

**INSTALLATION
INSTRUCTIONS****ALLIS CHALMERS 649
301 CID****CAUTION**

DO NOT plug in heater if heating element is not immersed in coolant. If not immersed, element sheath may burst and could result in personal injury.

HEATER INSTALLATION PROCEDURE

1. Drain engine coolant.
2. Remove water jacket access plate located on the right rear side of the engine.
3. Clean gasket surface.
4. Check heater installation by mounting heater unit to engine using bolts removed from original plate. Heater should be installed with element pointing forward. The element should not contact any part of the block.
5. Remove heater. Apply gasket cement to engine gasket surface and to the inside surface of the heater plate.
6. Install heater unit as in step 4. Tighten mounting bolts evenly and securely.
7. Insert power cord connector into socket, being careful to align pins with sockets of connector on cord. Press plug firmly into socket. Tighten strain relief nut securely by hand.
8. Allow slack for engine vibration and protect cord from excessive heat and also from possible chafing or mechanical damage.

**CAUTION**

Before applying power to heater, fill cooling system completely with good grade permanent antifreeze solution. Operate engine until all trapped air is removed. This is done by operating engine until thermostat opens (normal operating temperature). Run engine at governed high RPM for 5 to 10 seconds.

**NOTE**

Due to impurities found in most cooling systems, Phillips and Temro recommends the installation of an adequate water filtration system.

**CAUTION**

Do not start engine with heater plugged in. Turbulence and air bubbles can cause hot spots on heating element and can result in element failure.

WARRANTY

The Phillips & Temro Industries warranty statement is located on the website at phillipsandtemro.com/terms.