

16" X 20" HEATER ELEMENT WIRE CONNECTION REPAIR

DK20/A/S/SP

The following instructions are on the repair of a potentially faulty wire connection in your 16" x 20" heat platen. It is recommended that only those who are comfortable and knowledgeable with basic electrical repair work should perform the following repair. The following instructions start with the heat platen removed from your machine. If you have not removed the heat platen from the machine, call 1-800-525-6766 for instructions.

Note: Instructions include pictures of the repair being done on a DK20S Swinger Press, however you can perform the same primary repair on DK20-DK20A-DK20SP using the same techniques.

THE TOOLS RECOMMENDED

Phillips Screwdriver

Stripper/Crimper Electrician Pliers

1/2" open end wrench or ratchet wrench with 1/2" deep socket

Utility knife



1. Use the 1/2" wrench or deep socket ratchet wrench to remove the center (4) 5/16-18 nylon hex nuts from the heat platen cover.



2. Remove the (2) screws on the wire harness restraint clamp using the Philips screwdriver. Remove the little metal stamped plate.



3. Carefully lift the black heat platen cover up while feeding the wire harness thru the harness restraint clamp hole. Once the cover is clear of the wire harness, set it aside.



4. Locate the failed heat element wire connection.



5. Use the utility knife to carefully cut any white cloth tape that is used to keep wires together. Then remove the cut tape itself.



6. Isolate that failed long wire. Note the very end maybe discolored or burnt looking.



7. Cut off the discolored & burnt end of the wire.



8. Use the stripper pliers to strip off $\frac{1}{4}$ " of fabric insulation from the end of the wire. Make sure you do not remove any wire strand itself.



9. Slide half of the metal butt splice connector to the end of the wire and crimp using stripper/crimping pliers. Make sure it's crimped solidly.



10. Pull on the butt splice connector to insure it's crimped.



11. Slide the white silicon coated tube over the crimped connector and then further up the wire.



12. Cut off the very end of the burnt discolored end of heat element wire. Leaving the solid good wire section of the heat element wire about 2" long.

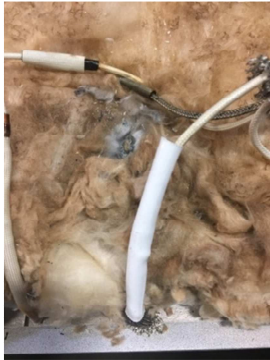


13. Slide the black sleeve tube over the heat element wire & cut the black tubing so only $\frac{1}{4}$ " of the wire is showing. Then strip the end of the wire $\frac{1}{4}$ ".



14. Feed the stripped end of the heat element wire into the crimped butt splice connector on the repaired wire. Crimp solidly and pull connection to check quality of crimp. Re-crimp if needed. Connection must be solid and tight.
CAUTION: If the heat element wire is to burnt & missing its fabric wire insulation, DO NOT PROCEED with repair.

Call customer service 1-800-525-6766.



15. Slide the white silicon coated tube down over the butt connection and then down over the black sleeve tube.

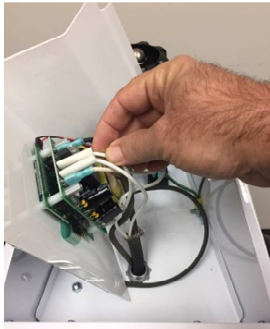
16.



17. Feed the wire harness back thru the metal restraint clamp and then lower the black heat platen cover into place. **Do not allow wires/harness to get pinched between the middle steel post plate and the cover.**



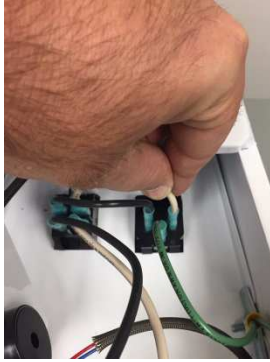
18. Gently pull on the wire harness to remove any slack. Re-attach the metal stamp plate and (2) screws on the wire harness metal cord restraint clamp.



19. Reattach heat platen to machine and connect the (2) white fabric heat wires to the male tabs marked (PRESS) on the circuit board. Connect the 3rd white fabric wire that connects to the green ground wire.



20. Reconnect the thermocouple wires to the green thermocouple connector. (Note wire color orientation SEE PICTURE) Then thermocouple connector to the green thermocouple female on the top edge of the processor board.



21. Reconnect the BLACK & WHITE wires on the back side of the power socket if you had removed them to determine if you had an issue with the heat platen.



22. Carefully re-position the top control panel to the top white head. make sure not to pinch any wires between the cover and sides of the top head. Re-attach the (2) front Phillips head screws.



23. Plug machine in and turn unit on.

You should start seeing the heat increase after a couple of mins. If after 10 mins. you see no increase in temperature, please call customer service at 1-800-525-6766.