General purpose terminal box can be attached on Duraband diameters of 2-1/2" or larger. It offers excellent protection to exposed terminals. To simplify wiring, the box has a 1/2" trade size knockout (actual diameter 7/8") that will accept standard conduit or flexible armor cable connectors. It can be field assembled on most band heaters with screw terminals having a center distance of 7/8".

Flexible armor cable for lead protection is available where abrasion is a problem.

For maximum surface contact, the torque resistant and virtually unbreakable stainless steel screw terminals are securely fastened to a connecting jumper, assuring positive contact with the windings and providing maximum amperage carrying capacity. For other terminal or lead arrangements, see pages 1-36 through 1-41.

Specially designed mounting brackets with 1/4"-20 socket cap screws are used to draw the Built-In Strap to a high degree of tension. This tension exerts the great amount of drawing power required to pull the heating element assembly against the cylinder evenly and tightly across its entire width, thus eliminating all air gaps that can cause premature heater failure. The number of bracket assemblies used increases as the width of a Duraband heater increases.

Specially treated rust-resistant steel sheath casing provides the best combination of physical strength, high emissivity and good thermal conductivity to heated cylindrical parts, good for sheath temperatures up to 900°F (480°C).

Specially selected grade and thickness of mica sheet is used to insulate the windings, providing excellent thermal conductivity and dielectric strength.

The gauge of nickel-chrome resistance ribbon wire is selected to achieve the lowest internal element temperatures possible, resulting in maximum heater life. The ribbon wire is wound evenly spaced on a specially selected mica strip, providing even heat distribution and thus eliminating hot spotting that can cause premature heater failure.

Duraband’s Built-In Strap is a unique design feature developed and patented by Tempco. A Low Thermal Expansion alloy sheath is used for the outer sheath, covering the entire width of the band heater.

*U.S. Patent #3829657

View Product Inventory @ www.tempco.com
Band Heaters

Typical Applications

➻ Plastic Injection Molding Machines
➻ Plastic Extruders
➻ Oil Reclamation Equipment
➻ Food and Candy Extruders
➻ Drum Heating
➻ Extrusion Dies
➻ Holding Tanks
➻ Blow Molding Machines
➻ Vending Machines
➻ Barrels & Heads
➻ Food Service Warming
➻ Autoclaves & Sterilizers
➻ Metallurgical Analyzers
➻ Fluidized Beds
➻ Hot Runner Molds
➻ Pulp and Paper Processing Equipment

Designed For Trouble-Free Service

Tempco’s Duraband heater design is the result of many years of research, development and testing for a reliable mica insulated band heater that can perform at the higher operating temperatures [up to 900°F (480°C)] essential to process high temperature resins, providing long, efficient service necessary for today’s high productivity of plastic extruders, injection and blow molding machines.

Duraband is a proven heater design for good life efficiency and dependability. It assures maintaining the lowest winding temperatures possible, keeping a low-mass heating element assembly for fast heat-up and quick thermal response to controls. It incorporates the Low Thermal Expansion Built-In Strap, a unique design feature originally developed and patented by Tempco.

Advantages and Variations

Duraband mica insulated heaters are widely used on operations involving heating of cylindrical surfaces and are manufactured in a full range of standard construction variations, physical dimensions, electrical ratings, and a complete arrangement of screw terminals and lead terminations. (See pages 1-36 through 1-41).

However, these standard Duraband heater variations and terminations do not represent the full extent of our capabilities. Tempco’s engineering staff, with many years of experience in heat processing and temperature control applications, can assist you in designing the right Duraband heater for your specific application.

Construction Characteristics & Features

✴ Built-in bracket for superior clamping
✴ Unbreakable and torque-resistant screw terminals
✴ Temperatures up to 900°F (480°C)
✴ Full width stainless steel built-in strap
✴ Flexibility to incorporate holes and cutouts
✴ Available two-piece and expandable designs
✴ Best mica insulated heater on the market
✴ Faster delivery than any other type of heater band
✴ Most economical among various heater bands
✴ Most versatile and commonly used heater band

makes handling and installation easier!
**Band Heaters**

**Duraband Specifications**

**Duraband® Standard Specifications and Tolerances**

**PERFORMANCE RATINGS**

- **Maximum Temperature:** Standard Sheath: 900°F (482°C)
- **Nominal Watt Density:** 20-45 W/in² (3-7 W/cm²)
- **Maximum Watt Density:** Dependent on heater size and operating temperature.

**ELECTRICAL RATINGS**

- **Maximum Voltage:** 480 VAC
- **Dual Voltage or 3-Phase:** Available depending on heater design
- **Maximum Amperage:** lead wire termination: 10 amp screw terminations: 8-32UNF – 20 amp; 10-32UNF – 25 amp
- **Resistance Tolerance:** +10%, –5%
- **Wattage Tolerance:** +5%, –10%

Exposed electrical wiring on band heater installations is a violation of Electrical Safety Codes including O.S.H.A.

**PHYSICAL SIZE CONSTRUCTION LIMITATIONS**

- **Minimum Width:** 3/4" (19.1 mm)
- **Width Tolerance:** ±1/16" (1.59 mm)
- **Minimum Inside Diameter:** 7/8" (22.1 mm)
- **Nominal Gap:** 3/8" (9.5 mm)—If a larger gap is required for probes or thermocouples, specify when ordering.

**BUILT-IN BRACKETS**

<table>
<thead>
<tr>
<th>Heater Width</th>
<th>Number of Brackets</th>
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</thead>
<tbody>
<tr>
<td>1-1/2&quot; to 3&quot; (38-76 mm)</td>
<td>1</td>
</tr>
<tr>
<td>3-1/8&quot; to 5&quot; (79-127 mm)</td>
<td>2</td>
</tr>
<tr>
<td>5-1/8&quot; to 6-7/8&quot; (130-145 mm)</td>
<td>3</td>
</tr>
<tr>
<td>7&quot; to 10&quot; (178-254 mm)</td>
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</tr>
<tr>
<td>10-1/8&quot; to 15&quot; (257-381 mm)</td>
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</table>

*If tighter tolerances are required, consult Tempco.*

---

**Minimum ID and Width for Construction/Clamping Styles**

<table>
<thead>
<tr>
<th>Style</th>
<th>Min. ID</th>
<th>Min. Width</th>
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<td></td>
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<tr>
<td>NB</td>
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<tr>
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<td>76.2</td>
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</tr>
<tr>
<td>RNS</td>
<td>10</td>
<td>254</td>
</tr>
</tbody>
</table>

**Note:** Refer to individual descriptions for further information. Actual heater minimums will be a combination of termination and construction/strap styles.
Duraband® Maximum Watt Densities

The chart displays the maximum Watt Density curves for various diameter heaters. Use this chart when determining the appropriate wattage value for your chosen heater.

Be aware that certain factors will require you to derate the watt density (W/in²) of your heater selection.

Failure to adhere to the maximum allowable watt density per heater size will result in poor operating life.

**Maximum Allowable Watt Density**

**Calculating Maximum Watt Density**

**Factors to be taken into consideration**

A. Type of controls
B. Voltage variations
C. Machine cycling rate
D. Type of resin being processed
E. Coefficient of thermal expansion and conductivity of the cylinder
F. Designing a heater that closely matches the wattage requirement will decrease the frequency of cycling and temperature overshoot, thereby increasing the life of the heater.

**Correction Factors**

For heaters wider than 3" (76.2 mm), reduce maximum recommended watt density from chart by 20%.

For applications using insulating shroud, reduce maximum recommended watt density from chart by 25%.

**Once these factors have been established, proceed with the following steps:**

1. Determine the maximum operating temperature.
2. Calculate the total wattage required to obtain the maximum operating temperature. (See engineering section.)
3. Determine the size and number of the heater bands to be used. 1-1/2" through 3" wide band heaters have proven to be the most efficient and reliable in most cylindrical heating applications.
4. Determine individual band heater wattage by dividing the total required wattage by the quantity of band heaters selected.
5. Determine the band heater watt density by subtracting unheated areas from the band heater diameter created by screw terminals, gaps, holes, and cutouts (see formula below).
6. Determine if the required watt density previously calculated exceeds the maximum recommended watt density. Note the maximum cylinder temperature required on the left-hand side of the graph, follow the horizontal line until it intersects with the line of the band heater being used, and read directly down to obtain the maximum recommended watt density (W/in²).
7. If the calculated watt density is higher than the recommended value, it must be corrected or it will cause poor heater life. This can be accomplished by using more band heaters, lowering the heater wattage, or using a different construction type or a different type of band heater.
8. Should you have a problem in selecting the proper band heater or establishing watt density for your application, consult with one of the qualified engineers at Tempco.

**Watt Density Formula**

\[
\text{Watt Density (W/in}^2\text{)} = \frac{\text{Wattage}}{(3.14 \times \text{(Band ID)} - \text{Gap-1-3/8}) \times \text{Band Width} - \text{Unheated Area (see table)}}
\]

\[
\text{Unheated Area (See Table)} = \text{Unheated area for construction style + unheated area for any holes or cutouts}
\]
**Construction Styles**

**Duraband® Construction Styles**

### CONSTRUCTION TYPES

**One-Piece Band**

The one-piece construction is available on any screw or lead termination and clamping variation. It can be used where band heaters can be slipped over the end of the cylinder.

![One-Piece Band](image)

*Shown with Type NB Built-In Strap*

**Two-Piece Band**

The Two-Piece construction is available on any screw or lead and clamping variation. The Duraband two-piece design provides a built-in hinge, making handling and installation easier. It is used on large cylinders or where the heater cannot be slipped over the end of the cylinder. Two-piece band heaters are rated at watts and volts per each half when ordering.

**Note:** Multiple segment designs are recommended on larger diameter (typically larger than 15") heaters to improve the clamping force and increase the surface contact between the heater and the barrel for efficient heat transfer.

![Two-Piece Band](image)

*Shown with Type NS Built-In Strap*

**One-Piece Expandable Band**

The one-piece expandable construction is available on any screw or lead and clamping variation. It can be used where a one-piece band heater would have to be expanded to fit over the barrel during installation, rather than slipped over the end of the barrel.

**Note:** The One-Piece Expandable Band should not be opened and closed more than twice.

![One-Piece Expandable Band](image)

*Shown with Type NE Built-In Strap*
Standard Built-In Strap Clamping (Low Thermal Expansion)

The Built-In Strap is available with any screw or lead termination and construction variation. The Built-In Strap eliminates the use of awkward-to-handle separate straps, providing more drawing power than any other type of clamping system. The Duraband with Built-In Strap is standard on many designs.
Consult Tempco for multiple segment heaters.

Type NB—One-Piece Band
Min. ID: 2" (50.8 mm)
Min. Width: 1-1/4" (31.8 mm)

Type NS—Two-Piece Band
Min. ID: 3" (76.2 mm)
Min. Width: 1-1/4" (31.8 mm)

Type NE—One-Piece Expandable Band
Min. ID: 2-1/2" (63.5 mm)
Min. Width: 1-1/4" (31.8 mm)

Wedge Lock

Wedge Lock clamping is designed for applications where mounting space is severely limited. It lends itself mainly to small diameter nozzle heaters.

Type TWL—One-Piece Band
Min. ID: 1" (25.4 mm)
Min. Width: 1" (25.4 mm)
Max. Width: 3-1/2" (88.9 mm)

Separate Straps

The Separate Strap clamping is available with any screw or lead termination and construction variation. It is strongly recommended that the Duraband with Built-In Strap design be used whenever possible because it provides more drawing power than any other type of clamping system.
Consult Tempco for multiple segment heaters.

Type SB—One-Piece Band
Min. ID: 7/8" (22.2 mm)
Min. Width: 3/4" (19.1 mm)

Type SS—Two-Piece Band
Min. ID: 2" (50.8 mm)
Min. Width: 3/4" (19.1 mm)

Type SE—One-Piece Expandable Band
Min. ID: 2-1/2" (63.5 mm)
Min. Width: 1-1/4" (31.8 mm)

Clearance Dimensions for Separate Strap Clamping

Separate strap clearance dimensions are dependent on heater ID. The strap dimensions are shown below.

< 2" ID — 6-32 Screw
2 to 3-1/2" ID — 8-32 Screw
> 3-1/2" ID — 1/4-20 Screw

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Band Heaters

Construction/Clamping Variations

**Duraband® Construction/Clamping Variations**

**Spring Loaded with Built-In Bracket**

The Heavy Duty Stainless Steel Spring with Built-In Bracket is a variation on the basic Duraband design. It is available with any screw or lead termination and construction variation. It is recommended for heaters over 12" in diameter, and for any diameter heater used in the vertical position, to prevent the heater from slipping off the machine. The springs provide constant tension, therefore maintaining optimum surface contact against the cylinder being heated. Consult Tempco for multiple segment heaters.

**Latch and Trunnion**

The Latch and Trunnion Clamping System is available with any screw or lead termination and construction variation. It is ideal in absorbing thermal expansion due to the spring loading on the screws. The latch fully opens, facilitating installation on large diameter cylinders. The outer sheath is made from a Low Thermal Expansion alloy.

Consult Tempco for multiple segment heaters.

**Bent-Up Flange (Ears)**

The Bent-Up Flange clamping is available with any screw or lead termination and construction variation. The outer sheath is made from a Low Thermal Expansion alloy. The Bent-Up Flange design is best suited for narrow band heaters with small diameters.

**Note:** The Bent-Up flange design should only be used when other clamping methods are not suitable for a specific application. Tempco recommends Built-In Strap Clamping be used whenever possible, especially on large diameter heaters, because it provides superior clamping power.

**Type SL—One-Piece Band**

- Min. ID: 4" (101.6 mm)
- Min. Width: 1-1/4" (31.8 mm)

**Type NSL—Two-Piece Band**

- Min. ID: 4" (101.6 mm)
- Min. Width: 1-1/4" (31.8 mm)

**Type NEL—One-Piece Expandable Band**

- Min. ID: 4" (101.6 mm)
- Min. Width: 1-1/4" (31.8 mm)

**Type LT—One-Piece Band**

- Min. ID: 7" (177.8 mm)
- Min. Width: 1-1/2" (38.1 mm)

**Type LS—Two-Piece Band**

- Min. ID: 7" (177.8 mm)
- Min. Width: 1-1/2" (38.1 mm)

**Type LE—One-Piece Expandable Band**

- Min. ID: 7" (177.8 mm)
- Min. Width: 1-1/2" (38.1 mm)

**Type FB—One-Piece Band**

- Min. ID: 1" (25.4 mm)
- Min. Width: 3/4" (19.1 mm)

**Type FS—Two-Piece Band**

- Min. ID: 2" (50.8 mm)
- Min. Width: 3/4" (19.1 mm)

**Type FE—One-Piece Expandable Band**

- Min. ID: 2-1/2" (63.5 mm)
- Min. Width: 1-1/4" (31.8 mm)
**Type RN** — Internal Reverse Band (with bracket clamping)

This construction style is used to heat cylindrical surfaces from the inside on heaters 5-1/2" diameter and larger.

**Type RNB — Reverse 1-Piece Construction**
- **ID:** 5-1/2" (139.7 mm) to 10" (254.0 mm)
- **Width:** 1" (25.4 mm) to 3-1/2" (88.9 mm)
- **Maximum Voltage:** 240VAC

**Type RNS — Reverse 2-Piece Construction**
- **ID:** 10" (254.0 mm) to 20" (508.0 mm)
- **Width:** 1" (25.4 mm) to 3-1/2" (88.9 mm)
- **Maximum Voltage:** 240VAC

For IDs greater than 20", consult Tempco with your requirements.

**Duraband Partial Coverage**

**Type NS — 2-Piece With Built-In Brackets**

Partial coverage band heaters are normally required when holes and cutouts will not allow the heater to sufficiently clear the machine obstructions. The preferred method of construction is the Two-Piece Band Heater with Built-In Brackets as illustrated. The heater is screwed down to the cylinder at the ends and the built-in Low Thermal Expansion Strap pulls the heater tightly against the cylinder being heated. The standard center of hole to edge of heater dimension is 1/4". When ordering, please provide the angle of coverage from center to center of the mounting screw holes as shown.

**Type PS — One-Piece with Two-Piece Separate Strap with Padded Ends**

The alternate method of partial coverage construction is the One-Piece Band Heater with a separate Two-Piece Strap. The two-piece strap itself is screwed down at the padded ends, allowing the heater to float between the pads as illustrated. When the strap is tightened, it will pull the heater against the cylinder being heated. The standard center of hole to edge of heater dimension is 1/4". When ordering, please provide the angle of coverage from center to center of the mounting screw holes as shown.

**Type NB — One-Piece with Built-In Strap Clamping**

Another alternate method of partial coverage construction. The one piece with clamp screws on both sides allows it to be secured to anchor points on either side of a barrel without drilling holes into the barrel.

**Type RTWL — Internal Reverse Band (with wedge lock clamping)**

This construction style is used to heat cylindrical surfaces from the inside on heaters less than 5" outside diameter.
- **ID:** Less than 5-1/2" (139.7 mm)
- **Width:** 1" to 3-1/2" (25.4 - 88.9 mm)
**Stainless Steel Power Terminals: Type T1, Type T2 & Type T3**

Available on any clamping or construction variation, the specially designed Stainless Steel Power Terminals are internally connected to the heater and are resistant to over-torquing. The screw terminals are virtually unbreakable. Secure tightening of the electrical connections is essential for safety and long heater life.

**Duraband® Type T1 – Screw Terminals**

**One-Piece Band**

**Standard Termination Location:**

- each side of gap; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 7/8” (22.2 mm)
- **Post Terminals:** 10-32 standard except 8-32 on < 1” wide heaters & heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32)

**Two-Piece Band**

**Standard Termination Location:**

- next to gaps on each half; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 7/8” (22.2 mm)
- **Post Terminals:** 10-32 standard except 8-32 on < 1” wide heaters & heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32) each half

**Duraband Type T2 – Screw Terminals**

**One-Piece Band**

**Standard Termination Location:**

- next to gap; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 7/8” (22.2 mm)
- **Post Terminals:** 10-32 standard except 8-32 on < 1” wide heaters & heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32)

**Two-Piece Band**

**Standard Termination Location:**

- next to same gap on each half; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 7/8” (22.2 mm)
- **Post Terminals:** 10-32 standard except 8-32 on < 1” wide heaters & heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32) each half

**One-Piece Expandable Band**

**Standard Termination Location:**

- next to gap; center of width

- **Minimum Inside Diameter:** 2-1/2” (63.5 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Post Terminals:** 10-32 standard except 8-32 on heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32)

**One-Piece Expandable Band**

**Standard Termination Location:**

- next to gap; center of width

- **Minimum Inside Diameter:** 2-1/2” (63.5 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Post Terminals:** 10-32 standard except 8-32 on heaters with ID < 3”
- **Max. Volts/Amps:** 480VAC/25A (10-32) or 20A (8-32)

Recommended for narrow band heaters where screw terminals are preferred or the C2 terminal box protection is required.

Considered standard on most band heaters unless otherwise specified.
The preferred design on band heaters over 3” (76.2 mm) wide or when C3 terminal box is required.

One-Piece Band

Standard Termination Location: next to gap; across center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 2" (50.8 mm)
- Post Terminals: 10-32 standard except 8-32 on 2" to 2-1/2" wide heaters & heaters with ID < 3"
- Max. Volts/Amps: 480VAC/25A (10-32) or 20A (8-32)

Two-Piece Band

Standard Termination Location: next to same gap on each half; across center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 2" (50.8 mm)
- Post Terminals: 10-32 standard except 8-32 on 2" to 2-1/2" wide heaters & heaters with ID < 3"
- Max. Volts/Amps: 480VAC/25A (10-32) or 20A (8-32) each half

Three types of Igloo™ bases are available:
- Type C6 – Double Port In-Line P/N CER-101-104
- Type C7 – Double Port 90° P/N CER-101-106
- Type C8 – Single Port P/N CER-101-107

Igloo™ caps are available in the following three screw terminal sizes:
- 10-32 – P/N CER-102-101
- 10-24 – P/N CER-102-104
- 8-32 – P/N CER-102-105

When ordering, specify the type of Igloo and the screw terminal size.

Exposed electrical wiring on band heater installations is a violation of Electrical Safety Codes including OSHA.
Low-Profile Button Terminals: Type B1, Type B2 & Type B3

Available on any clamping or construction variation, the specially designed Stainless Steel Button Terminals are internally connected to the heater and are resistant to over-torquing while offering a low profile for tight spaces. They are virtually unbreakable. Secure tightening of the electrical connections is essential for safety and long heater life.

**Duraband® Type B1 – Button Terminals**

![Duraband Type B1](image)

**One-Piece Band**

**Standard Termination Location:**
- each side of gap; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC / 25A (10-32) or 20A (6-32)

**Two-Piece Band**

**Standard Termination Location:**
- next to gaps on each half; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC / 25A (10-32) or 20A (6-32)

**One-Piece Expandable Band**

**Standard Termination Location:**
- each side of gap; center of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC / 25A (10-32) or 20A (6-32)

**Duraband Type B2 – Button Terminals**

![Duraband Type B2](image)

**One-Piece Band**

**Standard Termination Location:**
- next to gap; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts: 480VAC
- Maximum Amps: 25A (10-32) or 20A (6-32)

**Two-Piece Band**

**Standard Termination Location:**
- next to same gap on each half; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC / 25A (10-32) or 20A (6-32)

**One-Piece Expandable Band**

**Standard Termination Location:**
- next to gap; center of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/2" (38.1 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC / 25A (10-32) or 20A (6-32)
**Duraband® Type B3 – Button Terminals**

**One-Piece Band**

**Standard** Termination Location:
next to gap; across center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 2-3/8" (60.3 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts: 480VAC
- Maximum Amps: 25A (10-32) or 20A (6-32)

---

**Two-Piece Band**

**Standard** Termination Location:
next to same gap on each half; across center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 2-3/8" (60.3 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC/25A (10-32) or 20A (6-32) each half

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**One-Piece Expandable Band**

**Standard** Termination Location:
next to gap; across center of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 2-3/8" (60.3 mm)
- Screw Size: 10-32 standard except 6-32 on IDs < 5"
- Maximum Volts/Amps: 480VAC/25A (10-32) or 20A (6-32)

---

**Plain Lead Wire Terminations: Type L1, Type L2 & Type L4**

Available on any clamping or construction variation.

**Duraband Type L1 – Straight Lead Wires**

The lead wires exit through a brass eyelet. The standard flexible leads are 10" long with 3" of fiberglass sleeving. If longer leads are required, specify when ordering.

**Two-Piece Band**

**Standard** Termination Location:
next to same gap on each half; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A each half

---

**One-Piece Expandable Band**

**Standard** Termination Location:
next to gap; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

---

CONTINUED
L2 is the preferred termination on all small diameter and small width band heaters. The standard flexible leads are 10" long with 3" of fiberglass sleeving. If longer leads are required, specify when ordering.

**Duraband® Type L2 – Lead Wires**

**One-Piece Band**

*Standard Termination Location:*

- each side of gap; edge of width

- Minimum Inside Diameter: 7/8" (22.2 mm)
- Minimum Width: 3/4" (19.1 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

**Two-Piece Band**

*Standard Termination Location:*

- each side of each gap; edge of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 3/4" (19.1 mm)
- Maximum Volts: 480V each half
- Maximum Amps: 10A each half

**One-Piece Expandable Band**

*Standard Termination Location:*

- each side of gap; edge of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/4" (31.8 mm)
- Maximum Volts: 480V
- Maximum Amps: 10A

L4 is a suitable lead termination for small band heaters. The standard flexible leads are 10" long with 3" of fiberglass sleeving. If longer leads are required, specify when ordering.

**Duraband Type L4 – Lead Wires**

**One-Piece Band**

*Standard Termination Location:*

- same side of gap; edge of width

- Minimum Inside Diameter: 7/8" (22.2 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

**Two-Piece Band**

*Standard Termination Location:*

- each side of same gap; center of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480V each half
- Maximum Amps: 10A each half

**One-Piece Expandable Band**

*Standard Termination Location:*

- same side of gap; edge of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/4" (31.8 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

View Product Inventory @ www.tempco.com
Abrasion Resistant Lead Terminations:
Type W1, Type W2, Type W2M, Type W3, Type W4 & Type W5M

Available on any clamping or construction variation. Wire braid leads offer sharp bending not possible with armor cable.

**Duraband® Type W1 & W1T – Straight Wire Braid Leads**

**Type W1** — Braided lead wire crimped in place for heaters under 2-1/2” I.D. and/or under 1-1/4” width.

**Type W1T** — Braided lead wire attached with a threaded fitting for heaters over/equal 2-1/2” I.D. and over/equal 1-1/4” width.

**One-Piece Band**

*Standard Termination Location:*
  next to gap; center of width

- Minimum Inside Diameter: 2” (50.8 mm)
- Minimum Width: 1” (25.4 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

The standard leads are 10” of wire braid over 12” of flexible leads.

*If longer leads are required, specify when ordering.*

**Two-Piece Band**

*Standard Termination Location:*
  next to same gap on each half; center of width

- Minimum Inside Diameter: 2” (50.8 mm)
- Minimum Width: 1” (25.4 mm)
- Maximum Volts: 480VAC each half
- Maximum Amps: 10A each half

**One-Piece Expandable Band**

*Standard Termination Location:*
  next to gap; center of width

- Minimum Inside Diameter: 2-1/2” (63.5 mm)
- Minimum Width: 1-1/4” (31.8 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

The W2 wire braid exits at 180° from the gap for special nozzle heating applications. Sleeving is used for additional protection. The standard leads are 10” of wire braid over 12” of flexible leads with 3” of fiberglass sleeving.

*'mber leads are required, specify when ordering.*

**Duraband Type W2 – Wire Braid Leads**

**One-Piece Band**

*Standard Termination Location:*
  opposite the gap; edge of width

- Minimum Inside Diameter: 7/8” (22.2 mm)
- Minimum Width: 1-1/8” (28.6 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

**Note:** Type W2 is not available on Two-Piece or One-Piece Expandable Duraband Heaters

(800) 323-6859 • Email: sales@tempco.com
Duraband® Type W3 – Single Wire Braid Leads

Highly recommended for nozzle heating applications. The standard leads are 10" of wire braid over 12" of flexible leads with 3" of fiberglass sleeving.

If longer leads are required, specify when ordering.

One-Piece Band
Standard Termination Location: each side of gap; edge of width

- Minimum Inside Diameter: 3/4" (19.1 mm)
- Minimum Width: 7/8" (22.2 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

Two-Piece Band
Standard Termination Location: each side of each gap; edge of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 3/4" (19.1 mm)
- Maximum Volts: 480VAC each half
- Maximum Amps: 10A each half

One-Piece Expandable Band
Standard Termination Location: each side of gap; edge of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/4" (31.8 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

Duraband Type W4 – Wire Braid Leads On One Side

A suitable termination for nozzle heating applications. The standard leads are 10" of wire braid over 12" of flexible leads.

If longer leads are required, specify when ordering.

One-Piece Band
Standard Termination Location: next to gap; edge of width

- Minimum Inside Diameter: 7/8" (22.2 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

Two-Piece Band
Standard Termination Location: next to same gap on each half; edge of width

- Minimum Inside Diameter: 2" (50.8 mm)
- Minimum Width: 1" (25.4 mm)
- Maximum Volts: 480VAC each half
- Maximum Amps: 10A each half

One-Piece Expandable Band
Standard Termination Location: next to gap; edge of width

- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 1-1/4" (31.8 mm)
- Maximum Volts: 480VAC
- Maximum Amps: 10A

View Product Inventory @ www.tempco.com
**Duraband® Type W2M – Right-Angle Wire Braid Leads, 90° to Heater**

Stainless Steel Wire Braid exits perpendicular to the heater centerline through a low profile stainless steel cap. This cap acts as a strain relief which protects against excessive flexing or pulling of the lead wire. The standard leads are 10” of wire braid over 12” of flexible leads. **If longer leads are required, specify when ordering.**

**Notes:** Stainless steel construction may be required for widths of 7/8” (22.2 mm) to 1-5/8” (41.3 mm).

### One-Piece Band

**Standard** Termination Location: opposite of gap; center of width

- **Minimum Inside Diameter:** 1-1/2” (38.1 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC
- **Maximum Amps:** 10A

### Two-Piece Band

**Standard** Termination Location: next to same gap on each half; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC each half
- **Maximum Amps:** 10A each half

### One-Piece Expandable Band

**Standard** Termination Location: next to gap; center of width

- **Minimum Inside Diameter:** 2-1/2” (63.5 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC
- **Maximum Amps:** 10A

**Duraband Type W5M – Right-Angle Wire Braid Leads, Parallel to Heater**

Stainless Steel Wire Braid exits parallel to the heater centerline through a low profile stainless steel cap. This cap acts as a strain relief which protects against excessive flexing or pulling of the lead wire. The standard leads are 10” of wire braid over 12” of flexible leads. **If longer leads are required, specify when ordering.**

**Notes:** Stainless steel construction may be required for widths of 7/8” (22.2 mm) to 1-5/8” (41.3 mm).

### One-Piece Band

**Standard** Termination Location: opposite of gap; center of width

- **Minimum Inside Diameter:** 1-1/2” (38.1 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC
- **Maximum Amps:** 10A

### Two-Piece Band

**Standard** Termination Location: next to same gap on each side; center of width

- **Minimum Inside Diameter:** 2” (50.8 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC each half
- **Maximum Amps:** 10A each half

### One-Piece Expandable Band

**Standard** Termination Location: next to gap; center of width

- **Minimum Inside Diameter:** 2-1/2” (63.5 mm)
- **Minimum Width:** 1-1/4” (31.8 mm)
- **Maximum Volts:** 480VAC
- **Maximum Amps:** 10A
**Band Heaters**

**Terminations**

**Armor Cable Terminations: Type R1, Type R2 & Type R3**

Available on any clamping or construction variation. Armor cable provides far superior protection to lead wires where abrasion is a constant problem. The standard leads are 10" of armor cable over 12" of flexible leads.

*If longer leads are required, specify when ordering.*

**Duraband® Type R1 – Straight Armor Cable**

- **Type R1A** — Galvanized armor cable crimped in place for heaters under 2-1/2" I.D. and/or under 1-1/4" width.
- **Type R1AT** — Galvanized armor cable attached with a threaded fitting for heaters over/equal 2-1/2" I.D. and over/equal 1-1/4" width.
- **Type R1B** — Stainless Steel armor cable crimped in place for heaters under 2-1/2" I.D. and/or under 1-1/4" width.

**Type R1BT** — Stainless Steel armor cable attached with a threaded fitting for heaters over/equal 2-1/2" I.D. and over/equal 1-1/4" width.

**Type R1C** — Galvanized armor cable, tack welded

**Type R1D** — SS armor cable, tack welded

**Type R1E** — Galvanized armor cable, full silver brazing

**Type R1F** — SS armor cable, full silver brazing

- **One-Piece Band**
  - **Standard Termination Location:**
    - next to gap; center of width
  - Minimum Inside Diameter: 1-1/2" (38.1 mm)
  - Minimum Width: 1" (25.4 mm)
  - Maximum Volts: 480VAC
  - Maximum Amps: 10A

- **Two-Piece Band**
  - **Standard Termination Location:**
    - next to same gap on each half; center of width
  - Minimum Inside Diameter: 2" (50.8 mm)
  - Minimum Width: 1" (25.4 mm)
  - Maximum Volts/Amps: 480VAC/10A each half

- **One-Piece Expandable Band**
  - **Standard Termination Location:**
    - next to gap; center of width
  - Minimum Inside Diameter: 2-1/2" (63.5 mm)
  - Minimum Width: 1-1/4" (31.8 mm)
  - Maximum Volts/Amps: 480VAC/10A

**Duraband Type R2 – Right-Angle Armor Cable**

- **Type R2A** — Galvanized armor cable, crimped
- **Type R2B** — SS armor cable, crimped
- **Type R2C** — Plain leads, no cable

- **One-Piece Band**
  - **Standard Termination Location:**
    - next to gap; center of width
  - Minimum Inside Diameter: 1-1/2" (38.1 mm)
  - Minimum Width: 1-1/4" (31.8 mm)
  - Maximum Volts: 480VAC
  - Maximum Amps: 10A

- **Two-Piece Band**
  - **Standard Termination Location:**
    - next to same gap on each half; center of width
  - Minimum Inside Diameter: 2" (50.8 mm)
  - Minimum Width: 1-1/4" (31.8 mm)
  - Maximum Volts/Amps: 480VAC/10A each half

- **One-Piece Expandable Band**
  - **Standard Termination Location:**
    - next to gap; center of width
  - Minimum Inside Diameter: 2-1/2" (63.5 mm)
  - Minimum Width: 1-1/4" (31.8 mm)
  - Maximum Volts/Amps: 480VAC/10A

**View Product Inventory @ www.tempco.com**
One-Piece Band

**Standard** Termination Location:
next to gap; center of width

✻ Minimum Inside Diameter:
2" (50.8 mm)
✻ Minimum Width:
1-1/4" (31.7 mm)
✻ Maximum Volts/Amps:
480VAC/10A

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Two-Piece Band

**Standard** Termination Location:
next to same gap on each half; center of width

※ Minimum Inside Diameter:
2" (50.8 mm)
※ Minimum Width:
1-1/4" (31.7 mm)
※ Maximum Volts/Amps:
480VAC/10A each half

---

One-Piece Expandable Band

**Standard** Termination Location:
next to gap; center of width

※ Minimum Inside Diameter:
2-1/2" (63.5 mm)
※ Minimum Width:
1-1/4" (31.8 mm)
※ Maximum Volts/Amps:
480VAC/10A

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**Duraband Type S1 – Lead Wire Spring Strain Relief**

A strain relief spring is attached to the heater at the termination exit to reduce strain on leads subjected to excessive flexing. The spring is 2-1/8" long. The flexible standard leads are 10" long with 3" of fiberglass sleeving. **If longer leads are required, specify when ordering.**

**Type S1A** — Plain Leads and Strain Relief Spring crimped in place for heaters under 2-1/2" I.D. and/or under 1-1/4" width.

**Type S1AT** — Plain Leads and Strain Relief Spring attached with a threaded fitting for heaters over/equal 2-1/2" I.D. and over/equal 1-1/4" width.

**Type S1B** — Stainless Steel Wire Braided Leads and Strain Relief Spring crimped in place for heaters under 2-1/2" I.D. and/or under 1-1/4" width

10" of braid over 12° of flexible leads is standard.

**Type S1BT** — Stainless Steel Wire Braided Leads and Strain Relief Spring attached with a threaded fitting for heaters over/equal 2-1/2" I.D. and over/equal 1-1/4" width.

10" of braid over 12° of flexible leads is standard.
Band Heaters

Terminations

**General Purpose Terminal Boxes: Type C2 and Type C5**

Available with any construction or clamping variation. They are a simple & economical way to protect employees from electric shock or prevent electric shorts that can result from exposed wiring on band heater electrical installations.

The Heavy Duty Terminal Boxes have 1/2" knockouts that will accept standard armor cable connectors. They can be field assembled on band heaters that have a center distance between terminal screws of 7/8". Boxes can be pre-wired with galvanized armor, stainless steel armor, wire braid or plain leads. If a Low Profile Box with cable or leads is required, it is strongly recommended to order it pre-wired by the factory.

The standard leads are 10" of cable or wire braid over 12" of flexible leads. *If longer leads are required, specify when ordering.*

<table>
<thead>
<tr>
<th>Type C2 — Standard Terminal Boxes</th>
<th>Type C5 — Low Profile Terminal Boxes</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>One-Piece Band</strong></td>
<td><strong>One-Piece Expandable Band</strong></td>
</tr>
<tr>
<td>Standard Terminal Location:</td>
<td>Standard Terminal Location:</td>
</tr>
<tr>
<td>next to gap; center of width</td>
<td>next to gap; center of width</td>
</tr>
<tr>
<td><em>Minimum Inside Diameter:</em> 2-1/2&quot; (63.5 mm)</td>
<td><em>Minimum Inside Diameter:</em> 2-1/2&quot; (63.5 mm)</td>
</tr>
<tr>
<td><em>Minimum Width:</em> 1&quot; (25.4 mm)</td>
<td><em>Minimum Width:</em> 1&quot; (25.4 mm)</td>
</tr>
<tr>
<td>Heater widths between 1&quot; and 2-1/2&quot; require a minimum ID of 5-1/2&quot; or greater.</td>
<td>Heater widths between 1&quot; and 2-1/2&quot; require a minimum ID of 5-1/2&quot; or greater.</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Two-Piece Band</strong></td>
<td><strong>One-Piece Expandable Band</strong></td>
</tr>
<tr>
<td>Standard Terminal Location:</td>
<td>Standard Terminal Location:</td>
</tr>
<tr>
<td>next to same gap on each half; center of width</td>
<td>next to gap; center of width</td>
</tr>
<tr>
<td><em>Minimum Inside Diameter:</em> 3&quot; (76.2 mm)</td>
<td><em>Minimum Inside Diameter:</em> 2-1/2&quot; (63.5 mm)</td>
</tr>
<tr>
<td><em>Minimum Width:</em> 1&quot; (25.4 mm)</td>
<td><em>Minimum Width:</em> 1&quot; (25.4 mm)</td>
</tr>
<tr>
<td>Heater widths between 1&quot; and 2-1/2&quot; require a minimum ID of 5-1/2&quot; or greater.</td>
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</tr>
</tbody>
</table>

**Duraband® Type C2 — Standard Terminal Boxes**

**Duraband Type C5 — Low Profile Terminal Boxes**

**Type C2** — Standard Box
- C2A — Box only
- C2B — w/galvanized armor
- C2C — w/stainless steel armor
- C2D — w/wire braid

**Type C5** — Low Profile Box
- C5A — box only
- C5B — w/galvanized armor
- C5C — w/SS armor
- C5D — w/wire braid
- C5J — w/plain leads

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Rev 1 (6-21-2016)
Available on any construction or clamping variation. These plug assemblies are highly recommended and should be used whenever possible. The combination of plug & cup assembly along with armor cable covered leads eliminates all live exposed terminals or wiring that can be a potential hazard to employees or machinery.

Type P1 and P3 assemblies are available with a straight or right-angle plug. Type P2 and P4 plug assemblies have a lower profile and are available with a straight plug only.

To simplify installation, band heaters with these assemblies can be supplied pre-wired, using high temperature lead wires. The standard leads are 10" of armor cable over 12' of flexible leads. If longer leads are required, specify when ordering.

**Type P1**

- **P1K** – Cup assembly only
- **P1L** – w/straight plug only
- **P1M** – w/90° plug only
- **P1N** – w/str. plug & galvanized cable
- **P1O** – w/str. plug & SS cable
- **P1P** – w/str. plug & wire braid
- **P1Q** – w/90° plug & galvanized cable
- **P1R** – w/90° plug & SS cable
- **P1S** – w/90° plug & wire braid

**Plug Electrical Ratings**

- 2-Pole 3-Wire Grounding
- Maximum Volts: 250 VAC
- Maximum Amps: 16A
- Maximum Temperature: 572°F (300°C)

**One-Piece Band**

**Standard Termination Location:**
next to gap; center of width

- **Minimum Inside Diameter:** 2" (50.8 mm)
- **Minimum Width:** 1-1/2" (38.1 mm)
  - If width is between 1-1/2" and 2", minimum diameter is 5-1/2".
  - If width is greater than 2", minimum diameter is 2".

**Two-Piece Band**

**Standard Termination Location:**
next to same gap on each half; center of width

- **Minimum Inside Diameter:** 2" (50.8 mm)
- **Minimum Width:** 1-1/2" (38.1 mm)
  - If width is between 1-1/2" and 2", minimum diameter is 5-1/2".
  - If width is greater than 2", minimum diameter is 2".

**One-Piece Expandable Band**

**Standard Termination Location:**
next to gap; center of width

- **Minimum Inside Diameter:** 2-1/2" (63.5 mm)
- **Minimum Width:** 1-1/2" (38.1 mm)
  - If width is between 1-1/2" and 2", minimum diameter is 5-1/2".
  - If width is greater than 2", minimum diameter is 2".

CONTINUED
Band Heaters

Terminations

Duraband® Type P2 – High Temperature Quick Disconnect Plugs

Type P2 — Low Profile Assembly
P2F – Low profile assembly only
P2G – w/straight plug only
P2H – w/str. plug and galvanized cable
P2J – w/str. plug and SS cable
P2K – w/str. plug and wire braid

Two-Piece Band
Standard Termination Location:
next to gap; center of width

✻ Minimum Inside Diameter:
3" (76.2 mm)
✻ Minimum Width:
2-1/2" (63.5 mm)

One-Piece Band
Standard Termination Location:
next to gap; center of width

✻ Minimum Inside Diameter:
3" (76.2 mm)
✻ Minimum Width:
2-1/2" (63.5 mm)

Plug Electrical Ratings
✻ 2-Pole 3-Wire Grounding
✻ Maximum Volts: 250 VAC
✻ Maximum Amps: 16A
✻ Maximum Temperature: 572°F (300°C)

Duraband Type P3 – DIN 49458 A/B Quick Disconnect Plugs

One-Piece Band
Standard Termination Location:
next to gap; center of width

✻ Minimum Inside Diameter:
3" (76.2 mm)
✻ Minimum Width:
1-1/2" (38.1 mm)

Plug Electrical Ratings
✻ 2-Pole 3-Wire Grounding
✻ Maximum Volts: 250 VAC
✻ Maximum Amps: 16A
✻ Maximum Temperature: 392°F (200°C)

Standard Pin Orientation

Two-Piece Band
Standard Termination Location:
next to same gap on each half;
center of width

✻ Minimum Inside Diameter:
3" (76.2 mm)
✻ Minimum Width:
1-1/2" (38.1 mm)

One-Piece Expandable Band
Standard Termination Location:
next to gap; center of width

✻ Minimum Inside Diameter:
3" (76.2 mm)
✻ Minimum Width:
2-1/2" (63.5 mm)

Type P3 — Vertical Box Assembly
P3A – Box assembly only
P3B – Box assembly w/straight plug
P3C – Box assembly w/right-angle plug only

View Product Inventory @ www.tempco.com
**Band Heaters**

**Duraband® Type P4 – DIN 49458 A/B Quick Disconnect Plugs**

**Type P4® – Horizontal Box Assembly**
- **P4A** – Box assembly only
- **P4B** – Box assembly with straight plug

**Plug Electrical Ratings**
- 2-Pole 3-Wire Grounding
- Maximum Volts: 250 VAC
- Maximum Amps: 16A
- Maximum Temperature: 392°F (200°C)

**Standard Pin Orientation**

**One-Piece Band**
- **Standard Termination Location:**
  - next to gap; center of width
- Minimum Inside Diameter: 3" (76.2 mm)
- Minimum Width: 2-1/2" (63.5 mm)

**Two-Piece Band**
- **Standard Termination Location:**
  - next to same gap on each half; center of width
- Minimum Inside Diameter: 3" (76.2 mm)
- Minimum Width: 2-1/2" (63.5 mm)

**One-Piece Expandable Band**
- **Standard Termination Location:**
  - next to gap; center of width
- Minimum Inside Diameter: 2-1/2" (63.5 mm)
- Minimum Width: 3" (76.2 mm)

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Band Heaters

Construction Options and Variations

Special Duraband® Construction Options

Thermocouple Bayonet Adapter
A standard Bayonet Adapter facilitates the installation of an external thermocouple with a standard bayonet cap. The standard location for the adapter is 90° from the gap. Specify without through hole for heater sensing or with through hole for load sensing. For heaters less than 1" wide, order separate strap clamping and utilize the gap for the thermocouple.

Refer to pages 14-3 and 14-4 for a complete selection of thermocouples available from stock.

Holes and Cutouts
Holes and cutouts are normally required in band heaters for clearance for thermocouple probes or holding bolts. An oversize gap can in many cases serve the same purpose, saving the expense of the hole.

Using the center of the gap as a starting point, specify the location of the center-point of the hole or cutout in terms of degrees and the distance from the edge of the heater. In addition, state the size of the hole or cutout.

For critical hole and cutout locations, a detailed drawing will be required.

**Note:** A minimum of 1/2" is required from the hole to the edge of the heater.

Thermocouple Coupling
The Thermocouple Coupling facilitates the installation of an external thermocouple with a threaded fitting to sense the temperature of the band. The standard location for the coupling is 90° from the gap. Specify without through hole for heater sensing or with through hole for load sensing.

**Available Bushing Sizes:**

<table>
<thead>
<tr>
<th>Thread</th>
<th>D</th>
<th>H</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/8-27 NPT</td>
<td>9/16&quot;</td>
<td>5/8&quot;</td>
</tr>
<tr>
<td>1/4-18 NPT</td>
<td>3/4&quot;</td>
<td>11/16&quot;</td>
</tr>
<tr>
<td>3/8-18 NPT</td>
<td>7/8&quot;</td>
<td>5/8&quot;</td>
</tr>
<tr>
<td>M12–1.75 mm</td>
<td>3/4&quot;</td>
<td>1/2&quot;</td>
</tr>
</tbody>
</table>

Hinged Two-Piece Band
The Hinged Two-Piece Band Heater is connected with a continuous hinge for easy installation and removal. This heater can be opened and closed as often as is necessary. The preferred method of clamping is latch and trunnion. It is available with any screw or lead variation. When ordering, specify watts and volts each half.

**Minimum Width:** 1-3/8" (34.9 mm)

Special Mica Insulated Heater Construction Variations

Ring Heaters
When ordering Ring Heaters, specify inside and outside diameters. If mounting holes are required, specify location and hole size. For critical hole and cutout locations, a detailed drawing will be required.

View Product Inventory @ www.tempco.com
**Square or Rectangular** band heaters are normally used for heating dies on plastic extruders, or the barrels of twin screw extruders. They can be made in either one- or two-piece construction but two-piece construction with **Style 1 Clamping (see below)** is recommended.

**Square, Rectangular, or Hexagon Bands**

**Hexagon** shaped band heaters are used on the hex shaped portion of the nozzle on injection molding machines. These types of heaters are strictly made to customer specifications with bent-up flange clamping only.

**Clamping Styles** – Three clamping styles are used on square and rectangular band heaters:

- **Style 1 for 2-piece heaters**: bent-up flange clamping at the corners provides the most uniform clamping force and should be used whenever possible.

  **Maximum Recommended Watt Density**: 25 w/in²

- **Style 2 for 2-piece heaters**: bent-up flange clamping or built-in strap brackets at the sides requires a minimum “B” dimension of 3.75” (95.3 mm).

  **Maximum Recommended Watt Density**: 20 w/in²

- **Style 3 for 1-piece heaters**: bent-up flange clamping or built-in strap brackets at the sides requires a minimum “A” dimension of 3.75” (95.3 mm).

  **Maximum Recommended Watt Density**: 25 w/in²

**Ordering Information**

- Square, Rectangular or Hex
- Select Clamping Style 1, 2 or 3
- Specify inside dimensions – Square or Rectangular: “A” and “B”
  **Hexagon**: Specify internal dimension across flats
- Width: Minimum 3/4” (19.1 mm)
- Wattage: per half on two-piece heaters
- Voltage: per half on two-piece heaters
- Termination (see pages 1-32 through 1-45)
- Lead Cable/Braid Length
- Special Features (see page 1-46)
- Provide drawing or sample part when possible

**Cone Shapes**

Cone Shaped Heaters are normally used for special heating applications when heat is required for hoppers or funnels. They are made strictly to customer specifications. The preferred method of attachment is with built-in bracket clamping. When ordering or for quoting purposes, supply a detailed drawing or sample part. Include the top ID, bottom ID, and the vertical rise or heater width.

**WARNING**: Cancer and Reproductive Harm - www.P65Warnings.ca.gov.
Duraband Features

**Additional Duraband® Heater Features**

**Built-In Thermocouples**

Heaters can be manufactured with a Built-In Thermocouple to closely control the temperature of the heater.

Type J or K thermocouples are available with fiberglass, wire braid or any other required insulation.

Consult Tempco with your requirements.

**Construction Variations**

All Stainless Steel Construction

Mica band heaters can be constructed with the external sheath made entirely from stainless steel. This allows the Duraband to reach the maximum temperature of 1200°F (650°C). All Stainless Steel Construction is available on any clamping/construction or termination variation.

Other Sheath Materials

Other sheath materials, such as rust-resistant steel, Monel®, aluminum, or copper are also available for unique applications.

**Lead Variations**

**Terminal Lugs**

Various types of crimp terminals can be attached to the heater leads to make wiring into applications quick and easy. High temperature 1200°F (649°C) ring terminals and nylon or PVC insulated terminals are available. Spade, ring, and right-angle or straight quick disconnect type terminals can be attached to the leads.

**Electrical Variations**

Three-Phase

On very high wattage band heaters it would be advantageous to set up the wiring three-phase to reduce the current load across a single conductor. Three-Phase wiring is available on select clamping/construction or termination variation (termination location is subject to engineering approval).

- Min. ID: 3” (76.2 mm), Min. Width: 2” (50.8 mm)

Dual Voltage

Band heaters can be designed using 3-wire series/parallel circuits for dual voltage applications. Whether the heater is run on the higher or lower voltage, the wattage will be the same. Dual Voltage wiring is available on any clamping/construction or termination variation.

Ground Terminal or Lead

For those applications requiring a separate ground terminal or lead attached to the heater sheath. A Ground Terminal or Lead is available on any clamping/construction or termination variation.

Single Phase/Three Phase

Duraband Heaters can be designed with multiple circuits to operate single or three-phase.

**Electrical Plugs**

Industry standard NEMA Twist-Lock® electrical plugs are available. The plugs can be attached to fiberglass leads, armor cable or wire braid. Electrical Plugs can be added to any clamping/construction or termination variation. See page 15-15 for additional Twist-Lock electrical plugs.

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**Custom Engineered/Manufactured Heaters**

Understanding that an electric heater can be very application specific, for sizes not listed TEMPICO will design and manufacture a Duraband Heater to meet your requirements. **Standard lead time is 2 weeks.**

Please Specify the following:

- Inside Diameter
- Width
- Wattage
- Voltage
- Quantity
- Termination (see pages 1-32 through 1-45)
- Lead Cable/Braid Length
- Construction style (see pages 1-28, 1-46 and 1-47)
- Clamping variation (see pages 1-29 through 1-31)
- Special Features

**WARNING:** Cancer and Reproductive Harm - www.P65Warnings.ca.gov.

**View Product Inventory @ www.tempco.com**
Variety and Versatility in Mica Insulated Heaters. No other heater band has the design and manufacturing flexibility of mica insulated heaters. Tempco’s flexible CNC sheet metal fabricating machines, custom developed engineering programs with built-in intelligence, and experienced and talented engineering staff allow us to push the limits on band heater designs.

Throughout our catalog we show Tempco’s standard specifications and most popular designs. However, as a custom heating element manufacturer, we recognize that many applications require non-standard and unique designs.

At Tempco, we are constantly challenged by our customers to solve their heating applications. We have the experience, technical knowledge and manufacturing capability to solve all your heating problems with unique heater designs. You should use Tempco’s talent and capabilities to your benefit to solve your specific heating problem in an expeditious and cost effective manner.

The following pictures show some of the heater designs that we have developed for special applications. Next time, when you have a special application and you want someone to work with you and “think outside the box” to solve your specific heating application, call Tempco.

We haven’t seen all heating applications, but most likely our experienced staff has seen and solved more heating problems than you have seen.

Use our knowledge and experience to work for you. Challenge us! You will be glad you did.

We Welcome Your Inquiries.

(800) 323-6859 • Email: sales@tempco.com
An alternative to wound ribbon core heaters is the sinuated heater element. In this type of construction, the heating element resistance wire is sinuated, or “formed” back and forth without a middle core layer of mica insulation. The heating element is then sandwiched between two layers of specially selected mica insulation to provide excellent thermal conductivity and dielectric strength.

The sinuated formed element lends itself to lower temperature and watt density applications where high watt density construction is not required.

**Typical Applications (Cylindrical Surfaces)**

- Food and Candy Extruders
- Vending Machines
- Commercial Food Equipment
- Food Service Warming Items
- Laboratory and Scientific Apparatus
- Photographic Equipment
- Incubators

**Typical Applications (Flat Surfaces)**

- Laminating
- Food Service Warming Items
- Radiant Heating
- Incubators

This design is widely used in food service and the farming industry. By careful selection of economical materials used for these low temperature applications, significant cost savings can be realized compared to standard mica heaters.

*Contact Tempco for Complete Product Details.*
1. Disconnect electric power to the machine and/or heaters prior to installing or replacing heaters.

2. Do not install heaters in areas where combustible gases, vapor or dust is present.

3. Use as many narrow band heaters as the application will permit. 1-1/2” through 3” wide heaters are recommended.

4. Using a heater that closely matches the wattage requirements will decrease the frequency of cycling and temperature overshoot, thereby increasing the life of the heater.

5. Make certain that all barrel surfaces are clean and have a smooth finish. Any contaminants or imperfections on the surface can cause premature heater failure.

6. Tempco expandable type Mica Band Heaters may be opened once at the gap to fit on the barrel. Do not open these heaters beyond their specified heater diameter.

Do not open Tempco One-Piece Non-Expandable Type mica band Heaters. Opening of these heaters can damage Mica Insulation and will create electrical short circuits.

7. Position heater bands on the barrel.

8. Securely tighten heater bands around the barrel. Clamping force must be equally distributed on heaters with more than one set of clamping brackets.

Recommended clamping bolt torque is 10 ft/lbs.

9. For heaters with screw terminals, remove the top nut and flat washers from the power screw terminals. Do not remove or loosen the bottom nut on the power screw terminals. The bottom nut is tightened to 60 in/lbs. at the factory. A loose bottom nut may cause premature heater failure.

Installation Accessories Available

IMMEDIATE DELIVERY!

- High Temperature Terminal Lugs
- Igloo™ Ceramic Terminal Covers
- UL Listed Plugs
  - High Temperature Lead Wire 842°F (450°C)
  - Armor Cable
  - Stainless Steel Braid
  - High Temperature Slewing
  - High Temperature Mica Insulated Wiring Harnesses 842°F (450°C)
  - Thermocouples
  - Temperature Controllers
  - High Temperature Fiberglass Tape

10. All electrical wiring of heater bands should be done by a qualified electrician.

  a. Use only Stainless Steel or other high temperature lugs to prevent material degradation when exposed to high temperatures over a prolonged period of time.

  DO NOT USE COPPER OR PLATED COPPER LUGS.

  b. Use only lead wire with high temperature insulation and proper gauge size.

  c. When connecting power leads to screw terminals make certain that barrels of terminal lugs are not facing down toward the heater case, which will create a short circuit.

  Tighten the top nut to 30 in/lbs.

  d. Make certain power lead wires do not make contact with hot heater surface to avoid degradation of lead wire, as this can cause electrical short circuits.

  e. Make sure the voltage input to the heater bands does not exceed the voltage rating that is stamped on the heater band.

  f. It is recommended that an amperage reading is taken for each heater to verify proper wiring.

  (Amps = Watts/Volts)

11. Insulate all live electrical wires per applicable safety standards.


  a. Energize heater bands and allow the heater to reach 300°F (149°C). This usually takes between 3 and 5 minutes.

  b. Turn off power and immediately re-tighten the heater bands to 10 ft/lbs. Turn power back on.

13. Install shrouds around the machine to meet applicable safety requirements.

14. Once installed, check surroundings to make sure that contaminants won’t get on the heater while the unit is in operation. Accumulation of contaminants on heaters can cause premature heater failure.

15. Insulating blanket installations must have band heater retightening sequence (#12) completed before blanket installation. Lead wires must exit the insulation blanket as soon as possible; do not entrap lead wires between heater sheath and insulation blanket.

It is imperative that upon start-up of new machines at customer facilities, all of the aforementioned parameters are double checked by qualified field service personnel.

Exposed electrical wiring on band heater installations is a violation of Electrical Safety Codes including O.S.H.A.
## Band Heaters

### Duraband Nozzle Band Heaters

**STOCK** Replacement Band Heaters for Plastic Injection Molding Machines

**COST EFFECTIVE WITHOUT COMPROMISING QUALITY**

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**NHL Mica Insulated Nozzle Heater**

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*Note: For normal plastic processing Tempco recommends Watt Densities under 55 W/in².*

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**In Stock!**

* Economically Priced
* Type NHL with 12” leads and 2” of protective sleeving
* Supplied with low profile clamping strap

---

All Items Available from Stock

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View Product Inventory @ www.tempco.com
STOCK Replacement Band Heaters for Plastic Injection Molding Machines

In Stock!

* Economically Priced
* Type NHW with 12” leads and 10” SS wire braid
* Supplied with low profile clamping strap

**COST EFFECTIVE WITHOUT COMPROMISING QUALITY**

**NHW Mica Insulated Nozzle Heater**

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**Note:** For normal plastic processing Tempco recommends Watt Densities under 55 W/in².

Ordering Information
See page 1-48

(800) 323-6859 • Email: sales@tempco.com
Band Heaters

Made in USA

Duraband Nozzle Band Heaters

Stock and Standard (Non-Stock) Replacement Mica Insulated Band Heaters
for Plastic Injection Molding Machines

Stock Items Are Shown In RED

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① Heaters have built-in Type J Thermocouple

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Fig. A

Fig. B

Stock Items Are Shown In RED

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Fig. C

Design Features:
* All heaters have 24" high temperature leads with 22" stainless steel overbraid

Ordering Information
See page 1-48

View Product Inventory @ www.tempco.com
Stock and Standard (Non-Stock) Mica Insulated Band Heaters for Plastic Injection Molding Machines

Design Features:

✴ All heaters have 24" high temperature leads with 22" stainless steel overbraid — Type W3
✴ Heaters less than 1-1/2" wide have separate straps — Type SE
✴ Designed as one-piece expandable type, enables you to open up the heater to the diameter of the barrel for easy installation.

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Design Features:

✴ All heaters have 24" high temperature leads — Type L2
✴ Heaters less than 1-1/2" wide have separate straps — Type SE
✴ Designed as one-piece expandable type, enables you to open up the heater to the diameter of the barrel for easy installation.

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Band Heaters

Duraband Barrel Band Heaters

Stock and Standard (Non-Stock) Mica Insulated Band Heaters for Plastic Injection Molding Machines

Design Features:
✴ All heaters have 24" high temperature leads with 22" stainless steel overbraid — Type W1
✴ Heaters less than 1-1/2" wide have separate straps — Type SE
✴ Designed as one-piece expandable type, enables you to open up the heater to the diameter of the barrel for easy installation.

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Stock Items Are Shown In RED

View Product Inventory @ www.tempco.com

Ordering Information

See page 1-48
Stock and Standard (Non-Stock) Mica Insulated Band Heaters for Plastic Injection Molding Machines

Optional Igloo® ceramic covers can fully insulate any standard #8 or #10 terminal lugs used for electrical hook-ups. See page 1-33.

### Design Features:
- **Features unbreakable 10-32 screw terminals.**
- **Larger heaters (dia. 2-1/2” or greater) are designed as one-piece expandable type, enabling you to open up the heater to the diameter of the barrel for easy installation.**
- **Heaters less than 1-1/2” wide have separate straps — Type SE**

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*Wattage values are approximate and change with voltage and the amount and type of insulation.*

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## Stock and Standard (Non-Stock) Mica Insulated Band Heaters for Plastic Injection Molding Machines

### Duraband Barrel Band Heaters

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Stock Items Are Shown In RED

View Product Inventory @ www.tempco.com
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**Order Info.**
See page 1-48

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