

Band/Barrel Heaters

Ceramic Knuckle Band Heaters

Ceramic knuckle band heaters are designed to provide high-performance barrel heating at temperatures up to 1400°F (760°C). This level of performance is achieved utilizing ceramic materials, which provide excellent insulation and long heater life. The construction of the ceramic knuckle heater includes interlocking ceramic blocks with resistance wires threaded through holes within the ceramic. This method provides superior heat distribution across the band, resulting in a uniformly heated surface. Ceramic knuckle heaters are specifically engineered and manufactured with three layers.

The aluminized steel sheath layer improves mechanical protection to the heater and resists corrosion.

The ceramic fiber layer provides thermal insulation energy conservation and minimizes heat loss.

The ceramic knuckle layer provides mechanical protection and electrical insulation to the resistance element, which increases heater life and conducts or radiates the heat to the surface.

Performance Capabilities

- 1400°F (760°C) maximum operational temperatures
- Watt densities up to 45 W/in²

Features and Benefits

Ceramic insulator

- Allows for high temperature operation
- Provides longer heater life
- Ensures accurate heating

Aluminized steel cover

- Provides excellent protection from abrasion

Radiation or conduction heat transfer

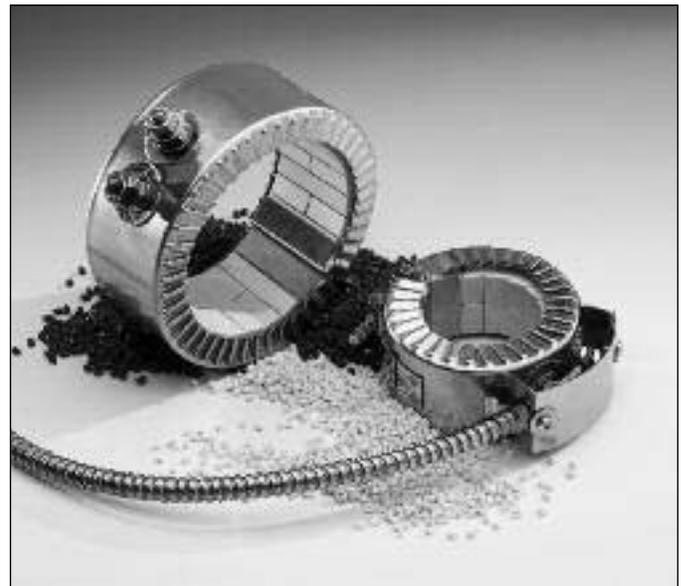
- Ensures dependable heat transfer method

Standard Construction

- Aluminized sheath
- Clamp tabs
- Post terminals

Applications

- Injection molding barrels
- Extruder barrels
- Blown film dies



Specifications

Electrical

- Resistance tolerance: -10% (+5%)
- Wattage tolerance: +10% (-5%)
- Maximum watt density: 114 W/cm² (45 W/in²)
- Maximum operating temperature: 1400°F (760°C)

Mechanical

- Overall thickness: 0.5 in. (13 mm)
- Minimum width: 1.5 in (38 mm)
- Maximum width: 9.69 in. (246.1 mm)
- Minimum I.D.: 2 in. (51 mm)
- Maximum I.D.: 15 in. (381 mm)*
- Width tolerance: 0.125 in. (±3.175 mm)
- Standard gap: 0.25 in. (6.4 mm):

*One-piece construction

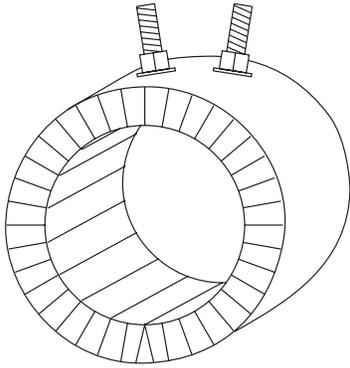


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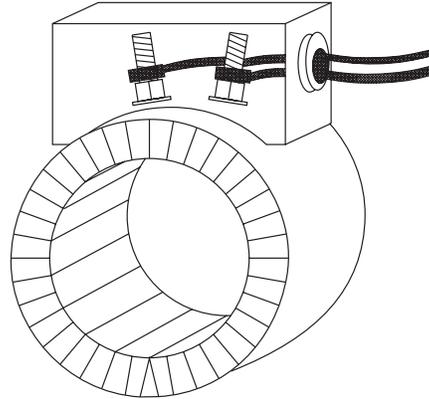
Termination Options

Post Terminals



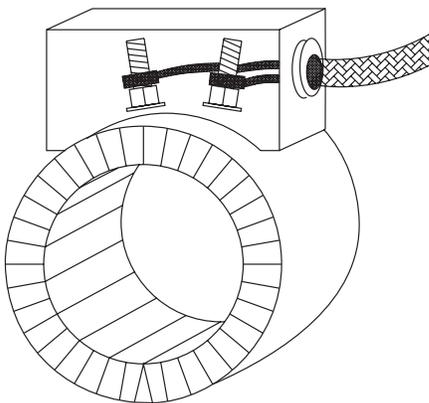
Post terminals are the standard termination, providing quick connection with ring or fork connectors or buss strips, ¼ -20 in. thread and includes double nuts and washers. Standard terminal location is 180° from gap.

Flexible Lead Wire



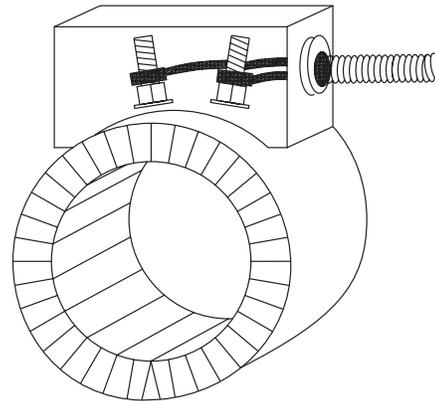
Flexible lead wire exits tangential to heater and includes leads connected to the post terminals with ring connectors. This termination method requires a terminal box.

Stainless Steel Braid



The stainless steel braid method includes a loose metal braid that is welded to the terminal box with a coupler. This provides excellent abrasion protection and flexibility. Leads are attached to posts with a ring connector.

Flexible Stainless Steel Hose



Flexible stainless steel hose is welded to the terminal box with a coupler. This terminal option provides superior mechanical protection where lead abrasion is a problem. Leads are attached to posts with a ring connectors.

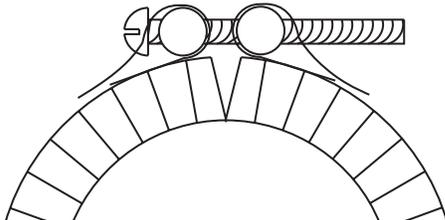


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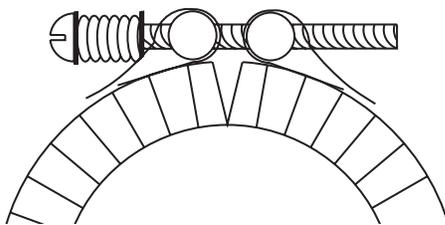
Clamping Options

Barrel Clamps



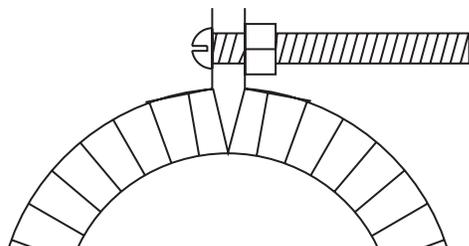
Barrel clamps are used in applications where access for instrumentation is required. It includes an oversized gap.

Spring Loaded Barrel Clamps



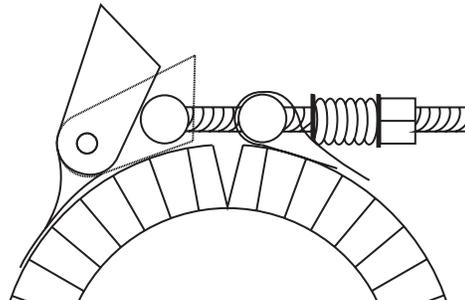
Spring loaded barrel clamps help to compensate for the thermal expansion of metals.

Clamp Tabs



Clamp tabs are a standard clamping option that offers a uniform clamping force across the heater width.

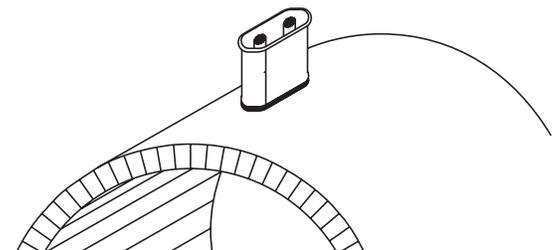
Flexible Lead Wire



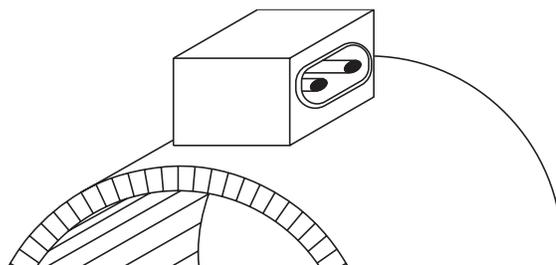
Latch and trunion clamps provide a quick clamp option. Clamping force is similar to barrel clamps and a spring is included to allow for thermal expansion of metals.

European Style Plugs

Vertical



Horizontal



European style plugs provide a simple and safe way to apply power. The combination of high temperature male and female “quick disconnect” plug assemblies eliminate all live exposed terminals and electrical wiring. When ordering, specify vertical or horizontal European plug.



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Options

Terminal box provides protection for electrical connections in hazardous environments.

Partial coverage helps heating of large pipes and covers large diameters with two or more sections, dimensional drawing required when ordering.

Thermocouple bracket % NPT necessary for instrumentation. A dimensional drawing is required when ordering.

Holes and notches necessary for instrument access, etc. Heater must be 2.5 in. (64 mm) minimum width and 2.5 in. (64 mm) minimum I.D. A dimensional drawing is required when ordering.

Ceramic terminal covers provide easy installation and protect electrical connections on each individual terminal.

Other Options

- Dual voltage (factory approval required)
- Stainless steel sheath
- Ground stud
- Ground lead
- Three-phase voltage (factory approval required)

Ceramic Band Heater Check List

- The surface where a heater will be mounted must be clean and the heater maintained. It must be free of all contaminants that might cause a short circuit in the heater (typically conductive liquids).
- To prevent overheating, Watlow recommends installing an appropriate temperature controller and checking the correct performance of the thermocouple.
- Do not use in environments containing combustible gases or vapors.
- Keep all electrical connections properly protected to avoid electrical hazards to machine operators.
- Do not over tighten clamps to the point where serrated side folds begin to collapse. Ceramic band heaters utilize radiation heating and excessive force may break ceramic insulators.



Physical Limitations

Options	I.D. (in.)		Width (in.)		Terminals	Clamp
	Min.	Max.	Min.	Max.		
One piece	2½	15	1½	10	—	—
Partial coverage	7	—	1½	9¾	—	Except clamp tabs
Clamp tabs	2½	15	1½	10	—	—
Barrel nuts	4	—	1½	10	—	—
Spring loaded barrel nuts	4	—	1½	10	—	—
Latch and trunion clamps	3	—	1½	10	—	—
Stud terminals	—	—	—	10	—	—
Flexible leads	2½	—	2½	10	—	—
SS hose leads	2½	—	2½	10	—	—
SS braided leads	2½	—	2½	10	—	—
Terminal box	2½	—	2½	10	—	—
Holes and notches	2½	—	2½	10	—	—
Ceramic cover	2	—	1½	10	Post	—
Terminal clamp	3	—	2½	9¾	Post with terminal box	—
European plug both vertical and horizontal	2½	—	2	10	—	—

— No restrictions.

Note: These are all standard clamping options, for special constructions please consult factory.