

# Service Bulletin

## Subject: Zone Low Temp Error Modification Thermal Cutout Switch

Models: Merco MHA, MHC, MHD, MHG, MHL, MHS,  
MHT Cabinets

9/22/2022

Merco cabinets that are experiencing multiple Zone Low Temp errors, where the thermal cut out switch is prematurely opening and turning off heat to heater pads, should perform the following steps to address this issue.

1. Remove the panels to access the affected heater pad leads.
2. Test resistance of cold heater pad circuit. If the circuit is open, replace the heater pad.
3. Test the amp draw of the heater pad while unit is in operation. If the circuit is opening and closing during heating, follow the procedure beginning with the next step.
4. Remove power from the cabinet.
5. Locate the affected thermal cutout switch. It will be located near the exit point of the harness (see Figure 1).
6. Expose the thermal cutout switch by carefully cutting through the top layer of the foil tape (see Figures 2 and 3).
7. Position a crimping tool over the center of the thermal cutout switch. With light pressure, squeeze the crimping tool with the **sharp heel of the crimper** until an indentation is created. It is critical this performed this way and **NOT** with pliers or the blunt end of the crimpers. This will compress the **flat side** of the housing, preventing the contacts from opening the heater circuit (see Figures 4 and 5).

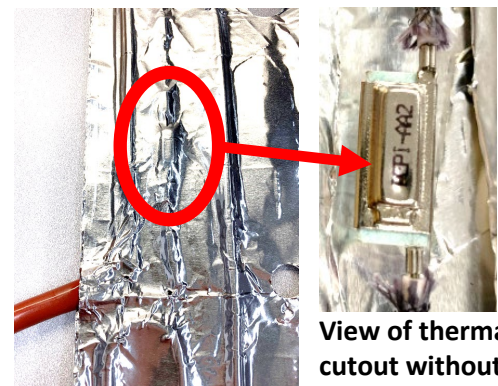


Figure 1

View of thermal cutout without heat shrink.



Figure 2



Figure 3

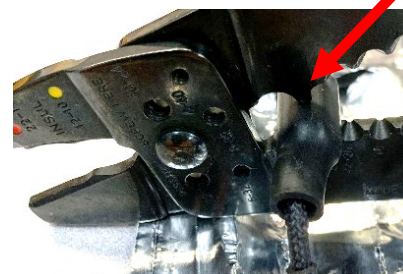


Figure 4



Figure 5

Continued on the following page.

8. Wrap three (3) loops of electrical tape securely around the thermal cutout switch to ensure isolation (see Figure 6).
9. Cover the thermal cutout switch with foil tape (see Figure 7).
10. Reassemble and connect power to the cabinet.
11. Verify the specific zone is reaching set point.



Figure 6



Figure 7