

SALES AND RENTAL OF HEAT TREATMENT EQUIPMENT

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SHRINK FIT APPLICATIONS

Customer: RWE Innogy PLC

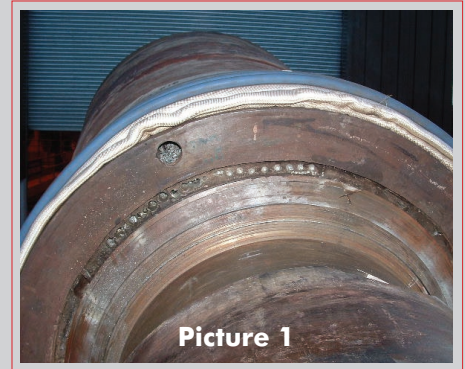
Job Description: To heat up a layer of Zinc 1" thick that encases a shaft in a collar 5" thick to a temperature of 450°C (melting point of zinc) to release the shaft out of the collar. (See pictures 1 & 2)
Target temperature 500°C at the zinc.

Job Location: RWE Innogy Plc
Ferrybridge
West Yorkshire

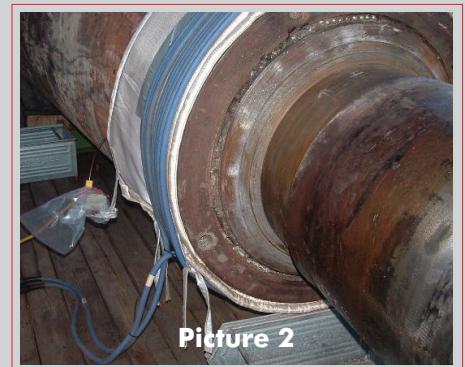
Job Date: 28.10.04

Equipment: 2 x 20kw RHS Induction Heating Machines
2 x 80ft Induction Heating Cables
2 x 50ft Induction Heating Extension Cables

Results: We set up a 5-coil configuration covering approximately 6" full circumference at the top edge of the collar. (See picture 3)
Target temperature was set at 500°C and switch on time was 1130 hours. After 20 hours soaking time we had taken the temperature of the zinc up to 350°C but due to the size of mass of the component it could not drive any more heat directly in to the zinc.
It was however hot enough for them to separate the shaft mechanically. (See picture 4)



Picture 1



Picture 2



Picture 3



Picture 4