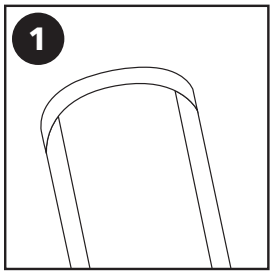
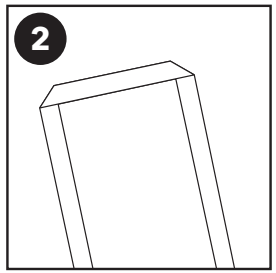
Installation Recommendations
for Heating Tape, Terminals & Making Heat Tape Connections

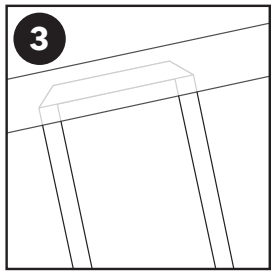
How to Apply Heating Tape to a Flat Surface:



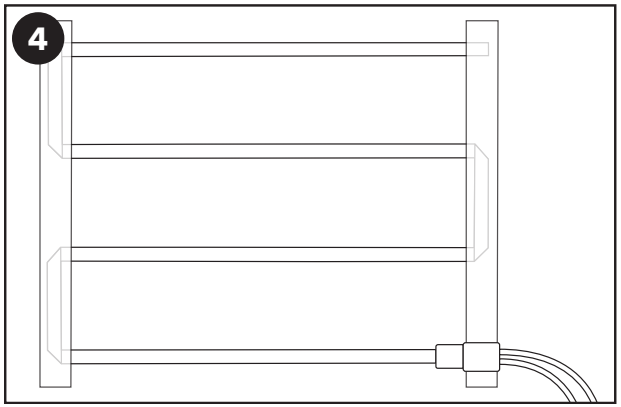
1. Apply heat tape in back-and-forth runs as shown. Leave end loops loose with adhesive side up.



2. Press end loops flat, creasing corners at 45° angles.

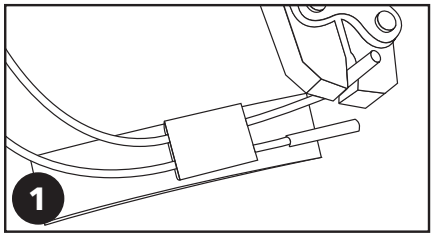


3. Apply Heat Transfer Tape across end loops and roll down firmly.

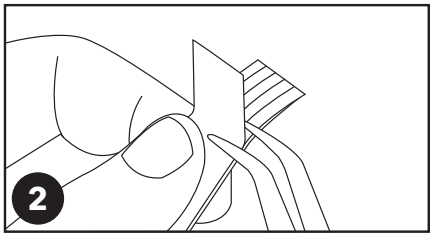


4. If the heater is permanent and is exposed to moisture, solvents or abuse, tape should be coated with a protective silicone rubber sealant.

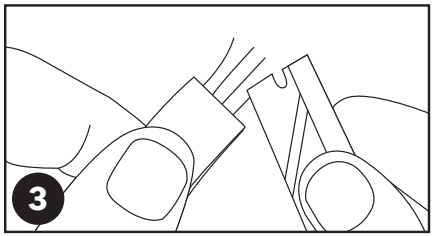
How to Install Terminals & Make Heating Tape Connections:



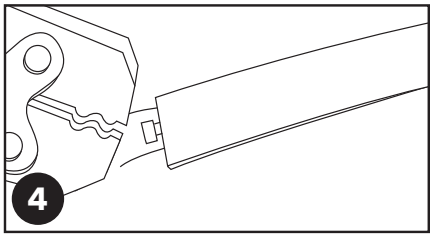
1. Push lead wires through terminal block holes. Strip lead wire ends and crimp butt connectors onto lead wires.



2. Split tape and open using tweezers. Dull tweezers are better than very sharp tweezers.



3. Cut back top & bottom laminations leaving wire ends exposed approx. 3/16" for small terminals & 1/4" for large terminals. Scrape enamel from wire ends using razor blade.



4. When using 4-wire tape in full series connection, crimp half of a #092 connector onto center two wires and trim short.

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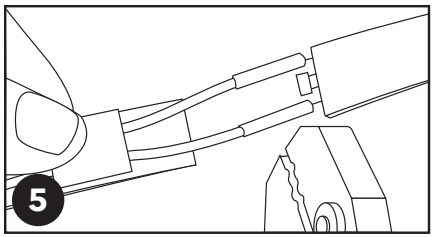
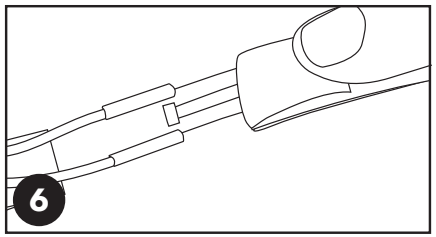
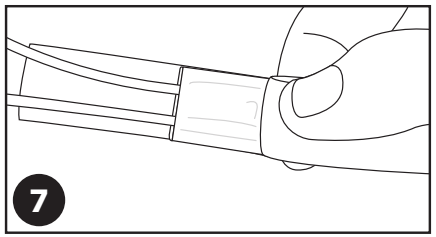


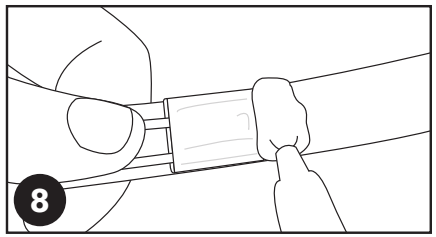
5. Crimp lead wires onto heater wires. To avoid breaking, do not crimp heater wire too hard!



6. Strip paper liner back about 1" from tape lead end. Push terminal block over connectors.

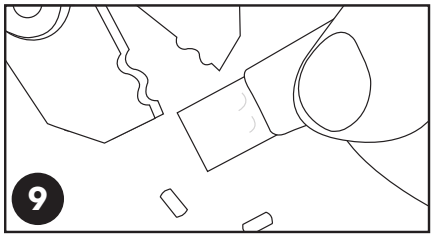


7. Press heater tape onto self-adhesive terminal flap.

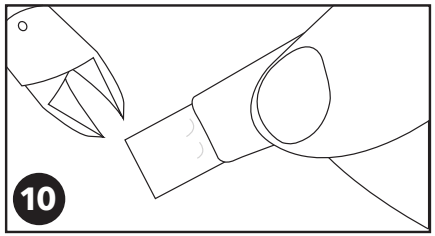


8. If desired, apply RTV Sealant over terminal block end.

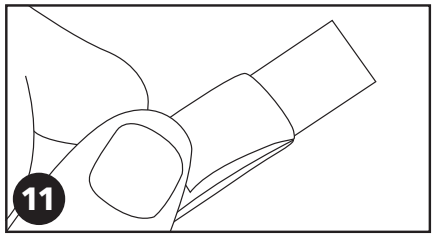
Hot End Connection:



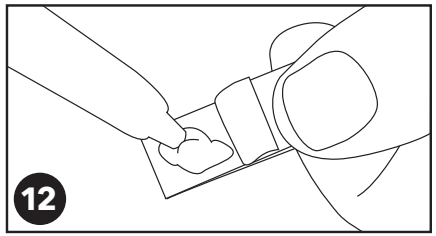
9. Split tape end open approx. 3/4" & scrape wire ends per steps 2 & 3 on previous page. DO NOT cut top & bottom tape laminations. Use half of #092 connector & crimp wire pairs together.



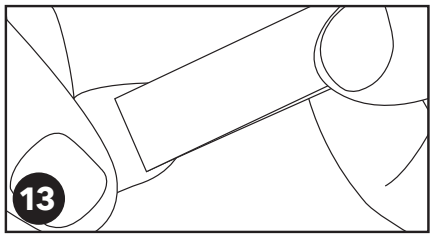
10. Trim rough ends of crimp connectors.



11. Use crimps to join wires.



12. Apply RTV Sealant over entire end and between top & bottom lamination flaps.



13. Re-laminate flaps & allow sealant to cure for permanent seal.

Notes:

1. See Tempco Catalog for application engineering information.

2. As with any electrical device, a grounding circuit should be present on the heat sink to which the heating tape is attached.

3. The excellent heat transfer characteristics of Tempco's Heat Tape are only as good as your complete heaters ability to remain attached to the heat sink. Make sure that all of the tape, including both ends, are securely attached to your heat sink.