

# Model 20 Changing the Sealing Head

We will be working with parts that get hot during normal use.

**CAUTION:** Ensure the power is off, the unit is unplugged and the unit is cool.



1. Ensure the unit is cool, powered off and unplugged. Then remove the nest insert.



2. Locate the two screws that hold the nest tray from sliding out and with a flat head screw driver turn them back far enough to allow the tray to slide completely out.



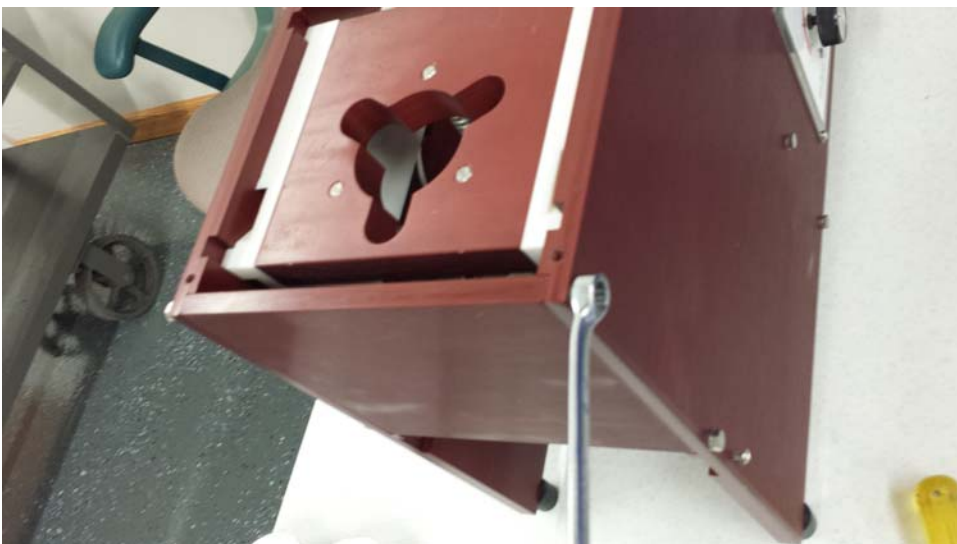
3. Remove the Nest Insert.



4. Remove the 6 screws that hold the top cover down.



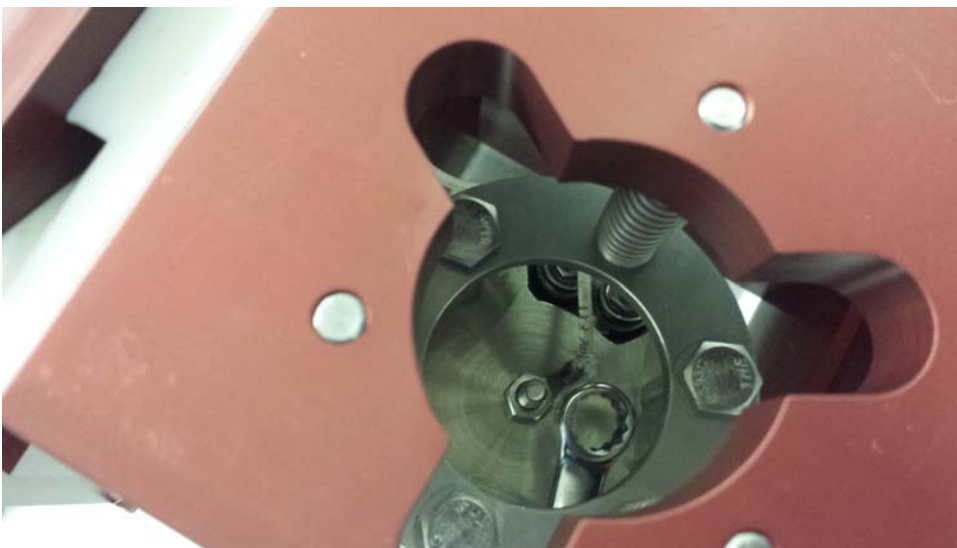
5. Remove the top cover.



6. With a 5/16 wrench remove the four bolts that hold the front cover on.



7. Remove the front cover.

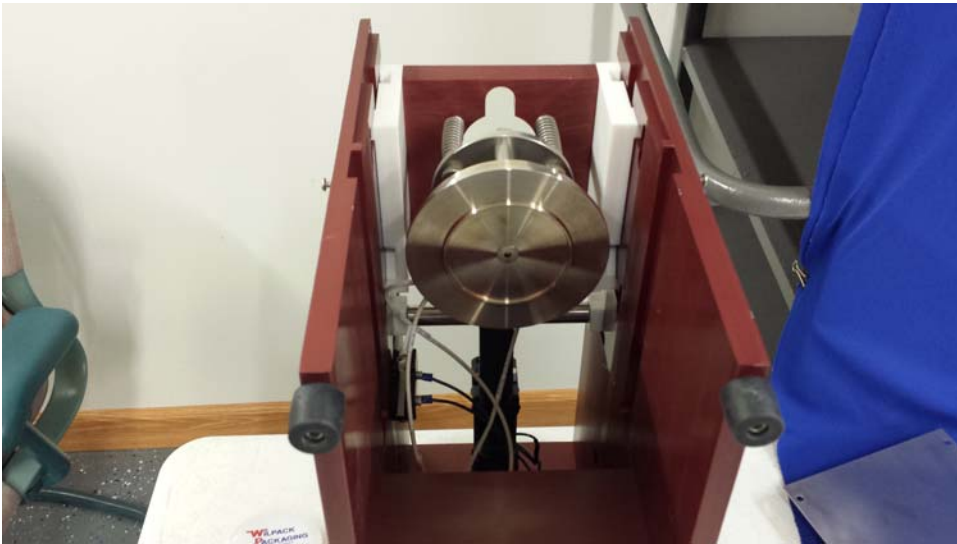


8. Using a 7/16 wrench remove the hex nut on the top of the heater head. There is a ground wire going to the center of the heater head plate underneath that hex nut. You may also try this with a ratchet wrench and an extension.



9. Remove the ground wire.





10. Now turn the unit on its back. This gives you access to the bottom side of the sealing head.

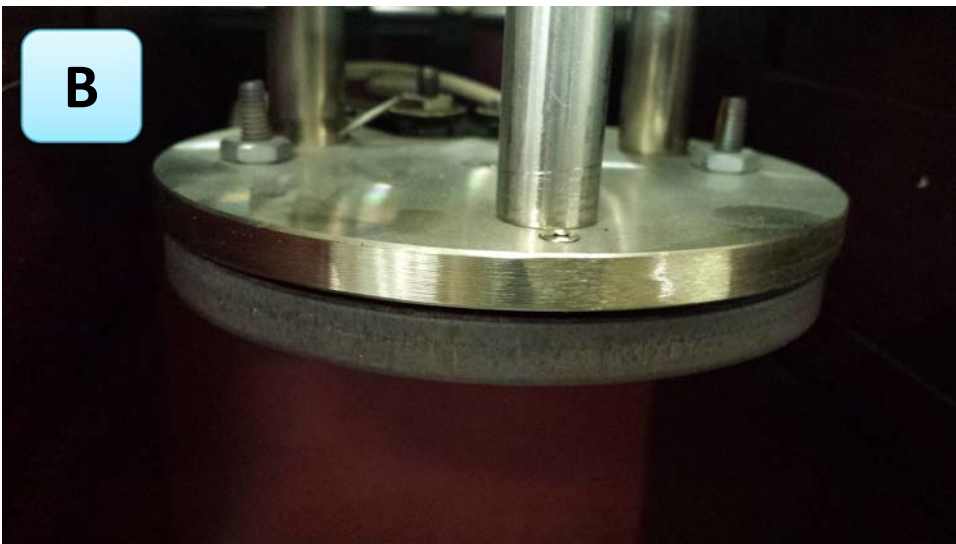
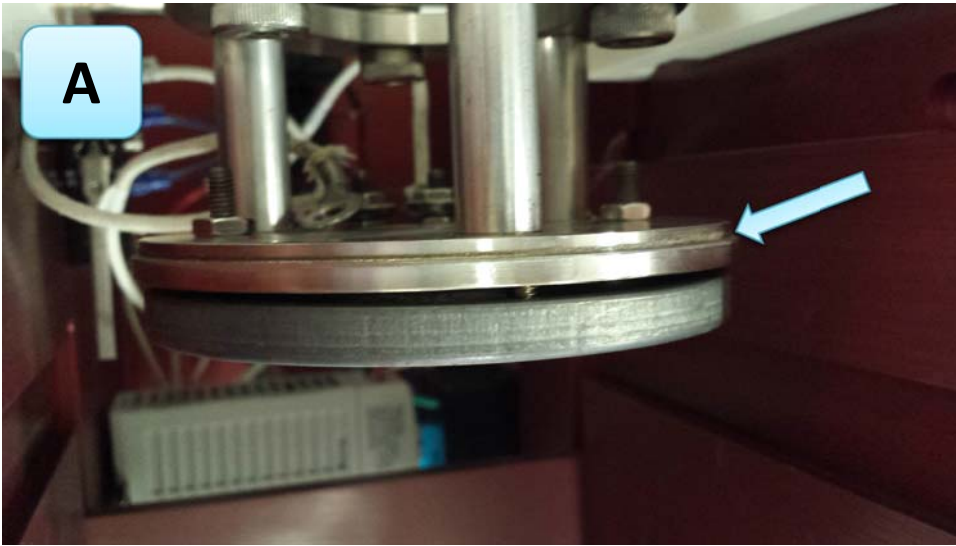


11. Use a 5/32 hex wrench or hex key to remove the bolt in the center of the sealing head.

**DO NOT REMOVE THIS UNTIL AFTER YOU HAVE REMOVED THE HEX NUT ABOVE THE HEATER SEAL PLATE IN STEP 8.**



12. Remove the sealing head from the heater head plate.



If you do not need to flip the heater head plate up-side down replace everything in the reverse order.

12. Now look to see if the heater head plate looks like either of two Figures to the left. Note the step in the top picture. This step could be in the up position or the down position.

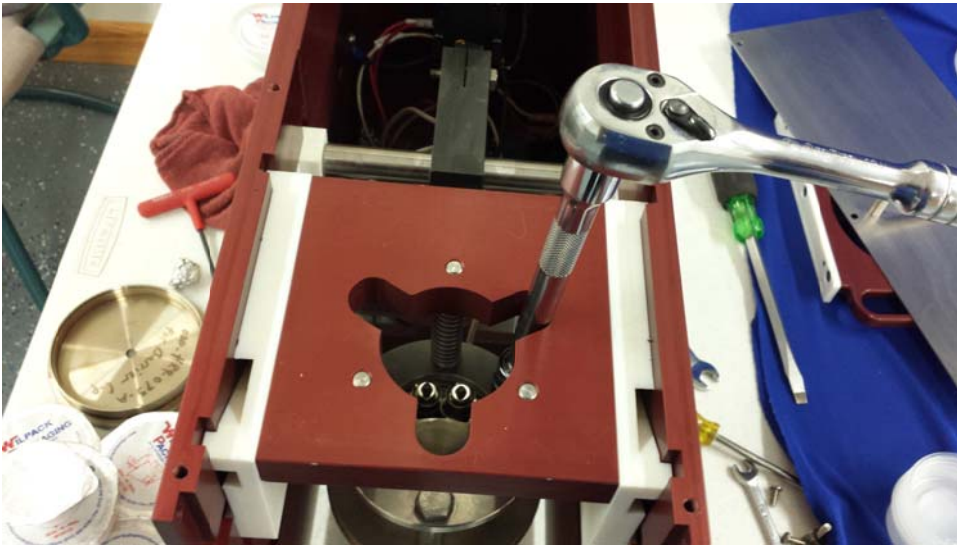
Note the two sealing heads below. One has the step and one does not.



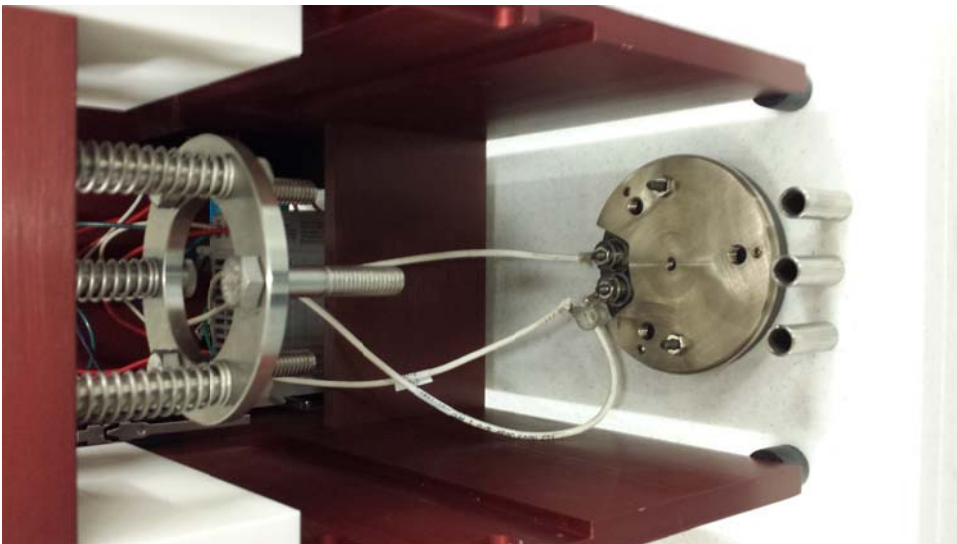
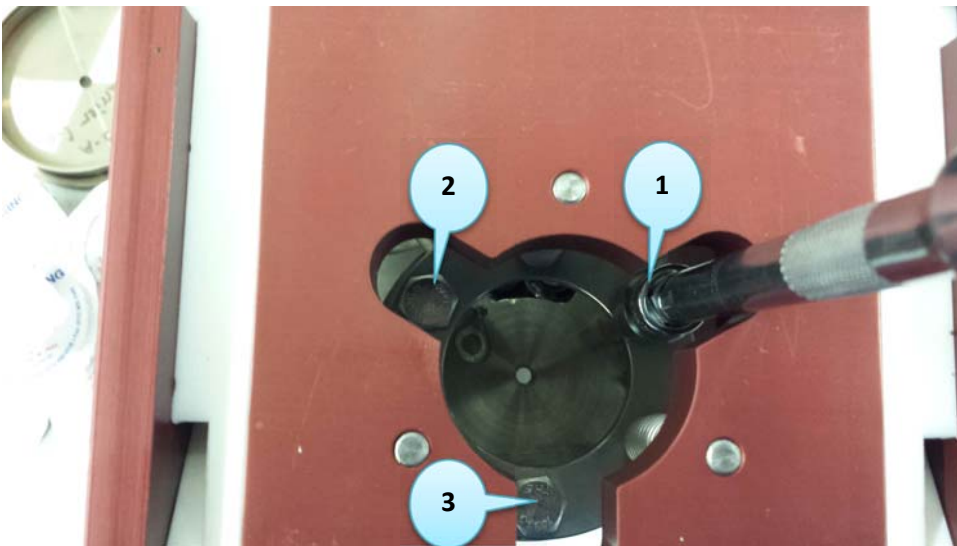
12a. If yours has the step then it works with either figure A or figure B.

Replace the heater reverse of the previous instructions.

12b. If yours does not have the step then it will only work with figure A and the heater head plate needs to be removed and flipped up-side-down. See continued Instructions



13. Using a 9/16 ratchet wrench remove the 3 bolts holding the heater head plate.



14. With the three bolts removed the heater head should come loose. Lay it down and set aside the three spacers that come loose as well.





15. Using a 3/8 wrench remove the two hex nuts holding the heating element to the heater head plate.

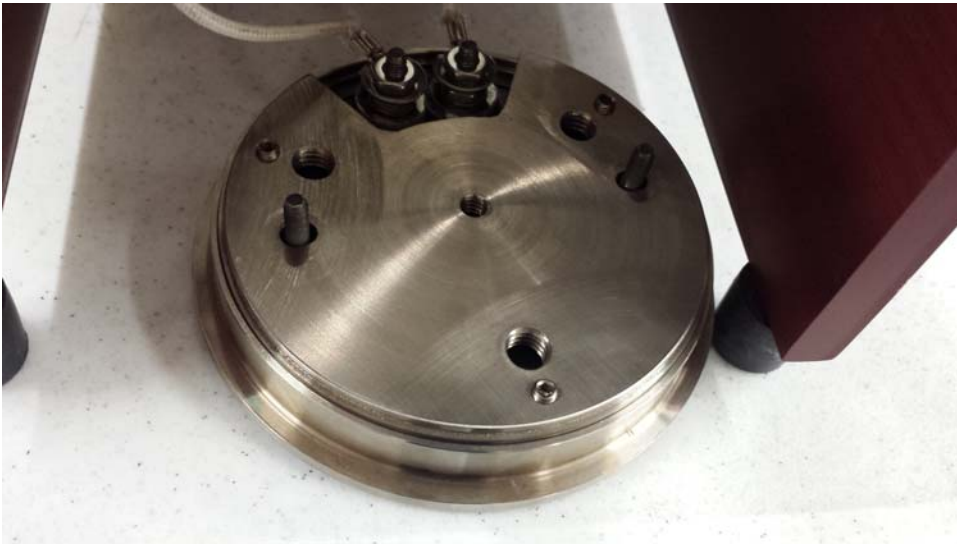


16. Remove the plate and locate the three set screws.



17. Flip the heater head plate over the put the set screws in the from the opposite side.

**IMPORTANT:** Do not screw the set screws all the way down yet.



18. Now plate the heat seal head onto the heater head plate, with the heating element between the two. Make sure the heater head plate is seated level into the heat seal head.



19. Now put the flat head bolt through the bottom. This will help ensure everything is aligned properly. Tighten down properly. This will sandwich the heating element between to heat seal head and the heater head plate.



20. Now you may turn the set screws through until they stop. This ensures that the heating element is pushed against the heat seal head for maximum heat transfer.





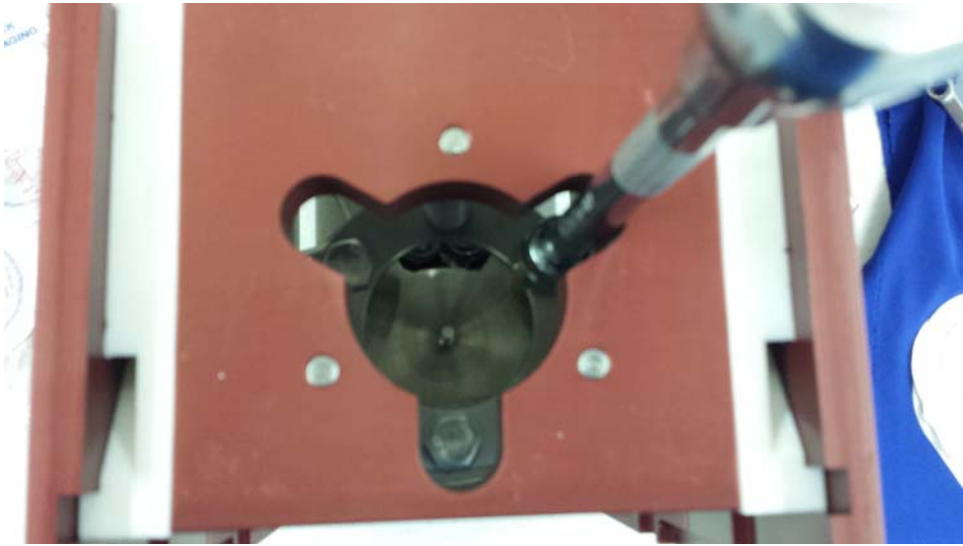
21. Now replace the two hex head nuts to the two prongs of the heating element to lock it in place.



22. Place the three spacers on the heater head plate directly over their respective socket.



23. Carefully raise the heater head assembly so that the spacers cover their three respective bolts. Manually turn the bolts to start them.



24. Tighten all three the bolts from the top.



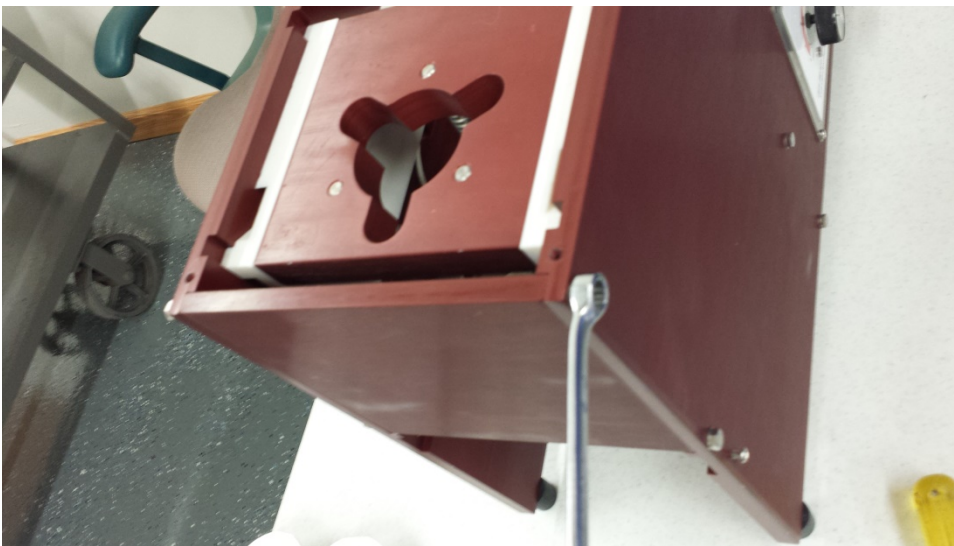
25. Replace the ground wire to the center bolt.



26. Replace the hex head nut to hold the ground wire down to the heater head plate.



27. Replace the front cover.



28. With a 5/16 wrench replace the four bolts that hold the front cover on.



29. Replace the top cover.

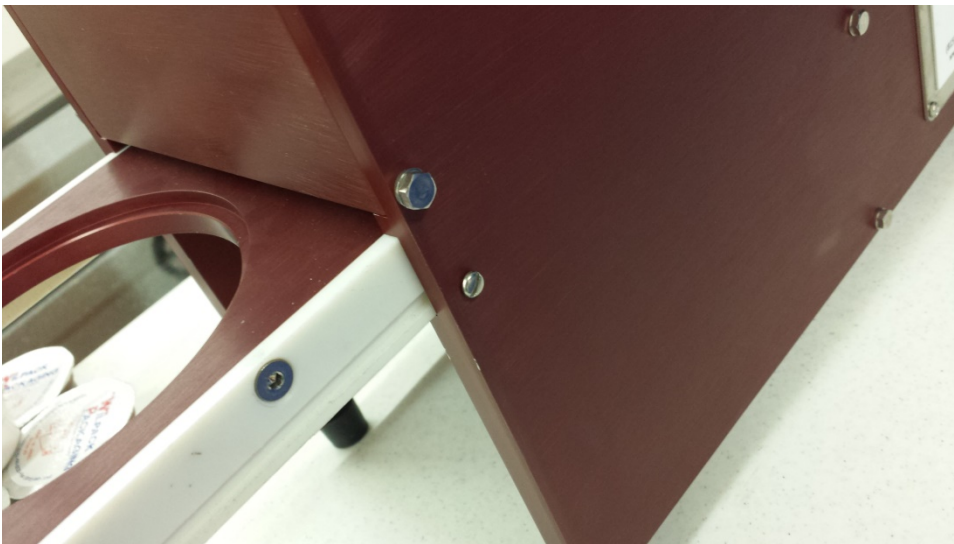




30. Replace the 6 screws that hold the top cover down.



31. Replace the Nest Insert.



32. Turn the two screws on the side back in so that the nest tray will not slide all the way out.



33. Replace the nest insert.