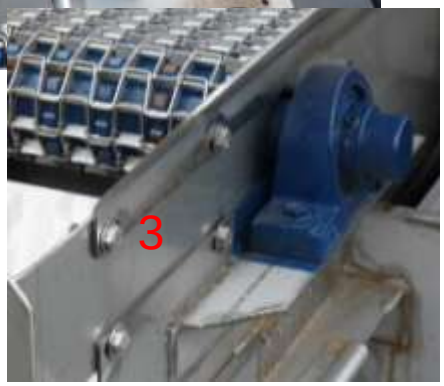
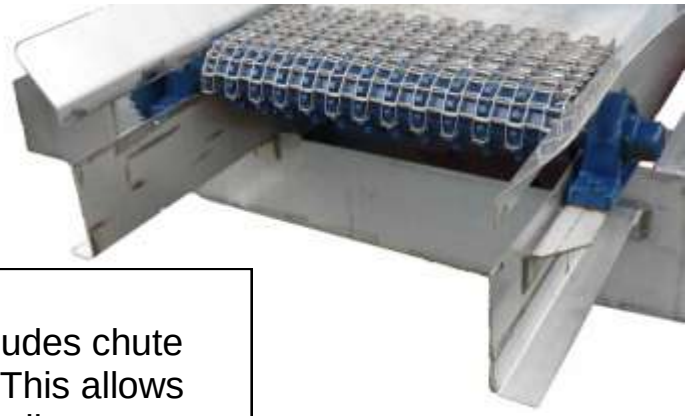
A Guide to Replacing Rear Roller

Step 1:
Using a 1” wrench, loosen nut on take-up screw. A 1” socket removes nut to allow front roller to slide all the way in toward the spreader body to remove tension from conveyor chain

Step 2:
Using 9/16” wrench, remove the bolts from gate screw brace (1). Slide brace off end of handle.



Step 3:
Using 9/16” wrench, remove the bolts (2 & 3) from side of chute .



Step 4:
Slide chute straight out (includes chute screw) and put to the side. This allows unrestricted access to rear roller.

Step 5:
Grasping ends of rear roller rotate roller so that the splice pin is visible on the rear roller.

Step 6:
Depending on the splice pin, pliers will remove nut on splice pin OR a bolt cutter will cut the welded end off splice pin. Slide pin out of chain links and remove chain.

Step 7:
Pull chain pin out. Chain can be removed from rear roller.

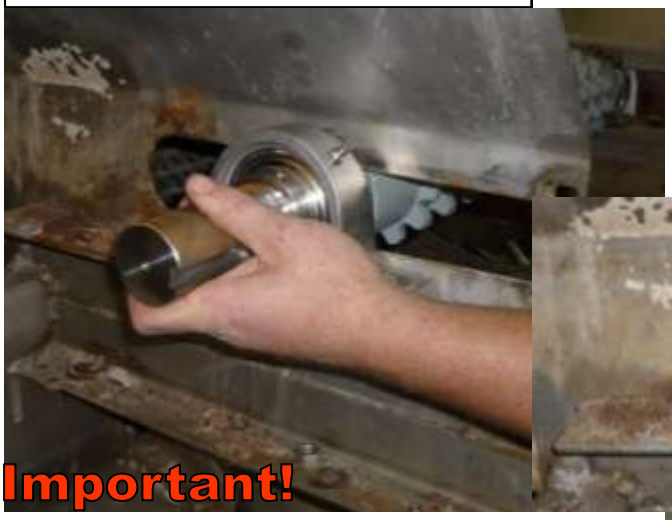
Step 8:
Using ¾" wrench, remove bolts from pillar block bearings that secure the roller. There are 4 bolt locations.

Hint! As you remove each bolt, thread the washers onto the bolt and secure with the nut. This will keep the small parts from scattering.

Step 9:
Slide roller and pillar block bearings straight off the back of the unit.

Step 10:
At this point, rear roller and/or pillar block bearings may be replaced.

Step 11:
Reverse the process by sliding roller and pillar block bearings through the chute



There is a stop welded onto the rail that indicates the correct position. Push bearing in until it fits against the stop.

- Measure from end of side runner to shaft center on each side of unit. **Must be equal**. Standard measurements 2" shaft = 1 ½" shaft =
- It is highly recommended that you use the same PB bearings used originally on the unit. Different bearings may hold the roller shaft at a different height or have a different "foot" causing the shaft location to vary.

Step 12:
Replace the bolts and washers removed in step 8

½" X 2" Screw
Flat Washer
PB Bearing
Flat Washer
Lock Washer
Nut

Tighten bolts securely.

Perform Steps 13—15 on each end of roller.

Step 13:
Using an Allen Head wrench remove the set screws from PB bearing.

Step 14:
Place a drop of LokTite on set screw and replace screw into PB bearing. The Lok-Tite will keep the screw from slipping.

Step 15:
Remove the second set screw. Using a drill with a ¼" bit, drill through set screw hole into roller shaft. Replace the set screw as shown in step 14.

Step 16:
Starting at rear roller, replace chain on sprockets. Be sure that sprocket tooth is pressing against the pin in the chain.

Step 17:
Place a block of wood under gate to apply pressure to chain after it is draped onto rear roller

Step 18:
Pulling chain under rear roller, line up ends together. Starting at the right, thread new splice pin into conveyor chain.

Step 19:
Put nut on end of splice pin. Using pliers hold pin immobile and tighten nut using wrench.

Step 20:
Trim off the end of the splice pin flush with the nut.

Step 21:
Spot welding the nut onto the splice pin will ensure the chain is securely fastened together when under load.

Important!

When welding on a truck unit, batteries MUST be disconnected. Failure to do this may "blow" any electronics installed in your truck!!

Place a ground on the truck bumper

Completely remove wiring and battery connections

Wear protective gear when welding

Completed weld

Measure both sides of unit. **Must be equal**. If roller is slanted, undue stress will damage your conveyor.

Step 22:
Push front roller into correct position. It should be 3 ½" from front roller bearing bracket to end of side runner. The lock nut should be tightened securely to prevent roller from sliding back.

Looking under front roller at properly installed bed chain

Bed chain may sag slightly to one side. This is acceptable. DO NOT attempt to pull chain straight by inserting pin at an angle into chain or slanting roller.
This will damage your conveyor!

Hint!

The process for changing out a front roller is basically the same as these instructions. On a truck unit, it is always easier to remove and replace the conveyor chain from the rear of the unit.