

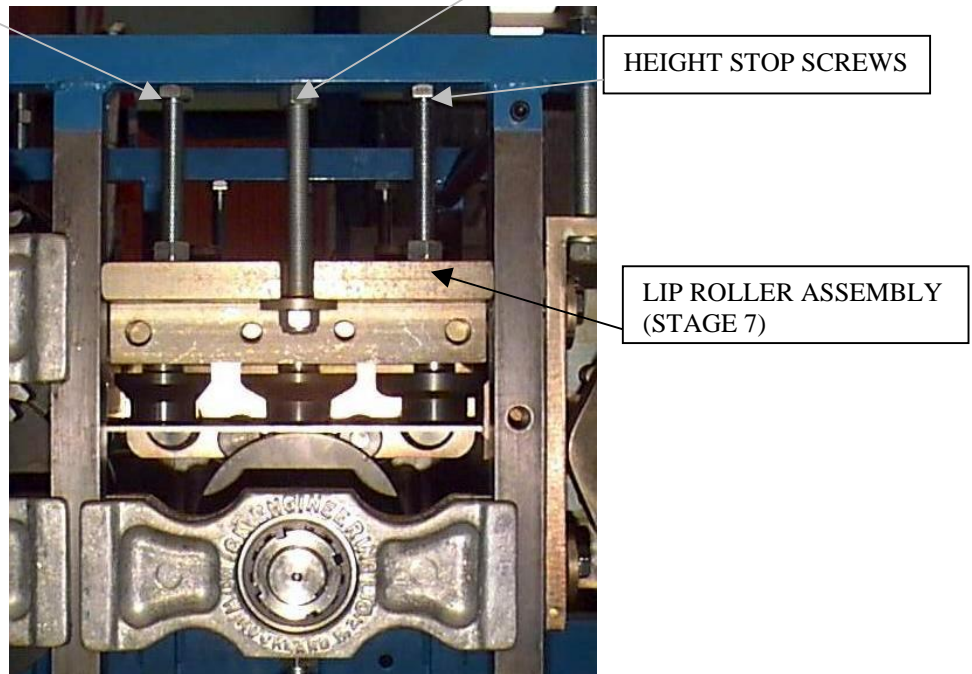
## Removal and Replacement of Lip Roller Assembly

### Replacement of roller mounting plates

1/ Remove the height adjustment screws and wind the 4 height stop screws all the way in

HEIGHT STOP SCREWS

HEIGHT ADJUSTMENT SCREWS



2/ Remove the locking tabs nuts and bearing blocks from the stage 6 top roller. Leave the top roller in the machine but roll it towards the infeed end of the machine to create more room to work.

3/ Using 2 people lift the lip rolling unit up about 1 ½” and then tilt on an angle to expose the hydraulic hose and fittings. Remove the hose and tilt in the opposite direction to remove the other side.

4/ Again using 2 people tilt the assembly as in step 3 and lift it up and out of the machine

5/ Wind out height stop screws and place the unit on a bench upside down as in the illustration. Remove the front guide plate

6/ Fasten the two clamps as in the picture on either side to prevent the plates from springing off when you remove the bolts.

7/ Remove the bolts only on one side

8/ Release the clamps evenly on both sides until there isn't any tension

9/ Remove the bolts from the other side also any adjustment screws in the plate

10/ Remove with circlip pliers the circlips holding the rollers on taking note of which roller goes where, take off the rollers and put them on the new plates making sure that the hole for the hydraulic fitting is on the correct side.

11/ Put back together in the same order as it was taken apart using the clamps etc. Remove the hydraulic fitting from the old plates and screw firmly into the new plates in the same direction they were facing before.

12/ Fit assembly back into the machine and use a spirit level to set it up correctly at the setting height – IMPORTANT

13/ Put stage 6 Top Roller back into position and adjust down evenly onto the material once material is run through.

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