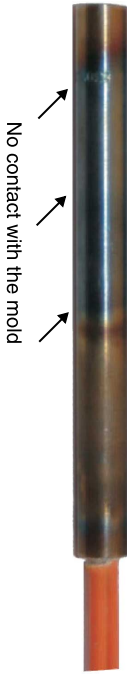
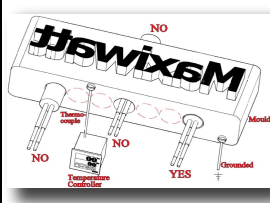



Breakage by	Over temperature	Repetitive cycles	Pollution	Leads
	Rated over temperature	Total cooling and maximum wire heating.	Absorption of contaminating elements inside the cartridge heater like moisture, water, oil, plastic, brine, etc.	broken or unprotected.
Effect	Heating wire melts or loses its insulation.	Dilation or contract on of the wire will finally reduce it or break itself due to the oxidation.	Short circuit, due to an internal contamination that causes grounding of the element.	No electricity input in the circuit or grounding due to a non insulation.
Reasons	Poor heating dissipat on.	Working without any external regulator at maximum capacity and total disconnection until the element is cold, during short and repetitive cycles.	Moisture condenses forming a bridge between the heating wire, sheet and leads. Producing short-circuit. Materials that in normal do not conduct electricity can do it after support high temperatures and be charred.	Vibrations, movement, impacts and high temperatures at leads side. Also leads inside the hole.
Appearance	Blue tones and also dark brown with small oxide layer in parts where the cartridge heater is not in contact with the hole.	heating element fusion.	Standard colors on the heater. Internally different colorations and steel sheet crater-shaped.	Rubbings, peels, cuts, material breakup.
Tips	<p>Exclusivity for holes with H7 mm tolerance.</p> <p>Cartridge heaters must be installed as tight as possible</p> <p>(\varnothing mold tolerance type H7 = \varnothing cartridge -0.02 to -0.06)</p> <p>Use the lowest possible power possible to extend the useful life of a cartridge heater.</p> <p>Stainless steel sheath has to be 100% introduced into the mold's holes without using anti-grippant paste.</p>  <p>No contact with the mold</p> <p>It shouldn't have that tone anywhere along the cartridge</p> <p>Short life span</p>	<p>It is recommended to use a fixed temperature with suitable power and not energize and de-energize.</p> <p>Attach regulator and cut systems (thermocouples and regulators).</p> <p>Thermocouples and sensor should be placed in the hottest part of the mold or piece.</p> 	<p>Maxiwatt offers different type of leads for each and specific protections over the leads.</p> <p>Store the cartridge heater in places without humidity.</p> 	<p>We have available special manufacturing systems to support excessive vibrations or repeated blows.</p> <p>That information must be on the purchases order otherwise we will produce them with a standard ending.</p> <p>Maxiwatt offers different type of leads for each use and specific protections over the leads.</p> <p>Do not place the cable inside the hole.</p> <p>Protect the heater cable and entrance connection against shocks, splashes and excess material.</p> <p>Keep the tails away from heat sources and protected from it</p> <p>Indicate and send before accepting the order, in writing, the work conditions (vibrations, blows, humid, environments...).</p>
<p>Installation tips:</p> <p>Cartridge heaters must be installed as tight as possible. You should take in consideration the following factors when drilling out:</p> <ul style="list-style-type: none"> - The inner of the drill must be uniform, no scratches or different diameters including minimal differences. We recommended finishing with a broach. - Note that when heat rises, the dissipation is higher at the ends and heat is concentrated in the center. - Try to have a hole with exit, it would be easier to remove the heater. - The connection never have to be in the drill, run the risk of short circuit or burn. - The connections have to be protected to prevent loss of liquid, plastic, gases, etc.. - We recommend gauges installation be placed at maximum 15mm of the heater. This last one must be connected to a temperature controller. - The cartridges must have minimum three diameters separations between them. 				