

**INSTALLATION
INSTRUCTIONS**

**CUMMINS 855 CID
REAR PLUG ENGINE HEATER**

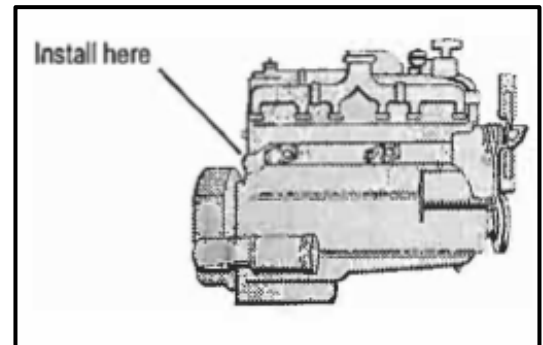
CAUTION



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. Flush cooling system if necessary. Remove plug located on the rear face of the engine on the right side. Clean threads of block opening thoroughly.
2.
 - a. If plug did not have an O-ring for sealing, it is pipe thread. Coat threads of heater adapter with gasket cement or teflon tape.
 - b. If plug had O-ring for sealing, install furnished O-ring to groove on heater. Lubricate O-ring for easier installation and prevent O-ring damage.
3. Loosely assemble heater, hex nut, element, gasket, and adapter. Install heater assembly into block.
4. Tighten adapter securely. Torque to engine manufacturers specifications.
5. Tighten hex nut on the element assembly unit to 30 foot pounds torque. Do not allow the element to turn while tightening.
6. Insert power cord connector firmly into socket, taking care to align pins with sockets of connector on cord. Tighten strain relief nut securely by hand.
7. Route cord to outside, securing where necessary to allow slack for engine vibration and ensure that cord does not touch engine, hot pipes, or any moving parts. **Connect only to properly grounded 120 Volt AC outlet. If an extension cord is used, it must be the three-wire grounded type.**
8. Refill cooling system 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.