

**INSTALLATION  
INSTRUCTIONS**

**MBE 4000 / OM460**



**WARNING**

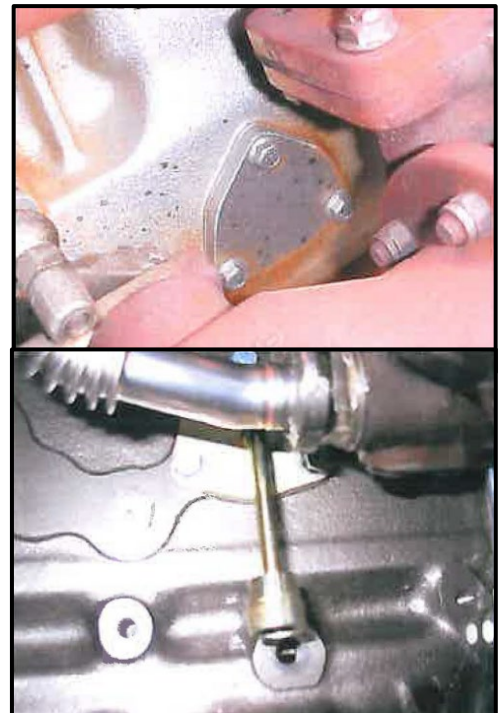
**PERSONAL INJURY. Never operate heater if element is not immersed in coolant.** Element sheath could burst and cause personal injury.

**HEATER DAMAGE. Never run engine while heater is in operation.** Shortened heater life will result.

**HEATER DAMAGE. Do not use stop leak additives or improper coolant mixtures.** Shortened heater life will result.

**HEATER INSTALLATION PROCEDURE**

1. Drain engine coolant. Flush system if necessary.
2. Remove 3-bolt access plate right side, center of engine (see pictures). Discard used gasket.
3. Clean gasket surfaces and apply gasket cement. Install gasket from kit and heater assembly with element pointing to 3 o'clock (for part numbers 3500082 and 3500083) or install the heater pointing to 9 o'clock (part number 3500080).
4. Tighten the bolts securely to 35Nm (26ft. lbs).
5. 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.
6. 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.
7. Connect only to a GFCI protected 120-Volt AC outlet. If an extension cord is used, it must be the three-wire grounded type.
8. Refill cooling system with coolant mixture. Use a standard 50/50 mixture of coolant and water. Do not use more than 60% concentration of coolant as it will reduce the heater life.
9. Run engine up to operating temperature and check for leaks. Let engine run for 5-10 minutes after thermostat opens to ensure all air is bled from system.



**NOTE**

**HEATER DAMAGE. Do not operate heater until all air is bled from system.** Shortened heater life will result.

**WARRANTY**

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