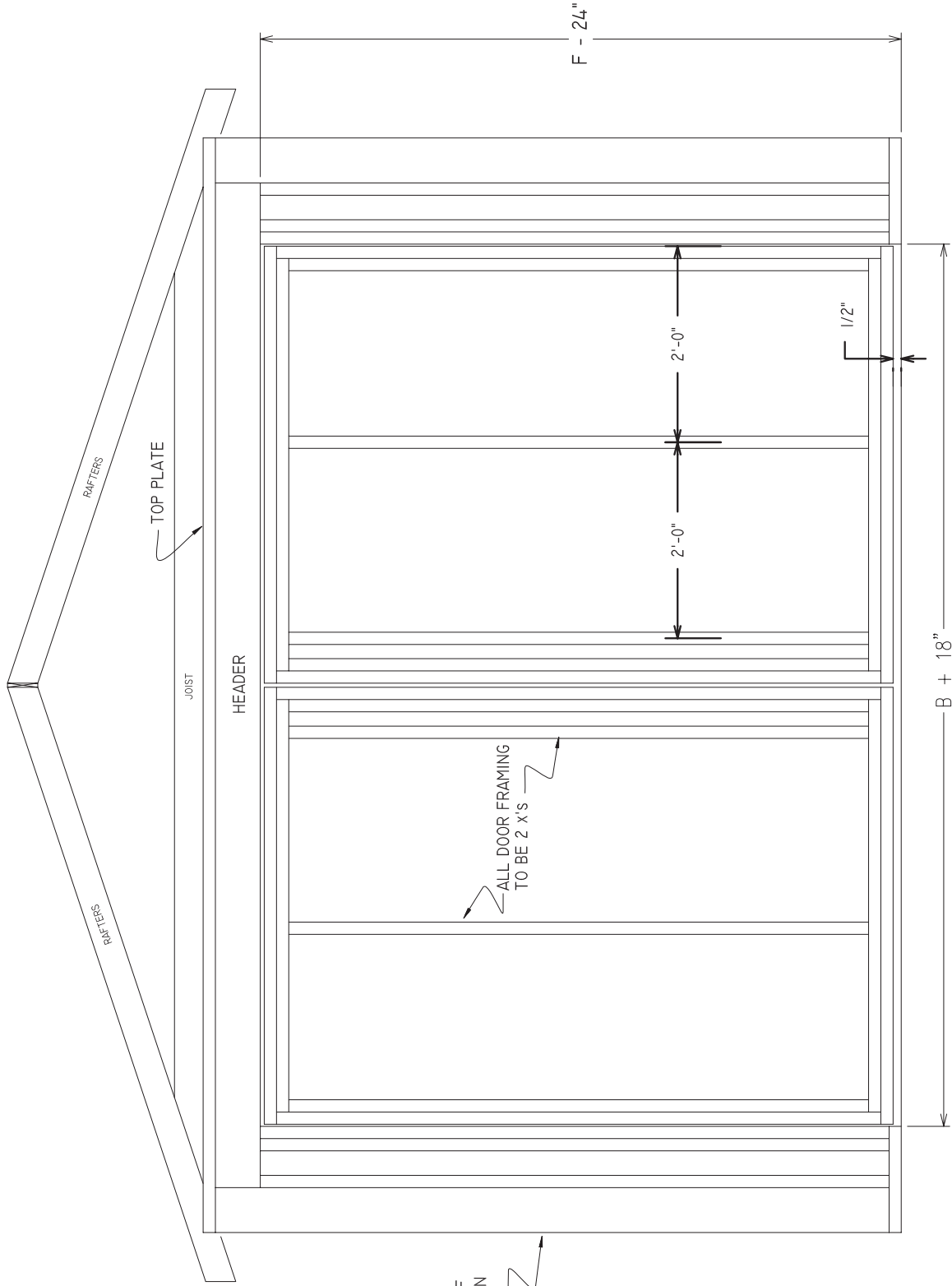
Front Elevation



FRONT ELEVATION

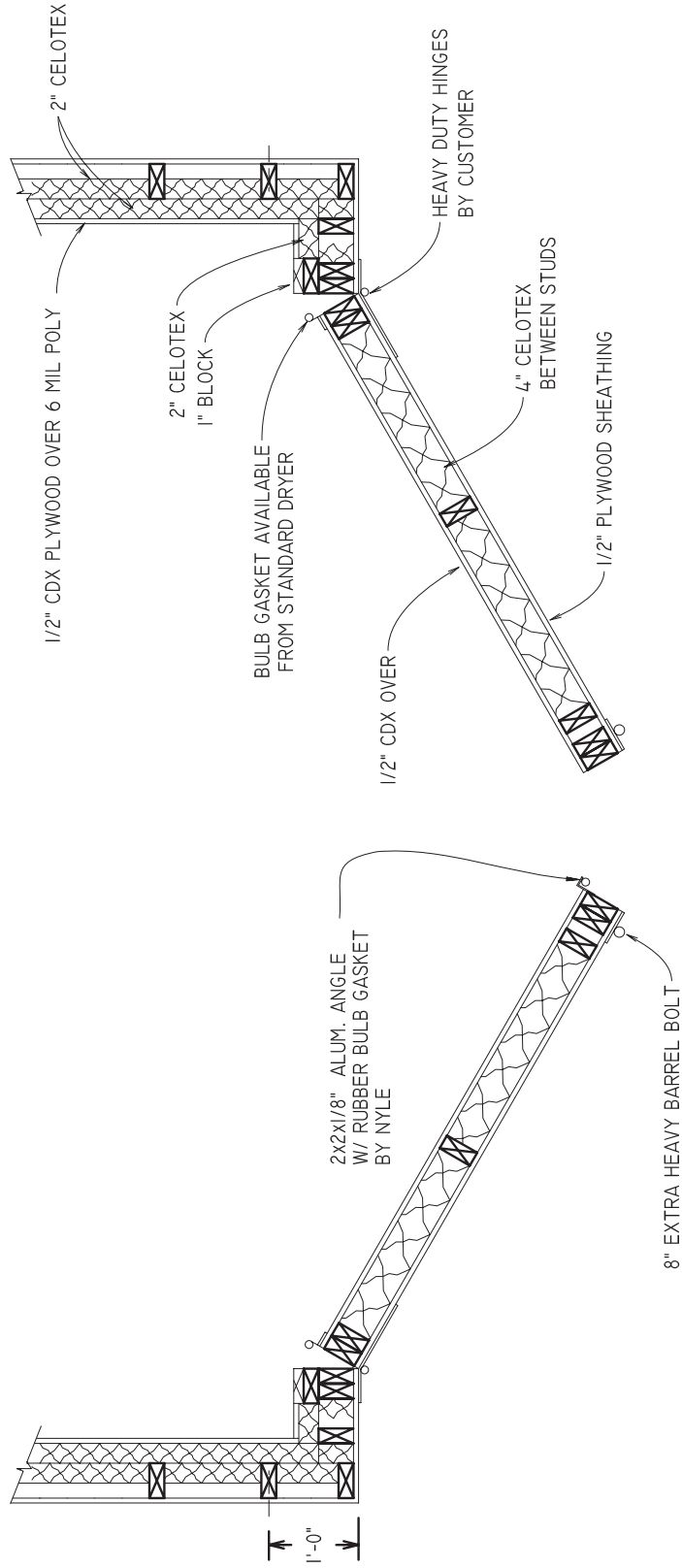
NOTE: DOOR GASKET KITS ARE AVAILABLE FROM NYLE AS AN OPTION.

Door Framing



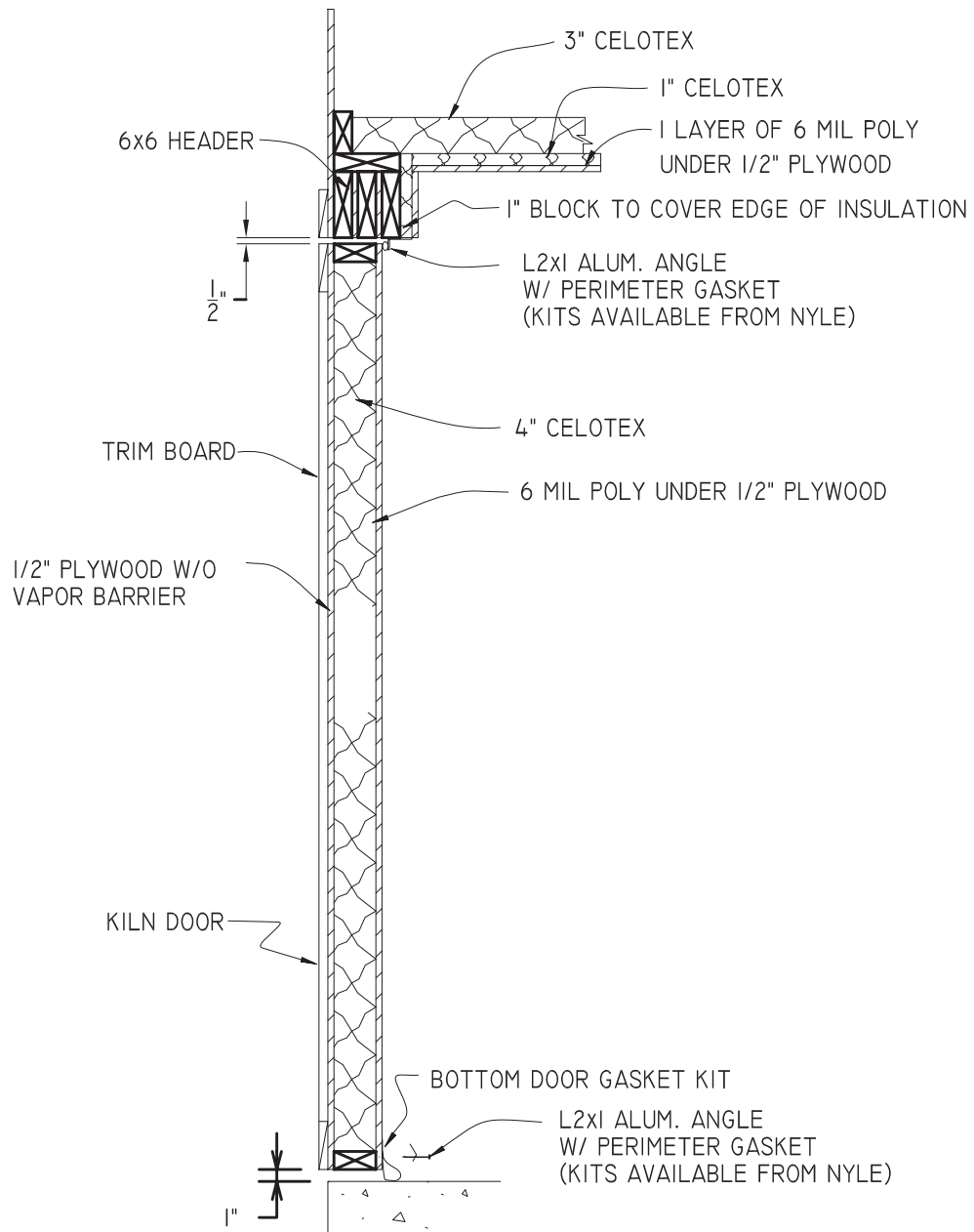
NOTE:
USE 2X4S AT WALLS
TO ALLOW FOR 1/2" OF
CELOTEX INSULATION
BETWEEN WALLS

FRONT WALL AND DOOR FRAMING



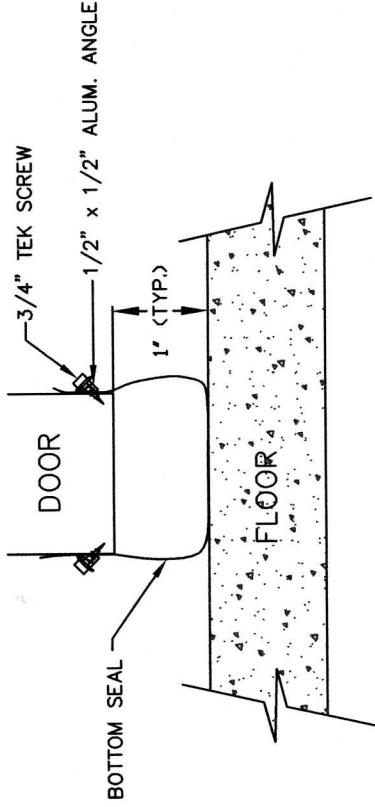
NOTE:
 COAT INTERIOR OF KILN WITH KILN COATING
 (FIBERED, ALUMINIZED ASPHALT BASED METAL
 ROOF COATING) TO PREVENT DETERIORATION.

SECTION FRONT WALL OF KILN CHAMBER E
 W/ 2 SWINGING DOORS 12

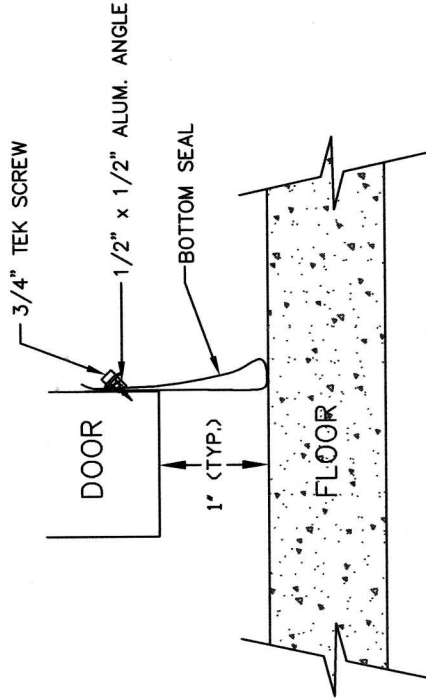


SECTION KILN DOOR AND HEADER F
13

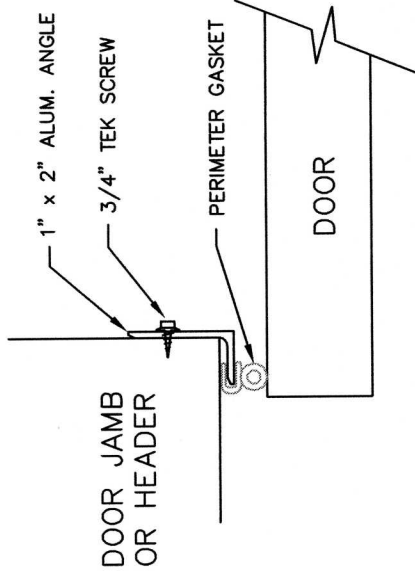
GASKETS AND DOOR KITS
AVAILABLE FROM WOOD-MIZER



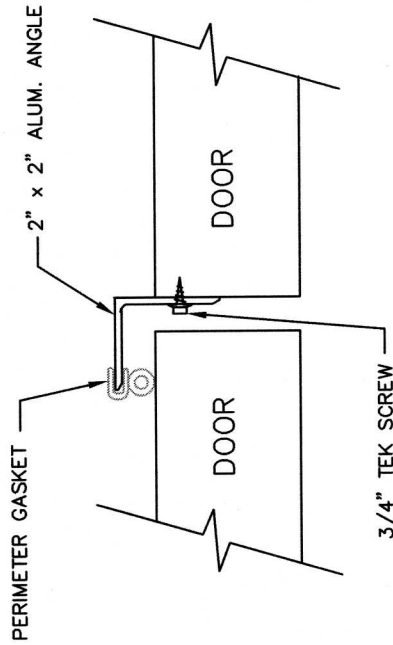
INSTALLATION OF BOTTOM DOOR GASKET



ALTERNATE INSTALLATION OF
BOTTOM DOOR GASKET



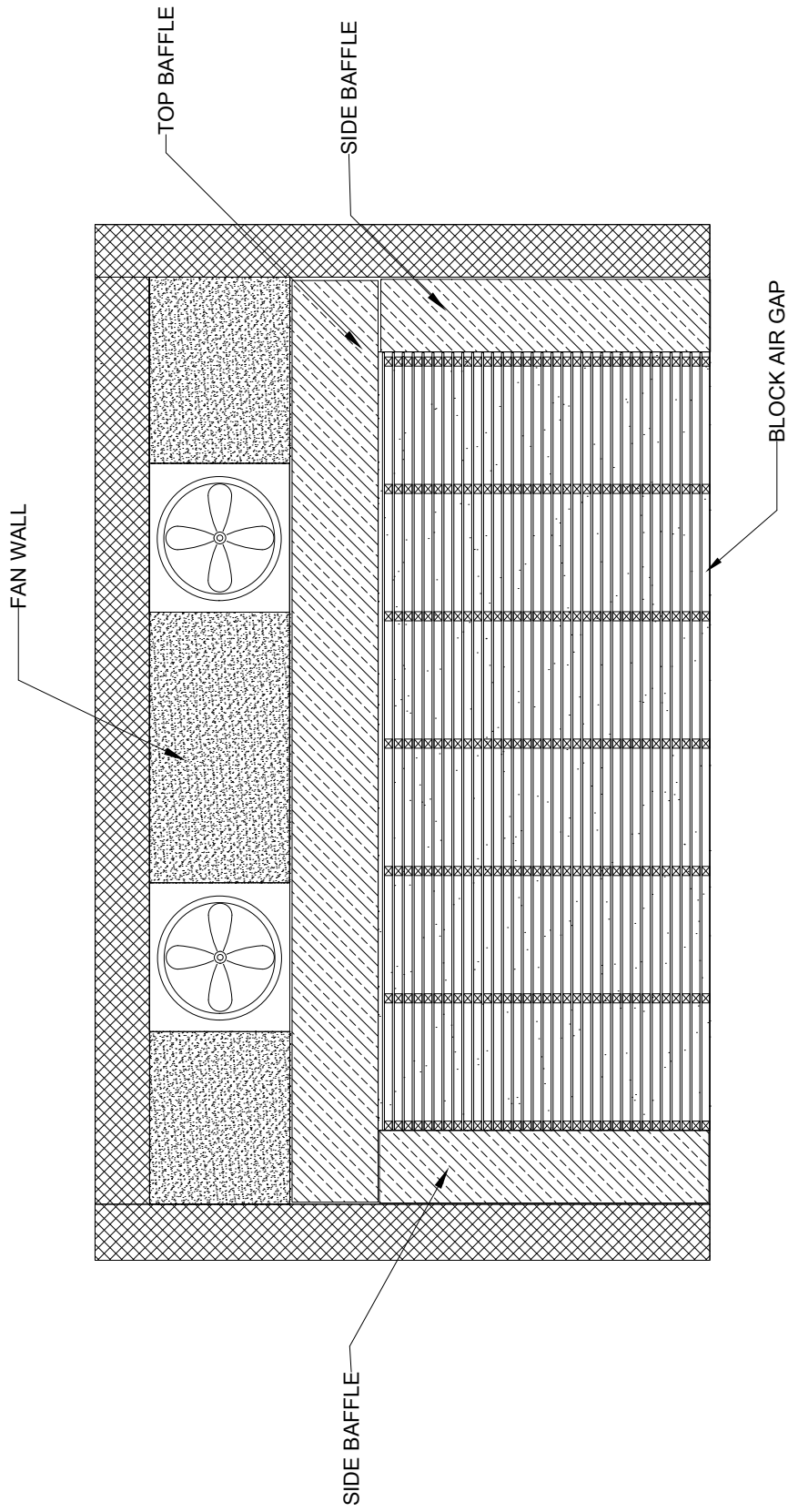
DOOR PERIMETER GASKET
INSTALLATION



INSTALLATION OF CENTER DOOR GASKET

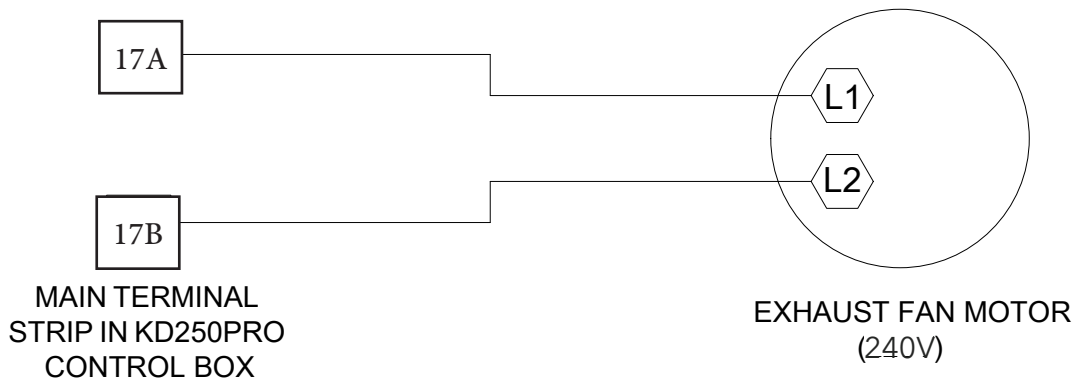
ADJUST ANGLE INSTALLATION SO THAT
GASKET IS SLIGHTLY COMPRESSED

Deflectors and Baffles

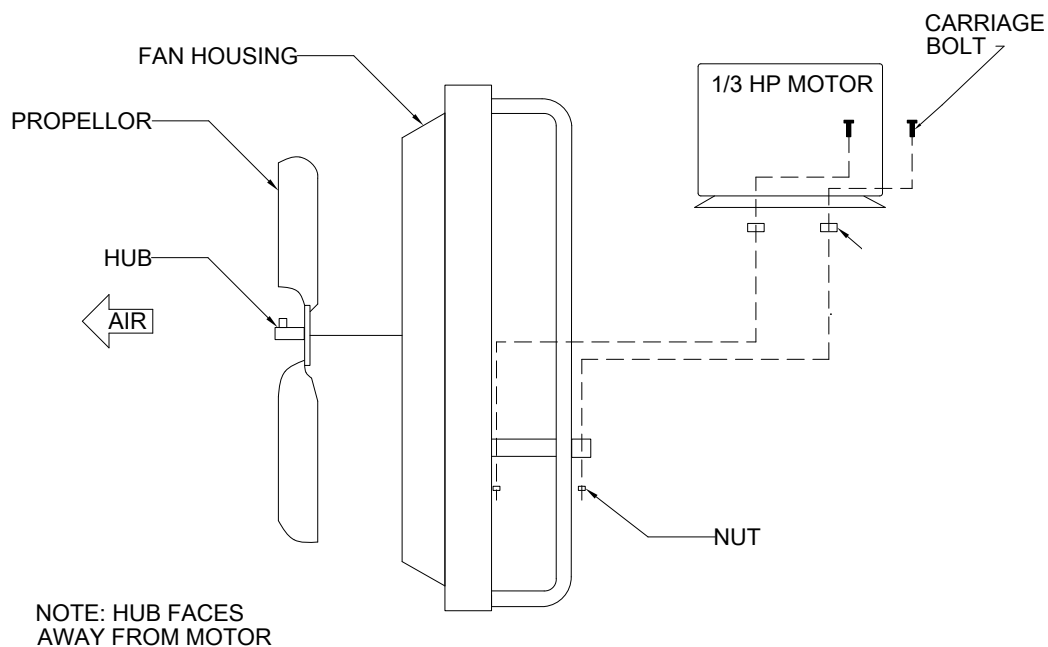


STACKING & BAFFLING
CLOSE ALL LARGE AIR GAPS SO THAT AIR CAN ONLY PASS THROUGH THE STICKER SPACE
CAREFULLY ALIGN STICKERS VERTICALLY
HANGED BAFFLE FROM FANWALL TO FRONT EDGE OF LUMBER STACK

Power Vent Wiring



Fan Diagram



1. MOUNT MOTOR ON BASE USING BOLTS AND NUTS PROVIDED
2. PLACE FAN ON MOTOR SHAFT SO THAT ONE SCREW SET MEETS THE FLAT OF THE SHAFT. TIGHTEN BOTH SET SCREWS
3. ADJUST THE MOTOR SO THAT THE TIO OF THE BLADE IS EVENLY SPACED AND AT THE TRHOAT OF THE VENTURI
4. FAN MOTOR CAN BE WIRED FOR 240V OR 120V BUT THE SWITCH SUPPLIED IS 240 VOLTS ONLY. IT HAS A BUILT IN OVERLOAD.

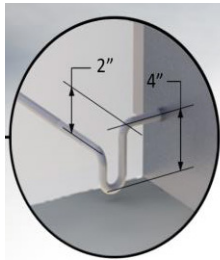
WIRING SUGGESTION : CHECK ON LOCAL CODES

Equipment Installation

Please reference "The Chamber Plans" for more information on installation.

Step 1: Place the dehumidifier at the center of the long wall with the inlet filter facing the board pile.

Step 2: Connect a proper length drain hose. The drain must have a trap.



DO NOT DROP LESS THAN 4" COMING OFF UNIT, DISTANCE BETWEEN PIPES IN AND OUT OF P-TRAP MUST BE ATLEAST 2". DRAIN LINE CAN BE RUBBER PLASTIC OR COPPER TUBING.

Note: The dehumidifier can be elevated to any reasonable amount to help the drain gravity feed. The wall opening should be sealed around where the drain hose extends outside of the chamber. Never have a floor drain.

Step 3: Place the controller at a convenient point outside the chamber near the dehumidifier.

Note: Be sure the controller is in a space that will not reach temperatures below freezing.

Step 4: Remove the cover

Step 5: Drill 2 holes in the kiln wall to allow control cables and separately the sensor wires (inside the controller) to be carefully routed into the chamber. Do not route control and sensor wires through the same hole.

Step 6: Mount the Digital Sensor See "Digital Sensor Installation" on the next page.

Step 7: Remove the right-side panel of the dehumidifier, gaining access to the compressor and terminal strip.

Step 8: Securely connect the control cable to the dehumidifier.

Step 9: Carefully connect each wire to its corresponding terminal. Do not stretch or over-stress the cable.

Note: Wire insulation is marked with the corresponding terminal number.

Step 10: Seal the holes in the kiln wall after wires are installed to keep moisture from the control box.

Step 11: Install the fans over the lumber; see "Chamber Plans" as a reference.

Step 12: Install and caulk the vents so that they are on opposite sides of the fans and at opposite ends of the kiln.

Note: The vents should be located as shown on the chamber drawings.

Step 13: With the system switch in OFF position, connect the control box to power.

Sensors

Digital Sensor

The Digital Sensor replaces the Dry bulb and Wet bulb sensors as well as it's function on the KD250Pro Controller.

Additional Probes

The Controller also still has 2 x PT100 probes which can be used as traditional Dry bulb and wet bulb sensors by disabling the Digital Sensor on the Advanced page of the touch screen controls

Digital Sensor Installation

The Digital Sensor probe is mounted on the Dry bulb sensor bracket approximately 3-4 ft from the floor and roughly 6-12" from the loading door against the side wall that is closest to the control box



Modes of Operation

Conventional Mode

Conventional mode is the basic mode from which all other modes are built. Conventional mode relies solely on venting or vent call to reduce high air humidity and spray or spray call to increase air humidity levels.

To simplify, in conventional mode, the Dry bulb set point drives the heat call, the Wet bulb set point drives the vent, & the spray set point drives the spray.

Conventional drying can be used on any type of lumber as a jack-of-all-trades mode.

DH Mode

DH (Dehumidification) mode is a drying mode pioneered by Wood-Mizer. It utilizes a compressor for the moisture removal call, and the vents are only used for a “cool down” call if the Dry Bulb begins to exceed set points. Since the vents don't open to remove moisture, all the energy used to heat the kiln chamber doesn't go to waste. A DH kiln can be equipped with a cold water spray for increasing humidity levels.

To simplify, in DH mode, the Dry Bulb set point drives the heat call, the Wet Bulb dry point drives the compressor call, and the spray set point drives the spray.

DH drying can be used on any type of lumber but particularly shines with slower-drying hardwoods.

Hybrid Mode

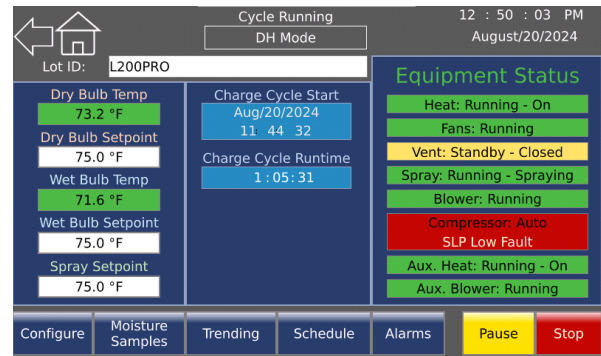
Hybrid Mode is a newly designed control system specifically for DH kiln applications. In this mode, a traditional heat source (gas, electric, etc.) provides the primary heat, while the compressor is intelligently used as a secondary heat source, complementing its dehumidification role. The control system manages primary and secondary heat calls based on dry and wet bulb setpoint offsets. These offsets create a dynamic combination of states that efficiently minimize heat loss while maximizing moisture removal. Vent & spray control are handled as usual via their respective setpoints.

To simplify, Hybrid Mode uses dry and wet bulb setpoint offsets to govern both heat and dehumidification calls, while separate wet bulb setpoints control vent and spray operations.

Hybrid drying is designed for use with a DH kiln and situations where DH drying can occasionally struggle. Fast-drying softwoods, particularly in small chambers, could benefit significantly from using hybrid mode.

Utilizing Your Controller

This section is a walk through of the complete operation of the KD250Pro controller. Starting at the home screen, this is a summarized view of the kiln's current state.



Kiln Status

Cycle Running

At the top of the screen will either show the kiln cycle is running or stopped.

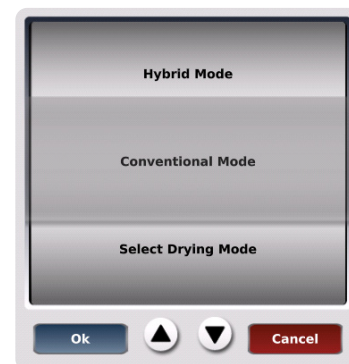
Kiln Mode

Just below this is the Mode indicator and Mode select button.

DH Mode

This button becomes inactive when the kiln is running. If the schedule is enabled, the mode becomes controlled by the mode option in the schedule.

You can change modes while the kiln is off by selecting the mode indicator. This will bring up a scroll box with the different modes.



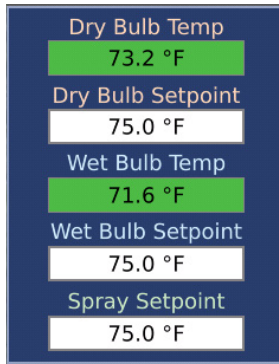
Select the desired mode and hit “okay”.

Lot ID



The lot ID allows the user to specify the log file name for the current run. This will be entered manually for each kiln charge.

Kiln Temperature and Set Points



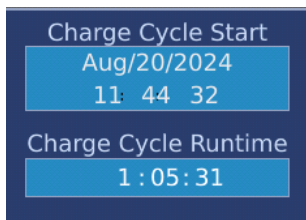
This shows current kiln temperatures, including the controlling or active probes. The active Dry bulb/ Wet bulb will have a green highlight. An orange or yellow highlight indicates a probe fault. Controlling probes can be assigned manually from the Misc. Equipment Screen if logged in as an Admin.

Manually Changing Set Points

When no schedule is enabled, temperature set points can be entered manually from the home screen. When the Set Point is highlighted white, settings can be manually adjusted by clicking on the box and inputting the desired values.

If the Set Point is highlighted gray, the kiln operates from a schedule, and these values cannot be manually adjusted.

Cycle and Runtime

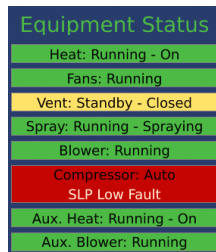


Cycle start and runtime show when the kiln was started and how long it has been running. If the cycle is stopped, the date and time it was stopped is displayed instead.

Equipment Status

The right half of the main screen shows equipment status. The general color schemes used are:

- Green: Enabled and running
- Orange: Enabled, not running
- White: Disabled and/or Off
- Yellow: Running in manual
- Red: Trip or Fault

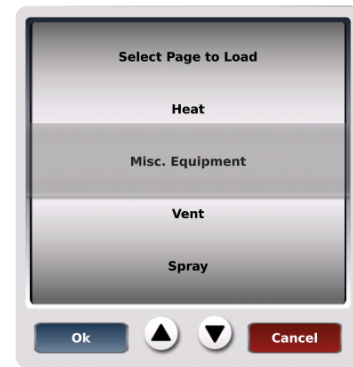


Navigation Buttons



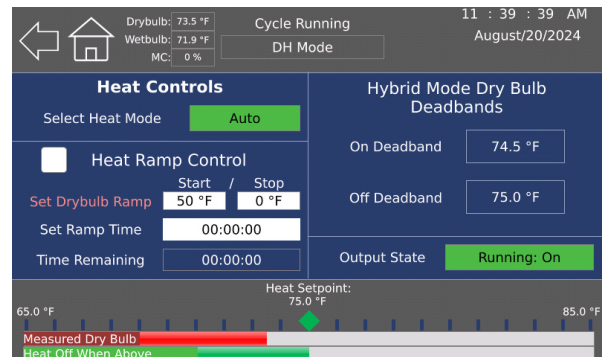
The above buttons allow the user to navigate to various settings and screens for configuring the kiln, viewing data trends, entering moisture samples, scheduling, and checking alarms.

Configuring Your Controller



The configure button opens up a scroll wheel list of equipment in the kiln. This allows the user to access much finer degrees of control with these various pieces of equipment. Specific adjustments can only be made while logged in as an Admin.

Heat



In the heat control screen, specific settings and adjustments can be made. Clicking on the heat control box (highlighted green) will open a scroll wheel for heat Auto, or Off.

Auto: Heat call adjusts based on kiln set point.

Off: The heat is always off.

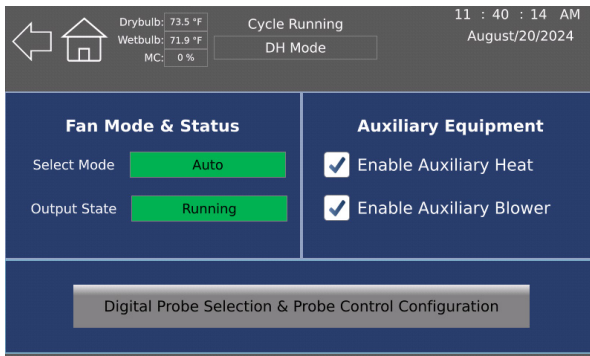


DB deadband is the difference between the Actual Dry bulb and Dry bulb set point; this tells the kiln when to call for heat. For example, with a -2.00 degree deadband on & a 0.00-degree deadband off, a kiln set to 100 degrees dry bulb will get the heat call on at 98 degrees & shut off at 100 degrees.

Ramp Start/End and Ramp time would manually ramp the kiln to temperature over as much time as desired. If the checkbox is directly under "Ramp:" it would enable a manual ramp based on any values plugged into this screen.

Misc. Equipment

Clicking on the fan control box (highlighted in green) will open a scroll wheel for Fan Auto or Fan Off.

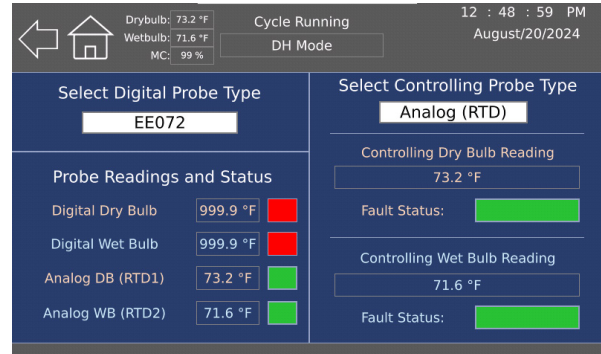


Auto: Fans adjust direction based on kiln settings

Off: Fans are always off

Implosion time is the amount of time the vents will open for upon fan start-up to prevent extreme pressures with various temperatures and air movement in the kiln. The KD250Pro has a 5 second implosion time before fans start up.

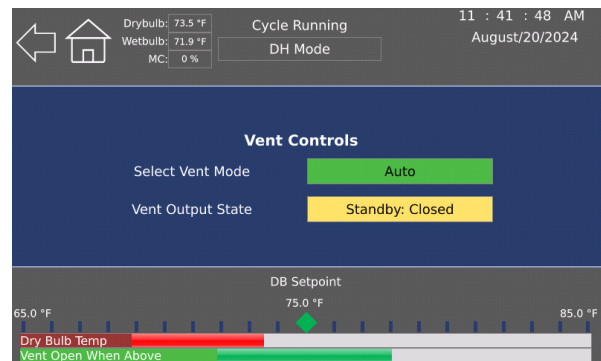
Digital Probe Selection / Configuration



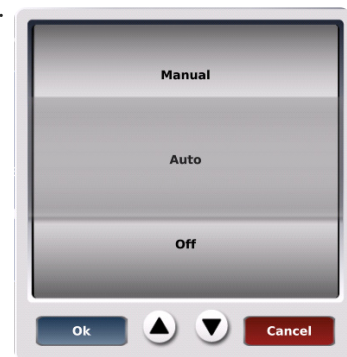
Probe setup is only accessible while logged in as an admin and allows a lot of changes & customization to how the kiln functions. The user can select which probe and see all the readings.

Wood-Mizer recommends having a clear understanding of how these changes will affect the operation before making any adjustments away from the default. Please feel free to reach out to our service line with any questions.

Vent



Clicking on the vent mode box (highlighted in green) will open a scroll wheel for Vent Auto, Vent Manual, and Vent Off.



Auto: Vents will operate based on kiln set points

Manual: Vents will open all the way

Off: Vents will close all the way

Vent Control (Conventional)

Vent on (WB) is your Wet bulb set point. This is the basic setting for when your kiln will vent moisture.

When in Manual Mode, the vents open all the way (not to a specified percentage).

Vent Control (DH Mode)

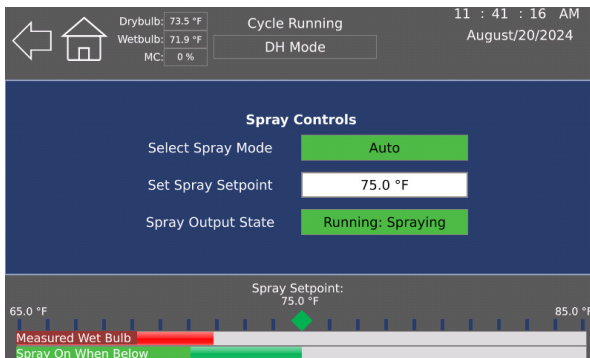
Vent control settings & deadbands function almost the same as conventional mode, except they would vent off the Dry Bulb instead of the Wet Bulb.

Vent Control (Hybrid Mode)

Vent control settings function the same as in conventional mode.

Spray

Clicking on the Spray Control box (highlighted in green) will open a scroll wheel for Spray Auto, Spray Manual, and Spray Off.



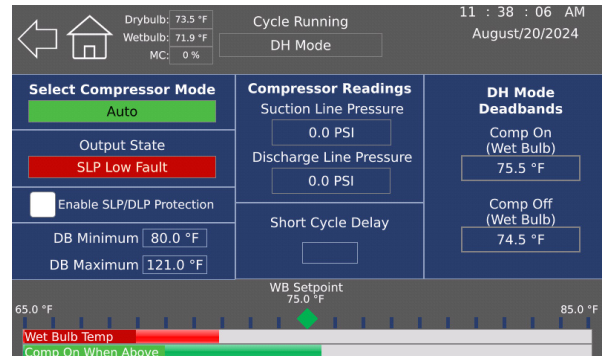
Auto: Spray will operate based on kiln set points.

Off: Spray will always be off.

Note: The spray setting cannot be higher than the current Wet Bulb setting.

The Spray screen is relatively simple; in auto, the kiln will spray until it hits the spray set point. Spray dead bands can be adjusted if the operator wants the spray to turn off or turn on a few degrees above or below the set point.

Compressor



In the compressor control screen, certain manual adjustments can be made. Specific information about the compressor is also only viewable from this screen. Clicking on the Comp Control box (highlighted in green) will open a scroll wheel for Comp Auto and Comp Off.



Auto: Compressor will run based on kiln set points.

Off: The compressor will not run based on kiln set points and will be off as much as possible.

Conventional Mode

In conventional mode, the compressor (if equipped) will remain permanently in the Off setting and will not run.

DH Mode

In DH mode, the compressor will run based on the WB setting.

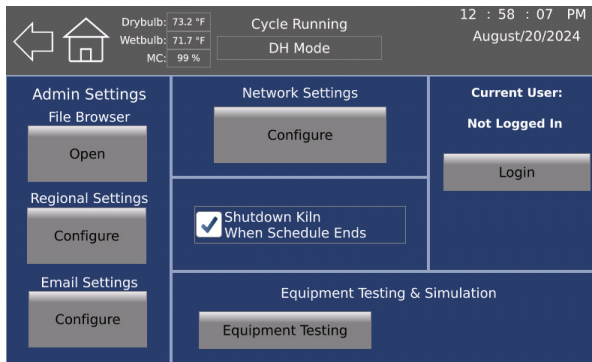
Hybrid Mode

In Hybrid mode, the compressor will run in a zone where certain conditions are met. The compressor

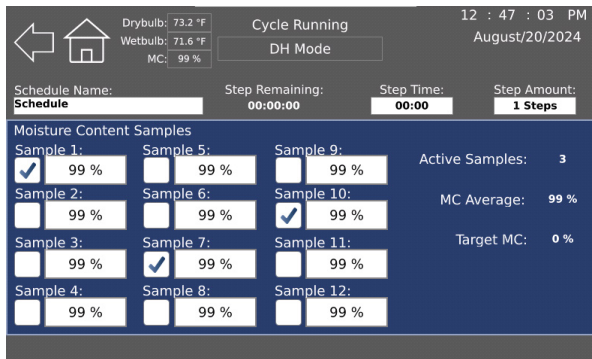
will run based on a heat call if the dry bulb is below a certain amount below the set point, but the wet bulb also needs to be above a certain set point.

Advanced Settings

The advanced settings screen allows the user to log in as an operator or admin. It also allows the user to browse saved files/logs, set up emails for log files, test equipment, & setup network settings.



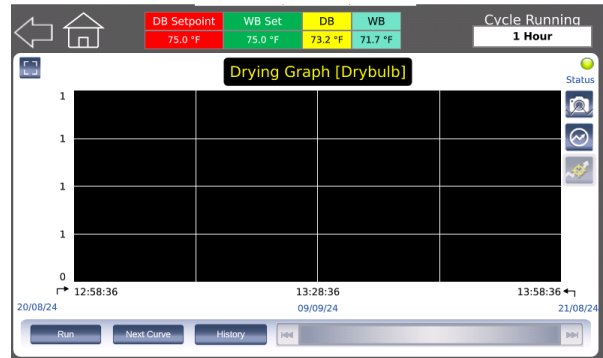
Moisture Samples Screen



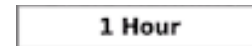
The moisture samples screen allows the user to manually input the moisture content of various samples in the kiln charge. These will directly correlate to MC% steps set up in the schedule. If the box next to a particular sample is checked, then that sample will be used as part of the average samples calculation. This is the value used for MC% steps in the schedule.

Trend Screen

The Trending button opens the Trend view screen. This view shows trends of currently measured values and only trends values when the kiln is in run mode.



The user can zoom in and out on the data range by tapping the time span value at the top center.

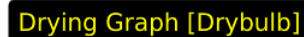


This opens a scroll selection box to view the data in 1-hour, 6-hour, 24-hour, 48-hour, and 99-hour spans. The user can further zoom in on data by tapping the [Stop] button. This freezes the graph and enables the focus button.



Once this button is tapped, the cursor changes to a crosshair, allowing one to click on a curve to see the specific time & actual value at that point.

The name of the current curve is displayed at the top.



Click on the [Next Curve] button to scroll through the curves.

To scroll through recorded value and time, tap on the forward and back arrows, or tap on a new point on the curve.

When finished viewing data, tap on the [Run] button; this will update the graph to live data.

Note: This trend graph shows data up to 99 hours at 1-minute intervals. Should one wish to see more data, they can download the Log file of the current run to a USB drive (see File Browser section under Advanced settings), import the .csv data into MS Excel, & generate a graph of the whole run.

Schedule Screen

When editing a specific step in the schedule section, there is an option to adjust step functions. This section details the differences between each function.



MC%: The schedule will advance when a specific Moisture Content is met across an average of samples. This directly correlates to the Moisture Samples tab accessible from the main screen.

Timed Step: The schedule will advance to the next step when an entered amount of time has passed.

Heat Ramp: The schedule will advance to the next step when a certain amount of time has passed and gives the option of gradually inputting an amount of time for the kiln to reach a Dry Bulb set point.

Navigating the schedule screen

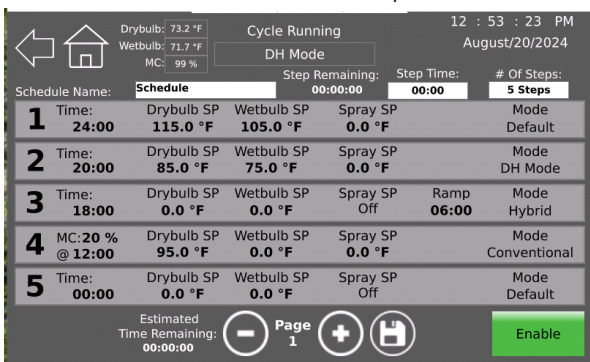
Use the plus (+) and Minus (-) buttons to cycle through multiple pages of steps.

When the kiln is running, use the arrow buttons (>>, <<) in the bottom left to cycle through active steps manually.

An orange step denotes a previous step, a green step is active, and a gray step is upcoming.

To create and save a schedule:

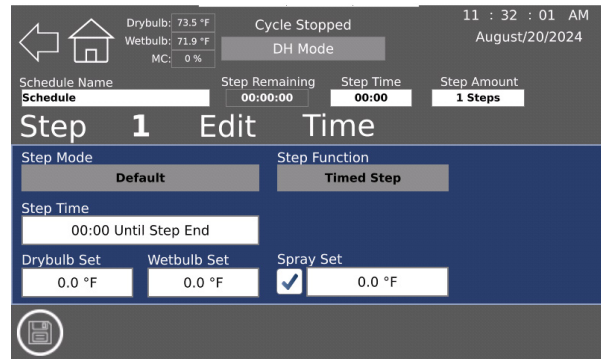
Once in the schedule tab, begin adding specifics of the desired schedule. Users can add the number of steps at the top right of the screen and the schedule name at the top left.



While there is no hard limit to the number of schedules that can be saved and loaded, we recommend only running those necessary for user operation. This will make frequently used

schedules easier to find and load from the file list.

Now, we can begin editing specific steps. Click on step one and determine step mode, step function, values for time, DB/WB, spray (if necessary), and any step-specific functions. Once the step is set up, click the save button in the bottom left, then the back arrow in the top left to return to the previous screen.



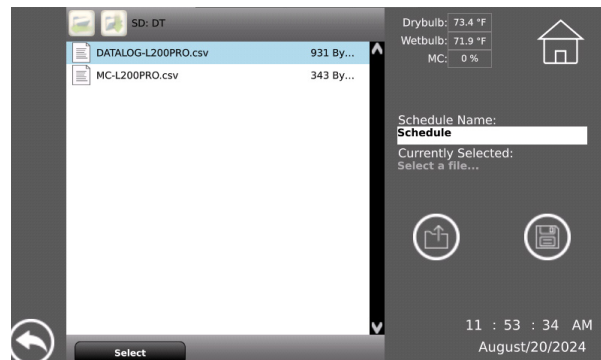
Once all steps are complete, click the "save/load" icon at the bottom of the screen. This will open up a file list, including all saved schedules.

By default, the selected schedule should be the one just edited and enabled. Click the "save" button on the right side of the screen to save the current schedule.

To load a previous schedule:

Once in the schedule tab, click on the "save/load" icon at the bottom of the screen. This will open up a list of files that includes all saved schedules.

To load a specific schedule, scroll up or down to find and click on the desired schedule. Make sure it is the correct schedule followed by ".csv", trying to load any files that do not have ".csv" should result in an error message.



Once the correct file is selected, click "Select" at the bottom of the screen. This should cause the text bar on the right of the screen to populate with the name of the selected schedule.

Under this text bar, click the load icon. Then, hit "yes" to the text box asking to load the schedule.

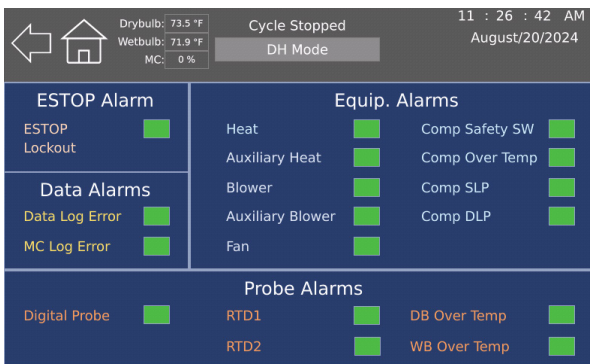
Your desired schedule should be loaded once you back out to the normal schedule screen.

Other pertinent information:

If the "enable" button in the bottom right of the schedule tab is not clicked, the program will disregard the schedule & run based on manual settings. The schedule can be enabled from the schedule tab or at the kiln start-up with a pop-up box.

If any steps chosen in a selected schedule are MC% steps, they will read off the Moisture Samples tab accessible from the main screen. If these values are not filled in either manually or with moisture probes, then the MC% steps will not function as intended.

Alarm Screen



The alarm screen details more information about different alarms and faults.

Logging into the Controller

To log in to the controller, the user must first go to Configure > Advanced settings.

There are two logins readily available to the user.

User: Operator

Password: 100000

User: Admin

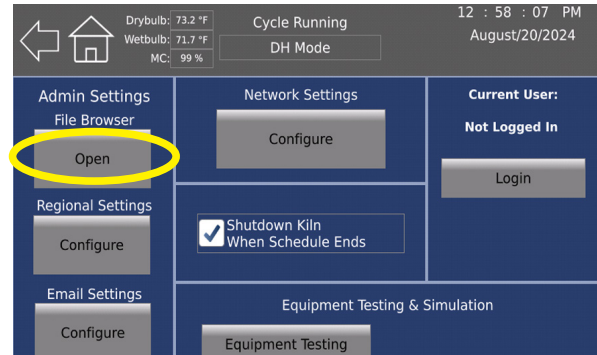
Password: NyleAdmin

Accessing the Data Logs

There are several ways to access data logs from the controller. The easiest way is to remove the micro SD card that can be found on the side of the screen near the ethernet port. This should only be done while the unit is not in cycle to prevent data loss. The log files can be found in the DT folder.

To access log files while the unit is running you can use the built in file browser to copy the logs to an external flash drive.

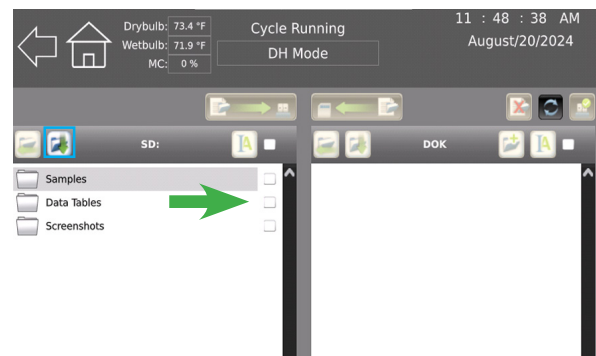
To do this insert a flash drive into the USB port on the side of the screen and follow these steps to navigate to and copy the desired files to the flash drive. Open the file browser on the advanced settings screen.



➔ Select the "Data Tables" folder by checking the box next to it.



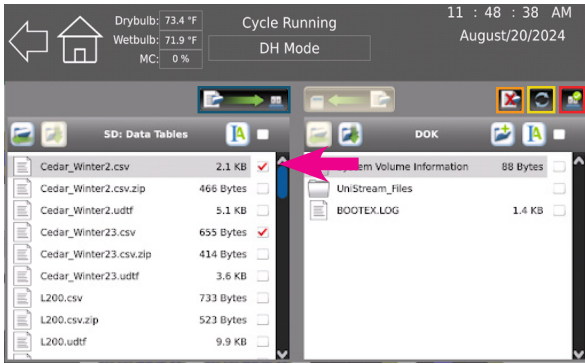
Open this folder.



➔ Select the log files you would like to copy by checking the boxes next to their name.



Once you have selected all the files you would like to transfer press the copy button.



This button deletes all selected files.

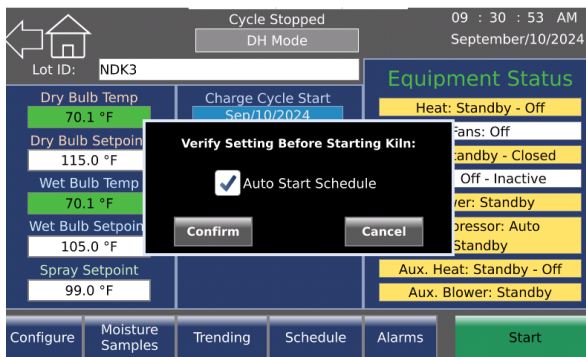


Use this button to refresh any changed files.



This button ejects the flash drive so it can be safely removed.

Starting Your Kiln



To start a kiln with an KD250Pro controller, click the green Start button in the bottom right of the main screen. This will open a pop-up box with two options.

Auto Start Schedule: If this box is checked when the kiln starts, the controller will automatically enable any schedule actively plugged into the schedule screen. If this box is unchecked, the kiln will be running manually, and all set points and functions will need to be inputted and operated manually.

Drying Lumber

Wood-Mizer recommends that these guidelines be followed carefully.

Placing Stickers and Loading Lumber

- Stickers should all be at least ¾" thick and all sticks in any load must be the same thickness.
- Thick lumber (10/4" and thicker) should be dried using double stickers.
- End stickers should be as close to the ends of the boards as possible.
- The sticker spacing should be approximately 18". This spacing can be reduced to 12" if excessive warping, cupping, and bowing are a problem.
- Keep stickers in a vertical line and always support the load under each sticker.
- If you have some wide boards, or other pieces that you want to keep as straight as possible, pile them on the bottom as the weight of the lumber above will constrain the wide boards and give the best result.
- If a less than full load is anticipated, it is better to reduce the depth rather than the height or width. This will obviously leave the stickers "hanging out", but will result in better drying.

Ensuring Proper Airflow

- When the lumber is fully loaded, the baffles should be lowered to the top of the lumber and the side baffles should be carefully positioned. If no side baffles are installed, the space could be closed off with plywood or boards.
- Never use plastic sheeting as it may come loose and become entangled in the fans.
- If the load supports are thicker than normal stickers, the extra space should be blocked with a narrow board or lath.
- Close off any large openings that will let air go around the lumber. Air will take the path of least resistance, and you must force it through the stickered pile.
- A small amount of time spent doing this correctly will result in more even, faster, and less expensive drying.

Drying Schedules

Each species of lumber has a maximum rate of drying (expressed as % loss/day) that can be tolerated without damage. These rates have been determined through experimentation by the U.S. Dept. of Agriculture, various universities and others. Schedules have been developed based on time, dry bulb-wet bulb temperatures, and even automatic moisture content devices. Due to the many important variables that affect drying such as kiln chamber heat loss, air velocity, ambient temperature and humidities, vapor leaks, etc., the most important consideration of a schedule is that you maintain a safe drying rate.

The KD250Pro drying system dries lumber by using the dry bulb and wet bulb temperatures of the kiln to control the operation of the dehumidifier. The schedules on page 20 are based on dry bulb and wet bulb conditions (humidity). These schedules are starting points; you will probably change these over time because you will find different settings work for you. This is due to the fact that different people saw boards differently, stack lumber differently, build chambers differently, etc.

If the dry bulb temperature is above 80°F, and the wet bulb is 2°F above its set point, (factory setting) the compressor will turn on. When the compressor is on, moisture is being condensed on the cold coil in the unit, and draining away. This moisture being removed reduces the humidity, dropping the wet bulb temperature.

The moisture removal rates on page 27 are the rates to follow when first using the machine. These rates can be safely exceeded by an additional 50% (i.e., 1.0% can be raised to 1.5% and 3.3% can be increased to almost 5%) given careful judgment and operating experience for Groups 1, 2, and 3. Top quality moisture meters, or weight samples, must be used at these higher drying levels to avoid lumber damage. Some hardwoods such as Southern Red Oak, White Oak, and Group 4 hardwoods should not use any sort of accelerated schedule.

Wood Groups

Note: When drying a mixed load of woods, colored wood (ie Red Oak) must be stacked on the bottom to prevent the moisture from it staining the other wood.

Group 1 (KD250 load size, 1500 BF, 3.5m³)
4/4 Softwoods
4/4 Soft Hardwoods
Group 2 (KD250 load size, 3000 BF, 7m³)
4/4 Medium Hardwoods
8/4 Softwoods
8/4 Soft Hardwoods
Group 3 (KD250 load size, 4000 BF, 9m³)
4/4 Hardwoods
8/4 Medium Hardwoods
Group 4
8/4 Hardwoods

Lumber Types

Softwood			
Cedar, Eastern White	Pine, Red (Norway)	Spruce, White	
Fir, Balsam	Pine, Eastern White		
Hemlock, Eastern	Spruce, Black		
Larch, Eastern	Spruce, Red		
Soft Hardwoods			
Aspen			
Basswood			
Cottonwood			
Poplar			
Medium Hardwood			
Ash, Black	Birch, Yellow	Maple, Soft	Walnut
Ash, White	Cherry, Black	Maple, Hard	
Beech	Elm, White	Sweet gum (Red gum)	
Birch, White	Hickory	Tupelo (Black gum)	
Hardwoods			
Elm, Rock			
Oak, Red			
Oak, White			

Moisture Removal Rates

Moisture Removal Rate Per Day (Maximum)

These removal rates are estimates only. Always check your actual removal rates daily, using an accurate moisture meter. There are many variables that affect drying rates, such as how lumber is sawn, stacked, and how the chamber is built.

The following chart shows the calculated moisture removal rate per 24 hour period for an KD250Pro Running at 100% .

Load Size	Group 1	Group 2	Group 3
1000 BF	13.7%	9.3%	8.5%
1500 BF	9.0%	6.2%	5.7%
2000 BF	6.7%	4.6%	4.3%
2500 BF	5.4%	3.7%	3.4%
3000 BF	4.5%	3.1%	2.8%
3500 BF	3.9%	2.6%	2.4%
4000 BF	3.4%	2.3%	2.1%

**Drying rate may be too high, look at the maximum rates.*

Drying Group 1 woods at a rate of less than 5% per day may result in mold or staining of the lumber.

Drying Group 3 woods at a rate greater than 3.5% per day may result in checking or other degrade to the lumber.

KD250Pro Drying Schedules

Group 1 woods generally do not have a maximum drying rate, you will want to remove the moisture quickly, and fast enough to avoid mold and stain. Set the Dry Bulb on 120°/Wet Bulb at 75°. The compressor will run constantly. You can turn the heat switch off once the temperature reaches 100°, Heat from the compressor motor and fan motors will keep the temperature rising. (At the end of the drying cycle, for softwoods, turn the compressor switch "OFF", and set the dry bulb temperature to 150° F. or 160° F. to set pitch.)

Use the alternate schedules if you are in a warm climate or otherwise unable to maintain a 90° F dry bulb temperature at the beginning of the drying cycle.

Moisture Content	Normal Schedule		Alternate Schedule	
	Dry Bulb	Wet Bulb	Dry Bulb	Wet Bulb
Group 2				
Above 45%	90° F	85° F	100° F	97° F
45% - 35%	100° F	87° F	105° F	93° F
35% - 25%	110° F	96° F	110° F	96° F
25% - Final	120° F	90° F	120° F	90° F
Group 3				
Above 45%	90° F	86° F	100° F	97° F
45% - 35%	100° F	96° F	105° F	101° F
35% - 25%	110° F	98° F	110° F	98° F
25% - Final	120° F	98° F	120° F	98° F
Group 4				
Above 50%	90° F	85° F	100° F	97° F
50% - 40%	95° F	89° F	100° F	96° F
40% - 35%	100° F	90° F	105° F	97° F
35% - 30%	110° F	98° F	110° F	98° F
30% - Final	120° F	95° F	120° F	95° F

Drying Rates (North American Measure)

Species	Oven Dry Weight #/MBF	Avg. Green MC %	Green Weight #/MBF	# Water Per % MC	Max MC% Loss/ day
Cedar, Eastern White	1578	93	3046	16	11
Fir, Balsam	1739	118	3790	17	20
Hemlock, Eastern	2161	111	4558	22	20
Larch, Eastern	2532	52	3849	25	20
Pine, Red (Norway)	2051	83	3747	21	15
Pine, Eastern White	1950	90	3705	20	12
Spruce, Black	2110	80	3798	21	20
Spruce, Red	2000	89	3781	20	20
Spruce, White	1840	115	3967	18	20
Ash, Black	2532	95	4937	25	7
Ash, White	3055	45	4431	31	10.4
Basswood	1899	107	3933	19	12
Beech	3114	63	5089	31	4.5
Birch, White	2692	73	4659	27	10
Birch, Yellow	2954	69	4996	30	6.1
Cherry, Black	2633	58	4161	26	5.8
Elm, Rock	3165	50	4760	32	3.5
Elm, White	2692	93	5207	27	10.4
Hickory	3325	64	5452	33	6
Maple, Soft	2692	93	4389	27	13.8
Maple, Hard	3165	68	5317	32	6.5
Oak, Northern Red Upland	3277	74	5703	33	3.8
Oak, White Upland	3518	70	5981	35	2.5
Oak, Southern Red	3092	80	5567	31	3.8
Sweetgum (Red gum)	2740	100	5480	27	5.3
Walnut	2851	85	5274	29	8.2
Yellow Poplar, Cottonwood	1899	154	4819	19	13.8

Northeast Lumber - Based on 4/4 (1" or 25 mm)

To estimate maximum % MC loss per day for other thickness' multiply % MC loss per day from the above table by 0.6 for 6/4 and 0.4 for 8/4.

Drying Rates (Metric)

Species	Oven Dry Weight Kg / M3	Avg. Green MC %	Green Weight Kg / M3	Kg Water Per % MC	Max MC% Loss/day
Cedar, Eastern White	315.6	93	609.2	7.27	11
Fir, Balsam	347.8	118	758	7.73	20
Hemlock, Eastern	432.2	111	911.6	10	20
Larch, Eastern	506.4	52	769.8	11.36	20
Pine, Red (Norway)	410.2	83	749.4	9.55	15
Pine, Eastern White	390	90	741	9.09	12
Spruce, Black	422	80	759.6	9.55	20
Spruce, Red	400	89	756.2	9.09	20
Spruce, White	368	115	793.4	8.18	20
Ash, Black	506.4	95	987.4	11.36	7
Ash, White	611	45	886.2	14.09	10.4
Basswood	379.8	107	786.6	8.64	12
Beech	622.8	63	1017.8	14.09	4.5
Birch, White	538.4	73	931.8	12.27	10
Birch, Yellow	590.8	69	999.2	13.64	6.1
Cherry, Black	526.6	58	832.2	11.82	5.8
Elm, Rock	633	50	952	14.55	3.5
Elm, White	538.4	93	1041.4	12.27	10
Hickory	655	64	1090.4	15	6
Maple, Soft	538.4	93	877.8	12.27	13.8
Maple, Hard	633	68	1063.4	14.55	6.5
Oak, Northern Red Upland	655.4	74	1140.6	15	3.8
Oak, White Upland	703.6	70	1196.2	15.91	2.5
Oak, Southern Red	618.4	80	1113.4	14.09	2
Sweetgum (Red gum)	548	100	1096	12.27	5.3
Walnut	570.2	85	1054.8	13.18	8.2
Yellow Poplar, Cottonwood	379.8	154	963.8	8.64	13.8

Northeast Lumber - Based on 4/4 (1" or 25 mm)

To estimate maximum % MC loss per day for other thickness' multiply % MC loss per day from the above table by 0.6 for 6/4 and 0.4 for 8/4.

Kiln Sample Boards

It is best to use sample boards to measure moisture content on a daily basis. Moisture meters are not accurate enough for most hardwood dry kiln operations when the wood is above 30% MC and there is a need to keep a close watch on the drying rate. In Oak, for example, all checks and honeycombing occur when the wood is drying from green down to 40% MC, so that is when the drying rate needs to be closely controlled.

Uses for Sample Boards

- To estimate the MC of the load in the chamber, so that kiln conditions can be regulated according to drying schedules.
- To measure the drying rate, which allows control of drying quality.
- To check on any degrade development.
- To check on final MC and drying stresses.
- To develop a MC vs. time curve.
- To study variations in drying within the kiln.
- To monitor changes in MC after drying (during storage and shipping) Note: It is a good idea to keep sample boards with dried lumber so that they can be used to track moisture content changes in storage.

Taking Samples

1. Select sample boards. Keep in mind that they need to represent a "sample" of the lumber in the kiln. Do not select junk boards, and select both the slowest and the fastest drying boards of the load. Generally, you want six sample boards.
2. Cut 30" samples, at least 12" from the ends of each of the sample boards. Avoid having knots, splinters or bark in the sample.
3. Number the samples you cut.
4. Cut two 1" sections off each end of the samples, and mark them with the number of the board they came from.

Example: the two sections that came from sample board 3 would be labeled 3A and 3B.

5. Apply end coat to the 28" sample boards. This assures that the sample board will dry as though it were a larger piece of lumber.

End coatings are not usually required when lumber is placed in the kiln directly after being sawn. However when lumber is air dried prior to kiln drying, end coating is often helpful in preventing end checks

6. Weigh the 28" sample boards. An accuracy of .025 pounds or 1 gram is recommended. Record these values.
7. Put the 28" sample boards in the lumber stacks in places where they can be reached and will dry at the same rate as the lumber. Do not place the sample boards where they will receive more air flow than the rest of the lumber.
8. Take the "green weight" by weighing all the 1" sections, to 0.1 gram accuracy is suggested. Record these values.
9. Oven dry the 1" sections using one of the two methods below.
 - Microwave with carousel tray: Put sections on a paper towel on the tray. Use low power (to avoid smoking) for 20 minutes. Weigh the section, and put back in the microwave for 1 minute. If the section has not lost any weight, it is oven dry. If still losing water, continue drying in 5 minute increments until a constant weight is achieved.
 - Oven: Place the 1" section in an oven at 215°F (101°C) until the section stops losing weight, usually takes 24 hours. Check hourly until the section weighs the same in separate weighings.
10. Calculate the moisture content of each 1" section separately using the following formula:
11. Average the moisture content of the two 1" sections from each 28" sample board to calculate the estimated moisture content of the sample board when it was cut.
12. Calculate the oven dry weight of the 28" sample board is using the following formula and the average moisture content (MC) from the previous step:
$$\text{OD weight} = \left(\frac{\text{Wet Weight}}{100 + \%MC} \right) \times 100$$
13. Write the calculated OD weight on the sample board so that it is readily available.

14. At about the same time each day, weigh the sample boards and calculate the current moisture content with this formula:

$$\text{Current \%MC} = \left(\frac{\text{Current Weight}}{\text{Calculated Oven Dry Weight}} - 1 \right) \times 100$$

15. Place the 28" sample board back in the same place in the kiln it came from.
16. Calculate the daily drying rate for each section. Keep all the figures written down as a record of the load. Make any adjustments to the schedule based on the fastest drying sample.
17. Once the moisture content of the kiln is below 20%, it is often a good idea to cut new 1" sections from the center of the sample boards (1 section per board).

Example: Two 1" sections are cut from 30" sample board 1, and labeled 1A and 1B. They are weighed on a balance, and the weights are: A=2.5g and B=2.3g. The sections are placed in a microwave on low power for 20 minutes and weighed, weighing A=1.7g and B=1.6g. They are put back in the microwave for 1 minute and weighed again. The weights did not change, so these values are now oven dry weights.

- Calculate the moisture content using the formula in step 10.
 $A = [(2.5 / 1.7) - 1] \times 100 = 47.06$
 $B = [(2.3 / 1.6) - 1] \times 100 = 43.75$
- Average the two calculations together:
 $(47.06 + 43.75) / 2 = 45.40\%$
 This is the calculated moisture content for the rest of the sample board.
- Calculate the oven dry weight of the sample board 1. Use the formula in step 11. The green weight is 1.64 kilograms.
 $ODW = (1.64 / 145.4) \times 100 = 1.13 \text{ kg}$
- After a day in the kiln, weigh sample board 1 and it weights 1.58 kg. Using the formula in step 13, the moisture content is:
 $\%MC = [(1.58 / 1.13) - 1] \times 100 = 39.8$
- The daily change in moisture content is:
 $45.4 - 39.8 = 5.6\%$.

Record Keeping

A good system of record keeping for the dry

kiln is essential to developing a good operating procedure. The records that are kept will indicate when operations are deviating from the norm and will allow future schedules to alter to improve production.

Note: It is recommended that all information be kept on the sample boards as outlined in the Dry Kiln Operator's Manual.

In addition to the records kept daily on the sample boards, it is also very important to plot on a graph the average and wettest drying sample. If possible, plot all the samples on the graph. This will indicate the drying rate and often any adjustment will become apparent on the graph before it is analyzed in the data.

Each day, the water removal should be weighed for one minute and that figure recorded on the kiln records. While one direct use is made of this information in the drying schedule, a deviation from normally expected water flows will give early warning of a malfunction in the refrigeration system.

Several times during the cycle the bulb should be measured on both sides of the load and in several areas. The average should be noted on the kiln record. As with measuring the water removal rate, this is not used in the operation of the kiln but deviations from normal will indicate a problem in loading, baffling, airflow etc. That will affect drying. These figures will always vary but being familiar with them, the operator will be able to detect a malfunction early.

Record should be kept for comparison throughout the year. It is wise to compare summer loads with summer and winter loads.

Drying Rate Index (DRI)

The dry kiln industry has never had a method of predicting drying rates. This is remarkable as one main reason for having a kiln is to bring about predictable production rates. The EMC value gives an end point of what the moisture content of the lumber would eventually become but it does not give an indication of how long it will take to reach that moisture content.

Drying schedules for dehumidification drying were developed in the late 1970's. It became obvious that a method of adjusting kiln schedules to meet drying time objectives within the limitations

of the operation range of the dehumidifiers had to be found. It was common to look up a drying schedule in the Dry Kiln Operators Manual or some other reference, and then find a set of conditions at which dehumidifier could run using the same EMC. This resulted in unnecessarily long drying cycles and was quickly shown to be an ineffective method of doing kiln schedules.

Wood-Mizer developed the Drying Rate Index in response to that but time has shown that the Drying Rate Index is very useful in both conventional and dehumidification kilns. With the trend to control kilns by monitoring drying rate to get maximum productivity and quality, the Drying Index becomes a very valuable tool.

The drying rate is a function of the vapor pressure deficit. Everyone knows that things dry faster in hotter, drier air. Every fluid has a vapor pressure associated with it that varies with the temperature of the fluid. Air has a vapor pressure that is of function of temperature and humidity. The difference between the two determines the rate drying. This is how everything in the world dries whether it is paint, the ocean, the lumber or perspiration. When the humidity of the air is 100% no evaporation takes place regardless of the temperature. As relative humidity drops the rate the fluid evaporates increases. The problem is that a way of predicting the change in drying rate with changes in temperature and humidity was needed.

The Drying Rate Index is a relative number.

Example: A kiln is operating at 120° F. dry bulb and 110° F. wet bulb, that means the depression is:

10° (120° F.- 110° F. = 10° F.) According to the Drying Chart, The relative humidity is 72% the Equilibrium Moisture Content (EMC) is 12.1% and the Drying Rate Index (DRI) is 1.0. The EMC indicates where the lumber will end eventually. The EMC is also an indication of where the surface moisture content of the lumber will go fairly quickly. The whole board will eventually be 12.1 % but the surface will reach 12.1% much quicker.

In the above example, the lumber might be drying at 3% per day but it could be dried faster at 5% per day. In order to change the drying rate from 3% per day to 5% per day, it would be necessary to find a DRI that is 1.67 times the existing drying rate.

Desired Drying Rate/Existing Drying Rate = Multiplier.
(5/3=1.67)

Multiplier x Existing DRI= Desired DRI

The existing DRI is 0.9 so the new DRI should be 1.5
(0.9 x 1.67)

Referring to the Drying Chart (Pg 27), it can be seen that if the temperature were increased to 130° F and the depression 13° F (read between 12 and 14 on the chart), the DRI will be 1.5. Other combinations of dry bulb and depression will give the same result.

Example: Dry bulb could be left at 120° F and the depression increased to 17° F, or the dry bulb could be raised to 140° F. and the depression left at 10° F. All of these would result in a 1.5 DRI and thus would dry the lumber at 5% per day.

Note: The above three choices, 130/13, 120/17 and 140/10, the EMC is 10.5, 9.1 and 11.9 respectively. It is clear that EMC has nothing to do with how fast lumber dries but it does mean that low temperatures and bigger depressions may mean the surface moisture content will be lower. In some cases, were this pressed to an extreme, it may make the surface shrink too much so that factor should be considered.

The best way to use the drying chart is to check the kiln each day. Calculate the moisture loss and then adjust the kiln temperature and humidity each day to achieve the drying rate desired. Each charge of lumber will be different and will result in a different drying schedule. For this reason, it will be clear that drying schedules are of little use except as a starting point. None of the drying schedule published state at what airflow they were developed. So running a schedule from a manual or another operation is ineffective as the airflow in the kiln may be different and may change through the cycle if variable speed fans are used.

Drying Tips

- Fresh cut lumber dries better and is less likely to be damaged during the drying process. Try to get it in the kiln as soon as possible.
- If you can't dry your lumber immediately after its been cut make sure that it is stacked, stickered and stored in a clean, dry place. Monitor it until it is ready to be put in the kiln as its moisture content will change during this time.

- Carefully plan your drying schedules for every batch of lumber and follow through with them, only making alterations when necessary. Neglecting an effective schedule can ruin product and cost you money.
- Air flowing through the lumber will be removing the moisture. Make sure you take the time to properly sticker and stack your lumber in the kiln. Better airflow will result in better drying.
- Use baffles and deflectors to control airflow inside the kiln when drying, it will be more efficient and result in more evenly dried lumber.
- Keep detailed records of every batch. If necessary you can use them as a reference when making improvements in scheduling or correcting mistakes.
- Make sure that an operator is always available when drying so that any necessary adjustments can be made as soon as possible. This will reduce the chance of any major issues during the process.
- Always double check your numbers at the end of a schedule to make sure that you have achieved your desired result.
- Every detail is important when drying lumber. Make sure that you are following operation and safety guidelines. Cutting corners can ruin your product, damage your unit, or even cause injury.
- If you are unsure about any aspect of operation or if something seems to be working incorrectly please contact **Wood-Mizer** as soon as possible.
Do not continue operation, attempt any adjustment or repair to a unit with out consulting a licensed professional.
- Once a batch of lumber is dried keep it in a clean, dry location, away from the elements. Ideally kept inside and off the ground.
- Always stay up to date with the latest information on lumber drying. Attend trainings and seminars whenever possible and keep in contact with your local forestry offices

Drying Chart

Wet Bulb Depression [Dry Bulb - Wet Bulb] °F

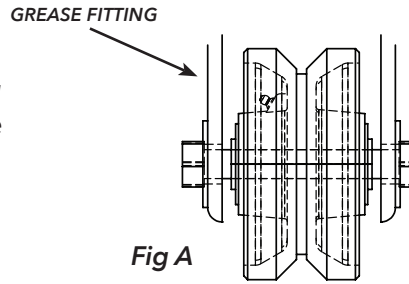
DryBulb °F	Measurement	2°	4°	6°	8°	10°	12°	14°	16°	18°	20°	25°	30°	35°	40°	45°	50°
30°	RH	78.0	57.0	36.0	17.0												
	EMC	15.9	10.8	7.4	3.9												
	DRI	0.0	0.1	0.1	0.1												
35°	RH	81.0	63.0	45.0	28.0	11.0											
	EMC	16.8	11.9	8.8	6.0	2.9											
	DRI	0.0	0.1	0.1	0.1	0.2											
40°	RH	83.0	68.0	52.0	37.0	22.0	8.0										
	EMC	17.6	12.9	9.9	7.4	5.0	1.9										
	DRI	0.0	0.1	0.1	0.2	0.2	0.2										
45°	RH	85.0	72.0	58.0	44.0	31.0	19.0	6.0									
	EMC	18.3	13.7	10.7	8.5	6.5	4.2	1.5									
	DRI	0.0	0.1	0.1	0.2	0.2	0.2	0.3									
50°	RH	86.0	74.0	62.0	50.0	38.0	27.0	16.0	5.0								
	EMC	19.0	14.4	11.5	9.4	7.6	5.7	3.9	1.5								
	DRI	0.1	0.1	0.1	0.2	0.2	0.3	0.3	0.3								
55°	RH	88.0	76.0	65.0	54.0	44.0	34.0	24.0	14.0	5.0							
	EMC	19.5	15.1	12.2	10.1	8.4	6.8	7.3	3.6	1.3							
	DRI	0.1	0.1	0.2	0.2	0.2	0.3	0.3	0.4	0.4							
60°	RH	89.0	78.0	68.0	58.0	48.0	39.0	30.0	21.0	13.0	5.0						
	EMC	19.9	15.6	12.7	10.7	9.1	7.6	6.3	4.9	3.2	1.3						
	DRI	0.1	0.1	0.2	0.2	0.3	0.3	0.4	0.5	0.5	0.5						
65°	RH	90.0	80.0	70.0	61.0	52.0	44.0	36.0	27.0	20.0	13.0						
	EMC	20.3	16.1	13.3	11.2	9.7	8.3	7.1	5.8	4.5	3.0						
	DRI	0.1	0.1	0.2	0.2	0.3	0.3	0.4	0.5	0.5	0.5						
70°	RH	90.0	81.0	72.0	64.0	55.0	48.0	40.0	33.0	25.0	19.0	3.0					
	EMC	20.6	16.5	13.2	11.6	10.1	8.8	7.7	6.6	5.5	4.3	0.7					
	DRI	0.1	0.1	0.2	0.3	0.3	0.4	0.4	0.5	0.6	0.6	0.7					
75°	RH	91.0	82.0	74.0	66.0	58.0	51.0	44.0	37.0	31.0	24.0	10.0					
	EMC	20.6	16.8	14.0	12.0	10.5	9.3	8.2	7.2	6.2	5.1	2.3					
	DRI	0.1	0.2	0.2	0.3	0.4	0.4	0.5	0.6	0.6	0.7	0.8					
80°	RH	91.0	83.0	75.0	68.0	61.0	54.0	47.0	41.0	35.0	29.0	15.0	3.0				
	EMC	21.0	17.0	14.3	12.3	10.9	9.7	8.6	7.7	6.8	5.8	3.5	0.3				
	DRI	0.1	0.2	0.3	0.3	0.4	0.5	0.5	0.6	0.7	0.7	0.9	1.0				
85°	RH	92.0	84.0	76.0	70.0	63.0	56.0	50.0	44.0	38.0	33.0	20.0	9.0				
	EMC	21.2	17.2	14.5	12.5	11.2	10.0	9.0	8.1	7.2	6.3	4.3	1.7				
	DRI	0.1	0.2	0.3	0.4	0.4	0.5	0.6	0.7	0.8	0.8	1.0	1.1				
90°	RH	92.0	85.0	78.0	71.0	65.0	58.0	52.0	47.0	41.0	36.0	24.0	13.0	3.0			
	EMC	21.3	17.3	14.7	12.8	11.4	10.2	9.3	8.4	7.6	6.8	4.9	2.8	0.9			
	DRI	0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.8	0.9	1.1	1.2	1.4			
95°	RH	92.0	85.0	79.0	72.0	66.0	60.0	55.0	49.0	44.0	39.0	28.0	17.0	8.0			
	EMC	21.3	17.4	14.9	12.9	11.6	10.5	9.5	8.7	7.9	7.1	5.3	3.6	1.9			
	DRI	0.1	0.2	0.3	0.5	0.6	0.7	0.7	0.8	0.9	1.0	1.2	1.4	1.5			
100°	RH	93.0	86.0	80.0	73.0	68.0	62.0	56.0	51.0	46.0	41.0	30.0	21.0	12.0	4.0		
	EMC	21.3	17.5	15.0	13.1	11.8	10.6	9.6	8.9	8.1	7.4	5.7	4.2	2.8	0.7		
	DRI	0.1	0.3	0.4	0.5	0.6	0.7	0.9	0.9	0.9	1.0	1.1	1.4	1.5	1.7	1.9	

105°	RH	93.0	87.0	80.0	74.0	69.0	63.0	58.0	53.0	48.0	44.0	34.0	24.0	16.0	8.0		
	EMC	21.4	17.5	15.1	13.2	11.9	10.8	9.8	9.0	8.3	7.6	6.1	4.6	3.3	1.8		
	DRI	0.2	0.3	0.4	0.6	0.7	0.8	0.9	1.1	1.2	1.3	1.5	1.7	1.9	2.1		
110°	RH	93.0	87.0	81.0	75.0	70.0	65.0	60.0	55.0	50.0	46.0	36.0	26.0	19.0	11.0	4.0	
	EMC	21.4	17.5	15.1	13.3	12.0	10.8	9.9	9.2	8.4	7.7	6.3	4.8	3.8	2.5	1.1	
	DRI	0.2	0.3	0.5	0.6	0.8	0.9	1.0	1.2	1.3	1.4	1.7	1.9	2.1	2.3	2.5	
115°	RH	93.0	88.0	82.0	76.0	66.0	61.0	56.0	52.0	48.0	38.0	29.0	22.0	14.0	8.0	2.0	
	EMC	21.4	17.5	15.1	13.4	12.1	10.9	10.0	9.3	8.6	7.8	6.5	5.2	4.1	2.9	1.7	0.4
	DRI	0.2	0.4	0.5	0.7	0.9	1.0	1.2	1.3	1.4	1.6	1.9	2.1	2.4	2.6	2.8	2.9
120°	RH	94.0	88.0	82.0	77.0	72.0	67.0	62.0	58.0	53.0	49.0	40.0	31.0	24.0	17.0	10.0	15.0
	EMC	21.3	17.4	15.1	13.4	12.1	11.0	10.0	9.4	8.7	7.9	6.6	5.4	4.4	3.3	2.3	1.1
	DRI	0.2	0.4	0.6	0.8	1.0	1.1	1.3	1.4	1.6	1.8	2.1	2.4	2.6	2.9	3.1	3.3
125°	RH	94.0	88.0	83.0	77.0	73.0	68.0	63.0	59.0	55.0	51.0	41.0	33.0	26.0	19.0	13.0	8.0
	EMC	21.2	17.3	15.0	13.4	12.1	11.0	10.0	9.4	8.7	8.0	6.7	5.5	4.6	3.6	2.7	1.6
	DRI	0.2	0.5	0.7	0.9	1.1	1.3	1.5	1.6	1.8	1.9	2.3	2.7	2.9	3.2	3.4	3.6
130°	RH	94.0	89.0	83.0	78.0	73.0	69.0	64.0	60.0	56.0	52.0	43.0	35.0	28.0	21.0	15.0	10.0
	EMC	21.0	18.2	14.9	13.4	12.1	11.0	10.0	9.4	8.7	8.0	6.8	5.6	4.8	3.8	3.0	2.0
	DRI	0.3	0.5	0.8	1.0	1.1	1.4	1.6	1.8	2.0	2.2	2.6	2.9	3.3	3.6	3.9	4.1
140°	RH	95.0	89.0	84.0	79.0	75.0	70.0	66.0	62.0	58.0	54.0	46.0	38.0	31.0	25.0	19.0	14.0
	EMC	1.0	16.9	14.8	13.2	11.9	10.6	10.0	9.4	8.7	8.0	6.9	5.8	5.0	4.1	3.4	2.6
	DRI	0.3	0.6	0.9	1.2	1.5	1.8	2.0	2.2	2.5	2.7	3.2	3.7	4.1	4.4	4.8	5.1
150°	RH	95.0	90.0	85.0	80.0	76.0	72.0	68.0	64.0	60.0	57.0	48.0	41.0	35.0	28.0	23.0	18.0
	EMC	20.2	16.9	14.5	13.0	11.8	10.8	9.9	9.2	8.6	8.0	6.9	5.8	5.1	4.2	3.6	2.9
	DRI	0.4	0.8	1.1	1.5	1.8	2.1	2.4	2.7	3.0	3.3	3.9	4.5	5.0	5.5	5.8	6.2
160°	RH	95.0	90.0	86.0	81.0	77.0	73.0	69.0	65.0	62.0	58.0	50.0	43.0	37.0	31.0	25.0	21.0
	EMC	19.8	16.2	14.2	12.7	11.5	10.6	9.7	9.1	8.5	7.9	6.8	5.8	5.1	4.3	3.7	3.2
	DRI	0.5	1.0	1.4	1.8	2.2	2.6	3.0	3.4	3.7	4.1	4.8	5.5	6.1	6.7	7.2	7.6
170°	RH	95.0	91.0	86.0	82.0	78.0	74.0	70.0	67.0	63.0	60.0	52.0	45.0	39.0	33.0	28.0	24.0
	EMC	19.4	15.8	13.9	12.4	11.3	10.4	9.6	9.0	8.4	7.8	6.7	5.7	5.1	4.4	3.7	3.2
	DRI	0.6	1.1	1.7	2.2	2.7	3.2	3.7	4.0	4.5	4.9	5.9	6.7	7.5	8.2	8.8	9.3
180°	RH	96.0	91.0	87.0	83.0	79.0	75.0	72.0	68.0	65.0	62.0	54.0	47.0	41.0	35.0	30.0	26.0
	EMC	18.9	15.5	13.7	12.2	11.1	10.1	9.4	8.8	8.1	7.6	6.5	5.7	5.1	4.4	3.8	3.3
	DRI	0.6	1.4	2.0	2.6	3.2	3.8	4.3	4.9	5.4	5.8	7.0	8.1	9.0	10.0	10.7	11.3
190°	RH	96.0	92.0	88.0	84.0	80.0	76.0	73.0	69.0	66.0	63.0	56.0	49.0	43.0	37.0	32.0	28.0
	EMC	18.5	15.2	13.4	12.0	10.9	10.0	9.2	8.6	7.9	7.4	6.4	5.5	4.9	4.4	3.8	3.3
	DRI	0.8	1.5	2.3	3.0	3.8	4.6	5.1	5.9	6.5	7.0	8.4	9.7	10.9	12.0	12.9	13.7
200°	RH	96.0	92.0	88.0	84.0	80.0	77.0	84.0	80.0	77.0	64.0	57.0	51.0	45.0	39.0	34.0	30.0
	EMC	18.1	14.9	13.2	11.8	10.8	9.8	9.1	8.4	7.7	7.2	6.2	5.4	4.8	4.3	3.8	3.3
	DRI	0.9	1.9	2.8	3.8	4.7	5.4	6.1	7.0	7.8	8.5	10.1	11.5	13.0	14.3	15.5	16.4
210°	RH	96.0	92.0	88.0	85.0	81.0	78.0	75.0	71.0	68.0	65.0	59.0	52.0	46.0	41.0	36.0	32.0
	EMC	17.7	14.6	13.0	11.7	10.6	9.7	9.0	8.3	7.6	7.1	6.1	5.3	4.7	4.2	3.7	3.2
	DRI	1.2	2.3	3.5	4.3	5.5	6.3	7.2	8.3	9.2	10.1	11.8	16.8	15.5	17.0	18.4	19.6
DryBulb °F	Measurement	2°	4°	6°	8°	10°	12°	14°	16°	18°	20°	25°	30°	35°	40°	45°	50°

Kiln Cart

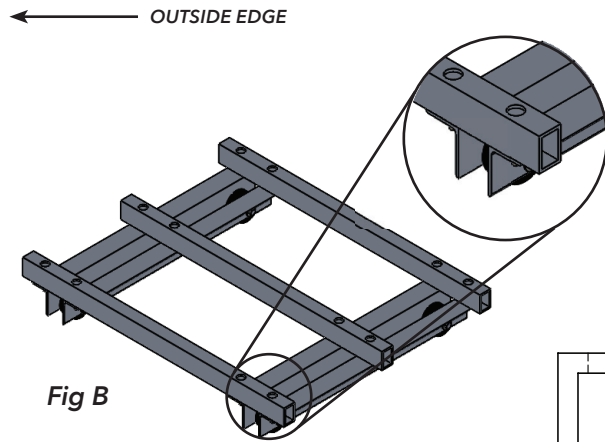
Cart Assembly

1. Install V Groove Wheels in the mounts using the wheel axle and flat washer; ensuring the wheels are oriented so the the grease fittings face outward. (See Fig A)



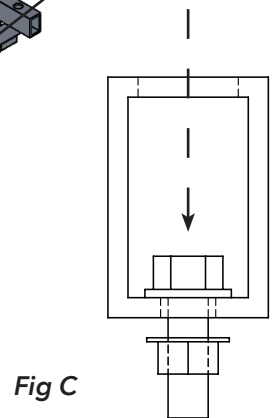
2. After installation layout the new installed cart frame out and place the rails on top aligning the holes. (see Fig B)

Note: when placing the rails on the frame be sure to have the smaller holes facing the frame and larger holes facing up.

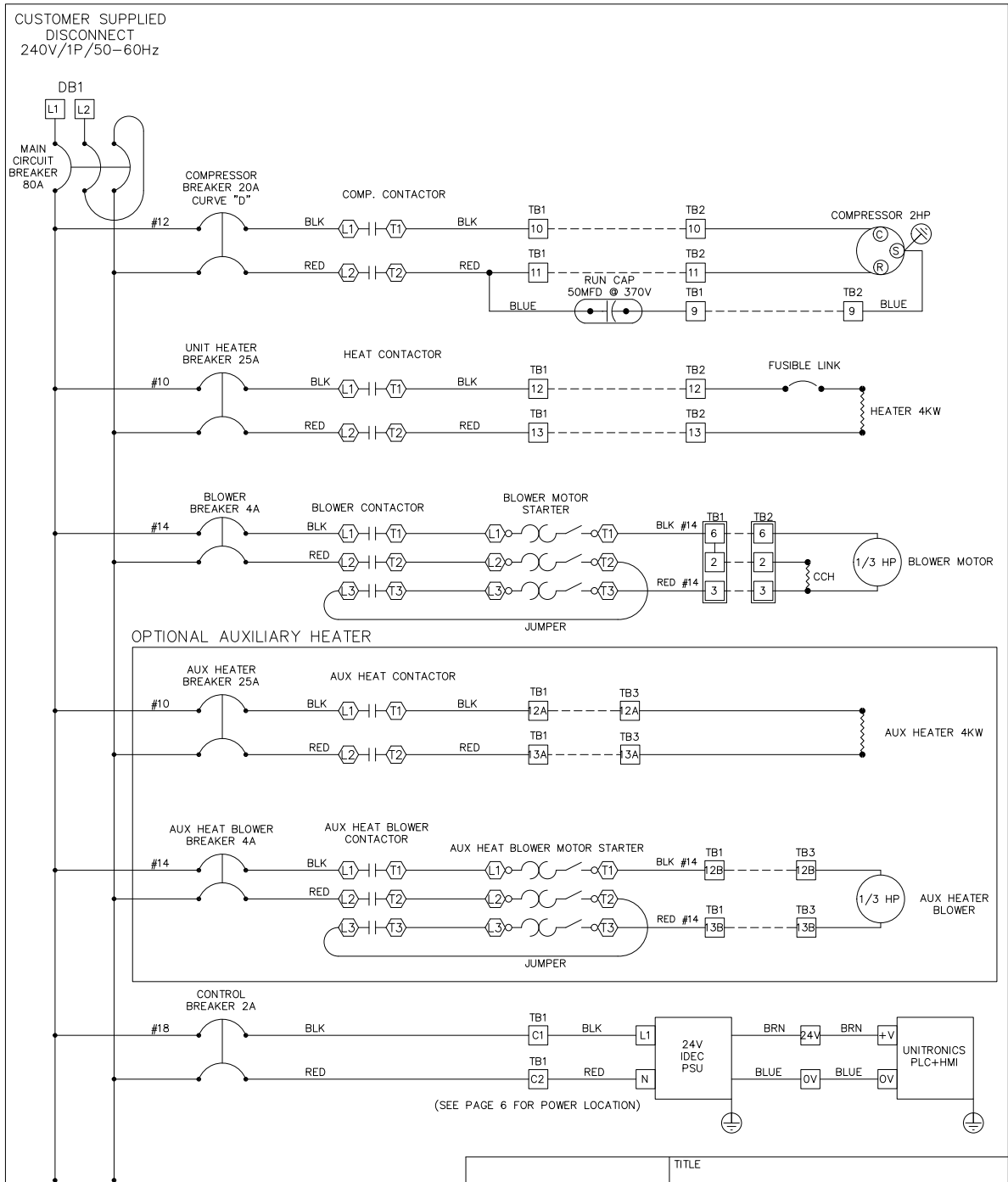


3. Install rails onto the base frame using the supplied bolts and locknuts. (See Fig C)

Note: To tighten the bolts, go through the top holes in the rail with a ratchet, 3/4" socket and extender.



Wiring Diagrams

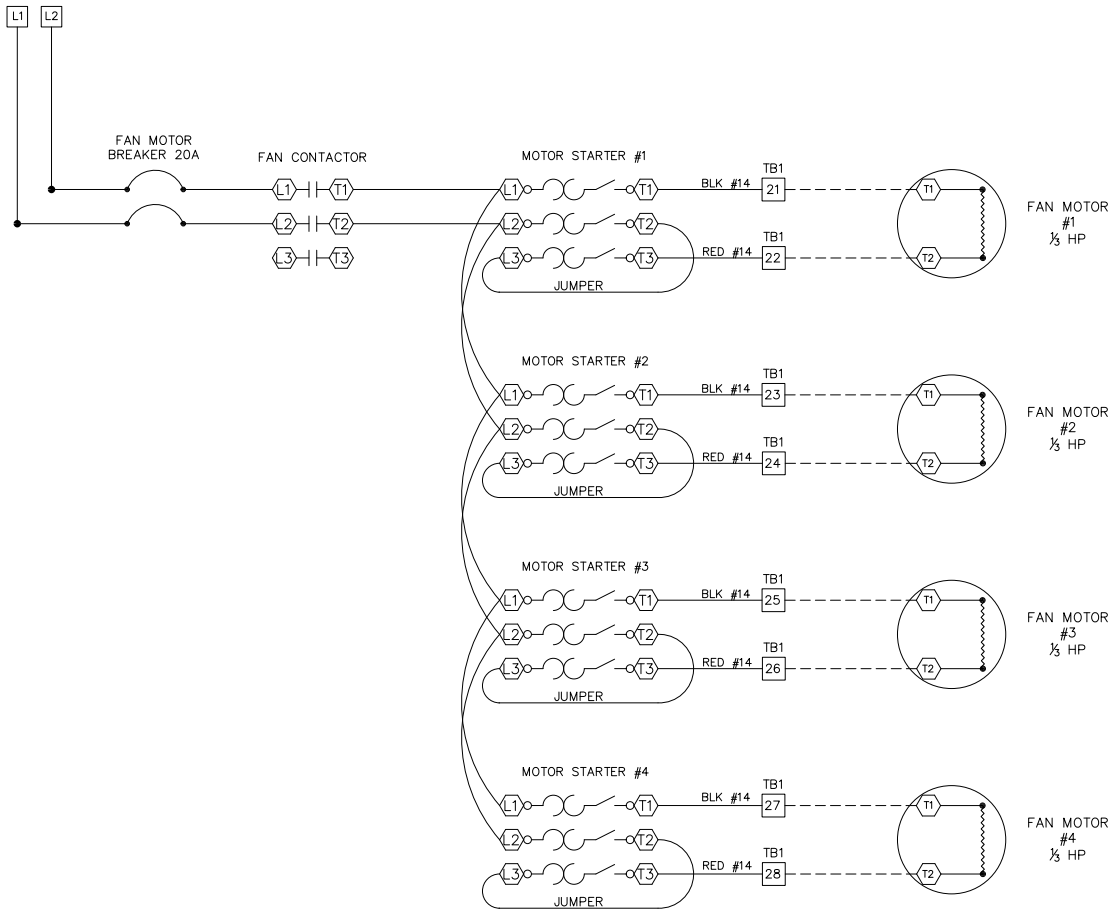


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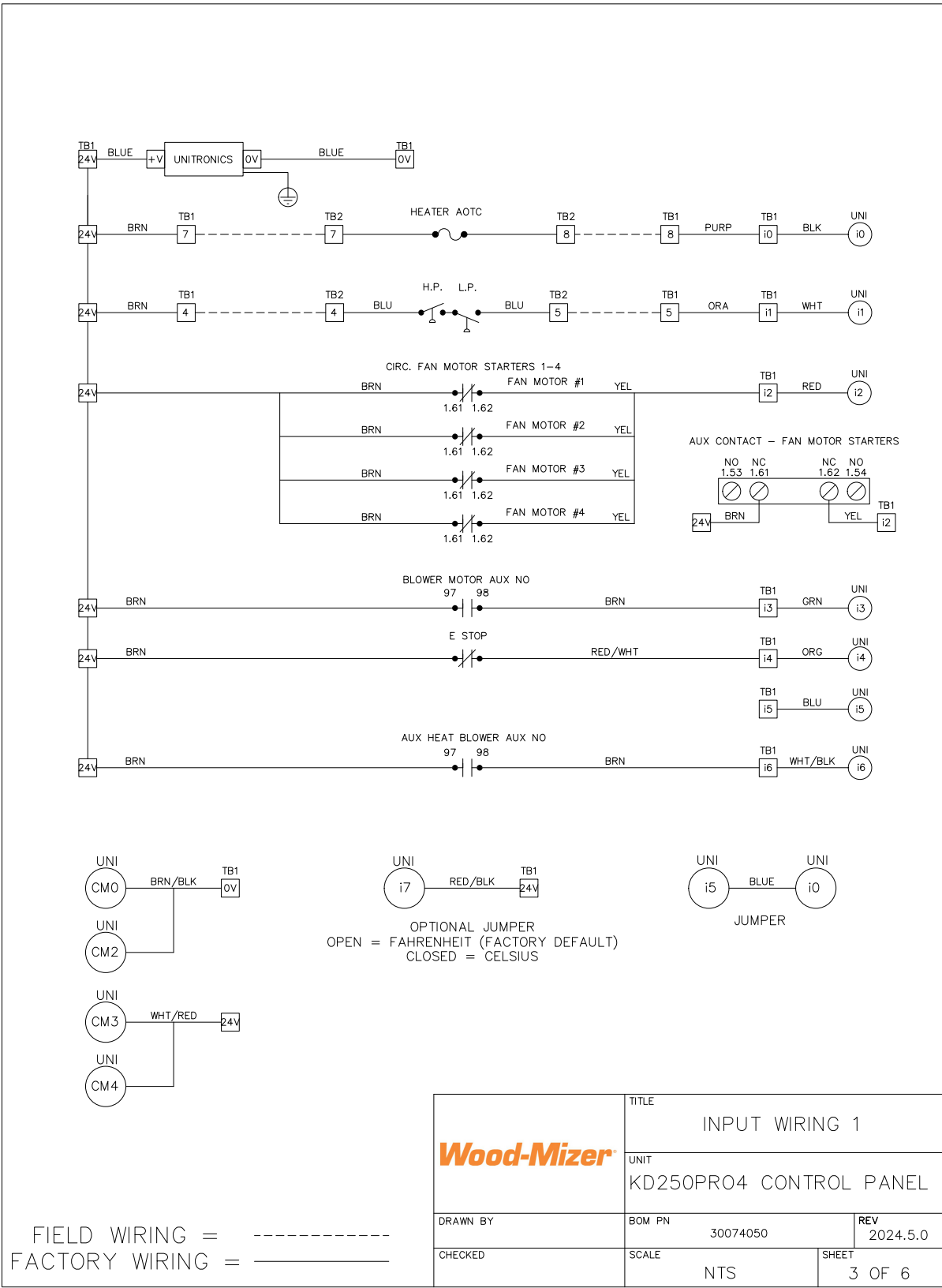
Wood-Mizer	TITLE POWER WIRING 1-1	
	UNIT KD250PRO4 CONTROL PANEL	
DRAWN BY KK	BOM PN: 30074050	REV 2024.5.0
CHECKED AS	SCALE NTS	SHEET 1 OF 6

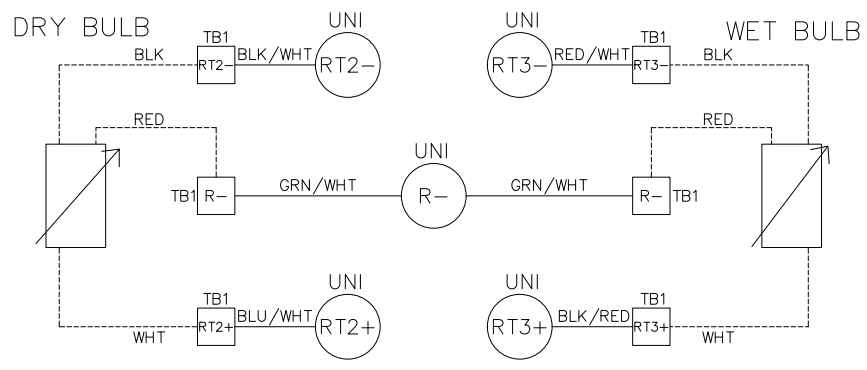
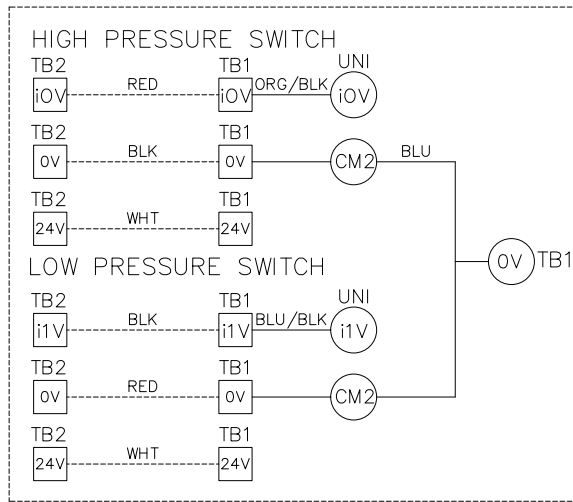
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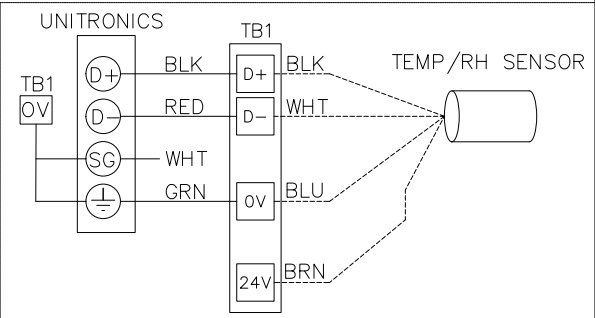
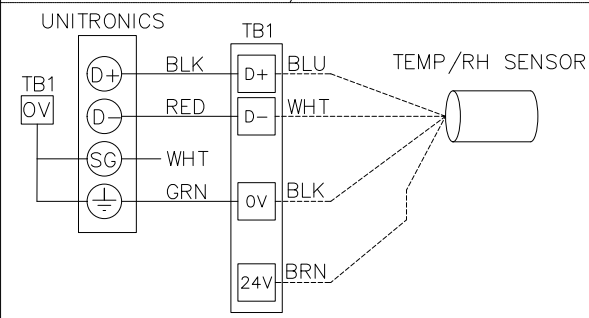
Wood-Mizer	TITLE INPUTS/SENSOR WIRING 1-1	
	UNIT KD250PRO4 CONTROL PANEL	
DRAWN BY	BOM PN: 30074050	REV 2024.5.0
CHECKED	SCALE NTS	SHEET 2 OF 6





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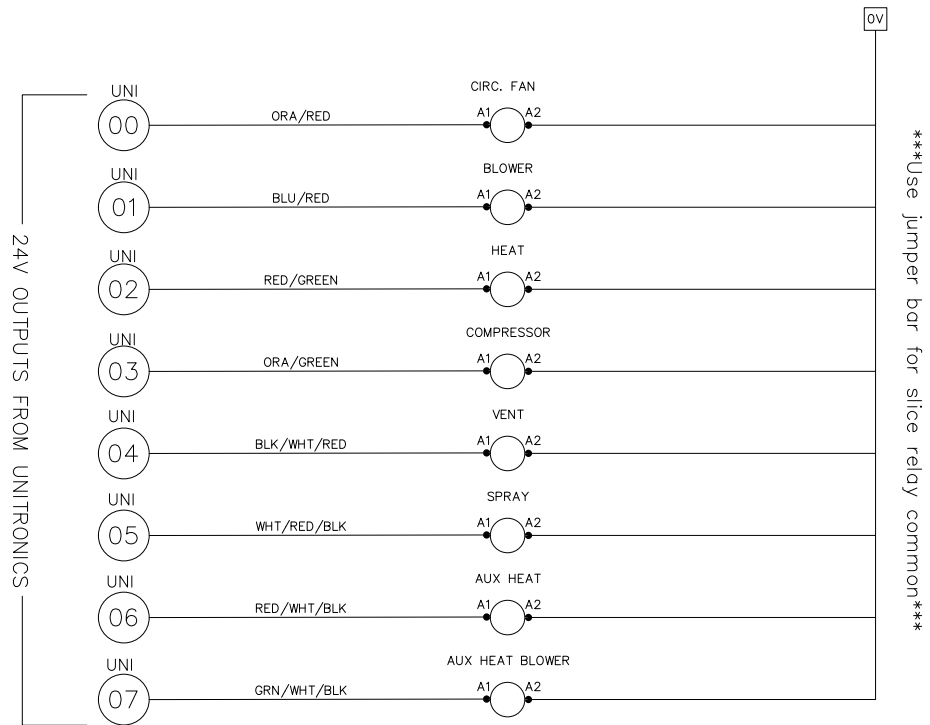
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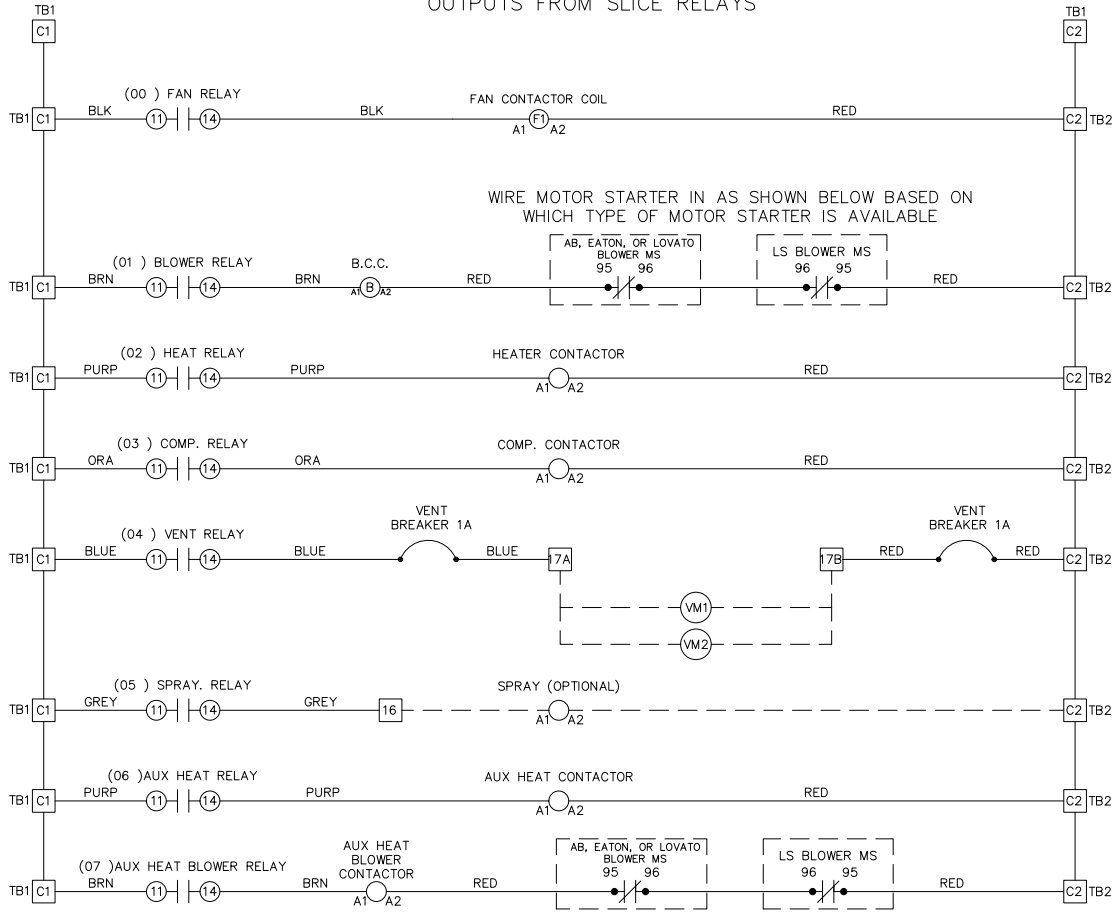
Wood-Mizer		TITLE INPUT WIRING 2	
		UNIT KD250PRO4 CONTROL PANEL	
DRAWN BY	BOM PN 30074050	REV 2024.5.0	
CHECKED	SCALE NTS	SHEET 4 OF 6	

OUTPUTS TO SLICE RELAYS



Wood-Mizer	TITLE OUTPUT WIRING 1	
	UNIT KD250PRO4 CONTROL PANEL	
DRAWN BY	BOM PN: 30074050	REV 2024.5.0
CHECKED	SCALE NTS	SHEET 5 OF 6

OUTPUTS FROM SLICE RELAYS



WIRE MOTOR STARTER IN AS SHOWN BELOW BASED ON WHICH TYPE OF MOTOR STARTER IS AVAILABLE

FIELD WIRING = - - - - -
 FACTORY WIRING = _____

Wood-Mizer	TITLE OUTPUT WIRING 2	
	UNIT KD250PRO4 CONTROL PANEL	
DRAWN BY	BOM PN: 30074050	REV 2024.5.0
CHECKED	SCALE NTS	SHEET 6 OF 6

KD250Pro Maintenance

General Maintenance

The KD250Pro is designed for continuous duty, with little maintenance. However, when a problem does arise prompt repair will ensure long life for the machine.

The blower system is direct drive and the motor has sealed high temperature ball bearings. This unit does not need regular maintenance.

The circulating fan system is also direct drive with a ball bearing motor. The motor does not require lubrication.

Air Inlet Filters

The air filters are provided to keep the air inside the unit as clean as possible. Dirt build-up on the coils will lead to poor heat transfer with loss of capacity.

In extreme cases, the coil will completely clog. The air filter should be washed when dirty and replaced when necessary. If the filter becomes clogged, the air supply will be drastically reduced, causing the heater to overheat and the refrigeration system to overload. Evap coil should be kept clean. Clean with dish soap and water.

Refrigerant Charging Procedure

The refrigeration system is a closed loop system with its own lubrication oil supply. The system should give years of trouble free service. However, if the system is not removing the right amount of water, or if a problem should arise from rough shipping or a refrigeration leak, the system should only be looked at and worked on by a qualified refrigeration mechanic.

When the system experiences reduced water output, this is generally associated with a leak in the refrigeration system. If the leak is found and repaired before the system is empty, there is little chance that the system will be contaminated with moisture. If the system is ignored for a long period of time, moisture can enter the system and combine with the refrigerant to form acid. The system will then corrode from the inside-out if not corrected properly.

Warning: Refrigeration professionals should use caution, these refrigeration conditions are uncommon.

These systems operate over a very wide temperature and humidity range. The pressures will be relatively high when compared to air conditioners and heat pumps. For these reasons, you cannot charge by the sight glass, the sight glass will eventually clear at certain conditions but it is unlikely that those conditions will exist when servicing.

If the kiln is loaded with lumber, it will be very dangerous to run the kiln at extreme limits, as the lumber will degrade severely. With this danger factor and the factor of time involved of heating the kiln, Wood-Mizer insists that these machines have weighed in charge. The amount is as follows:

KD250Pro 60 oz. R134a

CALL WM IF YOUR TECHNICIAN LACKS THE RECOMMENDED REFRIGERANT. WE CAN RECOMMEND ALTERNATIVES.

Appendix

Terminology

DRY BULB: The temperature as measured by a thermometer.

WET BULB: The temperature of a thermometer with a wet wick over the sensor.

WET BULB DEPRESSION: The difference between the dry bulb temperature and the wet bulb temperature.

Example: if the dry bulb is 105° F. and the wet bulb is 98° F., the depression is 105° F. - 98° F., or 7° F.

RH-RELATIVE HUMIDITY: The ratio of the amount of water in the air to what the air could hold. At 50% RH, the air has 50% as much water in it as it would hold at 100% RH. 100% is a 0° F. depression.

EMC-EQUILIBRIUM MOISTURE CONTENT: This is the average moisture content all wood will reach eventually when exposed to these conditions.

DRI-DRYING RATE INDEX: This is an index of relative drying rate.

Problem	Possible Causes / Actions	Corrections
Circulating Fan(s) won't Start	<ul style="list-style-type: none"> • New Install: Check your wiring • Existing System: Check your amp draw • Check motor rotation for signs of sticking or grinding. 	<ul style="list-style-type: none"> • Rewire or tighten connections. • If amps are high: check capacitors, replace if needed. • If rotation is sticking or grinding, bearings or bushing are bad, replace motor.
Unit won't Start	<ul style="list-style-type: none"> • Control Switch Tripping • Check Power 	<ul style="list-style-type: none"> • Rewire or tighten connections. • Check capacitors, replace if needed. • If Switch keeps tripping, replace switch.
No Heat	<ul style="list-style-type: none"> • Check that the automatic over temperature control switch (AOTC) is in auto position & the control is calling for heat, use wiring diagram to check heat circuit. • Check fusible link • Check heater coil 	<ul style="list-style-type: none"> • Replace the AOTC or fusible link if bad. • Replace whole heater if coil is bad.
Compressor doesn't run	<ul style="list-style-type: none"> • High Pressure Switch has tripped • Fault in circuit 	<ul style="list-style-type: none"> • Reset High Pressure Switch. • With a multimeter and wiring diagram check if: <ul style="list-style-type: none"> • Low Pressure switch tripped ; call WM. • Time delay relay is bad; Replace if it is. • Compressor has power ; call WM if it does.
Unit Starts and Runs but Screen is Dead	<ul style="list-style-type: none"> • Bad fuse in controller 	<ul style="list-style-type: none"> • Check fuse if fuse is bad, call WM.
Water isn't Draining	<ul style="list-style-type: none"> • Issue with drain line/ trap 	<ul style="list-style-type: none"> • Clear any blockages in drain line / trap. • Add trap to drain line if no trap installed.
Temperature is flashing ERR or both Wet & Dry Bulb	<ul style="list-style-type: none"> • Wet bulb too high • Wet bulb equals Dry bulb 	<ul style="list-style-type: none"> • Check Wet bulb bottle for water. • Check Wet bulb wick. • Make sure Wet bulb temperature doesn't equal Dry Bulb Temp.



Fusible Link
Automatic Over Temperature Control Switch (AOTC)

Still need help? Check out the video series KilnTECH on YouTube for more support



Upgrades & Accessories

Spray Systems Kit

Although not standard on Wood-Mizer DH Kilns you may choose to add on this optional Spray System Kit which will provide extra control when drying. The Sprayers are designed to be automatically activated by the system when needed and help with regulating the relative humidity within the kiln chamber.

Wood-Mizer spray systems are designed to inject into kiln air one gallon of water per hour for every 1000 BF. Because air temperature affects the quantity of water evaporated (warmer air holds more water vapor), we need to balance the quantity of water vapor to the kiln capacity. DH units with small heaters will require proportionately less water than larger units with bigger heating capacity. There are options available for every unit so be sure that the kit you are purchasing matches the specifications for the unit that it will be installed in.

Wood-Mizer encourages boosting water pressure to 100 psi for the spray system to have the best results. Commonly this is done with the use of a jet pump, which can be purchased, if requested. Contact your Wood-Mizer Sales or Service Representative for more information.

See "Getting Service" in the front of this manual.

Heat Booster Packages



The Heat Booster is an auxiliary heater that can be connected to the control and provide additional heat and airflow within the kiln. This upgrade is used to;

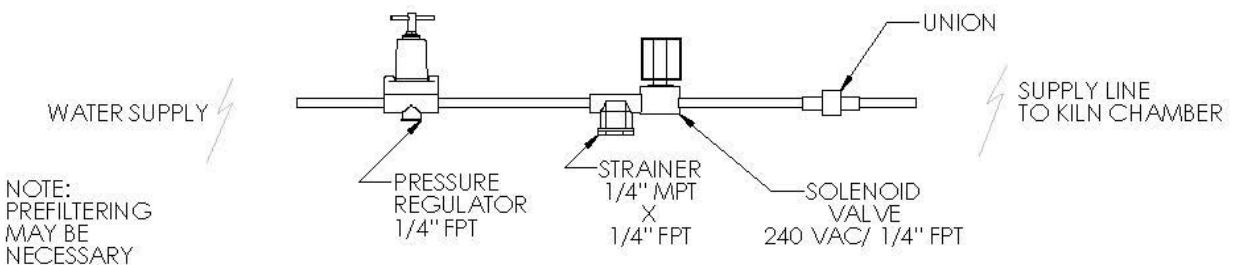
Set Pitch: The heat booster allows the kiln temperature to reach 160° F to set the pitch and prevent any future running.

Note: Pitch setting is only required when drying Pine.

Sterilize the Load: By the kiln reaching 160° F it also sterilizes the load. During this sterilization process any bugs or mold in the wood is killed off.

The heat booster is also used to increase the speed at which the kiln chamber heats to the desired temperature. This becomes useful for when you have a larger chambers.

CONTROL ROOM ASSEMBLY OF SOLENOID VALVE, STRAINER, AND REGULATOR



NOTE:
PREFILTERING
MAY BE
NECESSARY

LOCATE SUPPLY LINE IN A CONVENIENT LOCATION

ELECTICAL CONNECTIONS:
WIRE THE SOLENOID VALVE BACK TO NYLE ELECTRICAL
PANEL AND CONNECT TO TB1 [16] AND [N]

Kiln Store

Wood-Mizer likes to be there for our clients whether they have just bought a new kiln or if they have owned a kiln for years. It is because of this that we try to make replacement parts easily accessible right Online in our Kiln Store.

From The Kiln Store you can find many parts, equipment and accessories for both conventional kilns and DH kilns. Anything and everything you need to keep your **Wood-Mizer** Kiln running for years to come. We even sell parts supplies that will fit **Non-Wood-Mizer** kilns if you need them.

At The Kiln Store you can expect to find everything you need including:

- Accessory Kits
- Controls and Control Accessories
- Additional Heaters and Fans
- Sample Testing Supplies and Charts
- Replacement Meters, Probes and Sensors
- Replacement Belts, Filters and Parts

So when you need a part for your kiln you don't have to look any further than www.woodmizer.com to find exactly what you need.

If you ever need assistance don't forget **Wood-Mizer's** star service team is always available to help you whether its finding the right replacement part or purchasing additional accessories for upgrades.

Contact your **Wood-Mizer** Sales or Service Representative for more information.

Warranty

LIMITED WARRANTY: The equipment supplied by **Wood-Mizer** Dry Kilns is warranted to be free from defects in workmanship and materials for a period of one year from the date of the original installation under normal use and maintenance, or 15 months from the date of delivery, whichever comes first. A new or re-manufactured part will be supplied by **Wood-Mizer** Dry Kilns if the defective part is first returned to **Wood-Mizer** Dry Kilns for inspection. The replacement part assumes the unused portion of the warranty. The warranty does not include labor or other costs incurred for diagnosis, repairing or removing, installing or shipping the defective or replacement part(s). **Wood-Mizer** Dry Kilns makes no warranty as to the fitness of the equipment for a particular use and shall not be liable for any direct, indirect or consequential damages in conjunction with this contract and/or the use of its equipment. Buyer agrees to indemnify and save harmless **Wood-Mizer** Dry Kilns from any claims or demands against **Wood-Mizer** Dry Kilns for injuries or damages to the third parties resulting from buyer's use or ownership of the equipment. No other warranties, expressed or implied, will be honored unless in writing by an authorized officer of **Wood-Mizer** Dry Kilns.

Model _____

Serial Number _____

Date Purchased _____

Notes
