

USER MANUAL
INDUCTION HEATER IHN300



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Table of Contents

Chapter.....	Page
Safety Recommendations.....	3
1 Introduction.....	3
1.1 Intended Use.....	3
1.2 Principle of Operation.....	4
1.3 Distinguishing Feature.....	4
2 Description.....	4
2.1 Components.....	4
2.2 Technical Data.....	5
3 Installation of Mains Plug.....	5
4 Preparation for Use.....	6
5 Operation.....	7
5.1 Function of Displays.....	7
5.2 Function of Buttons.....	7
5.3 Temp Mode.....	8
5.4 Time Mode.....	8
5.5 Temperature Measurement.....	9
5.6 Change of Temperature Unit.....	9
5.7 Demagnetisation.....	9
5.8 Power Level Selection.....	9
6 Safety Features.....	10
7 Troubleshooting.....	10
8 Spare Parts.....	11

Safety Recommendations

- › Because the IHN300 generates a magnetic field, people wearing a pacemaker must not be within 5 m (16 ft) of the IHN300 during operation. Electronic equipment, such as wrist watches, may also be affected.
- › Follow the operating instructions at all times.
- › Be certain that the voltage supply is correct.
- › Electrical arcing may occur when a potential difference exists between the IHN300 and the workpiece. This is not dangerous to human beings and will not cause damage to the IHN300 or the workpiece. However, the IHN300 must never be used in areas where there is a risk of explosion.
- › Do not expose the heater to high humidity.
- › Never operate the IHN300 without a yoke in position.
- › Do not modify the IHN300.
- › Use proper handling equipment when lifting heavy workpieces.
- › Avoid contact with hot workpieces. Wear the supplied heat-resistant gloves to handle hot workpieces.

1 Introduction

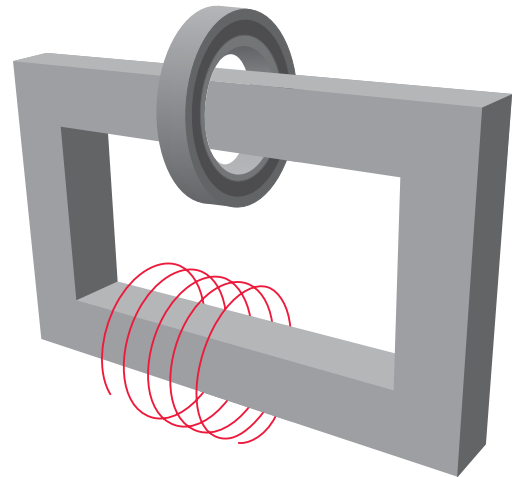
The IHN300 induction heater is designed to heat bearings that are mounted with an interference fit onto a shaft. The heat causes the bearing to expand, which eliminates the need to use force during installation. A 90°C (194°F) temperature difference between the bearing and shaft is generally sufficient to enable installation. At an ambient temperature of 20°C (68°F), the bearing must therefore be heated to 110°C (230°F).

1.1 Intended Use

The IHN300 has been designed to heat rolling bearings. However, other metal workpieces that form a closed circuit can also be heated. Examples of acceptable workpieces include bushings, shrink rings, pulleys, and gears. All bearings that fit over the inductive coil and between the vertical supports with the sliding yoke in place can be heated using the IHN300. In addition, smaller bearings can be placed over either of the two standard yokes.

1.2 Principle of Operation

The IHN300 generates heat by means of a large electrical current that is magnetically induced in the workpiece by a coil within the heater. The high voltage, low current electricity flowing through the large number of windings in the inductive coil induces low voltage, high current electricity in the workpiece. Because the workpiece has the electrical characteristics of a coil with a single, short-circuited winding, the high current generates heat within the workpiece. Because the heat is generated within the workpiece, all of the heater components remain cool.



1.3 Distinguishing Feature

The distinguishing feature of the IHN300 induction heater is the location of the workpiece at the same position on the core as the inductive coil. This design improves efficiency, resulting in less power consumption and faster heating, which reduces the cost to heat each bearing.

2 Description

The operation of the heater is controlled by the internal electronics in either of two modes. The operator can either select the desired temperature of the bearing in TEMP MODE or set the length of time that the bearing will be heated in TIME MODE. The power level can be adjusted in steps of 20% for slower heating of sensitive workpieces (for example, bearings with C1 or C2 clearance).

2.1 Components

The IHN300 induction heater contains an U-shaped iron core with an inductive coil surrounding one of the vertical supports. Internal electronics control the operation of the heater. A sliding yoke on the top of the vertical supports allows the workpiece to be placed onto the heater. To accommodate smaller workpieces, a small yoke is also provided. A temperature probe is also included with the heater. Heat-resistant gloves are also included.

2.2 Technical Data

IHN300	
Voltage ($\pm 9\%$)	3 ~ 400-575V / 50 – 60Hz*
Recommended circuit protection	32 A circuit breaker
Power consumption (maximum)	11.5k VA
Temperature control	0 – 250°C (32 – 482°F) in steps of 1°C (2°F)
Probe maximum temperature	250°C (482°F)
Time mode	0 – 60 minutes in steps of 0.1 minute
Power range	20 – 100% in steps of 20%
Demagnetisation, automatic	Residual magnetism < 2A/cm
Overall dimensions	600 x 350 x 420mm
Area between supports	250 x 250mm
Coil diameter	135mm
Weight (with yokes)	75kg
Workpiece maximum weight	Bearing 300kg, solid component 150kg
Maximum heating temperature	Approx. 400°C (752°F)
Standard yoke dimensions	70 x 70 x 420mm (for \varnothing of 100mm) 40 x 40 x 420mm (for \varnothing of 60mm)

* Each bearing heater family has several voltage options. Please refer to the type plate on the heater body to determine the actual operating voltage.

3 Installation of Mains Plug

Due to the many types of mains plugs, no mains plug is supplied with the IHN300. A qualified electrician must install a suitable mains plug. The correct supply voltage is shown on the type plate / underside of the heater.

The wires should be connected as follows:

Color of IHN300 Wire	Mains Supply Terminal
Yellow/green	Protection earth (PE)
Brown	Phase 1 (L1)
Blue	Phase 2 (L2)

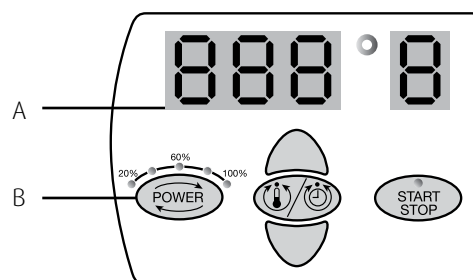
Connect the IHN300 to only two of the three phases. Verify that the correct circuit breaker is installed. See section 2.2 for circuit breaker specifications.

4 Preparation for Use

- › Place the IHN300 in the horizontal position on a stable surface.
- › Connect the mains plug to a suitable mains supply.
- › For workpieces with an internal diameter (>135mm) large enough to fit over the inductive coil, follow these steps:
 - › Place the workpiece over the inductive coil using appropriate lifting equipment.
 - › For best performance, adjust the position of the workpiece so that the inductive coil is in the centre.
 - › Remove the protective film from the bright underside of the sliding yoke before the first use.
 - › Slide the sliding yoke to the right so that it completely covers the top of both vertical supports.
- › For workpieces that do not fit over the inductive coil, follow these steps:
 - › Choose the larger of the two yokes that fit through the internal diameter of the workpiece.
 - › If necessary, remove the sliding yoke from the IHN300.
 - › Verify that the protective film has been removed from the underside of the small yoke if it is to be used for the first time.
 - › Slide the workpiece onto the yoke that you have selected.
 - › Position the yoke on the IHN300 with the bright underside resting evenly on the two vertical supports.
- › If TEMP MODE is used, plug the temperature probe into the connector on the left side of the heater. Place the magnetic end of the probe on the inner ring of the bearing or on the innermost surface of the workpiece.
- › Switch the IHN300 on using the power switch on the left side.
- › Observe the self-test of the display and signal tone.

5 Operation

5.1 Function of Displays



A) The main display shows the selected time or temperature for heating:

Display	Indication
t	Time in minutes
°C	Temperature in degrees Celsius
°F	Temperature in degrees Fahrenheit

B) The power display shows the selected power setting.

Display	Indication
●	20% power
●●	40% power
●●●	60% power
●●●●	80% power
●●●●●	100% power

5.2 Function of Buttons

Button	Function
POWER	Press to adjust the power in steps of 20%. The selected power is indicated on the power display.
MODE	Press to switch between TIME MODE and TEMP MODE.
UP (+)	Press to increase the value shown on the main display.
DOWN (-)	Press to decrease the value shown on the main display.
START/STOP	Press to start or stop the heater. The LED on the START/STOP button is lit when the heater is heating and flashes during temperature measurement.

5.3 Temp Mode

- › If the main display shows “t”, press MODE to select TEMP MODE. The main display shows °C or °F in TEMP MODE.
- › The selected temperature is shown on the main display. The default temperature for bearings is 110°C (230°F). If a different temperature is desired, press UP or DOWN to adjust the temperature in steps of 1°C (2°F). It may be desirable to heat bearings to temperatures above 110°C (230°F) for increased mounting time. Consult the bearing specifications to determine the maximum permitted temperature. Always ensure the bearing doesn't lock due to an excessive expansion of the inner ring compared to outer ring. See section 5.8.
- › Spherical Roller Bearings (SRBs) are subjected to a special heat treatment. These bearings can be operated at temperatures as high as 200°C (392°F). Heating these bearings above 110°C (230°F) will not cause any damage as long as the bearing is still able to rotate. For other bearings, a temperature of 125°C (257°F) must not be exceeded unless otherwise specified.
- › Press POWER to select the power level. Use the guidelines in section 5.8 to determine the correct power setting.
- › Press START/STOP to start the heater. The main display shows the current temperature of the workpiece.
- › When the selected temperature has been reached, the heater demagnetises the workpiece, switches off, and generates an acoustic signal for 10 seconds or until START/STOP is pressed.
- › Press START/STOP to stop the heater.
- › Remove the workpiece with proper handling equipment.
- › If the workpiece remains on the heater, the heater will start again when the temperature of the workpiece drops 10°C (18°F). Press START/STOP to stop the heater and demagnetise the workpiece.
- › The IHN300 is now ready to heat another workpiece with the same settings.

5.4 Time Mode

- › If the main display shows °C or °F, press MODE to select TIME MODE. The main display shows “t” in TIME MODE.
- › Press UP or DOWN to adjust the time in steps of 0.1 minute.
- › Press POWER to select the power level. Use the guidelines in section 5.8 to determine the correct power setting.
- › Press START/STOP to start the heater. The main display shows the time that remains.

- › When the time has elapsed, the heater demagnetises the workpiece, switches off, and generates an acoustic signal for 10 seconds.
- › Press START/STOP to cancel the acoustic signal and stop the heater.
- › Remove the workpiece with proper handling equipment.
- › The IHN300 is now ready to heat another workpiece with the same settings.

5.5 Temperature Measurement

When the heater is not operating, the temperature of the workpiece can be measured by pressing MODE and START/STOP at the same time. The LED on the START/STOP button flashes during temperature measurement. Press START/STOP to cancel temperature measurement.

5.6 Change of Temperature Units

Press MODE and UP at the same time to switch between °C and °F. The temperature unit setting remains the same even after disconnection from mains power.

5.7 Demagnetisation

The workpiece is automatically demagnetised when heating is complete. Demagnetisation will not occur if the power is interrupted or the main switch is switched off. To use the IHN0300 for demagnetisation only, select TIME MODE and set the time to 0.1 minute (6 seconds).

5.8 Power Level Selection

When heating bearings with an induction heater, most of the heat will be generated in the inner bearing race. The heat will then be transferred through the bearing. It is therefore important that bearings with small internal clearance or slight preload are heated slowly. Slow heating ensures that the bearing expands evenly, thereby preventing damage to the bearing.

The shape, weight, size and internal clearances all affect the amount of time required to heat a bearing. The large variety of bearing types precludes the possibility of providing a specific power level setting for each type. Instead, the following guidelines are provided:

- › For sensitive bearings (including bearings with C1 or C2 internal clearance) or bearings with brass cages, do not exceed 40% power when using the small yoke or 60% power when using the sliding yoke.
- › When using the small yoke, never exceed 60% power.

6 Safety Features

The IHN300 is equipped with the following safety features:

- › Main switch with overcurrent circuit breaker.
- › Automatic overheating protection.
- › Automatic current control.
- › In the TEMP MODE the heater will switch off if the temperature probe does not register a temperature increase of 1°C (2°F) every 15 seconds. To increase the interval to 30 seconds, press MODE and DOWN at the same time.

7 Troubleshooting

A system fault will be indicated by an acoustic signal and one of the following fault codes on the main display:

Display	Fault	Action
E01 E	General system failure	Return heater for repair
E02 E	Memory failure	Return heater for repair
E03 E	Overheated coil	Wait until the inductive coil cools
E04 E	Not in use	
E05 E	Temperature increase of less than 1°C (2°F) every 15 seconds (or 1°C (2°F) every 30 seconds)	Check the temperature probe connection. If the connection is OK, select the 30 second interval as described in section 6 or operate the heater in TIME MODE.
E06 E	Temperature probe not connected (or defective)	Check the temperature probe
E07 E	Failure during current measurement	Return heater for repair
E08 E	Failure during communication with power printed circuit board	Return heater for repair
E09 E	Overheated printed circuit board	Wait until the printed circuit board (PCB) has cooled down.

8 Spare Parts

Description	Part Number
Spare temperature probe	IHNP2SENSOR
Spare protective gloves	IHNGLOVES
Spare yoke 40 x 40 x 420mm for IHN300	IHN300-Y1
Spare yoke 55 x 55 x 420mm for IHN300	IHN300-Y2
Spare yoke 70 x 70 x 420mm for IHN300	IHN300-Y3
Spare yoke roller housing for IHN300	IHN300-YH
Spare yoke guides for IHN300	IHN300-FS
Spare support yoke 70 x 70 x 150mm for IHN300	IHN300-YS

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