



Watt-Flex® Heater Soft Start Sequence (bake out)

All cartridge heaters using MgO insulation require some form of “bake-out” process to drive out atmospheric moisture absorbed by the heater. Care should be taken to perform a “soft start” upon initial start-up and/or after extended (4+ days) shut down.

Prior to starting heaters, it is good practice to perform a megohm test. Heaters with megohm values less than 500 megohm, should utilize the heater soft-start sequence.

Soft start Sequence:

Once one of the chosen methods below are performed, the heater will be ready for full power to be applied.

Preferred Soft-Start Method

- Program a 30-minute cycle at 50% of the rated voltage into the heater controller.
- Connect heaters to a power source that is rated at half the required voltage. Energize heaters for no less than 30 minutes.

Alternative Method

- Place heaters in an oven at 350F for 4-6 hours to bake out any atmospheric moisture.
- Assuming it is safe to do so, some users temporarily store new replacement heaters on or near the heated equipment 24 hours prior to installation to facilitate the bake out process.

Heater Storage:

- Cool dry place 40-70F

Call us today (978) 356-9844 for more information on Dalton Electric **Watt-Flex®** heaters. We welcome the opportunity to help your operation reduce the total cost of heating.

Dalton Electric Process heat precisely delivered.

For more information and a quote please contact us at
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