

BUSSE

HEIZPLATTENTECHNIK GMBH



Busse Heizplattentechnik GmbH
Fritz-Souchon-Straße 22
D-32339 Espelkamp
Telefon +49.5772.97750
Telefax +49.5772.977555
Info @busse-heizplattentechnik.de
www.busse.cc

REPAIR INSTRUCTION
for defected electric heating plates

To repair an electrically defective heating plate, please proceed as follows:

- Loosen the fixing screws of the heating plate and remove the plates from the press. Now unscrew the connection box and detach the 3 or 4 mm cover plate from the lower 5 or 6 mm base plate.
- This is done by driving a pointed object into the adhesive joint at 2 corners of the heating plate and thus loosening the adhesive joint. Then the cover plate is peeled off the lower base plate by lifting it.
- Now the heating wire is pulled out of the grooves and the grooves are cleaned of the remaining glue. In the case of the long grooves, this is done with a high-speed drill that is pulled through the grooves. The transverse grooves are cleaned with a chisel. Now the surfaces of the cover sheet and the base sheet are cleaned of adhesive using a grinder.
- Once these operations have been carried out carefully, the new heating wire is inserted. It should be noted that the wire will stretch during later operation. Consequently, the wire must be placed in the transverse grooves in such a way that it does not rub against the corners.
- Furthermore, the fastening nuts in the base plate must be checked and the nuts with a defective thread must be re-placed.
- Now apply a thin layer of Hotplate Adhesive 1160, preferably to the cover sheet, using a spatula. (Approx. 0.3 kg per m²). Make sure that no adhesive is applied to the fixing nuts, as this would block the threads.
- Afterwards, both sheets are put together and pushed into a bonding press. Make sure that the heating wire remains in the grooves.
- After that, the press is run to approx. 1 -2 kg/cm² pressure. Then the heating of the press is switched on and the plate is heated up to 130° C. The plate has to be heated up after reaching this temperature.
- After reaching this temperature, the plate must remain at this temperature for another 1 hour so that the adhesive hardens. Now the heating is switched off and the heating plate should cool down under pressure.
- After the heating plate has cooled down, the temperature sensor hole is drilled out, the edges are ground and the connection box is screwed on. The heating plate is ready for operation again.