

Title (en)
METHOD OF MANUFACTURING A MODULE COMPRISING A TUBULAR HEATING ELEMENT

Publication
EP 0056834 B1 19850918 (DE)

Application
EP 81102911 A 19810415

Priority
DE 3102028 A 19810122

Abstract (en)
[origin: EP0056834A2] 1. A method of manufacturing a mountable tubular heater unit, wherein the tubular heater ends are sealingly joined to a fixing plate (9) having suitable holes (8) in such manner that the connector ends of the tubular heater (1) are located on the outer sides of the fixing plate (9) and the tubular heater itself is located on the inner side of the fixing plate (9), characterized by the combination of the following method steps known per se : a) the tubular heater ends, each of which has a free annular space (7) between the connector pin (5) and the inner surface of the tubular jacket (2), are fitted into the associated holes (8) of the fixing plate (9) in such manner that the end face edges (6) of the tubular jacket (2) slightly project beyond the outer side of the fixing plate (9) ; b) the welding electrode (11), which has a central bore (13) for receiving the connector pin (5), is introduced into the annular space (7), wherein the end face edge (6) is pressed outwards over the edge of the hole and welded to the fixing plate (9) ; c) after the withdrawal of the conical welding electrode (11), the annular space (7) is closed with an adhesive plug (14) which also cover and seals the outwardly flanged end face edges (6) of the tubular jacket (2), so that any leaks which remain in the holes (8) during the welding-on operation of the tubular heater (1) are closed by the adhesive (14).

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IPC 8 full level
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CPC (source: EP)
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Cited by
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