



Coil Heater Installation and Operation Guideline



Typical Technical Specifications:	
Heater Sheath	SS 321
Max Temperature	1382F
High Volt Stability	800VAC
Insulation Resistance	$\geq 5M @ 500VDC$
Leakage Current	$\leq .1mA @ 253VAC$
Wattage Tolerance	$\pm 10\%$
Max Voltage	250VAC
Minimum Bending Radius	5mm Heated Zone 4mm Unheated Zone

Dear Customer,

Thank you for your trust in Hotset heating elements.

Hotset heaters stand out due to their wide range of high performance features. Therefore they can be designed for individual applications and manufactured for optimum performance.

Hotset heaters are quality products – at every stage of their development and manufacturing they have to reach and pass our high quality standards.

This high standard of quality guarantees the long-lasting and reliable operation of the heaters when used in compliance within the following guidelines.

And of course if you have any further questions please feel free to contact us.

Installation:

- Installation should only be performed by people trained in electrical hookup.
- Keep in mind the minimum bending radius. Once the part is bent do not attempt to bend again.
- Do not bend the adapter head or the first 5mm (.197") from the head.
- Do not hold onto the connection head with a clamping method.

- Only use Non-Electrically conductive sprays and pastes for installation.
- Heaters should be installed with a holding device. Higher operating temperatures may cause the heater to lift off the tool causing premature failure and false thermocouple readings.
- Heaters should be installed by screwing on to tool. Never open the ID of the heater by twisting as it will not fit correctly and fail prematurely.

Temperature controllers:

- Temperature Controllers have to be matched to the heaters amp load with an appropriate thermocouple sensor input.
- Only use controllers that include a "Soft Start" function. This will allow the heater to burn off any moisture inside before applying full voltage.

Connections:

- Installation must protect adapter head and lead connection areas from liquids and gasses to avoid short circuits.
- If using a separate thermocouple be sure that the TC is not electrically grounded to the heater casing which could cause a feedback to the controller inputs.
- Watch sharp edges along the lead wire path.
- Be mindful of the maximum temperature of the lead wires during planning to avoid melting during operation.
- In cases where the heater is using the casing as the second power lead,

the tool temperature must stay below the corrosion point.

- Voltage differences have a dramatic effect on wattage output and heater life. Be sure the voltage is correct for the heater design. You will find the designed voltage stamped onto the heater.
- If using the internal thermocouple please be sure to follow the standard wiring polarity. If the temperature reading drops after power is applied the most common cause is the thermocouple is wired backwards.

Operation:

- All installations must be electrically grounded.
- Do not touch the heating element while in use – they get very hot.
- Please mount the heater so that there is no chance of fire from flammable material.

Storage:

- Store at room temperature in a dry location.

General Information:

- Please be sure to check over the order confirmation for any other information concerning operation or special applications.
- If the lead wires are supplied without insulation or with removable sleeves the customer must take care to insure their protection from electricity.