



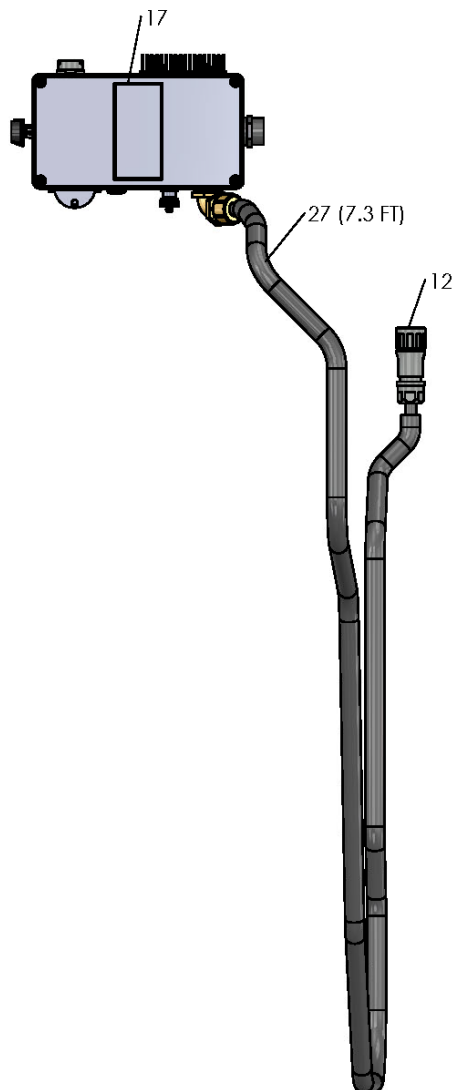
DRAWN:	PHE	CHECK:	TLJ	APPRVD:	GAR	DATE:	01/20/2025	SHT No:	1 of 6	REV No:	A	PART No:	18P1045628
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412/618 HEATER CONTROL ASSEMBLY

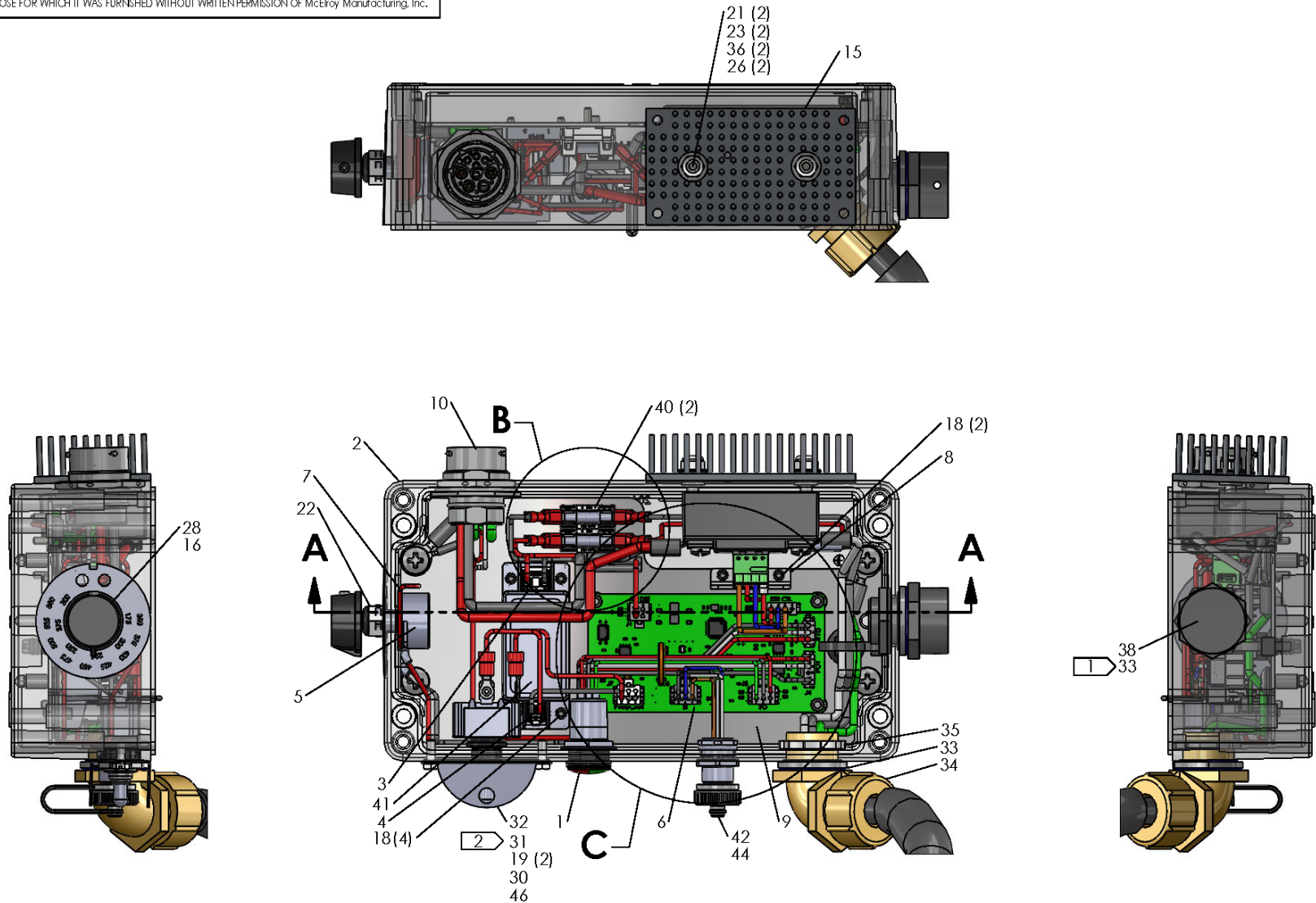
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NOTES:

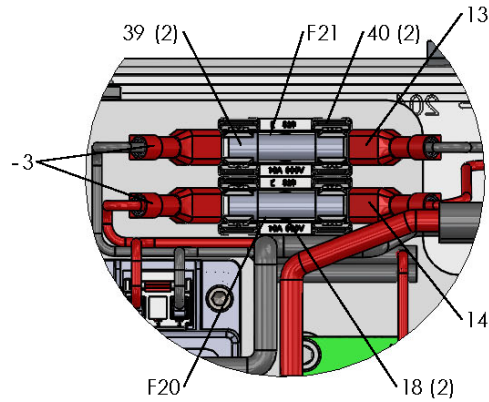
1. REMOVE EXISTING O-RING AND REPLACE WITH ITEM 33 (MLJ00004).
2. LEAVE HEX NUT ON ITEM 31 (MKEP1019187) BEFORE INSTALLING ITEM 30 (MKE00089)



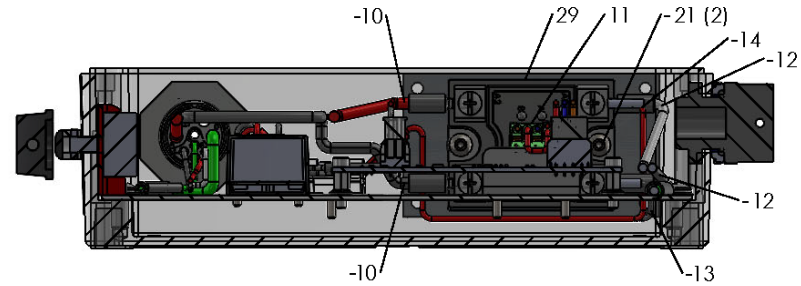
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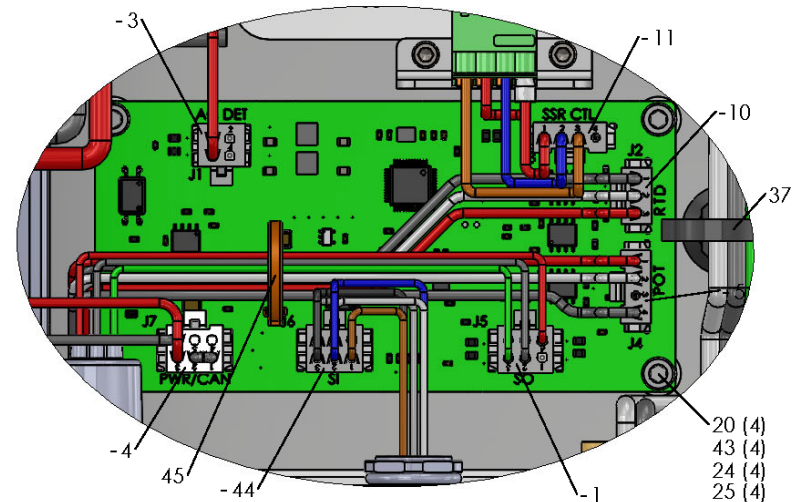


DETAIL B



SECTION A-A

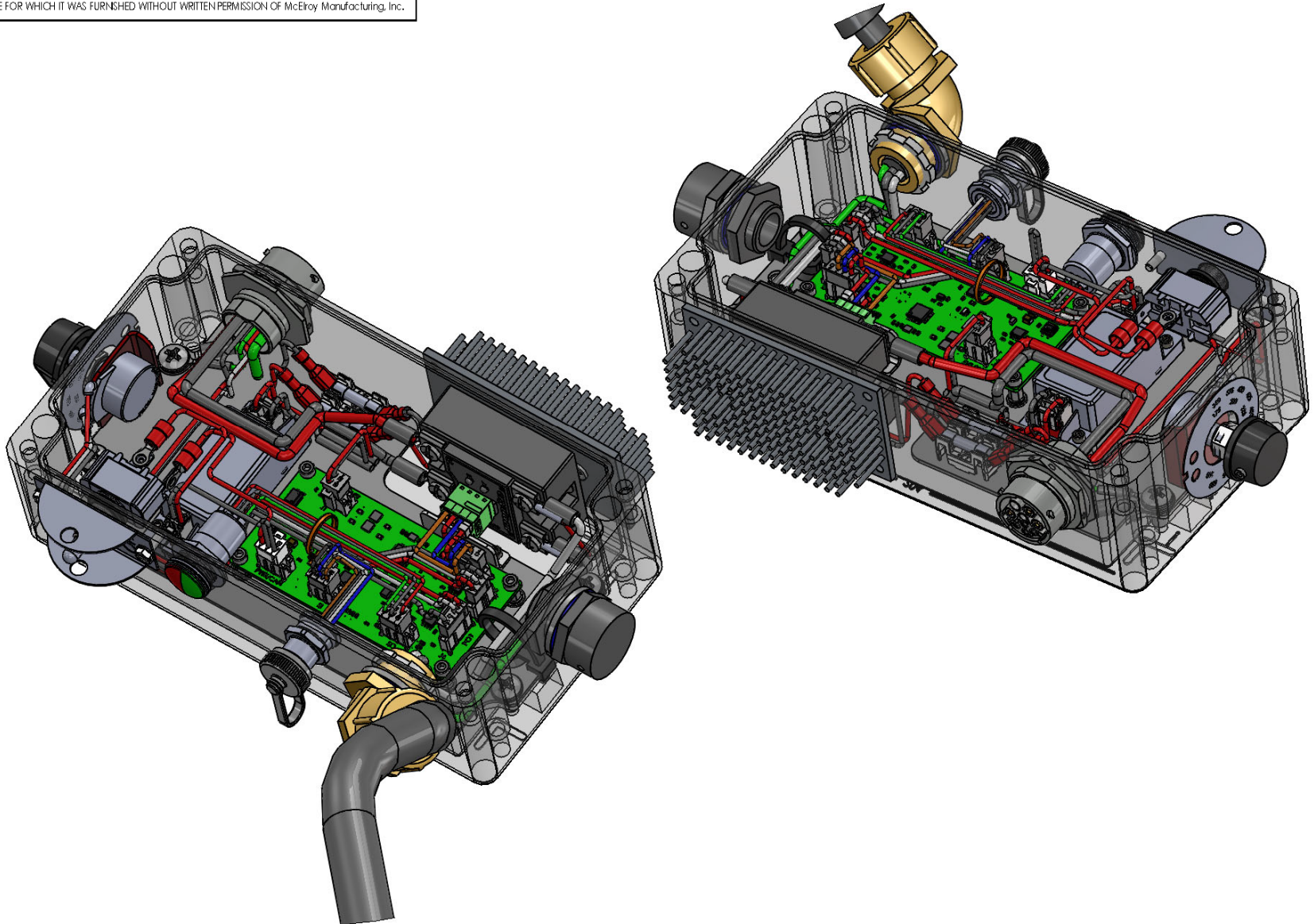
FROM	WIRE/CONNECTOR	TO
T18P1051262	BLACK	MKB00193-B2
T18P1051262	RED	MKB00193-A2
T18P1051262	MQFP0888776	T18P1017857-J2
T18P1051262	GREEN	GROUND
MLRP1020050-F20	T18P1052211	MKB00193-A1
MLRP1020050-F21	T18P1052201	MKB00193-B1
T18P1052101	WHITE	MKB00193-A2
T18P1052101	BLACK	MKB00193-B2
T18P1052101	GREEN	T18P1045625-GND
18P1052235	MQFP0888774	T18P1017857-J4
18P1051417	MLM00261	MKEP1019187
18P1051417	MQF00606	T18P1017857-J7
18P1051417	MQFP0936801	MQEP0936799
T18P1051291	MQF00719	MKB00193
T18P1051291	MQFP0888774	T18P1017857-J3
18P1021051	MQF00606	T18P1017857-J5
18P1051298	MQF00596	T18P1017857-J1
18P1051298	RED	MLRP1020050-F20
18P1051298	BLACK	MLRP1020050-F21
18P1051298	MQFP0936803	MQEP0936799
T18P1052219	MQF00606	T18P1017857-SI



DETAIL C

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FOR REFERENCE ONLY



McElroy Manufacturing Parts List

Part Number: 18P1045628 412/618 Heater Control Assembly

Part Number 18P1045628 Component List

Item	Component	Description	Quantity	Unit	Price
1	18P1021051	12V Red/green Panel Led Assy	1.0	EA	0.00
2	18P1045623	Box Mod	1.0	EA	0.00
3	18P1051298	AC Power Supply Cable Assy	1.0	EA	0.00
4	18P1051417	DC Power Supply Cable Assy	1.0	EA	0.00
5	18P1052235	Hcm Mod Potentiometer Assy	1.0	EA	152.00
6	T18P1017857	Power Control Module Pcb Assy	1.0	EA	188.00
7	T18P1019211	Potentiometer Position Plate	1.0	EA	19.18
8	T18P1019919	Brace Bracket	1.0	EA	0.00
9	T18P1045625	Electrical Panel Mod	1.0	EA	0.00
10	T18P1051262	Rtd & Ssr Cable Assy	1.0	EA	86.70
11	T18P1051291	Ssr Control Cable Assy	1.0	EA	0.00
12	T18P1052101	AC Power Cable Assy	1.0	EA	71.09
13	T18P1052201	Fuse to Ssr Black Cable Assy	1.0	EA	0.00
14	T18P1052211	Fuse to Ssr Red Cable Assy	1.0	EA	0.00
15	T560P0932496	Heatsink Mod	1.0	EA	43.87
16	816382	Temperature Scale Label	1.0	EA	7.33
17	829201	Danger High Voltage Label	1.0	EA	5.02
18	MAC00002	#4-40NCX3/8LG Shcs SS	8.0	EA	0.29
19	MAH00036	#6-32NCX3/8LG Hwh TC Scr	2.0	EA	0.29
20	MAHP1019772	#6-32NCX5/32LG Hshcs SS	4.0	EA	0.00
21	MAN00035	#8-32NCX3/4LG Bhscs SS	2.0	EA	0.23
22	MBA00070	3/8-32NEF X 0.36 X 1/4 Sealnut	1.0	EA	10.01
23	MBC00003	#8-32NC Mach Scr Nyl Lck Nut	2.0	EA	0.39
24	MBE00002	#6 Reg Splt Lck Washer Stl PL	4.0	EA	0.11
25	MBF00038	#6 Typ 'a' Wide FL Washer SS	4.0	EA	0.07
26	MDLP1018976	1/4IDX1/16 WD High Temp O-ring	2.0	EA	0.00
27	MFL00060	.79" ID Hose Sleeve	7.3	FT	4.21
28	MJJ00023	Control Knob	1.0	EA	5.24
29	MKB00193	Dual 25A Solid State Relay	1.0	EA	212.00
30	MKE00089	Switch Seal Ring	1.0	EA	11.08
31	MKEP1019187	Spst On-off Toggle Switch	1.0	EA	0.00
32	MLG00001	Switch Guard	1.0	EA	2.63
33	MLJ00004	1/2 Seal Ring	2.0	EA	5.24
34	MLK00020	1/2 X 90DEG Strain Relief Conn	1.0	EA	47.58
35	MLN00100	1/2" Conduit Lock Nut	1.0	EA	1.03
36	MLN00205	#8 X 1/2OD Seal Washer	2.0	EA	0.00
37	MLNP0867934	8" Black Cable Tie & Fir Tree	1.0	EA	0.00
38	MLNP1019942	Nema 4X1/2NPT Nylon Breather/ (Effective to 3/23/26)	1.0	EA	0.00
39	MLQ00126	1A Normal Blow 5X20 Fuse	2.0	EA	1.14
40	MLRP1020050	10A 5X20 Single Fuse Holder	2.0	EA	4.78
41	MQEP0936799	Power Supply	1.0	EA	0.00
42	MQFP1007322	M12 Socket Cap	1.0	EA	7.48
43	MQIP1019749	#6-32X1/4 M/f 3/16HEX Standoff	4.0	EA	0.00
44	T18P1023629	Hcm M12 Cable Assy	1.0	EA	58.71
45	MLN00113	5.5" X .095" Cable Tie	1.0	EA	0.17
46	MLH00001	Switch Boot	1.0	EA	5.67

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