

Flexible Induction Blankets

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Induction Heating System 



Blankets easily conform to circular and flat parts.



Miller's Patented Flexible Induction Blanket is the newest innovation in preheat technology from a leader in the welding industry. The flexible, lightweight induction heating blankets come in a variety of sizes and are capable of preheat temperatures up to 400° F (204° C). The blankets easily conform to circular and flat parts and install in a matter of seconds. Manufactured from durable high-temperature materials, flexible induction blankets are designed to withstand the tough conditions in both industrial and construction applications. Each blanket is supplied with two spare blanket-securing straps and one replaceable Kevlar® sleeve which provides added protection against abrasion, cuts and tears, extending blanket life.

Features and Benefits

Replaceable Kevlar® Sleeve: Each Flexible Induction Blanket is supplied with a replaceable Kevlar® sleeve for added protection against abrasion, cuts and tears. Straightforward installation with hook-and-loop Velcro allows for trouble-free field replacement.

Air-Cooled — 100% Duty Cycle: Rated for continuous operation at 400° F (204° C), all Flexible Induction Blankets feature air-cooling. By eliminating the need for water-cooling as used in conventional induction coils, the Miller Flexible Induction Blanket provides greater flexibility and reduced installation costs.

Twistlock Connectors: Electrical connection to output extension cables is made through the use of durable twistlock connectors. Molded to the ends of wires extending from the blanket, these connectors assure that connection is maintained during handling and operation of the induction system. A rubber boot seals the connection from dirt, debris and moisture.

High Operating Efficiency: With an operating efficiency greater than 90%, the Flexible Induction Blankets provide efficient preheat performance for thin or heavy wall part application.

True Blue® 90-Day Warranty: Miller Flexible Induction Blankets are built to the highest standards of quality and durability to ensure they withstand the rugged environment to which they're exposed.

Specifications

Maximum preheat temperature: 400° F (204° C)

MADE IN **USA**
APPLETON, WI **USA**



Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters
Phone: 920-735-4505
USA FAX: 920-735-4134
Canadian FAX: 920-735-4169
International FAX: 920-735-4125

Web Site
www.MillerWelds.com

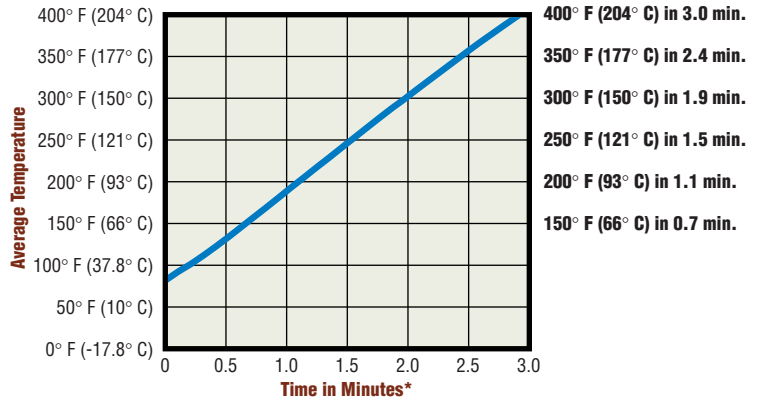


Performance Data

25 kW Time to Temperature
with 24-in. (61 cm) diameter
pipe blanket

Fixed Parameters

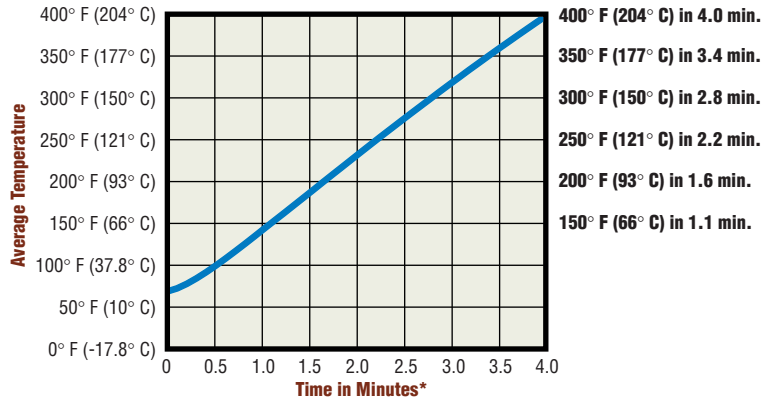
- Ambient temperature: 75° F (24° C)
- Material: carbon steel
- Material mass: 86 lb. (39 kg)
- Still air
- System efficiency: 95%



25 kW Time to Temperature
with 36-in. (91 cm) diameter
pipe blanket

Fixed Parameters

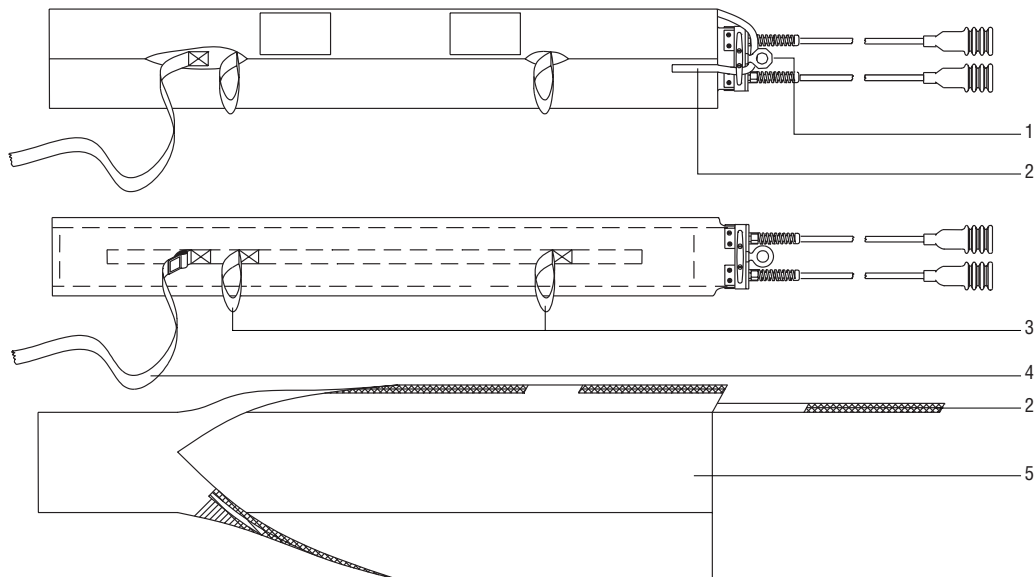
- Ambient temperature: 75° F (24° C)
- Material: carbon steel
- Material mass: 129 lb. (58.5 kg)
- Still air
- System efficiency: 95%



Blanket and Sleeve Assembly

Please refer to product manual for detailed assembly and safety information.

1. Eyelet
2. Sleeve Securing Strap
3. Handles
4. Blanket Securing Strap
5. Protective Sleeve



Duty Cycle on Air-Cooled Blankets

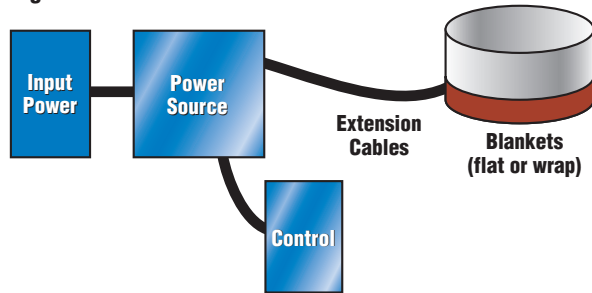
Use of the system with air-cooled blankets can be broken down into three different configurations. These include:

1. A single blanket attached to the power source. See Figure 1.
2. Two blankets in parallel on a single power source. See Figure 2.
3. Four blankets in a series/parallel arrangement on a single power source. See Figure 3.

Single Blanket Arrangement

A single blanket arrangement requires a single extension cable and blanket attached to the power source. In a single blanket configuration, the 25kW Intellifire power source will typically deliver approximately 220 to 245 amps of current. The blankets are designed to operate at this current level for short duty cycles (less than 25 minutes). In long duty cycle applications, where the 25 kW Intellifire power source must deliver full output for greater than 25 minutes, the blanket may degrade which could result in permanent damage to the blanket. If a longer operating time is required with a single blanket, the output power must be reduced, via the power adjust knob on the front of the power source or a parallel blanket arrangement should be used. The current can be read using the IHPC pendant control.

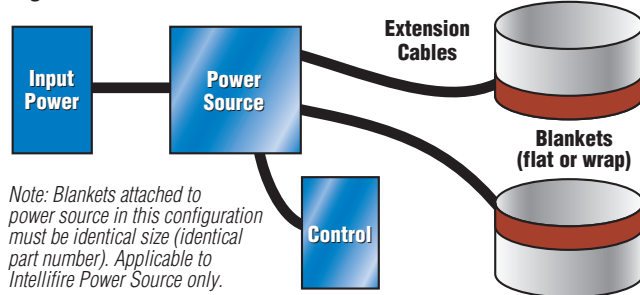
Figure 1



Parallel Blanket Adjustment

A two blanket parallel arrangement requires two equal size blankets and two extension cables attached to a single power source as shown in Figure 2. In this arrangement, the output power from the power source is divided equally between the blankets (assuming both blankets are in direct contact with the material being heated).

Figure 2

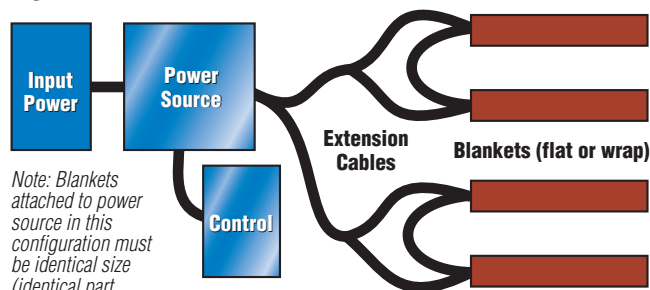


Note: Blankets attached to power source in this configuration must be identical size (identical part number). Applicable to Intellifire Power Source only.

Series/Parallel Blanket Arrangement

A series/blanket parallel arrangement requires four equal size blankets, two extension cables and two series adapter cables attached to a single power source as shown in Figure 3. In this arrangement, the output power from the power source is divided equally between the four blankets (assuming all blankets are in direct contact with the material being heated).

Figure 3



Note: Blankets attached to power source in this configuration must be identical size (identical part number). Applicable to Intellifire Power Source only.

Ordering Information

Induction Blanket

#194 886	47 x 10.1 in. (119 cm x 26 cm)	12-in. (31 cm) pipe with sleeve
#194 885	53 x 10.1 in. (135 cm x 26 cm)	14-in. (36 cm) pipe with sleeve
#194 884	60 x 10.1 in. (152 cm x 26 cm)	16-in. (41 cm) pipe with sleeve
#194 699	66 x 9.0 in. (168 cm x 23 cm)	18-in. (46 cm) pipe with sleeve
#198 657	72 x 9.0 in. (183 cm x 23 cm)	20-in. (51 cm) pipe with sleeve
#198 658	78 x 9.0 in. (198 cm x 23 cm)	22-in. (56 cm) pipe with sleeve
#194 686	85 x 9.0 in. (216 cm x 23 cm)	24-in. (61 cm) pipe with sleeve
#198 659	91 x 9.0 in. (231 cm x 23 cm)	26-in. (66 cm) pipe with sleeve
#198 660	97 x 9.0 in. (246 cm x 23 cm)	28-in. (71 cm) pipe with sleeve
#198 661	104 x 9.0 in. (264 cm x 23 cm)	30-in. (76 cm) pipe with sleeve
#194 817	110 x 7.5 in. (279 cm x 19 cm)	32-in. (81 cm) pipe with sleeve
#194 818	116 x 7.5 in. (295 cm x 19 cm)	34-in. (86 cm) pipe with sleeve
#194 687	122 x 7.5 in. (310 cm x 19 cm)	36-in. (91.5 cm) pipe with sleeve
#194 819	129 x 7.5 in. (328 cm x 19 cm)	38-in. (97 cm) pipe with sleeve
#198 662	141 x 7.5 in. (358 cm x 19 cm)	42-in. (106.7 cm) pipe with sleeve
#194 815	154 x 7.5 in. (391 cm x 19 cm)	46-in. (117 cm) pipe with sleeve
#198 663	160 x 7.5 in. (406 cm x 19 cm)	48-in. (122 cm) pipe with sleeve
#198 066	173 x 7.5 in. (439 cm x 19 cm)	52-in. (132 cm) pipe with sleeve
#216 340	185 x 7.5 in. (470 cm x 19 cm)	56-in. (142 cm) pipe with sleeve

Induction Blanket Sleeve Replaceable Kevlar sleeves for extended induction blanket life.

#194 889	49 x 10.1 in. (124 cm x 26 cm)	12-in. (31 cm) pipe
#194 888	55 x 10.1 in. (140 cm x 26 cm)	14-in. (36 cm) pipe
#194 887	62 x 10.1 in. (158 cm x 26 cm)	16-in. (41 cm) pipe
#194 707	68 x 9.0 in. (173 cm x 23 cm)	18-in. (46 cm) pipe
#198 664	74 x 9.0 in. (188 cm x 23 cm)	20-in. (51 cm) pipe
#198 665	81 x 9.0 in. (206 cm x 23 cm)	22-in. (56 cm) pipe
#194 706	87 x 9.0 in. (221 cm x 23 cm)	24-in. (61 cm) pipe
#198 666	94 x 9.0 in. (239 cm x 23 cm)	26-in. (66 cm) pipe
#198 667	100 x 9.0 in. (254 cm x 23 cm)	28-in. (71 cm) pipe
#198 668	107 x 9.0 in. (272 cm x 23 cm)	30-in. (76 cm) pipe
#194 811	114 x 7.5 in. (289 cm x 19 cm)	32-in. (81 cm) pipe
#194 812	120 x 7.5 in. (305 cm x 19 cm)	34-in. (86 cm) pipe
#194 705	127 x 7.5 in. (323 cm x 19 cm)	36-in. (91.5 cm) pipe
#194 813	133 x 7.5 in. (338 cm x 19 cm)	38-in. (97 cm) pipe
#198 669	146 x 7.5 in. (371 cm x 19 cm)	42-in. (106.7 cm) pipe
#194 809	159 x 7.5 in. (404 cm x 19 cm)	46-in. (117 cm) pipe
#198 670	166 x 7.5 in. (422 cm x 19 cm)	48-in. (122 cm) pipe
#200 262	179 x 7.5 in. (455 cm x 19 cm)	52-in. (132 cm) pipe
#217 628	193 x 7.5 in. (490 cm x 19 cm)	56-in. (142 cm) pipe



Blanket Securing Strap #197 866



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