



## INSTRUCTIONS FOR USING MINCO #20 HEATER INSTALLATION TAPE

Minco #20 Heater Installation Tape is a self-adhering silicone rubber tape with a .020" (.5 mm) nominal thickness and service temperature range from -50 to 200°C (-60 to 392°F). Its two-way stretch characteristics produce normal holding force for mounting Thermofoil™ Heaters on cylindrical surfaces. Follow the instructions below for proper results:

1. Wipe all surfaces of the heater and heat sink clean of dust and oil using a suitable solvent. Acetone, xylene, or toluene may be used for this purpose.

**Caution:** Use solvent cleaner sparingly—DO NOT SOAK THE HEATERS.

2. Position and contour the Thermofoil™ Heater to the mounting surface. Wrap tape around the assembly with sufficient tension to stretch the tape approximately 50%. A minimum of 1½ starter turns should be wrapped around the assembly.
3. For Thermofoil™ Heaters wider than standard tape widths, continue wrapping the tape in a helical manner, stretching the tape approximately 50% and overlapping each turn by at least 50%.
4. Wrap an additional of 1½ tape turns around the assembly on the last wrap, then cut the tape and press in place. Care should be taken to keep tape clean and ensure that the end is securely pressed in place.
5. If at all possible, use one continuous strip of Minco #20 stretch tape to mount each heater. If two or more strips are necessary, be sure to begin and end each strip with a minimum of 1½ tape turns around the assembly.
6. Minco #20 Heater Installation Tape is self-fusing silicone rubber and requires no cure cycle. The Thermofoil™ Heater is ready for use immediately after mounting.
7. The shelf life of Minco #20 tape exceeds 6 months when stored at 25°C (77°F) and 50% relative humidity. Refrigerate to prolong shelf-life.

We believe this information to be reliable, but the customer must assume responsibility for heater performance in the intended application. **Minco accepts no liability beyond our standard warranty for consequences of improper installation and/or heater or adhesive failure.**

If any questions or problems occur, contact your Minco sales representative or the factory for assistance.

DR: MH 8/17/00  
CHK: BHB 8/18/00  
ENG: MK 8/21/00  
APP: TJH 8/21/00



7300 Commerce Lane  
Minneapolis, MN 55432 U.S.A.  
Phone: 763-571-3121  
Fax: 763-571-0927  
www.minco.com

Engineering Instruction 124

ECO #36091

Rev. F

Page 1 of 1