

PROCEDURE TO REPLACE DMS, Inc. "FR" CARTRIDGE HEATER

TOOLS REQ'D:

Allen Wrench Set (3/32" – 3/16")
Electrician Wire Cutters & Crimpers

PARTS REQ'D:

RTV High Temp. Silicone (Gasket Maker)
Cartridge Heater

PROCEDURE:

1. Remove H.S. Unit from die station.
2. Remove die from H.S. Unit.
3. Remove lateral adjust assembly by completely turning knob counter clock-wise until it comes off.
4. Remove 4 screws (10-24 x 1/4") from top cover of Slip Ring Assembly (SRA) Box.
5. Remove 4 screws (10-24 x 3/8") from rear panel of SRA Box.
6. Disconnect air tubing from rear panel.
7. Disconnect white SRA block from heater cartridge leads by sliding white SRA block off of posts.
8. Remove ground wire screw (10-24 x 1/4"). This will completely free the rear panel from the SRA Box.
9. Loosen set screws in wire junction located on the end of the journal. This will allow you to remove the heater cartridge leads from the wire junction.
10. Remove 3 screws (4-40 x 3/8") from end of OS journal located through the wire junction assembly.
11. Slide end cap and plug off the ends of the leads one at a time. Make sure you do not lose the o-rings between the two pieces.
12. Tie a string on the ends of the leads to use as a guide during the assembly of the heater cartridge.
13. Mark the press side journal and copper shaft for correct screw hole alignment to eliminate run-out during assembly.
14. Remove press side (PS) H.S. block.
15. Remove 3 screws (10-24 x 1") from PS journal. This will free PS journal from the copper shaft.
16. Remove the pin located at the end of the heater cartridge by pulling the heater cartridge towards the press side of the copper shaft.
17. Pull heater cartridge towards the press side of copper shaft to remove the roll pin (1/8 x 1"). This will free the heater cartridge.
18. Now slide or pull the heater cartridge out towards the press side of the copper shaft.

ASSEMBLY:

Follow above procedure in opposite order.

For technical support or questions please call us toll free at **1-800-655-7882**.

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