

**INSTALLATION  
INSTRUCTIONS**

**JOHN DEERE SERIES 250 POWER TECH  
ENGINES 4042 (2.4L, 4 CYL) & 5030 (3.0L, 5 CYL)**



**CAUTION**

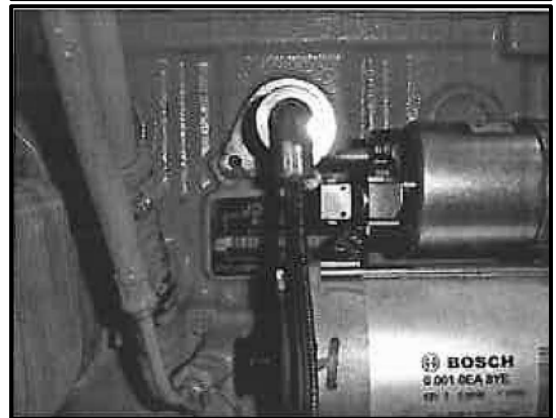
**PERSONAL INJURY. Never operate heater if element is not immersed in coolant.** Element sheath could burst and cause personal injury.

**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 core plug on **left side, rear** of engine (see picture).
3. Clean core hole surface thoroughly. Remove any burrs, paint or sharp edges on diameter of core hole. Burnish core hole surface with sandpaper or steel wool.
4. Apply lubricant to the heater O-ring to ease installation and prevent damage to O-ring.
5. Install heater into core hole and align the tapped hole in the block with the clearance hole on the mount plate. See picture (note the cord will not point to the ground as shown in the picture, it will be at an angle).
6. Install heater assembly and tighten to 12 lb-ft. (16 Nm) of torque.
7. 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.
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 a GFCI protected 120-Volt AC outlet. If an extension cord is used, it must be the three-wire grounded type.
9. 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.
10. 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.



**CAUTION**

**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).