



HEATER TEST PROCEDURE

1. Dimensional

- 1.1 Attribute sample shall be checked for critical features against specifications and drawings.
- 1.2 100% Visual check for general standards of workmanship is to be conducted during electrical testing.

2. Electrical

The electrical tests shall be carried out on 100% of the elements

- 2.1 Resistance check. The cold resistance shall be measured across the element terminations. Resistance shall be nominal (refer to drawings) +/- 10%
- 2.2 Insulation Resistance Check. The insulation resistance shall be measured between any element terminal and the element sheath / cast body using a 500V Megger. IR shall be greater than 50 MΩ.
- 2.3 Flash Withstand Test. The appropriate test voltage specified shall be applied between any terminal or cable and the element sheath / cast body for 10 seconds unless a specific test voltage is identified on the drawing or the job sheet. No breakdown shall occur with a 5mA trip setting.

ALL REJECTED ITEMS SHALL BE IDENTIFIED AND RETURNED TO PRODUCTION FOR REPAIR OR REPLACEMENT.

3. Calibration of Test Equipment

All test equipment shall carry a current calibration certificate conforming to the requirements of BSEN ISO9001-2008. All electrical test equipment is traceable to accurate records.

4. Certificate of Conformity

A Certificate of Conformity shall be completed and issued for each batch of product tested if required. The verifying inspector or Quality Manager will sign this, and a copy of the Certificate of Conformity shall accompany the goods when despatched. A duplicate copy is retained at our works.

5. NOTES:

- 1.1 All holes / cut outs / slots not produced by Soloheat Ltd may void any warranty on heaters.
- 1.2 Heaters cannot be guaranteed against cavitations.

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