

BTC 9100 Controller Manual

Single Program Degrees Per Hour Ramp Rate Controller with Soak



NOTE: Please read instructions before using your kiln.
Failure to do so may result in damage to the kiln and it's contents.

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SECTION 1 - Getting to know your Controller

The BTC 9100 Digital Temperature controller is designed to allow automatic firing to a set temperature at a set rate of rise. Once the Kiln has reached that temperature the Kiln can then Soak (dwell) at the set temperature for a set number of minutes.


The Controller has two rows of the digital read out:

The Top **RED** row is the **PV** or **Present Value**

This represents the Temperature of the Kiln at that moment. This is the temperature being measured at that moment by the Thermocouple (the internal thermometer that protrudes into kiln).

The Bottom **GREEN** row is the **SV** or **Set Value**

This is the Set Value for either the Temp, Soak or Ramp Rate.

The  button to the bottom left of the controller cycles through the three values. The "▲" or "▼" arrows adjust the Set Value.

The **R** button is for reset

The OP1 Light in the top Left above the PV lights up when the Elements are ON.

The ALM light indicates that the program has finished and the Kiln is cooling.

SECTION 2 – Programming your Controller

2.0 Turning the Kiln On


- I. Turn power ON at the power point (if not already hardwired).
- II. Turn the BLACK on/off Rocker switch on the front of the control panel to the ON position.
The "Cycle End" light should be illuminated.

2.1 Setting the Firing temperature

Set the Temperature you wish to fire to by pressing the "▲" or "▼" arrows on the front of the digital controller. The longer you hold the buttons down the faster the setting changes (Like an alarm clock).



2.2 Setting the Soak Period (soak time setting)


Now press the  Scroll Button in the bottom left corner of the controller to advance to the Soak Point Timer. This is indicated when the controller display “**SP3**” in the top display (as shown below) This Soak time is measures in Minutes and Seconds of Soak Time required. The range is from 1 second to 999 minutes. (Mins.Secs)



2.3 Setting the ramp rate (or Heating rate)


WARNING: The BTC9100 controller can be set as either Deg/hr or Deg/min.

(If this is the first time you are running a new controller it is worth checking by setting the **rr** rate to 60 and then running the Kiln for a few minutes. If the Kiln shoots up very quickly then the controller is set to Deg/min. This is generally the case for older units. You will need to divide all the recommended firing rates by /60 to determine what firing rates in Deg/min you need to enter.)

Now press the  Scroll Button in the bottom left corner of the controller again to advance to the “**rr**” Ramp Rate setting. This is indicated when the controller displays “**rr**” in the top display. This is the rate at which the kiln heats to the desired firing temperature. This mean that for every hour the kiln is running the temperature should increase by the rate set. To adjust this rate up or down simply use the “▲” or “▼” arrows on the front of the digital controller.



Note: The controller is set up to show the ramp rate (**rr**) in Deg C/hr (or Deg/min for older units).

You can now or at any time during the firing press the  Scroll Button in the bottom left corner of the controller to scroll through and see what settings you have programmed for the Temp, Soak (**SP3**) Time of Ramp Rate (**rr**)

SECTION 3 - Running the Kiln

3.1 To Start the Firing

It is advised that you always turn the Kiln OFF and then back ON between or after each firing. This resets the controller so it knows to begin a new firing and ensures it does not become confused.

To begin Firing Press the square **RED** Start Button.

The “Cycle End” light will turn off.

The controller will indicate that the kiln elements are being turned on by illumination of a small square red indicator light (marked OP1) in the top right hand corner of the controller.

The bottom display will start to indicate the theoretical target temperature which the kiln chamber should be at any point during the programmed firing. Visual checking of the bottom theoretical program display with the top actual process value display will be helpful to the operator to ensure that the kiln is able to keep up with the program.

NOTE: The Kiln will not always show the PV and SV being equal. The Controller will attempt to keep these values being equal but may lag or overshoot from time to time. This is the normal function of the controller. If these do become separated by a large amount you may have an issue with the Kiln not being able to keep up with the program or there may be a problem with the Kiln.

3.2 Completion of Firing

At the moment that the kiln reaches the set value (set temperature) both the top display and the bottom display will show this value at the same time. The program has now moved into the “timed soak” stage of the program. When the “timed Soak” period has been completed, the small red alarm light and the END light will be ON. The Kiln will now “Turn Off” as the firing is now completed and the kiln temperature will begin to fall. The top display will continue to display the falling temperature and the bottom section will display the set temperature that the Kiln reached.

SECTION 4 - Firing Time

4.1 Influences on Firing Time

For kilns & kilns fitted with Non Indicating Control firing time depends upon many use factors including the type of ware, the mass of the ware and the temperature which the furnace is required to operate at. Once the operator has learned the heating time taken for the particular process for which the kiln is being used, this time should be noted so that in future, the kiln can be checked to observe that it is not taking an unusually long time to reach the set temperature- which could indicate a problem with the kiln.

NOTE: The firing time will vary slightly with variations in the mass of the load, but this is normal.

4.2 Adjusting the Ramp rate while running a program

The heating rate can easily be adjusted while running by changing the “**rr**” value. Press the scroll button (left hand button) and advance to the “**rr**” setting. This requires two presses of the button. Providing the operator does not set an excessively high ramp rate that the kiln cannot achieve, the firing time will be predictable.

NOTE: If a ramp rate of 0000 (zero) is set, the ramp feature of the control will be defeated and the kiln will heat at the fastest possible speed. ie The natural full power heating rate of the kiln.

4.3 Firing Time - Influences on Firing Time

It is possible to set the firing rate to a speed that is faster than the kiln power can provide. Therefore it is important to learn what the kiln is capable of providing particularly at the very end of the firing. The maximum firing rate will be influenced by many factors including the type of ware, the mass of the ware and the maximum temperature to which the kiln is required to operate. Once the operator has learned the maximum heating rates and has the times, then the firing rate can be set so that it is always controlling the kiln and so the firing time (for a particular setting rate) from one firing to another will always be the same. The kiln can be checked to observe that it is not taking an unusually long time to reach the set temperature-which could indicate a problem with the kiln.

SECTION 5 - Suggested Firing Ramp Rates and Soaks.

	Top Temp	Soak (Sp3)	Ramp Rate (rr)
Bisque (Check Clay Recommendations)	980°C - 1000°C	10 mins	60°C - 100°C / hr
Earthenware Glaze (Check Glaze recommendations)	1080°C - 1100°C	15 - 30 mins	100 °C - 150°C /hr
Stoneware / Porcelain (Check Clay Recommendations)	1220°C - 1260°C	10 mins	60°C - 100°C / hr
Stoneware / Porcelain Glaze (Check Glaze recommendations)	1220°C - 1260°C	0 - 15 mins	100 °C - 150°C /hr