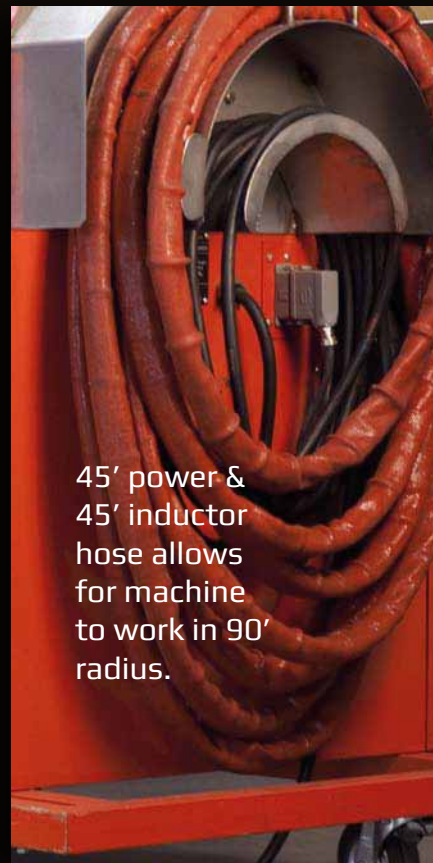




INDUCTOR SIZE SELECTION WORKSHEET



Built-in air/water heat exchanger
No water connection needed
HF generator power=20kW
Accepts any voltage from 250
to 500 volts
Worldwide operation without
modification



45' power &
45' inductor
hose allows
for machine
to work in 90'
radius.



ACCESSORIES

World class tools brought to you by your local distributor:



First Bolting sprl
Phone: +32 2 358 1933
Fax: +32 2 358 5066
Ave Louise, 306
B-1050 Brussels
Belgium

www.1bolting.com
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First Bolting IBH
Induction Bolt Heating

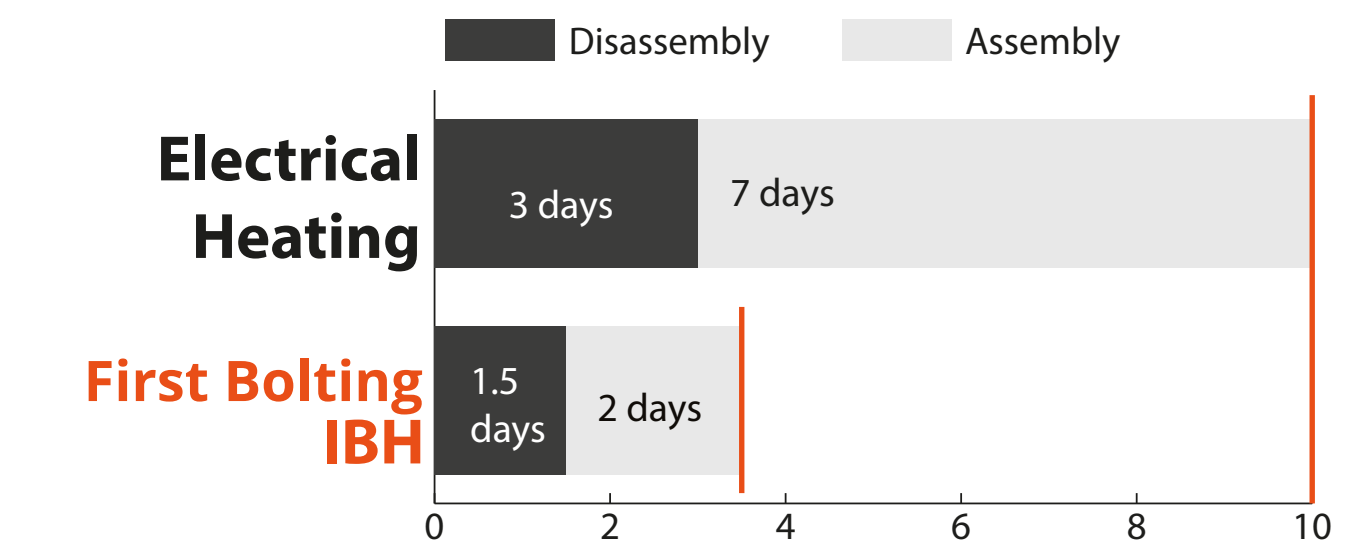
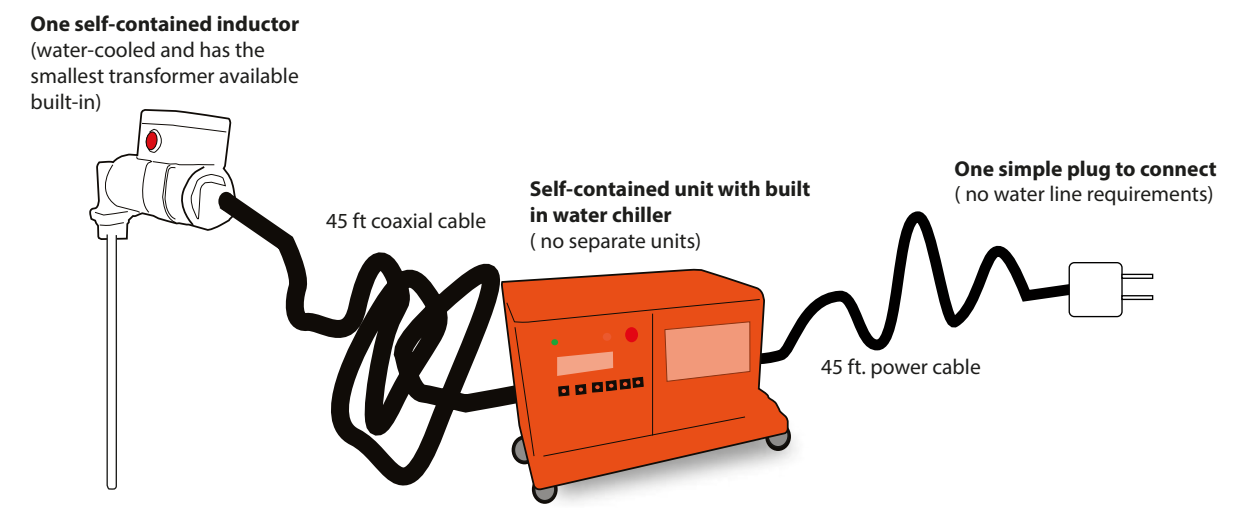
First Bolting IBH
INDUCTION BOLT HEATING

Advanced Bolt Heating
First Bolting engineers saw an opportunity to greatly reduce wasted downtime. With costs for downtime quickly escalating, there had to be a way to work fast, safe and efficiently. First Bolting IBH is the answer.

Self-contained water chiller allows for easy one plug setup. External water level indicator shows water level.

Easy-to-use control panel.

First Bolting IBH does not generate heat, as the case with electric, gas and radiant heating technologies. It uses induction heating, causing the bolt to heat itself. Induction heating occurs when a material capable of conducting electrical current, not necessarily ferrous or magnetic, is placed in a varying magnetic field. The material becomes heated as a result of hysteresis and eddy current losses. Hysteresis occurs with magnetic materials and is produced by retardation of the magnetization effect caused by the friction of the molecules, when the material is magnetized in one direction, then reversed at a very high frequency.



1

Optimal heating length

First Bolting technicians choose the best inductor size for the bolt, and especially look for the optimal heating length to work as fast and safe as possible.

First Bolting has the widest range of inductor sizes available and will even build a custom size for the applica-

2

Proper inductor size is confirmed

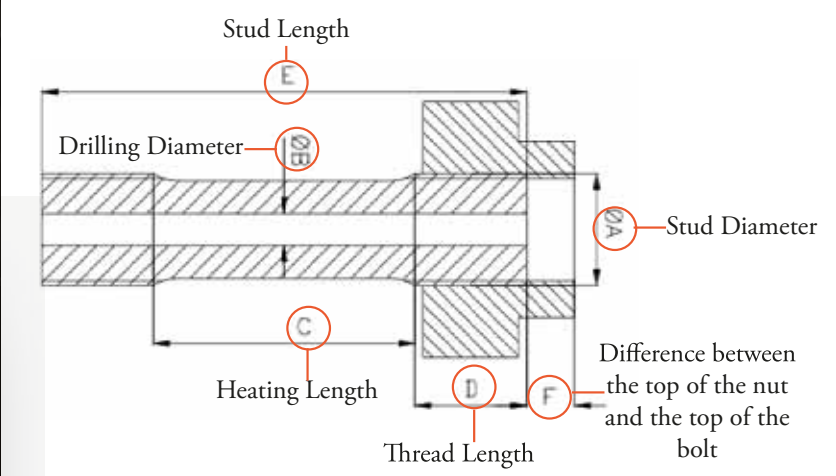
Once on the field, the technicians ensure the right inductor is chosen.

The ideal inductor will target the optimal heating length; this allows the electromagnetic field to work on the core of the stud and minimize heat transfer to other critical components.

3

Induction heating does the rest

First Bolting IBH controlled heating method heats only the center of stud and it minimizes heat transfer to the surrounding metal. In a short period of time, the stud is heated properly and assembly/disassembly can begin.



| Stud Diameter ØA | Stud 1 | Stud 2 | Stud 3 | Stud 4 | Stud 5 | Stud 6 | Stud 7 | Stud 8 |
|--|--------|--------|--------|--------|--------|--------|--------|--------|
| Drilling Diameter ØB | | | | | | | | |
| Heating Length C | | | | | | | | |
| Thread Length D | | | | | | | | |
| Stud Length E | | | | | | | | |
| Difference between the top of the nut and the top of the bolt F | | | | | | | | |