

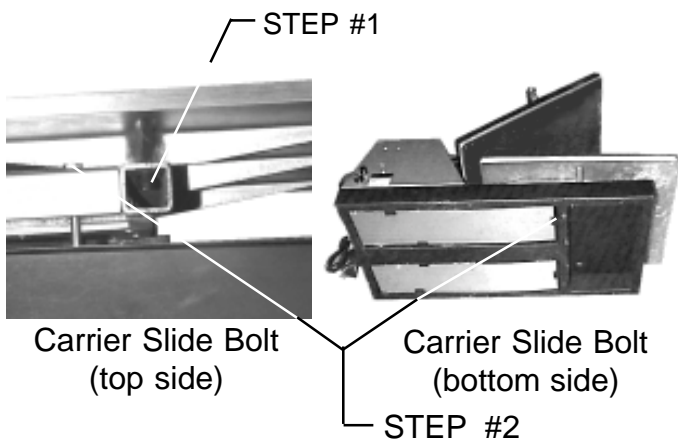
## N-600/800 Diaphragm Rubber Replacement

### Required Tools

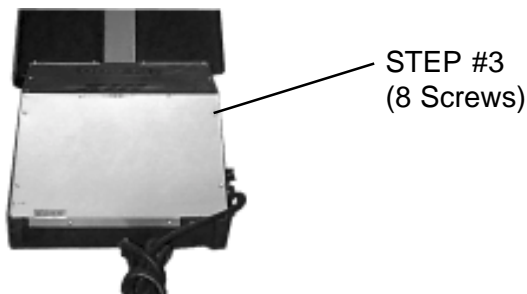
1. Phillips Screwdriver (Size #1)
2. Phillips Screwdriver (Size #2)
3. 9/16" Open End Wrench
4. 9/16" Socket
5. 7/16" Open End Wrench
6. 7/16" Deep Socket
7. Standard Screwdriver (1/4" tip)
8. Weatherstrip Adhesive (3M #08001 or equivalent)
9. Ice pick or similar
10. Replacement Rubber (available from Hix #39693)
11. 1/4" Allen Wrench

**Symptom-** Audible Air leak in carrier diaphragm when machine operates or the bottom platen doesn't rise properly.

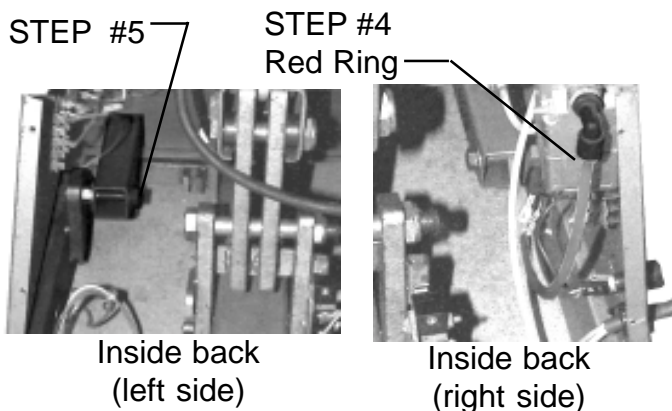
**WARNING: BEFORE MAKING REPAIRS, BE SURE ON/OFF SWITCH IS OFF AND MACHINE IS UNPLUGGED AND AIR IS DISCONNECTED!**



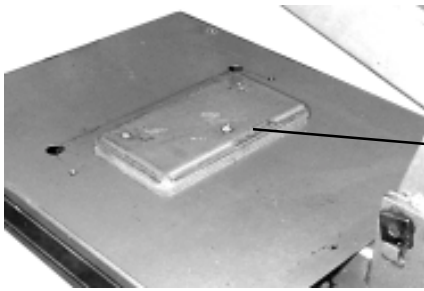
1. Using 1/4" Allen Wrench remove Platen by removing the bolts inside the tube indicated (one bolt on each side). Set Platen aside until repair is complete.  
**Note: (N-600 only)** remove side brackets
2. Gently tip machine on side, notice (2) two access holes for the carrier slide bolts. Using a 7/16" Deep Socket and a 7/16" Open end wrench remove these two bolts.



3. Remove back cover of machine with size #1 phillips head screwdriver.
4. Gently slide red ring up toward solenoid valve elbow, pull down on nylon tube while holding red ring up. This will disconnect the air line from the valve.

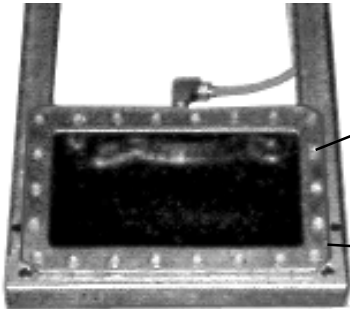


5. Using a 9/16" Socket wrench and a 9/16" open end wrench remove carrier bolt as indicated on both the left and the right side.
6. Now the entire Carrier Assembly can be pulled straight out from the front of the machine.



STEP #7  
(3 Screws)

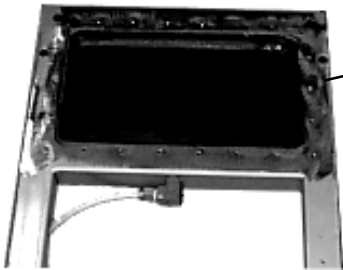
Reaction Pad  
(with head raised and lower platen and carrier assembly removed)



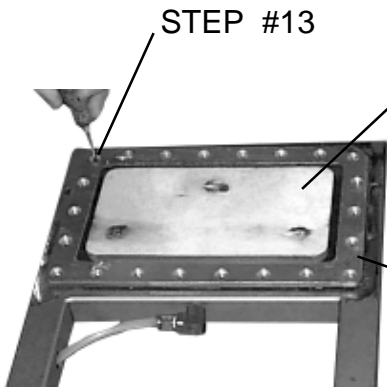
STEP #8  
(22 Screws)

Casting Ring

Carrier Assembly  
(Turned bottom-up)



STEP #9  
and  
STEP #10



STEP #13

STEP #12  
Reaction pad  
placed up side  
down on rubber

STEP #11  
Casting Ring

7. Remove Reaction Pad with Size #2 phillips head screwdriver.
8. Turn Carrier Assembly so that the casting ring side is facing up. Using a 1/4" tipped Standard screwdriver remove the casting ring.
9. With a hammer gently flatten the raised areas around the screw holes so that they are flush with the rest of the carrier. Sand off the old sealant.
10. Run a bead of Weather-strip Adhesive around the carrier assembly across all the screw holes.
11. Place Replacement Rubber on top of the sanded carrier frame so that all the mounting holes are covered with rubber. Lay the Casting ring on top of the rubber, sandwiching the rubber between the carrier and the casting ring.
12. Place the removed reaction pad from Step #7 into the center of the rubber. Press the reaction pad into the rubber and the carrier assembly to form a depression in the rubber.
13. Using a Ice pick or similar object, locate one of the corner screw holes to align the casting ring with the carrier assembly. Remove the ice pick and start one screw through this hole. **DO NOT** tighten this screw completely yet. Next locate the hole diagonal from the first using the same method. Start a screw through this second aligned hole. Next install the other screws and tighten them in steps around the ring just until the head of the screw is below the casting ring.  
**DO NOT OVERTIGHTEN THESE SCREWS!**
14. Trim off excess rubber outside the casting ring. Reinstall the Reaction Pad on the machine. Wipe some vasoline or light grease on the reaction pad. Reinstall carrier assembly onto machine and check for leaks.