

## **Procedure to replace DMS, Inc. H.S. JOURNAL, O.S. for FR210ARPOSG Hot Stamp Unit**

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### **TOOLS REQ'D:**

Allen Wrench Set (3/32" – 3/16")  
Snap Ring Pliers

### **PARTS REQ'D:**

RTV High Temp. Silicone (Gasket Maker)  
H.S. Journal, Operator side (F313)

### **PROCEDURE:**

1. Take notes to assemble unit in opposite order.
2. Remove H.S. Unit from die station.
3. Remove die from H.S. Unit.
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 2 set screws (6-32) outside diameter of phenolic electrical housing and remove the heater wires from the brass keys located on the face of the housing.
10. Remove 3 screws (4-40 x 5/8") from the face of the housing, this will allow you to remove the housing from the end of the journal. Note: Do not lose the 2 o-rings contained inside the housing, they are needed for assembly.
11. Remove 4 screws (10-24 x 3") from air union block.
12. The SRA Box and the air union block can now be removed by sliding them off the journal.
13. Remove 1.25" snap ring from OS journal.
14. Slide thrust bearings and H.S. block off journal.
15. Remove 4 screws (1/4-20 x 2") from the journal. Carefully remove the journal from the copper shaft.
16. Replace old journal with new journal.
17. Indicate shaft with new journal in place for run-out. Total run-out should be within 0.002".

**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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