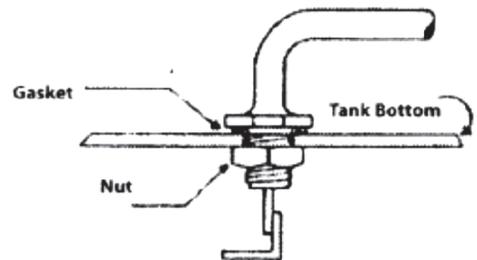
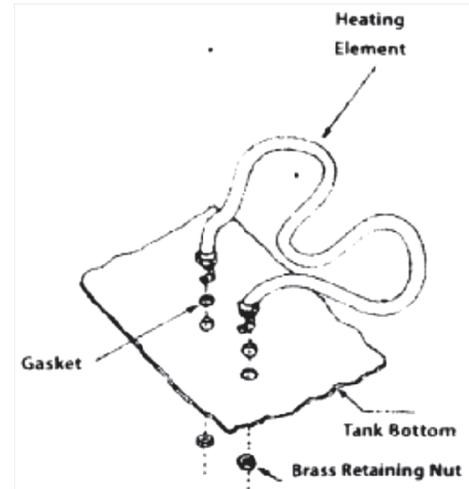


## Hydrocollator Heating Element Installation

**Note: Be sure the unit is disconnected from the power supply before proceeding with any installation.**

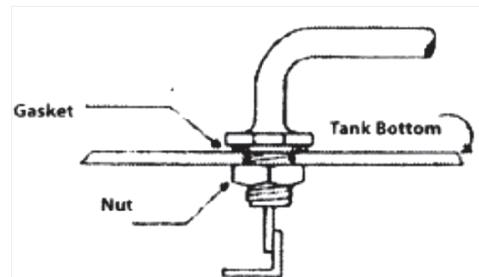
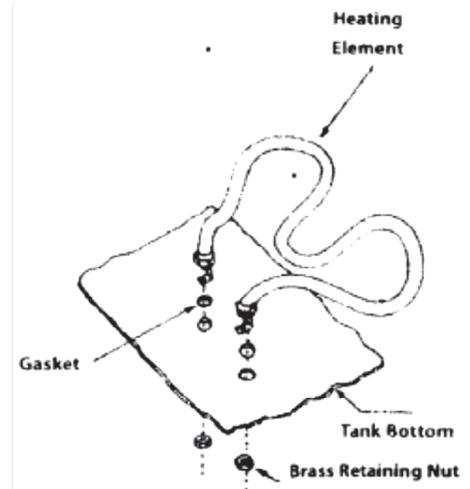
### Heating Element Installation (Models E-1, E-2, and SS):

1. Unplug the unit from the power supply and empty water from the tank.
2. Remove the junction box cover from the base of the unit. Lower the rear of the junction box and pull towards the back of the unit.
3. Note the positions of wiring and electrical components.
4. Disconnect the two wire leads from the heating element.
5. Loosen and remove the brass retaining nuts on the element, and remove old element from the unit.
6. Insert the new element through the holes of the tank bottom, and make certain that the round rubber gaskets are under the shoulders of the brass bushings of the element - on the inside of the tank.
7. On the underside of the tank, thread the two brass retaining nuts on the element threads and tighten just until the rubber gasket forms a watertight seal.  
NOTE: Avoid excessive tightening as it would strip the brass threads and could damage the rubber gasket.
8. Connect the proper leads to the terminals of the element. Make sure that all terminal screws are tightened.
9. Replace the junction box cover.
10. Attach the thermostat bulb clamp to the element.



### Heating Element Installation (Models M-2, and SS-2):

1. Unplug the unit from the power supply and empty water from the tank.
2. Remove the junction box cover from the bottom of the unit by taking out screws at the base of the unit's back panel.
3. Remove the thermostat bulb clamp from the element.
4. Disconnect the two wire leads from the heating element.
5. Loosen and remove the brass retaining nuts on the element, and remove old element from the unit.
6. Insert the new element through the holes of the tank bottom, and make certain that the round rubber gaskets are under the shoulders of the brass bushings of the element - on the inside of the tank.
7. On the underside of the tank, thread the two brass retaining nuts on the element threads and tighten just until the rubber gasket forms a watertight seal.  
NOTE: Avoid excessive tightening as it would strip the brass threads and could damage the rubber gasket.
8. Connect the proper leads to the terminals of the element. Make sure that all terminal screws are tightened.
9. Replace the junction box cover.
10. Check the alignment of the thermostat's adjusting stem with the hole in the rear of the unit.



### Heating Element Installation (Models M-4):

1. Unplug the unit from the power supply and empty water from the tank.
2. Remove junction box cover from bottom of unit.
3. Note positions of wiring and electrical components.
4. Remove the thermostat bulb and overtemperature/low - water sensor from the old element by loosening the screws in the holding clamps.
5. Remove old heating element.
6. Pull red rubber gasket (2) over the threads on bulkhead (1). Make sure rubber gasket is pulled up past the threaded area.
7. Remove the element support brackets from the old element and reattach them to longest length of new heating element.
8. Next, place element with gasket through the tank wall (3), as shown in diagram.
9. Re-attach thermostat bulb, heating element bracket, and overtemperature/low – water sensor. Secure by tightening screws (inside tank).
10. Next, install nut (4) on threaded bulkhead and snug up to tank wall until finger tight. With a wrench, tighten about 3/4 to full turn, or just until the gasket forms a watertight seal. Do not over tighten. Over tightening could result in damage to the rubber gasket or threads.
11. Fill tank with water and check for leaks. If heater is not leaking, re-install heater leads.
12. Re-install junction box (or junction box cover). Secure all electrical connections and resume normal operations.

