

# electric duct heaters



open coil



finned tubular



explosion-proof &  
corrosion resistant



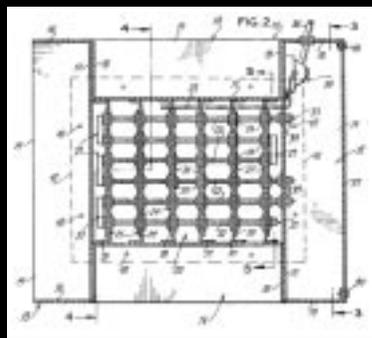
*electric heating and controls*

## Introduction

INDEECO designs and manufactures commercial and industrial electric heating and control systems that set the industry standard for excellence. The company's heating solutions reflect more than 70 years of innovation, product quality and efficient service. INDEECO's latest innovation, PC HEAT<sup>®</sup>, is custom software that enables our representatives to respond to your requests for pricing and sizing of open coil and finned tubular duct heaters within minutes. With this software, your local INDEECO representative becomes the source for certified prints, wiring diagrams — complete submittal information.

Our heaters and controls range from the simplest standard duct heater to the most sophisticated, custom designed comprehensive system. INDEECO's attention to detail and rigorous testing give worldwide customers premium products that they receive quickly and at a fair market price.

**For your nearest INDEECO representative call 1-800-243-8162.**



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# Choosing Open Coil or Finned Tubular Design

INDEECO manufactures both open coil (Figure 1) and finned tubular (Figure 2) heating elements and can supply virtually any duct heater with either type of element. While most simple space heating applications use the open coil design, there are many applications where finned tubular construction is appropriate. The following are the significant advantages of each type of construction.

## Open Coil



Figure 1.

Only the highest Grade A resistance wire (80% nickel, 20% chromium) is used in all INDEECO duct heaters. This iron-free wire has a higher maximum operating temperature, greater life, lower sag, less resistance change and higher corrosion resistance than other commonly used resistance wires.

Using calibrated tooling, the coils are mechanically crimped into stainless steel terminals. This connection, along with 10-32 terminal threads and stainless steel connection hardware, insures cool, minimum resistance, trouble free terminations.

An extended shank on the terminal places the critical resistance coil-to-terminal connection well out into the airstream to keep it cool even in applications where up to 1" of interior insulation is used in the duct.

Both terminal insulators and coil support insulators are fabricated from high-temperature ceramic. Their design and method of installation enable them to: 1) absorb both mechanical and thermal loading without chipping or cracking and 2) easily withstand high voltage dielectric tests.

**Element Temperature** – The open coil element releases its heat directly into the airstream. As a result, the open coil runs cooler than the coil in the finned tubular element which is isolated from the air by insulation and a metal sheath.

**Low Pressure Drop** – Because of the high percentage of open space across the heater, open coils have very low pressure drop as compared to finned tubular heaters. This can result in reduced fan motor horsepower and makes it possible to retrofit open coil heaters into existing systems without changing the fan motor.

**Large Electrical Clearances** – Generous electrical clearances between the coil and frame enable open coils to withstand severe applications such as subway car heating, where voltages may exceed 750 volts.

**Economy** – On relatively small, low KW heaters (the bulk of typical space heating applications) the open coil element is more economical. However, in large, high KW heaters, finned tubulars are more economical due to lower manufacturing costs.

**Smaller Size** – It is normally possible to get more KW with open coil construction for a given face area.

## Finned Tubular



Figure 2.

Finned tubular elements are designed and built by INDEECO to meet the requirements of each job. Length, wattage, voltage and element style are engineered to give the most economical package.

All elements consist of a Grade A coil (80% nickel, 20% chromium), precisely centered in a stainless steel tube which is filled with granular magnesium oxide. The entire assembly is compacted to maximize both the heat transfer and dielectric properties of the magnesium oxide. After compaction the tube measures 0.475" (12 mm) O.D., an unusually large diameter providing sufficient insulation for operation up to 600 volts.

A stainless steel fin is helically wound onto the tube to increase its heat transfer surface.

INDEECO has standardized on stainless steel for its finned tubular elements because of its superior resistance to moisture and corrosion.

Straight, Two-Pass and U-Bent elements are furnished with mounting flanges, making them individually removable through the terminal box.

# Specific Requirements

**Safety** – Because the heating coil is completely encased in a grounded metal sheath, shock hazard due to accidental contact with the coil is eliminated. Heaters installed close to a register, grille or access door should either use finned tubular construction or an open coil unit with a protective screen.

**Airflow Contamination** – If airborne contamination such as dirt or dust builds up on open coil elements during shutdown periods, the elements can short out. Finned tubular elements, with their insulated coils, eliminate this problem. Furthermore, upon start-up, a finned tubular heater which has been exposed to droplets of water in the airstream (e.g. immediately downstream from a spray type humidifier, a cooling coil or a fresh air intake) cannot short to ground as open coils can when support bushings are wet.

**Serviceability** – In the unlikely event of element failure, it is easier to replace individually mounted finned tubular elements than open coil elements.

**Mechanical Stability** – Finned tubular elements are more rugged than open coils. They will withstand more physical abuse.

**Airflow Uniformity** – Finned tubular duct heaters tend to be more tolerant of nonuniform airflow conditions. Heat conducted along the element length reduces or eliminates hot spots resulting from nonuniform airflow. With open coil heaters, it may be necessary to use a pressure plate to compensate for bad airflow conditions.

**Controllability** – Because of their relatively high thermal inertia, finned tubular elements controlled with on/off thermostat systems provide more precise control. Furthermore, finned tubular elements cycle at a reduced rate, thus increasing the life of the power components such as contactors. Nevertheless, when SCR controllers are used, equally precise control can be obtained with either construction.

## Calculating KW Requirements

Once the volume of airflow (CFM – in cubic feet per minute) and the required temperature rise ( $\Delta T$  – in degrees F) through the heater are known, the required kilowatt rating (KW) of the heater can be determined from the formula:

$$KW = \frac{CFM \times \Delta T^{\circ}F}{3193} \quad KW = \left( \frac{\text{Liters/Second} \times \Delta T^{\circ}C}{837} \right)$$

Where the desired heating capacity in BTU/Hr is known the KW is determined from the following formula:

$$KW = \frac{BTU/Hr}{3412}$$

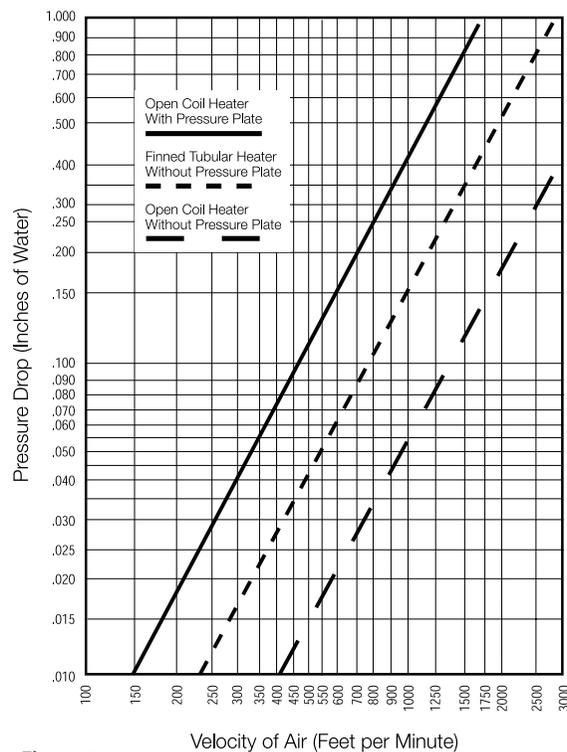


Figure 3.

## Static Pressure Drop

Static pressure drop through an open coil heater is quite low and, in most cases, can be ignored when calculating system pressure drop. The pressure drop across a finned tubular heater is greater than across an open coil. However, if pressure plates must be added to an open coil, the pressure drop over the open coil far exceeds the drop over a finned tubular heater. The curves in Figure 3 give data for all three constructions.



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# Specific Requirements

## Minimum Velocity

Electric heaters differ from steam or hot water coils in that the heat output is constant as long as the heater is energized. Therefore, sufficient airflow must be provided to prevent overheating and nuisance tripping of the thermal cutouts. The minimum required velocity is determined from Figure 4A or 4B on the basis of entering air temperature and KW per square foot of cross sectional duct area.

The maximum air inlet temperature for open coil heaters is 100°F (38°C) and for finned tubular heaters is 80°F (27°C).

Example: Determine whether the minimum air velocity requirement is met for a 10 KW open coil heater installed in a 24" wide x 12" high duct operating with 1000 cubic feet per minute (CFM) of air at a maximum inlet temperature of 65°F:

1. Duct Area =  $24" \times 12" / 144 = 2$  sq. ft.
2. KW per square foot =  $10 \text{ KW} / 2 \text{ sq. ft.} = 5$ .
3. Go to Figure 4B. Use top curve (below 80°F inlet air). Find 5 KW per square foot on the vertical axis. Read minimum velocity required, which in this case is 310 feet per minute (FPM).
4. Heater air velocity =  $1000 \text{ CFM} / 2 \text{ sq. ft.} = 500 \text{ FPM}$ .  
Since 500 FPM exceeds the minimum, this installation is safe. Consult your local INDEECO representative for assistance if you do not have sufficient air velocity.

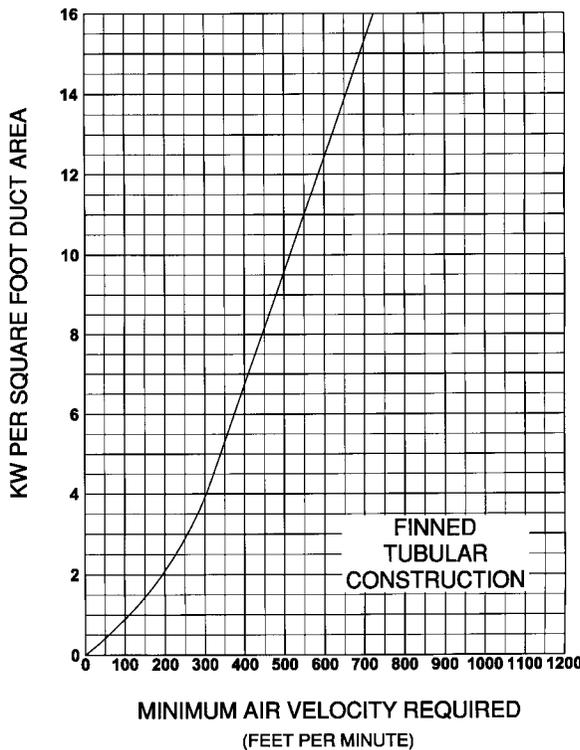


Figure 4A.

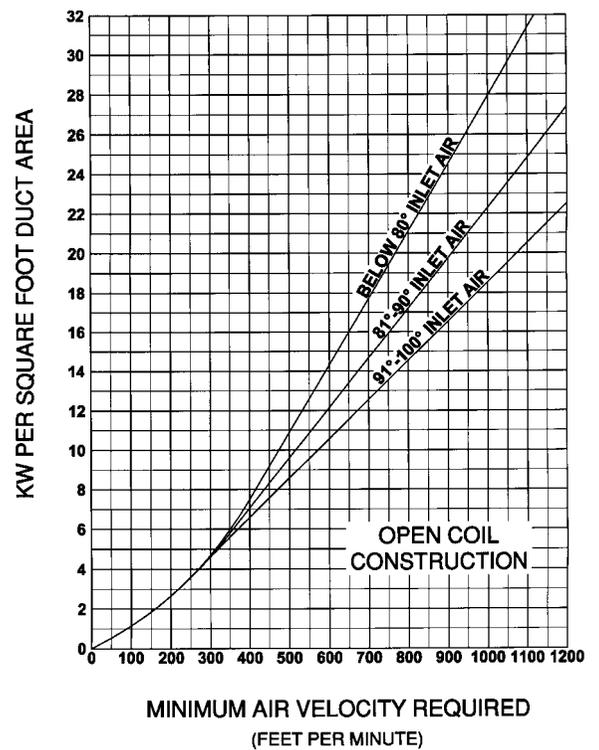
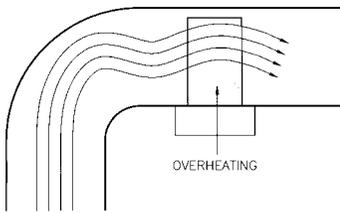


Figure 4B.

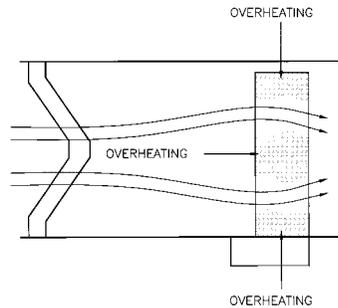
## Airflow Uniformity

To prevent hot spots, airflow must be uniformly distributed across the heater face. Figure 5 illustrates typical heater misapplications which result in non-uniform airflow. The heater's UL Listing requires that it not be installed closer than 4' (122 cm) downstream or upstream from a fan outlet, abrupt transition or other obstructions. Elbows or turns must be located at least 4' (122 cm) from inlet of the heater and 2' (61 cm) from outlet of the heater.

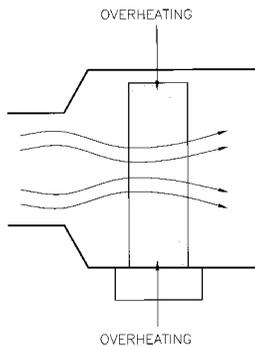
If such an installation cannot be avoided, consult your local INDEECO representative for assistance. We can provide a pressure plate, non-heated zones or special low watt density coils to overcome these problems. Final approval of such applications is up to the local inspection authority.



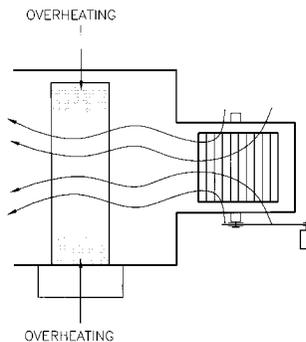
Heater too close to elbow



Heater partially blocked by filter or frame member



Heater adjacent to transition



Heater too close to fan

Figure 5.



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# Specific Requirements

## Multiple Heaters in the Duct

INDEECO heaters are designed to be used singly, not in series in a duct. Since INDEECO heaters can be furnished in virtually any size and KW rating, series installation of heaters can be avoided.

For very large heaters, field installation and shipping may be simplified by using two or more sections designed for parallel installation, illustrated by Figure 6. Each section, furnished in the flanged design, has individual thermal cutouts. Terminal blocks are provided to interconnect these cutouts in the field. Sections rest stably one on top of the other. Special angle iron frames are available to accommodate multiple section units on special order.

Heaters more than 6' (152 cm) high are normally provided in sections, but larger single section heaters can be provided. Consult your local INDEECO representative for details.

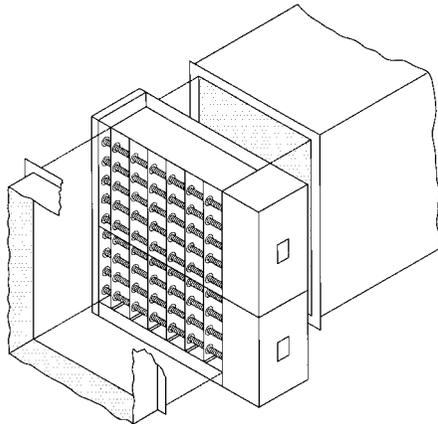


Figure 6.

## Clearance

INDEECO heaters are UL Listed for zero clearance to combustible surfaces. Thus, there is no minimum distance between combustible materials and the section of duct housing the heater, or the heater itself. However, the terminal box must be accessible for servicing. The NEC requires a minimum workspace at least 30" (76 cm) wide by 42" (107 cm) deep for access to the heater terminal box. More space is required for large heaters and for removal of slip-in heaters which are over 42" long.

In addition, sufficient clearance must be provided for convection cooling of all heaters with built-in SCR power controllers (Figure 7). Allow at least 5" (12.7 cm) of free air space around the cooling fins extending from the heater terminal box. Enclosing the fins in any fashion, insulating them, or preventing them from being cooled by normal convection will cause controller failure and void the heater warranty.

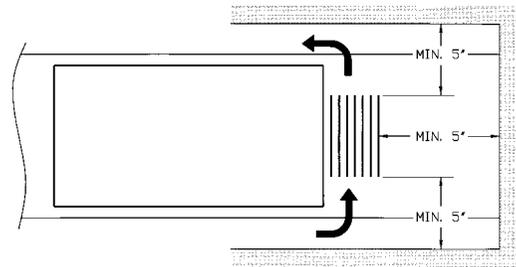


Figure 7.

## UL and NEC Requirements

All INDEECO electric duct heaters described in this catalog meet the requirements of Underwriters Laboratories (UL) and the National Electrical Code (NEC) unless otherwise indicated.†

Heaters furnished with one of the Control Options on pages 10 and 11 are automatically UL Listed and meet NEC requirements. Custom designed heaters must meet certain requirements to comply with UL and the NEC. The areas of particular concern are outlined below.

**Overtemperature Protection** – Duct heaters must be supplied with both primary and secondary overtemperature protection. All INDEECO heaters are provided with both automatic and manual reset thermal cutouts to serve this function.

**Airflow Interlocks** – An airflow interlock must be provided to keep the heater from operating with extremely low or no airflow. INDEECO's standard, a built-in differential pressure airflow switch described on page 15, senses static pressure in the duct as an indicator of airflow. Separate wiring to the fan motor or its controls is unnecessary.

Alternative methods for detecting airflow include:

1. The fan relay, described on page 15, provides a positive electrical interlock with the fan circuit.
2. A separate contactor, built into the duct heater, can energize the fan when the duct heater is on.
3. A terminal block to allow field connection of external contacts that close the circuit only when the fan is operating.

**Contactors** – Contactors connected to the thermal cutout and airflow interlock circuits must be provided by the duct heater manufacturer. Practically speaking, this means that all but small single-phase heaters must

be supplied with either contactors built into the heater terminal box or into a remote panelboard. INDEECO's standard is to supply de-energizing contactors which break only one line of single-phase circuits and two lines of three-phase circuits. Disconnecting contactors are available if required.

**Overcurrent Protection** – For heaters drawing more than 48 amps, the duct heater manufacturer must provide some means of overcurrent protection either built into the terminal box or a remote panelboard. While fuses or circuit breakers are available to meet this requirement, INDEECO's standard is fuses.

**Disconnecting Means** – All duct heater installations require a disconnecting means at or within sight of the heater controls. We recommend that a built-in, snap-acting, door interlocking disconnect switch with marked "on" and "off" positions be specified on all duct heaters. This insures the ultimate in safety, since the heater and built-in controls cannot be serviced without turning the disconnect switch off. It is also far less expensive than one obtained and installed in the field.

## International Requirements

INDEECO heaters can be supplied to operate from any electrical system throughout the world. Single and three-phase voltages through 600 volts are available. As described on pages 24 through 31, all type QUA and QUZ standard heaters are available in 380, 400 or 415 volt, three-phase ratings. All INDEECO heaters will operate on either 50 or 60 Hz.

† Although UL requirements are uniform throughout the country, local electrical codes may deviate from the NEC. For information on local requirements, consult your INDEECO representative.



# Installation Information

## Heater Installation

Slip-in heaters slide through a rectangular opening in the side of the duct per Figure 8. The heater is designed for 1/4" (6.35 mm) clearance around the inside of the duct. Slip-in construction is normally preferred for ducts up to 4' (122 cm) wide, but can be furnished for any width. The heaters are held in place with sheet metal screws through the back of the terminal box into the duct. However, if the duct is over 3' (91 cm) wide, supporting rails in the bottom of the duct are recommended.

Flanged heaters are attached to matching external duct flanges per Figure 9. The heaters are secured by using either sheet metal screws or bolts and nuts through the flanges.

A special flanged construction installed with conventional HVAC slip-and-drive connectors is also available. See page 40 for details.

Either flanged or slip-in heaters can be installed in fiberglass ducts as illustrated in Figure 10. Note that a sheet metal liner must be installed into the fiberglass duct work, extending at least 6" (152 mm) beyond the heater terminal box on both sides, more if required for structural rigidity.

## Field Wiring

Built-in power terminal blocks are sized for incoming copper conductors with 75°C insulation, rated to carry 125% of the heater load. However, lines may be sized to carry 100% of the heater load if a) the heater is rated at 50 KW or more, and b) the heater is controlled by a cycling device such as a multi-staged thermostat, step controller or SCR power controller. Terminal blocks and knockouts on such heaters will accommodate either 100% or 125% conductors. See **Table I** for field conductor and conduit sizing up to 500 MCM wiring. For higher amperages, terminal blocks are furnished for two or more parallel conductors per phase.

In general, aluminum conductors are not recommended and terminal blocks are not sized for aluminum. Consult your INDEECO representative if aluminum wire is specified for a particular job.

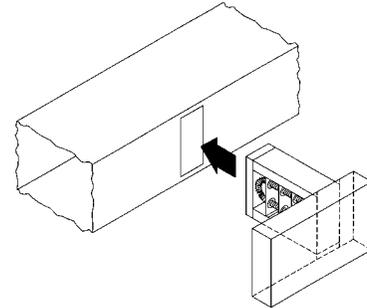


Figure 8.

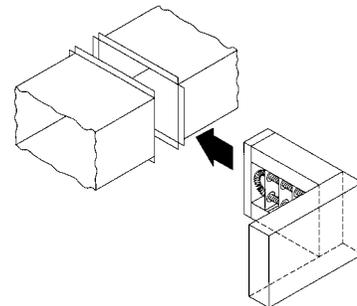


Figure 9.

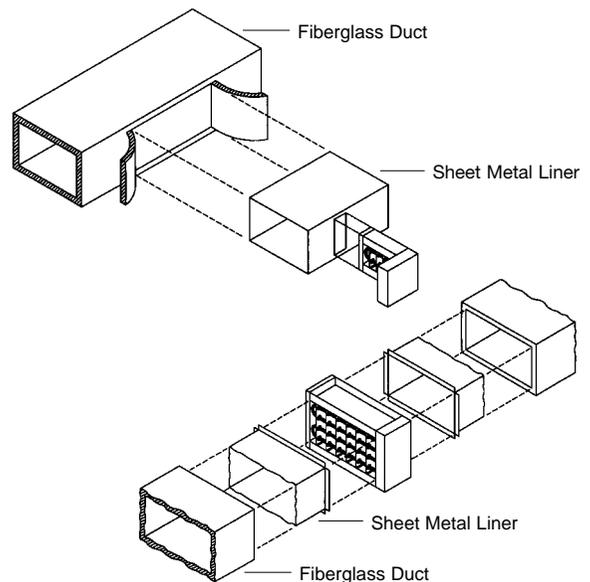


Figure 10.

# Installation Information

Field control wiring should also be copper conductors with 75°C insulation. Thermostat circuits for SCR's and step controllers are NEC Class II. Many small heaters with 24 volt control circuits are also NEC Class II. When Class II wiring is permissible, it will be shown on the wiring schematic. Other control circuits are NEC Class I.

When control power is taken from the heater's load circuit lines, INDEECO provides for the overcurrent protection of all control circuits as required by NEC or UL. When control circuit power is obtained from a separate source outside the heater, it is necessary for the installer to provide overcurrent protection for all control conductors.

**Table I**  
**Field Wiring and Conduit Sizing\* for Incoming Conductors**

	KW in Voltages Shown							Wire/ Size AWG or MCM	Trade Conduit Size (Inches)		Load Amps	
	Single-Phase				Three-Phase				1Ø	3Ø		
	120V	208V	240V	277V	208V	240V	480V					
<b>Sized For 125% of Heater Load</b>	1.4	2.4	2.8	3.3	4.3	4.9	9.9	14	½	½	12	
	1.9	3.3	3.8	4.4	5.7	6.6	13.3	12	½	½	16	
	2.8	4.9	5.7	6.6	8.6	9.9	19.9	10	½	¾	24	
	4.8	10.8	9.6	11.0	14.4	16.6	33.2	8	¾	1	40	
	6.2	10.8	12.4	14.4	18.7	21.6	43.2	6	1	1	52	
	8.1	14.1	16.3	18.8	24.4	28.2	56.5	4	1	1¼	68	
	9.6	16.6	19.2	22.1	28.8	33.2	66.5	3	1	1¼	80	
	11.0	19.1	22.0	25.4	33.1	38.2	76.4	2	1¼	1¼	92	
	12.4	21.6	24.9	28.8	37.4	43.2	86.4	1	1¼	1½	104	
	14.4	24.9	28.8	33.2	43.2	49.8	99.7	1/0	1¼	1½	120	
	16.8	29.1	33.6	38.7	50.4	58.1	116.3	2/0	1½	2	140	
	19.2	33.2	38.4	44.3	57.6	66.5	133.0	3/0	1½	2	160	
	22.0	38.2	44.1	50.9	66.2	76.4	152.9	4/0	2	2	184	
	24.4	42.4	48.9	56.5	73.4	84.8	169.6	250	2	2½	204	
	27.4	47.4	54.7	63.2	82.1	94.7	189.5	300	2	2½	228	
	29.8	51.6	59.5	68.7	89.3	103.0	206.1	350	2½	3	248	
	32.2	55.7	64.3	74.2	96.5	111.4	222.8	400	2½	3	268	
	36.5	63.2	73.0	84.2	109.5	126.3	252.7	500	2½	3	304	
	<b>Sized For 100% of Heater Load</b>						54.0		6	1	1	65
								70.7		4	1	1
							83.1		3	1	1¼	100
							95.6		2	1¼	1¼	115
						54.0	108.1		1	1¼	1½	130
					54.0	62.4	124.7		1/0	1¼	1½	150
						63.0	72.7	145.5	2/0	1½	2	175
				55.4		72.1	83.1	166.3	3/0	1½	2	200
			55.2	63.7		82.9	95.6	191.2	4/0	2	2	230
		53.0	61.2	70.6		91.9	106.0	212.0	250	2	2½	255
		59.2	68.4	78.9		102.6	118.4	236.9	300	2	2½	285
		64.5	74.4	85.9		111.7	128.9	257.7	350	2½	3	310
		69.7	80.4	92.8		120.7	139.2	278.5	400	2½	3	335
		79.0	91.2	105.3		136.9	158.0	315.9	500	2½	3	380

\*These tabulations are based on Table 310-16 of the NEC. Not more than 3 conductors in a raceway; 75°C rated copper wire.



# Standard Control Options

## Internal Wiring

Copper wire with a minimum of 105°C insulation is used throughout. Connections are made with either box lugs or connectors crimped on with calibrated tooling. Terminal blocks are provided for all field control and power wiring.

INDEECO developed the Control Option concept to maintain compliance with changing UL and NEC requirements and to stay current with new duct heater temperature control systems. The concept has also been broadened to include numerous “Special Features” to meet a wide variety of special requirements.

## Control Option G – Basic

Control Option G is a basic package designed for normal comfort heating applications – i.e., those that do not require pneumatic control or the unique features of SCR control. With Option G, the temperature is controlled by a pilot duty thermostat or a step controller.

Control Option G includes the following:

- **Automatic and manual reset thermal cutouts** to protect against overheating. The automatic reset cutout is wired into the control circuit; the manual reset de-energizes the heater load.
- A differential pressure **airflow switch** to de-energize the heater control circuit upon loss of airflow.
- **De-energizing magnetic contactors** for each heater stage.
- **Fuses** to protect each circuit in any heater drawing more than 48 amps.
- A control circuit **transformer**, with 24 or 120 volt secondary as specified, including any overcurrent protection required by UL or the NEC.
- A built-in, snap-acting **disconnect switch** with door interlock to protect service personnel.

## Control Option J – Pneumatic

Control Option J is designed for pneumatic temperature control.† The contractor need only connect one air line and the main power lines to the heater.

Option J includes the following:

- **Automatic and manual reset thermal cutouts** and a differential pressure **airflow switch**. The manual reset thermal cutouts always de-energize the heater load. The automatic reset cutout and airflow switch are normally wired in the control circuit. However, when single-phase KW ratings do not exceed the values in **Table II**, both of these devices also carry the heater load directly, eliminating the need for magnetic contactors.
- **PE switches** to control heater staging. To minimize field labor, multiple PE switches are factory-piped to a single port projecting through the terminal box. All PE switches close on pressure rise and open upon loss of pressure to de-energize the heater.
- **De-energizing magnetic contactors** on all three-phase Option J heaters and on single-phase heaters whose KW ratings exceed those shown in **Table II**.

Table II

Single-Phase Voltage	120	208	240	277
Maximum KW	1.8	3.1	3.6	4.1

- **Fuses** to protect each circuit in any heater drawing more than 48 amps.
- A **transformer**, with any overcurrent protection required by UL or the NEC, to supply the internal control circuit of heaters rated above 277 volts. All other heaters have line voltage control circuits.
- A built-in, snap-acting **disconnect switch** with door interlock to protect service personnel.

† Where more than six stages of pneumatic control are required, specify Option G with a step controller and pneumatic transducer as Special Features. Such a heater will function in the same manner as Option J but the number of stages is virtually unlimited.

## Control Option K – Proportional

Control Option K is designed for the most precise temperature control, using SCR proportional power controllers and a matching electronic thermostat. For heaters above the KW ratings in **Table III**, an electronic step controller is also provided. It works with the SCR to provide vernier proportional control. For more details on this system, see page 21.

**Table III**

Voltage		120	208	240	277	480	600
Maximum KW	1 Phase	23.0	39.9	46.0	53.1	91.1	115.2
	3 Phase	—	34.5	39.9	—	79.8	99.7

In addition to these electronic components, Control Option K includes the following:

- **Automatic and manual reset thermal cutouts** and a differential pressure **airflow switch**. The manual reset thermal cutouts always de-energize the heater load. The automatic cutout and airflow switch are normally wired in the control circuit. However, when single-phase KW ratings do not exceed the values in **Table IV**, the automatic reset cutout carries the heater load directly and the airflow switch either carries the load directly or is wired into the control circuit of the SCR, eliminating the need for magnetic contactors.
- **Safety magnetic contactors** controlled by the automatic reset cutout, for each heater circuit, when the KW exceeds the ratings in **Table IV**.
- **De-energizing, magnetic contactors** for each heater circuit, other than the SCR circuit, when the system includes a step controller.
- **Fuses** to protect each circuit in any heater drawing more than 48 amps.
- A **transformer**, with any overcurrent protection required by UL or the NEC, to supply the internal control circuit of 120 volts per heater with a step controller for vernier control and 24 volts for all other heaters with SCR control. Wiring to remotely mounted thermostats can be Class II since thermostat circuits are low voltage limited power circuits.
- A built-in, snap-acting **disconnect switch** with door interlock to protect service personnel.
- A choice of room thermostat, page 12, Figure 13 or 14; duct thermostat, page 13, Figure 18 or 19; built-in PE transducer, page 12, Figure 15; or field inputs of 135 ohms, 2200 ohms, 0-10 VDC and 4-20mA are available.

**Table IV**

Single-Phase Voltage	120	208	240	277
Maximum KW	3.0	5.2	6.0	6.0



# Standard Control Options

## Thermostats

### Room Thermostats

#### Single Stage, Catalog No. 1006998

- Built-in thermometer and adjustable heat anticipator
- Range: 50° to 90°F
- Differential: 1°F
- Inductive Rating: 1 amp at 30 volts max.



Figure 11.

#### Two Stage, Catalog No. 1007030

- Two mercury switches operated by a vapor-filled bellows
- Built-in thermometer
- Range: 40° to 80°F
- Differential: 1°F per stage  
Adjustable 1° to 5°F between stages
- Resistive Rating per Heater Stage:  
2.0 amps at 120 volts  
1.0 amp at 240 volts



Figure 12.

#### Electronic Proportional, Catalog No. 1007101

- Tamperproof construction
- Range: 40° to 90°F
- Type: Ohmic – 2200 ohms
- For use with INDEECO S95 step controllers



Figure 13.

#### Electronic Thermostat, Catalog No. 1016941

- C1025 Thermostat is microcomputer-based, PI Control
- Range: 50° to 90°F
- Type: Proportional 0-10 VDC
- For use with INDEECO SCR's and S208 step controllers



Figure 14.

### PE Transducer

#### Catalog No. 1019195

- Built into heater terminal box
- PSIG range: 3 to 20
- Throttling range: 2.5 – 7.5 psi
- Maximum pressure: 30 psi
- Type: Ohmic – 135 ohms
- For use with INDEECO SCR's and step controllers



Figure 15.

# Standard Control Options Thermostats

## Duct Thermostats

### Single Stage Heavy Duty, Catalog No. 1019682

- Hydraulic-action element actuates silver contacts
- Range: 20° to 120°F
- Differential: 4° to 30°F Adjustable
- Bulb Dimensions: 3/8" x 6"
- Capillary Length: 8'
- Resistive Rating:
  - 25 amps at 120 volts
  - 22 amps at 240 volts
  - 18 amps at 277 volts



Figure 16.

### Two Stage Light Duty, Catalog No. 1007044

- Two single-pole, double throw switches
- Adjustable by screw on graduated cam dial
- Range: 55° to 85°F
- Differential: 2°F between stages
- Bulb Dimensions: 5/8" x 11<sup>1</sup>/<sub>16</sub>"
- Capillary Length: 5'6"
- Resistive Rating per Heater Stage:
  - 13.3 amps at 120 volts
  - 6.6 amps at 277 volts



Figure 17.

### Electronic Proportional

Catalog No.: Sensor, 1001083

Adjuster, 1001068

- Range: 60° to 120°F
- Type: Ohmic – 2200 ohms
- For use with INDEECO S95 step controllers



Figure 18.

### Electronic Thermostat

Catalog No.: Sensor, 1016942

Adjuster, 1016941

- Range: 50° to 90°F
- Type: PI Proportional 0-10 VDC
- For use with INDEECO SCR's and S208 step controller



Figure 19.



www.indeeco.com  
800-243-8162

INDEECO offers a broad range of electrical components for temperature, safety, and power control.

For most applications, the Control Option system, described in the previous section, makes it easy to specify a complete control package.

For applications requiring a special control system, the following section describes components, their applications and limitations.

## Bi-Metallic Thermal Cutouts

Both UL and NEC require thermal cutout protection against overheating due to insufficient airflow, air blockage or air failure. Two levels of protection are provided:



Figure 20.

The primary or automatic reset thermal cutout (Figure 20) is a fixed temperature, bi-metallic disc type device which opens when its set point is reached and automatically resets when the temperature falls below its set point. The operating disc and contacts are completely enclosed to prevent infiltration of dirt or physical damage. This single pole device is most often wired into the heater control circuit, but will carry single-phase loads up to 25 amps at 240 volts and 22 amps at 277 volts (See **Table V**). Most heaters have only one automatic reset thermal cutout. However, on large heaters two or more may be supplied, wired in series.

**Table V**

Single-Phase Voltage	120	208	240	277
Maximum KW	3.0	5.2	6.0	6.0

The secondary manual reset thermal cutout (Figure 21) has a temperature setting approximately 50°F (10°C) higher than the automatic reset cutout to provide protection only if the primary system fails. Once it has tripped, it is necessary to press a reset tab to return the heater to operation.



Figure 21.

Open coil heaters use a cutout rated to carry the maximum heater circuit load allowed by UL and NEC: 48 amps at 480 volts. One cutout is supplied for each heater circuit, or group of circuits, drawing 48 amps or less.

Many manufacturers use heat limiters or fusible links which require field replacement when an overtemperature condition occurs. This often involves removing the heater from the duct and always involves ordering replacement heat limiters from the manufacturer. With INDEECO's manual resets, the heater can immediately be put back into operation simply by pressing the reset button.

There is no danger that backup protection will be lost because replacement heat limiters are not available. Furthermore, the services of a qualified electrician are not required, since maintenance personnel can easily reset the manual cutouts.

## Linear Thermal Cutouts



Figure 22.

The linear thermal cutouts (both automatic and manual reset) sensing element (Figure 22) is a fluid-filled capillary tube, strung across the entire heater width.

If any 6" (152 mm) segment of the capillary is overheated, the cutout will de-energize the entire heater, providing additional protection if the airflow is not sufficiently uniform. Furthermore, it is fail safe – it will trip if the capillary loses its fill. These cutouts are normally provided for pilot duty but can carry the heater load directly up to 25 amps, 277 volts, single-phase.

**Custom open coil heaters** – Only one linear automatic and/or one linear manual, set 50°F (10°C) higher than the automatic, may be furnished, in addition to the standard cutouts. They are wired in series with the standard disc type automatic cutout.

**Finned tubular heaters** – Triple overheating protection is standard for finned tubular heaters. In addition to the automatic disc thermal cutout, Figure 20, both automatic and manual reset linear cutouts, Figure 22, are furnished.

An automatic primary linear limit cutout, strung across the top and leaving air face of the coil (Figure 23), protects against overheating caused by low airflow. This device will turn the heater off if the fixed temperature set point is exceeded. It automatically resets when the temperature drops to safe levels.

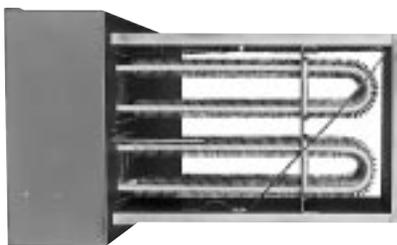


Figure 23.

A manual secondary linear limit cutout protects against failure of the primary overtemperature system. With a fixed temperature setting higher than either of the primary cutouts described above, this device is designed to trip only if both of the primary cutouts stick in the closed position, or controlling contactor points weld together.

## Airflow Switch



Figure 24.

A diaphragm operated differential pressure switch (Figure 24) is normally used to prevent a heater from operating unless air is flowing. The switch is provided with a velocity pick-up tube extending into the duct area, making it sensitive to static pressure as well as velocity pressure.

The switch requires at least .07" (17.4 Pa) of water column pressure difference between the inside and the outside of the duct. If the pressure will be below .07", a fan relay should be substituted as described below.

Airflow switches are normally connected for positive pressure – i.e. for a heater located on the discharge side of a fan. If the heater is on the suction side, the switch may be specified or field converted for negative pressure. In most applications the airflow switch is wired into the heater control circuit, but it can carry the heater load directly up to 15 amps at 277 volts, single-phase.

## Fan Relay

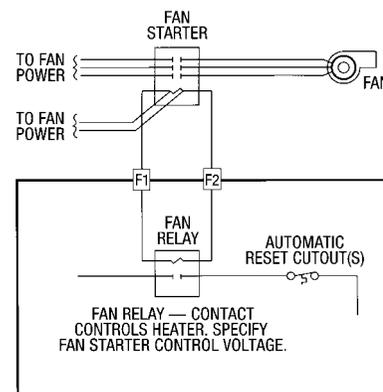


Figure 25.

A fan relay is available as an alternate to the standard airflow switch. It has the advantage of being a positive electrical interlock between the fan and the heater (see Figure 25 for wiring details). Its primary disadvantages are that it requires field wiring back to the fan control circuit and does not protect against conditions such as belt failure. When a fan relay is required, specify the fan starter control voltage. If not specified, it will be assumed to be the same as the heater control voltage. Both a fan relay and an airflow switch can be furnished.



## Magnetic Contactors

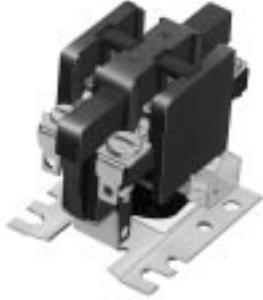


Figure 26.

All magnetic contactors supplied by INDEECO are UL Recognized for limit control duty, as opposed to less severe, general purpose duty. De-energizing contactors, breaking one power line on single-phase circuits and two lines on three-phase, are standard. Disconnecting contactors, breaking all ungrounded conductors, are available when specified. Note that for 120 and 277 volt, single-phase systems, de-energizing and disconnecting contactors are equivalent, since these voltages have only one ungrounded conductor. Both de-energizing and disconnecting models are available for heaters rated up to 600 volts. Contactors are available with holding coil voltages of 24, 120, 208, 240 or 277.

## Mercury Contactors



Figure 27.

For silent operation or longer life under frequent cycling, mercury contactors are preferred. Both de-energizing and disconnecting models are available for heaters rated up to 600 volts. Contactors are available with holding coil voltages of 24, 120, 208, 240 or 277.

## Fuses



Figure 28.

Low resistance fuses are mounted in phenolic fuse blocks fitted with extra tension springs to assure cool connections. To protect against faults in both contactors and heating elements, fuses are located on the line side of contactors built into heaters. To meet NEC requirements for continuous loads, fuses are rated at least 25% above the load they are protecting.

## Control Transformer



Figure 29.

Built-in control transformers are available to supply either 24 or 120 volt control circuits. The transformer primary is factory connected to the main supply and the secondary is wired directly to the built-in control components. Overcurrent protection and secondary grounding are provided when required by UL and the NEC.

## Disconnect Switch



Figure 30.

Built-in disconnect switches are an inexpensive, positive way to meet the NEC requirement for a disconnecting means within sight of the heater, controller(s), and overcurrent protection devices. The switches are interlocked with the heater terminal box cover and have labeled “on” and “off” positions. If there are any external sources of control voltage, a separate toggle switch is provided. Together these devices result in a “dead front” design to protect service personnel. Both fused (up to 48 amps) and unfused switches are available. However, unfused switches are most often specified, as they meet code safety requirements.

## Pilot Lights



Figure 31.

Pilot lights, projecting through the side of the heater terminal box, indicate functional operation. The most commonly specified functions are:

**Heater On** – This indicates that power has been supplied to the heater, but does not necessarily indicate that the control system is calling for heat or that heat is being produced.

**Low Airflow** – This indicates that there is either no airflow, or it is so low that the airflow switch has prevented the heater from operating.

**Each Stage On** – These indicate when each heater stage has been energized. Not available with SCR controlled stages.

## Pilot Switch

A pilot switch is a simple means of de-energizing the heater between seasons or during prolonged shut-downs. The switch is wired in series with contactor holding coils. It cannot be used as a disconnecting means and is therefore labeled with “on” and “standby” positions. If disconnecting contactors are also specified, the switch will have a labeled “off” position in accordance with UL and NEC provisions.

## Pneumatic/Electric (PE) Switches



Figure 32.

Built-in and pre-wired PE switches are available for pneumatic control systems. To minimize field labor, all PE switches are factory piped to a single port projecting through the terminal box. Pneumatic connections may therefore be made without interfering with electrical connections. Standard switches close on pressure rise, resulting in a fail-safe system since a loss of pressure de-energizes the heater. “Open on rise” switches are available on custom heaters for special applications.

PE switches can either be used as pilot duty devices, or to carry heater loads up to 22 amps, 480 volts, single-phase.

PE switches are limited to six stages because it is difficult to calibrate more switches and still maintain proper staging. For more than six stages, specify a step controller (described on pages 19 and 20) with a pneumatic transducer (described on page 12).



## Electronic Controls

INDEECO's controls division is the recognized industry leader in designing and manufacturing electronic controls for electric heating equipment. Controllers manufactured by INDEECO are precise and compatible with the latest HVAC control systems.

INDEECO duct heaters may be specified with SCR power controllers or electronic step controllers. While these devices are inherently different, they have certain common characteristics:

- **Input Flexibility** – Normally supplied with a thermostat, controls can be used with many field-supplied ohmic sensors or electronically generated control signals such as proportional milliamp or DC voltages. Thus they are compatible with virtually any field-installed control system.
- **Low Voltage Control** – NEC Class 2 field wiring may be used on the thermostat circuits of all controls.
- **High Ambient Temperature Rating** – All units are designed for full load operation in high ambient temperatures, making them particularly suitable for use in duct heater terminal boxes and remote control panels.
- **Fail Safe Circuitry** – In the event of either a short or open circuit in the thermostat leads, all controls de-energize the heaters, protecting the heaters from runaway overheating conditions.
- **LED Function Indicator** – Light emitting diodes (LED pilot lights) indicate the operating status of the controls. On SCR power controllers, the LED shows when the heater is on, indicating the percentage output being provided to the heater. On step controllers, LED's show when control power is on and the status of each heater stage.
- **Continuous Feedback** – Logic and control circuits continuously monitor the input signal to determine if more or less heat is required. Appropriate action is then taken automatically.

## SCR Power Controllers

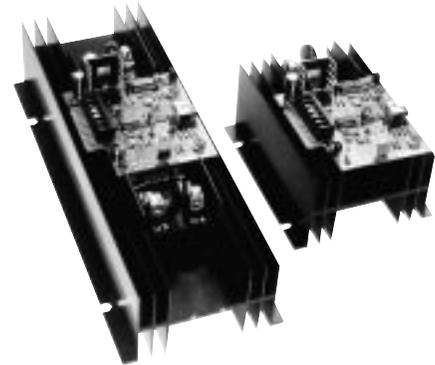


Figure 33. A & B Series for indoor use

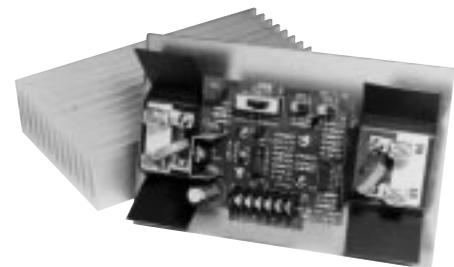


Figure 34. Series 103 for outdoor and dusty applications

The advanced programming and circuitry of the A&B Series and the Series 103 SCR's provides multi-purpose operation and field-switchable temperature control inputs for 4-20 milliamps, 0-10 VDC, 135 ohms, and 2200 ohms.

SCR power controllers modulate the entire heater load, varying the heater output from 0 to 100% of the total heater KW. Working on a one second time base, the heater will be energized only for the number of AC cycles necessary to produce the exact amount of heat required. The resulting precision control and rapid response make the INDEECO SCR the choice for many heating applications. For example, multi-stage discharge temperature control of a heater can produce unacceptable temperature swings, resulting in poor comfort levels and inefficient energy use. The same heater controlled by an SCR and a sensitive duct thermostat will produce stable, even heat for maximum comfort and efficiency.

The SCR's power switching devices are mounted on a large finned heat sink which extends outside the heater terminal box or control panel. The conservative SCR rating (no more than 75% of the manufacturer's rating) and this generous heat sink insures against overheating and SCR failure.

Both single-phase and three-phase SCR's are available as are master and slave units. Each master is capable of driving multiple slaves, giving a capability for 100%, fully proportional SCR control. However, when the load exceeds that tabulated in **Table III** on page 11, it is more economical to combine SCR's with an INDEECO step controller in a vernier configuration. See page 21.

The SCR is switched on only as the voltage wave form crosses the zero point, which virtually eliminates radio frequency interference (RFI). All 480 and 600 volt SCR's have a 1200 peak inverse voltage (PIV) rating and transient absorbers that protect them from the high voltage spikes found on 480 and 600 volt lines.

Except on small, single-phase heaters where the heater load can be carried directly by the automatic thermal cutout (see **Table V**, page 14), all heaters with SCR's require safety contactors for operation of the primary overtemperature protection system.

## Step Controllers (Sequencers)



Figure 35. Electronic Sequencers

INDEECO S95 step controllers can handle simple multi-stage control to sophisticated vernier systems. The advanced programming and circuitry of the S95 provides multi-purpose operation and field-switchable temperature control inputs for 4-20 milliamps, 0-10 VDC, 135 ohms, and 2200 ohms.

In addition to those previously listed features, S95 step controllers have the following important advantages:

- They de-energize and recycle all stages upon momentary power interruption to avoid heavy line surges and to provide a soft start when power is restored.
- Adjustable time delay of 5 seconds to 10 minutes between stages can be field programmed. For span settings for each input, see **Table VI** on page 21.
- Both master and slave units are available, each with 5 or 10 stages of operation. Up to 20 stages may be controlled with master slave combinations. Each S95 step controller is factory programmed for the exact number of stages required.
- The number of stages energized with a proportional S95 step controller is directly proportional to the input signal (normally DC volts or milliamps). Proportional step controllers are used with many building management systems.
- When the S95 step controller is ordered with an INDEECO-furnished thermostat (room or duct type), it is pre-programmed as a dead-band control which adjusts the number of stages "on" to satisfy the thermostat's set point.



## Step Controllers (Microprocessor-based)



Figure 36. Microprocessor-based S208

INDEECO's microprocessor-based S208 step controller provides temperature control for staged and vernier systems up to 4 stages. The S208 has many of the same advanced features as the S95 step controller but is designed for use with smaller heaters. The S208 includes the following unique features:

- Two to four stage control.
- Vernier control for heaters up to 240 amps.
- Field-switchable temperature control inputs for 4-20 milliamps and 0-10 VDC.
- Class II – 24 VAC, designed to be used in a low voltage 24 VAC Class II circuit.
- Time delay, the rate the stages are turned ON or shut OFF, is determined by a field-adjustable 1-75 second time delay.
- Proportional control, the number of stages turned ON, is proportional to the input signal.
- The S208 is available with model C1025 room thermostat (page 12, Figure 14) or with a duct sensor for duct temperature control (page 13, Figure 19).

While standard INDEECO SCR's and step controllers satisfy the majority of HVAC applications, a much broader range of special capabilities is also available with INDEECO custom heaters.

- **Close Tolerance Controller** – When used with a properly designed system, this modified SCR is capable of maintaining tight temperature control in a controlled space such as clean rooms and calibration labs.
- **Fan Motor Controls** – In addition to control of the heater, it is often desirable to control and power the fan through the heater. The heater is designed so that the electrician brings only one power circuit into the terminal box which is subdivided for fan power. The motor controller, overloads and overcurrent protection for this auxiliary fan circuit and motor will be provided.
- **Low Limit Discharge Control** – A thermostat is placed in the occupied area which has primary control of the heater. A second thermostat is placed in the discharge duct which is set for a predetermined minimum discharge temperature and will override the room thermostat if the discharge temperature falls below the duct sensor set point. This prevents cold air from being discharged into the occupied area.
- **Temperature Averaging** – Multiple sensors with a single set point are placed in different zones or in several locations of a large area such as a warehouse. The controller averages the readings of all the sensors to determine the heater output. This design is also used in the hot deck of multizone units.

## Vernier Proportional Control

Recommended for large KW heaters, the economical vernier control system offers many of the advantages of full SCR control. One vernier heater stage is connected to a slave SCR controller. Additional stages are sequenced on and off while the SCR-vernier stage automatically fills the gap between the step controlled stages, providing full proportional control over the entire heater KW range. Both the slave SCR-vernier stage and the step-controlled stages are controlled by the step controller. The vernier system is normally recommended for heaters drawing more than 96 amps for three-phase or 192 amps for single-phase (see **Table III**, Page 11).

For proportional vernier control systems used with building management systems, INDEECO recommends that the SCR stage be sized the same KW as the non-SCR stages to obtain the optimum control. See Figure 37A.

For dead-band vernier control with INDEECO furnished thermostats, the SCR stage is usually 25 to 50 percent larger than the non-step controlled heating stages to obtain the optimum control. See Figure 37B.

## Thermostats/Inputs for Electronic Controls

A tamperproof electronic proportional room thermostat (as described on page 12, Figure 13) is standard, but a duct type electronic proportional thermostat (shown on page 13, Figure 18) can be alternately specified. An accessory PE transducer (shown on page 12, Figure 15) is available for pneumatic operation. When a special thermostat or field-installed control is used, the controller can be specified with any of the inputs listed in **Table VI**.

**Table VI**

**Typical Thermostat Inputs Available for Step Controllers & SCR's**

Inputs	Spans (Factory Set)	
	SCR's	S95 Step Controller
2200 ohms	100 ohms	20-400 ohms (adjustable)
135 ohms	100 ohms	120 ohms
4-20 mA*	12.8 mA	15 mA
0-10 VDC	8.0 VDC	9 VDC

\* Standard input impedance is 250 ohms  
All inputs listed are available with QUA and QUZ type heaters. These inputs plus a variety of other inputs are available with custom heaters.

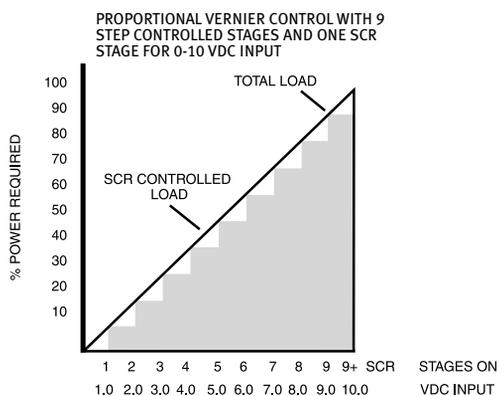


Figure 37A.

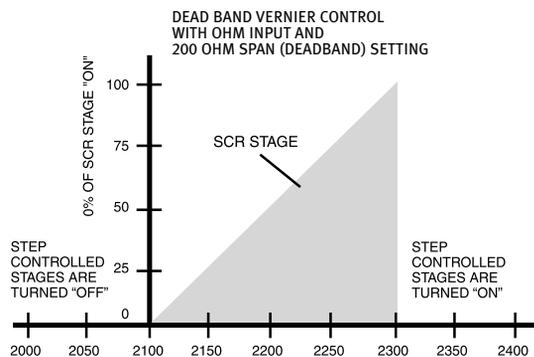


Figure 37B.



## Slip-In Heaters

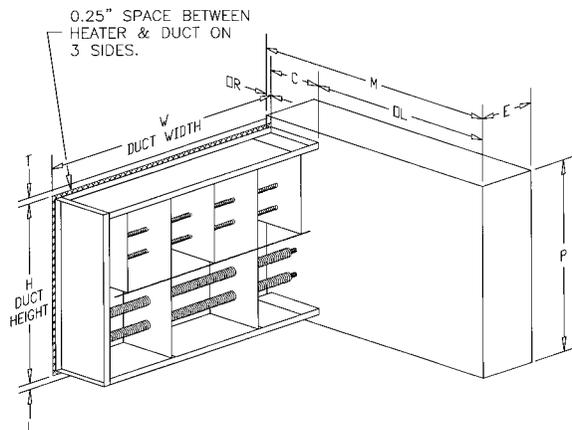


Figure 38.

Slip-in heaters are designed so that the entire frame, except the terminal box, slips into the duct with 1/4" (6.35mm) clearance all around. It is installed, as shown in Figure 8 on page 8, through a rectangular opening in the side of the duct and held in place with sheet metal screws through the back of the terminal box, which is large enough to provide a seal with the duct. Figure 38 illustrates the construction and provides reference dimensions.

Slip-in construction is used because it allows duct work to be installed before the heaters are available, simplifies on-the-job changes in heater location, and is easily retrofitted into existing duct systems. Furthermore, small slip-in heaters may be installed without any special provisions for their support.

While custom slip-in heaters can be provided to fit specific duct dimensions (W x H), selecting standard open coil type QUA frame sizes maximizes economy and minimizes delivery times.

## Flanged Heaters

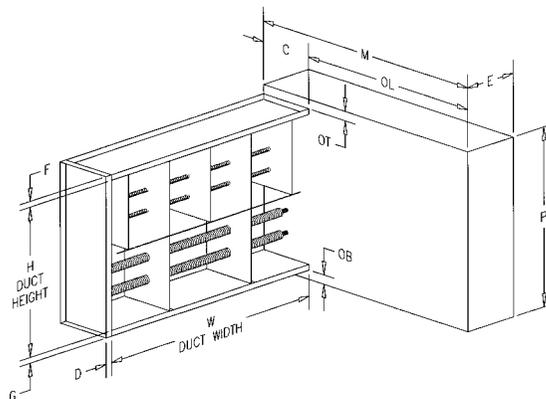


Figure 39.

Flanged construction is available with inside face dimensions exactly matching the duct dimensions. The heater frame is attached to matching turned out duct flanges as illustrated in Figure 9 on page 8. Standard flanges are a minimum of 3/4" deep; deeper flanges are provided on larger heaters for structural reasons. Custom flanges can be provided upon request. Figure 39 illustrates flanged heater construction and provides reference dimensions.

## Zero Clearance Construction

Slip-in and flanged heaters are UL Listed for zero clearance, allowing combustible material to be placed directly against exposed surfaces of the heater or surrounding duct work. Although this construction is not required by UL on heaters above 50 KW, INDEECO supplies it on all heaters regardless of KW. However, incorrect mounting will void the UL Listing, and may make the installation unsafe.

## Physical Standards

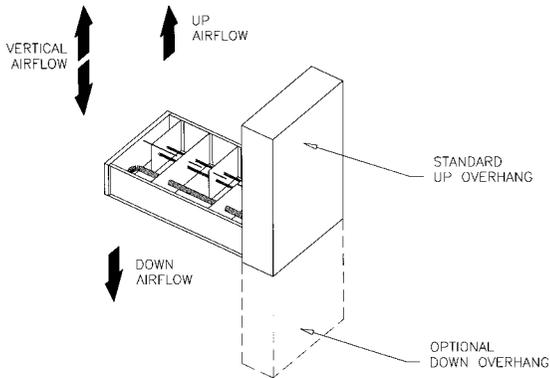


Figure 40.

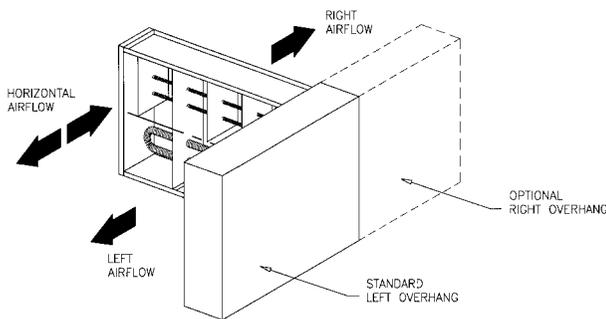


Figure 41.

Standardized dimensions and terminology avoid errors and confusion. The most common dimensions are defined in Figures 38 and 39.

Figures 40 and 41 illustrate airflow terminology. Most INDEECO open coil type heaters are suitable for horizontal or vertical airflow, but for finned tubular type heaters or heaters with pressure plates, exact airflow direction (right, left, up or down) must be specified.

In most heaters, the terminal box is significantly larger than the heater frame in at least one direction. This is referred to as the terminal box overhang, defined in Figures 40 and 41. For horizontal airflow, left overhang is standard. For vertical airflow, up overhang is standard. Optional right and down overhangs are also available.

## Heater Frame and Terminal Box

Frames and terminal boxes are fabricated from heavy gauge corrosion resistant steel. Optional stainless steel frames are recommended for wet or corrosive applications. Standard NEMA 1 terminal boxes have hinged covers.

Knockouts are provided for all field connections. Open coil heater element support brackets are spaced on 4.5" (114 mm) maximum centers to avoid coil sag, even under the most extreme operating conditions. Strengthening ribs on the brackets insure that coils are held in their proper location, even on large heaters.

Finned tubular heater element support brackets are spaced on 36" (914 mm) maximum centers.



# Standard Duct Heaters

## Open Coil

### QUA Slip-In and QUZ Flanged Heaters



Figure 42.

INDEECO has developed QUA (Figure 42) and QUZ (Figure 44) heater lines to satisfy most typical space heating requirements, simplifying specification, ordering and delivery.

Both standard and quick ship delivery programs are available for the full line of QUA and QUZ heaters.

### KW Ratings

QUA and QUZ heaters are available up to 458 KW. The KW ratings are limited both by frame size and electrical characteristics. Heater availability can be determined by contacting an INDEECO representative, who can provide a computerized heater selection with exact heater dimensions in minutes.

### Frame Sizes

The use of a standard QUA frame size will both reduce cost and permit rapid shipment. The 240 QUA frame sizes match popular duct sizes. For other duct sizes, INDEECO can either manufacture a custom frame size, or the heater's width and height dimensions can be determined using the 80% Rule, which in most cases will allow the use of a standard QUA frame size.

**The 80% Rule** – INDEECO recommends the heater should occupy at least 80% of the actual inside area of the duct as shown in Figure 43. Only small amounts of air will bypass the heater around its perimeter and normal turbulence will rapidly mix this unheated air with heated air downstream.

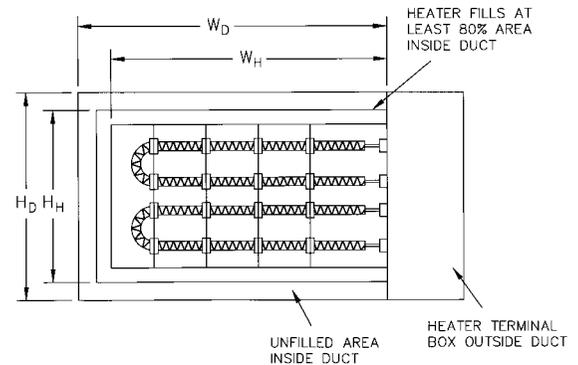


Figure 43.

All QUA heaters may be installed in ducts with up to 1" of interior lining, but the heater must be selected to fit the inside duct dimensions. For example, to fit a duct with 36" x 16" outside dimensions, but with 1" of interior insulation, specify a 35" x 14" heater.

QUZ flanged type heaters are available to fit 216 duct sizes. QUZ cannot be used with interior lined ducts. INDEECO can manufacture a custom frame size to meet virtually any application.



Figure 44.

# Standard Duct Heaters

## Open Coil

Table VII  
 Sizes and Maximum KW Ratings

		Duct Height									
		6"	8"	10"	12"	14"	16"	18"	20"	24"	30"
Duct Width	8"	7	10	14	17	21	23	26	29	36	46
	10"	9	13	17	22	26	29	34	38	46	59
	12"	11	16	21	27	32	36	41	46	56	72
	14"	13	18	25	31	37	42	48	54	67	85
	16"	15	21	28	36	43	49	56	63	77	98
	18"	17	24	32	40	48	55	63	71	87	111
	20"	19	27	36	45	54	61	70	79	97	123
	22"	21	29	39	49	59	68	78	87	107	136
	24"	23	32	43	54	65	74	85	96	117	149
	26"	25	35	47	59	71	81	92	104	127	162
	28"	27	38	51	63	76	87	100	112	137	175
	30"	29	41	54	68	82	94	107	121	147	188
	32"	31	43	58	72	87	100	114	129	158	201
	34"	32	46	62	77	93	107	122	137	168	214
	36"	34	49	65	82	98	113	129	145	178	226
	38"	36	52	69	86	104	119	136	154	188	239
	40"	38	54	73	91	109	126	144	162	198	252
	42"	45	57	76	95	115	132	151	170	208	265
	44"	47	60	80	100	120	139	159	178	218	278
	48"	52	65	87	109	131	152	173	195	238	304
	54"	58	74	98	123	148	171	195	220	269	342
60"	65	82	109	137	164	190	217	245	299	381	
66"	71	90	120	151	181	209	239	269	329	419	
72"	78	98	131	164	197	229	262	294	360	458	

### Type QUA Slip-in Heater

Maximum KW ratings in available frame sizes shown at left.

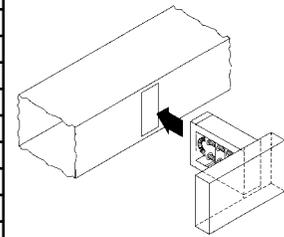


Figure 45.  
 Installation of Slip-in Heater

		Duct Height								
		6"	8"	10"	12"	14"	16"	18"	22"	28"
Duct Width	8"	11	14	18	22	25	29	33	40	51
	10"	13	18	22	27	32	36	41	50	64
	12"	16	22	27	33	38	44	49	60	77
	14"	19	25	32	38	45	51	57	70	90
	16"	22	29	36	44	51	58	66	80	102
	18"	24	33	41	49	57	66	74	91	115
	20"	27	36	45	55	64	73	82	101	128
	22"	30	40	50	60	70	80	91	111	141
	24"	33	44	55	66	77	88	99	121	154
	26"	35	47	59	71	83	95	107	131	167
	28"	38	51	64	77	90	102	115	141	180
	30"	41	55	68	82	96	110	124	151	193
	32"	44	58	73	88	102	117	132	161	205
	34"	46	62	78	93	109	125	140	171	218
	36"	49	66	82	99	115	132	148	182	231
	38"	52	69	87	104	122	139	157	192	244
	40"	55	73	91	110	128	147	165	202	257
	42"	57	77	96	115	135	154	173	212	270
	44"	60	80	101	121	141	161	182	222	283
	48"	66	88	110	132	154	176	198	242	308
	54"	74	99	124	148	173	198	223	273	347
60"	82	110	137	165	193	220	248	303	386	
66"	91	121	151	182	212	242	273	333	424	
72"	99	132	165	198	231	264	297	364	458	

### Type QUZ Flanged Heater

Maximum KW ratings in available frame sizes shown at left.

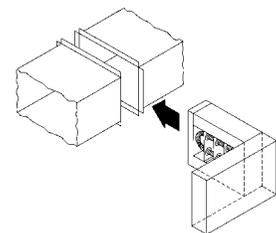


Figure 46.  
 Installation of Flanged Heater

Note: Maximum KW ratings may vary based on voltage and phase combination.

# Standard Duct Heaters

## Open Coil

### Detail Dimensions

The wide variety of QUA and QUZ (Figures 45 and 46) heaters makes it impractical to list the exact heater dimensions for every possible heater. For dimensional details, contact your local INDEECO representative.

### Voltage and Phase

Heaters are available in the voltage and phase combinations shown below. All are for operation at 50 or 60 Hz.

When three-phase is specified, each heating stage will be furnished with a multiple of three elements to give a balanced three-phase load.

Voltage	120 208 240 277	208 240 380 400 415 480 600
Phase	1	3

### Control Circuit Options & Special Features

QUA and QUZ heaters are available with Control Options G, J and K and a full range of Special Features. These are described briefly in **Table VIII** and in more detail in the standard Control Options section of this catalog, pages 10 and 11.

### Number of Heating Stages

Single and three-phase QUA and QUZ heaters are available with multiple heating stages. To comply with our UL and NEC maximum circuit sizes, no stage is rated at more than 48 amps.

**Table VIII**  
**Control Options**

Control Option	Disconnect Switch	Thermal Cutouts	Airflow Switch	Contactors	Control Transformer	Fuses	PE Switches	SCR	Thermostat
G Basic	■	■	■	■	■	■ <sup>1</sup>			
J Pneumatic	■	■	■	■ <sup>2</sup>	■ <sup>3</sup>	■ <sup>1</sup>	■		
K Proportional	■	■	■	■ <sup>2</sup>	■	■ <sup>1</sup>		■	■ <sup>4</sup>

- Notes: 1. Fuses supplied only on heaters over 48 amps.  
 2. Contactors supplied only when other devices cannot carry heater load.  
 3. Transformer only supplied on heaters rated higher than 277 volts.  
 4. Choice of room or duct thermostat, 135 ohms, 2200 ohms, 0-10 VDC or 4-20 mA inputs.  
 See pages 12 and 13 for full description of thermostats.

# Standard Duct Heaters

## Open Coil

### Special Features

While QUA slip-in and QUZ flanged heaters may be specified with one of the standard control circuit options, individual job requirements may demand slight variations from the standards. The most common variations are covered by INDEECO's set of Special Features which may be used to modify QUA/QUZ

heaters both mechanically and electrically. These are listed in **Table IX** with a brief description, availability and notes on any limitations of their use.

**Table X** provides a summary of thermostats offered with INDEECO QUA/QUZ heaters. See pages 12 and 13 for more detailed descriptions.

Table IX

Special Feature	Special Feature Code (SFC)	Description	Page Ref.	Availability & Limitations
<b>Mechanical</b>				
Substitute Negative Pressure Airflow Switch	Q5/Q6	Allows heater to be used on inlet side of fan.	15	Available on all heaters.
Vertical Airflow	U9	Allows heater to be used in applications where airflow is either vertical up (U3) or vertical down (U5).	23	Available on all heaters.
Right/Down Terminal Box Overhang	L4/L5	Heater will be supplied with terminal box overhang on right (if horizontal airflow installation) or downward (if vertical airflow installation).	23	Available on all heaters.
Insulated Terminal Box	B2	Prevents condensation inside terminal box when heater is installed in air conditioning duct running through un-airconditioned area.	37	Available on all heaters.
Dust-Tight Terminal Box	B7	Allows installation in dusty areas and satisfies local codes requiring dust-tight box if installed in area used as return air plenum.	36	Available on all heaters.
Remote Panelboard	B5	All controls except thermal cutouts, airflow switch and a pilot switch will be supplied in a separate NEMA 1 panelboard.	39	Available on all heaters except when transformer and contactors are deleted.



# Standard Duct Heaters

## Open Coil

Table IX (continued)

Special Feature	Special Feature Code (SFC)	Description	Page Ref.	Availability & Limitations																				
<b>Electrical</b>																								
Delete Transformer	—	Allows control circuit to be obtained from source outside the heater or, when line voltage is equal to control voltage, directly from power lines within the heater.	16	Only available on Option G heaters. Must be specified if control voltage is not 120 or 24 volts. Customer must specify control volts.																				
Delete Transformer & Contactors	—	Allows for control of heater directly using load carrying thermostats.	16	Available only on single stage, single-phase, Option G heaters with KW not exceeding the following:  <table border="1"> <thead> <tr> <th>Voltage</th> <th>120</th> <th>208</th> <th>240</th> <th>277</th> </tr> </thead> <tbody> <tr> <td>Max. KW</td> <td>1.8</td> <td>3.1</td> <td>3.6</td> <td>4.1</td> </tr> </tbody> </table>	Voltage	120	208	240	277	Max. KW	1.8	3.1	3.6	4.1										
Voltage	120	208	240	277																				
Max. KW	1.8	3.1	3.6	4.1																				
Delete Disconnect	—	Allows for use of field installed disconnecting means. (Must be within sight of the heater.)	17	Available on all heaters.																				
Add Fuses for Heaters Rated 48 Amps or Less	F1	Allows for addition of one set of fuses to low amperage heaters that do not need internal fusing to meet UL and NEC requirements.	16	Available on all heaters whose KW is lower than or equal to the following. (Other heaters include fusing as standard):  <table border="1"> <thead> <tr> <th rowspan="2">Line Volts</th> <th colspan="2">KW (at 48 amps)</th> </tr> <tr> <th>1 Phase</th> <th>3 Phase</th> </tr> </thead> <tbody> <tr> <td>120</td> <td>5.7</td> <td>—</td> </tr> <tr> <td>208</td> <td>9.9</td> <td>17.2</td> </tr> <tr> <td>240</td> <td>11.5</td> <td>19.9</td> </tr> <tr> <td>277</td> <td>13.2</td> <td>—</td> </tr> <tr> <td>480</td> <td>23.0</td> <td>39.9</td> </tr> </tbody> </table>	Line Volts	KW (at 48 amps)		1 Phase	3 Phase	120	5.7	—	208	9.9	17.2	240	11.5	19.9	277	13.2	—	480	23.0	39.9
Line Volts	KW (at 48 amps)																							
	1 Phase	3 Phase																						
120	5.7	—																						
208	9.9	17.2																						
240	11.5	19.9																						
277	13.2	—																						
480	23.0	39.9																						
Add "Stage On" Pilot Light(s)	P1	To indicate when each heating stage is producing heat.	17	Available on all heaters except Option K SCR stages.																				
Add "Low Airflow" and "Heater On" Pilot Lights	P2, P3	Separate pilot lights to indicate that power has been supplied to the heater and it is ready for operation and whether airflow has been interrupted.	17	Available on all heaters. When fan relay has been substituted for airflow switch, only "Heater On" will be supplied.																				
Substitute Disconnecting Contactors	C1, C3	To meet local codes which require that contactors break all ungrounded conductors.	16	Available on all Option G heaters, all three-phase Option J & K, and single-phase Option J & K heaters whose KW exceeds the following (lower KW single-phase heaters do not use contactors):  <table border="1"> <thead> <tr> <th>Voltage</th> <th>120</th> <th>208</th> <th>240</th> <th>277</th> </tr> </thead> <tbody> <tr> <td>KW Opt. J</td> <td>1.8</td> <td>3.1</td> <td>3.6</td> <td>4.1</td> </tr> <tr> <td>KW Opt. K</td> <td>3.0</td> <td>5.2</td> <td>6.0</td> <td>6.0</td> </tr> </tbody> </table>	Voltage	120	208	240	277	KW Opt. J	1.8	3.1	3.6	4.1	KW Opt. K	3.0	5.2	6.0	6.0					
Voltage	120	208	240	277																				
KW Opt. J	1.8	3.1	3.6	4.1																				
KW Opt. K	3.0	5.2	6.0	6.0																				

# Standard Duct Heaters

## Open Coil

Table IX (continued)

Special Feature	Special Feature Code (SFC)	Description	Page Ref.	Availability & Limitations																								
<b>Electrical (cont.)</b>																												
Substitute Mercury Controlling Contactors	C2	For silent operation or where long term reliability is crucial. Only controlling contactors will be mercury. Any safety contactors will be magnetic, as they rarely operate.	16	Available on Option G & J* heaters when KW per stage does not exceed the following: <table border="1" style="margin: 10px auto; border-collapse: collapse;"> <thead> <tr> <th colspan="6" style="text-align: center;">KW/Stage</th> </tr> <tr> <th style="text-align: left;">Volts</th> <th style="text-align: center;">120</th> <th style="text-align: center;">208</th> <th style="text-align: center;">240</th> <th style="text-align: center;">277</th> <th style="text-align: center;">480</th> </tr> </thead> <tbody> <tr> <td style="text-align: left;"><b>1 Ph.</b></td> <td style="text-align: center;">4.2</td> <td style="text-align: center;">7.2</td> <td style="text-align: center;">8.4</td> <td style="text-align: center;">9.6</td> <td style="text-align: center;">16.8</td> </tr> <tr> <td style="text-align: left;"><b>3 Ph.</b></td> <td style="text-align: center;">—</td> <td style="text-align: center;">12.6</td> <td style="text-align: center;">14.5</td> <td style="text-align: center;">—</td> <td style="text-align: center;">29.0</td> </tr> </tbody> </table> <p>* No contactors required in Option J heaters per <b>Table II</b>, page 10.</p> <p>Available on option K heaters only when total KW exceeds values shown in <b>Table III</b>, page 11. (Controlling contactors used only with the vernier control system.)</p>	KW/Stage						Volts	120	208	240	277	480	<b>1 Ph.</b>	4.2	7.2	8.4	9.6	16.8	<b>3 Ph.</b>	—	12.6	14.5	—	29.0
KW/Stage																												
Volts	120	208	240	277	480																							
<b>1 Ph.</b>	4.2	7.2	8.4	9.6	16.8																							
<b>3 Ph.</b>	—	12.6	14.5	—	29.0																							
Fan Relay	N	When static pressure in the duct is too low (below .07" WC) to operate the airflow switch or when airflow switch is not desired.	15	Available on Option G & K heaters except Option G heaters where deletion of contactors and transformer is specified.																								
Add INDEECO Electronic Step Controller	S	Allows better temperature control of high capacity heater by using multiple stages controlled by electronic thermostat and step controller.	19-20	Only available on Option G heaters with 2 or more heating stages. NOT AVAILABLE ON ORDERS FOR 1 WEEK OR 72 HOUR DELIVERY.																								
Low Watt Density Coils	D3, D4	To meet specifications which call for low watt density coils.	—	Available on all heaters.																								
Add Built-in PE Transducer	E32, S19	To allow for pneumatic control.	12	Available on Option K heaters or on Option G heaters with step controller and 6 or more stages.																								
Transformer Primary Fusing	T1	Add transformer primary fusing.	—	Available with all heaters with built-in transformer.																								



# Standard Duct Heaters

## Open Coil

Table X

Summary of Thermostats Available with Option G or K Heaters (No Thermostats are supplied on Option J Heaters)

Type of Thermostat		Use with Control Option	Catalog Number	Comments	
R O O M	Pilot Duty	1 Stage	G	1006998 (Fig. 11)	Rated for 30 volts max.
		2 Stage	G	1007030 (Fig. 12)	Rated for 240 volts max.
	† Proportional Electronic		G or K	SCR Controlled or 2-4 Stages 1016941 (Fig. 14) Vernier Controlled or over 4 Stages 1007101 (Fig. 13)	With Option G, can be used only when step controller is also specified.
D U C T	Pilot Duty	1 Stage	G	1019682 (Fig. 16)	Rated for 277 volts max.
		2 Stage	G	1007044 (Fig. 17)	Rated for 240 volts max.
	† Proportional Electronic		G or K	SCR Controlled or 2-4 Stages 1016942, 1016941 (Fig. 19) Vernier Controlled or over 4 Stages 1001083, 1001068 (Fig. 18)	With Option G, can be used only when step controller is also specified.
† No Thermostat (Special inputs for controller or SCR when customer supplied thermostat is used)		G or K	— — —	2200 ohm Input 135 ohm Input 4-20 mA Input 0-10 VDC Input	

†A thermostat or input must be specified with all Option K heaters and all Option G heaters with step controllers. Step controllers with 4-20 mA or 0-10 VDC will be furnished with proportional control.

# Standard Duct Heaters

## Open Coil

### QUA/QUZ – Sample Specification

A job specification can be prepared by using the following information. Simply darken the applicable circles. Material which is part of the basic specification has already been darkened. Additional copies of this specification guide are available from your local INDEECO representative.

- 1. Duct heaters shall be INDEECO
  - Type QUA Standard Slip-in Heaters
  - Type QUZ Standard Flanged Heaters
- 2. Approvals – Heaters and panelboards (if required) shall meet the requirements of the National Electrical Code and shall be listed by Underwriters Laboratories for zero clearance to combustible surfaces and for use with heat pumps and air conditioning equipment.
- 3. Heating elements shall be open coil, 80% nickel, 20% chromium, Grade A resistance wire. Type C alloys containing iron or other alloys are not acceptable. Coils shall be machine crimped into stainless steel terminals extending at least 1" into the airstream and all terminal hardware shall be stainless steel. Coils shall be supported by ceramic bushings staked into supporting brackets.
- 4. Heater frames and terminal boxes shall be corrosion resistant steel. Unless otherwise indicated, the terminal box shall be NEMA 1 construction and shall be provided with a hinged, latching cover and multiple concentric knockouts for field wiring.
- 5. All heaters shall be furnished with a disc type, automatic reset thermal cutout for primary overtemperature protection. All heaters shall also be furnished with disc type, load carrying manual reset thermal cutouts, factory wired in series with heater stages for secondary protection. Heat limiters or other fusible overtemperature devices are not acceptable.
- 6. Heaters shall be rated for the voltage, phase and number of heating stages indicated in the schedule. All three-phase heaters shall have equal, balanced, three-phase stages. All internal wiring shall be stranded copper with 105°C insulation and shall be terminated in crimped connectors or box lugs.
- 7. Terminal blocks shall be provided for all field wiring and shall be sized for installation of 75°C copper wire rated in accordance with NEC requirements.
- 8. Heaters shall be furnished either with the Control Option specified in the schedule and described below or with the specific components listed in the schedule.
  - Option G – Thermal cutouts, airflow switch, contactors, fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.
  - Option J – Thermal cutouts, airflow switch, PE switches, contactors (where required), fuses (if over 48 amps), control circuit transformer (where required), and built-in, snap-acting, door interlocked disconnect switch.
  - Option K – Thermal cutouts, airflow switch, SCR (with step controller if heater draws over 96 amps three-phase or 192 amps single-phase), fuses (if over 48 amps), control circuit transformer and built-in, snap-acting, door interlocked disconnect switch.
- 9. When specified in the schedule, or below, heaters will be supplied with the following Special Features:
  - Airflow switch for negative pressure operation
  - Insulated terminal box
  - Dust-tight terminal box
  - Controls mounted in NEMA 1 type remote panelboard
  - Deletion of transformer
  - Deletion of transformer and contactor
  - Transformer primary fusing
  - Deletion of disconnect switch
  - Fuses for heaters rated 48 amps or less
  - "Low Airflow" pilot light
  - "Heater On" pilot light
  - Each "Stage On" pilot light(s)
  - Disconnecting contactors
  - Mercury controlling contactors
  - Fan relay (instead of airflow switch)
  - Fan relay (in addition to airflow switch)
  - Step controller
  - 25 watt per square inch resistance coils
  - 35 watt per square inch resistance coils
  - Built-in PE transducer
- 10. When specified in the schedule, or below, heaters shall be supplied with the following thermostats:
  - Pilot duty single stage room thermostat
  - Pilot duty two stage room thermostat
  - Proportional electronic room thermostat
  - Pilot duty single stage duct thermostat
  - Pilot duty two stage duct thermostat
  - Proportional electronic duct thermostat with set point adjuster
  - Special inputs (135 ohms, 2200 ohms, 4-20 mA, 0-10 VDC)
- 11. Duct Heater Schedule – Use of the following typical format will insure that all necessary information is available to bidders:

Item or Tag #	Heater Type	KW	Duct Dimensions (Inches)		Supply Line		No. of Heating Stages	Control Circuit Voltage	Control Option	Special Features	Thermostats
			W (Width)	H (Height)	Volts	Phase					
H -1	QUA	10	24	12	208	3	2	24	G	Vertical Airflow Pilot Light	Room
H -2	QUZ	15	16	12	240	3	1	240	J	Insulated Terminal Box	None
H -3	QUA	39.9	38	24	480	3	1	24	K	Remote Panelboard	Duct

# Standard Duct Heaters

## Finned Tubular

### TFQU Standard Slip-In Finned Tubular Duct Heaters

The TFQU line of finned tubular duct heaters offers a quick ship alternative to our line of completely custom designed heaters (Figure 47). The greatly reduced lead-time is achieved by limiting the frame and KW offerings. The following is a summary of the custom features we have made available as part of the TFQU program.

**Twenty-three Frame Sizes**, ranging from 12" x 6" to 36" x 24". Heaters need not match duct sizes exactly as long as the duct is large enough to accommodate the heater frame and has no more than 1" of lining. Select a slightly smaller heater filling at least 80% of the duct area. See page 24 which explains how to size slip-in heaters with the 80% Rule.

**KW Ratings** ranging from 1 KW through 40 KW.

**Three Basic Control Circuit Options** and limited Special Features meet the vast majority of installation requirements.

**UL Listed** for zero clearance to combustible surfaces and conforms to National Electrical Code requirements.

These standardized heaters are particularly adaptable to remodeling jobs, contractor-designed jobs and jobs requiring quick completion.

Control Options G, J and K are available for all TFQU frame sizes. Option K controls are single stage only. Reference sample specification on page 34 for descriptions.



Figure 47.

### How To Order

Selection of a heater from our TFQU program is best done in consultation with an INDEECO sales representative. The information listed below is required to place an order. Contact the local representative for pricing and heater selection.

1. **Standard Slip-in Heaters** – Indicate Type TFQU for quick delivery option.
2. **KW Rating.**
3. **“W” and “H” Dimensions.**
4. **Voltage and Phase** – 277 volts available in single-phase only. 480 volts available in three-phase only. 208 and 240 volts available in either single or three-phase.
5. **Number of Stages.**
6. **Control Circuit Voltage** – It is only necessary to specify control circuit voltage for Option G. Either 24 or 120 volt is available.
7. **Control Option** – Option G, J or K are available. With Option K only, a room thermostat will be furnished unless a duct thermostat, input (135 ohms, 2200 ohms, 0-10 VDC, 4-20 mA) or PE transducer is specified. See page 33 for details.
8. **Airflow** – Specify left, right, up or down as illustrated on page 33.
9. **Terminal Box Overhang** – For left or right airflow, left overhang is standard, right overhang is optional. For up or down airflow, up overhang is standard, down overhang optional.
10. **Special Features** – Specify as required from the features listed in **Table XII**, page 33.

# Standard Duct Heaters Finned Tubular

## Airflow Direction and Terminal Box Overhang

For proper positioning of the terminal cutouts, the airflow direction must be specified on all Type TFQU heaters. Left, right, up or down airflows are available.

Left overhang is standard for either right or left airflow, and up overhang is standard for either up or down airflow. The alternate overhangs are available at no extra charge if specified on the order.

For definitions of airflow and terminal box overhangs, see Figures 48 and 49.

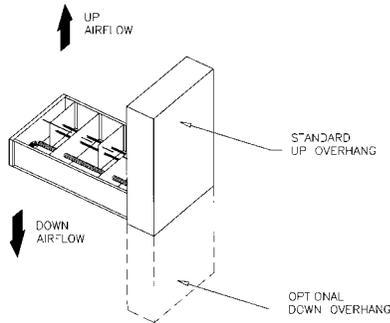


Figure 48.

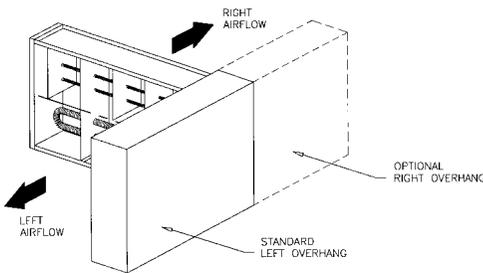


Figure 49.

## Control Circuit Options

Type TFQU heaters are available with control circuit Options G, J or K. These options are described in Table XI.

Use Option G with simple single or multi-stage on/off electronic thermostats.

Use Option J with pneumatic controls.

Use Option K for precise solid-state SCR temperature control.

Table XI

Option	G	J	K
Disconnect Switch	■	■	■
Thermal Cutouts	■	■	■
Airflow Switch	■	■	■
Contactors	■	■ <sup>2</sup>	■ <sup>2</sup>
Control Transformer	■	■ <sup>3</sup>	■
Fuses	■ <sup>1</sup>	■ <sup>1</sup>	■ <sup>1</sup>
PE Switches		■	
SCR			■
Thermostat			■ <sup>4</sup>

- Notes: 1. Fuses supplied only on heaters over 48 amps.  
 2. Contactors supplied only when other devices cannot carry heater load.  
 3. Transformer only supplied on heaters rated higher than 27 volts.  
 4. Choice of room or duct thermostat, 135 ohms, 2200 ohms, 0-10 VDC or 4-20 mA inputs.

## Special Features

In addition to the standard offerings, the following Special Features are available. A detailed description of each feature is given on the catalog page indicated.

Table XII

### Special Features Available on TFQU Heaters

Feature	Page Number
Airflow switch for negative pressure operation	15
Insulated terminal box	38
Dust tight terminal box	37
Controls mounted in remote panelboard	40
Deletion of transformer	16
Deletion of transformer and contactor	16
Transformer primary fused	—
Deletion of disconnect	17
Fuses for heaters rated 48 amps or less	16
“Low Airflow” pilot light	17
“Heater On” pilot light	17
Each “Stage On” pilot light(s)	17
Disconnecting contactors	16
Mercury controlling contactors	16
Fan relay (instead of airflow switch)	15
Fan relay (in addition to airflow switch)	15
Step controller	19-20
Built-in PE transducer	12
<b>When specified, heaters shall be supplied with the following thermostats:</b>	
Pilot duty single stage room thermostat (Fig. 11)	12
Pilot duty two stage room thermostat (Fig. 12)	12
Proportional electronic room thermostat (Fig. 13 & 14)	12
Pilot duty single stage duct thermostat (Fig. 16)	13
Pilot duty two stage duct thermostat (Fig. 17)	13
Proportional electronic duct thermostat with set point adjuster (Fig. 18 & 19)	13
Special inputs (4-20 mA, 0-10 VDC)	21

# Standard Duct Heaters

## Finned Tubular

### TFQU – Sample Specification

A job specification can be prepared by using the following information. Simply darken the applicable circles. Material which is part of the basic specification has already been darkened. Additional copies of this specification guide are available from your local INDEECO representative.

- 1. Duct heaters shall be INDEECO
  - Type TFQU Standard Slip-in heaters
- 2. Approvals – Heaters and panelboards (if required) shall meet the requirements of the National Electrical Code and shall be listed by Underwriters Laboratories for zero clearance to combustible surfaces and for use with heat pumps and air conditioning equipment.
- 3. Heating elements shall consist of a coil, 80% nickel, 20% chromium, Grade A resistance wire, precisely centered in a stainless steel tube filled with granular magnesium oxide. A stainless steel fin is to be helically wound onto the tube. Elements are to be furnished with mounting flanges, making them individually removable through the terminal box.
- 4. Heater frames and terminal boxes shall be corrosion resistant steel. Unless otherwise indicated, the terminal box shall be NEMA 1 construction and shall be provided with a hinged, latching cover and multiple concentric knockouts for field wiring.
- 5. All heaters shall be furnished with triple overtemperature protection. A disc type and linear, automatic reset thermal cutout are included for primary overtemperature protection. All heaters must also be furnished with a linear type manual reset thermal cutout with backup contactors (as required). For secondary overtemperature protection, heat limiters or other fusible overtemperature devices are not acceptable.
- 6. Heaters shall be rated for the voltage, phase and number of heating stages indicated in the schedule. All three-phase heaters shall have equal, balanced, three-phase stages. All internal wiring shall be stranded copper with 105°C insulation and shall be terminated in crimped connectors or box lugs.
- 7. Terminal blocks shall be provided for all field wiring and shall be sized for installation of 75°C copper wire rated in accordance with NEC requirements.
- 8. Heaters shall be furnished either with the Control Option specified in the schedule and described below or with the specific components listed in the schedule.

- Option G – Thermal cutouts, airflow switch, contactors, fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.
- Option J – Thermal cutouts, airflow switch, PE switches, contactors (where required), fuses (if over 48 amps), control circuit transformer (where required), and built-in, snap-acting, door interlocked disconnect switch.
- Option K – Thermal cutouts, airflow switch, contactors (where required), SCR, fuses (if over 48 amps), control circuit transformer and built-in, snap-acting, door interlocked disconnect switch.
- 9. When specified in the schedule, or below, heaters will be supplied with the following Special Features:
  - Airflow switch for negative pressure operation
  - Insulated terminal box
  - Dust-tight terminal box
  - Controls mounted in remote panelboard
  - Deletion of transformer
  - Deletion of transformer and contactor
  - Transformer primary fusing
  - Deletion of disconnect switch
  - Fuses for heaters rated 48 amps or less
  - “Low Airflow” pilot light
  - “Heater On” pilot light
  - Each “Stage On” pilot light(s)
  - Disconnecting contactors
  - Mercury controlling contactors
  - Fan relay (instead of airflow switch)
  - Fan relay (in addition to airflow switch)
  - Step controller
  - Built-in PE transducer
- 10. When specified in the schedule, or below, heaters shall be supplied with the following thermostats:
  - Pilot duty single stage room thermostat
  - Pilot duty two stage room thermostat
  - Proportional electronic room thermostat
  - Pilot duty single stage duct thermostat
  - Pilot duty two stage duct thermostat
  - Proportional electronic duct thermostat with set point adjuster
  - Special inputs (135 ohms, 2200 ohms, 4-20 mA, 0-10 VDC)
- 11. Duct Heater Schedule – Use of the following typical format will insure that all necessary information is available to bidders:

Item or Tag #	Heater Type	KW	Duct Dimensions (Inches)		Supply Line		No. of Heating Stages	Control Circuit Voltage	Control Option	Special Features	Thermostats
			W (Width)	H (Height)	Volts	Phase					
EDH -1	TFQU	10	24	24	208	3	2	24	G	Vertical Up Airflow Pilot Light	Room
EDH -2	TFQU	18	36	16	208	1	4	208	J	Insulated Terminal Box	None
EDH -3	TFQU	7.5	20	12	480	3	1	24	K	Fan Relay (24V)	Duct

## Special Applications

**Air Conditioning & Air Handling Units** – For more than 50 years, INDEECO has been supplying special heaters for use in air handling and air conditioning equipment (Figure 50). A wide range of special construction techniques has been developed to insure proper operation as well as easy installation, either in the OEM's plant or in the field. These heaters typically fall into one of the categories described on the following pages.



Figure 50.

**Modular Construction** – The heater is designed to match adjacent air handling unit components such as fans, cooling sections, filter boxes, etc. (Figure 51). Special construction is used so that the heater mounts adjacent to other components; the heater becomes simply one module of the air handling unit assembly. Unheated sections are provided where there is little or no airflow, such as the area blocked by an adjacent cooling coil header. Pressure plates can be provided to insure uniform airflow when the heater must be installed adjacent to the fan. Buffer sections can be furnished to space the heating coils away from temperature sensitive components or to help assure uniform airflow.

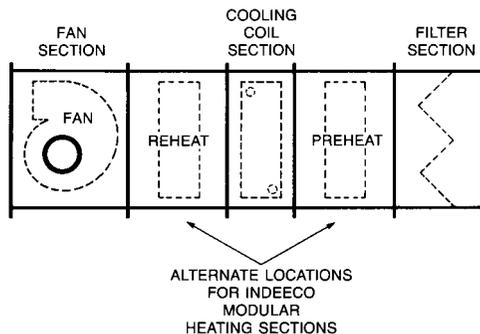


Figure 51.

**Multi-Zone or Dual Duct Heaters** – These heaters are designed for installation inside multi-zone or dual duct air conditioning equipment, where the airflow is highly variable and unevenly distributed (Figure 52). These heaters use coils derated to approximately 25 watts per square inch (3.8 watts per square cm) of wire surface area (approximately one half normal watt density). Low density coils run cooler and thus provide longer life under these stringent operating conditions.

These heaters are supplied with fully proportional SCR control or with many heating stages to insure that no more heat is being supplied than is absolutely necessary. Each heater stage is spread over the entire face area to take advantage of all available airflow.

A perforated pressure plate is factory-installed on the air inlet side of the heater to make the airflow as uniform as possible. Linear limit thermal cutouts protect against serious overheating anywhere along the length of the heater.

When the heater must be installed entirely within the unit, only thermal cutouts are built into the heater, a remote panel is required for controls. When the terminal box can be external, heaters are available with a wide range of built-in controls.

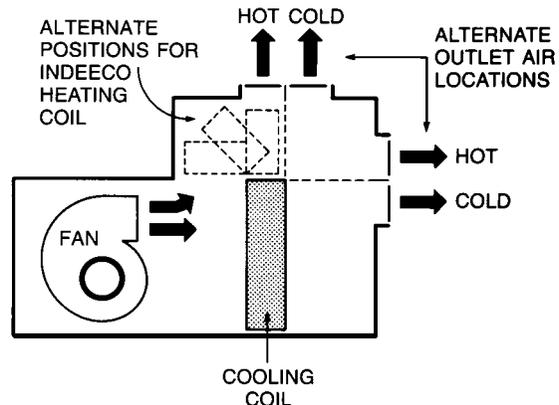


Figure 52.



# Custom Duct Heaters

**Package Units** – INDEECO manufactures heaters specifically designed for installation in packaged air conditioning equipment. This is a particularly tough application as package units are compactly designed. INDEECO developed heater designs to meet these conditions: narrow heating sections to fit into the thinnest of spaces; unusually configured terminal boxes and covers; special mounting flanges; prepunched mounting holes and detailed instructions to aid the field installer (see Figures 53 and 54).

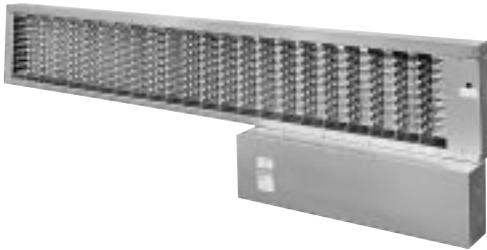


Figure 53. Heater with offset terminal box for package unit

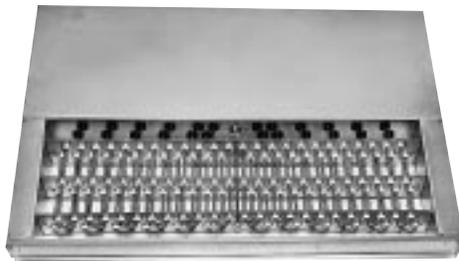


Figure 54. Heater with narrow coil section and terminal box for package unit

**Marine Duty** – Only INDEECO offers a UL Listed duct heater which is also ABS Approved and meets U.S. Coast Guard Requirements for shipboard use (Figure 55).



Figure 55.

**Variable Air Volume (VAV) Units** – To serve the fast moving and very competitive VAV market, INDEECO has developed a fully computerized design and construction system which enables us to ship substantial volumes of heaters in a wide variety of sizes, ratings and control options quickly. This system was patterned after our methods of designing and producing standard duct heaters, modified to solve the problems unique to the VAV industry. Slip-and-drive sheet metal connections, control packages tailored to VAV systems, and special techniques for fan interlocks are some of the features designed for this market (Figure 56).



Figure 56.

**Railway and Subway Applications** – Tough rail car industry standards have been developed to overcome the severe vibration, shock, high operating voltages and voltage swings routinely encountered. For more than 30 years, INDEECO has built heaters to meet these standards, using heavy gauge corrosion resistant steel frames and oversized coil and terminal support bushings (Figure 57).

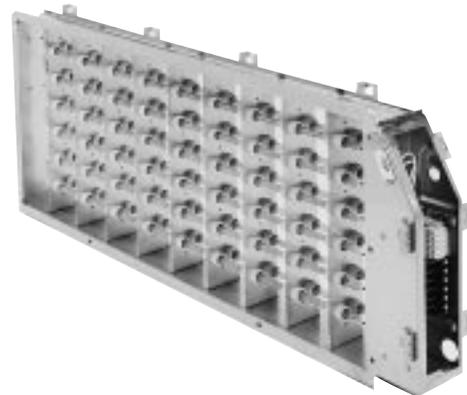


Figure 57.

## Duct Heaters for Wet, Dusty and Corrosive Areas

INDEECO offers a wide selection of custom built electric duct heater designs for outdoor, wet, dusty and corrosive areas. Typical applications include use with roof top air handling equipment, in washdown areas such as food processing plants, wet and humid spaces near indoor swimming pools, and marine or casino boat applications including shipboard use.

### Features:

- Disconnect switch with door interlock
- Manual reset thermal cutout
- Automatic reset thermal cutout
- Stainless steel frame
- Large diameter stainless steel finned tubular heating elements
- Heavy duty control transformer
- Fusing per NEC
- Airflow switch
- Stainless steel terminal hardware

### Outdoor UL Listed 3R

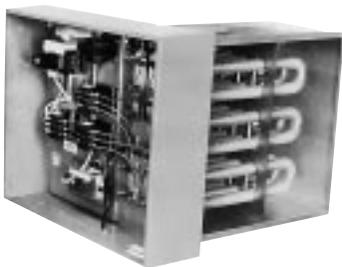


Figure 58.

Outdoor type 3R heaters (Figure 58) are intended for outdoor use to provide a degree of protection against falling rain, sleet and external ice formation. UL Listed 3R heaters can be used in most HVAC outdoor applications and indoors for protection against dripping water. Water-tight hubs for incoming power and control connections are furnished.

## Dust-tight Construction



Figure 59.

A dust-tight terminal box (Figure 59) is available to meet local codes that require dust-tight construction for a heater installed above a false ceiling when the entire area is used as a return air plenum. It is also suitable for commercial or light industrial applications and to avoid dust accumulation inside the terminal box while a building is under construction.

These boxes are spot welded corrosion resistant steel, with all openings sealed. The hinged cover is gasketed and hold-down clamps are provided. (Note that this construction does not meet the more rigid requirements of NEMA 12 described below).

### NEMA 12 Type Terminal Box

For heavy duty industrial applications involving both dust and oil, NEMA 12 construction is available on custom heaters (Figure 60). The all welded, stainless steel terminal box has a hinged, gasketed cover with hold-down clamps. Scru-tite hubs for line and power connections are included.



Figure 60.

### NEMA 4 Type Terminal Box

For weatherproof locations and washdown areas such as food processing plants, a NEMA 4 Type construction is available. This all welded stainless steel enclosure is furnished with a hinged, gasketed cover and is provided with water-tight hubs for incoming power and control connections.



# Custom Duct Heaters

## Bottom Mounted Terminal Box

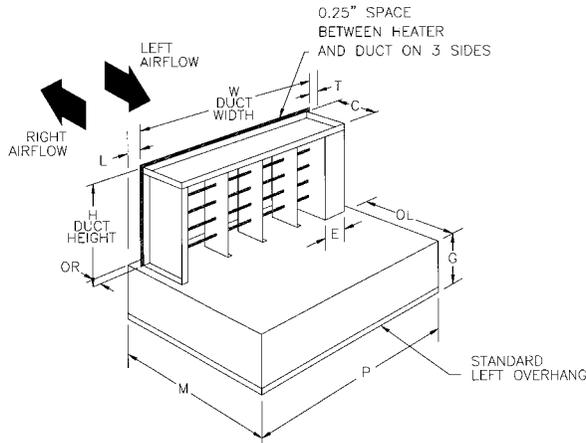


Figure 61.

The NEC requires a work space at least 2½' (76.2 cm) wide by 3½' (10.67 cm) deep in front of a heater terminal box for service access. More space is required for large heaters. When this space is not available at the side of a duct, the heater can be installed through the bottom using a special bottom mounted terminal box construction which maintains the required horizontal orientation of open coil resistance elements.

Custom heaters of either flanged or slip-in design are available with this feature. However, slip-in is normally preferred for ease of installation (Figure 61). UL Listed heaters are limited to the sizes indicated in **Table XIII**.

**Table XIII**

**Duct Size Limitations of Bottom Terminal Box Heaters**

Heater Type	Minimum W in (mm)	Minimum H in (mm)	Maximum H in (mm)
Open Coil Flanged	5 (127)	3 (76.2)	40 (1016)
Open Coil Slip-in	8 (203)	4.25 (108)	40 (1016)
Finned Tubular Flanged	4.5 (114)	4 (102)	72 (1829)
Finned Tubular Slip-in	11 (279)	5.25 (133)	72 (1829)

## Insulated Terminal Box

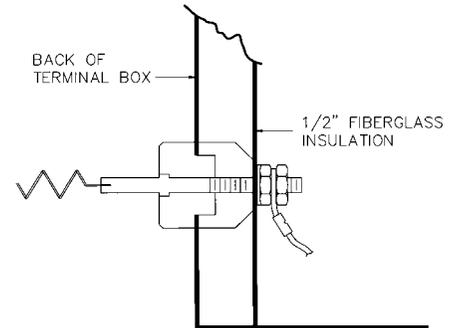


Figure 62.

When the heater is installed in an air conditioning duct which runs through an un-airconditioned space, condensation may form inside the terminal box. To eliminate this condensation or for energy conservation, the back of the terminal box can be factory insulated (Figure 62). This construction is available with all heaters.

## Pressure Plates

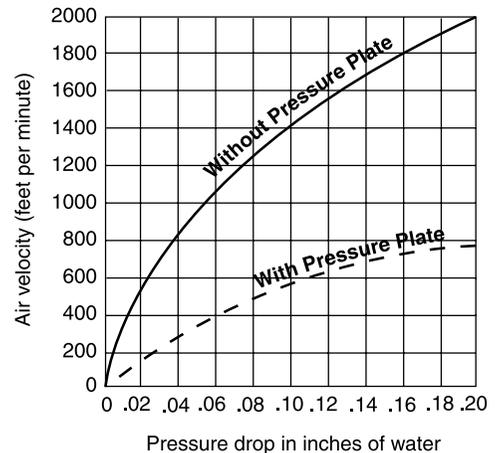


Figure 63.

A 40% open pressure plate on the inlet side of custom open coil type heaters evens out the airflow pattern in installations where it is not uniform. A pressure plate significantly increases the pressure drop across the heater (Figure 63). This increase must be considered in sizing the fan motor. To assure correct plate location, specify the exact airflow direction as defined in Figures 40 and 41, page 23.

# Custom Duct Heaters

## Protective Screens



Figure 64.

Protective screens protect personnel from accidental contact with electrically hot open coil elements and prevent large airborne contamination from reaching the elements (Figure 64). They are available on custom heaters only. The 3/8" (9.5mm) wire mesh screen may be mounted on both sides of the heater. Finned tubular duct heater construction may be more appropriate for these applications.

## Unheated Sections

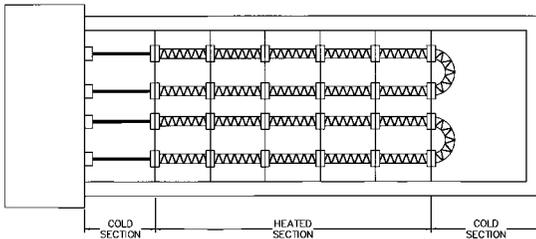


Figure 65.

INDEECO custom heaters can be supplied with unheated sections, either open or blocked off (Figure 65). Such constructions are particularly helpful when the heater frame must extend through an area with little or no airflow to maintain accessibility to the terminal box. For example, a heater next to a cooling coil should have extended terminal shanks so no heat is generated adjacent to the cooling coil header. Most constructions are available with a UL label.

## Construction For Lined Ducts

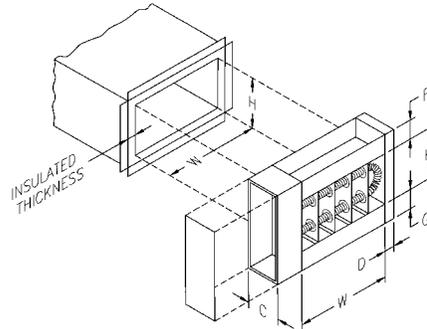


Figure 66. Installation of flange type heater in lined duct

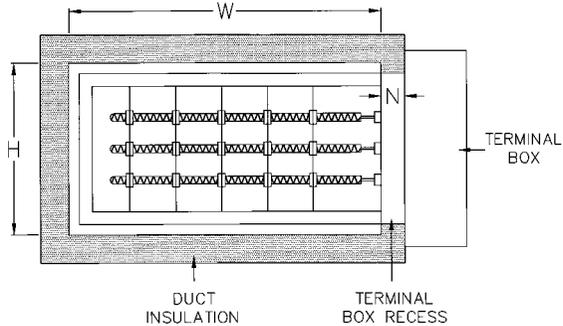


Figure 67. Installation of slip-in heater where insulation is more than 1" (25.4 mm) thick

All INDEECO slip-in heaters are suitable for use in ducts lined with up to 1" (25.4 mm) of interior insulation. Extended terminals and the design of the terminal cutout system make standard slip-in heaters suitable for such installations without any deterioration in performance or life. Be sure that the duct dimensions specified are those inside the duct lining.

For slip-in heater applications where the insulation is more than 1" (25.4 mm) thick or where flanged heaters are required, the special constructions illustrated in Figures 66 and 67 are available on custom heaters. Dimensions inside the insulation must be specified as well as the insulation thickness.



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# Custom Duct Heaters

## Slip-and-Drive Construction

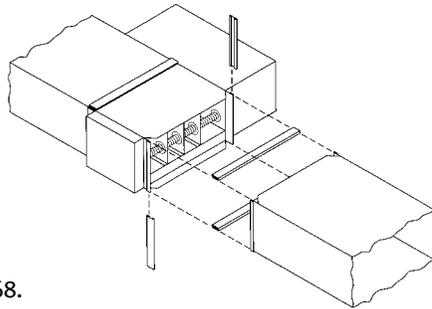


Figure 68.

This option for custom flanged heaters, allowing installation with conventional HVAC slip-and-drive connections, offers the rugged and secure mounting of a flanged heater, yet requires less installation labor than a slip-in heater. It is particularly useful when other equipment in the duct system uses slip-and-drive connections, as the contractor can standardize throughout (Figure 68).

By using INDEECO's slip-and-drive construction in variable air volume (VAV) units, the manufacturer can offer the same standard VAV box for electric heat, hot water heat or no heat.

## Remote Panelboard

When specifying remote panelboards (Figure 69), we recommend the following changes in control and safety components to insure the safety of the installation and to minimize the field labor costs.

- Contactors – Use disconnecting controlling contactors which break all ungrounded lines. Thus, when heat is not being called for, all terminals in the heater will be dead.

- Pilot Switch – Add a dead front pilot switch to the heater terminal box to make it safe for servicing by simply tripping the pilot switch. This shuts off power to the heater circuits through the disconnecting contactors in the panel.
- Fuses – Built-in fusing for each panelboard will be in accordance with UL and NEC requirements.

Except for SCR's, which are mounted through the panelboard side wall, control components are mounted on a sub-panel. Labeled terminal blocks are provided for all field wiring, both in the panel and in the heater. Knockouts and wiring gutter spaces are supplied in all panelboards.

NEMA 1 panels are made from heavy gauge steel, welded and painted (as required), and are provided with a lock and key. Wall mounting, flush mounting or floor mounting on legs are available.

NEMA 3R type panelboards for outdoor use are UL Listed. These are intended for outdoor use to provide protection against falling rain, sleet and external ice formation.

NEMA 4 and NEMA 12 panelboards for outdoor, dusty, and oil atmospheres are also available, as well as explosion-resistant panels furnished with cast aluminum enclosures.

All standard type QUA/QUZ and TFQU heaters are available with remote panels. Panels for these standard heaters are available in NEMA 1 wall mounting only. Fusing, disconnecting contactors and a heater-mounted pilot switch, all as described above, are supplied.



Figure 69.

# Custom Duct Heaters

## Minimum & Maximum Duct Dimensions

Although there is no limitation on the maximum size of custom heater assemblies, individual UL Listed heaters must meet the following minimum and maximum requirements (see tables below).

UL Listed custom heaters are also available in virtually any KW rating. However, heaters are restricted to maximum KW ratings based on the square feet of heated area.

INDEECO has built individual duct heaters for space heating applications ranging from 0.1 KW to over 900 KW, multi-section units with up to 2000 KW in one assembly, and face areas as large as 40' wide x 14' high. Exact dimensional and KW limits can be determined by contacting your local INDEECO representative.

**Table XIV**

**Open Coil Custom Heaters**

	Slip-in Type in (mm)	Flanged Type in (mm)
Minimum Duct Width (W)	5.25 (133)	5 (127)
Minimum Duct Height (H)	4.25 (108)	3 (76)
Maximum Duct Width (W)	240 (6100)	240 (6100)
Maximum Duct Height (H)	120 (3050)	120 (3050)

**Table XV**

**Finned Tubular Custom Heaters**

	Slip-in Type in (mm)	Flanged Type in (mm)
Minimum Duct Width (W)	4.75 (121)	4.5 (114)
Minimum Duct Height (H)	5.25 (133)	4 (102)
Maximum Duct Width (W)	175 (4450)	175 (4450)
Maximum Duct Height (H)	120 (3050)	120 (3050)

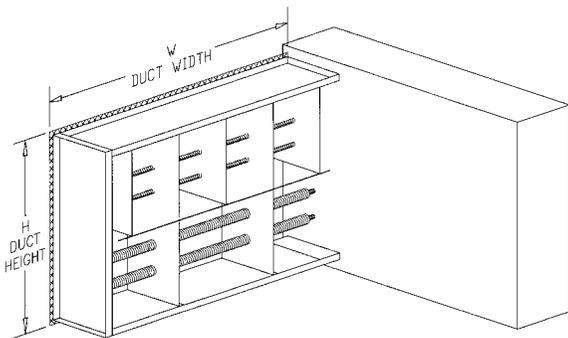


Figure 70. Slip-in Duct Heater

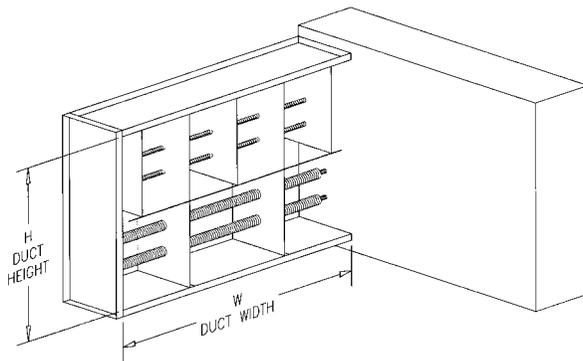


Figure 71. Flanged Duct Heater



# Custom Duct Heaters

## Open Coil Custom Heater – Sample Specification

A job specification can be prepared by using the following information. Simply darken the applicable circles. Material which is part of the basic specification has already been darkened. Additional copies of this specification guide are available from your local INDEECO representative.

- 1. Duct heaters shall be INDEECO:
  - Type XUB Custom Slip-in Heater
  - Type ZUB Custom Flanged Heater
- 2. Approvals – Heaters and panelboards (if required) shall meet the requirements of the National Electrical Code and shall be listed by Underwriters Laboratories for zero clearance to combustible surfaces and for use with heat pumps and air conditioning equipment.
- 3. Heating elements shall be open coil, 80% nickel, 20% chromium, Grade A resistance wire. Type C alloys containing iron or other alloys are not acceptable. Coils shall be machine crimped into stainless steel terminals extending at least 1" into the airstream and all terminal hardware shall be stainless steel. Coils shall be supported by ceramic bushings staked into supporting brackets.
- 4. Heater frames and terminal boxes shall be corrosion resistant steel. Unless otherwise indicated, the terminal box shall be NEMA 1 construction and shall be provided with a hinged, latching cover and multiple concentric knockouts for field wiring.
- 5. All heaters shall be furnished with a disc type, automatic reset thermal cutout for primary overtemperature protection. All heaters shall also be furnished with disc type, load-carrying manual reset thermal cutouts, factory wired in series with heater stages for secondary protection. Heat limiters or other fusible overtemperature devices are not acceptable.
- 6. Heaters shall be rated for the voltage, phase and number of heating stages indicated in the schedule. All three-phase heaters shall have equal, balanced, three-phase stages. All internal wiring shall be stranded copper with 105°C insulation and shall be terminated in crimped connectors or box lugs.
- 7. Terminal blocks shall be provided for all field wiring and shall be sized for installation of 75°C copper wire rated in accordance with NEC requirements.
- 8. Heaters shall be furnished either with the Control Option specified in the schedule and described below or with the specific components listed in the schedule.
  - Option G – Thermal cutouts, airflow switch, contactors, fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.

- Option J – Thermal cutouts, airflow switch, PE switches, contactors (where required), fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.
- Option K – Thermal cutouts, airflow switch, SCR (with step controller and contactors if heater draws over 96 amps three-phase or 192 amps single-phase), fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.
- 9. When specified in the schedule, or below, heaters will be supplied with the following Special Features:
  - Airflow switch for negative pressure operation
  - Insulated terminal box
  - Dust-tight terminal box
  - Controls mounted in remote panelboard
  - Deletion of transformer
  - Transformer primary fusing
  - Deletion of transformer and contactor
  - Deletion of disconnect switch
  - Fuses for heaters rated 48 amps or less
  - “Low Airflow” pilot light
  - “Heater On” pilot light
  - Each “Stage On” pilot light(s)
  - Disconnecting contactors
  - Mercury controlling contactors
  - Fan relay (instead of airflow switch)
  - Fan relay (in addition to airflow switch)
  - Step controller
  - 25 watts per square inch resistance coils
  - 35 watts per square inch resistance coils
  - Built-in PE transducer
  - Custom terminal box type:
    - UL3R ○ NEMA 4 ○ NEMA 12
  - Bottom mounted terminal box
  - 40% open pressure plate
- 10. When specified in the schedule, or below, heaters shall be supplied with the following thermostats:
  - Pilot duty single stage room thermostat
  - Pilot duty two stage room thermostat
  - Proportional electronic room thermostat
  - Pilot duty single stage duct thermostat
  - Pilot duty two stage duct thermostat
  - Proportional electronic duct thermostat with set point adjuster
  - Special inputs (135 ohms, 2200 ohms, 4-20 mA, 0-10 VDC)
- 11. Duct Heater Schedule – Use of the following typical format will insure that all necessary information is available to bidders:

Item or Tag #	Heater Type	KW	Duct Dimensions (Inches)		Supply Line		No. of Heating Stages	Control Circuit Voltage	Control Option	Special Features	Thermostats
			W (Width)	H (Height)	Volts	Phase					
EDH -1	XUB	10	27	14	208	3	2	24	G	UL 3R Type Terminal Box	Room
EDH -2	XUB	15	16.5	10	240	1	3	240	J	Insulated Terminal Box	None
EDH -3	XUB	7.5	24	24	280	1	1	24	K	Bottom Mounted Terminal Box	Duct

## Finned Tubular Custom Heater – Sample Specification

A job specification can be prepared by using the following information. Simply darken the applicable circles. Material which is part of the basic specification has already been darkened. Additional copies of this specification guide are available from your local INDEECO representative.

- 1. Duct heaters shall be INDEECO:
  - Type TFXU Custom Slip-in Heater
  - Type TFZU Custom Flanged Heater
- 2. Approvals – Heaters and panelboards (if required) shall meet the requirements of the National Electrical Code and shall be listed by Underwriters Laboratories for zero clearance to combustible surfaces and for use with heat pumps and air conditioning equipment.
- 3. Heating elements shall consist of coil, 80% nickel, 20% chromium, Grade A resistance wire, precisely centered in a stainless steel tube filled with granular magnesium oxide. A stainless steel fin is to be helically wound onto the tube. Elements are to be furnished with mounting flanges, making them individually removable through the terminal box.
- 4. Heater frames and terminal boxes shall be corrosion resistant steel. Unless otherwise indicated, the terminal box shall be NEMA 1 construction and shall be provided with a hinged, latching cover and multiple concentric knockouts for field wiring.
- 5. All heaters shall be furnished with triple overtemperature protection. A disc type and linear, automatic reset thermal cutout are included for primary overtemperature protection. All heaters must also be furnished with a linear type manual reset thermal cutout with backup contactors (as required). For secondary overtemperature protection, heat limiters or other fusible overtemperature devices are not acceptable.
- 6. Heaters shall be rated for the voltage, phase and number of heating stages indicated in the schedule. All three-phase heaters shall have equal, balanced, three-phase stages. All internal wiring shall be stranded copper with 105°C insulation and shall be terminated in crimped connectors or box lugs.
- 7. Terminal blocks shall be provided for all field wiring and shall be sized for installation of 75°C copper wire rated in accordance with NEC requirements.
- 8. Heaters shall be furnished either with the Control Option specified in the schedule and described below or with the specific components listed in the schedule.
  - Option G – Thermal cutouts, airflow switch, contactors, fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.

- Option J – Thermal cutouts, airflow switch, PE switches, contactors (where required), fuses (if over 48 amps), control circuit transformer (as required), and built-in, snap-acting, door interlocked disconnect switch.
- Option K – Thermal cutouts, airflow switch, contactors (where required), SCR (with step controller if heater draws over 96 amps three-phase or 192 amps single-phase), fuses (if over 48 amps), control circuit transformer (where required) and built-in, snap-acting, door interlocked disconnect switch.
- 9. When specified in the schedule, or below, heaters will be supplied with the following Special Features:
  - Airflow switch for negative pressure operation
  - Insulated terminal box
  - Dust-tight terminal box
  - Controls mounted in remote panelboard
  - Deletion of transformer
  - Transformer primary fusing
  - Deletion of transformer and contactor
  - Deletion of disconnect switch
  - Fuses for heaters rated 48 amps or less
  - “Low Airflow” pilot light
  - “Heater On” pilot light
  - Each “Stage On” pilot light(s)
  - Disconnecting contactors
  - Mercury controlling contactors
  - Fan relay (instead of airflow switch)
  - Fan relay (in addition to airflow switch)
  - Step controller
  - Built-in PE transducer
  - Custom terminal box type:
    - UL3R
    - NEMA 4
    - NEMA 12
  - Bottom mounted terminal box
  - Protective screens
- 10. When specified in the schedule, or below, heaters shall be supplied with the following thermostats:
  - Pilot duty single stage room thermostat
  - Pilot duty two stage room thermostat
  - Proportional electronic room thermostat
  - Pilot duty single stage duct thermostat
  - Pilot duty two stage duct thermostat
  - Proportional electronic duct thermostat with set point adjuster
  - Special inputs (135 ohms, 2200 ohms, 4-20 mA, 0-10 VDC)
- 11. Duct Heater Schedule – Use of the following typical format will insure that all necessary information is available to bidders:

Item or Tag #	Heater Type	KW	Duct Dimensions (Inches)		Supply Line		No. of Heating Stages	Control Circuit Voltage	Control Option	Special Features	Thermostats
			W (Width)	H (Height)	Volts	Phase					
EDH -1	TFXU	7.5	23	17	480	3	2	24	G	Insulated Terminal Box	Room
EDH -2	TFXU	25	36	20	208	3	3	240	J	—	None
EDH -3	TFXU	150	75	60	480	3	1	120	K	Vernier Controlled	Duct

# Explosion-proof Duct Heaters

## Safety

INDEECO explosion-proof ULTRA-SAFE™ and EP2 duct heaters are Factory Mutual (FM) and CSA Approved. The ULTRA-SAFE™ duct heater has the only standard product offering and features the industry's lowest ignition temperature code rating, T3C, 320°F (160°C).

## Experience

This catalog represents more than 70 years experience in industrial electric heating, our specialty since INDEECO was founded in 1929. INDEECO has more than 50 years experience with forced air comfort heating for hazardous locations.

## Complete Product Line

- Industry's most comprehensive product line of space heating equipment.
- Ratings up to 750 KW and 600 volts.
- Widest selection of built-in controls.

## Applications

INDEECO Duct Heaters provide a clean, safe source of electric heat for comfort heating and freeze protection in hazardous locations where specific explosive gases or dusts are present, and environments where moisture and corrosion exist.

## Use of Electric Heaters in Hazardous Areas

Electric heating equipment can be economically designed and safely used in hazardous areas if the following special requirements are kept in mind.

1. The surface temperature of the electric heating equipment cannot exceed the ignition temperature of the hazardous atmosphere. To insure that the proper heater has been selected, it is essential that the correct NEC Ignition Temperature Code be specified (see **Table XVI**). If the Temperature Code selected is too high, the electric heating system may operate above the ignition point of the application, creating a potentially hazardous condition.
2. All arc and spark producing control devices must be isolated from the hazardous atmosphere. If it is not economically feasible to locate the control devices in a non-hazardous area, they must be housed in an enclosure that will withstand the pressure of a potential explosion from within the enclosure.
3. All electrical supply connections must be made according to the latest NEC and local code requirements for hazardous locations. This includes the requirement that conduit entering the enclosures must be provided with seals at the enclosure.



# Explosion-proof Duct Heaters

Hazardous locations are those areas where a potential for explosion and fire exists due to the presence of flammable gases, vapors, pulverized dusts, or ignitable fibers in the atmosphere. Hazardous locations are created from the normal processing of volatile chemicals, gases, coal, grains, etc., or from the accidental failure of storage systems for these materials.

Both people and equipment in hazardous locations can be heated safely and economically with electric heat. Electric heating is typically much less expensive to install and maintain than comparable remote oil or gas fired heating systems.

**Table XVI**  
**Ignition Temperature**

Maximum Surface Temp. Of Heater*		NEC Ignition Temp. Code
°C	°F	
450	842	T1
300	572	T2
280	536	T2A
260	500	T2B
230	446	T2C
215	419	T2D
200	392	T3
180	356	T3A
165	329	T3B
160	320	T3C

\*All electrical equipment is designed not to exceed the ignition temperature of the hazardous atmosphere. The maximum surface temperature for electric heaters is defined by the NEC for each class as indicated above.

## National Electrical Code Classification

Articles 500 through 516 of the National Electrical Code deal with the definition of hazardous areas and the use or design of electrical equipment used in these locations. Electric heating equipment for hazardous areas is specified based on the NEC Class, Division, Group, and Ignition Temperature.

## Class

Hazardous locations are divided into the three general classes of vapors/gases, dusts, and fibers.

**Class I** – Locations where the potential for explosion and fire exists due to the presence of flammable gases or vapors in the air. Typical Class I locations include: oil or natural gas drilling rigs, petroleum refining or pumping facilities, petrochemical plants, wastewater/sewage treatment plants, solvent extraction plants, paint spraying booths, locations where open tanks or vats of combustible liquids are present, and storage areas for flammable materials.

**Class II** – Locations where the potential for explosion exists because of finely pulverized flammable dusts suspended in the atmosphere. Typical locations would include coal fired power plants, coal preparation/coal handling facilities, coal mines, grain elevators, flour and feed mills, packaging and handling of pulverized sugar, processing and storage of magnesium and aluminum powder.

**Class III** – This third classification is primarily a fire hazard where fibers or flyings suspended in the air create a hazard. This would include small pieces of thread like fiber, sawdust, lint, etc. Typical applications would include: textile mills, woodworking plants, cotton gins and cotton seed mills, and flax producing plants.

## Division

Class I, Class II, and Class III areas are further defined in terms of when the hazard occurs. Division 1 and Division 2 occurrences are summarized below:

**Division 1** – If the hazard is expected to be present under normal conditions, such as in a production or processing facility, the occurrence is designated Division 1. The hazardous atmosphere may be present continuously, intermittently, periodically, or during normal repair or maintenance operations. Division 1 occurrences also include locations where a breakdown in the operations of processing equipment results in the release of hazardous vapors.

**Division 2** – If the hazardous material is normally expected to be contained within a closed area, system or container and would enter the ambient atmosphere only under an abnormal failure, then it is referred to as a Division 2 occurrence.



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# Explosion-proof Duct Heaters

## Engineering Information

### National Electrical Code Requirements for Duct Heaters

In addition to the general requirements for hazardous areas on pages 45 and 46, the NEC also requires that all duct heaters have built-in protection against low airflow, primary and secondary overtemperature protection, and overcurrent protection for heaters drawing more than 48 amps. These safety features are provided with all INDEECO explosion-proof duct heaters.

## Airflow Requirements

Airflow must be calculated to give the required temperature rise and to ensure sufficient airflow to prevent the thermal cutouts from tripping prematurely.

**Required air volume** to give the desired temperature rise for a given KW is determined by the formula:  
 $SCFM = KW \times 3193 / \Delta T$  where SCFM is airflow volume in Standard Cubic Feet per Minute and  $\Delta T$  is temperature rise in °F.

**Minimum air velocity** for safe operation is determined by dividing the heater KW by the cross-sectional duct area:  
 $KW / Sq. Ft. = KW / (W \times H / 144)$  where W and H are duct width and height in inches. For ULTRA-SAFE™ duct heaters, use the minimum W x H dimensions shown in the Heater Listing on page 51. Read the minimum velocity from the horizontal axis of Figure 72A for ULTRA-SAFE™ Duct Heater or Figure 72B for Series EP2 heaters.

**Airflow must be uniform** over the face of the heater, and must be horizontal for all but Custom Explosion-proof Duct Heaters.

**Horizontal airflow direction** is defined in Figure 72C.

**Pressure drop** through the heater can be determined by using figure 72D for the ULTRA-SAFE™ duct heater unit sizes A through F. Contact INDEECO for pressure drop data for unit sizes G through Z.

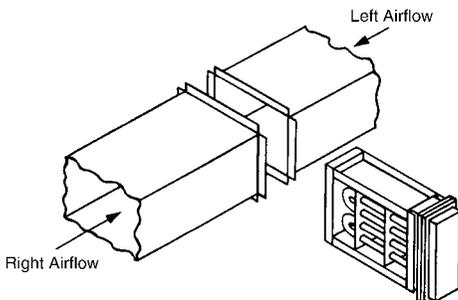


Figure 72C.

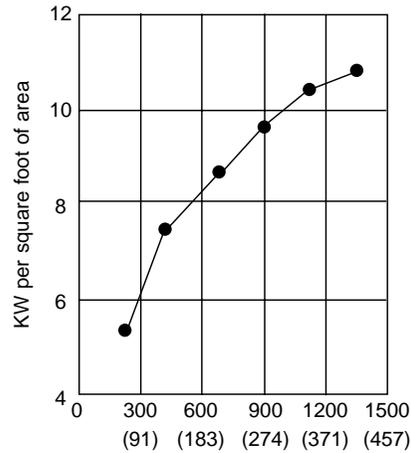


Figure 72A. Minimum air velocity required for ULTRA-SAFE™, feet per minute (meters per minute)

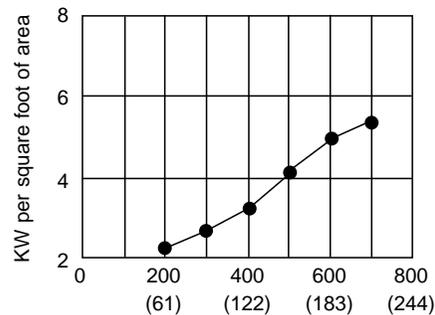


Figure 72B. Minimum air velocity required for EP2 feet per minute (meters per minute)

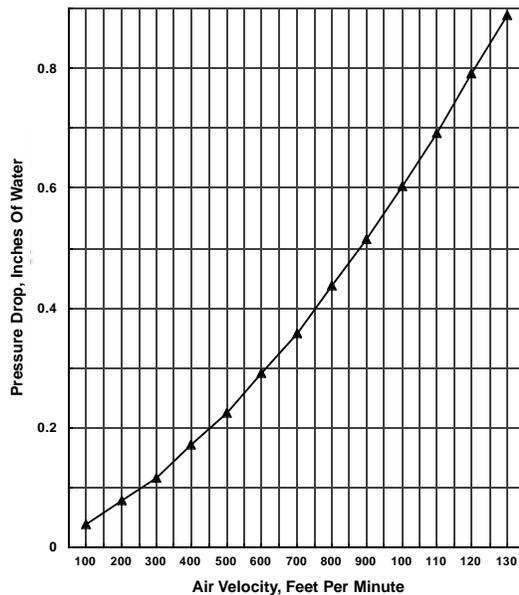


Figure 72D. ULTRA-SAFE™ Pressure Drop Curve

# Explosion-proof Duct Heaters

Engineering developments at INDEECO have made electric duct heaters for hazardous locations readily available at affordable prices.

## ULTRA-SAFE™

- FM and CSA Approved for virtually all Class I and Class II, Division 1 and 2 hazardous gas or dusty atmospheres
- Ignition temperatures as low as 320°F (160°C)
- Six standard sizes to fit a wide range of ducts
- Ratings up to 240 KW, 600 volts

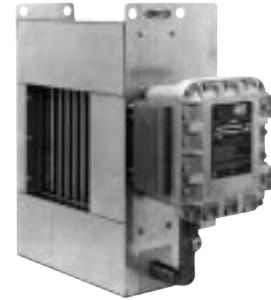


Figure 73. ULTRA-SAFE™ Explosion-proof Duct Heater

## Series EP2

- FM and CSA Approved for Class I, Division 2 locations where a hazardous gas is occasionally present
- Ignition temperatures as low as 392°F (200°C)
- For ducts up to 240" (610 cm) wide by 120" (305 cm) high
- Ratings up to 1000 KW, 600 volts

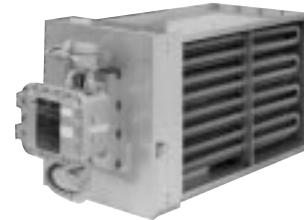


Figure 74. EP2 Explosion-proof Duct Heater

## Custom

- Wider range of sizes than available in the other two designs
- Vertical airflow
- Ratings up to 750 KW, 600 volts



Figure 75. Custom Explosion-proof Duct Heater

Table XVIII

Comparison Chart

Heater Type	KW and Control Range	Class and Division	NEC Ignition Temperature Code	Special Considerations
<b>ULTRA-SAFE™</b> For hazardous gas or dust atmospheres. Fits ducts from 12"W x 12"H to 52"W x 35"H.	Up to 240 KW  Single stage or SCR Control	Class I, Divisions 1 and 2, Groups B, C and D  Class II, Divisions 1 and 2, Groups E, F and G	T3C 320°F (160°C)	<ul style="list-style-type: none"> <li>• Fastest delivery of the three designs</li> <li>• Available for outdoor or wet locations</li> <li>• Corrosion resistant construction available</li> <li>• Horizontal airflow only</li> <li>• Not approved for shipboard use</li> </ul>
<b>Series EP2</b> For Division 2 hazardous gases (hazard exists only occasionally).	Up to 1000 KW  Multi-stage or SCR Control	Class I, Division 2, Groups C and D	T3 392°F (200°C)	<ul style="list-style-type: none"> <li>• Available for outdoor or wet locations</li> <li>• May be less expensive than ULTRA-SAFE™ for larger KW designs</li> <li>• Horizontal airflow only</li> <li>• Approved for shipboard use</li> </ul>
<b>Custom</b> Designed for each project. Not FM or CSA Approved.	Up to 750 KW  Multi-stage or SCR Control	Class I, Divisions 1 and 2, Groups C and D  Class II, Divisions 1 and 2, Groups E, F and G	T1 842°F (450°C) through T3B 329°F (165°C)	<ul style="list-style-type: none"> <li>• Horizontal or vertical airflow</li> <li>• Slip-in or flanged mounting</li> <li>• For ducts smaller than 12" x 12"</li> <li>• Available for outdoor or wet locations</li> </ul>

# ULTRA-SAFE™ Explosion-proof Duct Heaters

## Standard Construction

**Heat Exchanger** has copper tubes with integral aluminum fins. Each unit undergoes hydrostatic testing at 350 psig, five times the pressure relief valve setting of 70 psig.

**Heat Transfer Fluid** is propylene glycol, a non-toxic, rust-inhibiting fluid that provides freeze protection to  $-49^{\circ}\text{F}$  ( $-45^{\circ}\text{C}$ ). Its high heat transfer rate at 70 psig makes the heat exchanger suitable for gases that ignite at temperatures as low as  $320^{\circ}\text{F}$  ( $160^{\circ}\text{C}$ ). Thus every ULTRA-SAFE™ heater is rated for Temperature Code T3C.

**Industrial Grade Heating Elements**, built by INDEECO, are .475" (1.21 cm) diameter to provide extra insulation between the coil and sheath for high voltage protection.

**Frame** is heavy gauge galvanized steel, fitted with lifting lugs to facilitate installation.

**Four Levels of Safety** are provided on every heater: automatic and manual reset thermal cutouts, airflow interlock and pressure relief valve.

Two thermal cutouts limit the heat transfer fluid temperature, assuring thermal safety. The automatic reset operates a "primary" magnetic contactor. The manual reset operates a separate backup magnetic contactor. If either cutout opens, the entire heater is de-energized.

A fan relay, acting as an airflow interlock, prevents the heater from being energized unless the fan starter is on.

The pressure relief valve on the heat exchanger opens only if the thermal cutout system fails to prevent excessive temperatures.

**Standard Built-in Control Package** includes the following components mounted in a cast aluminum explosion-proof enclosure:

- De-energizing control and back-up magnetic contactors.
- 24V control circuit transformer.
- Fan relay, supplied with 24V or 120V holding coil to match the fan starter coil voltage.
- Terminal blocks for field power and control wiring.
- Grounding terminal.
- Supplemental fusing for heaters drawing more than 48 amps.

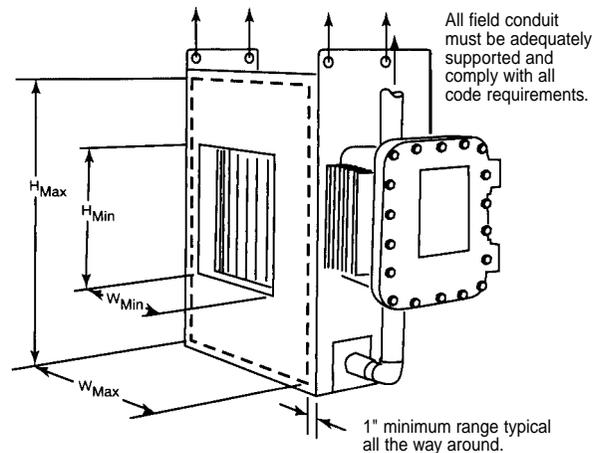
## Installation

Complete installation instructions are furnished with each heater. Following are some guidelines:

- The heater must be securely attached to external duct flanges.
- The heater must be adequately supported. If the duct flanges will not afford enough support, overhead hangers attached to the lifting lugs may be used for additional support.
- Each heater is suitable for a variety of duct sizes. See **Table XIX** on page 51 for maximum and minimum dimensions. Note that duct height and width can vary independently.
- Airflow must be horizontal. See page 47 for airflow requirements.

Attach hanger rods to structure capable of supporting the weight of the heater.

Ensure attachment allows for height adjustment so that heater is level along both axis.



Maximum duct dimensions ( $W_{Max}$  &  $H_{Max}$ ) should allow for 1" minimum flange all around.

Minimum duct dimensions ( $W_{Min}$  &  $H_{Min}$ ) are same as heat exchanger dimensions.

Figure 76. ULTRA-SAFE™ Mounting Configuration



Classes I and II, Division 1 and 2  
Groups B, C, D, F and G  
Temperature Code  
T3C,  $320^{\circ}\text{F}$  ( $160^{\circ}\text{C}$ )



Ratings Available  
• Up to 240 KW  
• Up to 600V



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# ULTRA-SAFE™ Explosion-proof Duct Heaters

## Temperature Control

**Single Stage Control** – For many applications, single stage on/off control is adequate. For higher KW ratings using two heat exchanger modules (unit size codes D, E, and F in **Table XIX** on page 51), each module may constitute a heating circuit. Non-catalog multi-unit designs with up to four ULTRA-SAFE™ duct heater units in series are also available.

**Solid-State SCR Control** – When temperature must be controlled precisely, built-in SCR's manufactured by INDEECO are recommended. They are furnished with field-selected inputs of 2200 or 135 ohms, 0-10 VDC, or 4-20 mA. SCR's have zero-cross firing to eliminate radio frequency interference.

To meet FM and CSA requirements, non-catalog multi-unit designs (up to four heating units in series) also have controls set at 80°F (27°C) to limit the inlet air temperature to all but the inlet unit. These limit controls prevent excessive temperatures at the heater outlet as the inlet air temperature rises.

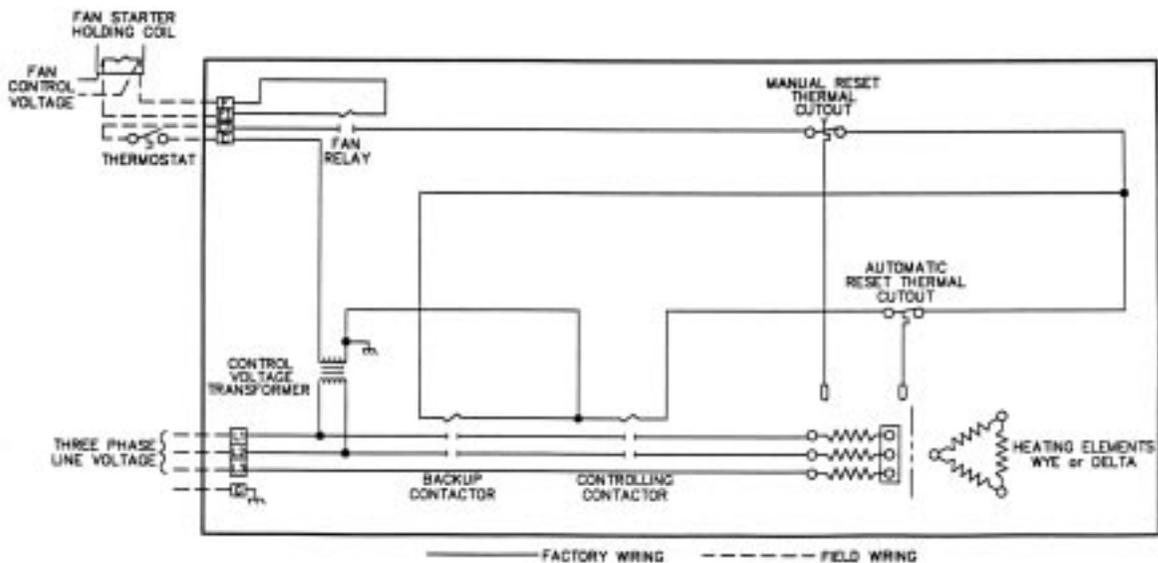


Figure 77. Heater with Single Stage Control

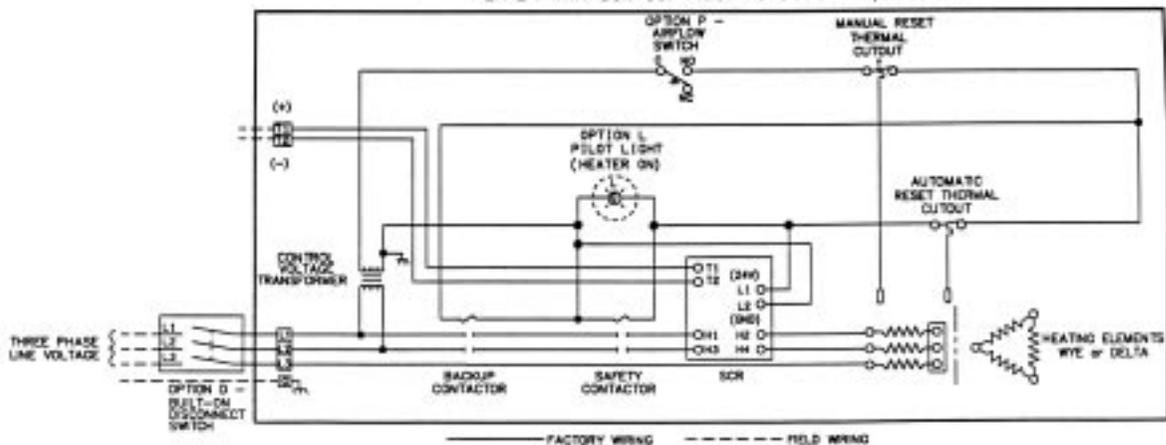


Figure 78. Heater with SCR Control and Options D, L and P

# ULTRA-SAFE™

## Explosion-proof Duct Heaters

**Table XIX**  
**Standard Heater Listing**

Catalog Number	KW	Inside Duct Dimensions - in (cm)		Depth(2) in (cm)	Weight(2) lb (kg)	Unit Size Code	Max. KW Available(2)
		Minimum(1) W x H	Maximum W x H				
227F30A003 227F30A005 227F30A008 227F30A010	3 5 7.5 10	12 x 12 (30.5 x 30.5)	18 x 24 (45.7 x 61)	8 (20.3)	130 (59)	A	40
227F30B003 227F30B005 227F30B010 227F30B015 227F30B020	3 5 10 15 20	16.5 x 16 (41.9 x 40.6)	22.5 x 28 (57.2 x 71.1)	12 (30.5)	150 (68)	B	80
227F30C010 227F30C015 227F30C020 227F30C025 227F30C030	10 15 20 25 30	21 x 21 (53.3 x 53.3)	27 x 35 (68.9 x 88.9)	12 (30.5)	200 (91)	C	120
227F30D006 227F30D010 227F30D015 227F30D020	6 10 15 20	24 x 12 (61 x 30.5)	36 x 24 (91.4 x 61)	8 (20.3)	260 (118)	D	80
227F30E006 227F30E010 227F30E020 227F30E030 227F30E040	6 10 20 30 40	33 x 16 (83.8 x 40.6)	45 x 28 (114.3 x 71.1)	12 (30.5)	300 (136)	E	160
227F30F020 227F30F030 227F30F040 227F30F050 227F30F060	20 30 40 50 60	42 x 21 (106.7 x 53.3)	54 x 35 (137.2 x 88.9)	12 (30.5)	390 (177)	F	240

(1) Use only Minimum W x H dimensions for minimum air velocity calculations (see page 47).  
 (2) Depth and weights shown for catalog listed KW ratings. They will be greater for larger KW, non-catalog designs. Max KW based on non-catalog designs with 4 units in series.

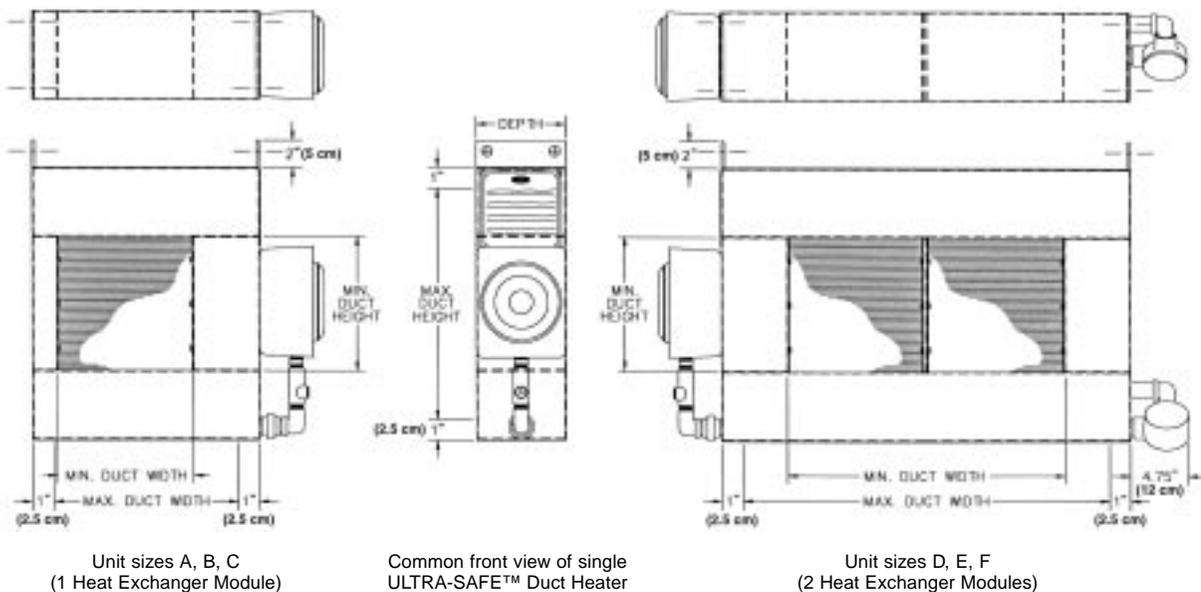


Figure 79. Dimensions

# ULTRA-SAFE™

## Explosion-proof Duct Heaters

Table XX  
Custom Options

Option	Description	Code
Corrosion Resistant Construction	Stainless frame, coated heat exchanger, epoxy-coated NEMA 4X, 7, 9 terminal box, conduit and fittings.	C
Built-on Disconnect Switch	To meet NEC requirement for a disconnect at or within sight of the heater. (Not available for outdoor or washdown use)	D
Built-on Airflow Switch	An explosion-proof differential pressure switch replaces the fan relay. Use only for positive pressure inside the duct. (Not available for outdoor or washdown use)	P
Supplementary Fusing	For heaters drawing 48 amps or less. Fusing is standard above 48 amps.	F
“Warning” Pilot Light	Red light to indicate when a thermal cutout or airflow interlock has tripped.	K
“Heater On” Pilot Light	Green light indicates when there is power to the heater.	L
Disconnecting Magnetic Contactors	Contactors that break all ungrounded lines replace standard de-energizing contactors.	M
120 Volt Control Circuit	A 120V control transformer with one leg fused replaces the standard 24V transformer.	V
NEMA 4 Construction	Explosion-proof box is gasketed for outdoor or wet locations.	G
Group B Construction	For Class I, Group B areas. Heater will be rated for Classes I and II; Divisions 1 and 2; Groups B, C, D, E, F and G.	Z

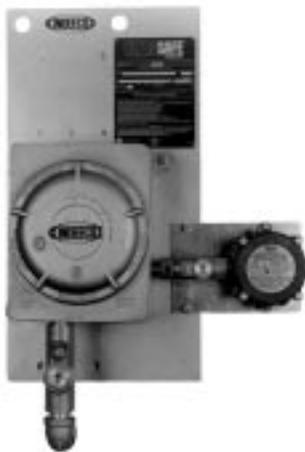


Figure 80. Built-on Airflow Switch



Figure 81. Built-on Disconnect Switch

## Explosion-proof Duct Heaters

### How to Order

1. **Catalog No. or Size** – For Standard Selections, specify Catalog Number from **Table XIX** on page 51. For special KW ratings, specify Size Code and KW Ratings.
2. **KW Rating** – Up to the maximum shown in **Table XIX**.
3. **Heater Voltage and Phase**
4. **Temperature Control** – Single Stage or SCR Control. If SCR Control, specify input signal.
5. **Fan Relay Voltage** – Specify 24 or 120 volt to match fan starter holding coil voltage.
6. **Airflow Direction** – Horizontal Right-Hand or Left-Hand airflow, as defined on page 47.
7. **Options** – Select from ULTRA-SAFE™ Custom Option codes in **Table XX**.

### Sample Specification

A sample specification can be prepared by using the following information. A circle has been supplied so that you may darken those sections which you require. Material which is part of the standard ULTRA-SAFE™ Explosion-proof Duct Heater specification has already been darkened.

- 1. Electric explosion-proof duct heaters shall be INDEECO ULTRA-SAFE™ Series, of the KW rating, voltage, phase, duct size and airflow direction specified in the schedule. They shall be Factory Mutual and CSA Approved for:
  - Class I, Divisions 1 and 2, Groups C and D; Class II, Divisions 1 and 2, Groups E, F, and G Ignition Temperature Code No. T3C, 320°F (160°C).
  - Class I, Divisions 1 and 2, Groups B, C, and D; Class II, Divisions 1 and 2, Groups E, F, and G Ignition Temperature Code No. T3C, 320°F (160°C).
- 2. Duct heaters shall have automatic and manual reset thermal cutouts for redundant overtemperature protection, fan relay for airflow interlock, de-energizing controlling and backup magnetic contactors, 24 volt

control circuit transformer, terminal blocks for field wiring and supplementary fusing for heaters over 48 amps. Controls shall be housed in a NEMA 7, 9 cast aluminum enclosure.

- 3. The heat exchanger shall be liquid-to-air design, utilizing a copper tube core with integral aluminum fins. Nontoxic, inhibited, propylene glycol heat transfer fluid shall be used that provides freeze protection down to -49°F (-45°C). Pressure relief valve setting to be 70 psig. The heat exchanger shall include industrial grade INDEECO electric heating elements.
- 4. Duct heaters shall be furnished with the control option indicated below (select one):
  - Single stage on/off control with field installed thermostat.
  - Solid-state control with built-in zero-cross switching SCR and field installed thermostat.
- 5. The following options are to be included:
  - Corrosion resistant stainless steel construction with iridite coated heat exchanger, epoxy coated NEMA 4X, 7, 9 terminal box, conduit and fittings.
  - Built-on disconnect switch (not available with Group B construction).
  - Supplementary fusing for heaters drawing less than 48 amps.
  - Warning pilot light to indicate overtemperature or no airflow.
  - “Heater On” pilot light to indicate power to the heater.
  - Disconnecting magnetic contactors.
  - Built-on airflow switch in place of the fan relay (not available with Group B construction).
  - 120 volt transformer in place of 24 volt transformer.
  - NEMA 4, 7, 9 gasketed control box for wet locations.

### Typical ULTRA-SAFE™ Duct Heater Schedule

Tag No.	KW	Supply Line		Stages	Duct Dimensions (Inches)		Special Features
		Volts	Phase		W (Width)	H (Height)	
DH1	10	480	3	1	18	12	Built-on disconnect switch
DH2	15	480	3	1	36	18	Corrosion resistant construction
DH3	75	480	3	1	48	24	

# Series EP2 Explosion-proof Duct Heaters

## Standard Construction

**Galvanized Sheet Metal Frame** includes external flanges for field mounting, and an element terminal box. Terminals are factory-connected to control and safety components in an integral cast aluminum explosion-proof box.

**Three Levels of Safety** are provided on every heater: automatic and manual reset thermal cutouts, plus a fan interlock relay.

The automatic reset cutout, operating through the temperature control system, is the primary protector. The manual reset operates a separate backup magnetic contactor, independent of the temperature control system. The fan interlock relay prevents the heater from being energized unless the fan starter is on.

**Standard Built-in Control Package** includes the following components mounted in a cast aluminum explosion-proof enclosure:

- De-energizing control and backup magnetic contactors.
- 24 volt control circuit transformer.
- Fan relay for heater/fan airflow interlock. Supplied with 120V or 24V coil to match the fan starter.
- Terminal blocks for field power and control wiring.
- Grounding terminal.
- Supplemental fusing for heaters drawing more than 48 amps.

**Industrial Grade Heating Elements**, built by INDEECO, are .475" (1.21 cm) diameter to provide extra insulation between the coil and sheath for high voltage protection. Stainless steel fins are helically wound onto the stainless steel sheath.

## Control Options

Two standard control options are available:

**Staged Control** – Either single or multi-staged through a step controller, which may be built-in or remotely mounted. Each three-phase stage has a multiple of three elements to balance the electrical load.

**Solid-State SCR Control** – When temperature must be controlled precisely, built-in SCR's are recommended. They are furnished with field-selected inputs of 2200 ohms, 135 ohms, 0-10 VDC, or 4-20 mA. SCR's have zero-cross firing to eliminate radio frequency interference.

## Installation

Complete installation instructions are furnished with each heater. The following are some guidelines:

- The heater must be attached to external duct flanges.
- The heater must be adequately supported. If the duct flanges will not afford enough support, use overhead hangers for additional support.
- Airflow must be horizontal. See page 47 for airflow requirements.



Figure 82. Series EP2 Explosion-proof Duct Heaters



# Series EP2 Explosion-proof Duct Heaters

Table XXI

Custom Options

Option	Description	Code
Built-in Step Controller	For two through ten heating stages. Input is field-selected at 2200 ohms, 135 ohms, 0-10 VDC, or 4-20 mA.	B
Built-on Disconnect Switch	To meet NEC requirement for a disconnect at or within sight of the heater.	D
Built-on Airflow Switch	An explosion-proof differential pressure switch replaces the fan relay. Use only for positive pressure inside the duct.	P
Supplementary Fusing	For heaters drawing 48 amps or less. Fusing is standard above 48 amps.	F
“Warning” Pilot Light	Red light to indicate when a thermal cutout or airflow interlock has tripped.	K
“Heater On” Pilot Light	Green light indicates when there is power to the heater.	L
Disconnecting Magnetic Contactors	Contactors that break all ungrounded lines replace standard de-energizing contactors.	M
120 Volt Control Circuit	A 120V control transformer with one leg fused replaces the standard 24V transformer.	V
NEMA 4 Construction	Explosion-proof box is gasketed for outdoor or wet locations.	G

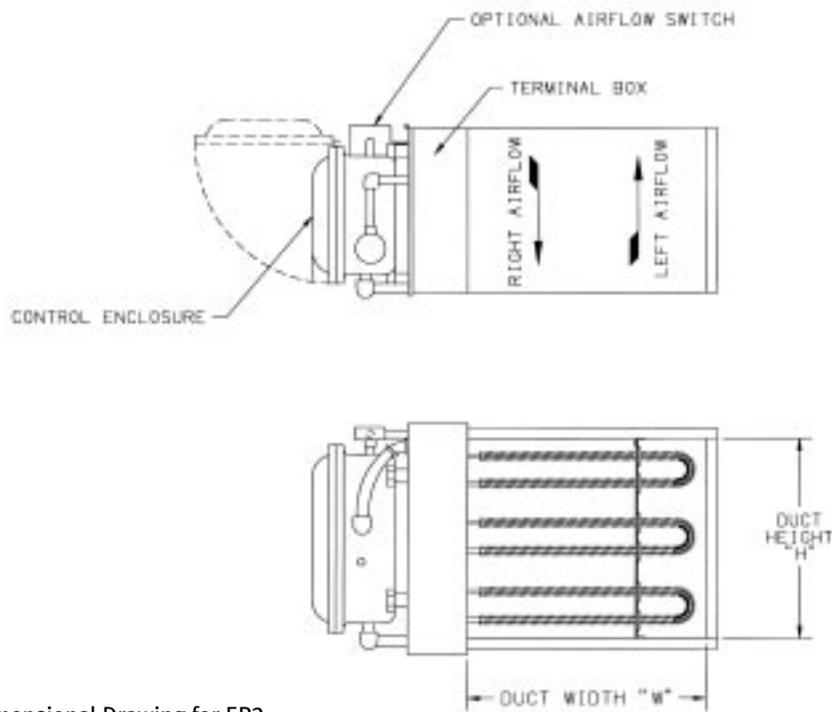


Figure 83. Dimensional Drawing for EP2



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# Series EP2

## Explosion-proof Duct Heaters

### How to Order

1. **Inside Duct Dimensions** – Width (W) by Height (H) per Dimensional Drawing on page 55. Maximum size 240" (610 cm) x 120" (305 cm). Other dimensions will be shown on certified print.
2. **KW Rating** – Up to 1000 KW.
3. **Heater Voltage and Phase**
4. **Temperature Control** – Staged or SCR control. If staged, specify number of stages (one through ten). If SCR control, specify input signal.
5. **Fan Relay Voltage** – Specify 24 or 120 volt to match fan starter holding coil voltage.
6. **Airflow Direction** – Horizontal right-hand or left-hand airflow, as defined on page 47.
7. **Airflow Volume** – Minimum flow in SCFM (Standard Cubic Feet per Minute) over the heater.
8. **Maximum Inlet Air Temperature** – Maximum of 80°F (27°C). If inlet air will be higher, consult factory.
9. **Options** – Select from EP2 Custom Option codes in **Table XXI**.

### Sample Specification

A sample specification can be prepared by using the following information. A circle has been supplied so that you may darken those sections which you require. Material which is part of the standard Series EP2 Explosion-proof Duct Heater specification has already been darkened.

- 1. Electric explosion-proof duct heaters shall be INDEECO Series EP2 of the KW rating, voltage, phase, duct size and airflow direction specified in the schedule. They shall be Factory Mutual and CSA Approved for:
  - Class I, Division 2, Groups C and D, Ignition Temperature Code T3, 392°F (200°C)

- 2. Duct heaters shall have automatic and manual reset thermal cutouts for redundant overtemperature protection, fan relay for airflow interlock, de-energizing controlling and backup magnetic contactors, 24 volt control circuit transformer, terminal blocks for field wiring and supplementary fusing for heaters over 48 amps. Controls shall be housed in a NEMA 7, 9 cast aluminum enclosure.
- 3. Duct heaters shall consist of industrial grade INDEECO stainless steel finned tubular electric heating elements mounted in a heavy-gauge galvanized steel frame.
- 4. Duct heaters shall be furnished with the control option indicated below (select one):
  - Single stage on/off control with field installed thermostat.
  - Multi-staged control with built-in step controller and field installed thermostat.
  - Solid-state control with built-in zero-cross switching SCR and field installed thermostat.
- 5. The following options are to be included:
  - Built-on disconnect switch.
  - Built-on airflow switch in place of the fan relay.
  - Supplementary fusing for heaters drawing less than 48 amps.
  - "Warning" pilot light to indicate overtemperature or no airflow.
  - "Heater On" pilot light to indicate power to the heater.
  - Disconnecting magnetic contactors.
  - 120 volt transformer in place of 24 volt transformer.
  - NEMA 4, 7, 9 gasketed control box for wet locations.

### Typical Series EP2 Duct Heater Schedule

Tag No.	KW	Supply Line		Stages	Duct Dimensions (Inches)		Special Features
		Volts	Phase		W (Width)	H (Height)	
DH1	3	480	3	2	24	12	Built-on disconnect switch
DH2	10	480	3	3	36	18	
DH3	15	480	3	5	72	24	Warning pilot light

# Custom Explosion-proof Duct Heaters

## Construction

Heaters are generally constructed per Series EP2 (see page 54), except that element terminals as well as control components are built into a single cast aluminum explosion-proof enclosure.

**Frame** – Sized to fit the duct. Standard flanged design recommended to support heater weight. Slip-in also available if necessary to match other equipment. Galvanized steel standard; stainless steel optional.

**Control Enclosure** – NEMA 7, 9 cast aluminum box with hinged cover houses controls and element terminals. Weatherproof construction optional.

**Heating Elements** – Heavy wall, large diameter stainless steel finned tubular elements, individually removable for servicing.

**SCR Temperature Control** – SCR's with zero-cross firing provide precise proportional control. SCR's also minimize element operating temperatures for extra safety. Optional on/off single or multi-stage control also available.

**Overtemperature Protection** – Thermocouple controllers measure element sheath temperature.

- Automatic reset control resets when temperature drops to a safe level.
- Manual reset control with external button provides back-up protection.

**Fuses** – Individual circuit fusing for heaters drawing over 48 amps to meet NEC requirements.

**Airflow Interlock** – Fan relay prevents heater operation unless fan is energized. Optional built-in or remote explosion-proof airflow switch can be provided.

**Magnetic Contactors** – Furnished as required for temperature and safety controls.

**Control Transformer** – Furnished as standard with fusing as required.

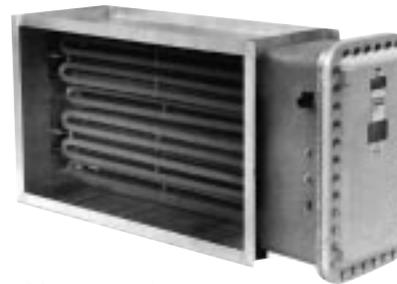


Figure 84. Custom Duct Heater

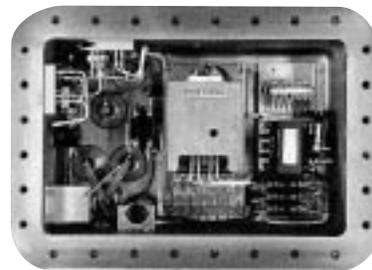


Figure 85. Control Enclosure

Class I, Division 1 and 2  
Groups C and D

Class II, Divisions 1 and 2  
Groups E, F, and G

Although built to hazardous safety standards,  
these heaters are not FM or CSA Approved.



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# Custom Explosion-proof Duct Heaters

## How to Order

1. **Construction Type** – Standard flanged or optional slip-in. See Figures 86A and 86B.
2. **Electrical Ratings** – Line voltage, KW, Phase and Control Voltage.
3. **Inside Duct Dimensions** – Width and Height.
4. **Temperature Control** – Staged or SCR Control. If staged, specify number of stages (one through ten). If SCR control, specify input signal.
5. **Airflow Direction** –
  - Horizontal (Right or Left).
  - Vertical (Up or Down).
6. **Airflow Volume** – Minimum flow in SCFM (Standard Cubic Feet per Minute) over the heater.
7. **Maximum Inlet Air Temperature** – Maximum of 80°F (27°C). If inlet air will be higher, consult factory.
8. **Classification of Hazardous Area** – Class, Group, Ignition Temperature and NEC I.D. Code No.
9. **Options** – Select from EP2 Custom Option codes in **Table XXI** on page 55.

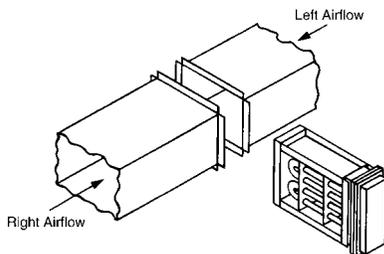


Figure 86A. Standard Flanged Heater Installation

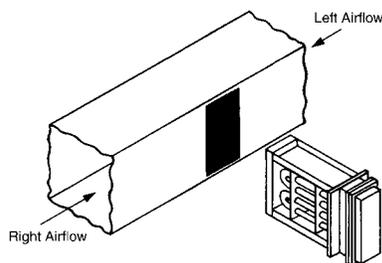


Figure 86B. Optional Slip-in Heater Installation

## Sample Specification

A sample specification can be prepared by using the following information. A circle has been supplied so that you may darken those sections which you require. Material which is part of the standard Custom Explosion-proof Duct Heater specification has already been darkened.

- 1. Electric explosion-proof duct heaters shall be INDEECO custom explosion-proof, the KW rating, voltage, phase, duct size, construction type and airflow direction specified in the schedule. They shall be approved for:
  - Class I, Divisions 1 and 2, Groups C and D, and NEC Ignition Temperature I.D. Code Number \_\_\_\_\_ (please specify).
  - Class II, Divisions 1 and 2, Groups E, F, and G, and NEC Ignition Temperature I.D. Code Number \_\_\_\_\_ (please specify).
- 2. Duct heaters shall have automatic and manual reset thermal cutouts for redundant overtemperature protection, fan relay for airflow interlock, de-energizing controlling and backup magnetic contactors, 120 volt control circuit transformer, terminal blocks for field wiring and supplementary fusing for heaters over 48 amps. Controls shall be housed in a NEMA 7, 9 cast aluminum enclosure.
- 3. Duct heaters shall consist of industrial grade INDEECO stainless steel finned tubular electric heating elements mounted in a heavy-gauge galvanized steel frame.
- 4. Duct heaters shall be furnished with the control option indicated below (select one):
  - Single stage on/off control with field installed thermostat.
  - Multi-stage control with built-in step controller and field installed thermostat.
  - Solid-state control with built-in zero-cross switching SCR and field installed thermostat.
- 5. The following options are to be included:
  - Built-on disconnect switch.
  - Supplementary fusing for heaters drawing less than 48 amps.
  - Warning pilot light to indicate overtemperature or no airflow.
  - "Heater On" pilot light to indicate power to the heater.
  - Disconnecting magnetic contactors.
  - Built-on airflow switch in place of the fan relay.
  - 24 volt transformer in place of 120 volt transformer.
  - NEMA 4, 7, 9 gasketed box for wet locations.

# Limited Warranty

Industrial Engineering and Equipment Company (INDEECO) products are warranted against defects in workmanship, material, design, labeling and packaging. No other warranty, expressed or implied, written or oral, applies. No person other than an officer or the general manager of INDEECO is authorized to give any other warranty or assume any liability.

**Warranty Period:** This warranty is effective for eighteen months from the date of shipment of the product from INDEECO's factory, or for twelve months from the date the product is first placed in service, whichever period lapses first.

**Conditions of Warranty:** INDEECO products must be installed, operated and maintained in accordance with INDEECO's instructions. INDEECO is not liable for damage or unsatisfactory performance of the product resulting from accident, negligence, alteration, unauthorized repair, improper application or installation of the product, improper specifications or corrosion. INDEECO IS NOT LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES. Claims against carriers for damage in transit must be filed by the purchaser with the carrier.

**Remedy:** The part or product in question should be returned, freight prepaid, to:

**INDEECO**

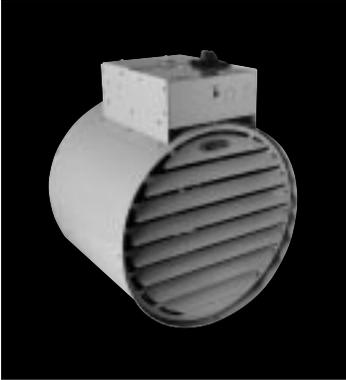
425 Hanley Industrial Court  
St. Louis, Missouri 63144  
Attention: Return Goods Manager

If after receipt of the product and the claim, INDEECO finds to its reasonable satisfaction that the product is defective in workmanship, material, design, labeling or packaging, the product will be repaired or replaced or the purchase price refunded at INDEECO's option. There will be no charge to the purchaser for parts or labor. Removal and reinstallation of the product, and shipment of the product to INDEECO for repair or inspection shall be at the purchaser's risk and expense.

THE REPAIR, REPLACEMENT OR REFUND PROVIDED FOR IN THIS LIMITED WARRANTY IS THE EXCLUSIVE REMEDY OF THE PURCHASER. THIS WARRANTY IS EXPRESSLY IN LIEU OF ANY OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE TERMS OF THIS LIMITED WARRANTY.



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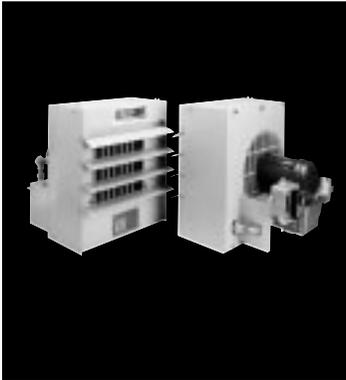
## Industrial Unit Heaters

- Ratings from 3 KW through 38 KW.
- Stainless steel finned tubular heating elements.
- Adjustable discharge louvers.
- Bracket for ceiling or wall mounting.
- Built-in controls.
- UL/cUL Listed.



## TRIAD® Washdown and Corrosion Resistant Unit Heaters

- Stainless steel construction with NEMA 4X enclosure.
- Built-in controls.
- Swivel mounting bracket.
- Ratings up to 47 KW.
- UL/cUL Listed and ABS Approved.



## Explosion-proof Unit Heaters

- ULTRA-SAFE™ Series T3C has industry's lowest ignition temperature code rating.
- Class I & II, Divisions 1 & 2, Groups C, D, E, F & G.
- Built-in controls.
- Unit Heater System Design available up to 91 KW.
- Small, economical COMPACT designs up to 12 KW.
- Factory Mutual (FM), CSA, ABS Approved.



## Explosion-proof Convectors

- Class I & II, Divisions 1 & 2, Groups B, C, D, E, F & G.
- Ratings from 500 to 9,500 watts.
- Sloped-top cabinet design.
- Available with built-in controls.
- Factory Mutual (FM), CSA, ABS Approved.





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