



STANDARDIZING  
 NOTICE

34-14-13N

SUPERSEDED DATE

SUBJECT HEATER (COILED) COATING  
 Process Specification

Initially used for MCH227K-2 heater for tube type 6S4 to reduce brittleness of heaters and stuck turns.

The herein given process for applying insulating coating to coiled heaters is the same as specified in 34-14-13D, except as follows:

1. Spray the heaters in a double clip up to approximately 50% of final weight and to a texture between #3 and #4.
2. Fire heaters at 1600-1650°C.
3. Re-spray the heaters up to final weight and to a texture between #3 and #4.
4. Re-fire the heaters at 1600-1650°C.

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ACCORDINGLY FUTURE REVISIONS  
 WILL NOT FOLLOW.

ENGINEERING SECTION  
 STANDARDIZING

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