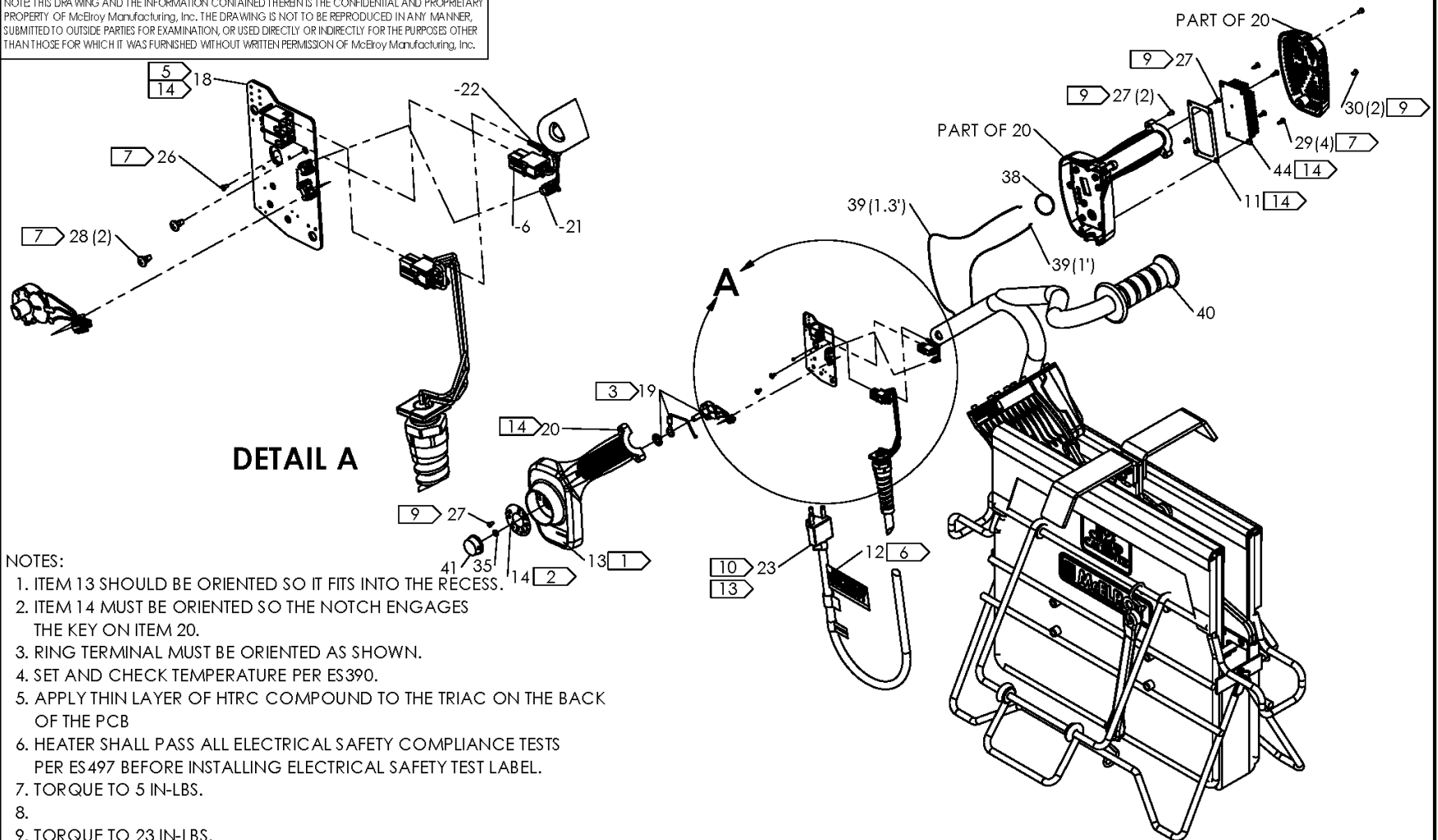


## #412 HEATER ASSEMBLY 220-240V, 50/60Hz, 1Ph

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**DETAIL A**

### NOTES:

- ITEM 13 SHOULD BE ORIENTED SO IT FITS INTO THE RECESS.
- ITEM 14 MUST BE ORIENTED SO THE NOTCH ENGAGES THE KEY ON ITEM 20.
- RING TERMINAL MUST BE ORIENTED AS SHOWN.
- SET AND CHECK TEMPERATURE PER ES390.
- APPLY THIN LAYER OF HTRC COMPOUND TO THE TRIAC ON THE BACK OF THE PCB
- HEATER SHALL PASS ALL ELECTRICAL SAFETY COMPLIANCE TESTS PER ES497 BEFORE INSTALLING ELECTRICAL SAFETY TEST LABEL.
- TORQUE TO 5 IN-LBS.
- 
- TORQUE TO 23 IN-LBS.
- THE STRAIN RELIEF OF THE POWER CORD SHOULD ALREADY BE TORQUED TO 20 IN-LBS.
- APPLY ITEM #43 TO ITEM #6 AND #21 APPROXIMATELY AS SHOWN TO PROTECT AGAINST SHARP EDGES ON ITEM #15. COMPONENT WIRES SHOULD BE TAPED SEPARATELY FROM OTHER COMPONENTS.
- ORDER T5077504 TO REPLACE THE HEATER HANDLE WELDMENT SUBASSEMBLY.
- ORDER AT5078114 TO REPLACE POWER CABLE.
- COMPONENT MUST BE ORDERED AS PART OF THE T5033401 SUBASSEMBLY



## McElroy Manufacturing Parts List

**Part Number:** 1284501 412 220-240V,50/60Hz,1Ph Heater Assembly

### Part Number 1284501 Component List

| Item | Component | Description                                          | Quantity | Unit | Price  |
|------|-----------|------------------------------------------------------|----------|------|--------|
| 1    | 1234202   | Heater Bag Assembly                                  | 1.0      | EA   | 820.00 |
| 2    | 1242103   | Right Heater Body                                    | 1.0      | EA   | 698.00 |
| 3    | 1242104   | Left Heater Body                                     | 1.0      | EA   | 698.00 |
| 4    | 1242105   | Heater O.d. Spacer                                   | 1.0      | EA   | 106.00 |
| 5    | 1242106   | Heater I.d. Spacer                                   | 1.0      | EA   | 14.03  |
| 6    | 1242202   | Mica/foil Heater Elem W/ Conn                        | 1.0      | EA   | 866.00 |
| 7    | 1808102   | Htr Gasket                                           | 1.0      | EA   | 4.92   |
| 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   | 8163393   | Model 1284501/02 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   | A1242107  | Heater Stripper Bar Kit                              | 1.0      | EA   | 184.00 |
| 17   | A1242108  | 12 Heater Butt Plate Kit                             | 1.0      | EA   | 836.00 |
| 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 2/3/20) | 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 2/3/20) | 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                               | 19.0     | 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 Splt 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)                             | 0.667    | 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.