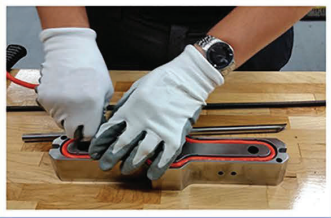


# Nextflex® Heater Installation

## Measurement Prep (These steps can be skipped if you already have the center of the manifold groove marked.)



### Measurement 1

Press a cord into the manifold groove (a 16-2 extension cord works well).



### Measurement 2

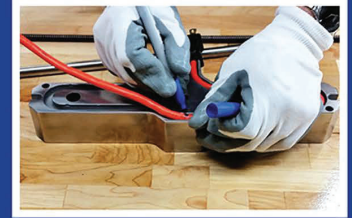
Mark the location of the groove starting and ending points on the cord.

**Note:** Because the heater length will grow during installation, consult the expansion chart on page 2 to ensure proper heater selection.



### Measurement 3

Measure the length between the two marks and make a third mark at the center point.



### Measurement 4

Press the cord back in the groove, starting with one groove end line at the end of the manifold groove. Install to the center point of the groove and mark the center point on the manifold. You are now ready to install the Nextflex.

## Installation Instructions



### Step 1

Starting at the center of the groove, bend the Nextflex heater at the center mark consistent with the direction of the groove.



### Step 2

Hold the Nextflex heater directly above the groove at the point of installation. Strike the Nextflex heater hard to seat it well. Form and install in short lengths to prevent rebending. Always start by installing the heater at the center mark at the center location of the groove.



### Step 3

It is important to make sure the Nextflex heater is directly above the groove prior to striking. Form and install in 1 to 2 inch sections (25 to 50 mm).

**NOTE:** Heater is flexible due to annealing. Multiple bends in the same location "work harden" the heater. For best results, form the heater as precisely as possible prior to installing in the groove.



### Step 4

Keeping the heater flat and forming it with your free hand, bend bends so that it is directly above the groove.

**IMPORTANT:** Make sure the straight section of the groove is fully installed prior to forming your bend.



### Step 5

One strong strike is more effective than two soft strikes. If your groove dimensions are correct, you will not damage the internal heater.



### Step 6

The Nextflex staking tool is a key component in seating the heater properly. This improves heat transfer and maximizes heater life. Strike hard to stake every 3/4 inch  $\approx$  20 mm.