

Error E05 – causes and remedies

1. Introduction

In temperature mode, the heater monitors the temperature rise of the bearing/workpiece. It is checked whether the temperature rises at least 1°C within the preset time interval. If this is not the case, error E05 is triggered and the device interrupts the heating cycle. The preset time interval for the IH025 is 20 seconds. The interval for the other heaters (IH070/IH090/IH210) is set to 15 seconds (0.25 t).

2. Causes

- Temperature probe still hot from the previous heating cycle
Occurs, when several bearings/workpieces must be heated to a high temperature in quick succession. The temperature probe does not have enough time to cool down between the heating cycles.
- Used yoke is too small
- The power was reduced too much
- Massive workpiece with a relatively small bore

3. Remedies

3.1. IH025 - Volcano

- Let the temperature probe cool down before starting the next heating cycle by placing it on a cool piece of metal. If you must heat several bearings/workpieces in quick succession, we recommend buying a second temperature probe. Between the heating cycles the temperature probe can be exchanged, so the not used one has more time to cool down.
- Increase the power if possible
- Press the "mode" and "minus" buttons simultaneously to increase the preset time interval from 20 to 50 seconds. Pressing the two buttons again reduces the interval to 20 seconds.



- Use the time mode by pressing the "mode" button
Caution! In time mode the temperature of the bearing/workpiece will not be monitored!



3.2. IH070 / IH090 / IH210

- Let the temperature probe cool down before starting the next heating cycle by placing it on a cool piece of metal. If you must heat several bearings/workpieces in quick succession, we recommend buying a second temperature probe. Between the heating cycles the temperature probe can be exchanged, so the not used one has more time to cool down.



- Always use the largest possible yoke



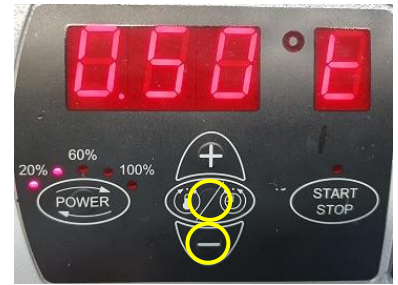
- Whenever possible, heat the bearings/workpieces over the coil



- Increase the power if possible



- Press the "mode" and "minus" buttons simultaneously to increase the preset time interval from 15 (0.25 t) to 30 (0.50 t) seconds. Pressing the two buttons again reduces the interval to 15 seconds.



- Use the time mode by pressing the "mode" button
Caution! In time mode the temperature of the bearing/workpiece will not be monitored!

