

DK32 HEATER BLOCK REPLACEMENT INSTRUCTIONS

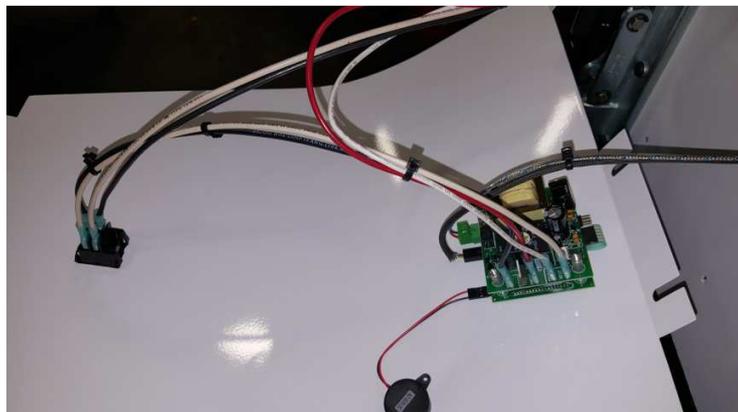
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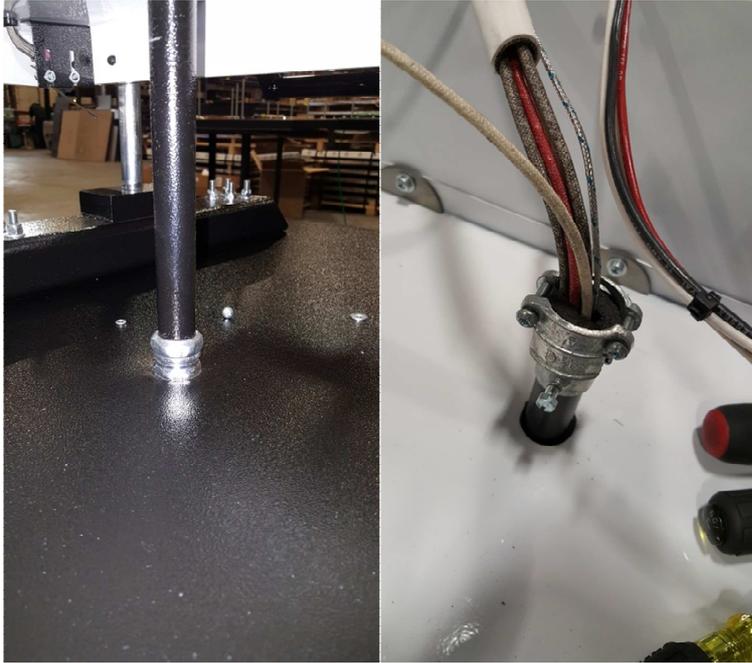


1. Unplug machine from power supply and make sure the machine is at room temperature.
2. Remove screws that fasten the top white control panel to the upper welded head. Lift panel up and rest on handle. (As shown in picture)



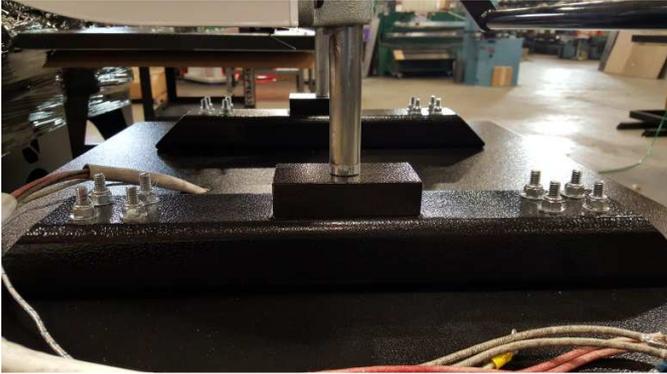
3. Disconnect wires from the heater block that connect to the HEATER RELAY, Green ground wire from ground screw, thermocouple wire from the circuit board. (See Picture)





4. Loosen the (2) screw wire conduit clamp and remove from the black conduit pipe. Once clamp is removed, loosen the locking nut on the conduit clamp attached to the heater block cover to allow you to carefully lift the black conduit pipe straight up and remove. Leaving only the heater block wires. (See above pictures)
5. Place the white control cover back in place. Lift the handle to take pressure off the heater block-(so it's only resting on the lower table) (See picture below)





6. Remove the (16) nylon hex nuts that attach the black mounting tubes to the heater block assembly. Then lift the handle to cause the tubes to lift up and over the threaded studs that come out of the heater block assembly. At this point, the heater block is detached completely mechanically as well as electrically.



7. Slowly pull out the loading table with the heater block resting on it.
8. Remove defective heater block and place New/Repaired heater block on the table carefully and slowly slide the table in.
9. Line up the (16) studs with the heater block mounting tubes so the threaded studs are lined up with the (16) holes in the heater block tubes.
10. Slowly lower the handle to the tubes will lower over the studs.
11. Once properly set in place, re-attach the (16) nylon hex nuts to the studs.
12. Next place the top white control cover again back on resting on the handle.
13. Slide the black conduit pipe back down thru the hole in the upper head belly cover so it sticks out about an inch.

14. Carefully, without damaging the heater block wires, pass them up into the black conduit pipe. The goal is to have the wires up into the pipe nice and straight.
15. With the wires nicely up into the pipe, lower the black conduit pipe back down to the conduit clamp that is attached the heater block cover. Once the pipe is fully seated, tighten the outer hex locking nut to tighten to the black pipe.



16. With the wires up thru the pipe and cleanly coming out of the upper conduit clamp, re-tighten the (2) clamp screws. Make sure the inner black rubber is in place before tightening.
17. Re-attach the ground wire to the head ground screw as it was. Reconnect the green thermocouple connector to the end of the black and red thermocouple wires as it was before.



18. Before connecting the heater wires to the HEATER RELAY, pair up the (2) heater wires that are marked with black marker together and slide on the piece of shrink tubing over them. Do the same for the (2) heater wires that are marked with red marker.
19. When re-connecting the heater wires to the HEATER RELAY, make sure the (2) heater wires marked black are connected to the RELAY LOWER screw lug under the UPPER screw lug that has the BLACK WIRES connected to it. And the (2) heater wires marked with red are connected to the RELAY LOWER screw lug under the UPPER screw lug that has the WHITE WIRES connected to it.
20. Once properly connected, use a hair dryer or the like to apply heat to the shrink tubing. This will cause the tubing to shrink and add extra insulation for the connection.
21. Double check all wire connections as well as connection locations and placement.
22. Make sure the thermocouple green connector is attached to the circuit board and that the thermocouple wires are firmly attached.
23. Carefully lower the top control panel and attach screws, you may need to bend gently the cover in order to mate properly with the top welded head.
24. Raise and lower the handle to insure the heater block is moving freely up and down.
25. Turn press on and allow the unit to heat to insure proper operation. If any issues or questions, please call the factory at 1-800-525-6766.