

**INSTALLATION  
INSTRUCTIONS**

**DETROIT DIESEL  
SERIES 55**



**WARNING**

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

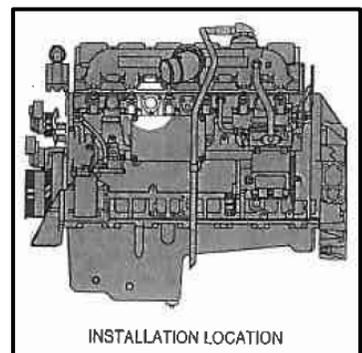
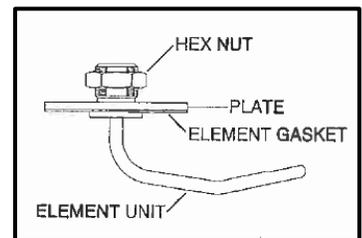


**CAUTION**

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, as a shortened heater life will result.

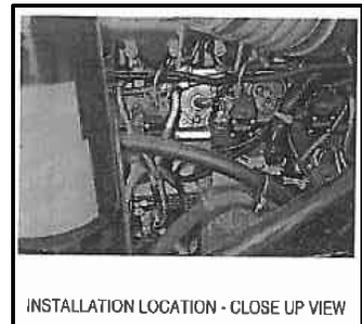
**HEATER INSTALLATION PROCEDURE**

1. Drain engine coolant.
2. Remove water jacket access plate (3-bolt flange plate) located on LEFT side (as viewed from driver's seat) of the engine as shown below.
3. Clean gasket surface. Apply gasket cement to engine gasket surface and to the inside surface of the heater plate.
4. Install element unit in plate with gasket between heater flange and plate. Heater should point toward rear when installed.
5. Mount heater unit (element and plate) to engine, using bolt removed from original plate. Tighten mounting bolts evenly and securely.
6. Tighten hex nut on the element assembly unit to 20 to 30 foot pounds torque. Do not allow the element to turn while tightening.
7. Insert power cord connector into socket, taking care to align pins with sockets of connector on cord. Press plug firmly into socket. Tighten strain relief nut securely by hand.
8. 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.**
9. 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).