

# TRX HX Stud Replacement Instructions



For TRX Series II boilers (models and S/Ns):

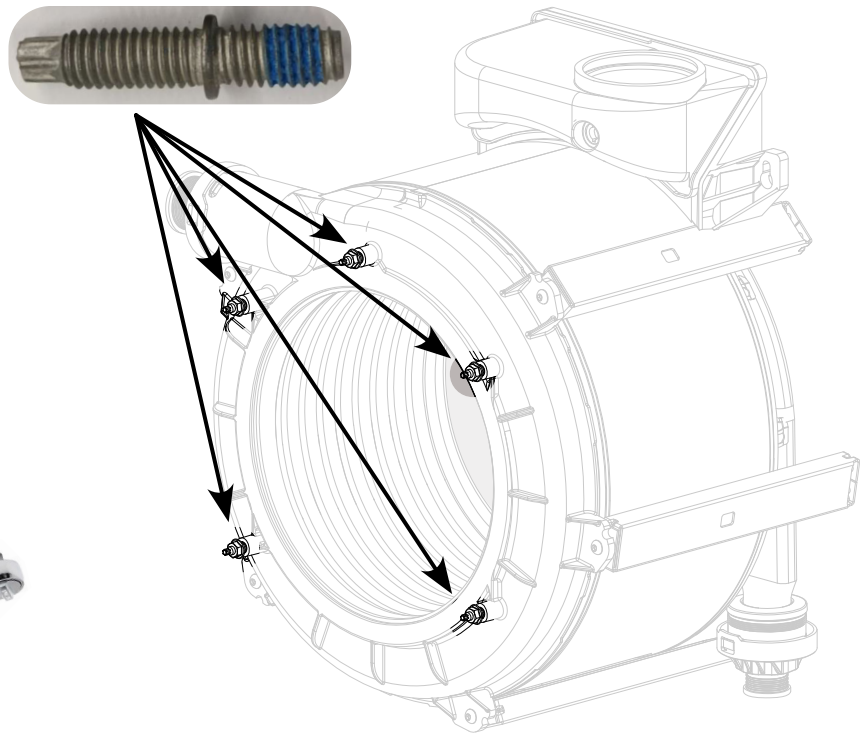
- TRX150 Series II  
S/Ns: 3314306C8[242830000177-250130000073)
- TRX199 Series II  
S/Ns: 3314307C8 (242740000006-250220000014)
- TRX199C Series II  
S/Ns: 3314308C8 (242750000127-250410000051)

Part # 4270278 Kit Contents:

- Replacement studs (5 + 1 spare)
- Torx E5 socket, ¼" square drive (1)
- Loctite 648, 10 mL (1)

Tools required:

- Cordless drill/driver (NON-impact)
- ¼" square drive adapter
- ¼" hex bit / nut driver
- Socket wrench, ¼" drive



## DANGER

These instructions must only be used by a qualified installer / service technician. Read all seven (7) steps of these instructions before continuing. Perform steps in the given order. Failure to do so could result in property damage, severe personal injury, or death.

## WARNING

Improper installation, adjustment, alteration, service, or maintenance could void product warranty and cause property damage, severe personal injury, or death.



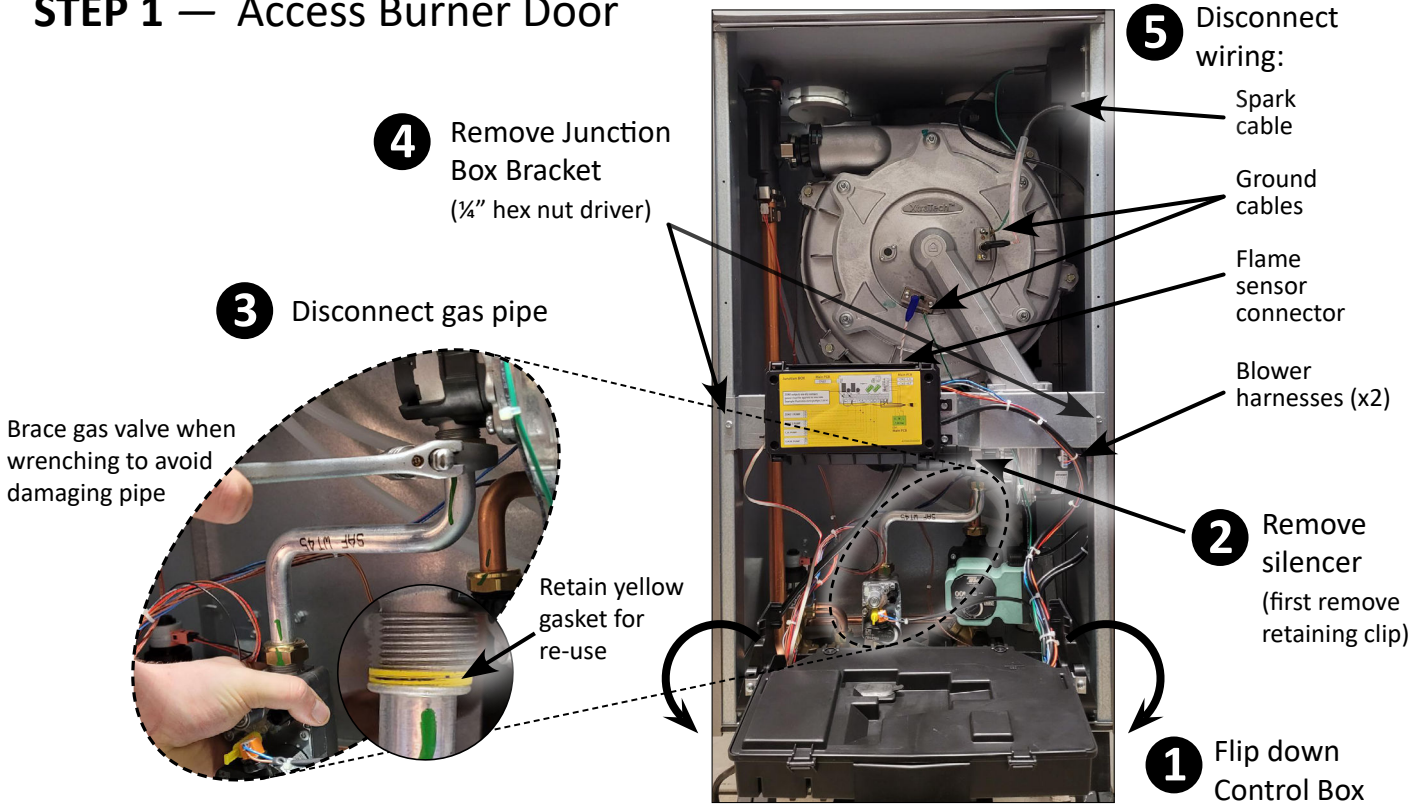
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# 2

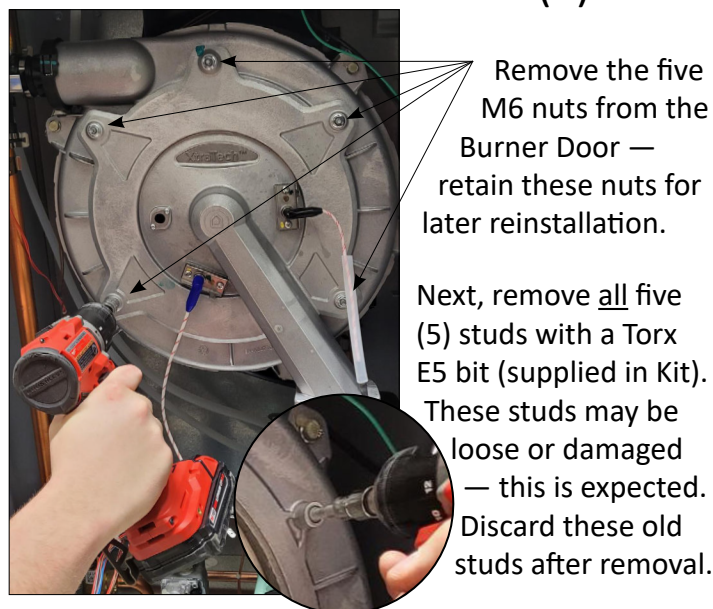
## TRX HX Stud Replacement Instructions

**BEFORE YOU START — Disconnect the appliance from its power supply and close the gas shut-off valve to the unit**

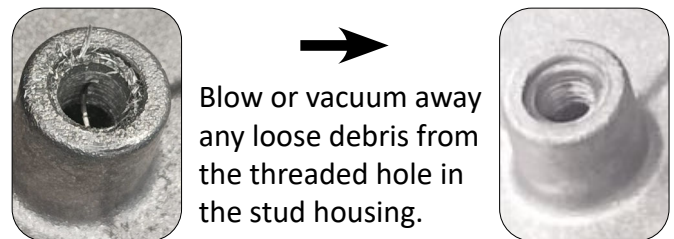
### STEP 1 — Access Burner Door



### STEP 2 — Remove Burner Door and all five (5) Studs



### STEP 3 — Remove debris



Visible wear to housing threads is expected. The new studs are significantly longer and will cut fresh threads into untouched material.



## ⚠ WARNING

Failure to tighten these and other fasteners to an appropriate or specified torque could result in property damage, gas leakage, fire, explosion, serious personal injury, or death.

### STEP 4 — Install new studs

Set the cordless drill/driver (do NOT use an Impact Driver) to the highest torque setting (but NOT to 'DRILL').



Apply one to two drops of threadlock (LOCTITE 648, supplied) to each new stud before installation, making sure to cover the threads completely, as shown.

Using the same Torx E5 bit, drive each new stud in smoothly, **slowing** as the flange approaches the lip of the stud housing.



**STOP** when it begins to meet resistance. **DO NOT** over-torque. Finish tightening by hand with a socket wrench.

Final stud depth shown here:

**Target stud torque (DO NOT exceed):** 7 – 8 N·m  
(5 – 6 ft·lb)



Photograph the newly-installed studs (and the boiler's rating plate – including Serial Number) for your records. Proof of their installation is required for reimbursement (details on following page).

**NOTE:** If a stud becomes compromised during installation:

- Stripped threads (stud will spin without tightening into housing)
- Broken / cracked stud or other mechanical failure

then the Heat Exchanger **MUST** be deemed scrap and the boiler decommissioned immediately until a new Heat Exchanger can be installed.

Please contact [recall@ntiboilers.com](mailto:recall@ntiboilers.com) or call 1-800-688-2575 (option 1) to document the issue and obtain a replacement:

- TRX150: Part #: 6500923900 (45 kW)
- TRX199 / TRX199C: Part #: 6500924000 (60 kW)



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## TRX HX Stud Replacement Instructions

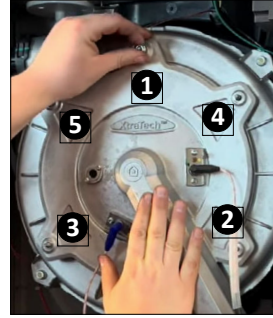
### STEP 5 — Reattach burner door

Thread nuts on by hand first to avoid cross-threading.

Tighten nuts with drill in an alternating star pattern.

Finish tightening by hand with socket wrench.

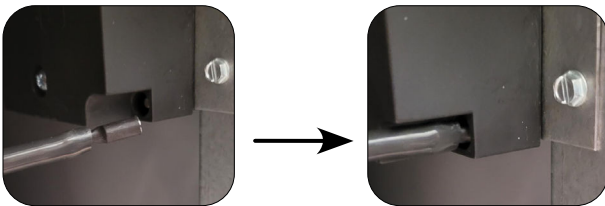
**Target nut torque: 6 – 7 N·m (4.5 – 5 ft·lb)**



### STEP 6 — Reassemble boiler

Repeat the actions from Step 1 (in reverse) in order to reassemble the boiler.

When reconnecting the Spark Cable, be sure to insert it fully into the transformer.



### STEP 7 — Test-fire and leak-check

Once everything has been reconnected, conduct a test of the boiler to ensure proper function.

Using a combustion analyzer or gas sniffer, and with the boiler running at maximum output, check for leaks around the burner door.



To obtain reimbursement for completing this Recall Repair procedure as instructed:  
Go to [ntiboilers.com/trx-safety-recall](http://ntiboilers.com/trx-safety-recall) and submit the Reimbursement Form.

To supplement these instructions, NTI has created a video to guide viewers through these steps – access the video from our TRX Recall Notice webpage:



[ntiboilers.com/trx-safety-recall](http://ntiboilers.com/trx-safety-recall)

For technical support, or if you have any questions about these instructions, please contact us:

### NTI Boilers Inc.

30 Stonegate Drive

Saint John, NB E2H 0A4 Canada

Technical Assistance: 1-800-688-2575

Website: [www.ntiboilers.com](http://www.ntiboilers.com)