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40 WATT CARTRIDGE HEATERS IMS #165818

**To fit (#109470) 7½" and (#109466) 8¼"
HEATED GATE CUTTERS**

**SOLD IN PAIRS WITH PLUG AND 6'
CONTAMINATION-RESISTANT LEADS
COATED WITH PTFE**

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ASSEMBLY

REMOVE EXISTING CARTRIDGE HEATER

Unplug controller.

Disconnect wires from controller.

Remove tape securing wires to handles.

Remove top retaining clip on each heater.

Slide heaters off blades.

Remove bottom retainer clip on each heater.

Slide heaters through handle cushions.

DANGER

Contact with ELECTRIC POWER will cause DEATH OR SHOCK.

Make sure cutters are grounded through controller.

Unplug controller to service cutters.

Do not allow wires to rub against each other or against other parts of cutter.

INSTALL NEW CARTRIDGE HEATERS.

Make sure controller is unplugged and old heater wires are removed.

Remove retainer clips from heaters

Slide heaters through handle cushions. You might need to work the wire channel a little with your fingers to open it up for the heaters. NEVER PULL heaters. Continue to PUSH leads to get them through wire channels.

Slide heaters into blades as shown in Figure on the next page.

Install bottom retainer clip on each heater. This is easiest if you slide clip over open end of heater first.

Apply heat transfer compound to heaters. IMS Infra-Kote (#107264 – 2 oz or #103781 – 16 oz) works well.

Slide heaters into blades as shown in Figure on the next page.

Install top retaining clip on each heater.

Tape wires to handle. Leave a little slack in wires. Leave a small gap between wires to keep them from rubbing against each other.

With controller unplugged, connect wires to controller.

ASSEMBLY (continued)

