

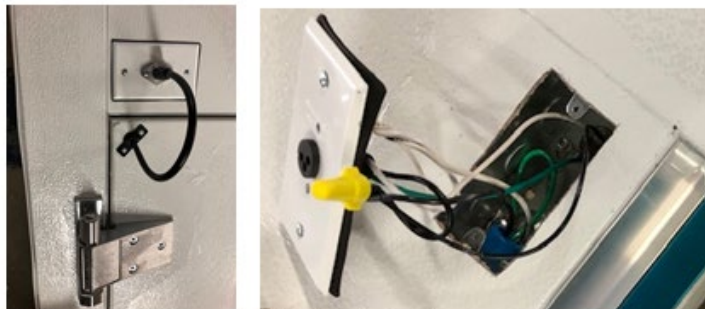
DOOR HEATER REPLACEMENT

1. The door heater is connected to the j-box at the upper corner of the door's hinged side. **TURN POWER OFF AT THE SOURCE!**

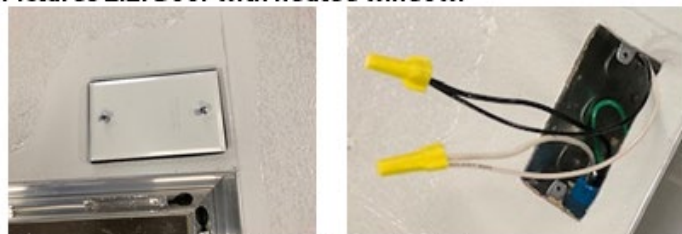


Picture 1.1. Arctic West Door; see location of the j-box where the heater cable is connected.

2. Remove threshold and disconnect heater wire leads (See pics with types of thresholds).



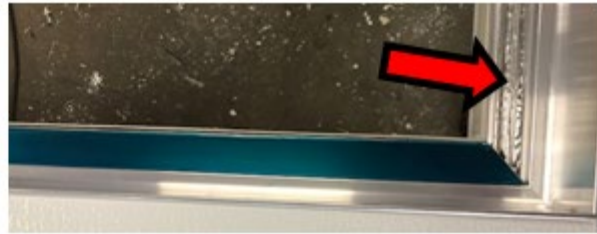
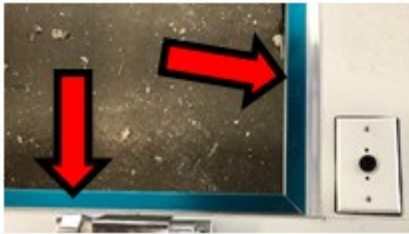
Pictures 2.1. Door with heated window.



Pictures 2.2. Door without heated window.

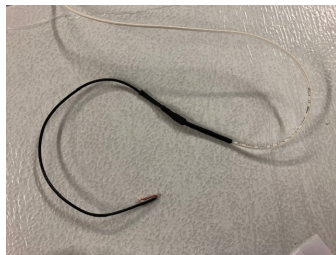
DOOR HEATER REPLACEMENT

- Using a thin-blade screwdriver apply pressure (not leverage) to the door frame extrusion. Pull the stainless steel snap-on cover with your hand. Always start at the end as indicated and continue the operation described above until the entire cover is removed.



Pictures 3.1. Remove ss snap-on. Right picture is already removed on the arrow.

- Remove defective heater wire.



- Install replacement heater wire. Tack with permagum sparingly in order to hold wire in its place



Picture 5.1. Heater wire routed all over the frame of the door, this picture shows the down step part of the frame.

DOOR HEATER REPLACEMENT

- o When laying wire groves or channels around door perimeters, sharp edges and corners must be avoided so that the wire is not cut or abraded. Fiberglass or aluminum braid over the wire is available as protection from such surface abrasion. Metal or plastic channels can be used, and grooves that are cut into wooden door frames should be lined with aluminum tape to prevent abrasion and also to reflect heat outward toward the surface being heater.
 - o If multiple passes of wire are used, it is important to keep them space $\frac{1}{4}$ " apart and not allow any contact. If the wire should cross itself, the effective wattage at that point is doubled and a hotspot or burnout could occur.
 - o If the wire exits through the wall of the cooler or freezer unit, care must be taken to ensure that it does not become buried or encapsulated in foam or other type of insulation, this causes poor heat transfer and overheating which could result in failure.
 - o It is important that heater wire be installed with a small amount of slack at the corners of the frame. When the wire is energized, it will move slightly. This "creeping" motion can cause abrasion if the wire is installed too tightly and is under tension in the channel.
6. Reinforce with aluminum foil tape (two wraps) at four corners.
 7. "Snake" heater wire at threshold taking extra care not to overlap wire, or allow wire to touch itself. Tack down with permagum and foil tape.



Picture 7.1. How to "snake" heater wire. Very important to keep space between routed wire $\frac{1}{4}$ " apart as minimum and not allow any contact. |