



RETRO-FIT ROLL ADAPTER NUT CHANGE OUT

WHAT YOU WILL NEED

1. New adapter nuts.
2. Two (2) wrenches of proper size. Wrench opening needs to be between 1.0" to 1.25" for B, C, and D adapter nuts. For E and E+ adapter nuts the opening needs to be between 1.75" to 2.25".
3. Two (2) jam nuts
 - B – 5/8"-18 UNF jam nut.
Dimensions: across the flats 0.938", thickness 0.375"
 - C and D – 3/4"-16 UNF jam nut.
Dimensions: across the flats 1.25", thickness 0.438"
 - E and E+ – 1 3/8"-12 UNF jam nut.
Dimensions: across the flats 2.0", thickness 0.813"
4. Thread retaining compound, medium strength.
5. For long idler rolls you will need a total of 2 people.



3/4"-16 UNF jam nuts



1 3/8"-12 UNF jam nuts

SUMMARY OF INSTRUCTION

1. Remove one adapter nut.
2. Install both jam nuts
3. Remove second adapter nut
4. Install new adapter nut
5. Remove both jam nuts
6. Install second adapter nut
7. Verify the location of the adapter nuts.



INSTRUCTIONS

1. Remove one adapter nut.

- Beginning with a roll with 2 adapter nuts use appropriate wrench to loosen and remove one.
- Because there is thread retaining compound on the threads only 1 nut can be removed at this time.



2. Install both jam nuts.



3. Remove second adapter nut.



4. Install new adapter nut.

- Apply thread retaining compound to threads when installing the new adapter nut.



5. Remove both jam nuts.



6. Install second adapter nut.

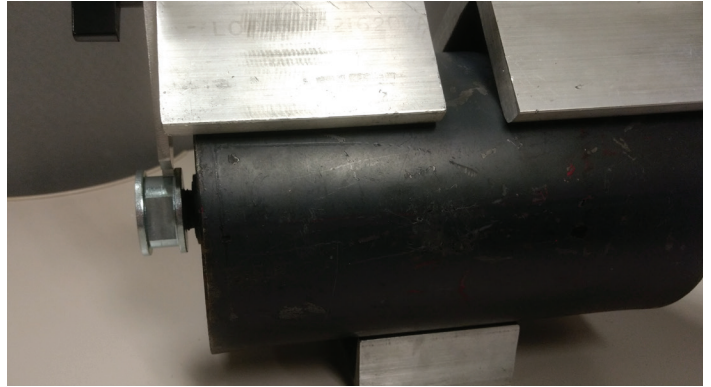
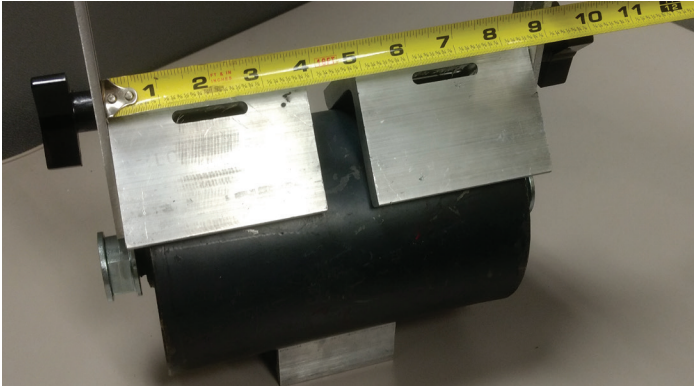
- Be sure to align the flats on the adapter nuts.
- Apply thread retaining compound to threads when installing the new adapter nut.



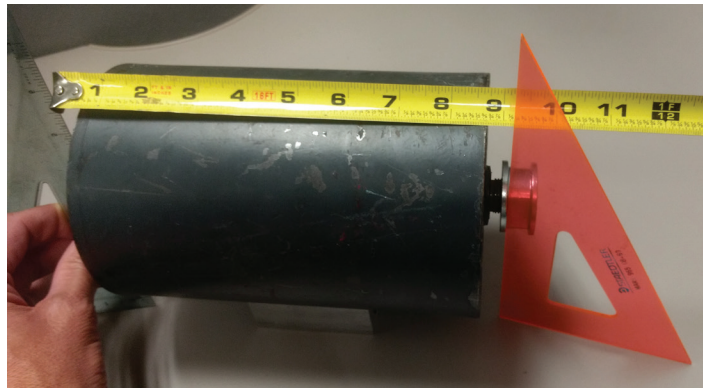
7. Verify the location of the adapter nuts.

The following pictures show two methods to verify the location of the adapter nuts.

Using the retro roll measuring kit.



Using 90° angles



Retro Roll Measuring Kit.
PPI part number RRMKIT.



CORPORATE OFFICE • P.O. Box 287 • Pella, IA 50219
800.247.1228 • 641.628.3115 • 641.628.3658 FAX