

**INSTALLATION
INSTRUCTIONS**

CUMMINS K6 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.

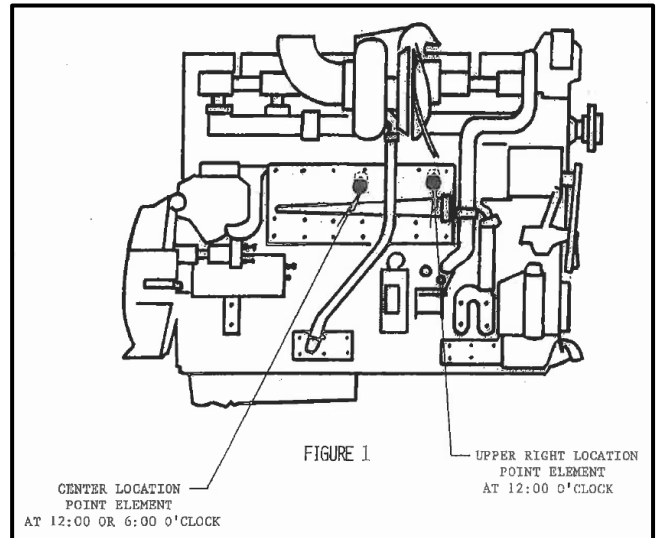
USE a 50/50 solution of ethylene glycol antifreeze and water for optimum heater performance.

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

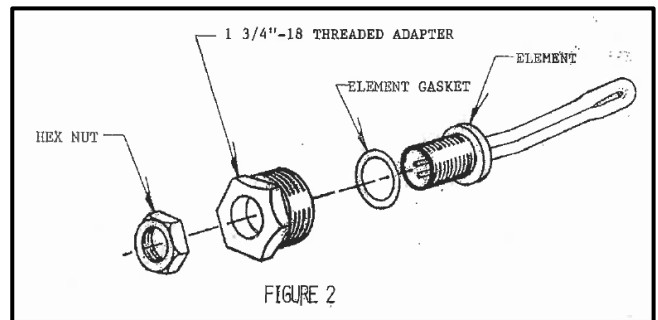
1. Drain engine coolant. Flush system if necessary.
2. Remove large hex plug on the oil cooler cover. The location of the hex plug varies depends on the cooler cover option: center (standard) or upper right corner (see Figure 1).
3. Clean threads and surface of block opening thoroughly.
4. Loosely assemble the heater components as shown (see Figure 2). Apply coating of grease to the heater O-ring, to ease installation and prevent O-ring damage.
5. Install heater assembly (see Figure 1).
 - a. For center location: locate tip of element in the 12:00 or 6:00 o'clock position.
 - b. For upper right location: locate tip of element in the 12:00 o'clock position (10:00 to 1:00 is acceptable).
6. Tighten threaded adapter securely (to Engine Mfr torque spec).
7. Tighten hex nut to 20-30 foot lbs. torque.



NOTE

Be sure element is not touching inside of block and does not turn while hex nut is being tightened.

8. 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.
9. Route cord to location for easy connection to a 120 Volt AC properly grounded outlet. Fasten cord where necessary to prevent contact with hot engine surfaces and moving parts. Allow slack for engine vibration.
10. Fill cooling system completely with good grade permanent 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.