



FLANGED ELEMENT REPLACEMENT INSTRUCTIONS

Kit items include:
Heater Element
Fiber Gasket
O-ring

Tools required:
9/16", 5/8" Sockets
Socket Wrench
Rags

ATTENTION! This product should be installed by a qualified electrician or pool/spa technician. If you're not qualified or do not have the technical skill to install this product correctly **STOP!** and contact your local spa repair professional.

WARNING! Damaging product by altering, bending, drilling, removing plug, subjecting to chemical corrosion or wet /dry fire will void product warranty.

STEPS FOR A SUCCESSFUL INSTALLATION

- 1.** Read through this complete instruction first before performing work.
- 2.** Inspect for shipping/handeling damage. **Do Not** install a product that appears to be damaged.
- 3.** Use the product data label and Element Replacement Chart to confirm your new element is the correct replacement part. Use diagrams 1,2 and 3 for help with physical identification.

WARNING! Do not attempt to install the wrong part. Stop and contact your product supplier if your replacement element has the wrong part number, flange size or plug type.

ELEMENT REPLACEMENT CHART

Flange	Element model	Replacement P/N	Kilowatts	Amps / Volts	Plug Type
4-bolt	25-1464-430AC	12-1464-AC-K	1.5kW	12.5/120V	NEMA 5-15
4-bolt	25-1464-430BC	12-1464-BC-K	1.5kW	12.5/120V	BC Molded
2-bolt	25-1463-430AC	12-1463-AC-K	2.5kW	10.4/240V	NEMA 6-15P
2-bolt	25-1463-430BC	12-1463-BC-K	2.5kW	10.4/240V	BC Molded

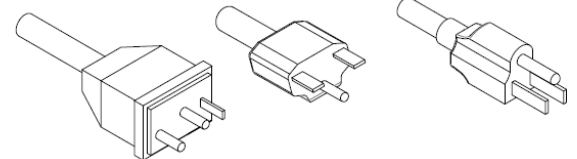
DIA#1

Plug Types

"BC" MOLDED

NEMA 6-15P

NEMA 5-15



- 4.** Turn the thermostat to the "OFF" position on the spa control
- 5.** Shut power OFF at spa breaker and unplug element from the pack
- 6.** Drain spa water or isolate the heater tubing so the spa water will not drain out.
- 7.** Remove bad element and note which direction the looped end is positioned (REF. DIA #2).

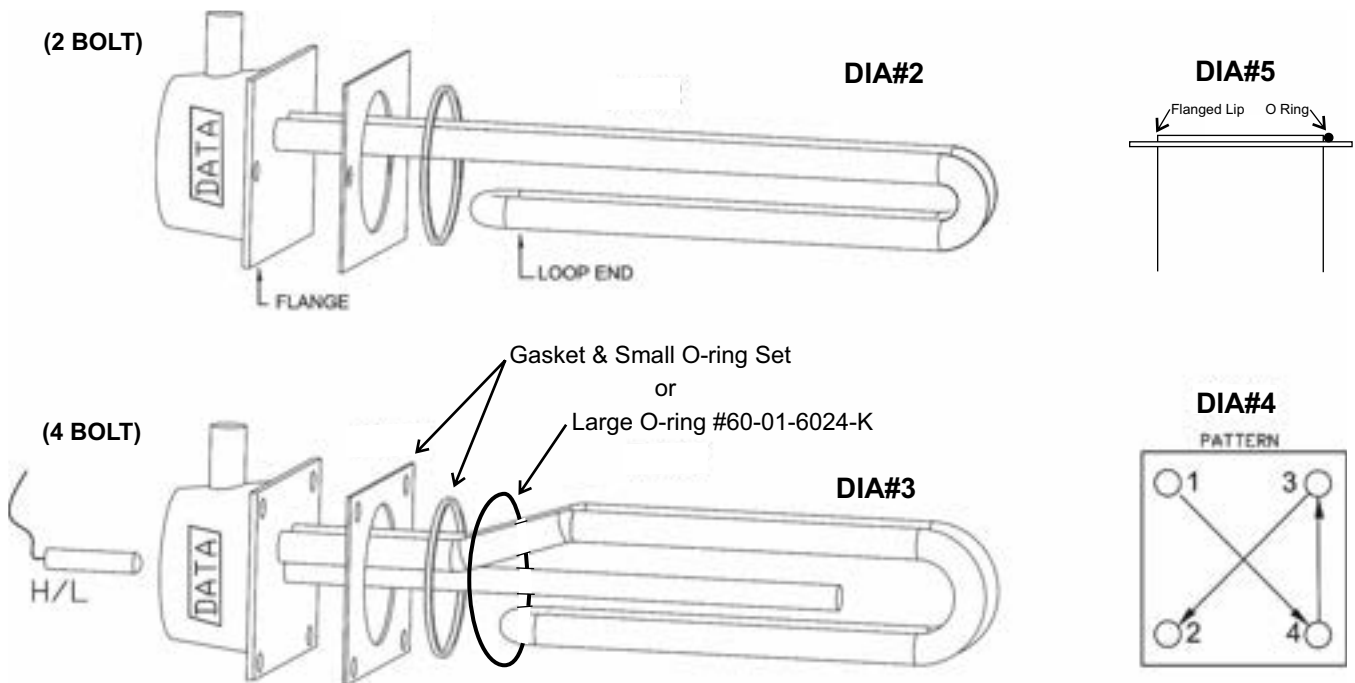
8. Clean heater housing surface, nuts, washers and bolt threads to be reused.
9. Place gasket and O-ring onto flange, and install element into housing placing the “looped end” in the same position as removed in step #6 (Note that gasket sealer is optional).
10. Tighten nuts so the gasket/O-ring are compressed to housing

➔ **Important for 4-bolt elements only**

- 10-a. Use the O-ring marked #60-01-6024-K for installations on housings with 3” flanged lip (DIA#5)
- 10-b. Tightened nuts in a harmonic pattern to place even pressure on flange (Ref. DIA #4)
- 10-c. Re-install the High Limit sensor (H/L) as far down the drywell as possible (Ref. DIA #3)

11. Plug element(s) into the pack electrical receptical.
12. When the installation is complete, water refilled, thermostat turned off and the breaker is turned on, run the pump and inspect for water leaks around the flange.

▲ WARNING! Never allow the element/heater to operate without water flow



WARRANTY GUIDELINES

▲ WARNING! Never allow the element/heater to operate without water flow

All warranty claims and product returns must be handled through your element provider (no exceptions) Product returns determined to have shipping or installation damaged, alteration, signs of chemical corrosion, evidence of wet/dry fire or abuse, will not be considered for warranty.