

PROCEDURE TO REPLACE DMS, Inc. CARTRIDGE HEATER

TOOLS REQ'D:

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

PARTS REQ'D:

2 PCs. Fast Disconnect Female (Tab 0.250")
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. Remove 4 screws (10-24 x 3") from air union block.
10. The SRA Box and the air union block can now be removed by sliding them off the operator side (OS) journal.
11. Remove 1" snap ring from OS journal.
12. Slide thrust bearings and OS H.S. block off OS journal.
13. Cut off connectors from heater cartridge leads.
14. Remove 3 screws (4-40 x 3/8") from end of OS journal.
15. Slide end cap and plug off the ends of the leads.
16. Mark both journals and copper shaft for correct screw hole alignment to eliminate run-out during assembly.
17. Remove 3 screws (10-24 x 1") from OS journal flange. This will free OS journal from the copper shaft.
18. Remove press side (PS) H.S. block.
19. Remove 3 screws (10-24 x 1") from PS journal flange. This will free PS journal from the copper shaft.
20. Push heater cartridge towards press side of copper shaft to remove roll pin (1/8 x 1"). This will free heater cartridge.
21. Now slide or press heater cartridge out of copper shaft.

ASSEMBLY:

Follow above procedure in opposite order.

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

DMS, Inc.
570A Telser Road
Lake Zurich, IL 60047