H-20 Replacing the Laminating Rolls

Take a couple pictures so you get the wires hooked up correctly and get the sprockets aligned properly.

These are the general steps

1, Remove the heaters, Unhook the heater wires, top and bottom on each side. Then remove the two screws that hold the heater retainers in. The heater Cal rods will slide right out.
2. Remove the sprockets and chains on the drive side. You can remove the front idler sprocket to loosen the chains and get them off
3. Remove the connecting plates, which is the assembly with the springs on it. Don't loosen the springs, no need to These assemblies will just slide off
4. Remove the snap rings that are on the roller shafts. The top roller will be able to be lifted out and removed through the hole in the side panel.
5. Remove the 3 screws that hold the bearing in on both sides of the lower roller. Now that roller can be lifted up and removed through the hole in the side panel.
6 Slide the new lower roller in, install the bearings and the screws that hold it in. Put the snap rings on and they will hold the roller in place
7. Install the upper roller, Don't forget the guide bushing, install the connecting plates and the snap rings.
8. Put the sprockets back on and hook the chains up
9. Before you adjust the chains put the heaters back in and hook up the wires.

The most important part is adjusting the chains. Most people get them too tight. When you run the machine you'll see the chains get slightly tighter and looser as they run. Make sure the sprockets are aligned correctly. Make sure they are all the same distance from the side panel. Then watch the chains as they run, they will get slightly tighter and looser as they run. . When they are at their tightest point, then move the idler sprockets until the chain is tight, then tighten down the idler sprocket. Same procedure with both chains... ** If you tighten the chain when it is at it's loosest point, when it gets tight the chain will be super tight. That tension will eventually shear the idler sprocket bolt. So be sure to **tighten the chain at it's tightest point**