Induction Heating Devices
HEATER
User manual
Foreword

The induction heating devices HEATER25, HEATER50, HEATER100, HEATER200, HEATER400, HEATER800 and HEATER1600 give rapid, clean operation. Their high efficiency level allows energy-efficient heating and shorter mounting times. This reduces the operating costs. The uniform, controlled heating allows consistently good quality of mounting.

Operation is simple and user-friendly, the touch-sensitive screen is oil-resistant, dustproof and waterproof.

When heating by induction is used, there is no need at all to use oil – this gives particularly good environmental compatibility. The scope of application is very extensive. It is possible to heat the loose inner rings of cylindrical or needle roller bearings as well as sealed and greased bearings. Compared with previous models, further improvements have been made in performance capacity and safety and the part to be heated need no longer be of a minimum mass.

In order to ensure durability in demanding industrial operation, the devices are extremely robust and reliable.

Current version

An induction heating unit is controlled by means of an operator unit with a touch-sensitive screen. The operator software can be developed further and an update is possible free of charge. Changes to the software can lead to adjustments in the user manual. A current version of this user manual can be found at http://medien.schaeffler.com using the search term BA42.
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About the user manual
This user manual is part of the device and contains important information.

Symbols
The warning and hazard symbols are defined in accordance with ANSI Z535.6-2006.

DANGER
In case of non-compliance, death or serious injury will occur.

WARNING
In case of non-compliance, death or serious injury may occur.

NOTICE
In case of non-compliance, damage or malfunctions in the product or the adjacent construction will occur.

Signs
The warning, prohibition and instruction signs are defined in accordance with DIN 4884-2 and DIN EN ISO 7010.

Warning, prohibition and instruction signs

<table>
<thead>
<tr>
<th>Signs and descriptions</th>
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<tbody>
<tr>
<td>Warning of magnetic field</td>
</tr>
<tr>
<td>Warning of non-ionising, electromagnetic radiation</td>
</tr>
<tr>
<td>Warning of hot surface</td>
</tr>
<tr>
<td>Prohibited for persons with heart pacemaker</td>
</tr>
<tr>
<td>Prohibited for persons with metallic implants</td>
</tr>
<tr>
<td>Carrying of metallic parts or watches prohibited</td>
</tr>
<tr>
<td>Observe manual</td>
</tr>
<tr>
<td>Wear safety gloves</td>
</tr>
<tr>
<td>Wear safety shoes</td>
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</tbody>
</table>
Availability
This user manual is supplied with each device and can also be ordered retrospectively.

**WARNING**
If the user manual is missing, incomplete or illegible, the user may make errors.
The Safety Officer must ensure that this user manual is always complete and legible and that any persons using the device have the user manual available.

Legal guidelines
The information in this manual corresponded to the most recent status at the close of editing. The illustrations and descriptions cannot be used as grounds for any claims relating to devices that have already been delivered. Schaeffler Technologies AG & Co. KG accepts no liability for any damage or malfunctions if the device or accessories have been modified or used in an incorrect manner.

Original user manual
The original user manual is taken to be a user manual in the German language. A user manual in another language is to be taken as a translation of the original user manual.
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### General safety guidelines
A description is given of how the device may be used, who may use the device and what must be observed when using the device.

### Usage for the intended purpose
Usage for the intended purpose of the induction heating device is defined as the industrial heating of rolling bearings and other rotationally symmetrical, ferromagnetic workpieces. Sealed and greased rolling bearings can also be heated. In this case, the maximum permissible heating temperatures for the seal and grease must be observed.

### Usage not for the intended purpose
The heating device may not be used for the heating of parts that are not ferromagnetic or not rotationally symmetrical. Do not use the heating device in an environment with a risk of explosion.

Usage not for the intended purpose can lead to the injury or death of persons or damage to the device.

### Qualified personnel
For safety reasons, the heating device may only be operated by qualified personnel.

A person defined as qualified personnel:
- has all the necessary knowledge
- is aware of all the hazards and safety guidelines
- is authorised to use the heating device by the safety co-ordinator
- has fully read and understood this user manual.

### Work on electrical devices
The heating device HEATER1600 may only be connected by a trained electrician. The switch cabinet may only be opened by an electrician. Only an electrician is in a position, on the basis of his technical training, knowledge and experience as well as his knowledge of the appropriate regulations, to carry out work on electrical devices correctly and recognise possible hazards.
**Hazards**

During operation, the device always generates an electromagnetic field. The electromagnetic field heats ferromagnetic parts and can disrupt or destroy electronic components. Examples include watches, clocks, mobile telephones, credit cards and other data carriers as well as electronic circuits.

**DANGER**

Danger of heart stoppage in persons fitted with a pacemaker due to the strong electromagnetic field.

Persons fitted with a pacemaker must remain outside the hazard area of the heating device, see page 33.

**WARNING**

Danger of death for persons with artificial heart valves made from metal, hazard of severe burns due to heating of implants by the electromagnetic field.

Persons with ferromagnetic implants must remain outside the hazard area of the heating device, see page 33.

**Implants**

Persons with implants must clarify with a doctor whether the implants are ferromagnetic before working with an induction heating device.

The following list is not exhaustive but is intended to give the user an initial overview of the types of implants that may be hazardous:

- artificial heart valve
- ICD
- stent
- hip implant
- knee implant
- metal plate
- metal screw
- dental implant and dentures
- cochlear implant
- neurostimulator
- insulin pump
- hand prosthesis
- subcutaneous piercing.
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**Metallic objects**

Persons with a metallic object must clarify whether it is ferromagnetic before working with an induction heating device.

The following list is not exhaustive but is intended to give the user an initial overview of the types of metallic objects that may be hazardous:

- prosthetic
- spectacles
- hearing aid
- earring
- piercing
- brace
- chain
- ring
- armband
- keys
- timepiece
- coin
- ballpoint pen, fountain pen
- belt
- shoes with metal caps or metal springs in the sole.

**Safety devices**

In order to protect the user and the heating device, the following safety devices are present:

- The temperatures of the cooling element, coil and housing are continuously monitored. The thermal protection system will switch off the heating device before any component is overheated. Once the thermal protection system has been triggered, the heating device can be put back into operation once the error has been eliminated and the device has been checked.

- The heating of the rolling bearing is continuously monitored. If the specified increase in temperature is not achieved within a certain period, the heating device is switched off by the software.
Operation

In order that the user can move out of the hazard area before the electromagnetic field is generated, the following operating options are available:

- The operator can set the time on the heating device that is counted down after pressing the START/STOP key before the electromagnetic field is generated. The user can then move out of the hazard area within the countdown time.

**WARNING**

Risk of damage to health from remaining in a strong electromagnetic field, since the device starts the heating operation unexpectedly. Set a sufficiently long countdown time in order to allow exit from the hazard area.

Activity display

During the heating operation, an animation with a red rectangle is visible. The user can thus recognise during heating when the electromagnetic field is being generated. During demagnetisation, the electromagnetic field is indicated by a red circle with a white exclamation mark.

Protective equipment

Personal protective equipment is intended to protect operating personnel against health hazards. This comprises safety shoes and gloves that are heat-resistant up to +250 °C and these must be used in the interests of personal safety.
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Safety regulations
The following safety regulations must be observed when working with the heating device. Further guidance on hazards and specific guidelines for action can be found, for example, in the section Operation, page 48.

Transport
The heating device must not be moved directly after heating.

Storage
The heating device must always be stored under the following ambient conditions:
- humidity max. 90%, non-condensing
- protected against sunlight and UV radiation
- no explosion risk in the environment
- no aggressive chemicals in the environment
- temperature from –40 °C to +40 °C.

If the heating device is stored under unsuitable ambient conditions, this will probably have consequences such as damage to the electronic unit, corrosion of the ground contact surfaces and deformation of the plastic housing.

Commissioning
The heating device must not be modified.

The heating device may only be commissioned if it fulfills the regulations to be adhered to at the place of use.

Only original accessories and replacement parts may be used.

The heating device may only be used in well ventilated rooms.

Do not feed the mains connection cable through the U-shaped core.
Operation

The heating device may only be operated under the following ambient conditions:

- closed room
- subsurface flat and capable of supporting loads
- humidity min. 5%, max. 90%, non-condensing
- no explosion risk in the environment
- no aggressive chemicals in the environment
- temperature from 0 °C to +40 °C.

If the heating device is operated under unsuitable ambient conditions, this can have consequences such as damage to the electronic unit, corrosion of the ground contact surfaces and deformation of the plastic housing.

The heating device may only be operated at the correct supply voltage.

Workpieces must not be heated if they are covered.

Workpieces must not be heated if they exceed the maximum permissible mass, see table, page 48.

Workpieces must not be suspended from ropes or chains made from ferromagnetic material while they are heated.

During the heating process, the user must maintain a distance of at least 2 m from the heating device.

Objects made from ferromagnetic material must be kept at a distance of at least 1 m from the heating device.

Support, slewing and vertical ledges must not be produced independently.

The heating device may only be switched on if the support, slewing or vertical ledge is correctly positioned.

The support, slewing or vertical ledge must never be removed during the heating process.

The heating device must not be switched off by means of the main switch while the device is heating a component.

Any smoke or vapour occurring during the heating process must not be inhaled.

The heating device must be switched off using the main switch if it is not in use.

**WARNING**

Back injuries due to incorrect handling of heavy rolling bearings. In the case of heavy rolling bearings, use suitable lifting gear. <
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### Maintenance
The heating device must be switched off before maintenance is carried out.

### Disposal
Locally applicable regulations must be observed.

### Conversion
The heating device must not be converted.

### Scope of delivery
The scope of supply comprises the heating device, standard accessories, safety guidelines, user manuals, and a USB stick.

#### Component Designation d

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>d (mm)</th>
</tr>
</thead>
<tbody>
<tr>
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<td>HEATER25</td>
<td>–</td>
</tr>
<tr>
<td>Support ledge</td>
<td>HEATERS0.LEDGE-55</td>
<td>55</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
<td>–</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATERS0.CARRY</td>
<td>–</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
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<tr>
<td>Safety guidelines</td>
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<tr>
<td>German user manual</td>
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<tr>
<td>English user manual</td>
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<tr>
<td>USB stick</td>
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</tbody>
</table>

1) Minimum inside diameter of rolling bearing.
2) Designation deviates from the naming system as the component is also used for HEATER50.

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**Figure 1**
Scope of delivery
Heating device HEATER25

1. Heating device
2. Support ledge 55
3. Grease
4. Temperature sensor, magnetic
5. Lifting tool
6. Gloves
7. Safety guidelines
8. User manuals (German and English)
9. USB stick
Scope of delivery

Heating device HEATER50

<table>
<thead>
<tr>
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<th>Designation</th>
<th>( d_1 ) mm</th>
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</thead>
<tbody>
<tr>
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</tr>
<tr>
<td>Support ledge</td>
<td>HEATER50.LEDGE-55</td>
<td>55</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
<td>–</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER50.CARRY</td>
<td>–</td>
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<tr>
<td>Gloves</td>
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<tr>
<td>Safety guidelines</td>
<td>–</td>
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<tr>
<td>German user manual</td>
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<tr>
<td>English user manual</td>
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<tr>
<td>USB stick</td>
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</tbody>
</table>

1) Minimum inside diameter of rolling bearing.

Figures:

- Figure 2: Scope of delivery
  Heating device HEATER50

1. Heating device
2. Support ledge 55
3. Grease
4. Temperature sensor, magnetic
5. Lifting tool
6. Gloves
7. Safety guidelines
8. User manuals (German and English)
9. USB stick
Induction heating devices HEATER

Scope of delivery
Heating device HEATER100

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
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<td>Slewing ledge</td>
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<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
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<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
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<td>Lifting tool</td>
<td>HEATER100.CARRY</td>
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<tr>
<td>Gloves</td>
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<tr>
<td>USB stick</td>
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</table>

\(d_{1})\) Minimum inside diameter of rolling bearing.

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1. Heating device
2. Slewing ledge 70
3. Grease
4. Temperature sensor, magnetic
5. Lifting tool
6. Gloves
7. Safety guidelines
8. User manuals (German and English)
9. USB stick

Figure 3
Scope of delivery
Heating device HEATER100
Scope of delivery
Heating device HEATER200

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
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<td>Heating device</td>
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<td>Slewing ledge</td>
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<td>ARCANOL-MULTI3-250G</td>
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<td>2×temperature sensor</td>
<td>HEATER.SENSOR-1000MM</td>
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</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER200.CARRY</td>
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<tr>
<td>Gloves</td>
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<tr>
<td>Safety guidelines</td>
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<td>German user manual</td>
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</table>

1) Minimum inside diameter of rolling bearing.

Figure 4
Scope of delivery
Heating device HEATER200
Induction heating devices HEATER

Scope of delivery
Heating device HEATER400

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>d₁ [mm]</th>
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<tr>
<td>Heating device</td>
<td>HEATER400</td>
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<td>Vertical ledge</td>
<td>HEATER400.LEDGE-120</td>
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<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
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<td>2× temperature sensor</td>
<td>HEATER SENSOR-1000MM</td>
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<td>Gloves</td>
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<tr>
<td>USB stick</td>
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</tbody>
</table>

| 1 Heating device               |                      |         |
| 2 Vertical ledge 120           |                      |         |
| 3 Grease                       |                      |         |
| 4 Temperature sensor, magnetic |                      |         |
| 5 Gloves                       |                      |         |
| 6 Safety guidelines            |                      |         |
| 7 User manuals (German and English) |                  |         |
| 8 USB stick                    |                      |         |

5) Minimum inside diameter of rolling bearing.

Figure 5
Scope of delivery
Heating device HEATER400
### Scope of delivery

Heating device HEATER800

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>(d_{1})) mm</th>
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<tbody>
<tr>
<td>Heating device</td>
<td>HEATER800</td>
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<td>Vertical ledge</td>
<td>HEATER800.LEDGE-150</td>
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<td>ARCANOL-MULTI3-250G</td>
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<tr>
<td>2 (\times) temperature sensor</td>
<td>HEATER.SENSOR-1500MM</td>
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<tr>
<td>Gloves</td>
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<td>Safety guidelines</td>
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<td>English user manual</td>
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<td></td>
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<tr>
<td>USB stick</td>
<td></td>
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</tbody>
</table>

1. Minimum inside diameter of rolling bearing.

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**Figure 6**

Scope of delivery
Heating device HEATER800

- 1. Heating device
- 2. Vertical ledge 150
- 3. Grease
- 4. Temperature sensor, magnetic
- 5. Gloves
- 6. Safety guidelines
- 7. User manuals (German and English)
- 8. USB stick
Induction heating devices HEATER

Scope of delivery

<table>
<thead>
<tr>
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<td>2× temperature sensor</td>
<td>HEATER.SENSOR-1500MM</td>
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<td>Gloves</td>
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</tr>
<tr>
<td>USB stick</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>

\(^1\) Minimum inside diameter of rolling bearing.

Accessories

The heating device is supplied with standard accessories. Special accessories such as support, slewing or vertical ledges in other sizes are available, see page 71.

Damage during transit

Any damage during transit must be reported as a complaint to the carrier.

Defects

Any defects must be reported promptly to Schaeffler Technologies AG & Co. KG.
Description

The heating device is robust and is operated by means of a touch-sensitive screen and a mechanical key below the touch-sensitive screen.

Overview

The components are made from the most suitable materials for the particular function, Figure 8.

Housing

The tabletop devices have a housing made from high grade steel, while the standalone devices have a housing made from painted sheet steel. The housing encloses the electronic unit, parts of the U-shaped core and the primary coil.

Housing casing

The housing of the tabletop devices has a casing made from PUR.

Heat-resistant plate

The heat-resistant plate between the struts of the U-shaped core comprises a fabric reinforced by carbon fibres.

U-shaped core

This is made from steel and protrudes partially from the housing. In the housing, the primary coil is axially arranged symmetrically around the U-shaped core, Figure 10, page 21.
Induction heating devices HEATER

Sliding table  The tabletop devices have a sliding table made from high grade steel, while the standalone devices have a sliding table made from painted sheet steel. In the case of HEATER800 and HEATER1600, the sliding table has wheels and a grip for screw mounting. It has support strips made from silicone.

Support ledge  This is made from the same material as the U-shaped core. The support ledge is not guided and is laid on the two upper ends of the U-shaped core.

Slewing ledge  This is made from the same material as the U-shaped core. The slewing ledge is fitted on the locating stud and is slewed on the U-shaped core.

Vertical ledge  This is made from the same material as the U-shaped core. The vertical ledge is guided at the top end of the U-shaped core and can be lifted and changed.

Main switch  This is used to switch the heating device on and off.

Touch-sensitive screen  The heating device is adjusted, started and stopped by means of the touch-sensitive screen mounted on the housing.

USB connection  A USB stick can be connected to the USB connector. This can be used to update firmware and import menu languages.

Temperature sensor  Two temperature sensors can be connected to each induction heating device. The sensor head of the temperature sensor is magnetic and is positioned on the component. The signal is fed via the cable and plug to the device, Figure 9.

Figure 9  Temperature sensor

1 Sensor head  2 Cable  3 Plug
**Function**

An induction heating device generates a strong electromagnetic field and can thus be used to heat a ferromagnetic workpiece. Due to heating, the workpiece expands, which makes mounting easier. A typical application is the heating of a rolling bearing. This manual therefore considers the heating of a rolling bearing.

DANGER

Strong electromagnetic field. Cardiac arrest due to failure of the pacemaker.

Persons fitted with a pacemaker must remain outside the hazard area, see page 33.

**Functional principle**

The primary coil generates an electromagnetic alternating field. This electromagnetic field is transmitted via the iron core to the secondary coil, for example a rolling bearing, *Figure 10*. In the secondary coil, a high induction current at low voltage is induced. The induction current causes rapid heating of the rolling bearing. Any parts that are not ferromagnetic, as well as the heating device itself, remain cold.

During heating, an electromagnetic field is generated. After the heating operation is stopped, the field remains in place while the workpiece is being demagnetised (max. 5 s).

The electromagnetic field is very strong directly at the heating device. The electromagnetic field becomes weaker with increasing distance from the heating device.

*Figure 10*

1. Primary coil
2. Secondary coil, in this case a rolling bearing
3. U-shaped iron core
4. Ledge
5. Electromagnetic field
Induction heating devices HEATER

Operation

The heating device is operated by means of a touch-sensitive screen, on which each heating method is indicated by a corresponding symbol. The symbol for the heating method currently in use is shown with a green border and the value or values currently set are displayed below the symbol, Figure 11.

![Figure 11](image)

Heating methods, symbols

1. Time control
2. Temperature control
3. Ramp control
4. Delta-T control
5. Set value

Heating is started using the mechanical key [START/STOP] below the touch-sensitive screen.

After pressing [START/STOP], the countdown time is counted down, Figure 12.

![Figure 12](image)

Countdown time

1. [START/STOP]
2. Display of countdown time

Once the countdown time has finished, the electromagnetic field is generated and the rolling bearing is heated.
Operating modes

The user sets which of the four operating modes the heating device should use.

Time control

In the case of time control, the heating time is set, Figure 13.

In order to determine the heating time for a rolling bearing, temperature control is used to heat the rolling bearing to the required temperature. The time required is noted as the heating time.

The advantage of time control compared to temperature control is that the temperature sensor is not necessary. Time control is therefore particularly suitable for the batch mounting of identical rolling bearings. When determining the heating time, it must be ensured that the initial temperature present is also maintained in the case of batch mounting.

Each time the heating temperature is reached, the heating device automatically starts the demagnetisation of the rolling bearing. After demagnetisation, “Heating operation ended” is displayed on the touch-sensitive screen, Figure 46, page 60.

Standard bearings can be heated up to +120 °C, while rolling bearings with reduced clearance may be damaged even at lower temperatures.

NOTICE

Destruction of the bearing by heating to an excessively high temperature, since an excessively long period was inputted.
Always input the time determined in the test.

NOTICE

Destruction of the heating device by heating to a temperature above +240 °C due to input of an excessively long period.
Check the current temperature continuously using a temperature gauge.
Induction heating devices HEATER

Temperature control

In the case of temperature control, the heating temperature is set, Figure 14.

The device heats the rolling bearing as quickly as possible. When the heating temperature is reached, the rolling bearing is demagnetised and the message “Heating operation ended” is displayed, Figure 46, page 60. If temperature hold has been set and the rolling bearing falls below a specified temperature, it is heated again, see page 27.

Heating time

The heating time is the time taken until the heating temperature is reached for the first time. The heating time depends on the size of the rolling bearing and the cross-section of the support, slewing or vertical ledge.
**Ramp control**

In the case of ramp control, the heating temperature and heating time are set, *Figure 15*.

Ramp control is primarily suitable for rolling bearings with reduced internal clearance and very thick-walled workpieces.

The advantage compared to temperature control is that the rolling bearing can be heated more slowly. The controller checks the temperature continuously and regulates the power level. The temperature differential between the inner ring and outer ring remains small, preventing stress and damage to the raceway due to the indentation of the rolling elements.

When the heating temperature is reached, the rolling bearing is demagnetised and the message “Heating operation ended” is displayed, *Figure 46*, page 60. If temperature hold has been set and the rolling bearing falls below a specified temperature, it is heated again, see page 27.
Induction heating devices HEATER

**Delta-T control**

In the case of delta-T control, the heating temperature and maximum temperature differential are set, *Figure 16*. Delta-T control is mainly suitable, similar to ramp control, for rolling bearings with reduced internal clearance.

The difference from ramp control is that not only the inner ring temperature is measured. In addition, the outer ring temperature is measured. The user inputs the maximum permissible temperature differential. The heating device continually checks the temperature differential during heating and reduces the power if the differential approaches the limit value very rapidly. If the limit value is reached, the device regulates the power to 0%, even if the heating temperature has not yet been reached. If the value undershoots the limit value by a sufficient amount, the heating device will regulate the power upwards again and the heating operation will be continued.

When the heating temperature is reached, the rolling bearing is demagnetised and the message “Heating operation ended” is displayed, *Figure 46*, page 60. If temperature hold has been set and the rolling bearing falls below a specified temperature, it is heated again, see page 27.

*Figure 16*

Delta-T control

1. Initial temperature
2. Heating temperature
3. Temperature of inner ring
4. Temperature of outer ring
5. Heating time
6. Calculation period
7. Maximum temperature differential
Temperature hold mode

This function of the heating device is only active in the operating modes:
- temperature control
- ramp control
- delta-T control.

Once the heating temperature is achieved, the heating device demagnetises the rolling bearing. If the temperature of the rolling bearing falls below the limit temperature, the heating device will again heat the rolling bearing to the heating temperature, Figure 17.

The user can maintain temperature hold by pressing [START/STOP]. If temperature hold is not maintained, temperature hold will stop once the temperature hold time has ended and the rolling bearing will cool again, Figure 18.
Induction heating devices HEATER

Transport and storage
The two smallest heating devices can be carried, while the larger and thus heavier heating devices are transported by means of a crane or pallet truck/fork lift truck. In order to protect a heating device against damage during storage, there are rules relating to permissible ambient conditions, see section Storage, page 10.

Transport
The safety regulations for transport must be observed, see page 10. For the transport of heavy heating devices, a device with sufficient load capacity must be used.

Transport of HEATER25 and HEATER50
This device can be carried with one hand using a lifting tool, Figure 19.

<table>
<thead>
<tr>
<th>WARNING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hazard of leg or foot damage due to falling heating device if this becomes detached from the lifting tool. Secure lifting tool by means of a cotter pin during transport.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>WARNING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hazard of falling injuries as a result of tripping due to hanging down of the mains connection cable. Secure mains connection cable against dropping during transport.</td>
</tr>
</tbody>
</table>

Figure 19
Transport of HEATER25 and HEATER50

1 Lifting tool
2 Cotter pin
3 Mains connection cable
Transport of HEATER100

This device can be carried using both hands. The protrusion on one side can be used as a hand grip. On the other side, a lifting tool can be screwed into the U-shaped core, Figure 20.

WARNING

Hazard of falling injuries as a result of tripping due to hanging down of mains connection cable.

Secure mains connection cable against dropping during transport.

Figure 20
Transport of HEATER100

1 Lifting tool
2 Mains connection cable
Induction heating devices HEATER

Transport of HEATER200

This device can be transported using a crane. A two-piece lifting tool can be fixed to the U-shaped core, Figure 21.

**WARNING**

Injuries due to falling heating device if this becomes detached from the lifting tool.
Secure transport handle by means of retaining nut during transport.

**WARNING**

Destruction of mains connection cable and dropping of heating device by hooking of mains connection cable hanging down.
Secure mains connection cable against dropping during transport.

![Figure 21](image)

Transport of HEATER200

① Lifting tool, transport eyelet
② Lifting tool, transport handle
③ Retaining nut
④ Mains connection cable
These devices can be transported using a pallet truck or by means of a fork lift truck, Figure 22. The fork spacing is dependent on the device size, see table.

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Fork spacing (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heating device</td>
<td>HEATER400</td>
<td>600</td>
</tr>
<tr>
<td></td>
<td>HEATER800</td>
<td>750</td>
</tr>
</tbody>
</table>

**NOTICE**
Damage to or separation of the mains connection cable hanging down.
Secure mains connection cable against dropping during transport.

*Figure 22*  
Transport of HEATER400 and HEATER800
Induction heating devices HEATER

Transport of HEATER1600

This device can be transported using a pallet truck or by means of a fork lift truck, Figure 23. The fork spacing is specified, see table.

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Fork spacing mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heating device</td>
<td>HEATER1600</td>
<td>1 000</td>
</tr>
</tbody>
</table>

Storage

The safety regulations for storage must be observed, see page 10. A heating device should be stored with protection against dust and UV radiation.
### Commissioning

**Hazard area**

The heating device is commissioned at the mounting area.

The hazard area of the heating device can represent a danger of death.

---

#### DANGER

Danger of heart stoppage in persons fitted with a pacemaker due to the strong electromagnetic field.

Ensure that persons fitted with a pacemaker remain outside the hazard area of the heating device. Erect barriers and attach clearly visible warning signs, *Figure 24.*

---

#### WARNING

Danger of death for persons with artificial heart valves made from metal, hazard of severe burns due to heating of implants by the electromagnetic field, see page 7.

Ensure that persons with a ferromagnetic implant remain outside the hazard area of the heating device. Erect barriers and attach clearly visible warning signs, *Figure 24.*

---

*Figure 24*  
Hazard area

1. Hazard area, 2 m  
2. Barrier  
3. Flat work surface capable of supporting load

---

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Induction heating devices HEATER

Initial stages

The first stages in commissioning are as follows:
- Remove packaging.
- Check the scope of delivery of the heating device.
- Place the heating device in a suitable mounting area.

A suitable mounting area has the following characteristics:
- flat and horizontal
- distance from ferromagnetic parts at least 1 m
- capable of supporting the total mass of the heating device and rolling bearing
- a barrier present at a distance of 2 m.

Voltage supply

Connect to voltage supply:
- Check the heating device and mains connection cable for visible damage.

⚠️ DANGER
Fatal electrocution due to exposed wires as a result of melted cable sheathing.

Feed the mains connection cable around the U-shaped core.
Avoid contact between the mains connection cable and the component to be heated.

- Connect the heating device to the voltage supply, Figure 25; Figure 26 or Figure 27, page 35. For specification of the voltage supply, see nameplate, Figure 8, page 19, and page 71.

---

Figure 25
Voltage supply for HEATER25, HEATER50 and HEATER100

1. Safety contact socket, 230 V
2. Safety contact plug, 230 V

Figure 26
Voltage supply for HEATER200, HEATER400 and HEATER800

1. CEE plug, 400 V
2. Three-phase plug, 5 pin, 400 V
**DANGER**

Fatal electrocution through contact with device if mains connection has been carried out incorrectly.

Mains connection must be carried out by a trained electrician.

---

**Figure 27**

Mains connection for HEATER1600

1. Phase L1
2. Phase L2
3. Protective conductor
**Induction heating devices HEATER**

**Configuration**

The heating device is supplied in a default configuration and is ready for immediate operation. The user can, however, configure the heating device at any time. The device has a configuration menu. The USB connector can be used for loading new firmware or other user languages, see page 39.

**USB connector**

A USB connector is present below the touch-sensitive screen, *Figure 28*.

The following media can be used:
- USB2.0 stick (up to 32 GB, FAT).

![USB connector](image-url)
Configuration menu

The configuration menu contains a list of parameters that influence the behaviour of the device, Figure 29.
The configuration menu is called up as follows:
▶ Press [START/STOP] for at least 8 seconds.

A parameter is selected and adjusted by means of symbols on the touch-sensitive screen, see table.

<table>
<thead>
<tr>
<th>Symbols</th>
<th>Designation</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>[Arrow up]</td>
<td>[Arrow down]</td>
<td>1: Change to previous parameter</td>
</tr>
<tr>
<td>[Arrow up]</td>
<td>[Arrow down]</td>
<td>2: Increase value</td>
</tr>
<tr>
<td>[Apply]</td>
<td>[Cancel]</td>
<td>1: Change to next parameter</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2: Reduce value</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Confirm modified value and go back to parameter list</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Undo changes and go back to parameter list</td>
</tr>
</tbody>
</table>
Induction heating devices HEATER

Updating the firmware

A firmware update is only possible via the USB connector:

- Copy the current firmware to your Windows PC from www.schaeffler.de/heater-software.
- Check whether the current firmware is already installed (U29), see page 47.
- Format a USB stick, see page 36. There must be no other files on the USB stick.
- Copy the following files onto the USB stick (top level)
  - BOOTGUI.BIN
  - BOOTGUI_DD-MMM-YYYY FAG v* build *.BIN.
- Connect the USB stick.
- Press [START/STOP] for at least 8 seconds.
- Scroll to parameter U26.
- Select the parameter on the screen.
- When the security question appears, click on [Apply].
- The firmware will now be updated, Figure 30.

![Figure 30: Updating firmware](image)

1 Parameter U26 selected
2 Security question, [Apply]
**User languages**

The control unit can simultaneously store up to 32 user languages.

**Deleting a user language**

The user languages cannot be individually deleted. Whenever the user languages are installed, all the languages present on the device are deleted. The languages present in the language package are then installed.
Induction heating devices HEATER

Copying user languages

The control unit can simultaneously store up to 32 user languages. These are installed as a package.

After a firmware update, the user languages must always be copied again.

Copy the user languages to the device:

- Copy the language package to your Windows PC from www.schaeffler.de/heater-software.
- Format a USB stick, see page 36.
  There must be no other files on the USB stick.
- Copy the following files onto the USB stick (top level)
  - TEXT_DD-MMM-YYYY_v*.BIN
  - FONTS_DD-MMM-YYYY_v*.BIN.
- Connect the USB stick.
- Press [START/STOP] for at least 8 seconds.
- Scroll to parameter U28.
- Select the parameter on the screen.
- When the security question appears, click on [Apply].

The languages will now be copied, Figure 31.

![Parameter U28 selected](image1)
![Security question, [Apply]](image2)

Figure 31

Copying user languages
Parameters

The behaviour of the device can be set by means of parameters. During configuration, the heating device is set to user mode.

There are three different types of parameters, see table, page 42:

- setting parameters
- command parameters
- information parameters.

A setting parameter sets and permanently saves a value. In order to change the value set in this way, the parameter must be called up again.

With a command parameter, selecting the parameter gives a command that initiates control of the device.

An information parameter saves values that can be called up.
## Overview of parameters

<table>
<thead>
<tr>
<th>Dimension</th>
<th>Definition</th>
<th>S</th>
<th>C</th>
<th>I</th>
</tr>
</thead>
<tbody>
<tr>
<td>U00</td>
<td>Resetting to device default setting</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U01</td>
<td>User language</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U02</td>
<td>Default setting for heating temperature</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U03</td>
<td>Temperature hold on/off</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U04</td>
<td>Temperature hold time</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U05</td>
<td>Signal for end of heating operation</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U06</td>
<td>Unit for temperature</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U07</td>
<td>Temperature differential delta-T</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U08</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U09</td>
<td>Calibration temperature of temperature sensor 1</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U10</td>
<td>Calibration temperature of temperature sensor 2</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U11</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U12</td>
<td>Start delay</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U13</td>
<td>Diagram of temperature pattern</td>
<td></td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>U14</td>
<td>Screensaver</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U15</td>
<td>Time</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U16</td>
<td>Date</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U17</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U18</td>
<td>Time format</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U19</td>
<td>Temperature differential in temperature hold</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U20</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U21</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U22</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U23</td>
<td>Deleting the favourites list</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U24</td>
<td>Exit</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U25</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U26</td>
<td>Updating firmware</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U27</td>
<td>...</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>U28</td>
<td>Loading languages</td>
<td></td>
<td>●</td>
<td></td>
</tr>
<tr>
<td>U29</td>
<td>Firmware version</td>
<td></td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>U30</td>
<td>Number of heating operations</td>
<td></td>
<td></td>
<td>●</td>
</tr>
<tr>
<td>U31</td>
<td>Total heating time</td>
<td></td>
<td></td>
<td>●</td>
</tr>
</tbody>
</table>

S: Setting parameter  
C: Command parameter  
I: Information parameter
Resetting to device default setting U00

The heating device is supplied with default settings for the parameters and a specific firmware. The heating device can be restored to this default setting at any time. This parameter resets all other parameters to the default settings. The firmware is also activated again at delivery and updates to the firmware are deleted.
Setting options:
■ Device default setting on (default setting)
■ Device default setting off.

User language U01

The heating device is supplied with several user languages. This parameter is used to select one of the available user languages as the current user language.
User language:
■ English
■ German
■ Dutch
■ ...

Default setting for heating temperature U02

The heating temperature is the temperature to which the rolling bearing is heated. If the operating mode of the heating device is temperature control, the heating temperature last used is shown in the display when it is switched on.
Heating temperature:
■ +50 °C, 122 °F Minimum value
■ +110 °C, 230 °F Default setting
■ +240 °C, 464 °F Maximum value
■ 1 Step size.
## Induction heating devices HEATER

<table>
<thead>
<tr>
<th>Setting</th>
<th>Description</th>
<th>Notes</th>
</tr>
</thead>
</table>
| **Temperature hold on/off** U03 | Once the heating temperature is achieved, the heating device stops
the heating operation. The rolling bearing starts to cool down.
If the temperature is below a certain temperature value, the bearing
is heated again. The time duration of temperature hold can be set
using the parameter U04. | Setting options:
- Temperature hold on (default setting)
- Temperature hold off. |
| **Temperature hold time** U04 | After the set time, temperature hold is switched off and the rolling
bearing cools down. | Values and step size:
- 0 s Minimum value
- 0 s Default setting
- 30 s Delivered condition
- 99 h:59 min:59 s Maximum value
- 1 Step size. |
| **Signal for end of heating operation** U05 | The end of the heating operation is always displayed optically on
the touch-sensitive screen but can also be displayed by acoustic
means. | Setting options:
- Signal for end of heating operation on (default setting)
- Signal for end of heating operation off. |
| **Unit for temperature** U06 | The measured temperature is shown in the selected unit. | Units:
- Display in °C (default setting)
- Display in °F. |
| **Temperature differential delta-T** U07 | This value is the maximum permissible temperature differential
in delta-T control. The temperature differential results from the
comparison of the temperatures measured by temperature sensor 1
and temperature sensor 2. | Values and step size:
- 1 °C, 33.8 °F Minimum value
- +35 °C, 95 °F Default setting
- +100 °C, 212 °F Maximum value
- 1 Step size. |
Before a new temperature sensor is used for the first time, it should be calibrated. Calibration is a point calibration. It is therefore advantageous if calibration is carried out at the heating temperature. The temperature of the sensor head is recorded using an adjusted temperature gauge. This temperature is inputted as the calibration temperature. Values and step size:
- +10 °C, 50 °F Minimum value
- +42 °C, 107,6 °F Maximum value
- 1 Step size.

Before a new temperature sensor is used for the first time, it should be calibrated. Calibration is a point calibration. It is therefore advantageous if calibration is carried out at the heating temperature. The temperature of the sensor head is recorded using an adjusted temperature gauge. This temperature is inputted as the calibration temperature. Values and step size:
- +9 °C, 48,2 °F Minimum value
- +41 °C, 105,8 °F Maximum value
- 1 Step size.

The heating device does not start heating immediately after pressing [START/STOP]. The start delay is the time that passes after pressing [START/STOP] until the heating device starts heating. Values and step size:
- 5 s Minimum value
- 5 s Default setting
- 30 s Delivered condition
- 99 s Maximum value
- 1 Step size.

The last heating curve saved by the device is displayed. The values from which the heating curve was generated can be saved as a file (.csv).
Induction heating devices HEATER

**Screensaver**

The screensaver for the touch-sensitive screen can be switched off by inputting the minimum value.

Values and step size:
- 0 min Minimum value
- 10 min Default setting
- 10 min Delivered condition
- 240 min Maximum value
- 1 Step size.

**Time**

The time is given in hours (h) and minutes (min).

Values and step size:
- 00 h:00 min Default setting
- 23 h:59 min Maximum value with 24 h
- 11 h:59 min Maximum value with 12 h AM/PM
- 1 Step size.

**Date**

The date is displayed in accordance with DIN 5008 in the format (day.month.year).

Delivered condition and step size:
- 01.01.2000 Delivered condition
- 1 Step size.

**Time format**

Display of the time can be selected as one of two formats.

Formats:
- 24 h Default setting
- 12 h AM/PM US format.

**Temperature differential in temperature hold**

If temperature hold is switched on, the device will carry out heating again if the temperature decreases by this value.

**Deleting the favourites list**

All favourites can be deleted using this command parameter.

Setting options:
- Delete favourites list (default setting)
- Do not delete favourites list.
Exit
U24
The configuration menu is exited and the changes to parameters are not saved.

Setting options:
- Exit (default setting)
- Do not exit.

Updating firmware
U26
This command parameter starts an update of the firmware. The system checks whether the firmware on the USB stick is more up to date than the existing firmware.

Setting options:
- Update (default setting)
- Do not update.

Note
This parameter only appears in the list of parameters if a USB stick is inserted.

Loading languages
U28
This command parameter starts loading of a language package. All the existing languages are deleted and the user languages in the language package are installed. An individual language package can be created; please contact Customer Service in this case.

Setting options:
- Load languages (default setting)
- Do not load languages.

Note
If a language package is loaded, all the existing user languages will be deleted.
This parameter only appears in the list of parameters if a USB stick is inserted.

Firmware version
U29
This parameter shows the currently installed version of the firmware. Before installing firmware, it can thus be checked whether the most up to date version of the firmware is already installed.

Number of heating operations
U30
This parameter displays the number of heating operations that have been performed by this device. This information may be useful in searching for errors.

Total heating time
U31
This parameter displays the time for which the device was in operation during all heating operations. This information may be useful in searching for errors.
Induction heating devices HEATER

Operation

It is recommended that only one rolling bearing should ever be heated at one time.

A heating operation comprises the following stages:
■ Select the suitable heating device
■ Select and if necessary change the ledge
■ Position the rolling bearing
■ Attach the temperature sensor
■ Select the heating method
■ Set the values
■ Carry out heating
■ Remove the temperature sensor
■ Remove the rolling bearing
■ Save the heating curve (optional).

Selecting a heating device

Not all rolling bearings are suitable for these heating devices. The mass and dimensions must fulfill certain values.

WARNING

Risk of injury due to tilting of heating device and falling rolling bearing.

Ensure that the permissible masses and dimensions are observed, see table.

<table>
<thead>
<tr>
<th>Designation</th>
<th>Mass Rolling bearing max. kg</th>
<th>Mass Other component max. kg</th>
<th>Inside diameter max. mm</th>
<th>Outside diameter max. mm</th>
<th>Width max. mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>HEATER25</td>
<td>25</td>
<td>20</td>
<td>10</td>
<td>400</td>
<td>140</td>
</tr>
<tr>
<td>HEATER50</td>
<td>50</td>
<td>40</td>
<td>10</td>
<td>400</td>
<td>140</td>
</tr>
<tr>
<td>HEATER100</td>
<td>100</td>
<td>80</td>
<td>15</td>
<td>500</td>
<td>180</td>
</tr>
<tr>
<td>HEATER200</td>
<td>200</td>
<td>150</td>
<td>20</td>
<td>600</td>
<td>210</td>
</tr>
<tr>
<td>HEATER400</td>
<td>400</td>
<td>300</td>
<td>40</td>
<td>1 000</td>
<td>330</td>
</tr>
<tr>
<td>HEATER800</td>
<td>800</td>
<td>600</td>
<td>50</td>
<td>1 500</td>
<td>400</td>
</tr>
<tr>
<td>HEATER1600</td>
<td>1 600</td>
<td>1 200</td>
<td>90</td>
<td>2 000</td>
<td>650</td>
</tr>
</tbody>
</table>

Selecting a support ledge

If a support ledge is used whose cross-section is too small, the heating device cannot carry out heating at full power:
▷ Select the support ledge with the largest possible cross-section.
Changing the slewing ledge

Before heating, the slewing ledge with the largest possible cross-section is selected. When using a support ledge, the slewing ledge present is removed but a new slewing ledge is not put in place.

**Lifting off the slewing ledge**

Lift off the slewing ledge, *Figure 32*:
- Switch off the heating device using the main switch.
- Lift the slewing ledge upwards off the locating stud.
- Place the slewing ledge on the work surface next to the heating device.
- Grease the contact surfaces.

![Figure 32](image)

1. Slewing ledge
2. Locating stud

*Figure 32*  
Lifting off the slewing ledge

**Locating the slewing ledge**

Locate the slewing ledge, *Figure 33*:
- Place the new slewing ledge from above on the locating stud.
- Position the slewing ledge on the U-shaped core.
- The slewing ledge has been changed.

![Figure 33](image)

1. Slewing ledge
2. U-shaped core

*Figure 33*  
Locating the slewing ledge
Induction heating devices HEATER

Changing the vertical ledge

Removing the vertical ledge

Before heating, the vertical ledge with the largest possible cross-section is selected.

- Remove the vertical ledge, Figure 34:
  - Switch off the heating device using the main switch.
  - Lift the vertical ledge away from the ledge guide using a suitable lifting device.
  - Place the vertical ledge on the work surface next to the heating device.
  - Grease the contact surfaces and guide of the vertical ledge to be mounted as well as the contact surfaces on the U-shaped core.

Mounting the vertical ledge

Mount the vertical ledge, Figure 35:

- Mount the vertical ledge from above in the ledge guide using a suitable lifting device.
- The vertical ledge has been changed.

Figure 34

Removing the vertical ledge

Figure 35

Mounting the vertical ledge
Positioning the rolling bearing

Depending on the heating device used, the rolling bearing can be positioned either suspended or lying flat, see table.

Positioning

<table>
<thead>
<tr>
<th>Designation</th>
<th>Support ledge</th>
<th>Sliding ledge</th>
<th>Vertical ledge</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Suspended</td>
<td>Lying flat</td>
<td>Suspended</td>
</tr>
<tr>
<td>HEATER25</td>
<td>●</td>
<td>●</td>
<td>–</td>
</tr>
<tr>
<td>HEATER50</td>
<td>●</td>
<td>●</td>
<td>–</td>
</tr>
<tr>
<td>HEATER100</td>
<td>●</td>
<td>●</td>
<td>●</td>
</tr>
<tr>
<td>HEATER200</td>
<td>●</td>
<td>●</td>
<td>●</td>
</tr>
<tr>
<td>HEATER400</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>HEATER800</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>HEATER1600</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>

Support ledge: positioning the rolling bearing suspended

Position the rolling bearing on the heating device, Figure 36:

**NOTICE**

Damage to the heating device due to overloading of the support ledge.

Observe the maximum mass of the rolling bearing, see table.

1. Remove the slewing ledge if necessary.
2. Grease the support surfaces.
3. Slide the rolling bearing onto the support ledge.
4. Lay the support ledge with the rolling bearing on the U-shaped core.

The rolling bearing is positioned suspended from the support ledge.

Mass, maximum

<table>
<thead>
<tr>
<th>Designation</th>
<th>Mass max. kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HEATER25, HEATER50</td>
<td></td>
</tr>
<tr>
<td>HEATER50.LEDGE-10</td>
<td>0.5</td>
</tr>
<tr>
<td>HEATER50.LEDGE-15</td>
<td>1</td>
</tr>
<tr>
<td>HEATER50.LEDGE-20</td>
<td>3</td>
</tr>
<tr>
<td>HEATER100</td>
<td></td>
</tr>
<tr>
<td>HEATER100.LEDGE-15</td>
<td>1</td>
</tr>
<tr>
<td>HEATER100.LEDGE-20</td>
<td>3</td>
</tr>
<tr>
<td>HEATER200</td>
<td></td>
</tr>
<tr>
<td>HEATER200.LEDGE-20</td>
<td>3</td>
</tr>
</tbody>
</table>

*Figure 36*

Rolling bearing suspended, support ledge
Induction heating devices HEATER

Slewing ledge: positioning the rolling bearing suspended

Position the rolling bearing, Figure 37:

**WARNING**
Risk of injury due to tilting of heating device and falling rolling bearing.

In the case of heavy rolling bearings, use a suitable carrying sling and a suitable lifting device, then slide the rolling bearing to the end of the slewing ledge during positioning.

**NOTICE**
Damage to the heating device due to overloading of the open slewing ledge.

Observe the maximum mass for open slewing ledges, see table.

- Rotate the slewing ledge away from the U-shaped core.
- Slide the rolling bearing onto the slewing ledge.
- Rotate the slewing ledge with the rolling bearing until the slewing ledge is fully located on the U-shaped core.
- Lower the rolling bearing.
- Remove the carrying sling.

The rolling bearing is positioned suspended from the slewing ledge.

<table>
<thead>
<tr>
<th>Designation</th>
<th>Mass max. kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HEATER100</td>
<td>20</td>
</tr>
<tr>
<td>HEATER200</td>
<td>30</td>
</tr>
</tbody>
</table>

**Figure 37**
Rolling bearing suspended, slewing ledge

1 Rolling bearing
2 Slewing ledge
Support ledge: positioning the rolling bearing lying flat

Position the rolling bearing, Figure 38:

- Remove the slewing ledge if necessary.
- Slide the sliding table out so that the sliding table supports the outer ring of the rolling bearing.
- Lay the rolling bearing on the sliding table.
- Lay the support ledge centrally on the U-shaped core.

The rolling bearing is positioned lying flat.

---

Slewing ledge: positioning the rolling bearing lying flat

Position the rolling bearing, Figure 39:

- Rotate the slewing ledge away from the U-shaped core.
- Slide the sliding table out so that the sliding table supports the outer ring of the rolling bearing.
- Lay the rolling bearing on the sliding table.
- Rotate the slewing ledge so that it is fully located on the U-shaped core.

The rolling bearing is positioned lying flat.
Induction heating devices HEATER

Position the rolling bearing, Figure 40:

**WARNING**

Risk of injury due to tilting of heating device and falling rolling bearing.

For rolling bearings and other heavy workpieces, always use the sliding table. Use a suitable carrying sling and a suitable lifting device for the vertical ledge.

- Slide the sliding table out so that the sliding table supports the outer ring of the rolling bearing.
- Lift the vertical ledge using a suitable lifting device.
- Position the rolling bearing by means of the sliding table so that the vertical ledge can be lowered through the inner ring onto the U-shaped iron core.
- Lower the vertical ledge and remove the carrying sling.

The rolling bearing is positioned.

---

**Figure 40**

Positioning the rolling bearing, vertical ledge

1. Sliding table
2. Vertical ledge
3. Rolling bearing

---

<table>
<thead>
<tr>
<th>1</th>
<th>2</th>
<th>3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sliding table</td>
<td>Vertical ledge</td>
<td>Rolling bearing</td>
</tr>
</tbody>
</table>
Except in the operating mode of time control, at least one temperature sensor must be used, see table.

### Temperature sensors

<table>
<thead>
<tr>
<th>Heating method</th>
<th>Temperature sensor</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Inner ring</td>
</tr>
<tr>
<td>Time control</td>
<td>–</td>
</tr>
<tr>
<td>Temperature control</td>
<td>●</td>
</tr>
<tr>
<td>Ramp control</td>
<td>●</td>
</tr>
<tr>
<td>Delta-T control</td>
<td>●</td>
</tr>
</tbody>
</table>

**NOTICE**

Destruction of the temperature sensor through heating of the cable, leading to melting of the cable sheathing.

Feed the temperature sensor cable around the U-shaped core.

- Insert the plug of the temperature sensor with the red mark facing upwards in one of the two sockets.
- Place the magnetic sensor head of the temperature sensor on the end face, which must be free from grease and oil, of the inner ring.
- The temperature sensor is connected and attached and the temperature can be measured.

![Connecting and attaching the temperature sensor](image)

**Figure 41**

Connecting and attaching the temperature sensor
Induction heating devices HEATER

Connecting and attaching two temperature sensors

Connect and attach two temperature sensors, Figure 42:

**NOTICE**

Destruction of the temperature sensors through heating of the cable, leading to melting of the cable sheathing.

Feed the temperature sensor cable around the U-shaped core.

- Insert the plug of one temperature sensor with the red mark facing upwards in one of the two sockets.
- Place the magnetic sensor head of the temperature sensor on the end face, which must be free from grease and oil, of the inner ring.
- Insert the plug of the other temperature sensor with the red mark facing upwards in the socket not used yet.
- Place the magnetic sensor head of the temperature sensor on the end face, which must be free from grease and oil, of the outer ring.

The temperature sensors are connected and attached and the temperatures can be measured.

**Figure 42**

Connecting and attaching the temperature sensor

1. Inner ring of rolling bearing
2. Sensor head on inner ring
3. Cable of temperature sensor
4. Socket for temperature sensor
5. Plug of temperature sensor
6. Outer ring of rolling bearing
7. Sensor head on outer ring
Selecting the heating method

- Switch on the heating device using the main switch.
- If the symbol for the heating method (in this case [Temperature control]) does not have a green border, click on the symbol.
- The symbol will be shown with a green border and the preset values (in this case the heating temperature) will be displayed.
- Click on the value displayed (in this case the heating temperature).
- The screen with the values for this heating method (in this case the heating temperature) will be displayed, Figure 43.

![Figure 43 Setting](image-url)
Setting values

A heating operation by means of temperature control is described here. Heating by one of the other heating methods is carried out according to the same system.

- Set the value (in this case the heating temperature) by means of [Arrow up] and [Arrow down], Figure 44.
- Click on [Apply].
- The value will be accepted and the start screen will be displayed.

![Heating temperature screen](image)

**WARNING**
Serious injuries due to destroyed heating device with heating of the component to more than +240 °C.
Restrict the heating temperature to +240 °C. >>
Heating

- Press [START/STOP].
- The countdown time is counted down, *Figure 45*.
- Move out of the hazard area of the heating device and observe the safe distance while the heating device is heating the rolling bearing.

*Figure 45 Countown*

Heating begins in 2 seconds.
Cancel start using START/STOP.

Observe safe distance (2m)!

- Wait for the end of the countdown time.
- The temperature will be displayed, the electromagnetic field will be generated and the heating operation will start.
- Wait until the temperature is reached.
Induction heating devices HEATER

Cancelling temperature hold

If temperature hold is switched on, this can be cancelled before it stops itself.
There is normally sufficient time to reach the heating device and activate [START/STOP]. If the countdown time has been set to a low value and the rolling bearing is cooling very quickly, the countdown may start while the user is still in the hazard area.

**WARNING**

Risk of damage to health from remaining in the electromagnetic field.
Leave the hazard area of the heating device and observe the safe distance if the countdown time is being counted down.

- From a safe distance, check whether the touch-sensitive screen is displaying a white tick in a green circle and the text Heating operation ended, *Figure 46*.
- Press [START/STOP] to end temperature hold.
  The heated rolling bearing can be removed.

*Figure 46*  
Heating operation ended
Removing the temperature sensor

In order to protect the temperature sensor against damage, it should be removed before removing the rolling bearing.

Remove the temperature sensor, *Figure 47*:

- Grip the temperature sensor by its sensor head.
- Detach the sensor head from the end face of the inner ring.
- Where necessary, pull the plug of the temperature sensor out of the socket.

*Figure 47* Removing the temperature sensor

1. Inner ring of rolling bearing
2. Sensor head of temperature sensor
3. Cable of temperature sensor
4. Socket for temperature sensor
5. Plug of temperature sensor
Removing the rolling bearing

Once the temperature sensor or sensors have been detached, the rolling bearing can be removed.

Remove the rolling bearing, Figure 48:

⚠️ WARNING
Severe burns to hands due to touching the hot workpiece without protective gloves.
Wear gloves that are heat-resistant up to +250 °C.

⚠️ WARNING
Severe foot injuries due to falling ledge or falling rolling bearing.
Wear safety shoes.

➤ Lift the rolling bearing and the support ledge together off the U-shaped core.
➤ Remove the support ledge from the rolling bearing and lay both down separately.
➤ The rolling bearing can now be mounted.

Figure 48
Removing the suspended rolling bearing from the support ledge
Slewing ledge: removing the suspended rolling bearing

Remove the rolling bearing, *Figure 49*:

**WARNING**

Severe burns to hands due to touching the hot workpiece without protective gloves.

Wear gloves that are heat-resistant up to +250 °C.

**WARNING**

Severe foot injuries due to falling ledge or falling rolling bearing.

Wear safety shoes.

- Lift heavy rolling bearings by means of a carrying sling and suitable lifting device.
- Rotate the rolling bearing and slewing ledge away from the U-shaped core.
- Slide the rolling bearing off the slewing ledge.
- The rolling bearing can now be mounted.
Slewing ledge: removing the rolling bearing lying flat

Remove the rolling bearing, Figure 50:

**WARNING**
Severe burns to hands due to touching the hot workpiece without protective gloves.
Wear gloves that are heat-resistant up to +250 °C. ◀

**WARNING**
Severe foot injuries due to falling ledge or falling rolling bearing.
Wear safety shoes. ◀

- Rotate the slewing ledge away from the U-shaped core.
- Remove the rolling bearing.
- The rolling bearing can now be mounted.

Figure 50
Removing the rolling bearing lying flat
Remove the rolling bearing, *Figure 51*:

**WARNING**
Severe burns to hands due to touching the hot workpiece without protective gloves.
Wear gloves that are heat-resistant up to +250 °C.

**WARNING**
Severe foot injuries due to falling ledge or falling rolling bearing.
Wear safety shoes.

- Lift the vertical ledge using a suitable lifting device.
- Remove the rolling bearing from the heating device by means of the sliding table.
- Lower the vertical ledge.
- Lift the rolling bearing off the sliding table.
- The rolling bearing can now be mounted.

---

1. Sliding table
2. Vertical ledge
3. Rolling bearing

*Figure 51*  
Removing the rolling bearing
Induction heating devices HEATER

**Saving the heating curve**

- Click on the symbol [Display heating curve], *Figure 52*.

- Insert the USB stick in the USB connector.

- Click on the symbol [Save file].

- Confirm the suggested filename by clicking on the symbol [Apply], *Figure 53*.

- The values from the heating curve will be saved as a file on the USB stick.

*Figure 52*  
Displaying the heating curve

*Figure 53*  
Saving the heating curve
Troubleshooting

A malfunction of the heating operation may have many causes. Some errors can be identified by the user from the behaviour of the heating device but an error number is not displayed. Other errors are identified by the heating device. The heating device will then display a corresponding error number and the associated error message on the touch-sensitive screen.

General errors

General errors are not displayed as an error message on the touch-sensitive screen, see table.

<table>
<thead>
<tr>
<th>Error, cause, remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>Error</td>
</tr>
<tr>
<td>Date is not current and is displayed in red</td>
</tr>
<tr>
<td>During heating, the heating device emits strong vibrations</td>
</tr>
</tbody>
</table>

Slight error

If an error message is displayed in a window with a grey background, the error can in most cases be remedied by the user, Figure 54.

- Eliminate the error.
- Restart heating device.

Figure 54

Slight error, grey background
Induction heating devices HEATER

**Serious error**

Some errors are displayed in a window with a red background, *Figure 55*. These errors cannot be remedied by the user.

- Make a note of the error number.
- Contact Customer Service at Schaeffler Technologies AG & Co. KG.

![Error Number](image)

---

**Repair**

The heating device can be returned to Schaeffler Technologies AG & Co. KG for repair. In the case of smaller devices, an employee from Customer Service may be able to repair the device on site.

---

**WARNING**

The heating device may operate incorrectly in a manner that is fatal if it is not repaired correctly.

A heating device may only be repaired by Schaeffler Technologies.
**Maintenance**

Before every use, a visual and functional inspection must be carried out. If necessary, maintenance must be carried out on the device.

**Maintenance plan**

The maintenance items are stated in the maintenance plan, see **tables**.

### Before every use

<table>
<thead>
<tr>
<th>Subassembly</th>
<th>Activity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heating device</td>
<td>Visual inspection:</td>
</tr>
<tr>
<td></td>
<td>- Check the housing for damage</td>
</tr>
<tr>
<td></td>
<td>- Check the plug and cable for damage to the insulation</td>
</tr>
<tr>
<td></td>
<td>- Check that the sliding table and the support, slewing and vertical</td>
</tr>
<tr>
<td></td>
<td>- Check the function of the display</td>
</tr>
<tr>
<td></td>
<td>- Check the function of the display</td>
</tr>
</tbody>
</table>

### As necessary

<table>
<thead>
<tr>
<th>Subassembly</th>
<th>Activity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heating device</td>
<td>Clean with a soft, dry cloth</td>
</tr>
<tr>
<td>Contact surfaces on U-shaped core</td>
<td>Cleaning of contact surfaces</td>
</tr>
<tr>
<td></td>
<td>- For optimum contact and to prevent corrosion, regularly grease with</td>
</tr>
<tr>
<td></td>
<td>- an acid-free grease, see label</td>
</tr>
<tr>
<td></td>
<td>LUBRICATE CONTACT SURFACES</td>
</tr>
</tbody>
</table>
Induction heating devices HEATER

Decommissioning
If the heating device will no longer be used regularly, it should be decommissioned.
Decommissioning:
► Switch off the heating device using the main switch.
► Disconnect the heating device from the voltage supply.
► Fit the cover to the heating device.

Disposal
The device can be returned to Schaeffler for disposal.
The heating device can be dismantled in order to dispose of the subassemblies separately.
The heating device may only be dismantled by an electrician.

WARNING
Electrocution due to sudden discharge of capacitors.
Before dismantling of the heating device, wait at least 24 h after disconnection from the voltage supply.

WARNING
Cutting injuries to the hands when working on sharp-edged components located in the interior of the heating device.
In dismantling, use cut-resistant safety gloves.

Regulations
Disposal must be carried out in accordance with locally applicable regulations.
Technical data and accessories

Standard accessories are included in the scope of delivery, special accessories can be ordered separately.

HEATER25

Technical data and accessories for HEATER25, see tables.

### Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>465 mm×220 mm×275 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>16 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 230 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>2,3 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>10 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>3 strands, length 1,5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>Safety contact plug to CEE-7</td>
</tr>
</tbody>
</table>

### Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d (1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Support ledge</td>
<td>HEATER50.LEDGE-55(2)</td>
<td>40×38×200</td>
<td>55</td>
<td>2,3</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER50.CARRY(2)</td>
<td>–</td>
<td>–</td>
<td>0,35</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,28</td>
</tr>
</tbody>
</table>

(1) Suitable for rolling bearings with minimum inside diameter as stated.
(2) Designation deviates from the naming system as the component is also used for HEATER50.

### Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d (1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sliding table</td>
<td>HEATER50.SLIDING-TABLE(2)</td>
<td>350×180×180</td>
<td>–</td>
<td>0,7</td>
</tr>
<tr>
<td>Support ledge</td>
<td>HEATER50.LEDGE-10(2)</td>
<td>7×7×200</td>
<td>10</td>
<td>0,1</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-15(2)</td>
<td>10×10×200</td>
<td>15</td>
<td>0,2</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-20(2)</td>
<td>14×14×200</td>
<td>20</td>
<td>0,3</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-35(2)</td>
<td>25×24×200</td>
<td>35</td>
<td>0,9</td>
</tr>
<tr>
<td>Adapter posts</td>
<td>HEATER50.ADAPTER-75(2)</td>
<td>40×50×75</td>
<td>–</td>
<td>2,2</td>
</tr>
</tbody>
</table>

(1) Suitable for rolling bearings with minimum inside diameter as stated.
(2) Designation deviates from the naming system as the component is also used for HEATER50.
# Induction heating devices HEATER

## HEATER50

Technical data and accessories for HEATER50, see tables.

### Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>450 mm × 225 mm × 260 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>18 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 230 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>3 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>13 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>3 strands, length 1,5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>Safety contact plug to CEE-7</td>
</tr>
</tbody>
</table>

### Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Support ledge</td>
<td>HEATER50.LEDGE-55</td>
<td>40×38×200</td>
<td>55</td>
<td>2,3</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER50.CARRY</td>
<td>–</td>
<td>–</td>
<td>0,35</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,28</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.

### Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Support ledge</td>
<td>HEATER50.LEDGE-10</td>
<td>7×7×200</td>
<td>10</td>
<td>0,1</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-15</td>
<td>10×10×200</td>
<td>15</td>
<td>0,2</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-20</td>
<td>14×14×200</td>
<td>20</td>
<td>0,3</td>
</tr>
<tr>
<td></td>
<td>HEATER50.LEDGE-35</td>
<td>25×24×200</td>
<td>35</td>
<td>0,9</td>
</tr>
<tr>
<td>Adapter posts</td>
<td>HEATER50.ADAPTER-75</td>
<td>40×50×75</td>
<td>–</td>
<td>2,2</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.
HEATER100  Technical data and accessories for HEATER100, see tables.

### Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>540 mm × 227 mm × 310 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>35 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 230 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>3,7 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>16 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>3 strands, length 1,5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>Safety contact plug to CEE-7</td>
</tr>
</tbody>
</table>

### Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>$d^{(1)}$ mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Slewing ledge</td>
<td>HEATER100.LEDGE-70</td>
<td>50×48×280</td>
<td>70</td>
<td>5,6</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-500MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER100.CARRY</td>
<td>–</td>
<td>–</td>
<td>0,48</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.

### Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>$d^{(1)}$ mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Support ledge</td>
<td>HEATER100.LEDGE-15</td>
<td>10×10×280</td>
<td>15</td>
<td>0,2</td>
</tr>
<tr>
<td></td>
<td>HEATER100.LEDGE-20</td>
<td>14×14×280</td>
<td>20</td>
<td>0,4</td>
</tr>
<tr>
<td></td>
<td>HEATER100.LEDGE-35</td>
<td>25×24×280</td>
<td>35</td>
<td>1,8</td>
</tr>
<tr>
<td>Slewing ledge</td>
<td>HEATER100.LEDGE-55</td>
<td>40×38×280</td>
<td>55</td>
<td>3,7</td>
</tr>
<tr>
<td>Adapter posts</td>
<td>HEATER100.ADAPTER-120</td>
<td>50×62×120</td>
<td>–</td>
<td>4,7</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.
Induction heating devices HEATER

**HEATER200**

Technical data and accessories for HEATER200, see tables.

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>695 mm × 330 mm × 370 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>86 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 400 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>8 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>20 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>5 strands, length 3.5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>5-pin three-phase plug to CEE-3P+N+E-32A</td>
</tr>
</tbody>
</table>

**Technical data**

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Slewing ledge</td>
<td>HEATER200.LEDGE-100</td>
<td>70×70×350</td>
<td>100</td>
<td>13,9</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-1000MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Lifting tool</td>
<td>HEATER200.CARRY</td>
<td>–</td>
<td>–</td>
<td>0,5</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,28</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.

**Standard accessories**

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Support ledge</td>
<td>HEATER200.LEDGE-20</td>
<td>14×14×350</td>
<td>20</td>
<td>0,5</td>
</tr>
<tr>
<td>Slewing ledge</td>
<td>HEATER200.LEDGE-30</td>
<td>20×20×350</td>
<td>30</td>
<td>2</td>
</tr>
<tr>
<td></td>
<td>HEATER200.LEDGE-40</td>
<td>30×26×350</td>
<td>40</td>
<td>3,2</td>
</tr>
<tr>
<td></td>
<td>HEATER200.LEDGE-55</td>
<td>40×38×350</td>
<td>55</td>
<td>5</td>
</tr>
<tr>
<td></td>
<td>HEATER200.LEDGE-70</td>
<td>50×48×350</td>
<td>70</td>
<td>7,4</td>
</tr>
<tr>
<td></td>
<td>HEATER200.LEDGE-85</td>
<td>60×60×350</td>
<td>85</td>
<td>10,4</td>
</tr>
<tr>
<td>Adapter posts</td>
<td>HEATER200.ADAPTER-150</td>
<td>70×80×150</td>
<td>–</td>
<td>11,4</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.
HEATER400 Technical data and accessories for HEATER400, see tables.

### Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>850 mm×420 mm×950 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>157 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 400 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>12,8 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>32 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>5 strands, length 3,5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>5-pin three-phase plug to CEE-3P+N+E-32A</td>
</tr>
</tbody>
</table>

### Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER400.LEDGE-120</td>
<td>80×92×490</td>
<td>120</td>
<td>28,5</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATERSENSOR-1000MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,28</td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.

### Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d1) mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER400.LEDGE-40</td>
<td>20×32×490</td>
<td>40</td>
<td>4</td>
</tr>
<tr>
<td>HEATER400.LEDGE-50</td>
<td>30×38×490</td>
<td>50</td>
<td>6,1</td>
<td></td>
</tr>
<tr>
<td>HEATER400.LEDGE-65</td>
<td>40×50×490</td>
<td>65</td>
<td>9</td>
<td></td>
</tr>
<tr>
<td>HEATER400.LEDGE-80</td>
<td>50×60×490</td>
<td>80</td>
<td>12,8</td>
<td></td>
</tr>
<tr>
<td>HEATER400.LEDGE-90</td>
<td>60×72×490</td>
<td>90</td>
<td>17,4</td>
<td></td>
</tr>
<tr>
<td>HEATER400.LEDGE-105</td>
<td>70×82×490</td>
<td>105</td>
<td>22,6</td>
<td></td>
</tr>
</tbody>
</table>

1) Suitable for rolling bearings with minimum inside diameter as stated.
# Induction heating devices HEATER

## HEATER800

Technical data and accessories for HEATER800, see tables.

### Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>1080 mm × 500 mm × 1250 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>280 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 400 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>25,2 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>63 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>5 strands, length 3,5 m, rigidly connected to heating device</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>5-pin three-phase plug to CEE-3P+N+E-64A</td>
</tr>
</tbody>
</table>

### Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d¹ mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER800.LEDGE-150</td>
<td>100×112×750</td>
<td>150</td>
<td>65,9</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-1500MM</td>
<td>–</td>
<td>–</td>
<td>0,05</td>
</tr>
<tr>
<td>Gloves</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>–</td>
<td>–</td>
<td>0,28</td>
</tr>
</tbody>
</table>

¹) Suitable for rolling bearings with minimum inside diameter as stated.

### Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension mm</th>
<th>d¹ mm</th>
<th>Mass kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER800.LEDGE-50</td>
<td>30×38×750</td>
<td>50</td>
<td>7,4</td>
</tr>
<tr>
<td>HEATER800.LEDGE-65</td>
<td>40×50×750</td>
<td>65</td>
<td>12,2</td>
<td></td>
</tr>
<tr>
<td>HEATER800.LEDGE-80</td>
<td>50×60×750</td>
<td>80</td>
<td>18,3</td>
<td></td>
</tr>
<tr>
<td>HEATER800.LEDGE-90</td>
<td>60×72×750</td>
<td>90</td>
<td>25,4</td>
<td></td>
</tr>
<tr>
<td>HEATER800.LEDGE-105</td>
<td>70×82×750</td>
<td>105</td>
<td>33,8</td>
<td></td>
</tr>
<tr>
<td>HEATER800.LEDGE-120</td>
<td>80×92×750</td>
<td>120</td>
<td>43,3</td>
<td></td>
</tr>
<tr>
<td>HEATER800.LEDGE-135</td>
<td>90×102×750</td>
<td>135</td>
<td>54</td>
<td></td>
</tr>
</tbody>
</table>

¹) Suitable for rolling bearings with minimum inside diameter as stated.
HEATER1600

Technical data and accessories for HEATER1600, see tables.

Technical data

<table>
<thead>
<tr>
<th>Designation</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>1 500 mm × 800 mm × 1 600 mm</td>
</tr>
<tr>
<td>Mass without ledge</td>
<td>650 kg</td>
</tr>
<tr>
<td>Voltage supply</td>
<td>AC 400 V</td>
</tr>
<tr>
<td>Frequency</td>
<td>50 Hz</td>
</tr>
<tr>
<td>Power consumption</td>
<td>40 kVA</td>
</tr>
<tr>
<td>Current rating</td>
<td>100 A</td>
</tr>
<tr>
<td>Residual magnetism, maximum</td>
<td>2 A/cm</td>
</tr>
<tr>
<td>IP protection class</td>
<td>54</td>
</tr>
<tr>
<td>Mains connection cable</td>
<td>3 strands, minimum cross-section 35 mm²</td>
</tr>
<tr>
<td>Mains connection plug</td>
<td>—</td>
</tr>
<tr>
<td>Fuse protection</td>
<td>3NA3 830 NH000 500VAC 100A</td>
</tr>
</tbody>
</table>

Standard accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension (mm)</th>
<th>d1) (mm)</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER1600.LEDGE-220</td>
<td>150×162×1080</td>
<td>220</td>
<td>206,1</td>
</tr>
<tr>
<td>Temperature sensor</td>
<td>HEATER.SENSOR-1500MM</td>
<td>—</td>
<td>—</td>
<td>0,05</td>
</tr>
<tr>
<td>Gloves</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>0,2</td>
</tr>
<tr>
<td>Grease</td>
<td>ARCANOL-MULTI3-250G</td>
<td>—</td>
<td>—</td>
<td>0,28</td>
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</table>

Special accessories

<table>
<thead>
<tr>
<th>Component</th>
<th>Designation</th>
<th>Dimension (mm)</th>
<th>d1) (mm)</th>
<th>Mass (kg)</th>
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</thead>
<tbody>
<tr>
<td>Vertical ledge</td>
<td>HEATER1600.LEDGE-90</td>
<td>60×72×1080</td>
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<td>HEATER1600.LEDGE-120</td>
<td>80×92×1080</td>
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<td>HEATER1600.LEDGE-150</td>
<td>100×112×1080</td>
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<td>94,9</td>
</tr>
</tbody>
</table>

Original accessories

Only use FAG original accessories.

1) Suitable for rolling bearings with minimum inside diameter as stated.
Induction heating devices HEATER

Appendix

This appendix contains the Declaration of Conformity for heating devices.

EC Declaration of Conformity

Declaration of Conformity for heating devices HEATER25, HEATER50, HEATER100, HEATER200, HEATER400, HEATER800 and HEATER1600, Figure 56.

Figure 56

Declaration of Conformity
Every care has been taken to ensure the correctness of the information contained in this publication but no liability can be accepted for any errors or omissions. We reserve the right to make technical changes.

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