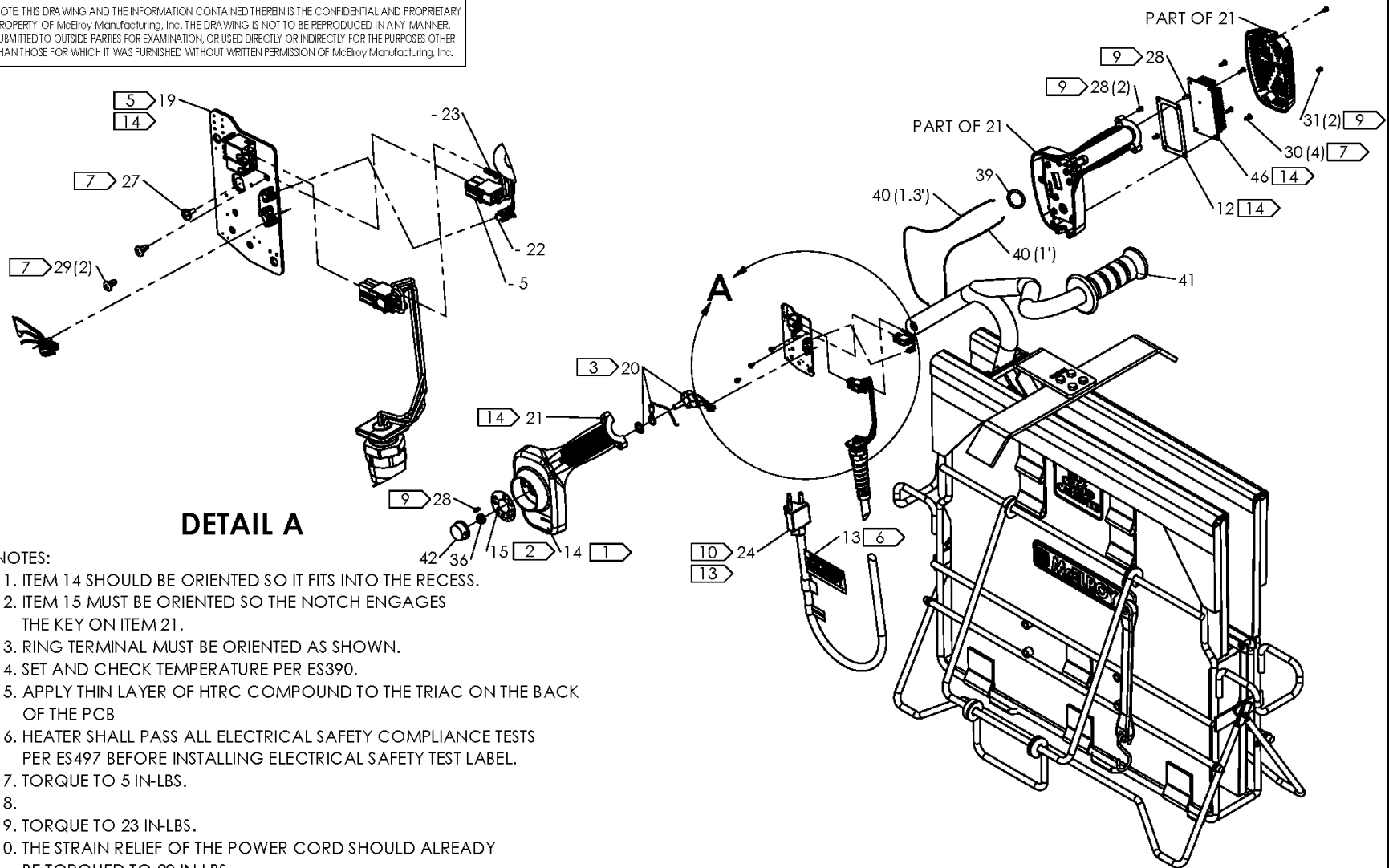


618 HEATER ASSEMBLY (6"/12") 220-240V, 50/60Hz, 1Ph

NOTE: THIS DRAWING AND THE INFORMATION CONTAINED THEREIN IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF McElroy Manufacturing, Inc. THE DRAWING IS NOT TO BE REPRODUCED IN ANY MANNER, SUBMITTED TO OUTSIDE PARTIES FOR EXAMINATION, OR USED DIRECTLY OR INDIRECTLY FOR THE PURPOSES OTHER THAN THOSE FOR WHICH IT WAS FURNISHED WITHOUT WRITTEN PERMISSION OF McElroy Manufacturing, Inc.



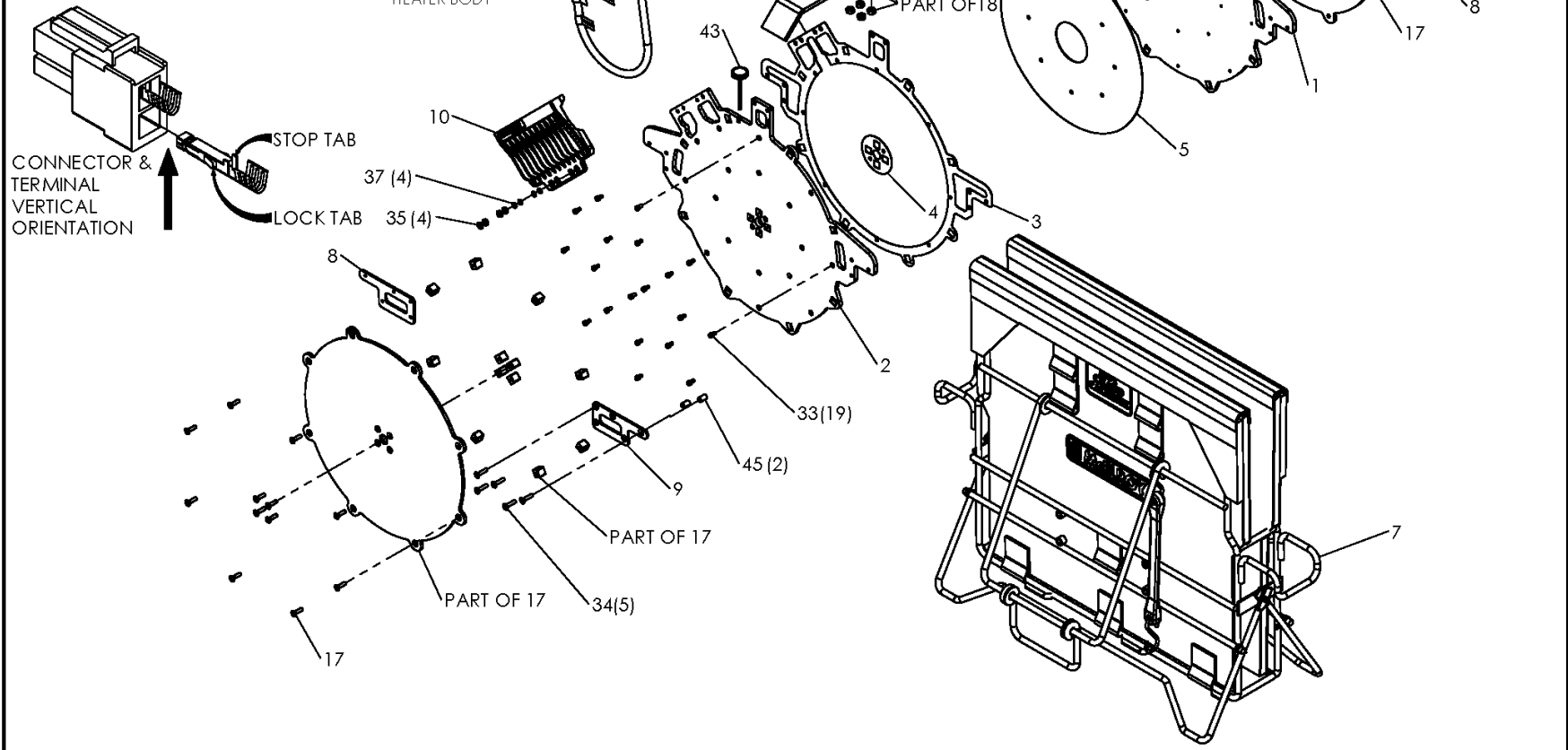
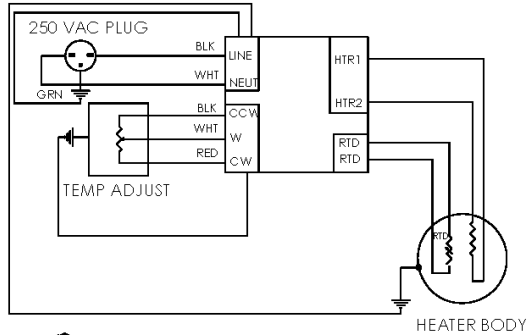
DETAIL A

NOTES:

1. ITEM 14 SHOULD BE ORIENTED SO IT FITS INTO THE RECESS.
2. ITEM 15 MUST BE ORIENTED SO THE NOTCH ENGAGES THE KEY ON ITEM 21.
3. RING TERMINAL MUST BE ORIENTED AS SHOWN.
4. SET AND CHECK TEMPERATURE PER ES390.
5. APPLY THIN LAYER OF HTRC COMPOUND TO THE TRIAC ON THE BACK OF THE PCB
6. HEATER SHALL PASS ALL ELECTRICAL SAFETY COMPLIANCE TESTS PER ES497 BEFORE INSTALLING ELECTRICAL SAFETY TEST LABEL.
7. TORQUE TO 5 IN-LBS.
- 8.
9. TORQUE TO 23 IN-LBS.
10. THE STRAIN RELIEF OF THE POWER CORD SHOULD ALREADY BE TORQUED TO 20 IN-LBS.
11. APPLY ITEM #44 TO ITEM #5 AND #22 APPROXIMATELY AS SHOWN TO PROTECT AGAINST SHARP EDGES ON ITEM #16. COMPONENT WIRES SHOULD BE TAPED SEPARATELY FROM OTHER COMPONENTS.
12. ORDER T5077504 TO REPLACE THE HEATER HANDLE WELDMENT SUBASSEMBLY.
13. ORDER AT5078114 TO REPLACE POWER CABLE.
14. COMPONENT MUST BE ORDERED AS PART OF THE T5033401 SUBASSEMBLY

618 HEATER ASSEMBLY (6"/12") 220-240V, 50/60Hz, 1Ph

NOTE: THIS DRAWING AND THE INFORMATION CONTAINED THEREIN IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF McElroy Manufacturing, Inc. THE DRAWING IS NOT TO BE REPRODUCED IN ANY MANNER, SUBMITTED TO OUTSIDE PARTIES FOR EXAMINATION, OR USED DIRECTLY OR INDIRECTLY FOR THE PURPOSES OTHER THAN THOSE FOR WHICH IT WAS FURNISHED WITHOUT WRITTEN PERMISSION OF McElroy Manufacturing, Inc.



McElroy Manufacturing Parts List

Part Number: 1853601 #618 (6"/12") 220-240V Heater Assembly

Part Number 1853601 Component List

| Item | Component | Description | Quantity | Unit | Price |
|------|-----------|---|----------|------|--------|
| 1 | 1242103 | Right Heater Body | 1.0 | EA | 611.00 |
| 2 | 1242104 | Left Heater Body | 1.0 | EA | 611.00 |
| 3 | 1242105 | Heater O.d. Spacer | 1.0 | EA | 89.48 |
| 4 | 1242106 | Heater I.d. Spacer | 1.0 | EA | 11.87 |
| 5 | 1242202 | Mica/foil Heater Elem W/ Conn | 1.0 | EA | 732.00 |
| 6 | 1808102 | Htr Gasket | 1.0 | EA | 4.31 |
| 7 | 1835102 | Heater Bag Assembly | 1.0 | EA | 753.00 |
| 8 | 1852014 | Tapped Htr Guide Rod Sprt Bkt | 2.0 | EA | 33.61 |
| 9 | 1852015 | C'sunk Htr Guide Rod Sprt Bkt | 2.0 | EA | 33.61 |
| 10 | 1863102 | Htr Terminal Enclosure Half | 2.0 | EA | 44.10 |
| 11 | 1863201 | Stripper Bar Bracket | 1.0 | EA | 160.00 |
| 12 | 437401 | Heat Sink Gasket | 1.0 | EA | 0.00 |
| 13 | 8163210 | Electrical Safety Test Label | 1.0 | EA | 0.00 |
| 14 | 8163396 | Model 1853601/02 Part NO Label | 1.0 | EA | 17.00 |
| 15 | 816382 | Temperature Scale Label | 1.0 | EA | 6.00 |
| 16 | 838007 | Heater Handle Wld | 1.0 | EA | 162.00 |
| 17 | A1242108 | 12 Heater Butt Plate Kit | 1.0 | EA | 802.00 |
| 18 | A1818803 | 618(6/12) Stripper Bar Kit | 1.0 | EA | 161.00 |
| 19 | T5030006 | Heater Control Pcb Assy (Effective to 12/15/20) | 1.0 | EA | 0.00 |
| 19 | T5030009 | Heater Control Pcb Assy | 1.0 | EA | 0.00 |
| 20 | T5030007 | Potentiometer Assy | 1.0 | EA | 20.85 |
| 21 | T5030108 | Heater Handle/enclosure | 1.0 | EA | 19.78 |
| 22 | T5077603 | Rtd W/ Conn X 26" | 1.0 | EA | 79.61 |
| 23 | T5077902 | Ground Wire W/ Term X 17" | 1.0 | EA | 25.51 |
| 24 | T5078103 | 15A/250V Pwr Cord W/plug&conn | 1.0 | EA | 75.40 |
| 25 | MAC00038 | #10-24NCX3/4LG Shcs SS | 8.0 | EA | 0.77 |
| 26 | MAH00030 | #10-24NCX1/4LG Rhsms SS | 1.0 | EA | 0.29 |
| 27 | MAH00296 | #6-32X1/4 Phil Pan Sealg Scr | 1.0 | EA | 1.58 |
| 28 | MAL00010 | #6-19X3/4LG Torx T15 Pan Hdscr | 4.0 | EA | 0.49 |
| 29 | MAL00011 | #6-19X1/4LG Torx T15 Pan Hdscr (Effective to 1/16/20) | 2.0 | EA | 0.63 |
| 29 | MAL00034 | #6-19X1/4LG Phil Pan Hdscr | 2.0 | EA | 0.06 |
| 30 | MAL00030 | #6-19X3/8LG Torx T15 Pan Hdscr (Effective to 1/16/20) | 4.0 | EA | 0.07 |
| 30 | MAL00035 | #6-19X3/8LG Phil Pan Hdscr | 4.0 | EA | 0.08 |
| 31 | MAL00031 | #6-19X1-1/2'LG Torx T15 Panscr | 2.0 | EA | 0.19 |
| 32 | MAN00008 | #10-24NCX1LG Shcs SS | 4.0 | EA | 1.04 |
| 33 | MAN00023 | #8-32NCX5/16LG Shcs SS | 19.0 | EA | 0.59 |
| 34 | MAN00036 | #10-32NFX7/8LG Fhscs SS | 10.0 | EA | 0.79 |
| 35 | MBA00004 | #10-24NC Hex Nut Stl PL | 4.0 | EA | 0.31 |
| 36 | MBA00067 | 3/8-32NEF X 0.22 X 1/4 Sealnut | 1.0 | EA | 3.45 |
| 37 | MBE00004 | #10 Reg Split Lck Washer Stl PL | 4.0 | EA | 0.10 |
| 38 | MBG00072 | #10 Int Tooth Lock Washer | 1.0 | EA | 0.29 |
| 39 | MDL00018 | O-ring | 1.0 | EA | 0.56 |
| 40 | MDL00373 | .040DIA Buna O-ring Cord Stock | 2.3 | FT | 1.42 |
| 41 | MJJ00009 | 1" Black Gloss Hand Grip | 1.0 | EA | 3.04 |
| 42 | MJJ00023 | Control Knob | 1.0 | EA | 4.12 |
| 43 | MJK00002 | 2.5LG,150-650DEG F Thermometer | 1.0 | EA | 41.71 |
| 44 | MLN00219 | Fiberglass Tape (per Ft) | 0.66 | FT | 0.44 |
| 45 | MLN00402 | #10 X 5/16OD X 1/2LG Spacer | 4.0 | EA | 1.13 |
| 46 | MQI00111 | Heatsink | 1.0 | EA | 0.00 |

Please visit <https://fusion.mcelroy.com/parts> to purchase parts or for more information.