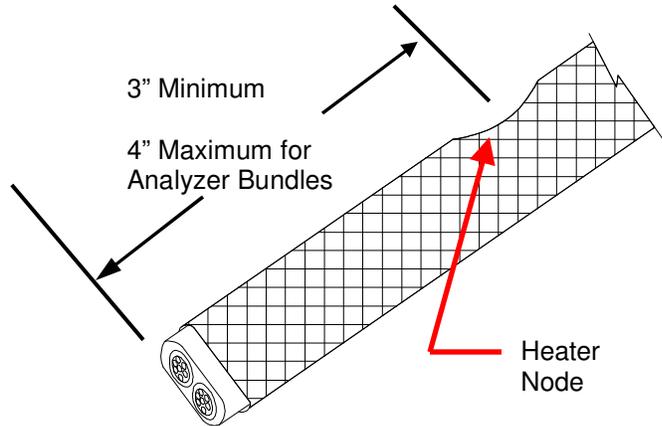


# CPD TERMINATION

The details below show the proper way to terminate a Dekoron/Unitherm CPD heating element using components from the 1548-1200x Electrical Connection Kit. This procedure should be used in all cases and **MUST** be used for applications where the bundle is operating at temperatures above 250°F (121°C) or in hazardous locations.

## Step 1: Locate the Heater Node

The heater node appears as a notch or lump in the side of the heater.  
The heater termination should be no less than 2 inches from the node.  
If the application is an analyzer bundle, the termination should be no more than 4 inches from the node.

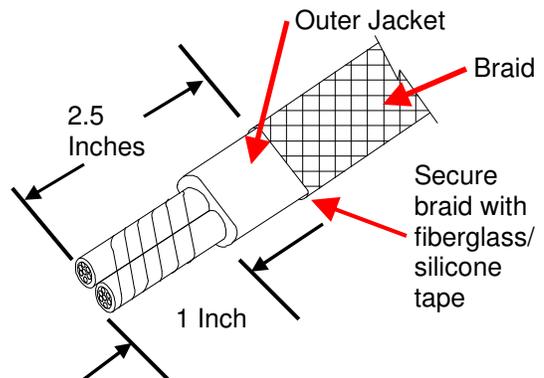


## Step 2: Trim the Outer Jacket

Trim the braid 2.5 inches from the end of the heater.

Secure the braid to the heater with fiberglass/silicone tape.

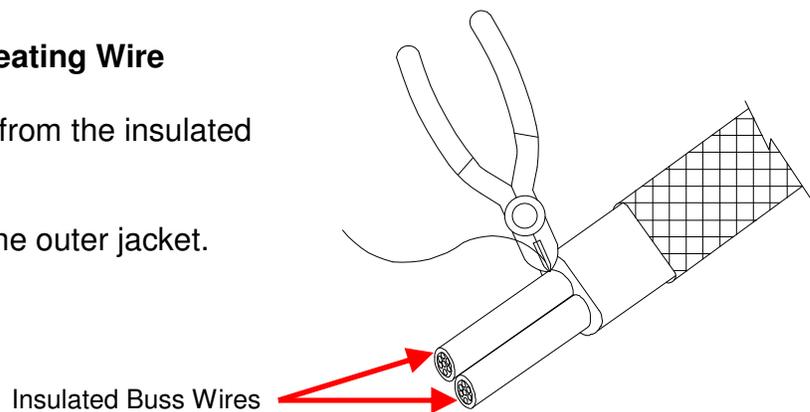
Remove the outer jacket 1 inch from the end of the heater.



## Step 3: Remove the Nichrome Heating Wire

Unwind the nichrome heating wire from the insulated buss wires.

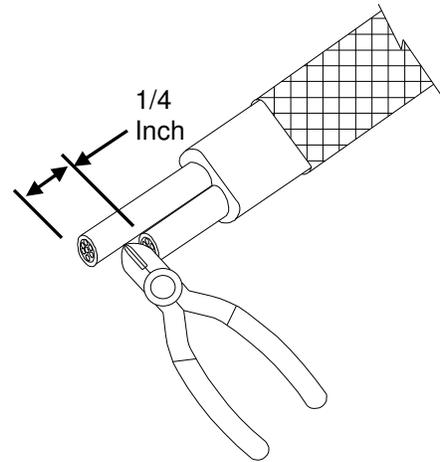
Cut this wire where it goes under the outer jacket.



## Step 4: Trim ONE buss wire

Trim one buss wire 1/4 inch behind the other.

**DO NOT REMOVE ANY INSULATION FROM THE BUSS WIRES**

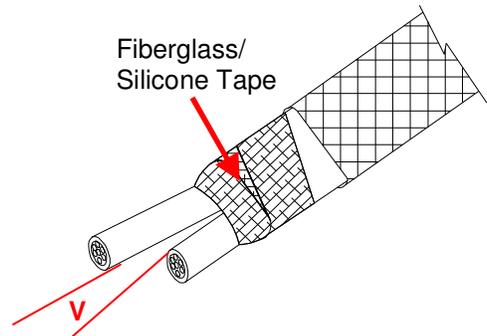


## Step 5: Secure heater wire

Insulate the end of the heater using fiberglass/silicone tape to insure the small nichrome heating wire does not come in contact with either buss wire or the braid.

Separate the two buss wires, forming a "V".

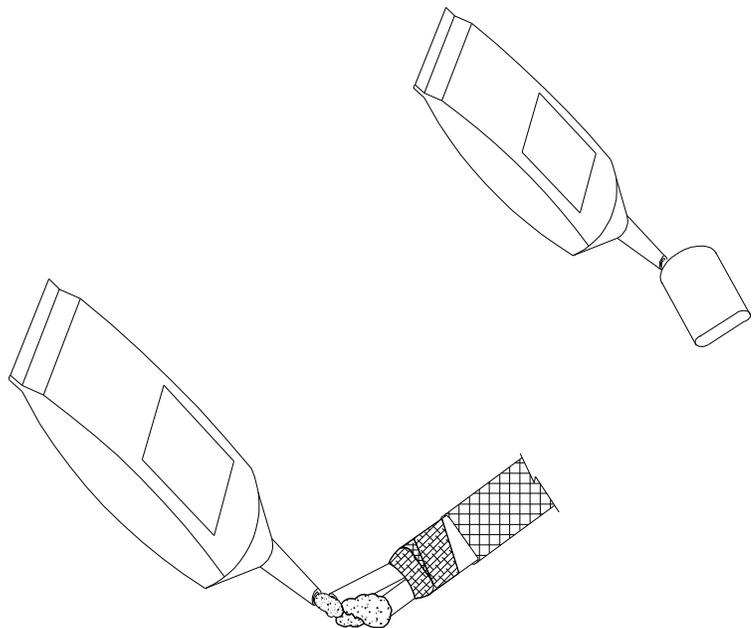
**DO NOT REMOVE ANY INSULATION FROM THE BUSS WIRES**



## Step 6: Coat the end of the heater

Apply RTV silicone to the end of the heater .

Also place a bead of RTV silicone inside each pocket of the white silicone end seal boot.



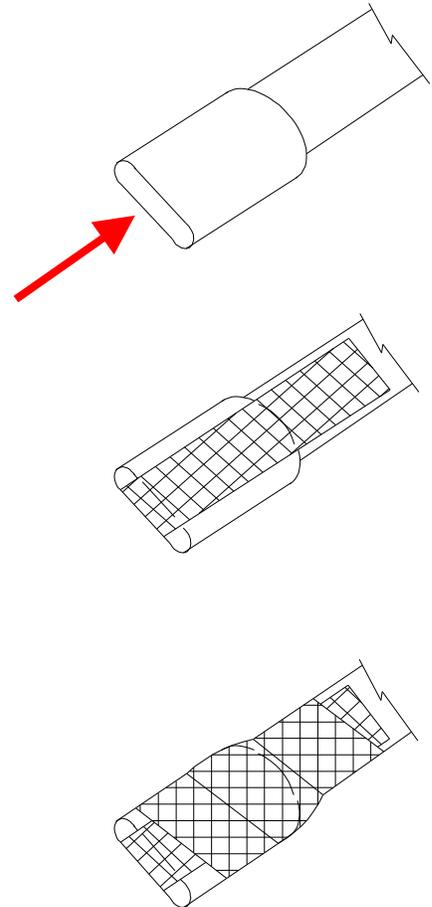
**Step 7: Install Silicone Boot and Secure**

Slide the silicone boot over the heater. Each buss wire should be in a separate pocket in the boot and covered with RTV silicone.

Secure the boot to the heater with a long strip of fiberglass/silicone tape over the end of the boot.

Secure this tape by winding fiberglass/silicone tape around the heater and boot.

Secure the completed termination to the bundle core using fiberglass/silicone tape.

**Final Step: Test the Termination**

Test the termination by checking the heater resistance.

The resistance from buss wire—to—buss wire should be as noted on the design sheet or tool sheet. The resistance from the buss wires to the braid should be infinite.

Hypot the heater per standard test procedure STP 82-04-06 with both buss wires tied together to the braid. If the heater will not pass the hypot test, recheck the termination and the power end connection. If both connections are insulated properly, contact your supervisor.