

INSTRUCTIONS FOR

ULTIMILL UPGRADE

BEFORE STARTING:

Kit includes the following replacement parts:

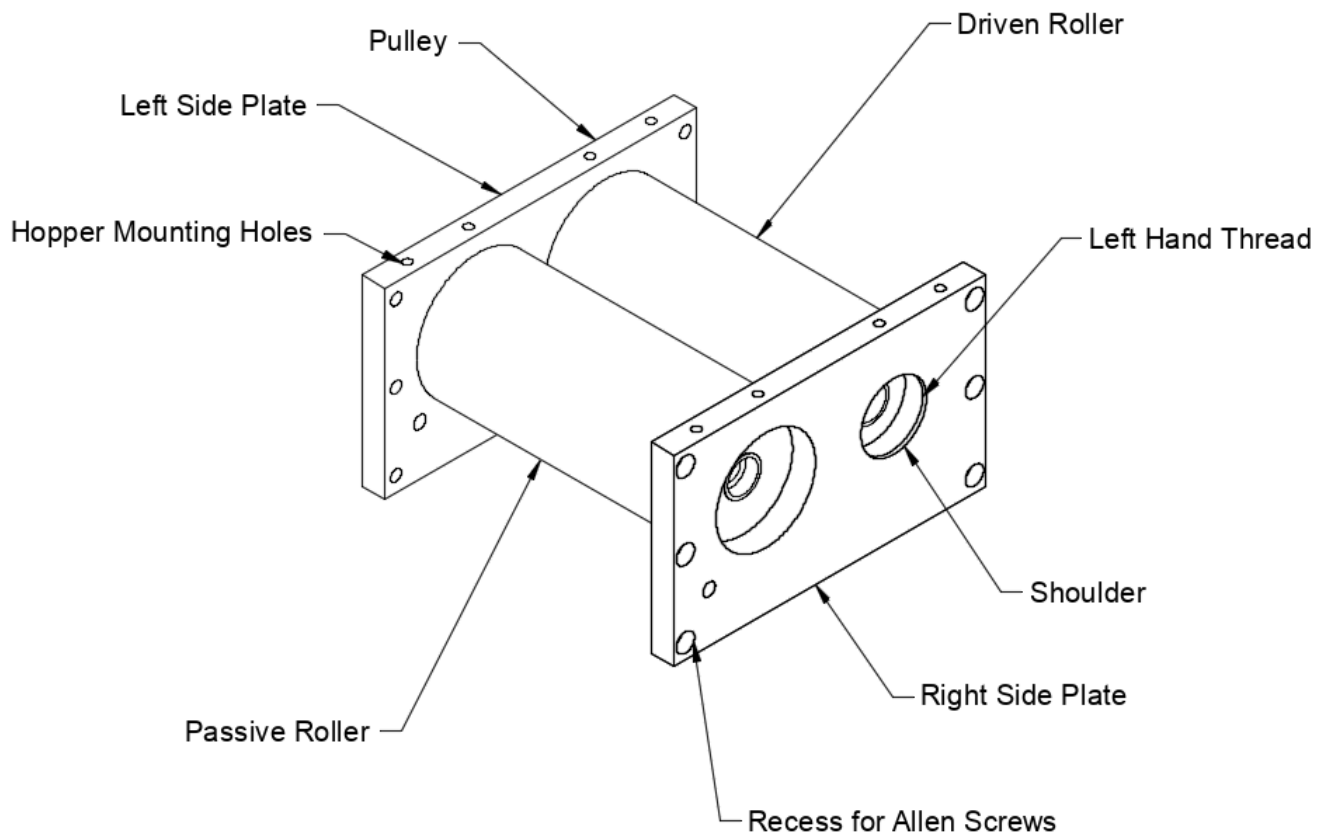
- Driven roller
- 2 Side plates (to hold roller in place)
- 2 bearings
- Pulley shaft
- Left-hand threaded roller bolt

To assist in assembly we suggest using the following tools:

- Two 7/16" open-end wrenches
- A long and short #2 Phillips screwdriver
- 1/4" nut driver
- SAE Allen wrench set

INSTRUCTIONS:

1. Unplug the mill.
2. Remove hopper.
 - a. Remove the two 1/16" bolts that hold the hopper support to the hopper.
 - b. Remove the 8 Allen bolts that hold the hopper to the mill body.
3. Remove the 9 Phillips screws and nuts that hold the belt guard and remove the belt guard.
4. Loosen the lock Allen screw and remove mill pulley and belt.
5. Remove the two 7/16" bolts holding the mill body to the stand and remove mill body.
6. Place the mill body on the bench with the hopper side up and the sticker facing you.
7. Using the diagram identify the Passive Roller, the Driven Roller, the Left Side Plate, and the Right Side plate. Also, take note of the location of the left-hand thread.
8. Remove both rollers remembering which one is passive and which one is driven. Be mindful of the left-hand thread on the right side of the driven roller.



9. Identify the left and right side plates from your kit. They are mirror images of each other. Make sure the recesses for the Allen screws are facing outward.
10. If your bearings are not preinstalled, press the bearings in for the driven roller. Make sure to only press on the outer race in order to not damage the bearing.
11. Keeping track of top, bottom, right, and left, screw the side plates to the endplates. Leaving these a half turn loose will make fitting the rollers easier.
12. Install the adjuster assemblies.
13. Examine the rollers carefully. The passive roller is being reused from your mill and has two right hand thread holes. The new driven roller has larger holes. Make sure the left-hand threaded hole is on the right side.
14. Install the passive roller.
 - a. Using a wooden wedge between the roller and the endplate will hold it still enough for proper tightening.
15. Install the driven roller making sure to use the left-hand threaded hole with the new bolt. A wooden wedge between the rollers will help with tightening.
16. Check the tightness of all fasteners.
17. Re-assemble the mill body to the stand.
18. Install the pulley and belt at the same time.
19. Check and adjust the belt tension but it should not have changed.
20. Install the belt guard.
21. Install the Hopper.