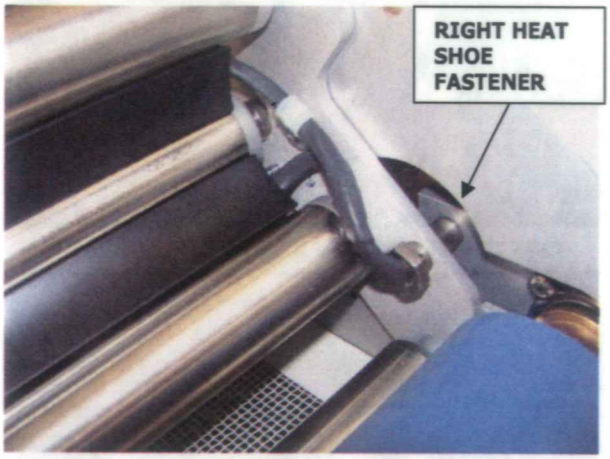
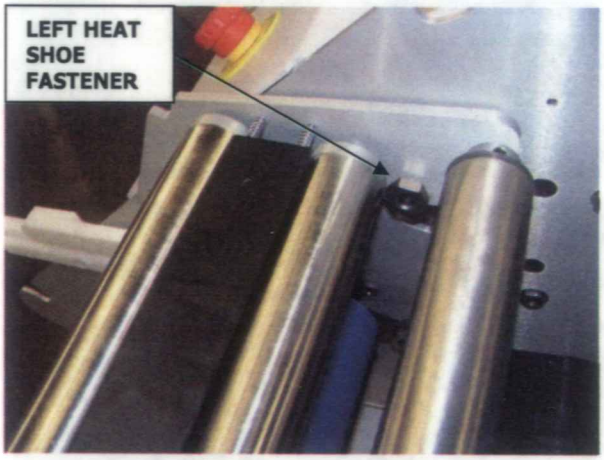
DIGITAL 42 THERMOGLIDE HEAT SHOE INSTALLATION

1) THE THERMOGLIDE HEAT SHOE ASSEMBLY IS HEAVY. THE FEED TABLE SHOULD BE REMOVED BEFORE INSTALLING THE HEAT SHOE. SLIDE A TOP HEAT SHOE FASTENER (LC38 068.4) RACK 1 UP THE THERMOGLIDE SENSOR AND HEATER WIRES, WITH THREADS OUTWARD. USING TWO PEOPLE TO HOLD THE ASSEMBLY, FROM THE FRONT, CAREFULLY INSERT THE THERMOGLIDE HEAT SHOE UNIT BETWEEN THE SIDE PANELS, ORIENTED WITH THE NYLATRONG BEARING IDLER TUBE TOWARD THE REAR.

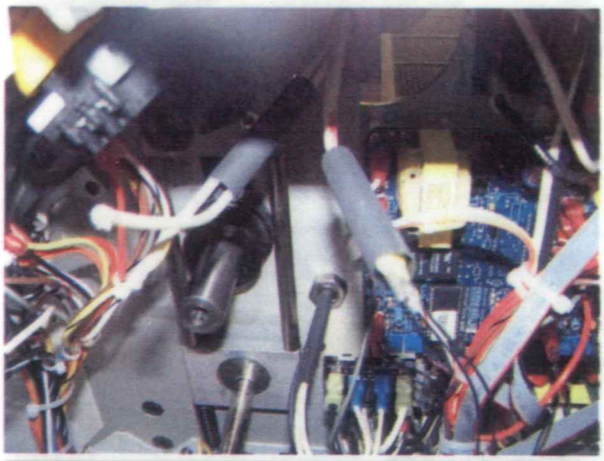


2) THE TOP HEAT SHOE FASTENERS SLIDE THROUGH THE REAR RIGHT AND LEFT HEAT SHOE BRACKET, THROUGH THE SIDE PANEL OPENING AND THREADS INTO THE TOP FRONT CONNECTING PLATES. USE AN ADJUSTABLE WRENCH TO TIGHTEN HEAT SHOE FASTENERS.



3) AFTER BOTH HEAT SHOE FASTENERS ARE SECURE, LIFT THE THERMOGLIDE HEAT SHOE UPWARD AND LET IT REST IN THAT POSITION. ADJUST THE RIGHT SIDE HEATER AND SENSOR WIRES THROUGH THE HEAT SHOE FASTENER. THERE SHOULD BE JUST ENOUGH INSULATION TUBING TO START INTO THE HEAT SHOE FASTENER.

4) ON THE RIGHT SIDE, PAIR ONE LONGER HEATER WIRE AND ONE SHORTER HEATER WIRE TOGETHER. TRIM THE LONGER WIRE TO MATCH THE SHORTER WIRE LENGTH. PLACE ABOUT 1 ½ INCHES OF INSULATION TUBING ON EACH PAIR OF HEATER WIRES. STRIP THE ENDS, TWIST THE PAIRED WIRES TOGETHER AND CRIMP A YELLOW FIF CONNECTOR ONTO EACH PAIR. PLACE INSULATION TUBING OVER PAIRED HEATER WIRES AND CONNECTOR, HEAT SHRINK.



PAIR LONG & SHORT HEATER WIRES AND CRIMP

5) TERMINATE FEMALE HEATER WIRE ENDS ON TOP RELAY. CRIMP A RED FIF ONTO EACH OF THE SENSOR WIRES AND TERMINATE ON TOP HEAT BOARD # 10 AND #11. THE TOP HEAT BOARD IS TOWARD THE REAR.

6) LOWER THE THERMOGLIDE HEAT SHOE ASSEMBLY.

7) PLUG THE DIGITAL 42 THERMOGLIDE INTO A 60 HZ OUTLET. TEST ALL SWITCHES AND EMERGENCY STOPS.

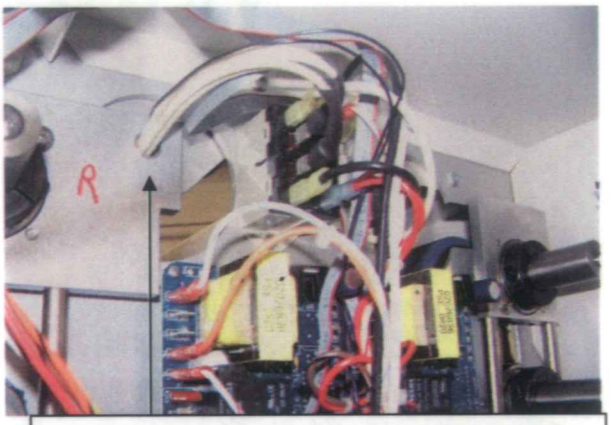
8) SET THE TOP HEAT TO 280 AND THE BOTTOM HEAT TO 240. THE THERMOGLIDE TESTS WITH A 40 DEGREE DIFFERENCE IN TOP AND BOTTOM SHOES BECAUSE THE IDLER TUBESS MUST ALSO BE HEATED.

9) HIGH POT TEST THE TERMOGLIDE.

10) LOAD FILM ON TOP AND BOTTOM SUPPLY ROAD. THE TOP FILM GOES UNDER REAR THERMOGLIDE IDLER TUBE AND OVER REMAINING IDLER TUBES. THE BOTTOM SUPPLY ROLL GOES UNDER STABILIZER BAR AND INNER IDLER TUBE.

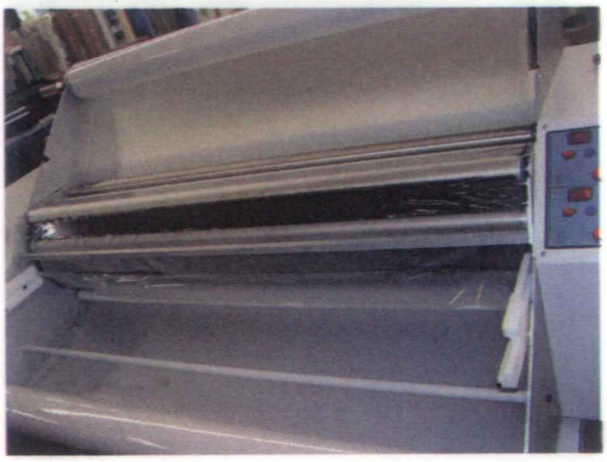
11) AFTER DESIRED HEAT IS REACHED, THE TOP AND BOTTOM FILM CAN ADHERE TO EACH OTHER. SHINY SIDE TOWARD HEAT SHOE. THREAD WITH A THREADBORD, WITH RUBBER ROLLS IN THE LOCKED POSITION.

12) BEFORE TESTING, BE CERTAIN THE THERMOGLIDE IDLER TUBES HAVE REACHED LAMINATING TEMPERATURE.



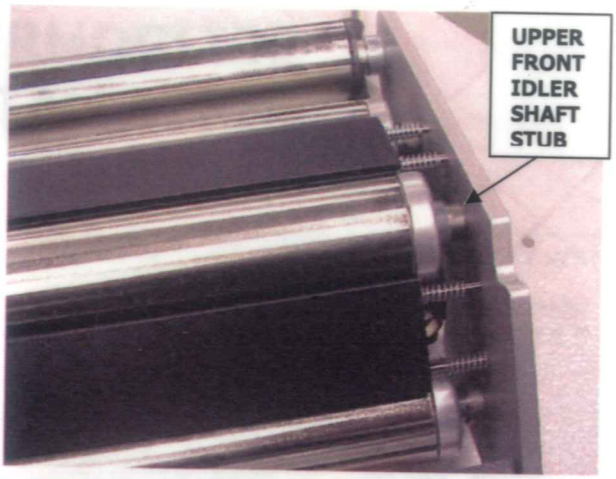
THERMOGLIDE HEATER WIRES THROUGH BOLT

LOWERED TOP HEAT SHOE & WIRES

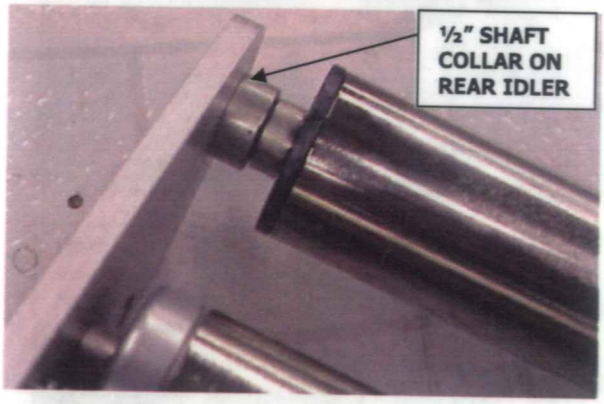


FOLLOWING IDLER TUBE ASSEMBLY PROCEDURES ARE COMPLETED, AND ALL FOUR IDLER TUBES ARE STATIONED, THE LOOSE SIDE OF THE HEATSHOE BRACKET CAN BE STRAIGHTENED AND SECURED.

13) ATTACH *FRONT AND TOP MIDDLE IDLER TUBES* TO HEATSHOE BRACKETS BY INSERTING IDLER SHAFT THROUGH BEARINGS AND ADDING A CAM SPACER (LC38 131.4) RACK 2 ON BOTH ENDS OF SHAFT BEFORE SECURING BETWEEN HEATSHOE BRACKETS. ** *WIRES FIT UNDER IDLER TUBE*. SECURE WITH 10-32 X ¾ FHSH AND LOCTITE THREADS.

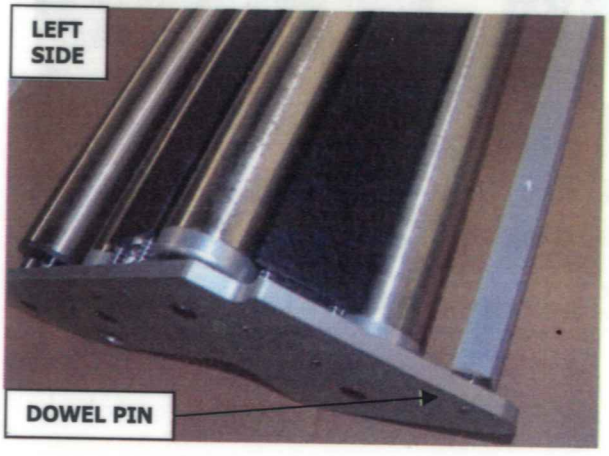


14) TAP (2) IDLER BEARINGS NYLATRON STYLE (PRB086A) AS13 ONTO ENDS OF THE REMAINING D42 THERMAL IDLER TUBE. *THIS IDLER TUBE LOCATES IN THE REAR HEATSHOE BRACKET HOLES*. INSERT AN IDLER SHAFT THROUGH NYLATRON IDLER BEARINGS. SECURE ON EACH END OF IDLER SHAFT A ½" SHAFT COLLAR (PRC096) AS07 CLOSE TO BRACKET, BUT NOT RUBBING ON IT. USE THE SET SCREWS ALREADY IN SHAFT COLLARS. THE STOP COLLARS ARE EVEN DISTANCE ON THE SHAFT. USE 10-32 X ¾ FHSH.



15) ALIGN AND TIGHTEN BOTH HEATSHOE BRACKETS AND LOOSE SCREWS ON THE HEATSHOE BRACKET.

16) FROM UNDERSIDE, ADJUST FRONT HEATER/SENSOR WIRES SO THEY ARE NOT TOUCHING EITHER HEATSHOE SEGMENT AND SECURE TO RIGHT HEATSHOE BRACKET USING A CABLE CLIP CATAMOUNT (PRC080) AS01 AROUND 2 ½" OF ½" INSULATION TUBING (PRI163) UNIT. ADD A #8 STAR WASHER TO AN 8-32 X 3/8 TH AND FASTEN.



7) TEST HEATSHOE BOLTS IN BRACKET OPENINGS TO BE CERTAIN BOLT FITS IN BRACKET HOLE. IT IS EASIER TO REMOVE BURRS OR EXCESS PLATING AT THIS TIME.

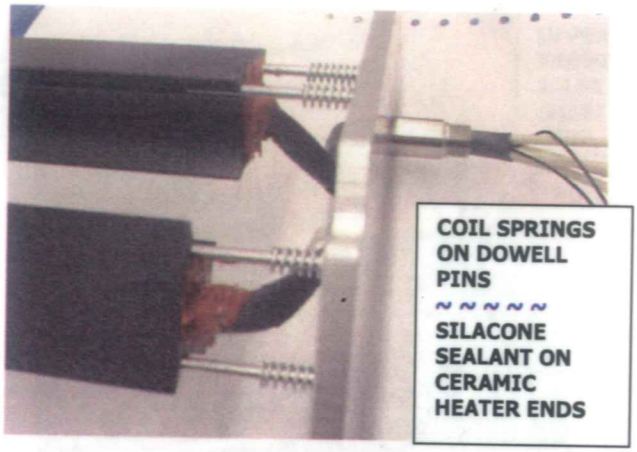
8) PLACE A COIL SPRING (PRS240) RACK 2 ON EACH OF THE (4) RIGHT HEATSHOE BRACKET DOWEL PINS. ALIGN DOWEL PINS ON RIGHT SIDE HEATSHOE BRACKETS, WITH FLAT SIDE OUTWARD ON FRONT AND BACK HEATSHOES. TAP DOWEL PINS INTO HEATSHOE CHANNELS UNTIL COIL SPRING FITS LOOSELY. THIS WILL BE TIGHTENED WHEN THE IDLERS ARE ADDED.

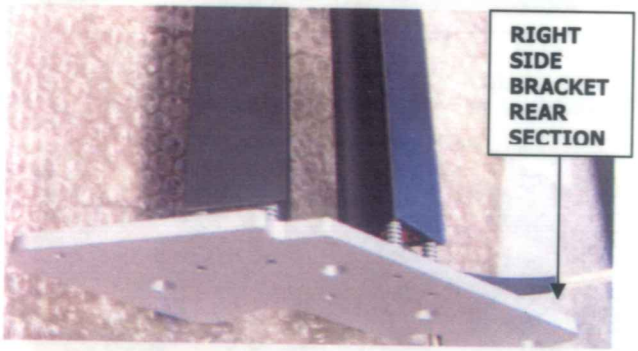
9) PLACE A COIL SPRING ON EACH DOWEL PIN ON THE LEFT HEATSHOE BRACKET AND TAP INTO CHANNELS ON LEFT SIDE OF HEATSHOES UNTIL SPRINGS LOOSELY TOUCH BRACKET AND SHOES.

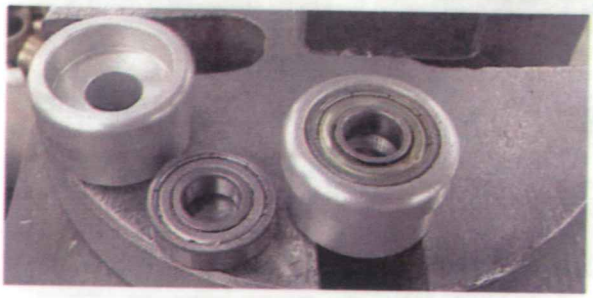
10) ARBOR PRESS (6) BALL BEARINGS (PRB083) RACK 16 INTO RECESS OF (6) BEARING SUPPORTS (D105 304.4) RACK 10.

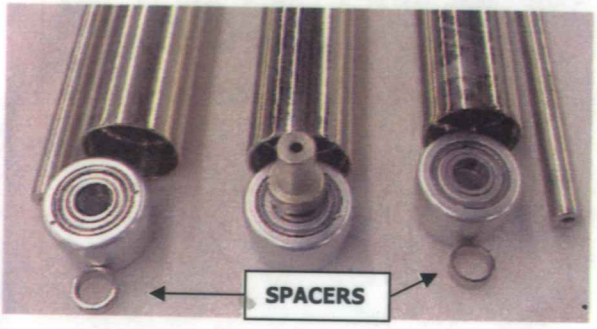
11) TEST PLATING ON BOTH ENDS OF (2) D42 HEATSHOE IDLER SHAFT (D105 305.4) D105-01 FLOOR BY INSERTING THEM INTO BALL BEARINGS IN BEARING SUPPORTS. SHAFTS MAY NEED PLATING TRIMMED. TAP THE RECESSED SIDES OF (6) BALL BEARING UNITS INTO ENDS OF (3) D42 THERMAL IDLER TUBES (D105 303.4) D105-01 FLOOR. THE FOURTH SHAFT USES (2) NYLATRON IDLER BEARINGS (PRB086A) AS13.

12) ATTACH *UPPER FRONT IDLER TUBE TO HEATSHOE BRACKETS FIRST.* PREPARE THIS IDLER TUBE BY INSERTING AN IDLER SHAFT STUB (D105 306.4) RACK 1 INTO BEARING SUPPORT ON BOTH ENDS OF THE IDLER TUBE. SECURE TO HEATSHOE BRACKET WITH A 10-32 X ¾ FHSH SCREW ON ONE SIDE USING LOCTITE ON THREADS. USE TOOL TO HOLD STUB, AS IT WILL SPIN AS YOU THREAD SCREW. ATTACH THE OTHER SIDE LOOSELY, THE SAME WAY USING THE SAME HARDWARE. AFTER THE



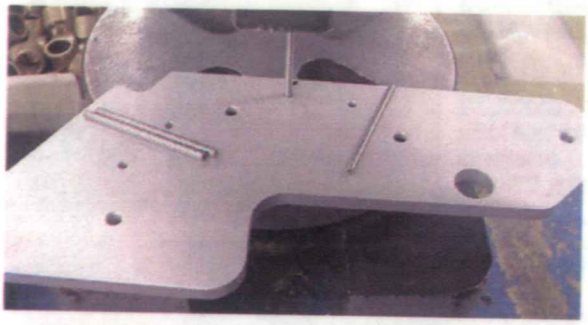




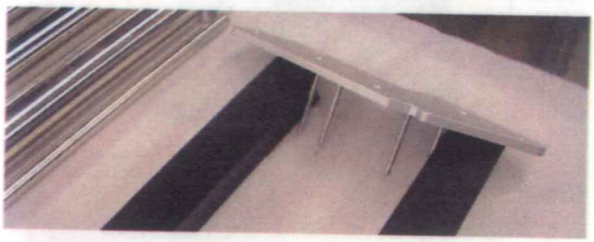


DIGITAL 42
THERMOGLIDE HEATSHOE ASSEMBLY

1) ARBOR PRESS (4) 1/8 X 2 DOWELL PINS (.125JOP32) INTO BOTH HEATSHOE BRACKET TYPE 1 (D105 309.4) RACK 2 AND HEATSHOE BRACKET TYPE 2 (D105 310.4) RACK 2 FLUSH WITH OUTSIDE WHICH IS THE COUNTERSUNK SIDE.

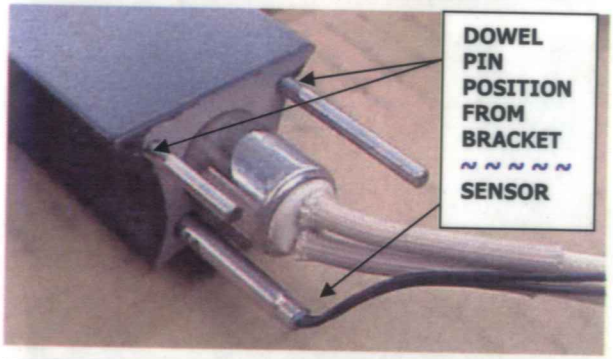


2) SET (2) D42 HEATSHOE SEGMENT W/O ENGRAVE (D105 301.4) AS22 WITH FLAT SIDE UPWARD ON CLEAN TABLE. ORIENT THE SENSOR OPENING TO THE RIGHT SIDE ON THE BOTTOM OF THE FRONT SEGMENT. ONLY ONE SENSOR IS USED PER THERMOGLIDE ASSEMBLY.



3) FROM THE RIGHT SIDE INSERT A 220V CARTRIDGE HEATER (PRH171) AS22 INTO BOTH HEAT SHOE SEGMENTS. STAKE BOTH HEATERS.

4) APPLY LOCTITE HIGH TEMPERATURE SILICONE SEALANT TO THE CERAMIC END OF HEATERS AND WHERE WIRES EXIT CERAMIC. ALLOW TO SET.



5) INSERT (1) SENSOR FOR TRAKSTAT (PRC212S) LD03 INTO FRONT HEATSHOE SEGMENT. STAKE SENSOR.

6) PLACE 2" OF BLACK INSULATION TUBING 1/8" (PRI162) CAB1 ON SENSOR WIRES AND HEAT TO SHRINK. PLACE 3 ½" OF BLACK INSULATION TUBING 3/16" (PRI164) ON HEATERS WIRES IN FRONT HEATSHOE WITH SENSOR AND SHRINK. PLACE 3" OF 3/16" INSULATION TUBING ON REAR HEATSHOE HEATER WIRES AND SHRINK. PLACE 4" OF 3/8" BLACK INSULATION TUBING OVER ENTIRE BUNDLE AND SHRINK. SHAPE BUNDLE WHILE TUBING IS STILL WARM TO ALIGN WITH HEATSHOE BRACKET OPENING. THE BUNDLE MUST NOT BE BULKY, AS IT HAS TO FIT THROUGH HEATSHOE BOLT.

UPSIDE DOWN VIEW OF THERMOGLIDE HEATSHOES ON RIGHT SIDE BRACKET