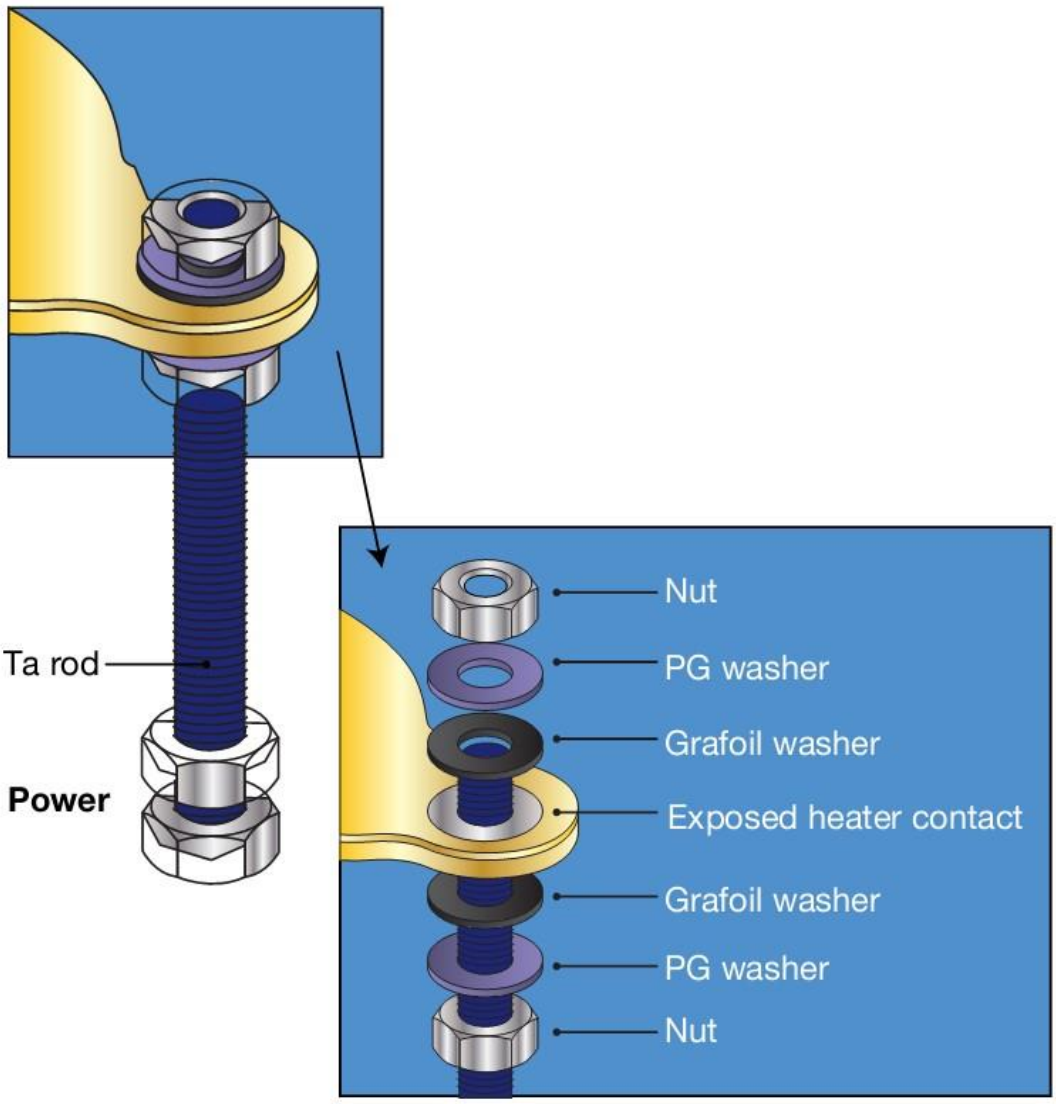
Application Note

Connecting PG/PBN Heating Elements

Typical and Recommended Electrical Connection Method (no graphite post design)



Typical Torque

Nuts on heater finger tight, then turn another ~45°
Equivalent to
~ 0.7 in/lb (~ 0,08 N/m) for M2
~ 1.3 in/lb (~ 0,15 N/m) for M3
~ 2.9 in/lb (~ 0,33 N/m) for M4

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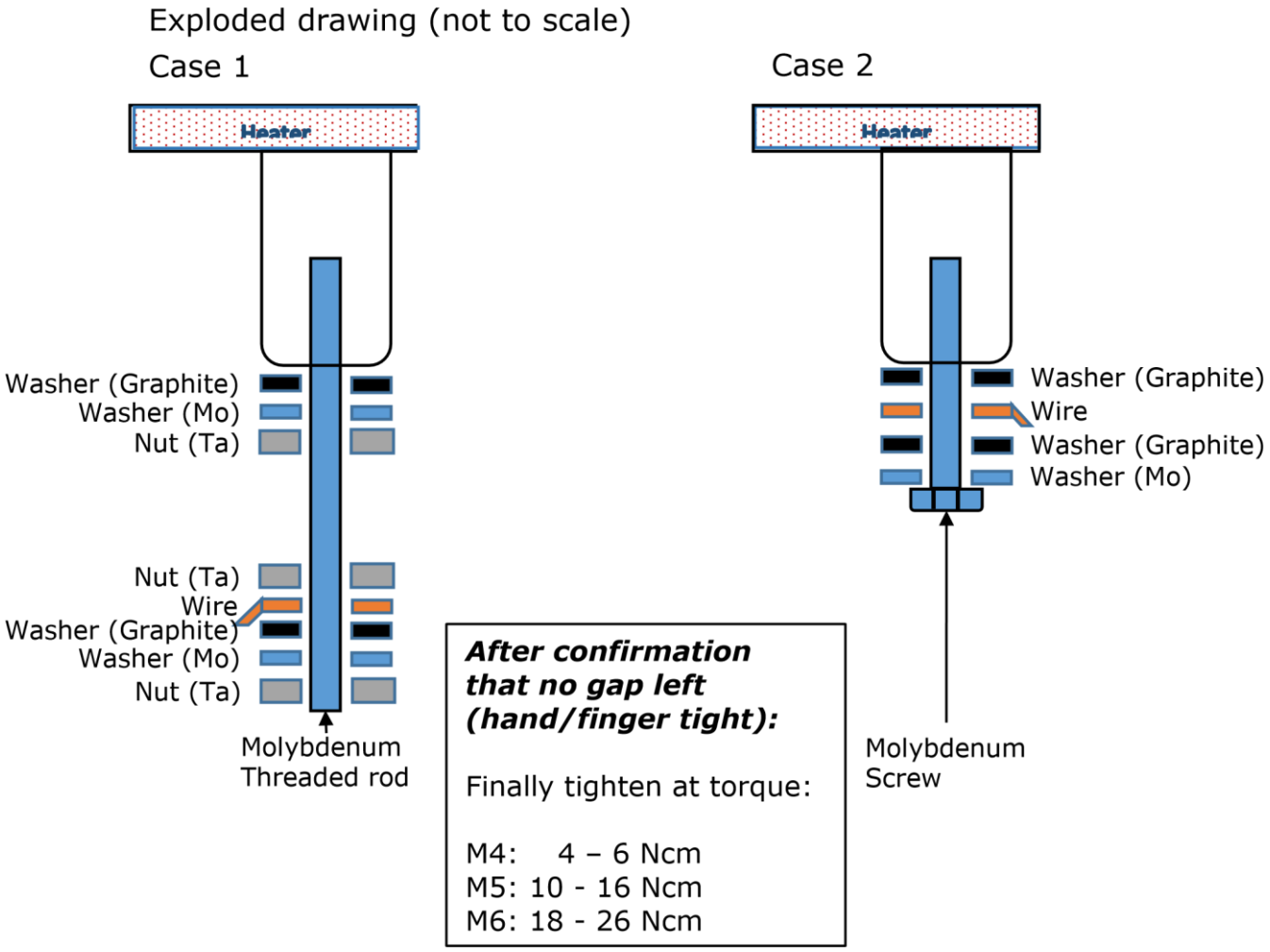
Typical and Recommended Electrical Connection Method (graphite post design)



In any case:

Do not torque the joint between the post and the heater. This is a critical electrical connection. Hold the post by hand, or wrap the post with a cloth and hold lightly with pliers. Do not hold the Heater body to make the post electrical joint.

Post connections require about 10 threads of engagement for strength and electrical contact. The end of the post is coated for protection.

Check the heater resistance before and after connection.
The connections should add no more than 1 Ohm of resistance.

tectra GmbH, Reuterweg 51 – 53, Frankfurt/M., Germany, Phone: +49-(0)69-720040 www.tectra.de