



# **Watlow Heating Element Replacement**

## **Steam'N'Hold**

**S/N 21218 thru 29030**

**12KW and Lower**

# **CAUTION – IMPORTANT NOTES**

- All required studs must be in place to avoid failure of the heating element.
- The bottom must be flat on the horizontal and vertical planes so the heating system can transfer heat properly, to avoid nuisance over-temp trips and to avoid early failure of the heating element.
- A capacitive discharge welder similar to the "Nelson NCD 100" must be used to weld any replacement 1/4-20 stainless steel studs to the bottom of the steamer.
- All replacement studs must be located in the exact location as the old studs.
- The bottom of the steamer must be free of any debris including old anti-seize, welding debris and other foreign material.
- Silver Grade Anti-Seize such as "Loctite Silver Grade", AccuTemp P/N ATR-ANTSZ must be used where noted to avoid friction induced failure of the heating element.
- An inch pound torque wrench is required to assure that the fasteners for the heating system are tightened to 45 inch pounds.

# Instructions

1. Before proceeding in replacing the heater verify that all ¼-20 stainless steel studs are in place and that the 2 10-24 studs for the over-temp thermostat are in place. If not contact Accutemp Products, Inc. 800.480.0415 for further instructions.
2. After the heating assembly is removed make sure to remove the Isolation Plate and check the bottom for flatness in the horizontal and vertical planes. If not contact Accutemp Products, Inc.
3. Clean the bottom of the steamer of all anti-seize and any other foreign material. This area must be totally clean.
4. Clean the isolator plate . It must be totally clean of all old anti-seize and foreign material.
5. Apply a good even coat of silver grade anti-seize – P/N ATR-ANTSZ to the side that is in contact with the steamer bottom and install.
6. Apply a even coat of silver grade anti-seize to both sides of the heating element making covering the complete metal sheeth of the heating element.
7. Install the Fire Bar heating element to the steamer making sure to evenly space away from the studs.
8. Clean all anti-seize and grind down any areas that are not total flat on the mounting brackets. Install as shown making sure to center as much as possible.
9. Install the Belleville washers
10. Install the washers
11. Install the center locking nuts and hand tighten.
12. Center the Belleville washer and washer on the bracket opening and tighten each nut to 45 inch lbs. Once all are tightened check each nut to 45 inch lbs.
13. Install the insulation strips
14. Complete the assembly of the bottom.
15. Complete the wiring of the heater at the terminal strip.

# WATLOW FIREBAR HEATING SYSTEM ASSEMBLY

