 <p>Committed to Excellence</p>	Work Instruction	
	Infrared Department Coil Preparation	
Revision: 01	Procedure No.: WI-8.2.4.26	Date Effective: 6/11/2012


### Coil Preparation

1. Check ohms for 100% of coils used
2. Crimp leadwire to resistance wire (except for twin-bore quartz heater)
3. Stretch coil to the length required for each heater type before coil is put in clay (ceramic heaters) or quartz tubes (KTE-, GEM-, and VSR-style heaters)
  - a. Special instruction for traditional solid body heaters rated above 301 V: the ends of the coil must be stretched more than the rest of the coil
  - b. Special instruction for hollow body heaters: the outside of the coil is stretched more than the inside of the coil, as defined on the Specification Sheet

### Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	5/25/2009	All	Initial Release	-
01	6/11/2012	All	Complete rewrite. Too much specific detail in some areas, wrong or incomplete information in others	TCH

### Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	
Senior Management Representative	Abraham Joseph	