



INSTRUCTION SHEET

8"-18" Heater Rebuild Kits

A855901 & A1862601

This instruction sheet describes the steps necessary to rebuild the heater control system of 8" – 18" heaters. It will convert them from being tethered to controls on the heater bag frame to electronic controls located inside the heater handle with a knob for setting the temperature and a heating indicator light.

This instruction sheet covers 2 kits (120 Volt and 240 Volt) for rebuilding the following five heaters (8" - 18"):

OLD	NEW	
848701	848709	8 dips 100-120V,50/60,1 Heater Assembly
848801	848803	8 dips 220-240V,50/60,1 Heater Assembly
1242101	1242112	12 220-240V,50/60,1 Heater Assembly
1852001	1852019	18 (12/18)220-240V Heater Assembly
1855501	1855502	18 (6/12)220-240V Heater Assembly

Heater Conversion Kits:

Contents of A855901 8" Heater Handle/Controller Rebuild Kit, 120V

Qty	Item	Description
1	855901	8" Heater Handle/Controller Assembly, 120V
1	A855902	Hardware Kit (consists of items below)
1	816393	Model 848709 Part No Label
1	1808102	Heater Gasket
2ft	MLN00219	High Temp Tape
8	MAH00046	#10-24ncx1/2lg socket head capscrew
1	MFA00021	1/2" Plug
1	186260101	Instruction Sheet (this paper)



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Contents of A1862601 8-18" Heater Handle/Controller Rebuild Kit, 240V

Qty	Item	Description
1	1862601	8-18" Heater Handle/Controller Assembly, 240V
1	A1862602	Hardware Kit (consists of items below)
1	816394	Model 848803 Part No Label
1	816395	Model 1242112 Part No Label
1	816396	Model 1852019 Part No Label
1	816397	Model 1855502 Part No Label
1	1808102	Heater Gasket
2ft	MLN00219	High Temp Tape
8	MAH00046	#10-24ncx1/2lg socket head capscrew
1	MFA00021	1/2" Plug
1	186260101	Instruction Sheet (this paper)



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Tool list for rebuilding 8" – 18":

- 5/64" hex L-key
- 5/32" hex L-key
- 3/8" hex L-key
- channel lock pliers
- wire cutters
- butt splice crimp tool: SPC Technology P/N CTT-8425-01, Sta-Kon P/N WT111M, WT110M or equivalent
- medium width flat screw driver.



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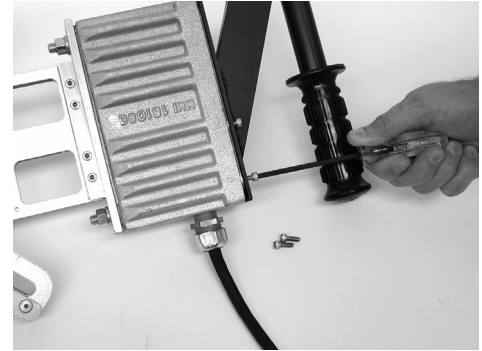
8"-18" Heater Rebuild Kits

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Step 1

Unplug the heater and let it cool to room temperature. Protect the butt plates from abrasion during this rebuild. Remove the 8 screws attaching the heater handle with a 5/32" hex wrench. Discard the screws.

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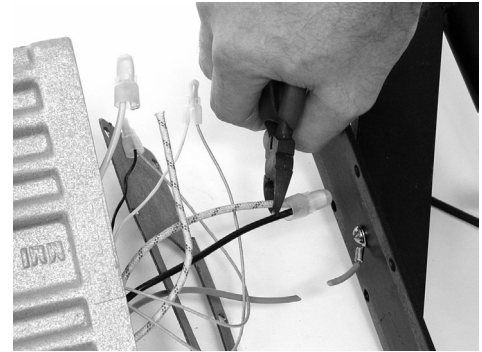


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Step 2

Pull the handle away from the heater and cut the green wire going to the handle and discard the old handle and gasket. Inside the enclosure, cut the remaining four wires next to the butt splice joints. Cut so that the fabric covered (braided) wires on the heater are as long as possible.

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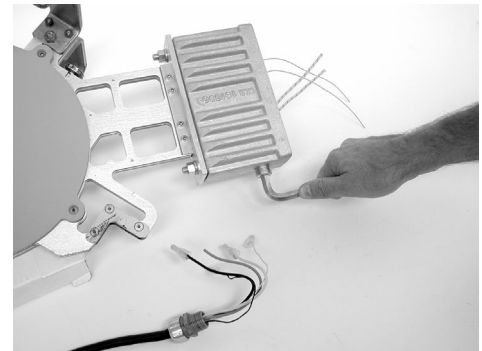


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Step 3

Unscrew the power cord grip from the terminal enclosure using channel lock pliers. Discard the power cord and grip (see step 7). Install a 1/2" pipe plug in the hole using a 3/8" hex wrench and tighten.

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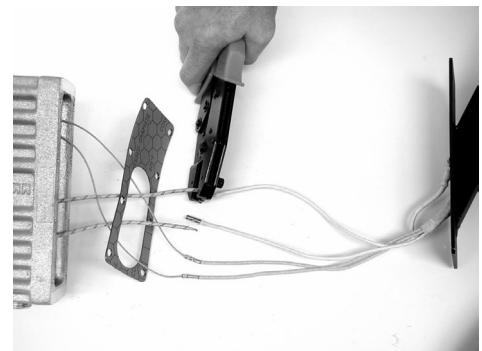
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Step 4

Place the new gasket on top of the terminal enclosure and pull the heater wires through its slot. Make electrical connections between the new handle assembly and the heater. The two small gage wires on the handle butt splice to the two small gage wires on the heater (RTD). Crimp using the 18-22 AWG crimp position. There is no polarity.

The two large gage wires on the handle butt splice to the two large gage wires on the heater (heating element). Crimp using the 14-16 AWG position. There is no polarity.

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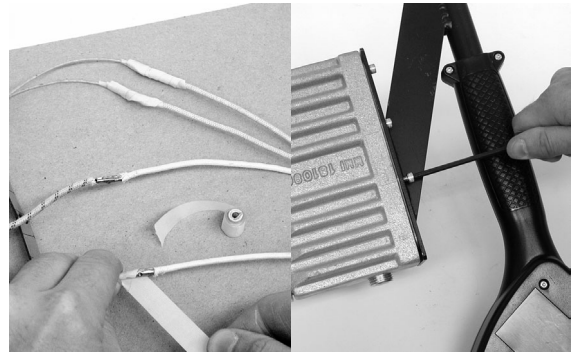
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Step 5

Use 6" of the white high temperature insulating tape to wrap and fully cover each of the four butt splice connections, with a double layer.

Push the wires into the terminal enclosure, align the gasket and bolt on the new handle/controller assy using the 8 screws and a 5/32 hex wrench. If available, apply high temperature anti-seize compound (not included in the kit) to the screw threads.

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Step 6

Several Part Number Labels may be included in the kit. Choose the one that matches the heater size and voltage and affix it to the back of the handle. Be sure it is turned the same way as the MMI logo on the handle. Discard the remaining Part Number labels.

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Step 7

Remove the heater and the heater bag from the frame. Remove the four screws attaching the control box to the heater bag frame with a 5/32 hex wrench.

Hint: If the screws won't come out then use a flat screwdriver to pry between the frame and box to hold the nut inside the box. Discard the control box along with its contents and power cords. Reinstall the heater bag.

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Step 8

Put the heater in the bag frame assembly, set the knob to 500F and plug its cord into power. The red indicator light on the temperature dial should glow steadily until the set temperature is reached. Then it should cycle on and off slowly to maintain temperature. If it flashes a signal repeatedly an error has occurred, count the flash sequence and unplug the heater. Call McElroy Technical Service at 918-836-8611 for more information.

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Step 9

The control knob should be calibrated to agree with the surface temperature as measured with a pyrometer. Let the heater come to temperature (indicator light cycling on and off slowly). If the butt plate temperature measurement is not 500F then hold the knob still and loosen its set screw with a 5/64" hex key. Turn the loose knob to the measured temperature and tighten the screw (do not over tighten). Turn tightened knob to 500F and measure the temperature after the heater light has cycled a few times.

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Step 10

For parts information, refer to the assembly drawing listed on the heater handle part number label. The drawing can be viewed and printed via the Internet at McElroy Manufacturing Inc's web site: www.mcelroymfg.com.

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DRAWING REVISION HISTORY LISTING

PART NO: 186260101

DESCRIPTION: 8"-18" HEATER REBUILD KITS INSTRUCTION SHEET

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SWB	A	10/6/06	RLE	ADDED 816393 MODEL 848709 PART No. LABEL TO CONTENTS OF A855901 8" HEATER HANDLE/CONTROLLER REBUILD KIT, 120V