



**WORK INSTRUCTION**

**Baking/Drying of MI Plus Heaters**

REVISION: 01

PROCEDURE NO.: WI-8.2.4.36

DATE EFFECTIVE: 05/24/10

The following is the procedure for baking MI Plus heaters

Step	Initial Temperature (°F)	Final Temperature (°F)	Duration (hh:mm)
1	Ambient	450	01:30
2	450	450	05:00
3	450	600	00:30
4	600	600	05:00
5	600	750	00:30
6	750	750	04:00
7	750	900	00:30
8	900	900	02:00
9	900	1050	00:30
10	1050	1050	99:00

- Temperatures listed above are reference temperatures.
- Durations listed above are approximate times and may be changed to achieve required Hi Pot values.
- Heaters that meet required Hi Pot values can be removed at any time during step 10 of the baking procedure.

For MI Plus cement potting (SEA-101-101) – Apply cement to required areas and cure at room temperature overnight. Then bake at a minimum of 150°F for 2 to 3 hours. Normally heaters are baked at 250°F to 400°F for 2 to 3 hours.

**REVISION HISTORY**

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/28/09	All	Initial release
01	05/24/10	All	±5°F temperature tolerance was removed. Temperatures listed are now reference temperatures.



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**AUTHORIZATION**

<b>POSITION</b>	<b>HELD BY</b>	<b>AUTHORIZATION SIGNATURE OR INITIALS</b>
Prepared By: Design Engineer	Ryan Lott	<i>Ryan M Lott</i>
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