

FAG



FAG PowerTherm

HEATER35
HEATER150
HEATER300
HEATER600
HEATER1200

User manual

SCHAEFFLER GROUP
INDUSTRIAL

FAG PowerTherm

	Page
Features	
Safety guidelines.....	3
HEATER35 to HEATER1200.....	3
Scope of delivery.....	4
Initial operation of devices	
Safety guidelines.....	5
Trolley for HEATER300.....	6
Positioning of workpieces.....	6
Configuring HEATER35, 150, 300.....	7
Configuring HEATER600, 1200.....	8
Heating of rolling bearings	
Temperature-controlled heating process.....	10
Time-controlled heating process.....	11
Troubleshooting	
Error messages in the display.....	11
Alignment of ledges.....	12
Technical data	
HEATER35.....	13
HEATER150.....	14
HEATER300.....	15
HEATER600.....	16
HEATER1200.....	17
Spare parts	
HEATER35.....	18
Accessories	
HEATER150.....	19
Ordering designations	
HEATER300.....	20
HEATER600.....	21
HEATER1200.....	22
Specifications.....	23

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Features This manual is valid for the HEATER35, 150, 300, 600, 1200. The HEATERS are supplied in appropriate packaging. The packaging and the device should be checked immediately for any damage during transit. Photograph any damage and inform the carrier without delay.

Safety guidelines

Caution! It is essential that all instructions in this user manual are observed. Operating personnel must be authorised. Unauthorised persons should be kept at a distance during heating; it may be appropriate to close off the area.

Safety regulations must be kept ready with the device and observed. Heating devices must be operated and stored in dry rooms only – otherwise there is a risk of corrosion.

Remove any contamination and oil residues immediately. Ledges must be handled carefully; mechanical damage, deformation and moisture must be avoided.

Repairs should only be carried out by FAG Industrial Services (FIS) or authorised companies.

Only HEATER genuine spare parts should be used.

Schaeffler KG assumes no liability for damage arising from incorrect handling, negligence, modifications to the heating device or a failure to provide information to third parties.

HEATER35 to HEATER1200

The devices are used to heat rolling bearings, including sealed or greased bearings, for the purposes of easier mounting. They can also be used to heat other rotationally symmetrical steel parts such as bushes, rings, gears, etc. The permissible heating temperatures for INA and FAG brand bearings are given in the corresponding catalogues. For other products, the data provided by the manufacturer should be taken as valid.

Function The heart of each of the five heating devices is a live electric coil with an iron core (primary circuit). This induces a high current at low voltage in a short-circuited secondary circuit (a bearing or round workpiece). The part to be mounted is heated quickly; the device itself, the ledges and non-metallic components remain cool. After heating, the parts are demagnetised and voltage-free. Safe operation of the device is ensured by means of an integrated temperature cut-off switch, a current regulator (thyristor) and an overcurrent protector. The devices can be operated continuously without the need for cooling.

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Scope of delivery

- HEATER35** Heating device, slewing ledge for bore diameters from 70 mm, magnetic temperature sensor, metal box, safety gloves.
- HEATER150** Heating device, slewing ledge for bore diameters from 100 mm, magnetic temperature sensor, safety gloves.
- HEATER300** Heating device, slewing ledge for bore diameters from 115 mm, magnetic temperature sensor, safety gloves.
Accessories: Trolley HEATER300.TROLLEY, *Figure 1.*



Figure 1
HEATER300.TROLLEY

- HEATER600** Heating device, vertical ledge for bore diameters from 145 mm, magnetic temperature sensor, four support blocks, safety gloves.
- HEATER1200** Heating device, vertical ledge for bore diameters from 215 mm, magnetic temperature sensor, four support blocks, safety gloves.

Caution! The devices are top heavy – there is a risk of tilting.
When transporting with a fork lift truck or crane always pay attention to the fact that, due to the copper coil, the centre of gravity is located near the top, not in the middle. Aids must be designed in accordance with the weight of the heating devices.

Initial operation of devices

Safety guidelines

Danger! HEATER should never be used in rooms with an explosion risk. Persons with pacemakers must not use the devices or stay in their vicinity. Sensitive devices such as wristwatches, information media with a magnetic strip, electronic devices etc. may be rendered unusable – a safe distance of 2 metres must be maintained.

Caution! The material must be suitable for induction heating. The workpiece must be of a closed shape.

Workpiece weight limits must be observed:

- HEATER35: max. 35 kg
- HEATER150: max. 150 kg
- HEATER300: max. 300 kg
- HEATER600: max. 600 kg
- HEATER1200: max. 1200 kg

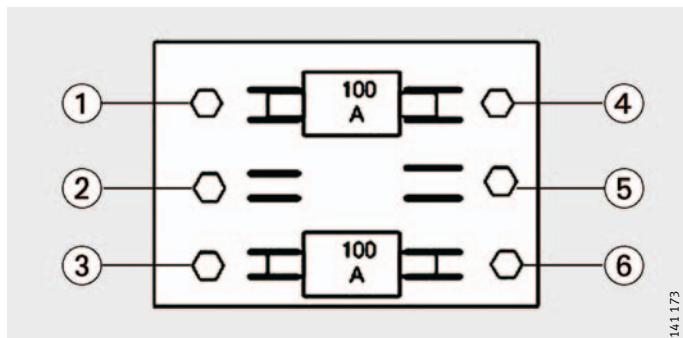
Work steps:

- Place the HEATER on a stable, flat surface.
- Ensure that the voltage of the power supply matches the voltage indicated on the identification plate.
- Connect to the mains supply.
If necessary, the mains plug should be changed by skilled personnel
- HEATER35: 3 strand cable; BROWN = live, BLUE = neutral, YELLOW-GREEN = earth (230 V, see rating plate).
- HEATER150, 300, 600: Mains plug with two phases (400 V, see rating plate)
- HEATER1200: Connect directly in terminal box, *Figure 2* (400 V, see rating plate).

- ① Live L1 (R)
- ② No connection
- ③ Live L2 (S)
- ④ Main switch
- ⑤ No connection
- ⑥ Main switch

Figure 2

Terminal box on HEATER1200



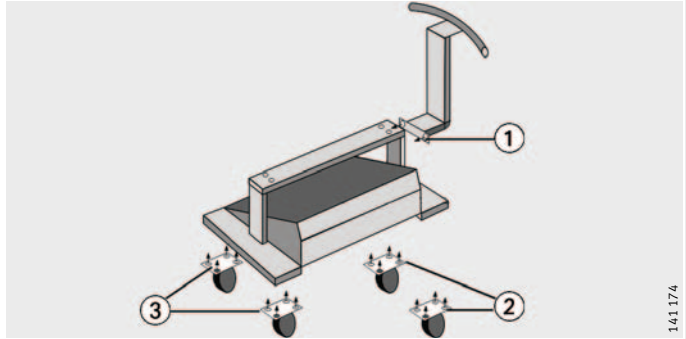
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Trolley for HEATER300

Mount the trolley handle and wheels using the screws supplied, *Figure 3*. Fasten the heating device to the support surface using four M8×30 screws, *Figure 4*.

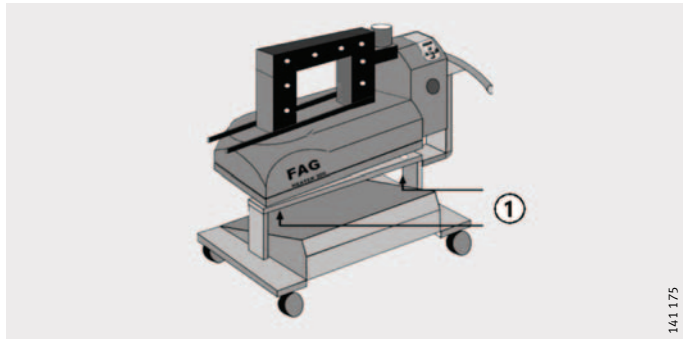
- ① 2 M10×12 screws for handle
- ② 8 M10×M12 screws for castors
- ③ 8 M10×M12 screws for fixed wheels

Figure 3
Assembling the trolley for HEATER300



- ① 4 M8×30 screws

Figure 4
Fastening HEATER300 to the trolley with screws



Positioning of workpieces

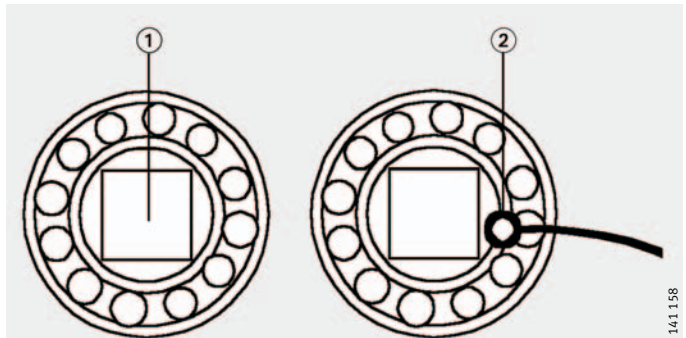
Caution!

Clean the ledges and magnetic temperature sensor.

Ensure that the inside diameter of the bearing is filled optimally, *Figure 5*, ①. The larger the cross-section of the ledge that is used, the shorter the heating time. On rolling bearings, position the magnetic temperature sensor as centrally as possible on the end face of the inner ring, *Figure 5*, ②.

- ① Optimally used ledge cross-section
- ② Position of the temperature sensor

Figure 5
Optimally used ledge cross-section and correct position of the temperature sensor



Configuring HEATER35, 150, 300

Caution!

Grease the ground surfaces of the ledges.
Position the horizontal ledge correctly.

Work steps: see *Figure 6*:

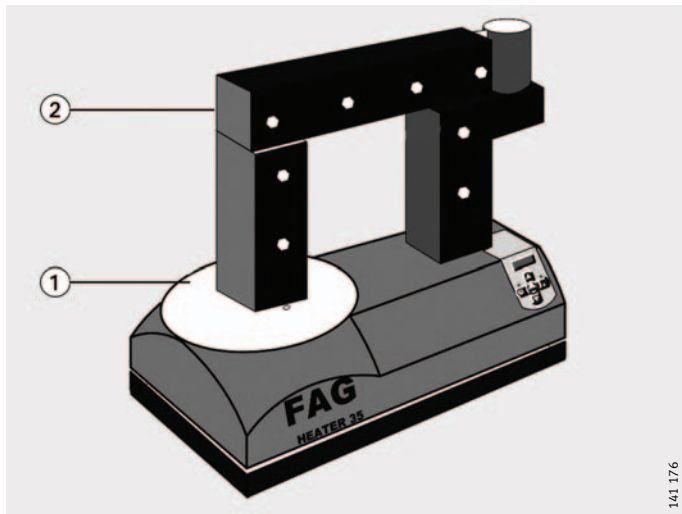
- Swivel the horizontal slewing ledge to the side.
- Place the bearing on the circular area above the induction coil ① or on the slewing ledge ②.
- Move the slewing ledge back to its original position, ground side downwards. Two identical bearings can be heated simultaneously on the slewing ledge ② or one of the accessory ledges.
- The weight limits must be observed.

Accessory ledges

Suitable accessory ledges should be used for smaller bore diameters. Remove the slewing ledge from the shaft and position the accessory slewing ledge on the stud. Simply place the accessory slewing ledges available for the HEATER35 and the HEATER150 with the ground side downwards on the ground end faces of the two vertical ledges.

- ① Induction coil
- ② Slewing ledge

Figure 6
HEATER35
Configuration identical to
HEATER150, 300



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Accessory extension pieces

For the heating of bearings with a larger cross-section, place two accessory extension pieces on the vertical posts, *Figure 7*.

① Extension pieces

Figure 7

HEATER35, 150, 300
Extension pieces for larger bearing cross-sections



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Configuring HEATER600, 1200

Caution!

Grease the ground surfaces of the ledges.
The vertical ledge must lie flat.

Work steps: see *Figure 8*:

- Lift the vertical ledge ③ manually or using hoisting equipment.
- Place the bearing horizontally on the support blocks ② in the support rails ① and centre.
- Lower the vertical ledge again until it lies flat. Do not tilt or rotate.

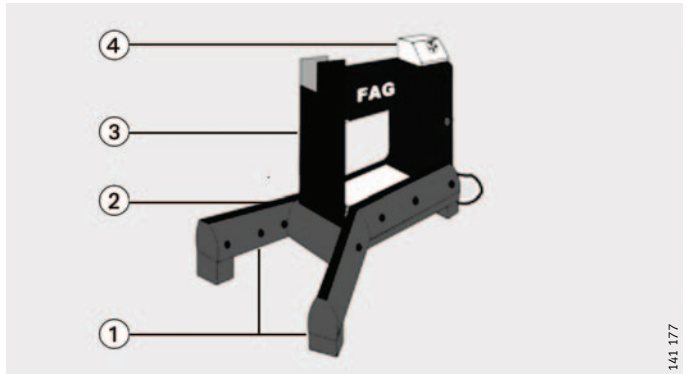
Use support blocks during horizontal positioning.

Provide additional support for large rolling bearings projecting beyond the support rails. The operator console ④ can be rotated 90 degrees to a convenient position.

- ① 4 support rails
- ② Support blocks
- ③ Movable vertical ledge
- ④ Swivelling operator console

Figure 8

HEATER600, 1200



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Lifting fixture for HEATER1200

If the heating devices HEATER600 or HEATER1200 are equipped with a lifting fixture, the vertical ledge can be raised and lowered easily via remote control. See the separate user manual.

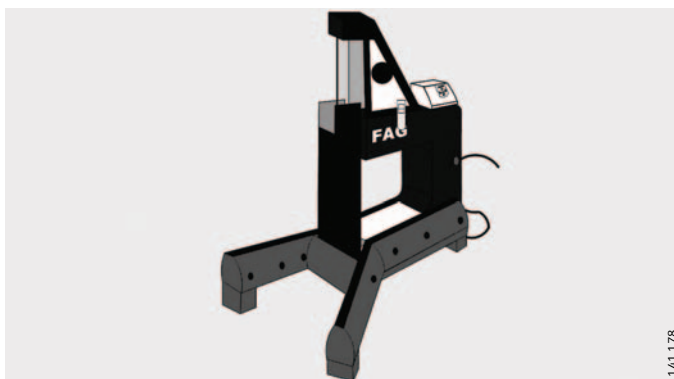


Figure 9
HEATER1200 with lifting fixture

Accessory ledges

For optimum heating of workpieces with smaller inside diameters, use the corresponding accessory vertical ledges.

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Heating of rolling bearings

Danger!

Caution!

Safety gloves must be worn.

Before starting the heating process, ensure that the horizontal ledge is correctly positioned.

Connect the temperature sensor and position it correctly.

Do not heat rolling bearings to more than +120 °C.

Temperature-controlled heating process

Work steps: see *Figure 10*:

- Switch on the power supply (main switch: see *Figure 24*, page 22). The display ① will show +110 °C.
- Set the temperature to a value between +40 °C and +240 °C (rolling bearings, max. +120 °C). Start the heating process using the Start/Stop button ③.
- When the selected temperature is reached, an acoustic signal sounds and the selected temperature value flashes in the display ①:
 - Acknowledge using the Start/Stop button ③, detach the magnetic temperature sensor and remove the workpiece using safety gloves.

Self-compensating function

The function operates as follows:

- If the heated part is not removed and its temperature decreases by 5 °C, the process is repeated up to five times.
- When the selected temperature value flashes in the display, the process described above should be terminated.

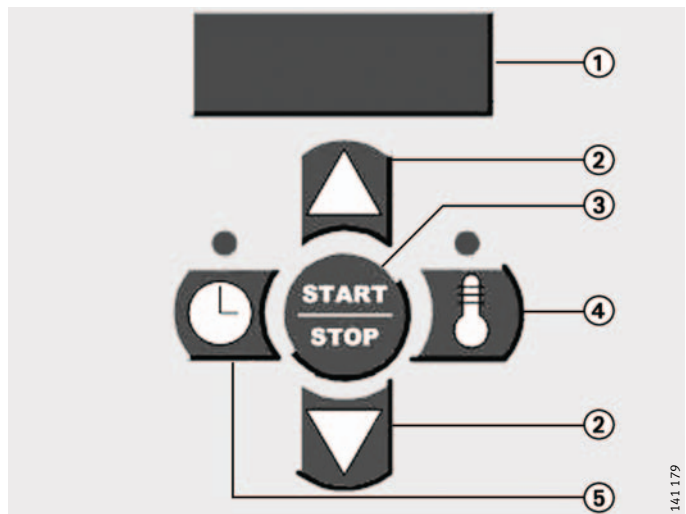
Interruption of heating

The heating process can be interrupted at any time using the Start/Stop button ③.

- ① Display
- ② Buttons for setting the temperature
- ③ Start/Stop button
- ④ Temperature display
- ⑤ Time display

Figure 10

Display and control panel



Time-controlled heating process

Work steps: see *Figure 10*:

Caution!

Do not connect the temperature sensor.

- Switch on the power supply (main switch: see page 18 to page 21). The display ① will show +110 °C.
- Press the button Time display ⑤, the display ① will now show 00.00.
- Use the temperature setting buttons ② to set the desired heating time up to max. 99 min + 59 s (99.59).
- Start the heating process using the Start/Stop button ③.
- The time shown in the display ① counts down to 00.00 and then triggers an acoustic signal.
- Acknowledge using the Start/Stop button ③ and remove the workpiece using safety gloves.

Interruption of heating

The heating process can be interrupted at any time using the Start/Stop button ③.

Troubleshooting

Error messages in the display

The display may show the error messages E01, E02, E10 and E12; see table Display, errors, actions.

Danger!

Before opening the device, disconnect the power supply.

Display, errors, actions

Display code	Error	Actions and remedies
E01	Magnetic temperature sensor inoperative	Check: <ul style="list-style-type: none"> ■ Is the temperature sensor connected? ■ Is the power cable in working order?
E02	The temperature is increasing by less than +1 °C within: 1 minute: HEATER35 3 minutes: HEATER150 5 minutes: HEATER300, 600 10 minutes: HEATER1200	Check: <ul style="list-style-type: none"> ■ Is the temperature sensor correctly positioned? ■ Are the temperature sensor and power cable intact? ■ Is the bearing/workpiece too heavy? ■ Is the shape and material suitable for induction heating?
E10	Electronic system is not measuring any zero crossing	Check: <ul style="list-style-type: none"> ■ Are the cable connections of the circuit board correct? (replace main circuit board if necessary)
E12	Main power circuit interrupted	Check: <ul style="list-style-type: none"> ■ Are all the electronic plug-in connections made correctly? ■ Is the cable connection of the thyristor to the high voltage circuit board in working order? (if necessary, replace the circuit board and test the device)

Alignment of ledges

The slewing ledge (support ledge) in HEATER35 and HEATER150 consists of a large number of transformer sheets permanently bonded together.

HEATER300, 600, 1200: The slewing ledge and the vertical ledges can be adjusted, for example if the device is generating a large amount of noise.

Work steps:

- Switch off the HEATER using the Start/Stop button.
 - Ensure that the ground ledge surfaces are smooth and greased.
 - Check that the horizontal slewing ledge is laid flat on the vertical ledges.
 - With HEATER600, 1200 the vertical ledge must fit correctly.
- Switch on the device.

- ① Screws
- ② Slewing ledge

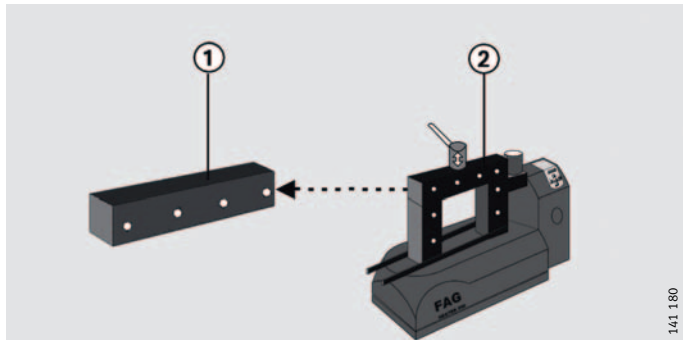


Figure 11
HEATER300
Alignment of slewing ledge

- ① Screws
- ② Vertical ledge

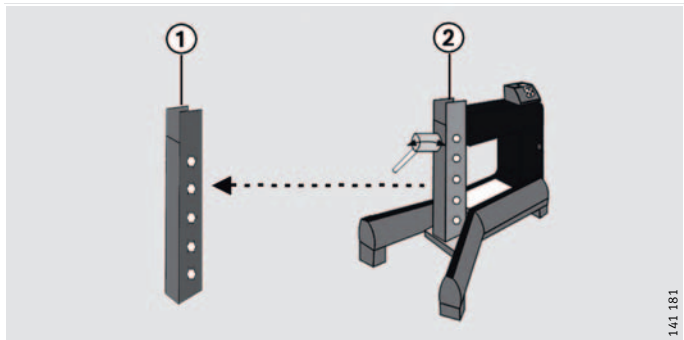


Figure 12
HEATER600, 1200
Alignment of vertical ledge

HEATER is still too noisy.

Work steps: see *Figure 11* and *Figure 12*:

- Switch off the device using the Start/Stop button.
 - Loosen the screws ① in the slewing ledge ② / vertical ledge ② by $\frac{1}{4}$ turn anticlockwise.
 - Switch on the device and the ledge should align itself; if not, use a plastic hammer to assist the process.
 - Retighten the screws ①.
- Switch off the device.

Technical data HEATER35

Designation	Technical data
Power consumption	max. 3,6 kVA at 230 V max. 2,2 kVA at 110 V
Voltage and frequency	115 V to 240 V (50 Hz/60 Hz)
Current	16 A
Temperature display	+50 °C to +240 °C
Mass	31 kg
Workpiece mass	max. 35 kg

Dimensions (W×H×L)

Designation	Dimensions in mm
Heating device	260×360×420
Slewing ledge	50× 50×280

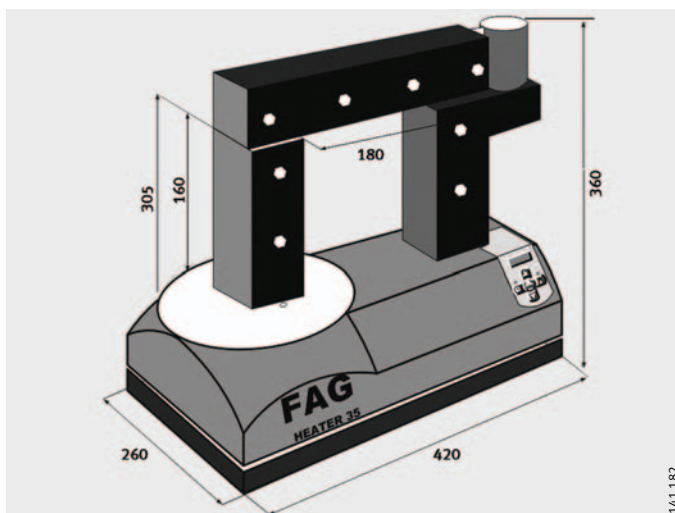
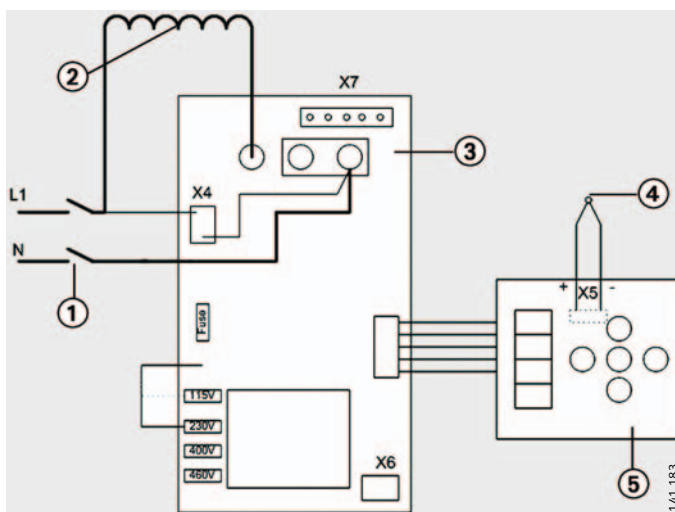


Figure 13
HEATER35

Circuit diagram



① Main switch
② Coil
③ Circuit board for high voltage
④ Magnetic temperature sensor
⑤ Circuit board for low voltage

Figure 14
Circuit diagram for HEATER35

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HEATER150

Designation	Technical data
Power consumption	max. 12,8 kVA
Voltage and frequency	200 V to 600 V (50 Hz/60 Hz)
Current	32 A
Temperature display	+50 °C to +240 °C
Mass	51 kg
Workpiece mass	max. 150 kg

Dimensions (W×H×L)

Designation	Dimensions in mm
Heating device	260×505×440
Slewing ledge	70× 70×350

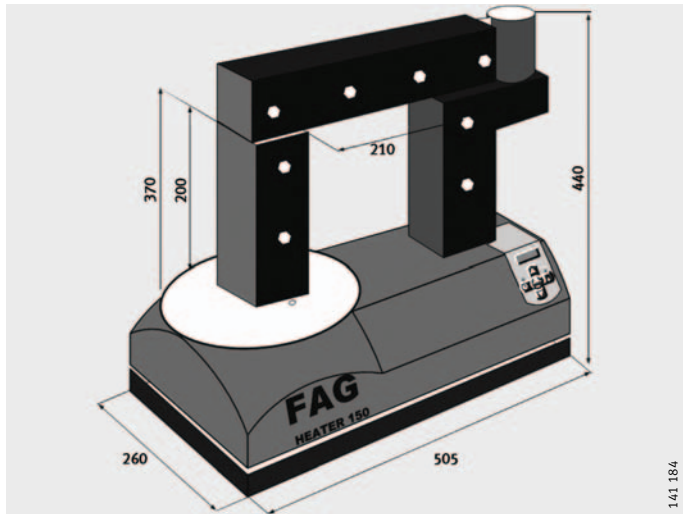


Figure 15
HEATER150

HEATER300

Designation	Technical data
Power consumption	max. 12,8 kVA
Voltage and frequency	200 V to 600 V (50 Hz/60 Hz)
Current	32 A
Temperature display	+50 °C to +240 °C
Mass	75 kg
Workpiece mass	max. 300 kg

Dimensions (W×H×L)

Designation	Dimensions in mm
Heating device	310×880×565
Slewing ledge	80× 80×490

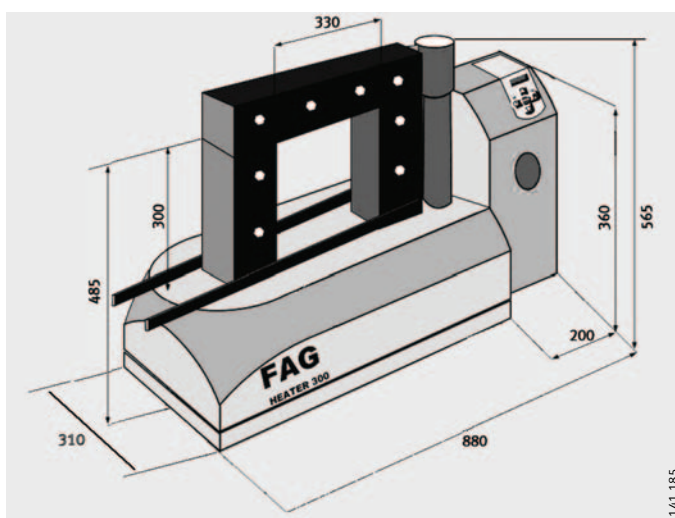


Figure 16
HEATER300

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HEATER600

Designation	Technical data
Power consumption	max. 25 kVA
Voltage and frequency	200 V to 600 V (50 Hz/60 Hz)
Current	63 A
Temperature display	+50 °C to +240 °C
Mass	350 kg
Workpiece mass	max. 600 kg

Dimensions (W×H×L)

Designation	Dimensions in mm
Heating device	820×1100×1070
Vertical ledge	100× 100× 700

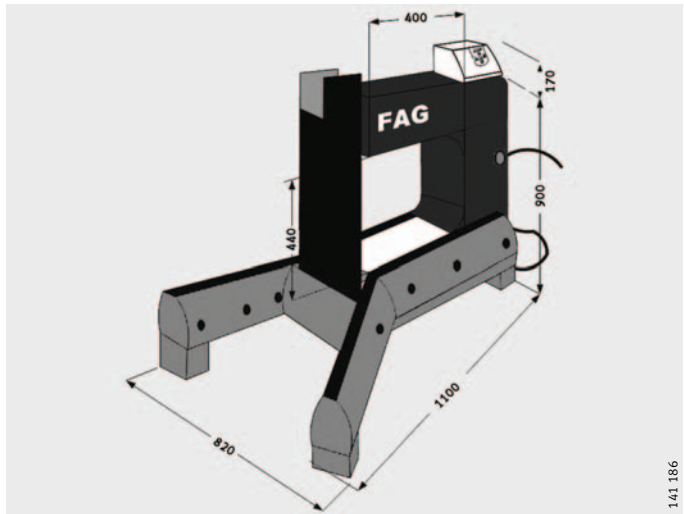


Figure 17
HEATER600

141 186

HEATER1200

Designation	Technical data
Power consumption	max. 40 kVA
Voltage and frequency	200 V to 600 V (50 Hz/60 Hz)
Current	100 A
Temperature display	+50 °C to +240 °C
Mass	850 kg
Workpiece mass	max. 1200 kg

Dimensions (W×H×L)

Designation	Dimensions in mm
Heating device	1050×1500×1270
Vertical ledge	150× 150× 850

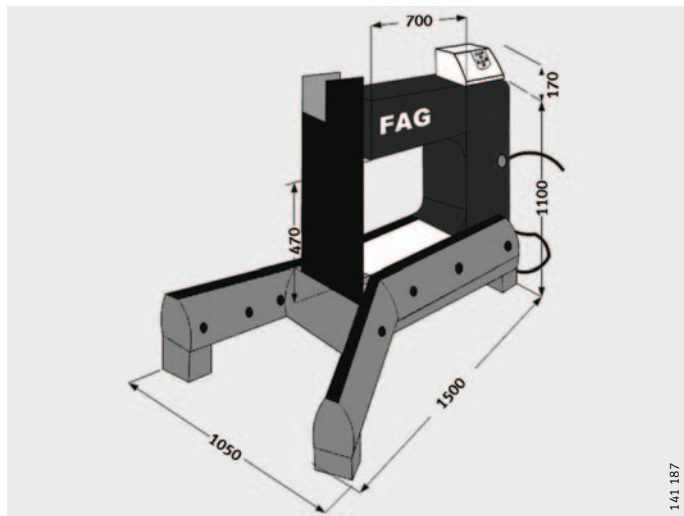


Figure 18
HEATER1200

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Circuit diagram

The circuit diagram for HEATER150, HEATER300, HEATER600 and HEATER1200 is identical.

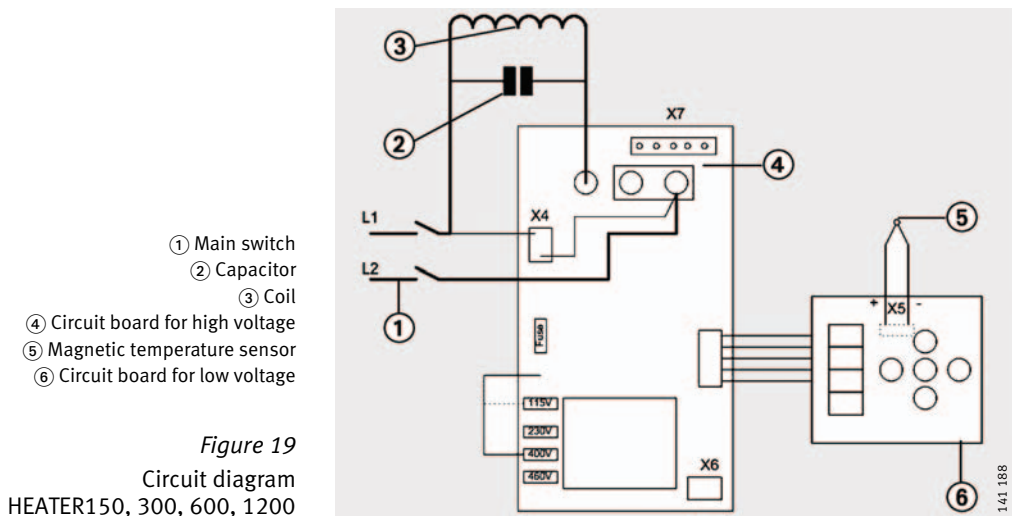


Figure 19
Circuit diagram
HEATER150, 300, 600, 1200

141 188

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Spare parts Accessories Ordering designations HEATER35

- ① Power supply connector
- ② Coil
- ③ U-shaped core
- ④ Housing cover
- ⑤ Slewing ledge
- ⑥ Operator terminal
- ⑦ Operator circuit board
- ⑧ Main switch
- ⑨ Jack for temperature sensor
- ⑩ Baseplate
- ⑪ Main circuit board

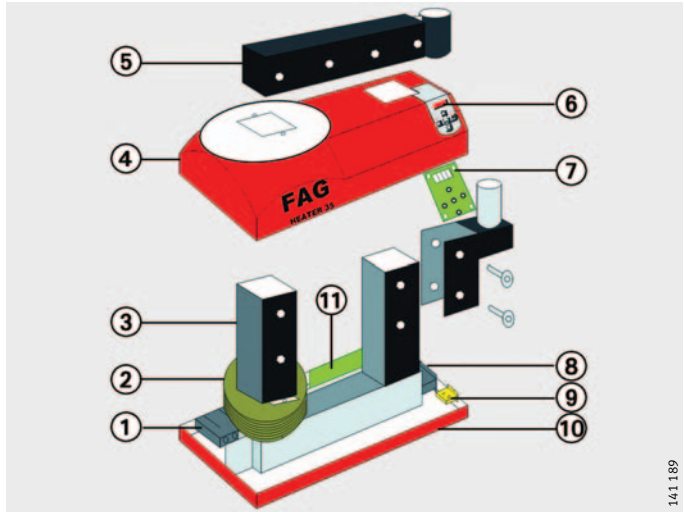


Figure 20
HEATER35

Spare parts Ordering designations

Designation	Ordering designation
Temperature sensor	HEATER.SENSOR
Controller	HEATER35.ETRONIC
Main switch	HEATER35.MAIN.SWITCH
Main circuit board	HEATER35.BOARD1
Operator circuit board	HEATER35.BOARD2
Thyristor	HEATER35.THYRISTOR
Display	HEATER35.DISPLAY
Slewing ledge	HEATER35.LEDGE-70 ¹⁾

¹⁾ Smallest workpiece bore diameter.

Accessories Ordering designations

Designation	Ordering designation
Support ledges, dimensions in mm	
10×10×280	HEATER35.LEDGE-15 ¹⁾
14×14×280	HEATER35.LEDGE-20 ¹⁾
Slewing ledges, dimensions in mm	
25×25×280	HEATER35.LEDGE-35 ¹⁾
30×30×280	HEATER35.LEDGE-45 ¹⁾
40×40×280	HEATER35.LEDGE-60 ¹⁾
Two extension pieces, dimensions in mm	
50×50×120	HEATER35.ADAPTER120 ¹⁾
Clamping temperature sensor	HEATER.SENSOR-CLAMP

¹⁾ Smallest workpiece bore diameter.

HEATER150

- ① Baseplate
- ② Power supply connector
- ③ Main switch
- ④ Coil
- ⑤ U-shaped core
- ⑥ Housing cover
- ⑦ Slewing ledge
- ⑧ Operator terminal
- ⑨ Operator circuit board
- ⑩ Jack for temperature sensor
- ⑪ Capacitor
- ⑫ Main circuit board

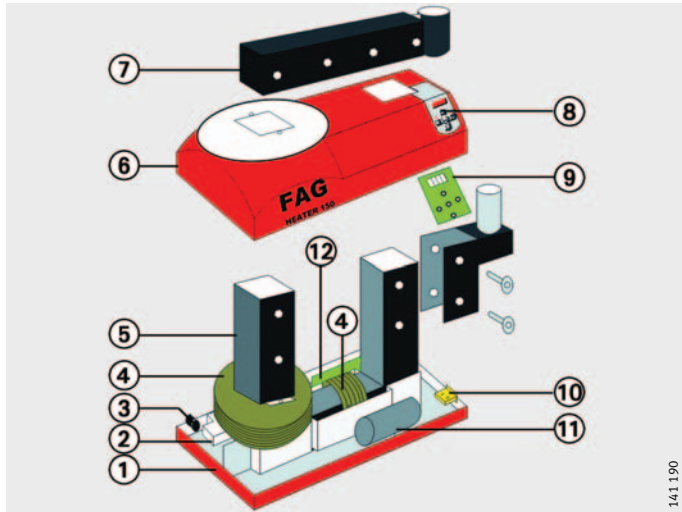


Figure 21
HEATER150

Spare parts Ordering designations

Designation	Ordering designation
Temperature sensor	HEATER.SENSOR
Controller	HEATER150.ETRONIC
Main switch	HEATER150.MAIN.SWITCH
Main circuit board	HEATER150.BOARD1
Operator circuit board	HEATER150.BOARD2
Thyristor	HEATER150.THYRISTOR
Display	HEATER150.DISPLAY
Slewing ledge	HEATER150.LEDGE-100 ¹⁾

¹⁾ Smallest workpiece bore diameter.

Accessories Ordering designations

Designation	Ordering designation
Support ledges, dimensions in mm	
14×14×350	HEATER150.LEDGE-20 ¹⁾
Slewing ledges, dimensions in mm	
20×20×350	HEATER150.LEDGE-30 ¹⁾
30×30×350	HEATER150.LEDGE-45 ¹⁾
40×40×350	HEATER150.LEDGE-60 ¹⁾
50×50×350	HEATER150.LEDGE-70 ¹⁾
60×60×350	HEATER150.LEDGE-85 ¹⁾
Two extension pieces, dimensions in mm	
70×70×150	HEATER150.ADAPTER150 ¹⁾
70×70×200	HEATER150.ADAPTER200 ¹⁾
Clamping temperature sensor	HEATER.SENSOR-CLAMP

¹⁾ Smallest workpiece bore diameter.

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HEATER300

- ① Baseplate
- ② U-shaped core
- ③ Housing cover
- ④ Support rails
- ⑤ Rotation point
- ⑥ Slewing ledge
- ⑦ Operator terminal
- ⑧ Jack for temperature sensor
- ⑨ Control cabinet
- ⑩ Main switch
- ⑪ Operator circuit board
- ⑫ Capacitor
- ⑬ Thyristor
- ⑭ Main circuit board
- ⑮ Coils

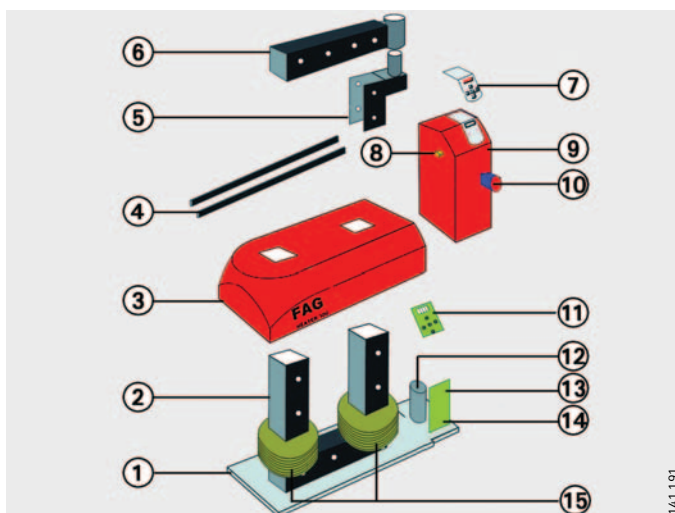


Figure 22
HEATER300

Spare parts Ordering designations

Designation	Ordering designation
Temperature sensor	HEATER.SENSOR
Controller	HEATER300.ETRONIC
Main switch	HEATER300.MAIN.SWITCH
Main circuit board	HEATER300.BOARD1
Operator circuit board	HEATER300.BOARD2
Thyristor	HEATER300.THYRISTOR
Display	HEATER300.DISPLAY
Slewing ledge	HEATER300.LEDGE-115 ¹⁾
Two support rails	HEATER300.BLADE

¹⁾ Smallest workpiece bore diameter.

Accessories Ordering designations

Designation	Ordering designation
Slewing ledges, dimensions in mm	
20×20×490	HEATER300.LEDGE-30 ¹⁾
30×30×490	HEATER300.LEDGE-45 ¹⁾
40×40×490	HEATER300.LEDGE-60 ¹⁾
50×50×490	HEATER300.LEDGE-70 ¹⁾
60×60×490	HEATER300.LEDGE-85 ¹⁾
70×70×490	HEATER300.LEDGE-100 ¹⁾
Two extension pieces, dimensions in mm	
80×80×150	HEATER300.ADAPTER150 ¹⁾
80×80×200	HEATER300.ADAPTER200 ¹⁾
Trolley	HEATER300.TROLLEY
Clamping temperature sensor	HEATER.SENSOR-CLAMP

¹⁾ Smallest workpiece bore diameter.

HEATER600

- ① Support rails
- ② Support blocks
- ③ Vertical ledge
- ④ Main circuit board
- ⑤ Thyristor
- ⑥ Capacitor
- ⑦ Jack for temperature sensor
- ⑧ Operator terminal
- ⑨ Swivelling operator console
- ⑩ Operator circuit board
- ⑪ Main switch
- ⑫ Coils
- ⑬ U-shaped core
- ⑭ Power supply connector

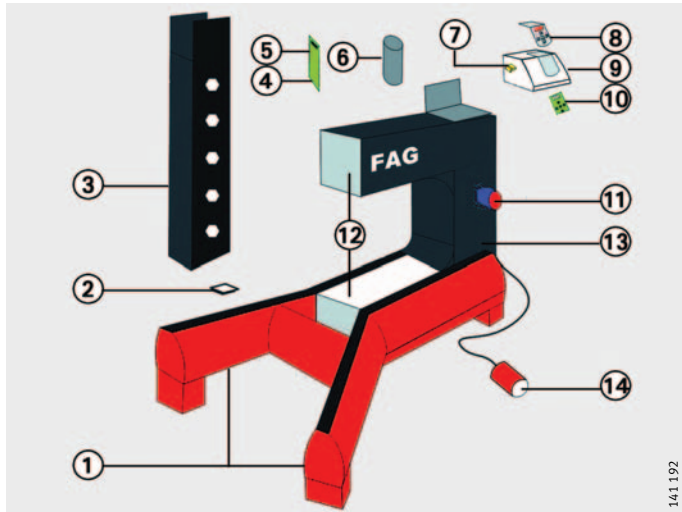


Figure 23
HEATER600

Spare parts Ordering designations

Designation	Ordering designation
Temperature sensor	HEATER.SENSOR
Controller	HEATER600.ETRONIC
Main switch	HEATER600.MAIN.SWITCH
Main circuit board	HEATER600.BOARD1
Operator circuit board	HEATER600.BOARD2
Thyristor	HEATER600.THYRISTOR
Display	HEATER600.DISPLAY
Vertical ledge	HEATER600.LEDGE-145 ¹⁾
Four support rails	HEATER600.SUPPORT.BLADE
Four support blocks	HEATER600.BASE.PLATE

¹⁾ Smallest workpiece bore diameter.

Accessories Ordering designations

Designation	Ordering designation
Vertical ledges, dimensions in mm	
30×40×700	HEATER600.LEDGE-45 ¹⁾
40×40×700	HEATER600.LEDGE-60 ¹⁾
50×50×700	HEATER600.LEDGE-70 ¹⁾
60×60×700	HEATER600.LEDGE-85 ¹⁾
70×70×700	HEATER600.LEDGE-100 ¹⁾
80×80×700	HEATER600.LEDGE-115 ¹⁾
90×90×700	HEATER600.LEDGE-130 ¹⁾
Clamping temperature sensor	HEATER.SENSOR-CLAMP

¹⁾ Smallest workpiece bore diameter.

HEATER1200

- ① Support rails
- ② Support blocks
- ③ Vertical ledge
- ④ Main circuit board
- ⑤ Thyristor
- ⑥ Capacitor
- ⑦ Jack for temperature sensor
- ⑧ Operator terminal
- ⑨ Swivelling operator console
- ⑩ Operator circuit board
- ⑪ Main switch
- ⑫ Coils
- ⑬ U-shaped core
- ⑭ Power supply connector

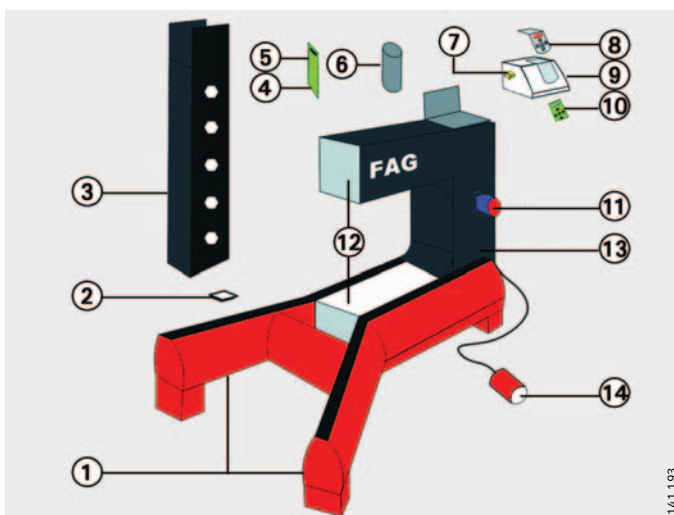


Figure 24
HEATER1200

Spare parts Ordering designations

Designation	Ordering designation
Temperature sensor	HEATER.SENSOR
Controller	HEATER1200.ETRONIC
Main switch	HEATER1200.MAIN.SWITCH
Main circuit board	HEATER1200.BOARD1
Operator circuit board	HEATER1200.BOARD2
Thyristor	HEATER1200.THYRISTOR
Display	HEATER1200.DISPLAY
Vertical ledge	HEATER1200.LEDGE-215 ¹⁾
Four support rails	HEATER1200.BLADE
Four support blocks	HEATER1200.BASE.PLATE

¹⁾ Smallest workpiece bore diameter.

Accessories Ordering designations

Designation	Ordering designation
Vertical ledges, dimensions in mm	
60 × 60 × 850	HEATER1200.LEDGE-85 ¹⁾
80 × 80 × 850	HEATER1200.LEDGE-115 ¹⁾
100 × 100 × 850	HEATER1200.LEDGE-145 ¹⁾
Clamping temperature sensor	HEATER.SENSOR-CLAMP

¹⁾ Smallest workpiece bore diameter.

Specifications

EU Declaration of Conformity

Electrical safety:

- IEC 335-1 Class 1,
- IEC 664-1 Class 1 and
- Safety Class 1.

The heating devices comply with:

- Low Voltage Directive 73/23/EEC and
- EMC Directive 89/336/EEC.

EMC emission:

- EN 55011,
- EN 60555-2 and
- EN 60555-3.

EMC immunity:

- IEC 801-2,
- IEC 801-3,
- IEC 801-4 and
- IEC 801-5.

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We reserve the right to make technical changes.

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