

## SCREW PLUG IMMERSION HEATERS



### Typical Heating Applications:

- *Process Water Heating*
- *Heating Oils, Wax, Tar, Asphalt, Paraffin*
- *Mild Alkaline & Acid Solutions*
- *Freeze Protection*
- *Equipment Warm-up*
- *Heating Gases*
- *Food Processing*

Bucan's screw plug immersion heaters are medium capacity heating units designed to provide heat inside tanks and pipes. They consist of a single or a set of tubular elements that are formed into hairpins and welded or brazed to a screw plug. The sheath material of the heating elements could be steel, copper, stainless steel or Incoloy. The standard screw plug sizes utilized are 1", 1 1/4", 2" and 2 1/2" and are either made of steel, brass or stainless steel. Various types of electrical protective enclosures, built-in thermostats, thermocouples and high limit switches can be incorporated.

Screw plug NPT size	Plug material	Standard element diameters	Maximum voltage	Phase	Heating elements material	Maximum number of elements
1"	BRASS STEEL SS 304 SS 316	0.315" / 0.375"	300 V / 600	1	COPPER STEEL SS 304 SS 316, INCOLOY 800® INCONEL 600®	2 / 1
1 1/4"		0.315" / 0.375"	300 V / 600	1 / 3		3
2"		0.430"	600 V	3		3
2 1/2"		0.430"	600 V	3		3

Table 1

# BUCAN SCREW PLUG IMMERSION HEATERS

## Selection tips for screw plug heaters

Screw plug immersion heaters have a wide range of applications. It is essential to take several factors into consideration in order to select a heater that has features that match the requirements of a specific application and suitable to the environment where the heater will operate. The following are a number of criteria that should be taken into consideration:

- Besides the heating capacity required, a heater should operate at a temperature and a watt density that is adequate to the fluid heated. Tables 2 and 3 provide maximum sheath temperatures and watt densities that are recommended for heating various fluids.
- In order to select proper materials for screw plug heaters, general selection guides that are based on common experience in industrial usage could be used. However, this selection should always be based on a user's experience and knowledge in a specific application. Table 3 provides recommended sheath and screw plug materials for different mediums.
- It is important to note that at all times the temperature of the sheath material should not exceed the following temperatures:

Sheath material	Maximum temperature
Copper	360° F (180° C)
Stainless steel	1200° F (650° C)
Steel	750° F (400° C)
Incoloy	1500° F (815° C)

Table 2

- Taking the environment within which the heater will operate into account, safety issues should be taken into consideration.
- Adequate temperature controlling devices, temperature and pressure high limit switches, low liquid level and flow controllers and other control/safety devices should be used. These instruments will control the heating process and protect the heater from excessive heat.
- The classification of the electrical terminal box should match the application (NEMA 1, NEMA 4, NEMA 7, NEMA 12 etc...).
- The amount of contamination that the heater will be exposed to should be taken into account.
- Electrical safety codes should be considered.

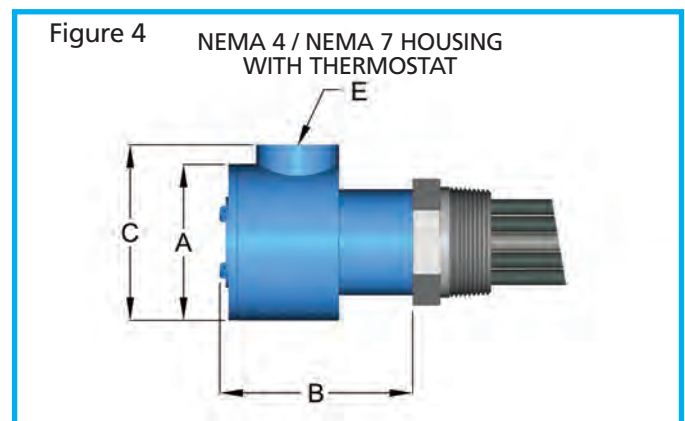
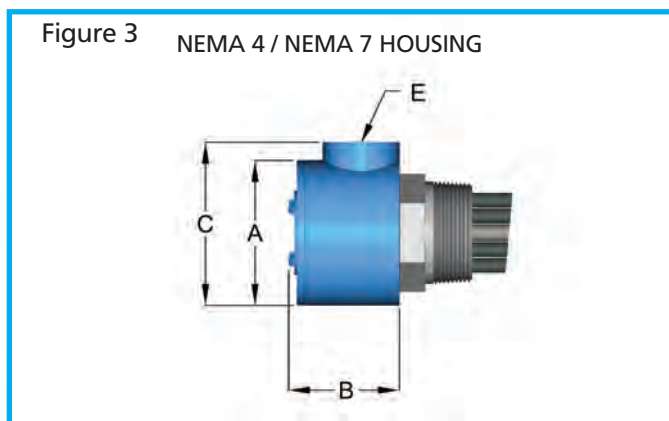
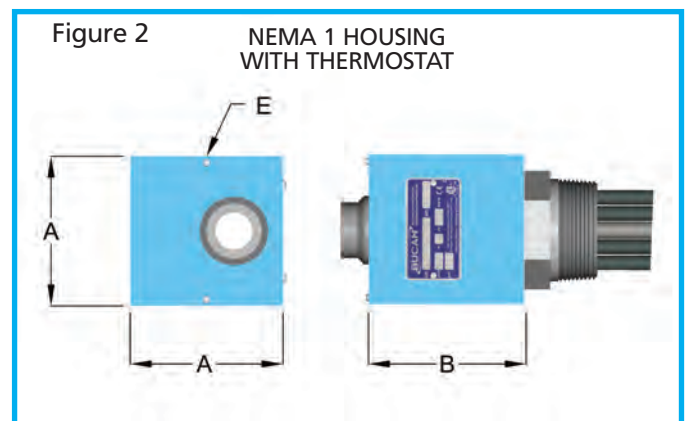
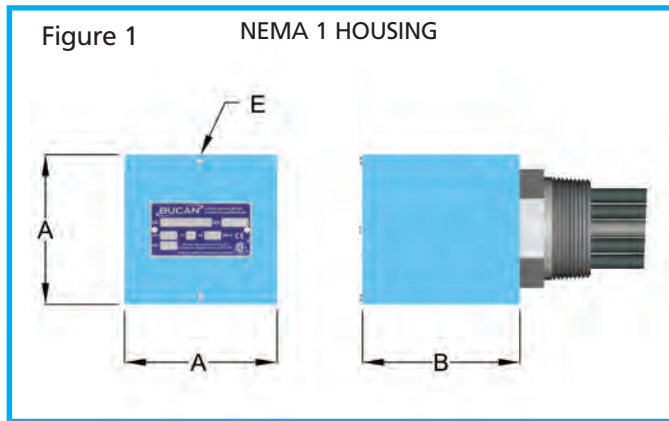
For more information, please contact our technical specialists.

Application	Sheath material	Screw plug material	Typical watt density w/in <sup>2</sup>
Clean water	Copper	Brass	55-80
Process water / Weak solution	Stainless steel	Stainless steel	25-55
Oil light	Steel	Steel	20-25
Oil medium	Steel	steel	12-15
Corrosive solutions (basic)	Incoloy	Stainless steel	20-25
Corrosive solutions (acidic)	Stainless steel	Stainless steel	20-25
Vegetable oil	Stainless steel	Stainless steel	30-40
Asphalt, tar, wax	Steel	Steel	4-10
Air	Incoloy	Steel	25-30

Table 3

# BUCAN SCREW PLUG IMMERSION HEATERS

## Terminal boxes



Terminal box type	Fig#	Dimensions			"E" Size hole
		A	B	C	
NEMA 1 Terminal box	Fig. 1	3 3/4" Dia.	2 3/4"	N/A	7/8" Knock-out
NEMA 1 Terminal box with built-in thermostat	Fig. 2	3 3/4" Dia.	3 3/4"	N/A	7/8" Knock-out
NEMA 4 / NEMA 7 Terminal box	Fig. 3	3 1/2" Dia.	3 1/8"	4 1/2"	1" NPT
NEMA 4 /NEMA 7 Terminal box with built-in thermostat	Fig. 4	4 1/4" Dia.	5 3/16"	5 1/4"	1 1/4" NPT

## Optional features

- Nema 4 (moisture proof) terminal box.
- Nema 7 (Hazardous location) terminal box.
- Built-in thermowell.
- Built-in single or double pole thermostats.
- Passivation for stainless steel and Incoloy heaters.
- Built-in process or high limit thermocouples.
- Special screw plugs or non-standard thread sizes. (SPT, BSPP, BSPT.....etc.)

# BUCAN SCREW PLUG IMMERSION HEATERS

## Thermostats and thermocouples

Thermostats that are utilized in screw plug heaters are the bulb and capillary style. These thermostats operate by the principle of expansion and contraction of a heat sensitive liquid found inside the bulb and capillary assembly, which controls the activation of an electrical switch inside the thermostat.

Thermostats in most cases open the electrical circuit when the desired temperature is attained (open on rise). The table below shows available ranges of thermostats.

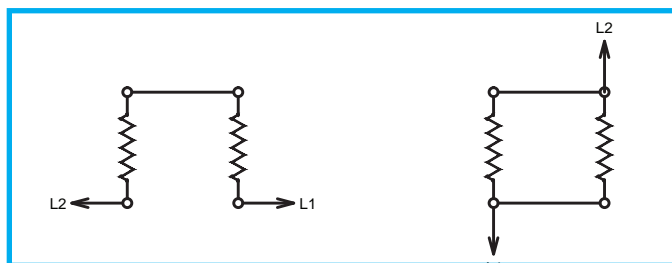
A pilot duty thermostat can always be used when the ampacity of a heater is higher than the available thermostat amperages shown below.

Thermostat	Contact operation	Temperature range	Volts / Amps
T0	SPST	10° to 120°C	125V - 30A / 250V - 30A / 277V - 25A
T1	SPST	-15,5° to 40°C	125V - 30A / 250V - 30A / 277V - 25A
T2	SPST	70° to 280°C	125V - 30A / 250V - 30A / 277V - 25A
T3	SPST	149° to 370°C	125V - 30A / 250V - 30A / 277V - 25A
T4	SPST	0° to 120°C	125V - 30A / 250V - 30A / 277V - 25A
T5	DPST	10° to 120°C	max. 277V - max. 25A
T6	DPST	-15,5° to 40°C	max. 277V - max. 25A
T7	DPST	-25,5° to 204,5°C	max. 277V - max. 25A
T8	DPST	10° to 120°C	max. 600V - max. 15A

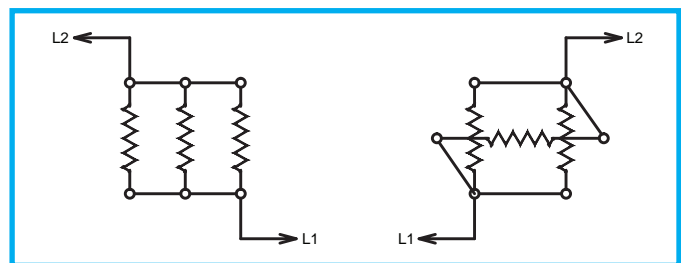
It should be noted that thermostats are only temperature controllers and should not be used as fail-safe high limit switches.

Built-in thermocouples could be utilized inside screw plug heaters to give more accurate temperature indications. Thermocouples could also be attached to one of the heating elements and utilized as high-temperature limiting devices.

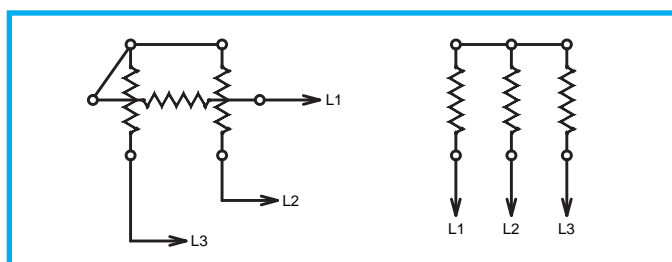
## Typical wiring diagrams for screw plug heaters



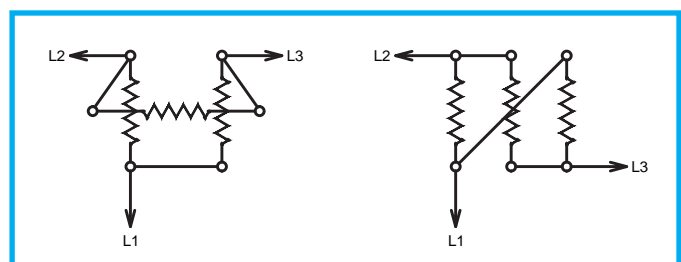
Typical wiring diagram for single phase, 2 elements



Typical wiring diagram for single phase, 3 elements



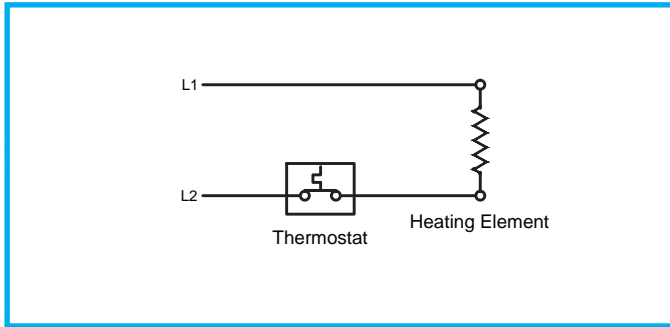
Typical wiring diagram for 3 phase wye, 3 elements



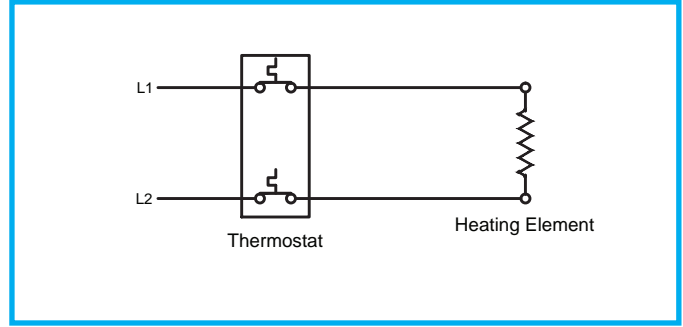
Typical wiring diagram for 3 phase delta, 3 elements

# BUCAN SCREW PLUG IMMERSION HEATERS

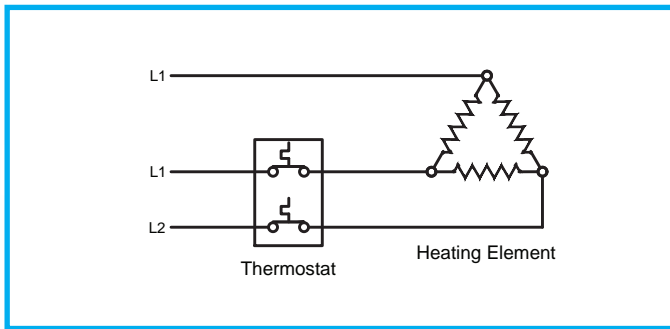
## Typical wiring diagrams for screw plug heaters



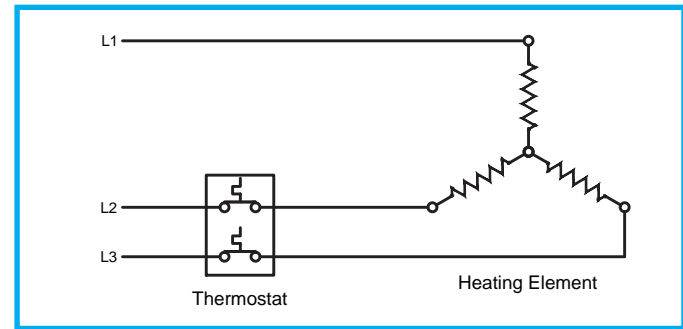
Single phase, single pole, single throw line duty thermostat max. 25A max. 277V



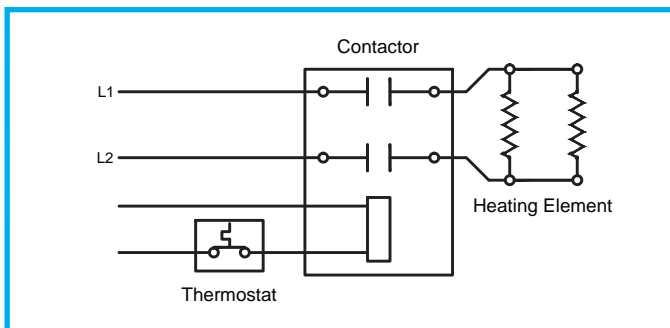
Single phase, double pole, single throw line duty thermostat max. 15A and max. 600V



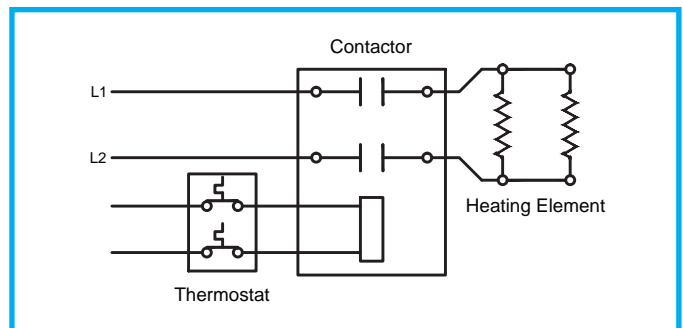
Three phase, (Delta) double pole, single throw line duty thermostat either max. 15A or max. 600V



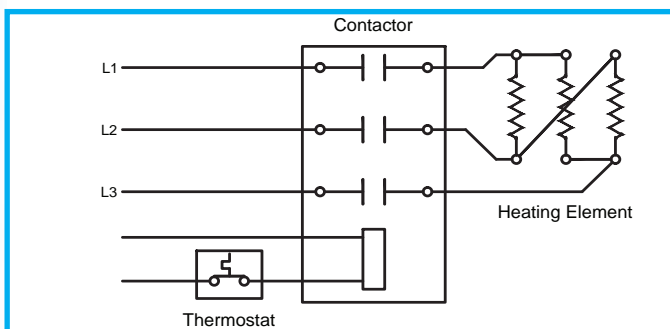
Three phase, (Star) double pole, single throw line duty thermostat either max. 15A or max. 600V



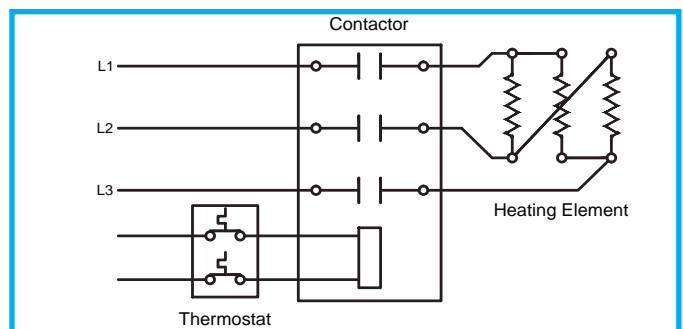
Single phase, single pole, single throw pilot duty thermostat (SPST)



Single phase, double pole, single throw pilot duty thermostat (DPST)

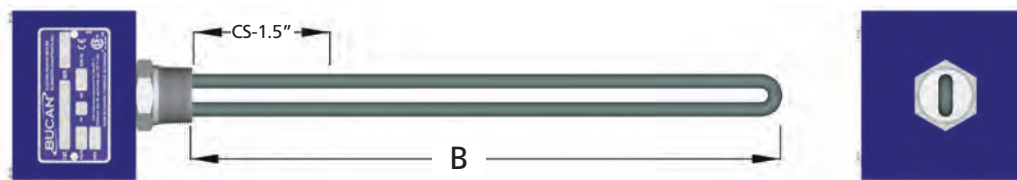


Three phase, single pole, single throw pilot duty thermostat (SPST)



Three phase, double pole, single throw pilot duty thermostat (DPST)

# BUCAN SCREW PLUG IMMERSION HEATERS



KILO WATTS	'B' DIMENSION		STANDARD VOLTAGES	COLD SECTION	WATT DENSITY		WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT 10-120°C / 50-250°F	NET WEIGHT	
	inch	mm			W/in <sup>2</sup>	W/cm <sup>2</sup>			LBS	KG

## HIGH DENSITY / 1" NPT BRASS PLUG / 1 COPPER ELEMENT

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
0.5	5.5	140	120 208 240	1.5"	63	9.8	SH1B105C140	SH1B105C140T	2.0	0.9
0.75	5.5	140			95	14.7	SH1B107C140	SH1B107C140T	2.0	0.9
1	7	178			92	14.2	SH1B110C178	SH1B110C178T	2.0	0.9
1.5	10.5	267			84	13.1	SH1B115C267	SH1B115C267T	2.1	1.0
2	7.5	191			84	13.1	SH1B120C191	SH1B120C191T	2.0	0.9
3	11	279			80	12.4	SH1B130C279	SH1B130C279T	2.0	1.0
5	17	432			81	12.6	SH1B150C432	SH1B150C432T	2.3	1.0

## MEDIUM DENSITY / 1" NPT STEEL PLUG / 1 INCOLOY ELEMENT

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
0.3	7.5	191	120 208 240	1.5"	25	3.9	SH1F103I191	SH1F103I191T	2.0	0.9
0.5	9	229			34	5.2	SH1F105I229	SH1F105I229T	2.0	0.9
0.7	11	279			37	5.8	SH1F107I279	SH1F107I279T	2.1	1.0
0.9	12	305			43	6.7	SH1F109I305	SH1F109I305T	2.1	1.0

## LOW DENSITY / 1" NPT STEEL PLUG / 1 INCOLOY ELEMENT

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
0.2	7.5	191	120 208 240	1.5"	17	2.6	SH1F102I191	SH1F102I191T	2.0	0.9
0.4	9.5	241			25	3.9	SH1F104I241	SH1F104I241T	2.1	0.9
0.6	11	279			32	4.9	SH1F106I279	SH1F106I279T	2.1	1.0

## HIGH DENSITY / 1 1/4" NPT STEEL PLUG / 2 COPPER ELEMENTS

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
1.5	6	152	120 208	1.5"	84	13.1	SH12B215C152	SH12B215C152	2.4	1.1
2	7	178			92	14.2	SH12B220C178	SH12B220C178	2.5	1.1

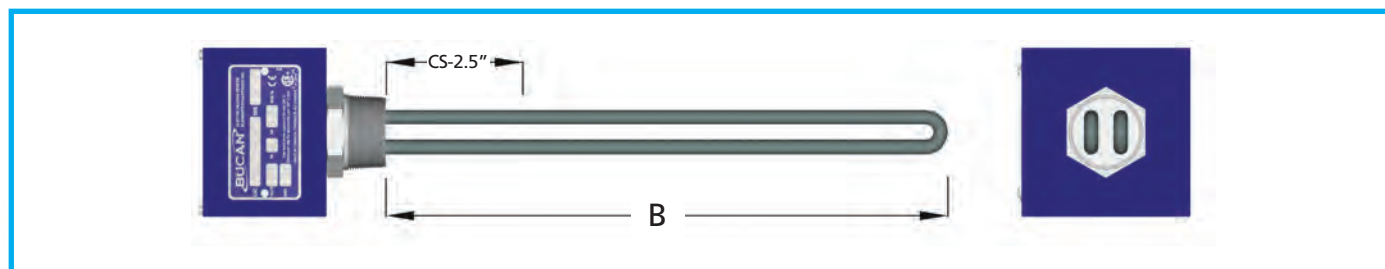
## MEDIUM DENSITY / 1 1/4" NPT STEEL PLUG / 2 INCOLOY ELEMENTS

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
1	11	279	120 208	1.5"	27	4.1	SH12F210I279	SH12F210I279T	2.8	1.3
2	21	533			26	4.0	SH12F220I533	SH12F220I533T	3.4	1.5

## LOW DENSITY / 1 1/4" NPT STEEL PLUG / 2 INCOLOY ELEMENTS

KILO WATTS	inch	mm	STANDARD VOLTAGES	COLD SECTION	WATT DENSITY W/in <sup>2</sup>	WATT DENSITY W/cm <sup>2</sup>	WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT	LBS	KG
0.6	11	279	120 208	1.5"	16	2.5	SH12F206I279	SH12F206I279T	2.8	1.3
1.2	21	533			16	2.4	SH12F212I533	SH12F212I533T	3.4	1.5

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KILO WATTS	'B' DIMENSION		STANDARD VOLTAGES	COLD SECTION	WATT DENSITY		WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT 10-120°C / 50-250°F	NET WEIGHT	
	inch	mm			W/in <sup>2</sup>	W/cm <sup>2</sup>			LBS	KG

## HIGH DENSITY / 2" NPT BRASS PLUG / 2 COPPER ELEMENTS

1.5	8	203	120 / 208 240 / 416 480 / 600	2.5"	50	7.8	SH2B215C203	SH2B215C203T	4.3	1.9
2	8	203			67	10.4	SH2B220C203	SH2B220C203T	4.3	1.9
3	12	305			58	9.1	SH2B230C305	SH2B230C305T	4.6	2.1
4	18	457			48	7.4	SH2B240C457	SH2B240C457T	5.1	2.3
5	22	559			47	7.4	SH2B240C559	SH2B240C559T	5.5	2.5
6	25.5	648			48	7.5	SH2B260C648	SH2B260C648T	5.8	2.6
8	32.5	826	280	48	7.6	SH2B280C826	SH2B280C826T	6.4	2.9	
10	39.5	1003	240 / 416	50	7.8	SH2B2100C1003	SH2B2100C1003T	7.0	3.2	
12	47	1194	480 / 600	50	7.7	SH2B2120C1194	SH2B2120C1194T	7.7	3.5	

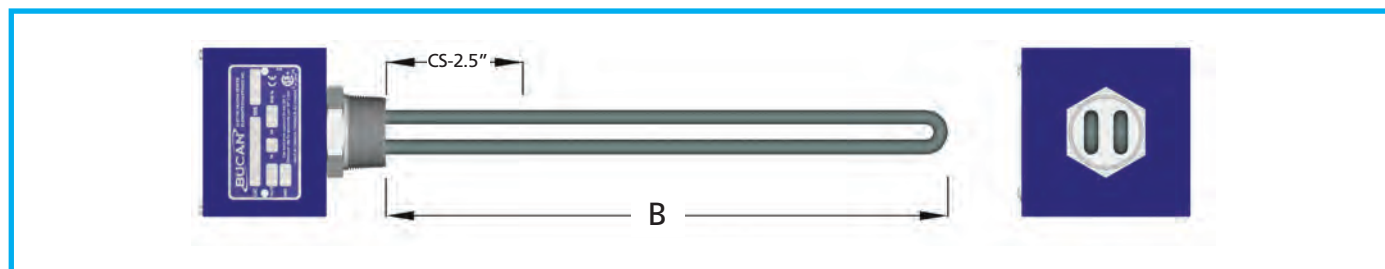
## HIGH DENSITY / 2" NPT STAINLESS PLUG / 2 INCOLOY ELEMENTS

1.5	8	203	120 / 208 240 / 416 480 / 600	2.5"	50	7.8	SH2S215I203	SH2S215I203T	4.2	1.9
2	8	203			67	10.4	SH2S220I203	SH2S220I203T	4.2	1.9
3	12	305			58	9.1	SH2S230I305	SH2S230I305T	4.6	2.1
4	18	457			48	7.4	SH2S240I457	SH2S240I457T	5.2	2.4
5	22	559			47	7.4	SH2S250I559	SH2S250I559T	5.6	2.6
6	25.5	648			48	7.5	SH2S260I648	SH2S260I648T	6.0	2.7
8	32.5	826	280	48	7.6	SH2S280I826	SH2S280I826T	6.7	3.0	
10	39.5	1003	240 / 416	50	7.8	SH2S2100I1003	SH2S2100I1003T	7.4	3.4	
12	47	1194	480 / 600	50	7.7	SH2S2120I1194	SH2S2120I1194T	8.2	3.7	

## MEDIUM DENSITY / 2" NPT STEEL PLUG / 2 INCOLOY ELEMENTS

1.5	12	205	120 / 208 240 / 416 480 / 600	2.5"	29	4.5	SH2F215I205	SH2F215I205T	4.6	2.1
2	18	457			24	3.7	SH2F220I457	SH2F220I457T	5.2	2.4
3	26	660			24	3.7	SH2F230I660	SH2F230I660T	6.0	2.7
4	32.5	826			25	3.8	SH2F240I826	SH2F240I826T	6.7	3.0
5	39.5	1003			25	3.9	SH2F250I1003	SH2F250I1003T	7.4	3.4
6	47	1194			280 240 / 416 480 / 600	25	3.9	SH2F2560I1194	SH2F2560I1194T	8.2

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	inch	mm			W/in <sup>2</sup>	W/cm <sup>2</sup>			LBS	KG

## MEDIUM DENSITY / 2" NPT STAINLESS PLUG / 2 INCOLOY ELEMENTS

1.5	12	305	120 / 208 240 / 416 480 / 600	2.5"	29	4.5	SH2S215I305	SH2S215I305T	4.6	2.1
2	18	457			24	3.7	SH2S220I457	SH2S220I457T	5.2	2.4
3	26	660			24	3.7	SH2S230I660	SH2S230I660T	6.0	2.7
4	32.5	826			25	3.8	SH2S240I826	SH2S240I826T	6.7	3.0
5	39.5	1003			25	3.9	SH2S250I1003	SH2S250I1003T	7.4	3.4
6	47	1194	280 240 / 416 480 / 600		25	3.9	SH2S2560I1194	SH2S2560I1194T	8.2	3.7

## LOW DENSITY / 2" NPT STEEL PLUG / 2 INCOLOY ELEMENTS

1	18	457	120 / 208 240 / 416 480 / 600	2.5"	12	1.9	SH2F210I457	SH2F210I457T	5.2	2.4
1.5	26	660			12	1.8	SH2F215I660	SH2F215I660T	6.0	2.7
2	32.5	826			12	1.9	SH2F220I826	SH2F220I826T	6.7	3.0
3	39	991			15	2.4	SH2F230I991	SH2F230I991T	7.4	3.3

## LOW DENSITY / 2" NPT STAINLESS PLUG / 2 INCOLOY ELEMENTS

1	18	457	120 / 208 240 / 416 480 / 600	2.5"	12	1.9	SH2S210I457	SH2S210I457T	5.2	2.4
1.5	26	660			12	1.8	SH2S215I660	SH2S215I660T	6.0	2.7
2	32.5	826			12	1.9	SH2SF220I826	SH2S220I826T	6.7	3.0
3	39	991			15	2.4	SH2S230I991	SH2S230I991T	7.4	3.3

## HIGH DENSITY / 2" NPT BRASS PLUG / 3 COPPER ELEMENTS

3	6	203	120 / 208 240 / 416 480 / 600	2.5"	67	10.4	SH2B330C203	SH2B330C203T	4.6	2.1
4.5	12	305			58	9.1	SH2B345C305	SH2B345C305T	5.1	2.3
6	18	457			48	7.4	SH2B360C457	SH2B360C457T	5.9	2.7
7.5	22	559			47	7.4	SH2B375C559	SH2B375C559T	6.5	3.9
9	26	660			47	7.3	SH2B390C660	SH2B390C660T	7.0	3.24
12	32.5	826	280 240 / 416 480 / 600		49	7.6	SH2B31200C826	SH2B31200C826	7.8	3.6

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	inch	mm			W/in <sup>2</sup>	W/cm <sup>2</sup>			LBS	KG

## MEDIUM DENSITY / 2" NPT STEEL PLUG / 3 INCOLOY ELEMENTS

3	18	457	120 / 208	2.5"	24	3.7	SH2F330I457	SH2F330I457T	6.1	2.8
6	32.6	826	240 / 416		25	3.8	SH2F360I826	SH2F360I826T	8.4	3.8
9	47	1194	280 / 416 / 480 / 600		25	3.9	SH2F390I1194	SH2F390I1194T	10.6	4.8

## LOW DENSITY / 2" NPT STEEL PLUG / 3 INCOLOY ELEMENTS

1.5	18	457	120 / 208	2.5"	12	1.9	SH2F315I457	SH2F315I457T	6.1	2.8
3	32.5	826	240 / 416		12	1.9	SH2F330I826	SH2F330I826T	8.4	3.8
4.5	39	991	480 / 600		15	2.4	SH2F345I991	SH2F345I991T	9.4	4.3

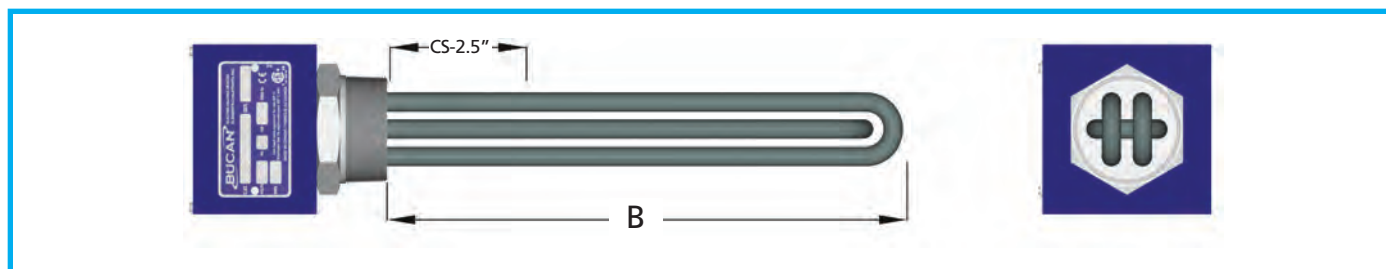
## HIGH DENSITY / 2 1/2" NPT BRASS PLUG / 3 COPPER ELEMENTS

3	8	203	120 / 208 / 240 / 416 / 480 / 600	2.5"	67	10.4	SH25B330C203	SH25B330C203T	6.7	3.1
4.5	12	305			58	9.1	SH25B345C305	SH25B345C305T	7.3	3.3
6	17.5	445			49	7.6	SH25B360C445	SH25B360C445T	8.0	3.6
7.5	21.5	546			49	7.5	SH25B375C546	SH25B375C546T	8.5	3.9
9	25	635			49	7.6	SH25B390C635	SH25B390C635T	9.0	4.1
12	32	813			50	7.8	SH25B3120C813	SH25B3120C813T	9.9	4.5
15	39	991	280	51	7.9	SH25B3150C991	SH25B3150C991T	10.8	4.9	
180	47	1194	240 / 416	50	7.7	SH25B3180C1194	SH25B3180C1194T	11.9	5.4	

## HIGH DENSITY / 2 1/2" NPT BRASS PLUG / 3 INCOLOY ELEMENTS

3	8	203	120 / 208	2.5"	67	10.4	SH25B330I203	SH25B330I203T	6.9	3.1
4.5	12	305	240 / 416		58	9.1	SH25B345I305	SH25B345I305T	7.5	3.4
6	17.5	445	208		49	7.6	SH25B360I445	SH25B360I445T	8.4	3.8
7.5	21.5	546			49	7.5	SH25B375I546	SH25B375I546T	9.0	4.1
9	25	635			49	7.6	SH25B390I635	SH25B390I635T	9.5	4.3
12	32	813	240 / 416		50	7.8	SH25B3120I813	SH25B3120I813T	10.6	4.8
15	39	991	480 / 600		51	7.9	SH25B3150I991	SH25B3150I991T	11.7	5.3
18	47	1194			50	7.7	SH25B3180I1194	SH25B3180I1194T	12.9	5.9

# BUCAN SCREW PLUG IMMERSION HEATERS



KILO WATTS	'B' DIMENSION		STANDARD VOLTAGES	COLD SECTION	WATT DENSITY		WITHOUT THERMOSTAT CATALOG NO.	WITH THERMOSTAT 10-120°C / 50-250°F	NET WEIGHT	
	inch	mm			W/in <sup>2</sup>	W/cm <sup>2</sup>			LBS	KG

## MEDIUM DENSITY / 2 1/2" NPT STEEL PLUG / 3 INCOLOY ELEMENTS

3	17.5	445	120 / 208	2.5"	25	3.8	SH25F330I445	SH25F330I445T	8.0	3.6
4.5	25	635	240 / 416		25	3.8	SH25F345I635	SH25F345I635T	9.2	4.2
6	32	813	208		25	3.9	SH25F360I813	SH25F360I813T	10.2	4.6
7.5	39	991	240 / 416		25	3.9	SH25F375I991	SH25F375I991T	11.3	5.1
9	47	1194	480 / 600		25	3.9	SH25F390I1194	SH25F390I1194T	12.6	5.7

## MEDIUM DENSITY / 2 1/2" NPT STAINLESS PLUG / 3 INCOLOY ELEMENTS

3	17.5	445	120 / 208	2.5"	25	3.8	SH25S330I445	SH25S330I445T	8.0	3.6
4.5	25	635	240 / 416		25	3.8	SH25S345I635	SH25S345I635T	9.2	4.2
6	32	813	208		25	3.9	SH25S360I813	SH25S360I813T	10.2	4.6
7.5	39	991	240 / 416		25	3.9	SH25S375I991	SH25S375I991T	11.3	5.1
9	47	1194	480 / 600		25	3.9	SH25S390I1194	SH25S390I1194T	12.6	5.7

## LOW DENSITY / 2 1/2" NPT STEEL PLUG / 3 INCOLOY ELEMENTS

3	32	813	120 / 208	2.5"	13	1.9	SH25F330I813	SH25F330I813T	10.2	4.6
4.5	39	991	240 / 416		15	2.4	SH25F345I991	SH25F345I991T	11.3	5.1
6	47	1194	208 240 / 416 480 / 600		17	2.6	SH25F360I1194	SH25F360I1194T	12.6	5.7

## LOW DENSITY / 2 1/2" NPT STAINLESS PLUG / 3 INCOLOY ELEMENTS

3	32	813	120 / 208	2.5"	13	1.9	SH25S330I813	SH25S330I813T	10.2	4.6
4.5	39	991	240 / 416		15	2.4	SH25S345I991	SH25S345I991T	11.3	5.1
6	47	1194	208 240 / 416 480 / 600		17	2.6	SH25S360I1194	SH25S360I1194T	12.6	5.7