



## Technical Letters

### How To Properly Install Square & Round Profile Coil Heaters

- For installation never open the ID of the coil heater to slide on the part. Opening the diameter could lead to improper fit which reduces the surface contact and drastically reduces the life of the heater.
- Heater should be screwed onto the nozzle - Never Pushed.
- When installing the heater the connection head or transition section should not be used as a handle.
- The coil section can only be formed once. Please do not try to change the diameter after being coiled.
- Transition zone (cold section) should only be bent once - if needed.
- Minimum bending radius is .500 inch. The use of a shaft is recommended when forming to insure this.
- No bends should be placed within .500 inch of any bend.
- The connection head and leads are heat resistant to a maximum of 280°C. Additional protection is available if needed.
- Sharp tools should never be used when forming or installing the heater.
- For units controlled by the built in thermocouple special care is needed during installation to insure that the last coil is in contact with the nozzle. Improper contact will result in material burning or severe overheating.
- As the heater may be twisted by coiling we recommend that flat and square type coil heaters be coiled by National Plastic Heater.
- Please insure that no liquids or gases can enter the connection area of the heater unless a special connection has been installed, as this may cause a short circuit.
- Protect the leads from chaffing during installation and operation as this may cause a short circuit.
- Be sure to check the controller to ensure that it can handle the load and thermocouple, installed in the heater.
- Please take care that all sensors and wiring is done correctly before first power up, as units heat very quickly and can fail if allowed to operate uncontrolled.
- We recommend the use of soft start or rank soak controllers so that the heaters can dry before reaching 200°F.
- Ground the tool before operating.

- Please enforce security procedures for the handling of electrical products and ensure that all operators are aware of the heaters being an electrical product.
- Please note that the heaters can get very HOT during use - Do Not Touch.



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