***Instructions for***

**Model “K” Electric Elrod**

**Crucible and Throat Thermostat Calibrations**

1. **Crucible Thermostat Calibration**.
2. Set thermostat knob at 500o F.
3. Insert hot metal thermometer in crucible.
4. Wait until thermostat pilot light goes out.
5. Check temperature reading on thermometer in crucible.
6. Remove knob of thermostat and adjust to reading of thermometer by loosening two small screws and rotating the index dial. (Note: This should be done in multiples of 25o to prevent damage to thermostat.)
7. Thermostat knob should be replaced and crucible temperature should be increased by turning up thermostat in steps of 25o until thermostat is set at 600o. Points C, D and E should be repeated after each 25o increase in temperature.
8. Allow machine to cycle at least three times or approximately ½ hour. Recheck calibration and make any minor adjustment necessary.
9. Lock and replace plate over adjusting screws and replace knob.
10. **Throat Thermostat Calibration.**
11. Leave crucible thermostat set at 600o F. (Note: This should be done because of heat transfer.)
12. Be sure sealing heater switch is turned off.
13. Set throat thermostat knob at 500o F.
14. Wait until thermostat pilot light goes out and note mold housing indicator for amount of melt out.
15. Remove knob of thermostat and adjust index dial in multiples of 25o (to prevent damage to thermo-stat). If indicator had not started to melt out, ad-justment should be made to increase temperature.
16. Thermostat knob should be replaced and thermo-stat turned up in steps of 25o until the setting is at 575o. Indicator should be checked for melt out after each 25o increase in temperature and any necessary adjustments made with the index dial. Correct setting is achieved when indicator is melted out to approximately 1/16” of complete melt out with the thermostat set at 575o and the thermostat pilot light out.
17. Allow machine to cycle at least three times or approximately ½ hour. Recheck calibration and make any adjustment necessary.
18. Lock and install plate over adjusting screws and replace knob.

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