

**INSTALLATION  
INSTRUCTIONS**

**CUMMINS (855) ENGINE SERIES  
WITH PLATE**

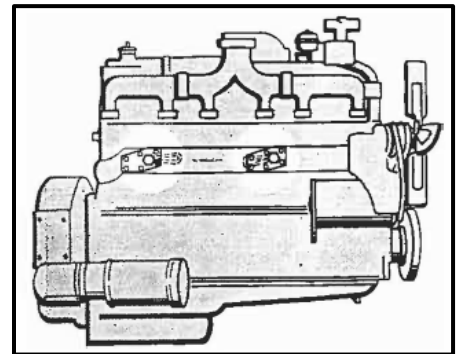
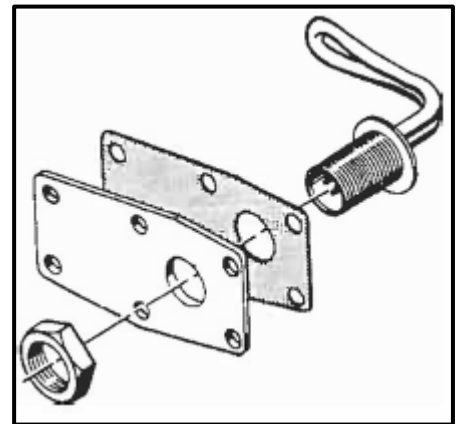
**CAUTION**



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.  
 USE a 50/50 solution of ethylene glycol antifreeze and water for optimum heater performance.  
 DO NOT use more than 65% concentration of antifreeze, as a shortened heater life will result.  
 DO NOT use heater in coolant system containing any form of stop-leak additive.

**HEATER INSTALLATION PROCEDURE**

1. Drain engine coolant.
2. Remove water jacket access plate (6 bolt flange plate) located on right side of the engine as shown. The heater plate can be installed in both the standard orientation or the reversed bolt orientation as on the New Big Cam IV engines, forward plate location.
3. Clean gasket surface. Apply gasket cement to engine gasket surface and to the inside surface of the heater plate.
4. Mount heater unit (element and plate) to engine using bolts removed from original plate. Do not tighten completely. Hex nut on the heater unit should be loose enough to allow the element to be turned to check for interference inside the block. Do not force the element into position. Tighten mounting bolts evenly and securely.
5. Tighten hex nut on the element assembly unit to 20 or 30 foot pounds torque. Do not allow the element to turn while tightening.
6. 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.
7. Route cord to location for easy connection to 120 Volts AC properly grounded outlet. Fasten cord where necessary to prevent contact with hot engine surfaces and moving parts. Allow slack for engine vibration.
8. Fill cooling system completely with good grade permanent antifreeze solution. See CAUTION note above.



**CAUTION**



Before applying power to heater, remove all trapped air by running engine for 5-10 minutes after the thermostat opens (normal operating temperature).

**WARRANTY**

The Phillips & Temro Industries warranty statement is located on the website at [phillipsandtemro.com/terms](http://phillipsandtemro.com/terms).