

hotcast Die-Casting Nozzle Heater (Type GMH)

Installation and Storage Advice

Dear Customer!

Thank you for your trust in hotset heating elements.

Sealed heaters by hotset stand out due to their wide range of high performance features. Therefore they can be designed for individual applications and manufactured to a performance profile that is adjusted to a specific task. Solutions which meet the industrial requirements.

Sealed heaters by hotset are quality products made in Germany – at every stage of their development and manufacturing they have to reach and pass our high quality control standards. This high standard of quality guarantees the longlasting and reliable operation of the sealed heaters when used in compliance with the technical instructions.

Please do not hesitate to contact our representative, in case you require any further details regarding the installation and operation of the hotset sealed heaters or the product range.



hotcast Sealed Heater (Type GMH)
Compact, sealed heating solution!

Installation

- Please secure that heating elements will only be connected from instructed operators.
- Clean cones before installation.
- Check confirmity of cones at gooseneck and nozzle before installation.
- Spray cones and thread with assembly spray (Our "Isolite-Spray" is especially designed for those applications).
- The set nut has to be screwed on before installation of a new sealed heater.
- Check centre between gooseneck and tool.
- When installing, the cone in the gooseneck has to be warm and the nozzle tip has to be cold.
- Observe accuracy of connecting surface at the nozzle tip:
 - GMH 5 – 100, 1 x 45°
 - GMH 125 – 200, 2 x 45°
- The nozzle tip should short as possible to temperature loss.

Connections

- Protect connections against the ingress of zinc, grease, lubricants and oils.
- Do not bend metal sleeving.
- Connection tube must be adjusted vertically from the nozzle.
- Avoid tensile loads onto connection leads.
- Pay attention to the connection voltage.
- Thermocouple leads: pay attention to the correct polarization and complete protection against accidental contact of heating elements with an integrated thermocouple.
- Between power conductors and thermocouple is only a basic insulation.
- Thermo leads and contacts must be shock protected.

Temperature Controllers

- Only install NiCr-Ni temperature controllers with automatic soft start function (suitable temperature controllers are available from hotset).

Operation

- Please secure that heating elements can not touch flammable material while in use.
- To expel any moisture, slowly increase the temperature to 100 °C / 212 °F.
- Always earth sealed heater at the side facing the machine.
- Observe maximum temperature data provided by the manufacturer of the materials processed.
- Minimize cooling of cone as much as possible.
- Do not touch heating elements while in use because they can get very hot.
- Do not heat the nozzle external (e. g. by a flame).
- Please note that a temperature control of hotcast GMH above the normal processing temperature of approx. 430 °C / 806 °F may lead to a limited service life under certain circumstances!

Storage

- Store at room temperature in a dry place.

General Information

- For further security information for special applications please take a look at our order confirmation.
- If our heating elements are delivered with connection leads without insulation (naked connection) or with removable insulation (covered with GLS-sleeving), the customer himself has to take care about the protection against electricity.