



**SUSSMAN**  
ELECTRIC BOILERS

*MBA Electric  
Steam Generator*

*Installation, Operation and Maintenance Manual*

Model No. \_\_\_\_\_ Power Circuit Voltage \_\_\_\_\_

Generator Serial No. \_\_\_\_\_ Control Circuit Voltage \_\_\_\_\_

National Board No. \_\_\_\_\_ Amps \_\_\_\_\_ Phase \_\_\_\_\_ Cy \_\_\_\_\_

**IMPORTANT:** This data file contains the National Board Registration Certificate approving your generator. It must be kept near the generator at all times.

**Products Covered by this Manual**

Model	KW Range	Steam Rate	BHP	Design Pressure	Max. Work Pressure*
MBA3	3	9 lbs./hr	0.3	100 PSIG	85 PSIG
MBA6	6	18 lbs./hr	0.6	100 PSIG	85 PSIG
MBA9	9	27 lbs./hr	0.9	100 PSIG	85 PSIG
MBA12	12	36 lbs./hr	1.2	100 PSIG	85 PSIG
MBA18	18	54 lbs./hr	1.8	100 PSIG	85 PSIG
MBA20	20	60 lbs./hr	2.0	100 PSIG	85 PSIG

\*Line water pressure must be a minimum of 10 PSIG higher than generator operating pressure or you will require high pressure water feed w/motor and pump.



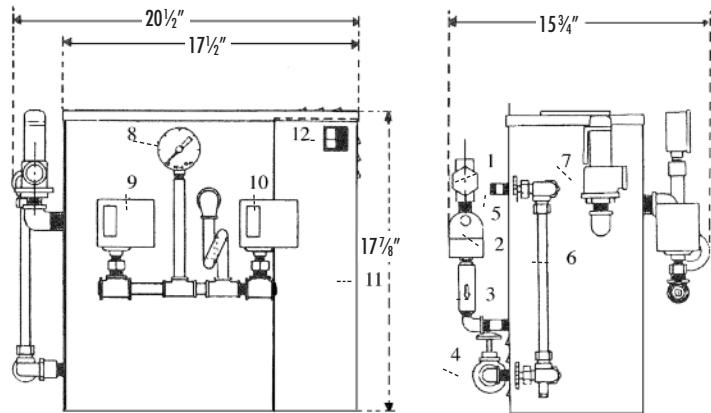
**SUSSMAN**  
ELECTRIC BOILERS

A Division of Sussman-Automatic Corporation  
43-20 34th Street, Long Island City, NY 11101 • 718-937-4500 • 1-800-238-3535  
Fax: 718-937-4676 • www.sussmanboilers.com • Email: seb@sussmancorp.com

## Standard Features

- LIQUID LEVEL / LWCO CONTROLLER**  
 The electronic controller automatically maintains proper water level, and shuts off the generator when water supply in the boiler drops below a safe operating level.
- WATER LEVEL SIGHT GLASS**  
 Allows constant observation of water level while boiler is in operation.
- ON-OFF SWITCH**  
 Complete with pilot light, for switching on the generator.
- INTEGRAL ELECTRICAL CONTROL**  
 Magnetic contactor energizes the element and is integrally mounted in the control unit.
- BLOWDOWN/DRAIN VALVE**  
 Facilitates emptying the pressure vessel during blowdown/drain sequence.
- J-BOX** for motor/pump connection.
- LONG LIFE HEATING ELEMENTS**  
 Industrial grade, heavy duty stainless steel heating elements equipped with one piece resistance welded terminations for added strength and safety.
- OPERATING PRESSURE CONTROL**  
 Operates automatically to maintain steam pressure within generator.
- MANUAL RESET PRESSURE CONTROL**  
 Provides high limit pressure cut-out with manual reset.
- STEAM SAFETY VALVE**  
 ASME Code valve, automatically opens to reduce pressure should excessive steam cause pressure build-up.
- STEAM PRESSURE GAUGE**  
 Allows visual observation of steam pressure over full range.
- ENERGY SAVING AND MINIMUM MAINTENANCE**  
 Fully insulated pressure vessel minimizes heat loss and maximizes energy savings.
- EASY CONTROL MAINTENANCE**  
 All controls and components are easily accessible. Fully-louvered openings avoid component heat build-up.
- RUGGED CONSTRUCTION**  
 Performance is insured for all typical industrial applications.

## Component Identification Dimensional Information



Symbol	Description
1	Strainer
2	Water Solenoid
3	Check Valve
4	Drain Valve
5	Steam Outlet
6	Gauge Glass Assembly
7	Safety Valve
8	Pressure Gauge
9	Hi-Limit Pressure Control
10	Operating Pressure Control
11	Access Panel
12	On/Off Switch

## Meeting Code Requirements

- Pressure vessel rated at 100 PSIG to ASME Section I, Code M and National Board registered.
- UL listed, cUL Listed, built to NEC.
- All units are physically identical and have a packed shipping weight of 125 lbs.
- Units are trimmed at 100PSIG as standard. 15PSIG trim also available.
- Incoming water line pressure must be 10 PSIG greater than generator operating pressure. If not, a motor/pump must be used. Specify Sussman MBA38002A high pressure water feed motor/pump system.
- When ordering specify Model No., KW, Volts/PH and motor/pump if required.
- Water Connection is 1/4 NPT. Steam outlet is 1/2 NPT.

Model	KW	Volts	PH	Amps	PPH
MBA3	3	120,208,240	1	25, 15, 13	9
MBA6	6	208,240,480	3	17, 15, 8	18
MBA9	9	208,240,480	3	25, 22, 11	27
MBA12	12	208,240,480	3	34, 29, 15	36
MBA18	18	208,240,480	3	50, 44, 22	54
MBA20	20	208,240,480	3	56, 49, 25	60

## Installation

**CAUTION** Refer to National and all applicable Local Codes for specific installation requirements.

**NOTE:** Reference heating element clearance requirements for particular boiler to allow for removal of elements. Standard minimum suggested clearance is 21 inches.

1. The boiler should be mounted on a solid level foundation.
2. All piping should be installed by a licensed plumber.
3. When any type water feed other than a pump feed is used, the existing water supply pressure must be 10 PSIG greater than boiler operating pressure to assure water supply maintains proper water level in boiler. Lack of water can result in improper boiler operation. Keep feed water valves open at all times during normal operation.
4. Connect steam line with customer supplied outlet valve to boiler steam outlet.
5. During normal operation, keep drain valve closed.
6. If pump and boiler are plumbed within 30 ft (pipe length), a minimum of two check valves are required on boiler to avoid damage to pump.

**NOTE: THE SAFETY VALVE SHALL NOT BE PLUMBED WITH A DRAIN LINE SIZED LESS THAN THE OUTLET SIZE OF THE SAFETY VALVE.**

## Wiring

**CAUTION** Ground boiler according to National Electric Code requirements to avoid shock. Use proper sized wire. Power wiring to boiler should be in accordance with Local and N.E.C. requirements following wiring diagram supplied. Wire size specified adjacent to field wiring terminal block(s). Use 90° C copper wire only.

Purchaser should use a disconnect switch employing circuit breakers or fuses between the main power source and the boiler.

**CAUTION** Boilers are susceptible to lightning damage because of plumbing water lines. Industrial type lightning/surge protectors should be installed according to the manufacturer's recommendation at your service entrance. Consult your contractor or electrical dealer.

1. The unit is pre-wired and tested. Connect control circuit voltage at the control circuit terminal block.
2. With the main power off, make sure that all wiring terminations are tight to avoid arcing, carbonizing and/or overheating of contacts.

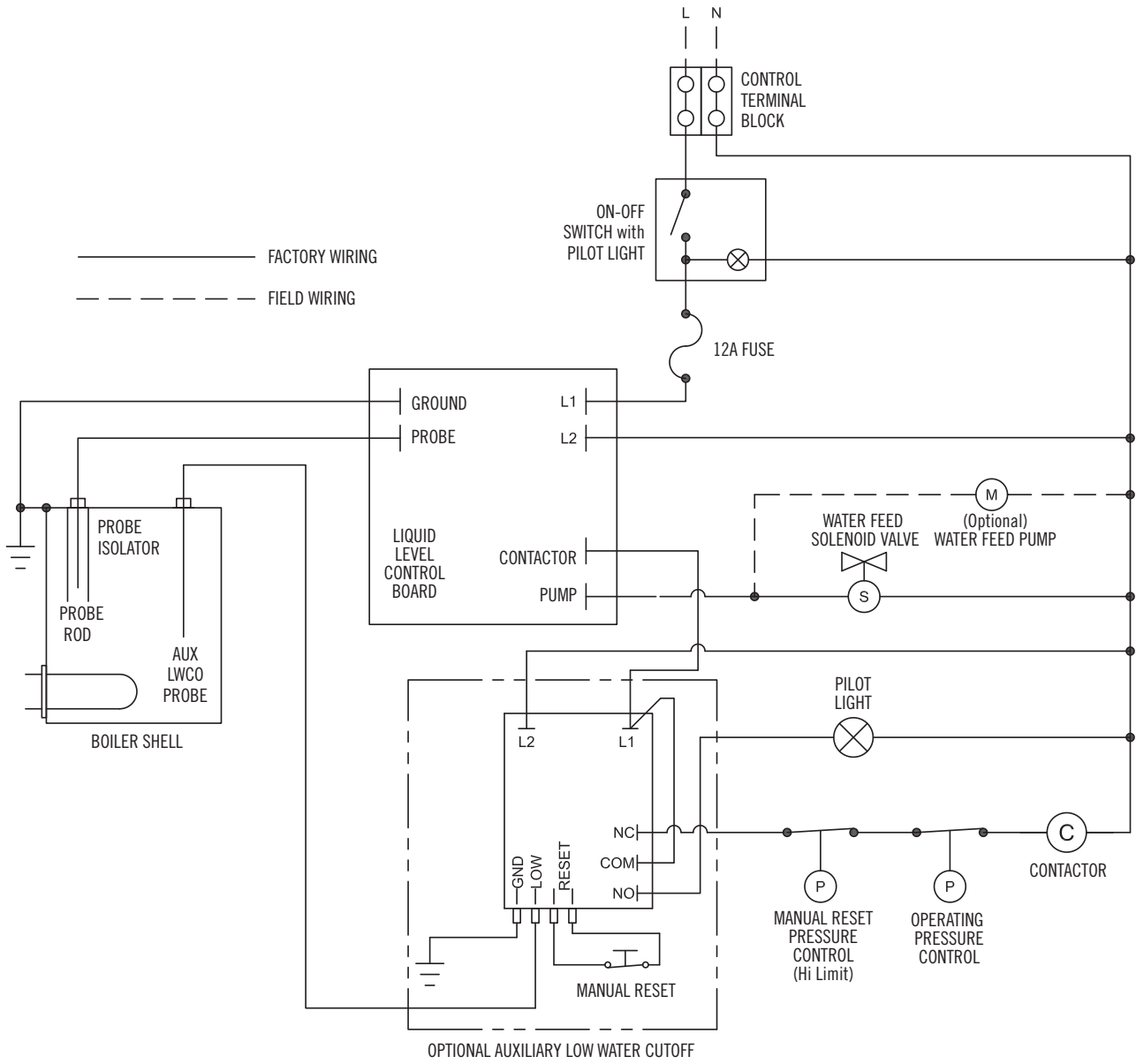
**WARNING** Substitution of components or modification of wiring systems voids the warranty and may lead to dangerous operating conditions.

3. Instructions for water feed control system (i.e. motor and pump or solenoid feed).
  - a. Check the voltage of the motor or solenoid before making electrical connection.

**WARNING** b. The water feed circuit should be wired to the junction box provided.

- c. Motors rated greater than 1/3HP or are not 120VAC single phase require the use of suitable motor starter.
- d. Amperage/Wire Size – For correct sizing refer to the label on the boiler located next to the field wiring terminals. This label states the wire size (AWG or MCM), minimum temperature rating (90°C) and conductor material (copper only). Deviation from this information may result in improper or unsafe boiler operation.

**MBA Steam Wiring Control Circuit Wiring Diagram**



**Replacement Heating Elements**

PART NO.	DESCRIPTION	PHASE	PART NO.	DESCRIPTION	PHASE	PART NO.	DESCRIPTION	PHASE
29031A	3KW, 120V	1	29091C	9KW, 240V	1	39181C	18KW, 240V	1
29031B	3KW, 208V	1	29093B	9KW, 208V	3	39183B	18KW, 208V	3
29031C	3KW, 240V	1	29093C	9KW, 240V	3	39183C	18KW, 240V	3
29061B	6KW, 208V	1	29093F	9KW, 480V	3	39183F	18KW, 480V	3
29061C	6KW, 240V	1	39121B	12KW, 208V	1	39201B	20KW, 208V	1
29063A	6KW, 208V	3	39121C	12KW, 240V	1	39201C	20KW, 240V	1
29063B	6KW, 240V	3	39123B	12KW, 208V	3	39203B	20KW, 208V	3
29063C	6KW, 240V	3	39123C	12KW, 240V	3	39203C	20KW, 240V	3
29063F	6KW, 480V	3	39123F	12KW, 480V	3	39203F	20KW, 480V	3
29091B	9KW, 208V	1	39181B	18KW, 208V	1			

## Pre-Operation Check - All Boilers

### IWCO/PUMP CONTROL, OPERATION AND TESTING

1. All valves for incoming water supply are to be fully opened. Main disconnect switch to be in "ON" position. Boiler switch to be in "ON" position. Since boiler will be empty, pump (or solenoid) will be energized allowing boiler to fill with water. Control will allow for automatic reaching of proper water level. Contactors will be energized, applying voltage to heating elements.
2. Pump Switch Operation – At this point, water should be visible approximately halfway up sight glass. Slowly open drain valve located at bottom of boiler. Water level will fall, allowing low water cutoff/pump control to energize feed water system. Close drain valve for proper operation.
3. Low Water Cut-Out Switch Performance. Open drain valve completely. Maintain this condition until water level falls within gauge glass enough to cause low water cut-out switch to de-energize heating elements. Contactor will be in the de-energized state at this time. Close the drain valve. For automatic resetting type low water cut-out switches, feed system will return water level to normal. Boiler is now qualified for proper low water cut-out and normal liquid-level operating conditions.

### PRESSURE CONTROLS OPERATION AND TESTING

**NOTE: ALL MBA STEAM BOILERS ARE PROVIDED WITH ONE HI-LIMIT PRESSURE CONTROL AND ONE OPERATING PRESSURE CONTROL.**

1. All pressure controls are equipped with a screw allowing for setting of the desired operational and hi-limit pressures. To reduce pressure setting, rotate screw in direction which allows indicator to point to a lower pressure setting.

**NOTE: IT IS RECOMMENDED THAT THE HI-LIMIT CONTROL BE SET 10 PSIG ABOVE DESIRED NORMAL OPERATION PRESSURE.**

2. A differential pressure can be obtained on all automatic re-setting operating pressure controls in the same manner as operating pressure control is set. Differential indicated pressure below the main operating maximum pressure the pressure control will reset.
3. Pressure Control Operating Check – Close steam outlet valve (by customer) and adjust operating pressure control to a low pressure setting. Set hi-limit control at 10 PSIG above that setting. Switch boiler on to allow for steam pressure build-up. Pressure gauge reading will build and the operating pressure control will shut off boiler at its pressure setting. Re-setting of operating pressure control is accomplished by bleeding off pressure through steam outlet valve (by customer) and allowing pressure to drop below set point.
4. Hi-limit Pressure Control Check – See item 3 above but, in doing so, assure for this test purpose only, that the operating control is set above the pressure setting of the hi-limit control. The hi-limit trip will de-energize the contactors. Resetting of the hi-limit occurs after bleeding steam to reduce pressure inside the boiler.

**! CAUTION TO AVOID IMPROPER OR UNSAFE CONDITIONS, INSURE OPERATING PRESSURE CONTROL IS RESET TO PROPER DESIRED BOILER OPERATING PRESSURE**

## Operation

**! CAUTION ONLY WITH MAIN DISCONNECT "OFF", TIGHTEN ALL ELECTRICAL CONNECTIONS BEFORE ENERGIZING BOILER TO PREVENT ARCING, CARBONIZING OF CONTACTS AND/OR OVERHEATING.**

1. Turn on water supply. Turn main switch on. Turn boiler switch to ON position. When water appears approximately halfway up the gauge glass, the pump or solenoid feed will automatically shut off and the contactors will switch on.
2. Operation of Low Water Cut-Off – The boiler is equipped with a probe type liquid level control which is coupled to an electronic controller (pc board).
3. The automatic reset operating pressure control has a visual pressure adjustment. The top screw of the control adjusts the scale in the large indicator window. By turning the screw, the pressure setting can be adjusted. Selection of desirable pressure is very easily made. Some pressure controls have an additional screw for adjustment of pressure differential (OFF/ON pressure operating range) which is factory set at the maximum allowable rating.
4. Close steam outlet valve. Boiler will build up to desired pressure and shut off automatically.
5. High Pressure Control – This control will de-energize the boiler should pressure within the boiler exceed the set pressure.
6. Slowly open steam outlet valve and use steam as needed.
7. Boiler should be blowdown daily (see blowdown instructions on page 6).

## Blowdown

Blowdown is an essential part of boiler operation. It is one of the best preventative maintenance steps you can take. Make sure a blowdown schedule is established and followed regularly.

In hard water areas, blowdown is necessary at least once a day. In soft water areas, once a week. If there is a particular problem which applies to your own local water condition other than mineral content, take this into consideration in determining which schedule is to be followed.

1. At the end of the working day, while boiler is still operating, turn switch to the OFF position and close water supply valve. De-energize wall mounted safety switch.
2. It is preferable to connect the blowdown valve directly into a drainage system when allowed by local codes. If this is done, the boiler can be discharged at operating pressure.  
Consult local plumbing codes before doing so.
3. If blowing-down into a receptacle, allow pressure to decrease to 15-20 PSIG before opening blowdown valve.
4. When discharge is complete and boiler is drained:
  1. Close the blowdown valve
  2. Open water supply valve;
  3. Put boiler switch in the ON position
  4. Close wall mounted safety switch.
5. When refilling is complete, turn off the boiler switch unless further operation is desirable.
6. If you have been supplied with a Manual Reset Low Water Control as required in some states, the reset button on the control must be pushed before boiler will begin developing pressure. (Do not push reset until boiler has filled with water.)

### AUTOMATIC BLOWDOWN INSTRUCTIONS

(PN ES81600) 1" NPT, Starts, stops and blows down the boiler automatically, utilizing a programmable time clock a time-delay relay and motorized ball valve.

**CAUTION** If the blowdown valve is plumbed into a blowdown tank, the boiler can be discharged at operating pressure. If the blowdown valve is not plumbed into a blowdown tank, consult with local plumbing codes regarding boiler discharge.

**NOTE:** The manual valves from the boiler drain and the lower float control equalization tube must be fully open for the automatic blowdown to be effective.

1. Program time clock by setting the time boiler is to turn on and off daily. (Refer to instructions in time clock insert.)
2. When the time clock turns the boiler "off" the blowdown is activated. A red pilot light over the time clock will come on and remain on while the motorized ball valve is open. The time duration the valve is open is set by an adjustable potentiometer built into the time delay board. The water level in the boiler after blowdown is complete, will be approximately at the lower gauge glass valve. (Elements are not exposed to air between operations.)
3. Boiler will automatically refill at next programmed on cycle.

Blowdown program can be overridden to allow for unscheduled blowdown or operational cycles. Refer to the time clock instruction insert.

## Optional Equipment

### OPTIONAL AUXILIARY LOW WATER CUT OFF

- For model MBA boilers PN MBA81017MR (with manual reset).

Senses water level electronically using a resistance probe. When a low water condition is detected, the contactor control voltage circuit is interrupted and the heating elements are de-energized. When water level returns to proper levels voltage is restored to the contactor coils and the elements are re-energized.

For controls with a manual reset button voltage to the contactor coils is not restored until the water level has returned to proper operating levels and the reset button is pushed. Do not depress the reset button before the correct water level is achieved.

To test AUX LWCO, press and hold the manual reset button on the side of the boiler for 5 seconds.

## Digital Timer - Operation Instructions

### TO SET TIME & DAY OF CLOCK

1. Hold down the image of clock button (🕒) for steps 2-4.
2. Press the **"Day"** button to cycle through the days which are listed on the top line.
3. Press the **"h+"** button to increase the current hour.



**NOTE:** this will also change the **AM/PM** as it is listed to the right of the minutes.

4. Press the **"m+"** button to increase the current minute.

### TO SET TIMER ON/OFF TIMES

(there are 7 different programs that can be set)

5. Click the **"Timer"** button to go into the timer mode.
6. **Program 1 ON** will be the first to come up.  
This will be when the boiler turns on. Set the day and time the same way you set the timer in steps 2-4.
7. Hit the **"Timer"** button to save the entry and move onto the next setting.
8. The next setting will be **Program 1 OFF**.  
This will be when the boiler turns off. Once the boiler is turned off the automatic blowdown system will activate. Follow steps 2-4 to set the date and time. Hit the **"Timer"** button to save the settings.
9. Repeat steps 6-8 to set programs 2-7.

### ON/OFF STATUS:

Pressing the image of a hand with a pointed finger button (👉) changes the current mode of the timer. If **ON** is indicated on the display the boiler is currently running and if **OFF** is indicated the boiler is off/blowing down. Once one of the programs are started the indicator will automatically turn to the **ON** position and when one of the programs ends it will automatically be set to the **OFF** position.

### DAYLIGHT SAVING TIME:

The timer does not automatically adjust for daylight saving time and the time will have to be adjusted manually.

### PROGRAMMED COMBINATIONS:

Switch **OFF** commands have priority over switch **ON** commands.

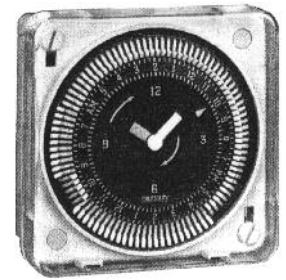
### NOTES:

1. The timer is set according to the boiler operation.  
When the timer is **ON** the boiler is **ON** and the blowdown is **OFF**.
2. During programming, if no button is pressed after 30 seconds, the timer will revert back to normal operating mode.

## 24-Hour and 7-Day Time Switches

### PROGRAMMING

For electric steam boilers equipped with Automatic Blowdown Systems ES 81600, refer to the following instructions for time clock operation and settings.



Timer settings for blowdown operation are at the discretion of the owner/operator.

The weekly program dial shows the seven days of the week and AM/PM imprints for each day.

The time switch is set by pushing the captive trippers to the outer ring position for the entire period that the load is to be turned ON, i.e., 2 hours to each tripper on the 7-day dial. When the tripper is pushed to the inside, the switch is in the OFF position.

### SETTING TIME

To set the current time and day of week, turn the minute hand clockwise. Do not set the time by rotating "Outer" Dial.

Turn the minute hand clockwise until the day of the week and the time of day on the outer dial is aligned with the triangle marker on the inner dial (two o'clock).

Example for 7-day program dial Monday 10:30 AM.

Turn the minute hand clockwise until Monday 10:30 AM is aligned with the triangle on the inner dial.

The hour and minute hand will show exactly 10:30.

### FOR MANUAL OVERRIDE

Manual override can be accomplished at the discretion of the owner/operator as follows:

### 3-WAY MANUAL OVERRIDE SWITCH

- I = permanent ON
- ☉ = automatic
- O = permanent OFF

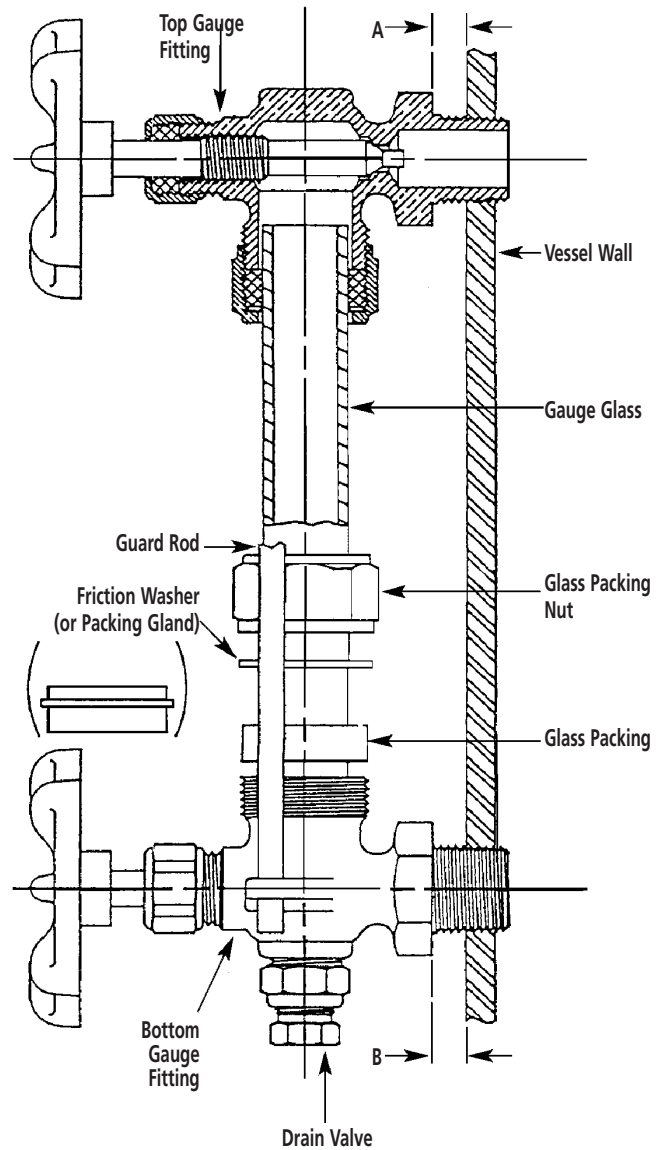


**IMPORTANT:** It is recommended that for periodic and effective blowdown, the override switch be set in the ☉ automatic setting.

## Gauge Glass Installation

**IMPORTANT NOTE:** Read all warnings and instructions before performing installation or maintenance. Safety glasses and gloves should be worn at all times when working with or examining water gauge glass and connections. Pressure in generator to be at zero before proceeding. Improper installation or maintenance of gauge glass and connections can cause immediate or delayed breakage resulting in bodily injury and/or property damage.

1. Apply Teflon tape or pipe dope to pipe threads. Install top gauge fitting (fitting without a drain valve) into the uppermost tapping. Wrench tighten the fitting until it is snug and the glass outlet is pointing at five o'clock (about 1/8 turn from its final downward vertical position).
2. Install the bottom gauge fitting (the fitting with a drain valve) until it is snug and the glass outlet is pointing directly upward. Verify top and bottom fittings are threaded into the tappings the same number of turns (distance A= distance B).
3. Remove glass packing nut, friction washer (or packing gland, depending upon the model), and glass packing from the fittings, and place them, in the same order, on to both ends of the gauge glass. Push both packings about an inch up the gauge glass.
4. Gently insert one end of the glass into the top gauge fitting. Keeping the glass inside the top fitting, gently rotate the top gauge fitting clockwise until vertically aligned with the bottom gauge, then insert glass into bottom fitting until glass bottoms out on the shoulder inside the bottom fitting.
5. Carefully raise glass about 1/16" and slide lower glass packing down until the glass packing contacts the lower gauge fitting. DO NOT allow the glass to remain in contact with any metal!
6. Carefully slide upper glass packing up as far as possible.
7. Hand tighten both glass packing nuts, then tighten 1/2 turn more by wrench. Tighten only enough to prevent leakage. DO NOT OVER TIGHTEN! If any leakage should occur, tighten lightly, a quarter turn at a time, checking for leakage after each turn.



**IMPORTANT NOTE:** Read all warnings and instructions before performing installation or maintenance.

**! WARNING** Safety glasses and gloves should be worn at all times when working with or examining water gauge glass and connections.

Pressure in generator to be at zero before proceeding. Improper installation or maintenance of gauge glass and connections can cause immediate or delayed breakage resulting in bodily injury and/or property damage.



## Gauge Glass Installation - Use and Care

### DO NOTs

- DO NOT use glass if it contains any scratches, chips, or any other visible signs of damage.
- DO NOT reuse any tubular glass or glass packings.
- DO NOT subject gauge glass to bending or torsional stresses.
- DO NOT over tighten glass packing nuts.
- DO NOT allow glass to touch any metal parts.
- DO NOT exceed the recommended pressure of the gauge or gauge glass.
- DO NOT clean the gauge or gauge glass while pressurized or in operation.

### DO's

- DO verify proper gauge has been supplied.
- DO examine gauge glass and packings carefully for damage before installation.
- DO install protective guards and utilize automatic ball checks where necessary to help prevent injury in case of glass breakage.
- DO inspect the gauge glass daily, keep maintenance records, and conduct routine replacements.
- DO protect glass from sudden changes in temperatures such as drafts, water spray, etc.

### MAINTENANCE

Examine the gauge glass regularly for any signs of clouding, scratching, erosion, or corrosion. The glass should be inspected daily until the need for replacement becomes apparent. This will help establish the routine inspection and routine replacement schedules.

### CLEANING

Use commercial non-abrasive glass cleaners to keep glass clean. Use diluted acids such as Hydrochloric (muriatic) acid when regular cleaners do not seem to work. Do not use wire brushes or any other abrasive materials which could scratch the glass.

### INSPECTION

Examine the surface of the glass for scratches, corrosion, chips, cracks, surface flaws, or nicks. To do this, shine a very bright concentrated light at an angle of about 45 degrees. A defective glass will glisten as the light strikes imperfections. Glass which appears cloudy or roughened, and will not respond to cleaning, should be replaced.

### STORING

Keep gauge glass in original packaging until ready to install.

## Maintenance

**CAUTION HAZARD OF ELECTRICAL SHOCK. DISCONNECT ALL POWER BEFORE WORKING ON BOILER.**

Sussman Electric Steam boilers are designed for years of trouble-free performance. To establish a good preventative maintenance program, we suggest that the building maintenance person or engineer familiarize themselves with these simple rules.

1. The sight glass should be checked daily to ensure that boiler has adequate water.
2. A monthly inspection should be made of the internal wiring. All electrical connections should be checked for tightness. A check for water leaks should also be made and any loose fittings immediately tightened.
3. Every four months, the low water cut-off and pump control should be checked to insure that it is functioning properly.
4. Every four months, the probe and isolator should be checked for deposits and cleaned, if necessary. This is accomplished by removing the inspection plate, removing the probe (with a standard socket wrench) cleaning and replacing.
5. Every four months, the heating elements should be removed. If scale has begun to form, the element should be cleaned and the boiler should be drained and flushed.

**NOTE: THE SYSTEM WILL NOT OPERATE IF THE BOILER IS USING DISTILLED, DEMINERALIZED OR DEIONIZED WATER**

**NOTE: NEW BOLTS AND GASKET SHOULD BE USED WHEN RE-INSTALLING THE ELEMENT TO ASSURE PROPER SEALING.**

## Element Replacement

### READ INSTRUCTIONS COMPLETELY BEFORE STARTING WORK

**CAUTION** Before installing your new elements be sure the McDonnell Miller low water cut-off and aux. low water cutoff (if supplied) is operating properly. The float chamber and lower equalizer column of the MM control must be completely clear of sludge or other foreign matter. Failure to do this may cause the immediate burn-out of the new elements. If the unit is probe equipped, check condition of the probes and isolator.

All elements are thoroughly checked before shipment. The manufacturer cannot be responsible for burn-outs caused by a faulty low water cut-off.

The lower equalizer column can best be examined by breaking the unions on either side and then visually and manually examining the piping with your finger or probes to see if it is clear and clean.

1. Disconnect boiler from electric power supply at main safety switch or fuse panel. Then turn boiler switch to "OFF" position.
2. Close water supply valve on incoming water supply line. Drain boiler completely of water.
3. Open boiler door to access heating element.
4. Disconnect wire (electric) leads connecting element to main power system of boiler. Again, note wire connections to facilitate re-assembly. Proceed to remove and discard (6) bolts from flange.

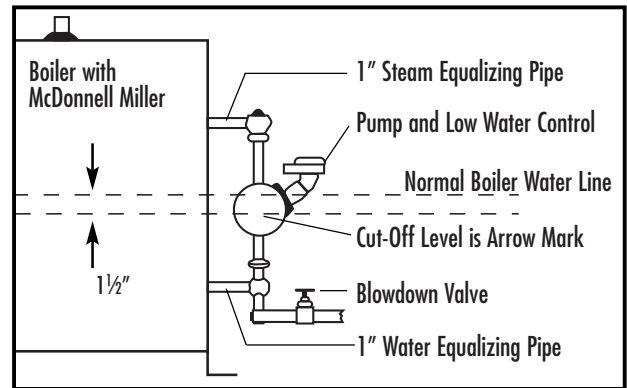
**IMPORTANT:** Note the wire connections to facilitate re-assembly (see wiring schematic). Remove and discard six (5/16" -18) bolts from flange. Do not reuse these bolts.

5. Thoroughly clean boiler flange of all foreign material. Be certain no part of old gasket remains on flange.
6. Apply "Slic-Tite" Gasket Compound (or equal) to both surfaces of new gasket supplied with replacement element. Proceed to install element flange assembly with gasket between boiler flange and element flange. In doing this, be careful to align flange holes so element wire connection terminals on element assembly are in line with previously disconnected wire leads to facilitate easy connections.

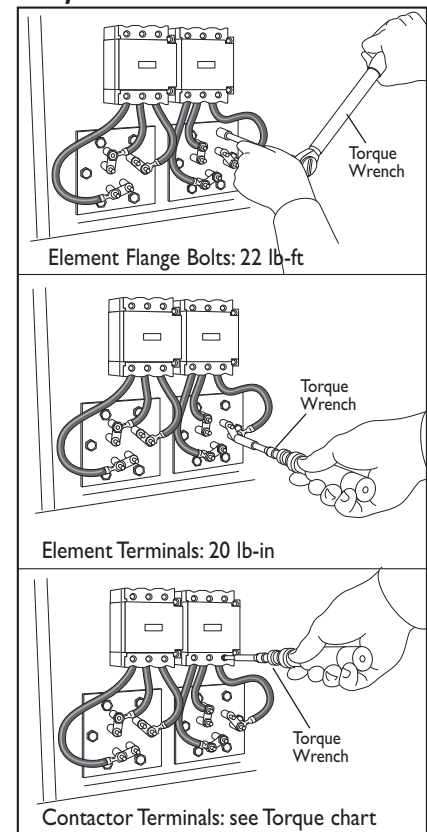
**NOTE:** Observe markings on element flange. Install element marking "TOP" on top.

7. Use only new element flange bolts. Tighten all (6) element flange bolts to a torque value of 22 lb-ft each (see illustration).
8. Connect all wires to the terminals. Tighten all element terminals to a torque value of 20 lb-in each (see illustration). Make sure all wires are clean and bright to assure good electrical contact.
9. Check that the wires are correctly connected to the contactor terminals and are tightened to a torque listed on the contactor. Make sure all wires are clean and bright to assure good electrical contact.
10. Open water valve to allow water supply to reach boiler feed mechanism.
11. As boiler automatically refills, observe the new flange assembly for possible leaks. If water is noticed, the bolts must be re-tightened. Before doing this, turn the boiler off at the main fuse safety switch.
12. When boiler reaches working pressure, check flange assembly again for leaks.

**CAUTION** Follow maintenance instructions provided with the boiler.



### Torque Values:



**For Illustrative Purposes Only.**  
Power wiring shown in approximate factory-installed location

TORQUE VALUES	
Element Flange Bolts	22 lb-ft
Element Terminals	20 lb-in
Contactor Terminals	Tighten to torque specified on contactor

## Water Quality Information for Carbon Steel Boilers

For optimum results, the feedwater supply should be tested prior to initial startup, if the mineral content exceeds the following recommended limits, various external treatment processes (water softener, reverse osmosis, etc.) may be used to correct the problem.

**NOTE:** an analysis of the on-site boiler feedwater must be made by a recognized and reliable water treatment company to ascertain the existing condition and treatment required.

### RECOMMENDED FEEDWATER QUALITY

Hardness, ppm	8 – 85 (~0.5–5 gpg)
P-Alkalinity, ppm	85 – 410 (~5–24 gpg)
T-Alkalinity, ppm	200 – 500 (~7–0 gpg)
ph (strength of alkalinity)	8.0 – 11.4
Specific Resistivity	~50k $\omega$ -cm (50,000 ohm-centimeter)

Blow down boiler on at least a once a day basis. If boiler water or feedwater are outside the above limits, a more frequent blowdown is required.

### RECOMMENDED LIMITS WITHIN A BOILER

Total dissolved solids, ppm	3500
Total alkalinity, ppm	850
Suspended solids, ppm	300
Silica (siO2), ppm	125
Sulfite (so3), ppm	25–50
Phosphate, ppm	30–60
P-Alkalinity as caco3, ppm	900
Iron, ppm	2

Water quality can affect efficiency or result in boiler damage if neglected. Boiler feedwater contains impurities in solution and suspension. These impurities concentrate in the boiler since the steam generated is essentially pure. The concentration of these impurities increases as more feedwater is introduced into the boiler and steam is produced. If the suspended solids are allowed to concentrate beyond certain limits, a deposit or "scale" will form on the boiler internal surfaces. This deposit can interfere with proper boiler operation and cause boiler failure.

The concentration of these impurities is generally controlled by the feedwater quality and by blowdown. Blowdown refers to removing a portion of the boiler water with high solids concentration and replacing it with makeup water of a lower concentration.

Lbs./Hr Sat. Steam	9 to 60
KW Rating	3 to 20
PSIG Range	0 to 90

## MBA Spare Parts List

90229	Probe Plug	99128R	Pressure Control Operating Pressuretrol 0-100 PSIG
92830	On-Off Switch with Pilot Light	100706-12	12 amp Fuse
99042	Water Solenoid 1/4" 120V	99807F	1/4 Probe Rod 5-Inch
99042C	Water Solenoid 1/4" 240V	99075	Contactora, 60 amp; 3 Pole, 120V
99080-1	9-7/8" Gauge Glass w/ (2) 99174CV O-Ring	99007	Contactora, 60 AMP, 3 Pole 240V
99173C	Gauge Valve Set	100412A	Liquid Level Control Board; 120V
99136	Safety Valve 100PSIG, 1/2" NPT	100412C	Liquid Level Control Board; 240V
99197	Pressure Gauge 160 PSIG, 2-1/2" NPT	100378	Probe Isolator
99130R	Pressure Control Hi Limit Pressuretrol 0-100 PSIG w/Reset Button on Rise	103540	Boiler Gasket Kit, 99096; 99547B, 99088 Gasket; Bolts & Compound



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**SUSSMAN**  
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*A Division of Sussman-Automatic Corporation*  
43-20 34th Street, Long Island City, NY 11101 • 718-937-4500 • 800-238-3535  
Fax: 718-937-4676 • [www.sussmanboilers.com](http://www.sussmanboilers.com) • Email: [seb@sussmancorp.com](mailto:seb@sussmancorp.com)