**ELECTRIC HEAT INSTALLATION PROCEDURE**

**CAUTION:**
Turn the unit off, disconnect the battery & allow sufficient time for the engine & its fluids to cool before proceeding.

**NOTE:** It is extremely important that the unit remain disabled throughout this procedure.

1. Remove hardware located on each side.
2. Remove hardware.
3. Remove Prestige and banding clamps.

(Continued on next sheet)

---

**SEE SEPARATE PARTS LIST**
HEATER MOUNTING

2.) LOOSELY ASSEMBLE THE HEATERS (IT.40) TO THE HEATER BRACKET ASSEMBLY (IT.115) WITH HARDWARE SHOWN. NOTE: THE SMALLER WASHERS (IT.60) SHOULD BE USED TO MOUNT THE HEATERS.

3.) LOOSELY INSTALL THE ASSEMBLY INTO THE EVAPORATOR WRAPPER MAKING CERTAIN EACH BRACKET ALIGNS CORRECTLY WITH THE EVAPORATOR WRAPPER MOUNTING HOLES.

4.) TIGHTEN ALL HARDWARE. IT MAY BE NECESSARY TO REMOVE THE ASSEMBLY IN ORDER TO TIGHTEN THE BOLTS THAT SECURE THE HEATERS. REINSTALL ASSEMBLY.

5.) MOUNT THE SUPPLY AIR SENSOR (IT.239) AND THE HIGH TEMPERATURE SAFETY HTS (IT.220) TO THE EVAPORATOR WRAPPER AS SHOWN IN "FIGURE A".

6.) REMOVE THE JUNCTION BOX (IT.120) COVER & LOCATE THE BOX INSIDE THE BULKHEAD AS SHOWN IN "FIGURE B".

7.) MARK THE POSITION OF THE MOUNTING HOLES. USING A .199 (5.08 mm) DRILL BIT, DRILL THE TWO HOLES FOR THE BOX & THE ONE HOLE FOR THE CLAMP.

8.) MOUNT THE JUNCTION BOX & CLAMP (SEE "FIGURE A").

(CONTINUED ON NEXT SHEET)

FIGURE A

FIGURE B

DRILL 3 HOLES (SEE STEPS 6 & 7)
9.) Use the wire assembly supplied (marked 2HT1) to connect the HTs. Use butt splices (IT1, 2IT) to make the connections.

10.) Plug the SAS into the existing harness connector.

11.) Separate the heater wires into pairs of each heater rod, tape each pair together.

12.) Route the heater wires along with the HT wires through the split tubing (IT.95) and through the coil as shown. Route the wires to the “Junction Box”.

13.) Remove the flag terminals located on the HTs (2HT1) wires.

14.) Trim all wires to the appropriate lengths to make connections inside of the junction box, trim 1/4” off of each wire & make connections as shown in the “Junction Box Diagram”.

15.) Route the harness shown through the evaporator bulkhead. Add caulking around the opening to prevent air leaks.

16.) Add ty-wraps (IT.75) as required to support loose harnesses.

17.) Reinstall drain-pan using previously removed hardware & new prefitite (IT.B).

(Continued on next sheet)
18.) ROUTE THE WIRES THROUGH THE BOTTOM OF THE UNIT DOWN THE FRONT OF THE TRUCK BODY.

19.) REFER TO "HEATER BOX INSTALL" FOR MOUNTING THE "HEATER CONTROL BOX (IT.10)".

20.) ROUTE THE HARNESS FROM THE EVAPORATOR JUNCTION BOX TO THE "HEATER CONTROL BOX". ROUTE THE HEATER CONTROL BOX HARNESS TO THE "MAIN CONTROL BOX".

21.) SECURE THE HARNESS TO THE TRUCK WALL WITH CLAMPS (IT.43) & HARDWARE (IT.53).

(continued on next sheet)
22.) SECURE THE HARNESS CONNECTOR TO THE "HEATER CONTROL BOX".

23.) INSTALL THE GROUND WIRE "GRO" TO THE GROUND STUD. STRIP 1/4" OF INSULATION FROM EACH WIRE AND MAKE REQUIRED CONNECTIONS.

**ASSEMBLY NOTE:** MAKE SURE THAT EACH PAIR OF HEATER WIRES ARE INSTALLED CORRECTLY.


24.) SECURE THE HARNESS CONNECTOR TO THE "MAIN CONTROL BOX".

25.) INSTALL THE GROUND WIRE "GRO" TO THE GROUND STUD.

26.) FIND THE CONNECTOR WITH WIRES MARKED "PHC" INSIDE THE LOWER PORTION OF THE "MAIN CONTROL BOX" AND PLUG IN THE CONNECTOR.

27.) INSTALL THE RED WIRES MARKED L1, L2 & L3 INTO THE OVERLOAD AS SHOWN.

28.) FIND THE CONNECTOR WITH WIRES MARKED "EH1" INSIDE THE UPPER PORTION OF THE CONTROL BOX AND INSTALL THE RELAY (T1/B).

29.) RECONNECT THE UNIT BATTERY AND RUN-TEST THE UNIT CHECKING FOR PROPER OPERATION.

30.) REINSTALL ALL CONTROL BOX DOORS/PANELS.