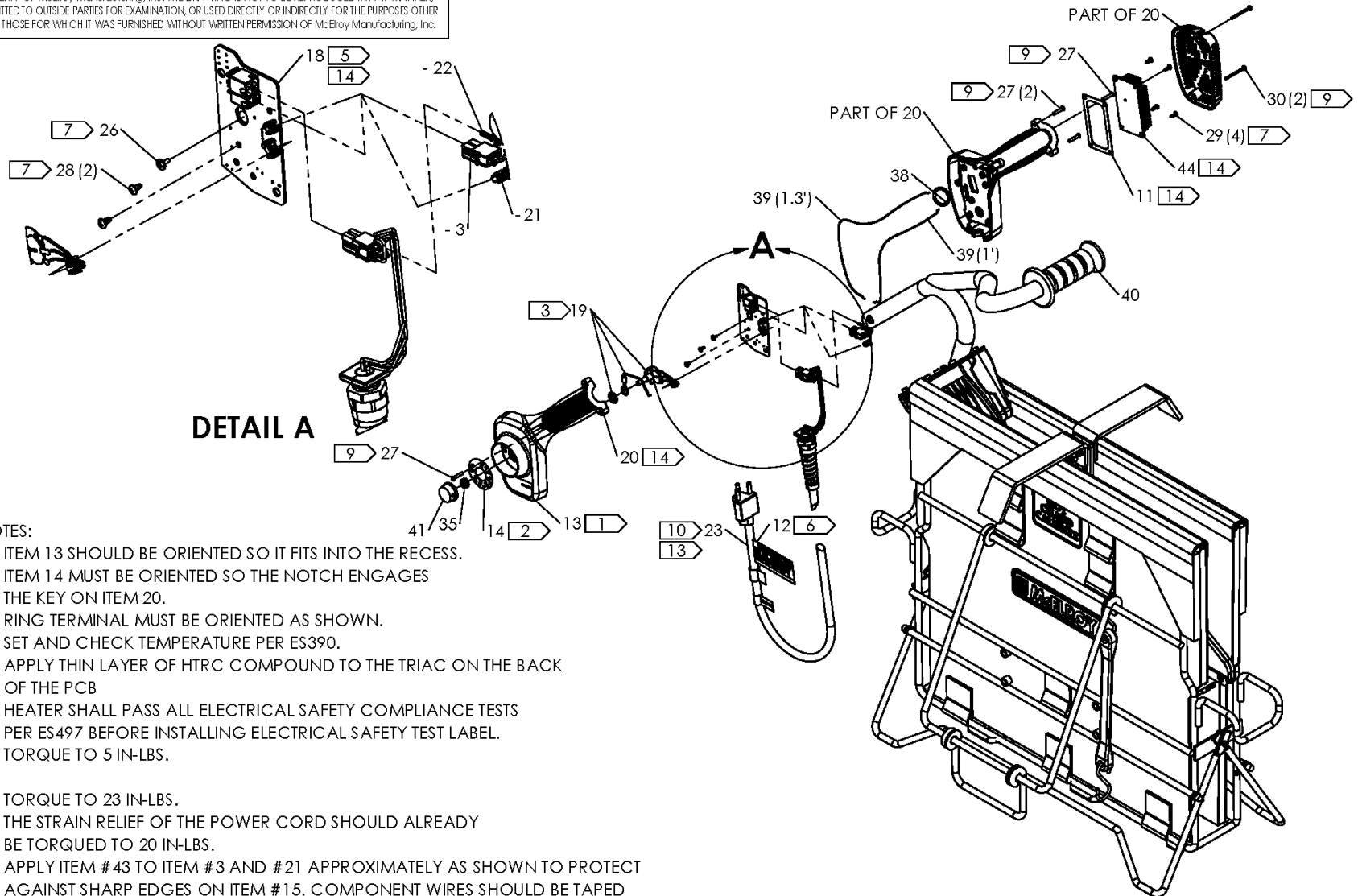


#618 HEATER ASSEMBLY (12"/18") 220-240V, 50/60Hz, 1Ph

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.

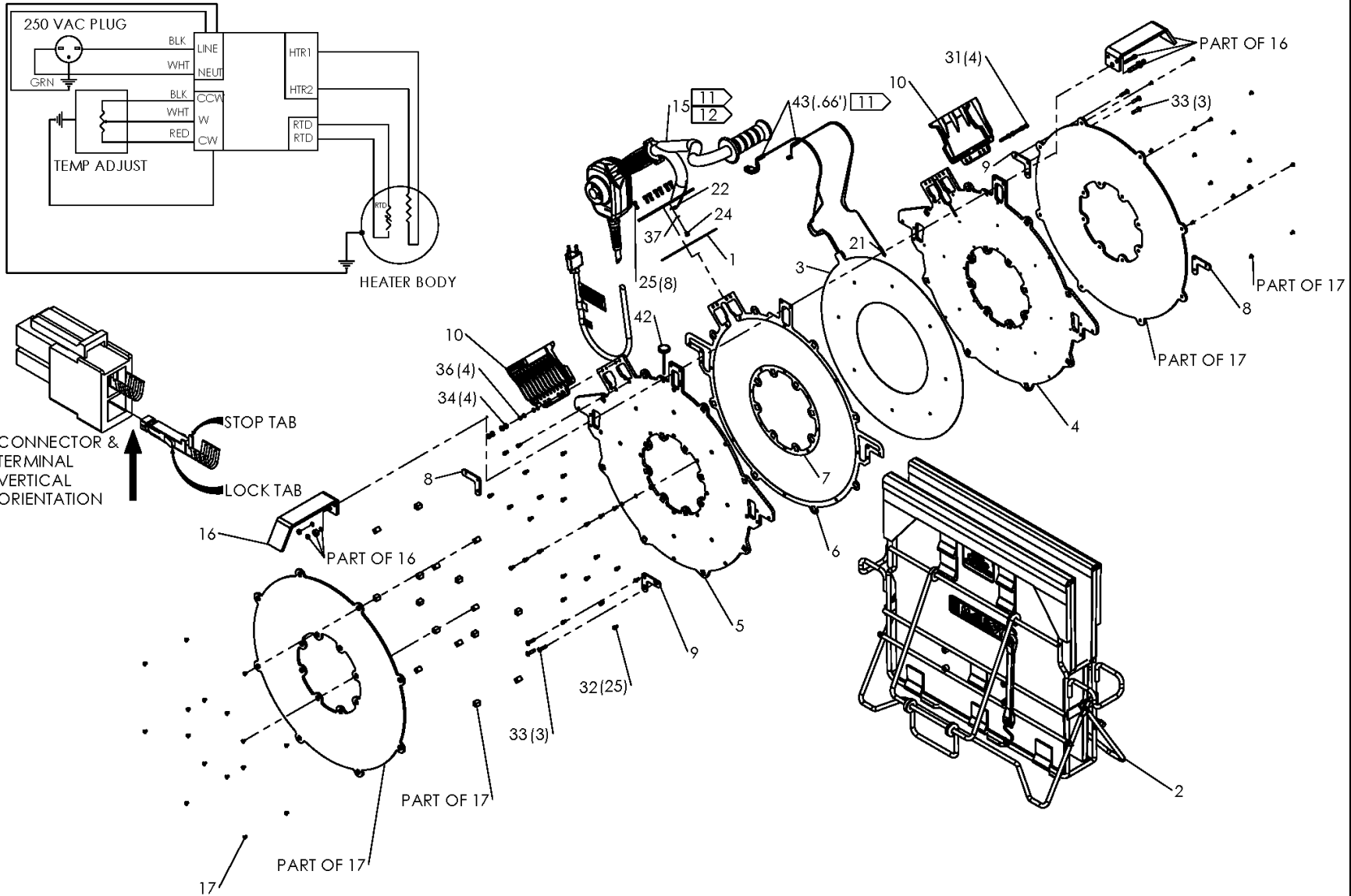


NOTES:

1. ITEM 13 SHOULD BE ORIENTED SO IT FITS INTO THE RECESS.
2. ITEM 14 MUST BE ORIENTED SO THE NOTCH ENGAGES THE KEY ON ITEM 20.
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 #43 TO ITEM #3 AND #21 APPROXIMATELY AS SHOWN TO PROTECT AGAINST SHARP EDGES ON ITEM #15. 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.

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McElroy Manufacturing Parts List

Part Number: 1853401 #618 (12"/18") 220-240V Heater Assembly

Part Number 1853401 Component List

Item	Component	Description	Quantity	Unit	Price
1	1808102	Htr Gasket	1.0	EA	4.92
2	1835102	Heater Bag Assembly	1.0	EA	860.00
3	1851902	Mica/foil Heater Elem W/ Conn	1.0	EA	1,140.00
4	1852003	Right Heater Body	1.0	EA	1,019.00
5	1852004	Left Heater Body	1.0	EA	1,019.00
6	1852005	Heater O.d. Spacer	1.0	EA	272.00
7	1852006	Heater I.d. Spacer	1.0	EA	108.00
8	1852011	Tapped Htr Guide Rod Sprt Bkt	2.0	EA	38.39
9	1852012	C'sunk Htr Guide Rod Sprt Bkt	2.0	EA	38.39
10	1863102	Htr Terminal Enclosure Half	2.0	EA	50.38
11	437401	Heat Sink Gasket	1.0	EA	0.00
12	8163210	Electrical Safety Test Label	1.0	EA	0.00
13	8163394	Model 1853401/02 Part NO Label	1.0	EA	10.00
14	816382	Temperature Scale Label	1.0	EA	6.85
15	838007	Heater Handle Wld	1.0	EA	185.00
16	A1852010	618(12/18) Stripper Bar Kit	1.0	EA	169.00
17	A1852013	18 Heater Butt Plate Kit	1.0	EA	1,040.00
18	T5030006	Heater Control Pcb Assy (Effective to 12/15/20)	1.0	EA	0.00
18	T5030009	Heater Control Pcb Assy	1.0	EA	0.00
19	T5030007	Potentiometer Assy	1.0	EA	24.65
20	T5030108	Heater Handle/enclosure	1.0	EA	0.00
21	T5077603	Rtd W/ Conn X 26"	1.0	EA	94.12
22	T5077902	Ground Wire W/ Term X 17"	1.0	EA	29.14
23	T5078103	15A/250V Pwr Cord W/plug&conn	1.0	EA	89.15
24	MAH00030	#10-24NCX1/4LG Rhsmss SS	1.0	EA	0.29
25	MAH00046	#10-24NCX1/2LG Shcs SS	8.0	EA	1.09
26	MAH00296	#6-32X1/4 Phil Pan Sealg Scr	1.0	EA	1.86
27	MAL00010	#6-19X3/4LG Torx T15 Pan Hdscr	4.0	EA	0.55
28	MAL00011	#6-19X1/4LG Torx T15 Pan Hdscr (Effective to 1/16/20)	2.0	EA	0.64
28	MAL00034	#6-19X1/4LG Phil Pan Hdscr	2.0	EA	0.06
29	MAL00030	#6-19X3/8LG Torx T15 Pan Hdscr (Effective to 1/16/20)	4.0	EA	0.07
29	MAL00035	#6-19X3/8LG Phil Pan Hdscr	4.0	EA	0.08
30	MAL00031	#6-19X1-1/2'LG Torx T15 Panscr	2.0	EA	0.22
31	MAN00008	#10-24NCX1LG Shcs SS	4.0	EA	0.70
32	MAN00023	#8-32NCX5/16LG Shcs SS	25.0	EA	0.40
33	MAN00036	#10-32NFX7/8LG Fhscs SS	6.0	EA	0.40
34	MBA00004	#10-24NC Hex Nut Stl PL	4.0	EA	0.35
35	MBA00067	3/8-32NEF X 0.22 X 1/4 Sealnut	1.0	EA	4.08
36	MBE00004	#10 Reg Split Lck Washer Stl PL	4.0	EA	0.10
37	MBG00072	#10 Int Tooth Lock Washer	1.0	EA	0.29
38	MDL00018	O-ring	1.0	EA	0.57
39	MDL00373	.040DIA Buna O-ring Cord Stock	2.3	FT	1.68
40	MJJ00009	1" Black Gloss Hand Grip	1.0	EA	3.59
41	MJJ00023	Control Knob	1.0	EA	4.86
42	MJK00002	2.5LG,150-650DEG F Thermometer	1.0	EA	47.64
43	MLN00219	Fiberglass Tape (per Ft)	0.66	FT	0.52
44	MQI00111	Heatsink	1.0	EA	0.00

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