

# SERVICE INSTRUCTIONS FOR HEATER KIT – WE11M60

Kit WE11M60 replaces WE11M4 (WE11M1)  
WE11M3 (WE11M2)

Kit contains: 2 Heater Coil WE00M115  
3 Studs WE2X136  
7 Washers WE2X279  
3 Nuts WE2X278

## To Replace a Heater Coil:

1. Cut both ends of defective coil at the terminals (Fig. 1).
2. Cut the end of the good coil at the common terminal only.
3. Remove the two terminals from which the heater coils were cut and replace with the two new terminals from Heater Kit.
4. Stretch the replacement coil to the proper free length; also cut ends of coil to the dimension ('A') Fig. 4, and as follows:

	Prestretch Length	Free Length After Prestretching	Dimension 'A'
Outer Coil	63"	40"	1"
Inner Coil	56"	35"	2-1/2"

Stretch the heater coil to the "prestretch" dimension shown. This should be done in one operation to the whole coil length. Do not stretch the coil in a series of stretches on short lengths of the coil; this would cause uneven stretching.

When the coil is released from its "prestretch" length, it should return to within 1" of the indicated "free length".

5. Inspect the stretched coil. Each turn of the coil should not touch the turn next to it.
6. Remove the inoperative heater coil from the heater assembly and thread the replacement coil through the insulators, making sure that the coil is evenly spaced to prevent hot spots.
7. Form hooks with the ends of the coil and complete the terminal assembly as shown in Fig. 2. The hook-up for 3-terminal and 2-terminal machines is shown in Fig. 3.

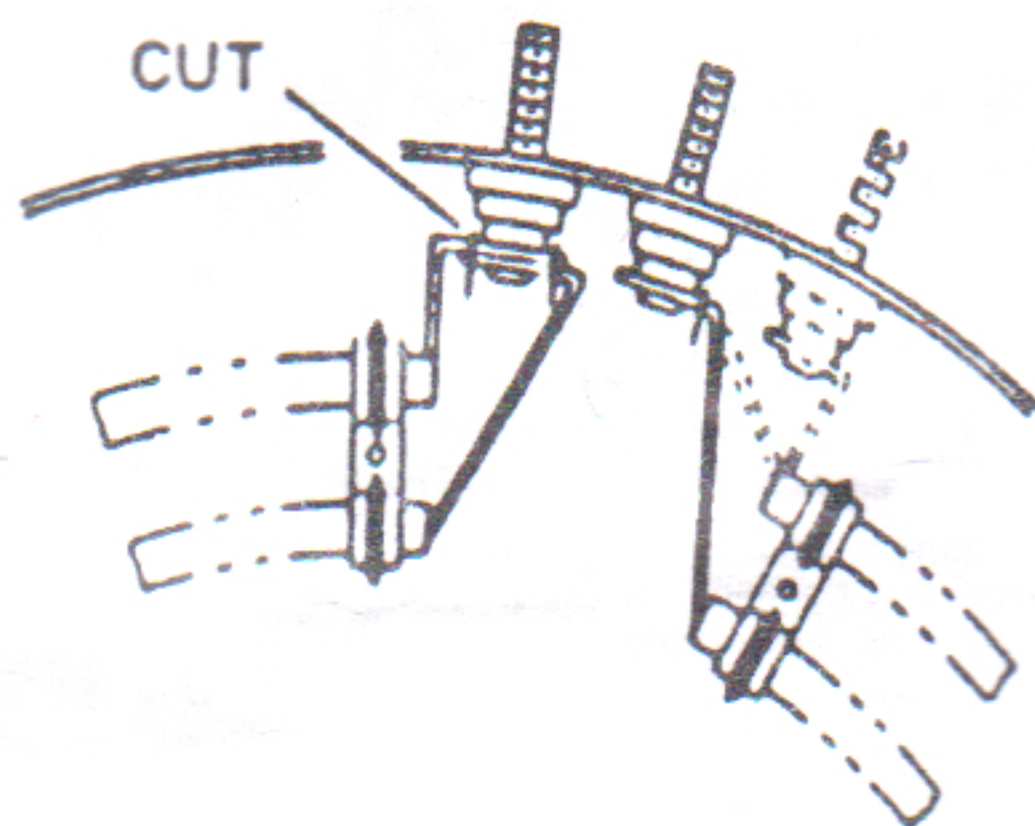
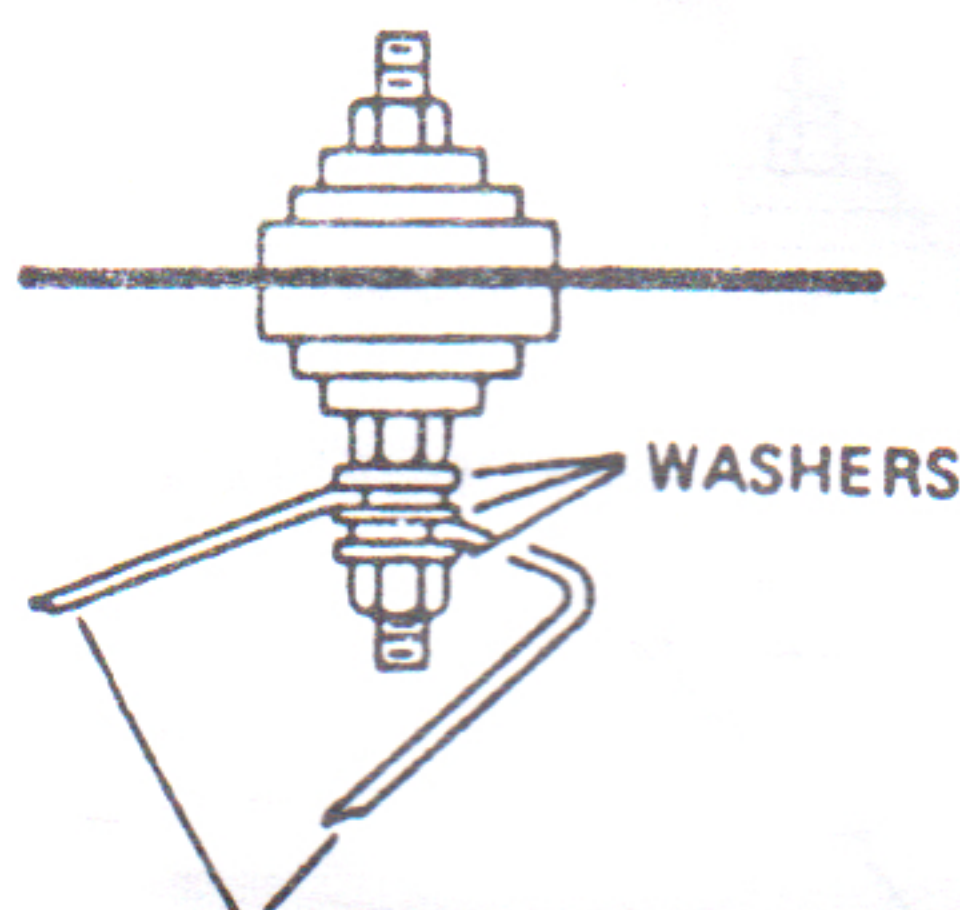


FIGURE 1



HEATER COIL ENDS  
FIGURE 2

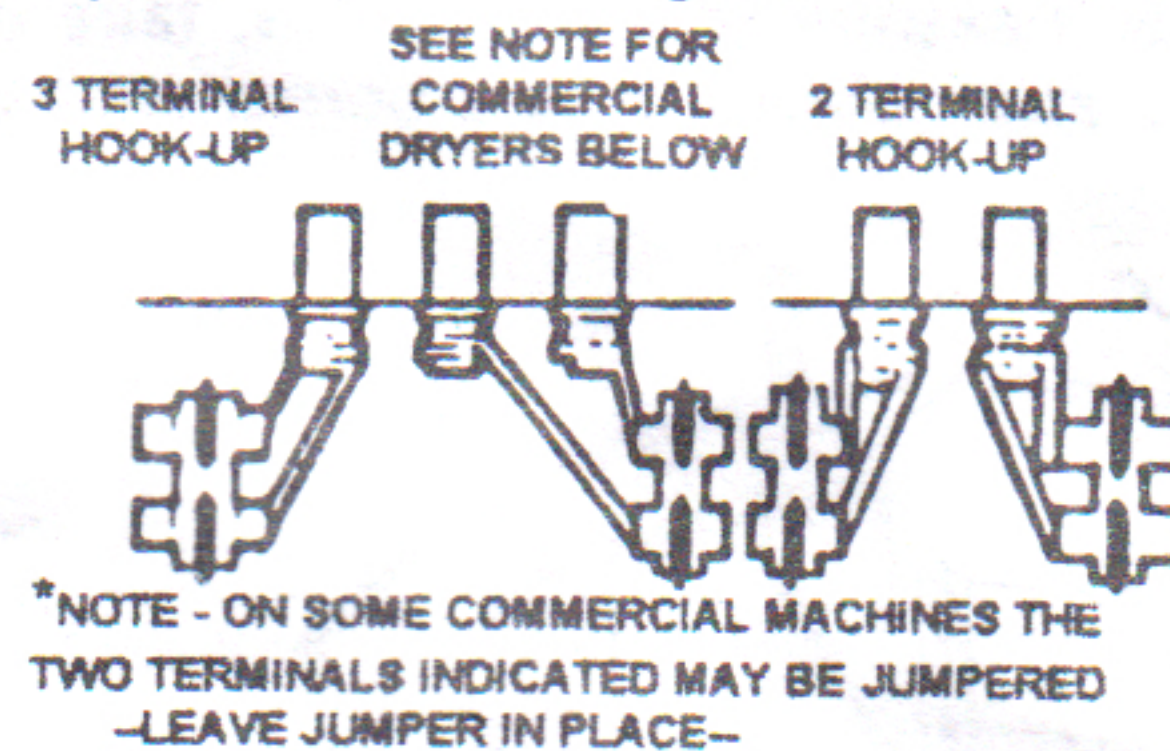


FIGURE 3

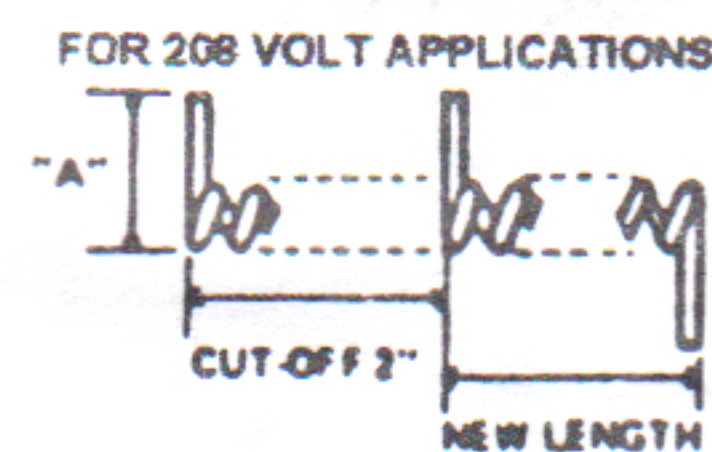


FIGURE 4

The heater as supplied, is for 230V operation. If the heater is to be used for 208V operation (WE11M1 and WE11M4), it will be necessary to modify the unstretched coil as follows:

- A. Cut 2" from the end of each coil as indicated in Fig. 4.
- B. Straighten the cut end as shown. Bend to dimension "A" given above.