

PRODUCT DATA SHEET

MM-052-02



HEATY

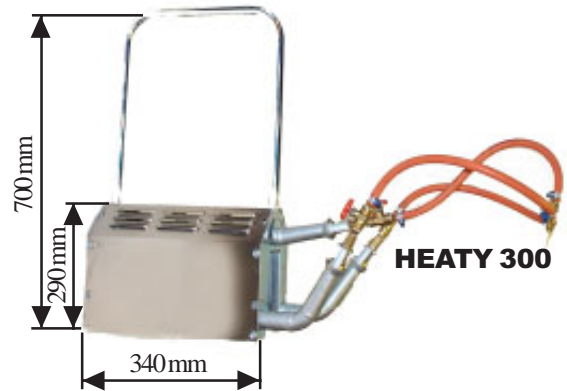
Rail Heater

HEATY 300, L=300mm, SAFE 4045

HEATY 600, L=600mm, SAFE 4048

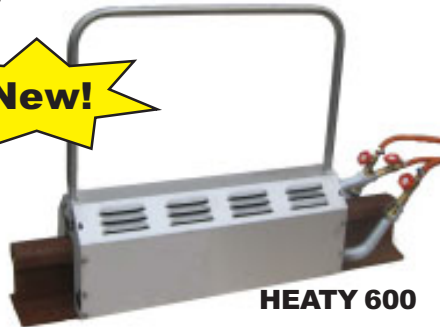
The rail heater HEATY is an oven for even and precise preheating of rails before welding. HEATY can also be used for the gradual cooling of welds to prevent brittle fracture.

HEATY consists of three propane burners using the Bunsen principle. HEATY 600 can heat 24 inch / 600 mm at the same time.



(640 mm, HEATY 600)

New!



HEATY 600

Technical data

| | |
|---------------------------|--------------------|
| Weight HEATY 300 | 30.2 lbs / 13.7 kg |
| Weight HEATY 600 | 47,8 lbs / 21.7 kg |
| Gas consumption / min: | |
| - preheating at 2 bar | 1.75 oz / 50 g |
| - post-heating at 0.5 bar | 0.7 oz / 20 g |

Heat-up time

| | |
|-----------|-------------------------------|
| HEATY 300 | 350°C / 660°F at 2 bar: 5 min |
| HEATY 600 | 350°C / 660°F at 2 bar: 8 min |

Heating with HEATY means:

- Even heat distribution
- Even holding heat
- Exact holding heat
- Only propane necessary
- Easy to handle
- Fast heating
- Adjustable heaters

How to use HEATY

Place HEATY on the rail and connect it to the propane cylinder regulator by means of tubing.

Preheating of welding area

Adjust the regulator to a pressure of 2 bar and open the three valves of the burners completely. Light the burners and readjust the pressure to 2 bar.

After 5 minutes (8 min. f. Heaty 600) HEATY provides a preheating temperature of 350°C / 660°F.

Post-heating of weld area

Shut down the upper burner and adjust the regulators to 0.5 bar. HEATY will then keep a temperature of 625-675°C / 1160-1250°F on the rail, web and base for 10 minutes. Even heating and even cooling are essential for a durable weld.

HEATY could with advantage be used together with gas bottle heater SAFE 4052 during use in cold weather to increase the output of gas in the bottle.

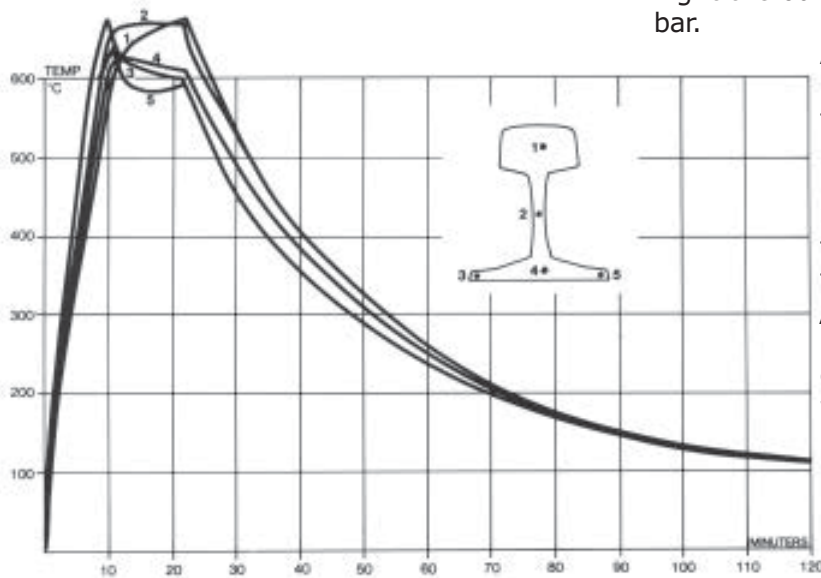


Diagram showing the even heat distribution throughout the rail.