

USER MANUAL  
INDUCTION HEATER IHN080/120



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## Safety Recommendations

- › Because the IHN080/120 generates a magnetic field, people wearing a pacemaker must not be within 5 m (16 ft) of the IHN080/120 during operation. Electronic equipment, such as wrist watches, may also be affected.
- › Follow the operating instructions at all times.
- › Be certain that the voltage supply is correct.
- › Electrical arcing may occur when a potential difference exists between the IHN080/120 and the workpiece. This is not dangerous to human beings and will not cause damage to the IHN080/120 or the workpiece. However, the IHN080/120 must never be used in areas where there is a risk of explosion.
- › Do not expose the heater to high humidity.
- › Never operate the IHN080/120 without a yoke in position.
- › Do not modify the IHN080/120.
- › Use proper handling equipment when lifting heavy workpieces.
- › Avoid contact with hot workpieces. Wear the supplied heat-resistant gloves to handle hot workpieces.

# 1 Introduction

The IHN080/120 induction heater is designed to heat bearings that are mounted with an interference fit onto a shaft. The heat causes the bearing to expand, which eliminates the need to use force during installation. A 90°C (194°F) temperature difference between the bearing and shaft is generally sufficient to enable installation. At an ambient temperature of 20°C (68°F), the bearing must therefore be heated to 110°C (230°F).

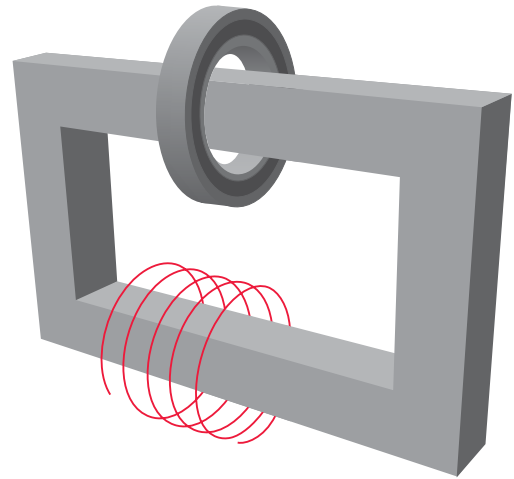
## 1.1 Intended Use

The IHN080/120 has been designed to heat rolling bearings. However, other metal workpieces that form a closed circuit can also be heated. Examples of acceptable workpieces include bushings, shrink rings, pulleys, and gears. All bearings that fit over the inductive coil and between the vertical supports with the top yoke in place can be heated using the IHN080/120. In addition, smaller bearings can be placed over either of the three standard yokes.

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## 1.2 Principle of Operation

The IHN080/120 generates heat by means of a large electrical current that is magnetically induced in the workpiece by a coil within the heater. The high voltage, low current electricity flowing through the large number of windings in the inductive coil induces low voltage, high current electricity in the workpiece. Because the workpiece has the electrical characteristics of a coil with a single, short-circuited winding, the high current generates heat within the workpiece. Because the heat is generated within the workpiece, all of the heater components remain cool.



## 1.3 Distinguishing Feature

The distinguishing feature of the IHN080/120 induction heater is the location of the workpiece at the same position on the core as the inductive coil. This design improves efficiency, resulting in less power consumption and faster heating, which reduces the cost to heat each bearing.

# 2 Description

The operation of the heater is controlled by the internal electronics in either of two modes. The operator can either select the desired temperature of the bearing in TEMP MODE or set the length of time that the bearing will be heated in TIME MODE. The power level can be adjusted in steps of 20% for slower heating of sensitive workpieces (for example, bearings with C1 or C2 clearance).

## 2.1 Components

The IHN080/120 induction heater contains a U-shaped iron core with an inductive coil surrounding one of the vertical supports. Internal electronics control the operation of the heater. A removable yoke on the top of the vertical supports allows the workpiece to be placed onto the heater. The top yoke of the IHN120 is mounted on a swivel. To accommodate smaller workpieces, two smaller yokes are also provided. A temperature probe is included with the heater. Heat-resistant gloves are also included.

## 2.2 Technical Data

	IHN080	IHN0120
Voltage ( $\pm 9\%$ ):	1 ~ 100 – 240 V / 50-60 Hz*	3 ~ 400 – 575 V / 50-60 Hz*
Recommended circuit protection	20 A circuit breaker	20 A circuit breaker
Power consumption (maximum)	3.7 kVA	9.2 kVA
Temperature control	0 – 250 °C (32 – 482 °F) in steps of 1 °C (2 °F)	0 – 250 °C (32 – 482 °F) in steps of 1 °C (2 °F)
Probe maximum temperature	250 °C (482 °F)	250 °C (482 °F)
Time mode	0 – 60 minutes in steps of 0.1 minute	0 – 60 minutes in steps of 0.1 minute
Power range	20 – 100% in steps of 20%	20 – 100% in steps of 20%
Demagnetisation, automatic	Residual magnetism < 2 A/cm	Residual magnetism < 2 A/cm
Overall dimensions	420 x 280 x 345 mm	420 x 280 x 420 mm
Area between supports (wxh)	145 x 205 mm	145 x 205 mm
Coil diameter	115 mm	115 mm
Weight (with yokes)	35 kg	38 kg
Workpiece maximum weight	Bearing 80 kg, solid component 40 kg	Bearing 120 kg, solid component 60 kg
Maximum heating temperature	Approx. 400°C (752°F)	Approx. 400 °C (752 °F)
Standard yoke dimensions	55 x 55 x 275 mm (for $\varnothing$ of 80 mm) 28 x 28 x 275 mm (for $\varnothing$ of 40 mm) 14 x 14 x 275 mm (for $\varnothing$ of 20 mm)	55 x 55 x 275 mm (for $\varnothing$ of 80 mm) 28 x 28 x 275 mm (for $\varnothing$ of 40 mm) 14 x 14 x 275 mm (for $\varnothing$ of 20 mm)

\* Each bearing heater family has several voltage options. Please refer to the type plate on the heater body to determine the actual operating voltage.

## 3 Installation of Mains Plug

Due to the many types of mains plugs, no mains plug is supplied with the IHN080/120. A qualified electrician must install a suitable mains plug. The correct supply voltage is shown on the type plate / underside of the heater.

**The wires should be connected as follows:**

IHN080	
Color of IHN080 Wire	Mains Supply Terminal
Yellow/green	Protection earth (PE)
Brown	Phase 1 (L1)
Blue	Neutral (N)

IHN120	
Color of IHN120 Wire	Mains Supply Terminal
Yellow/green	Protection earth (PE)
Brown	Phase 1 (L1)
Blue	Phase 2 (L2)

Connect the IHN120 to only two of the three phases. Verify that the correct circuit breaker is installed. See section 2.2 for circuit breaker specifications.

## 4 Preparation for Use

› Place the IHN080/120 in the horizontal position on a stable surface.

› Connect the mains plug to a suitable mains supply.

› For the IHN120 only, follow these steps to install the swivel arm:

› Attach the protection plate (4) to the side post to prevent damage.

› Install the swivel head (1) and the swivel body (2) on the lefthand side post of the heater.

› Install the large top yoke (55 x 55mm) in the swivel head. Adjust the swivel body so that there is no visible gap (A) between the side post and the yoke.

› Tighten the four screws (3) of the swivel body (maximum torque 5Nm).

› Turn the screw (5) on top of the swivel head to position the top yoke. The top yoke must contact as much of the upper surface of the right-hand side post (B) as possible. Noise during operation could indicate that the top yoke is not positioned properly.

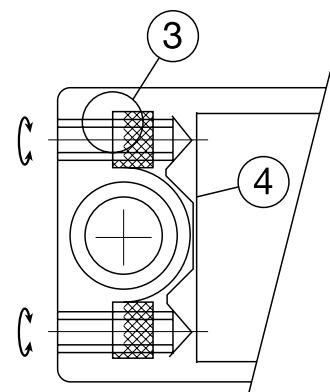
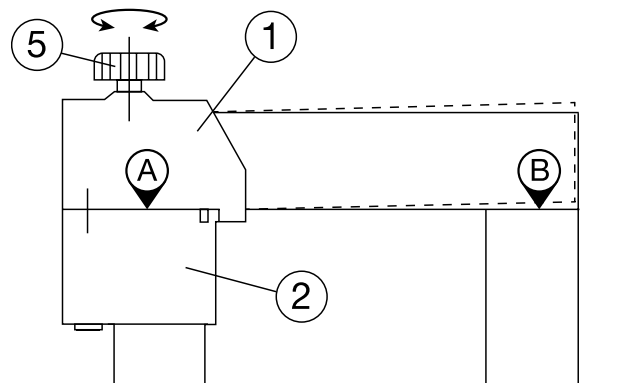
› Special notes for the IHN120:

› The yoke support is required when either of the smaller yokes (28 x 28mm or 14 x 14mm) is installed. Install the yoke support and the yoke together in the swivel head. If necessary, rotate the swivel head to provide better access.

› Heavy workpieces ( $\geq 10\text{kg}$  / 22lbs) that must be installed on the top yoke should be supported until the yoke is in the correct position on the right-hand side post. The heater may tip over if the workpiece is not supported.

› The swivel body (2) can remain on the heater at all times.

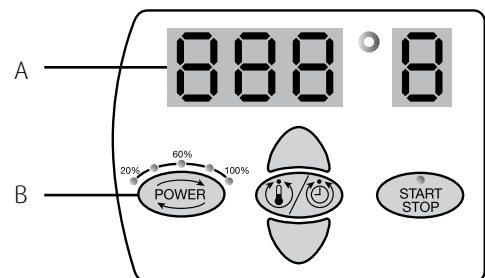
› Turn the screw (5) on top of the swivel head to position the top yoke. The top yoke must contact as much of the upper surface of the right-hand side post (B) as possible. Noise during operation could indicate that the top yoke is not positioned properly.



- › For workpieces with an internal diameter large enough to fit over the inductive coil, follow these steps:
  - › Place the workpiece over the inductive coil using appropriate lifting equipment.
  - › For best performance, adjust the position of the workpiece so that the inductive coil is in the center.
  - › Remove the protective film from the bright underside of the top yoke before the first use.
  - › Position the top yoke so that it completely covers the top of both vertical supports.
  
- › If you will use TEMP MODE, plug the temperature probe into the connector on the left side of the heater. Place the magnetic end of the probe on the inner ring of the bearing or on the innermost surface of the workpiece.
  
- › Use the power switch on the left side to switch on the IHN080/120.
  
- › Observe the self-test of the display and signal tone.

## 5 Operation

### 5.1 Function of Displays



A) The main display shows the selected time or temperature for heating:

Display	Indication
t	Time in minutes
°C	Temperature in degrees Celsius
°F	Temperature in degrees Fahrenheit

B) The power display shows the selected power setting:

Display	Indication
●	20% power
●●	40% power
●●●	60% power
●●●●	80% power
●●●●●	100% power

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## 5.2 Function of Buttons

Button	Function
POWER	Press to adjust the power in steps of 20%. The selected power is indicated on the power display.
MODE	Press to switch between TIME MODE and TEMP MODE.
UP (+)	Press to increase the value shown on the main display.
DOWN (-)	Press to decrease the value shown on the main display.
START/STOP	Press to start or stop the heater. The LED on the START/STOP button is lit when the heater is heating and flashes during temperature measurement.

## 5.3 Temp Mode

- › If the main display shows “t”, press MODE to select TEMP MODE. The main display shows °C or °F in TEMP MODE.
- › The selected temperature is shown on the main display. The default temperature for bearings is 110°C (230°F). If a different temperature is desired, press UP or DOWN to adjust the temperature in steps of 1°C (2°F).
- › It may be desirable to heat bearings to temperatures above 110°C (230°F) for increased mounting time. Consult the bearing specifications to determine the maximum permitted temperature. Always ensure the bearing does not lock due to an excessive expansion of the inner ring compared to outer ring. See section 5.8.
- › All Spherical Roller Bearings (SRBs) are subjected to a special heat treatment. These bearings can be operated at temperatures as high as 200°C (392°F). Heating these bearings above 110°C (230°F) will not cause any damage as long as the bearing is still able to rotate. For other bearings, a temperature of 125°C (257°F) must not be exceeded unless otherwise specified.
- › Press POWER to select the power level. Use the guidelines in section 5.8 to determine the correct power setting.
- › Make sure the temperature probe is mounted on the bearing inner ring.
- › Press START/STOP to start the heater. The main display shows the current temperature of the workpiece.
- › When the selected temperature has been reached, the heater demagnetises the workpiece, switches off and generates an acoustic signal for 10 seconds or until START/STOP is pressed.
- › Press START/STOP to stop the heater.
- › Remove the workpiece with proper handling equipment.



- › If the workpiece remains on the heater, the heater will start again when the temperature of the workpiece drops 10°C (18°F). Press START/STOP to stop the heater and demagnetise the workpiece.
- › The IHN080/120 is now ready to heat another workpiece with the same settings.

#### 5.4 Time Mode

- › If the main display shows °C or °F, press MODE to select TIME MODE. The main display shows “t” in TIME MODE.
- › Press UP or DOWN to adjust the time in steps of 0.1 minute.
- › Press POWER to select the power level. Use the guidelines in section 5.8 to determine the correct power setting.
- › Press START/STOP to start the heater. The main display shows the time that remains.
- › When the time has elapsed, the heater demagnetises the workpiece, switches off and generates an acoustic signal for 10 seconds.
- › Press START/STOP to cancel the acoustic signal and stop the heater.
- › Remove the workpiece with proper handling equipment.
- › The IHN080/120 is now ready to heat another workpiece with the same settings.

#### 5.5 Temperature Measurement

When the heater is not operating, the temperature of the workpiece can be measured by pressing MODE and START/STOP at the same time. The LED on the START/STOP button flashes during temperature measurement. Press START/STOP to cancel temperature measurement.

#### 5.6 Change of Temperature Units

Press MODE and UP at the same time to switch between °C and °F. The temperature unit setting remains the same even after disconnection from mains power.

#### 5.7 Demagnetisation

The workpiece is automatically demagnetised when heating is complete. Demagnetisation will not occur if the power is interrupted or the main switch is switched off. To use the IHN080/120 for demagnetisation only, select TIME MODE and set the time to 0.1 minute (6 seconds).

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## 5.8 Power Level Selection

When heating bearings with an induction heater, most of the heat will be generated in the inner bearing race. The heat will then be transferred through the bearing. It is therefore important that bearings with small internal clearance or slight preload are heated slowly. Slow heating ensures that the bearing expands evenly, thereby preventing damage to the bearing.

The shape, weight, size, and internal clearances all affect the amount of time required to heat a bearing. The large variety of bearing types prevents the possibility of providing a specific power level setting for each type. Instead, the following guidelines are provided:

- › For sensitive bearings (including bearings with C1 or C2 internal clearance) or bearings with brass cages, do not exceed 20% power when using the small yoke, 40% power when using the medium yoke, or 60% power when using the large yoke.
- › When using the small yoke, never exceed 40% power.
- › When using the medium yoke, never exceed 60% power.

## 6 Safety Features

The IHN080/120 is equipped with the following safety features:

- › Automatic overheating protection.
- › Automatic current control.
- › In the TEMP MODE the heater will switch off if the temperature probe does not register a temperature increase of 1°C (2°F) every 15 seconds. To increase the interval to 30 seconds, press MODE and DOWN at the same time.
- › Additionally, the IHN120 is equipped with a main switch with over-current circuit breaker.

## 7 Troubleshooting

A system fault will be indicated by an acoustic signal and one of the following fault codes on the main display:

Display	Fault	Action
E01 E	General system failure	Return heater for repair
E02 E	Memory failure	Return heater for repair
E03 E	Overheated coil	Wait until the inductive coil cools
E04 E	Not in use	
E05 E	Temperature increase of less than 1°C (2°F) every 15 seconds (or 1°C (2°F) every 30 seconds)	Check the temperature probe connection. If the connection is OK, select the 30 second interval as described in section 6 or operate the heater in TIME MODE.
E06 E	Temperature probe not connected (or defective)	Check the temperature probe
E07 E	Failure during current measurement	Return heater for repair
E08 E	Failure during communication with power printed circuit board	Return heater for repair
E09 E	Overheated printed circuit board	Wait until the printed circuit board cools.

## 8 Spare Parts

Description	Part Number
Spare temperature probe	IHNP2SENSOR
Spare protective gloves	IHNGLOVES
Spare set support yoke 55 x 55 x 100 mm for IHN080/120	IHN080/120-YS
Spare yoke 10 x 10 x 275 mm for IHN080/120	IHN080/120-Y1
Spare yoke 14 x 14 x 275 mm for IHN080/120	IHN080/120-Y2
Spare yoke 20 x 20 x 275 mm for IHN080/120	IHN080/120-Y3
Spare yoke 28 x 28 x 275 mm for IHN080/120	IHN080/120-Y4
Spare yoke 40 x 40 x 275 mm for IHN080/120	IHN080/120-Y6
Spare yoke 55 x 55 x 275 mm for IHN080/120	IHN080/120-Y8
Spare swivel arm complete for IHN080/120	IHN080/120-SA

## NSK SALES OFFICES WORLDWIDE

MOTION & CONTROL™  
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### HEADQUARTER

#### Japan

NSK Ltd.-Headquarters  
Nissei Bldg., 1-6-3 Ohsaki  
Shinagawa-ku  
Tokyo 141-8560

Industrial machinery business  
Division-Headquarters  
Tel. +81 (3) 3779 7227  
Fax +81 (3) 3779 7644

Automotive business  
Division-Headquarters  
Tel. +81 (3) 3779 7189  
Fax +81 (3) 3779 7917

### AFRICA

#### South Africa

NSK South Africa (Pty) Ltd.  
27 Galaxy Avenue  
Linbro Business Park  
Sandton 2146  
Tel. +27 (011) 458 3600  
Fax +27 (011) 458 3608  
nsk-sa@nsk.com

### ASIA AND OCEANIA

#### Australia

NSK Australia Pty. Ltd.  
11 Dalmore Drive  
Scoresby  
Victoria 3179  
Tel. +61 3 9765 4400  
Fax +61 3 9764 8304  
aus-nskenquiries@nsk.com

#### New Zealand

NSK New Zealand Ltd.  
3 Te Apunga Place  
Mt. Wellington  
Auckland  
Tel. +64 9 276 4992  
Fax +64 9 276 4082  
nz-info@nsk.com

#### China

NSK Hong Kong Ltd.  
Suite 705, 7th Floor South Tower  
World Finance Centre  
Harbour City, T.S.T  
Kowloon, Hong Kong  
Tel. +852 2739 9933  
Fax +852 2739 9323

NSK China Sales Co., Ltd.  
No.8 NSK Rd., Huaqiao Economic  
Development Zone, Kunshan  
Jiangsu, China (215332)  
Tel. +86 512 5796 3000  
Fax +86 512 5796 3300

### India

NSK in diasales Co.Pvt.Ltd.  
6th Floor, Bannari Amman Towers  
No.29 Dr. Radhakrishnan Salai  
Mylapore, Chennai-600 004 Tamil Nadu  
Tel. +91 44 2847 9600  
Fax +91 44 2847 9601

### Indonesia

Pt. NSK Indonesia  
Summitmas II, 6th Floor  
Jl. Jend Sudirman Kav. 61-62  
Jakarta 12190  
Tel. +62 21 252 3458  
Fax +62 21 252 3223

### Korea

NSK Korea Co., Ltd.  
Posco Center (West Wing) 9F  
892, Daechi-4Dong  
Kangnam-Ku  
Seoul, 135-777  
Tel. +82 2 3287 0300  
Fax +82 2 3287 0345

### Malaysia

NSK Bearings (Malaysia) Sdn. Bhd.  
No. 2, Jalan Pemaju, U1/15, Seksyen U1  
Hicom Gienmarie Industrial Park  
40150 Shah Alam  
Selangor  
Tel. +60 3 7803 8859  
Fax +60 3 7806 5982

### Philippines

NSK Representative Office  
8th Floor The Salcedo Towers  
169 H.V. dela Costa St.  
Salcedo Village Makati City  
Philippines 1227  
Tel. +63 2 893 9543  
Fax +63 2 893 9173

### Taiwan

Taiwan NSK Precision Co., Ltd.  
11 F., No.87, Song Jiang Rd.  
Jhongshan District  
Taipei City 104  
Tel. +886 2 2509 3305  
Fax +886 2 2509 1393

### Thailand

NSK Bearings (Thailand) Co., Ltd.  
26 Soi Onnuch 55/1 Pravet Subdistrict  
Pravet District  
Bangkok 10250  
Tel. +66 2320 2555  
Fax +66 2320 2826

### Vietnam

NSK Vietnam Co., Ltd.  
Techno Center, Room 204-205  
Thang Lang Industrial Park  
Dang Anh District  
Hanoi  
Tel. +84 4 3955 0159  
Fax +84 4 3955 0158

### EUROPE

#### UK

NSK UK Ltd.  
Northern Road, Newark  
Nottinghamshire NG24 2JF  
Tel. +44 (0) 1636 605123  
Fax +44 (0) 1636 643276  
info-uk@nsk.com

#### France & Benelux

NSK France S.A.S.  
Quartier de l'Europe  
2, rue Georges Guynemer  
78283 Guyancourt Cedex  
Tel. +33 (0) 1 30573939  
Fax +33 (0) 1 30570001  
info-fr@nsk.com

#### Germany, Austria, Switzerland, Nordic

NSK Deutschland GmbH  
Harkortstraße 15  
40880 Ratingen  
Tel. +49 (0) 2102 4810  
Fax +49 (0) 2102 4812290  
info-de@nsk.com

#### Italy

NSK Italia S.p.A.  
Via Garibaldi, 215  
20024 Garbagnate  
Milanese (MI)  
Tel. +39 02 995 191  
Fax +39 02 990 25 778  
info-it@nsk.com

#### Poland & CEE

NSK Polska Sp. z o.o.  
Warsaw Branch  
Ul. Migdałowa 4/73  
02-796 Warszawa  
Tel. +48 22 645 15 25  
Fax +48 22 645 15 29  
info-pl@nsk.com

#### Russia

NSK Polska Sp. z o.o.  
Russian Branch  
Office I 703, Bldg 29,  
18<sup>th</sup> Line of Vasilievskiy Ostrov,  
Saint-Petersburg, 199178  
Tel. +7 812 3325071  
Fax +7 812 3325072  
info-ru@nsk.com

#### Spain

NSK Spain, S.A.  
C/ Tarragona, 161 Cuerpo Bajo  
2<sup>a</sup> Planta, 08014 Barcelona  
Tel. +34 93 2892763  
Fax +34 93 4335776  
info-es@nsk.com

#### Turkey

NSK Rulmanları Orta Doğu Tic. Ltd. Şti  
19 Mayıs Mah. Atatürk Cad.  
Ulya Engin İş Merkezi No: 68/3 Kat. 6  
P.K.: 34736 - Kozyatağı - İstanbul  
Tel. +90 216 4777111  
Fax +90 216 4777174  
turkey@nsk.com

### MIDDLE EAST

#### Dubai

NSK Bearings Gulf Trading Co.  
JAFZA View 19, Floor 24 Office 2/3  
Jebel Ali Downtown,  
PO Box 262163  
Dubai, UAE  
Tel. +971 (0) 4 804 8205  
Fax +971 (0) 4 884 7227  
info-me@nsk.com

### NORTH AND SOUTH AMERICA

#### United States of America

NSK Americas, Inc.  
4200 Goss Road  
Ann Arbor, Michigan 48105  
Tel. +1 734 913 7500  
Fax +1 734 913 7511

NSK Latin America, Inc.  
2500 NW 1 07th Avenue, Suite 300  
Miami, Florida 33172  
Tel. +1 305 4 77 0605  
Fax +1 305 4 77 0377

#### Canada

NSK Canada Inc.  
5585 McAdam Road  
Mississauga, Ontario  
Canada L4Z 1 N4  
Tel. +1 905 890 07 40  
Fax +1 800 800 2788

#### Argentina

NSK Argentina SRL  
García del Río 2477  
Piso 7 Oficina „A“ (1429)  
Buenos Aires  
Tel. +54 11 4704 51 00  
Fax +54 11 4704 0033

#### Brazil

NSK BRASIL LTDA.  
Rua 13 de Maio  
1633-14th Andar-Bela Vista-CEP  
01327-905 Sao Paulo, SP  
Tel. +55 11 3269 4786  
Fax +55 11 3269 4720

#### Peru

NSK PERU S.A.C.  
Av. Caminos del Inca 670  
Ofic: #402  
Santiago del Surco  
Lima  
Tel. +51 1 652 3372  
Fax +51 1 638 0555

#### Mexico

NSK Rodamientos Mexicana  
S.A. DE C.V.  
Av. Presidente Juárez No.2007 Lote 5  
Col. San Jeronimo Tepellacalco  
Tlalnepanitla, Estado de Mexico  
C.P. 54090  
Tel. +52 (55) 3682 2900  
Fax +52 (55) 3682 2937

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