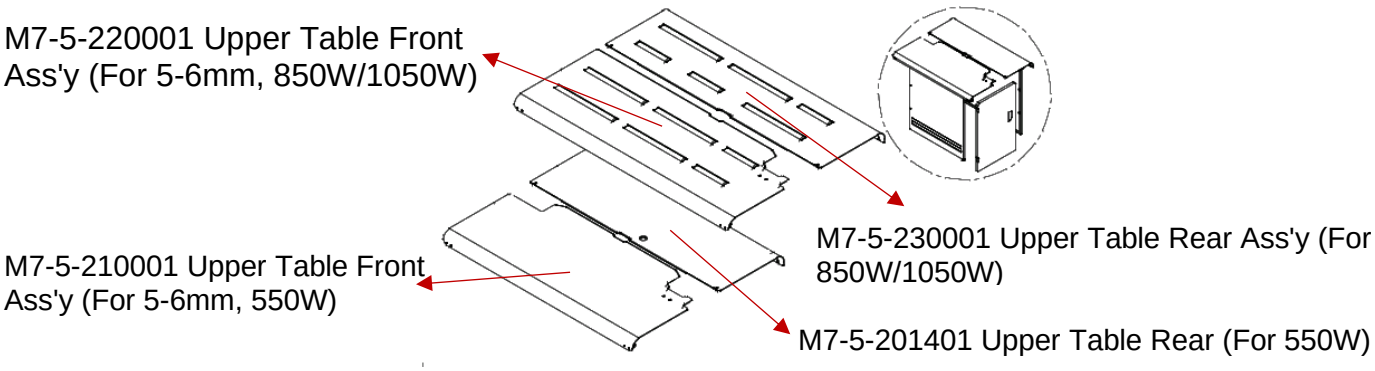
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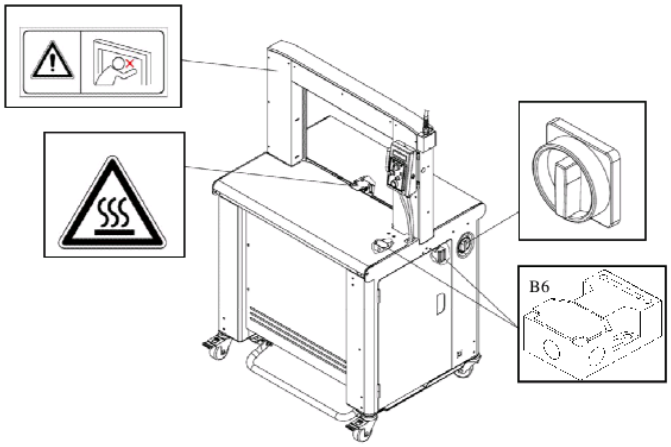
M7-1-140101 Heater Cleaning and Replacing

Cleaning:

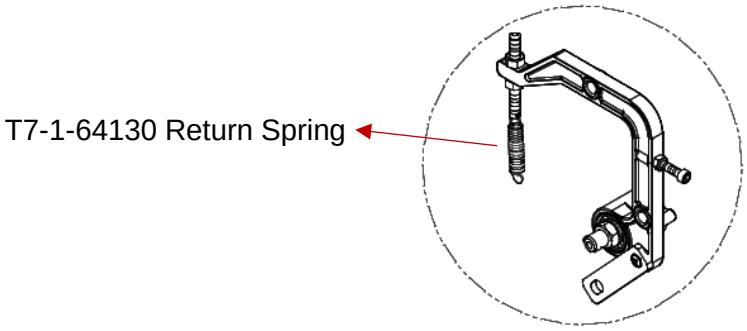
1. Turn off the power and open the Upper Table Front Ass'y and Upper Table Rear Ass'y (M7-5-210001, M7-5-220001, M7-5-201401 & M7-5-230001)



2. Let the Heater cool down to a temperature that is safe for handling.



3. Remove the Heater Cover (M7-1-101700) by loosening the fixed screws.
4. Remove the Heater Crank by first unscrewing its screw and then removing the Return Spring (T7-1-64130). Push the Heater Crank backwards to detach it.

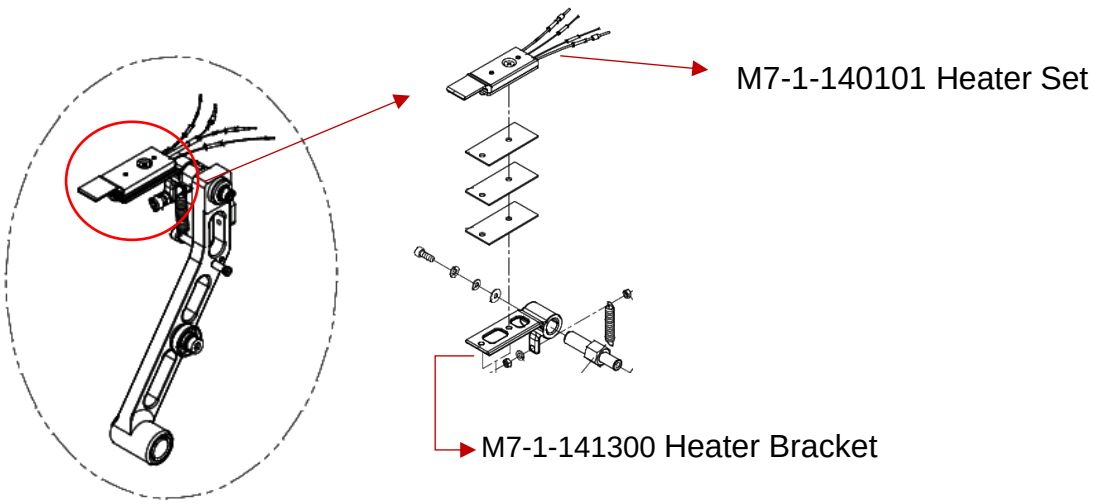


5. Clean both the top and bottom of the Heater with fine sandpaper.
6. Re-install the heater by doing the steps in reverse

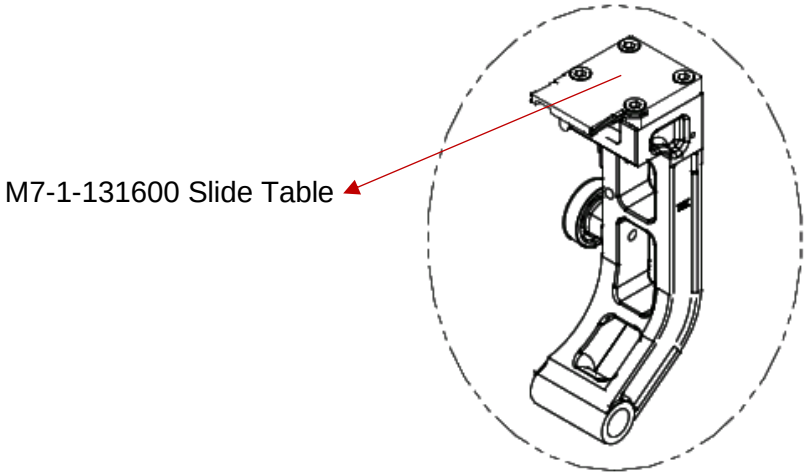
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Replacing:

1. Same sequence as step 1-4 mentioned above.
2. Turn over the Heater Bracket (M7-1-141300) so that you can loosen the nuts of the heater. After loosening the nuts, turn it back to its original position.



3. Remove the Heater Ass'y and make sure the insulations stay intact. If any of the insulation fall and get broken, replace it with a new one to avoid welding problem.
4. Install the new Heater Ass'y in reverse then rotate the M1 Handle (T7-1-11240) forward until the Heater Ass'y goes to welding position.
5. Make sure the clearance between Heater Ass'y and Slide Table (M7-1-131600) is about 1.8 - 2.2mm. If it is too big, turn HBS0530N clockwise to adjust it. If it is too small, turn HBS0530N counterclockwise.



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