



## WORK INSTRUCTION

### Drying/Baking Instructions

REVISION: 03

PROCEDURE NO.: WI-8.2.4.33

DATE EFFECTIVE: 03/04/20

**Heaters with Teflon plug** - bake at 150°F minimum until IR is above 1G before the swaging process. Normally heaters are baked at 250°F overnight to achieve desired results.

**Low temperature epoxy (SEA-103-117), RTV seals (SEA-102-102, SEA-102-105 & SEA-102-101) and Polyester Resin (SEA-109-101)** – bake heaters at 150°F minimum until IR is above 1G. Normally heaters are baked at 250 to 400°F overnight. Then apply the seals and post curing is done at room temperature.

**Stycast (SEA-103-103) & Epoxy Lite (SEA-103-122)** – bake heaters at 150°F minimum until IR is above 1G. Normally heaters are baked at 250 to 400°F overnight to achieve IR requirements. Then apply the seal and post cure at a minimum of 150°F until heaters pass hipot and IR requirements. Normal post cure temperature is around 165 to 180°F for a period of about 12 to 24 hours.

**High temperature UL approved epoxy seal (SEA-103-118)** – bake heaters at 150°F minimum until IR is above 1G. Normally heaters are baked at 165 to 180°F overnight. Then apply the seal and post cure it at the same temperature for about 12 to 24 hours or until the heaters pass hipot and IR requirements.

**Cement seal (SEA-101-101)** – apply cement onto the heaters and cure it at room temperature overnight. Then bake at 150°F minimum until heaters pass hipot. Normally heaters are baked at 250 to 400°F for about 6 hours.

**Cement seal (SEA-101-102)** – apply cement onto the heaters and cure at room temperature for a minimum of half hour. Post cure at approximate temperature of 200°F until heaters pass requirements. Normally heaters are baked at 200°F for about 17 hours.

**EI-Cast with 601 Hardener (SEA-103-109)** – apply epoxy to heaters and cure at room temperature for a minimum of one hour.



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**REVISION HISTORY**

REVISION LEVEL	DATE OF REVISION	SECTIONS	DESCRIPTION OF CHANGE
00	05/28/09	All	Initial release
01	04/15/14	All	Added Epoxy Lite to Stycast instructions
02	10/30/14	All	Added Polyester Resin (SEA-109-101) & RTV 108 (SEA-102-101) to instructions, changed Part Number SEA-103-112 to SEA-103-118
03	03/04/20	All	Added EI-Cast with 601 Hardener (SEA-103-109)

**AUTHORIZATION**

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
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