Adjuster Knob Threaded Insert Replacement

This documentation explains how to replace the threaded insert in the bead roller frame. A list of tools needed to replace the insert is also given below.

Tools Needed:

- 1/8” Allen Wrench
- 5/32” Allen Wrench
- 5/16” Allen Wrench
- 7/8” Wrench
- Flat Screw Driver
- Pliers
- Battery/ Electric Drill
- Tap Handle
- 11/16” Drill Bit
- 3/4”-16 Tap

When replacing the threaded insert in the bead roller, a bead roller threaded nut insert shown in **Figure 1** will need to be used to replace the original threaded insert.

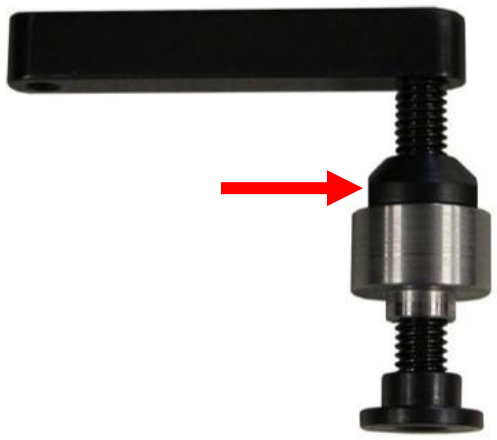

Figure 1

Replacement Procedures

1. Remove the gear guard by removing the four (4) button head cap screws shown in **Figures 2** & **3**.

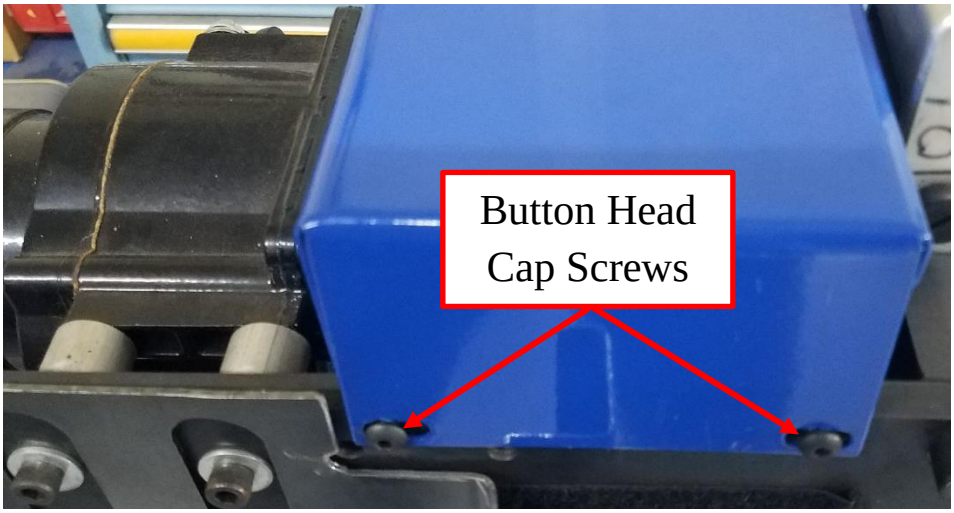

Figure 2

Figure 3

2. Remove the two (2) socket head cap screws holding the motor plate onto the bead roller frame shown in **Figure 4**. Set the motor and control box down on the ground.

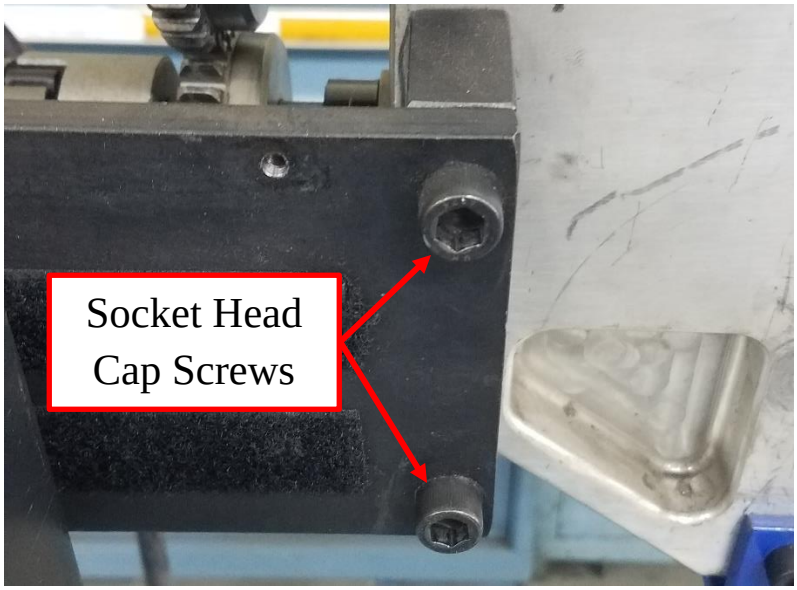

Figure 4

3. If there is a roll on the upper shaft, remove it and if the bead roller has the optional adjustable shaft as shown in **Figure 5**, loosen the set screw and slide it off the shaft.

Figure 5

4. Loosen the set screw in the set collar and slide the collar off the shaft as shown in **Figure 6**.

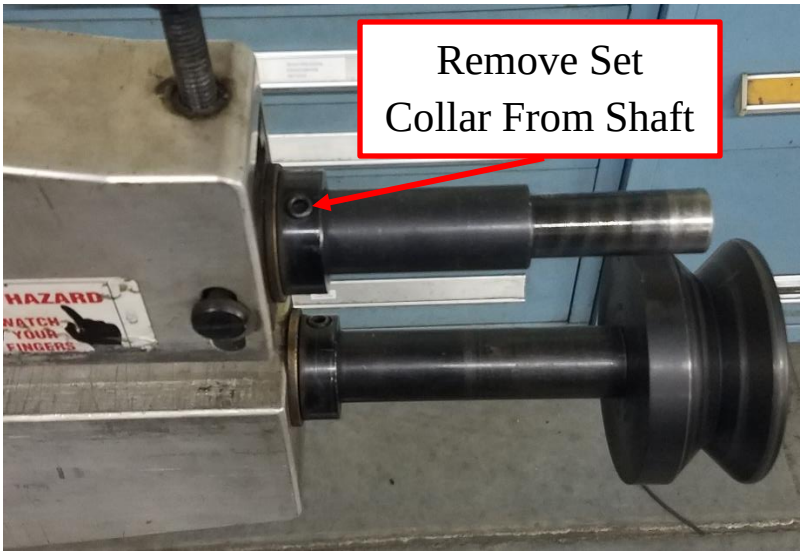

Figure 6

5. Remove the side screw that threads into the upper shaft bushing block as shown in **Figure 7**.

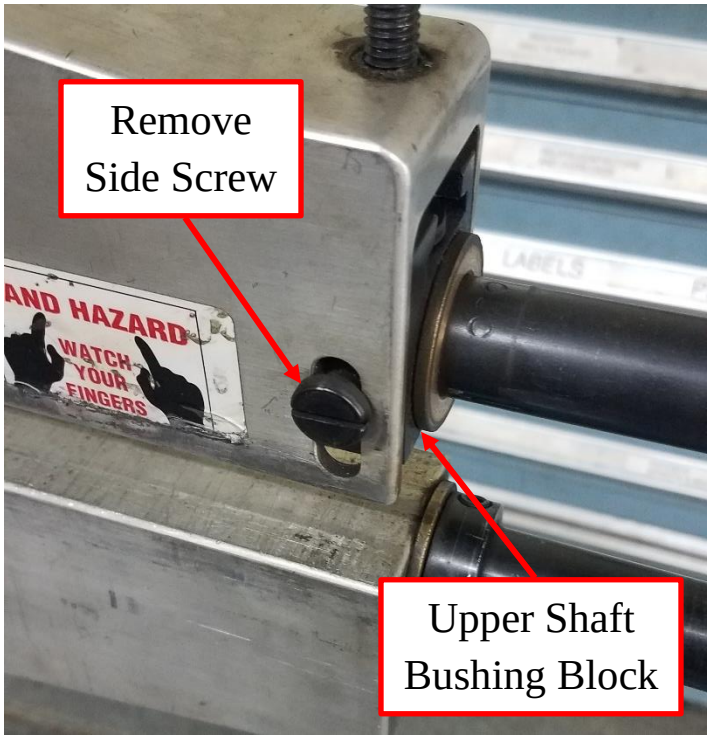

Figure 7

6. Once the side screw has been removed, the bushing block should slide out of the slot in the bead roller frame. Slide the bushing block all the way off the shaft.

7. Slide the top shaft back towards the back of the machine so that it is not sticking out of the pocket where the bushing block was just removed.

8. Once the bushing block and shaft have been removed, use tongue and groove pliers to remove the T-nut that is on the end of the threaded stud as shown in **Figure 8**. Firmly grip the pliers down on the nut to keep it from rotating and turn the adjustment knob counter clockwise and the nut should come loose from the threaded stud.

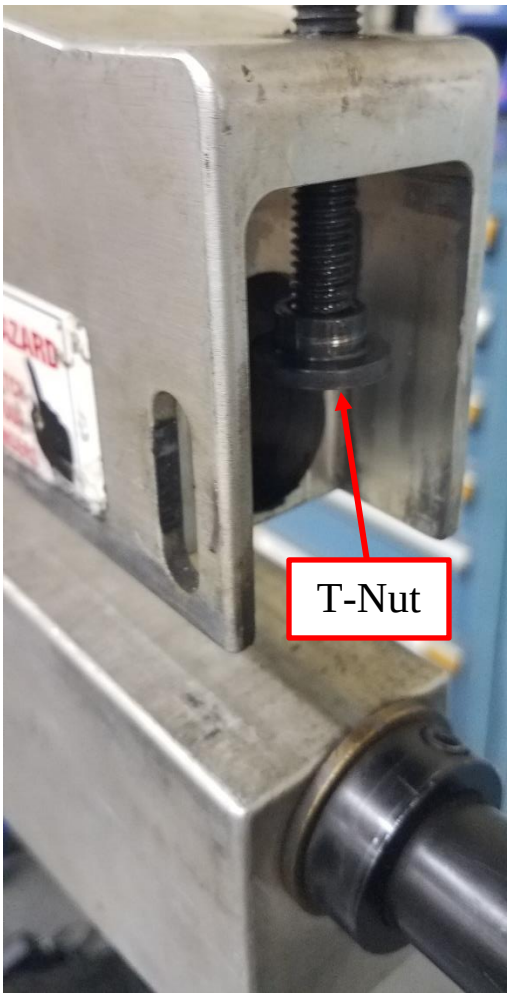

Figure 8

9. Remove the threaded stud from the threaded insert in the frame of the bead roller as shown in **Figure 9**.

Figure 9

10. Drill out the threaded insert with the 11/16” drill bit as shown in **Figure 10**. A smaller pilot drill bit may first be used to help open up the hole. If a drill press is accessible the frame can be removed from the stand and the hole drilled out using the drill press. It is critical that the hole be drilled straight up and down and not on an angle. Pay careful attention if hand drilling the hole.

Figure 10

11. Once the insert is drilled out and the hole is 11/16” in diameter, tap the hole with the 3/4”-16 tap as shown in **Figure 11**.

Figure 11

12. Once the hole has been tapped, clean up and burs or sharp edges and then insert the new threaded nut insert as shown in **Figure 12**. Tighten the insert down in the frame with a 7/8" wrench

Figure 12

13. Reinsert the treaded stud into the new threaded nut insert and put the T-nut back on the threaded stud as shown in **Figure 13**. Firmly grip the tongue and groove pliers down on the nut to keep it from rotating and turn the adjustment knob clockwise and the nut should tighten back up on the stud.

Figure 13

14. Slide the shaft back in towards the front of the machine and make sure the gears on the back side mesh up and the back set collar is up against the back bushing block. Slide the front bushing block back on the shaft and slide it back into the slot in the frame with the T-nut in the top T-slot of the bushing block as shown in **Figure 14**.

Figure 14

15. Thread the side screw back into the bushing block as shown in **Figure 15**.

Figure 15

16. Slide the set collar back on the shaft and up against the bushing block as shown in **Figure 16**. Pull the shaft towards the front of the machine and tighten the set screw to lock the set collar down on the shaft.

Figure 16

17. Slide the optional adjustable shaft back on the shaft, if necessary, as shown in **Figure 17**.

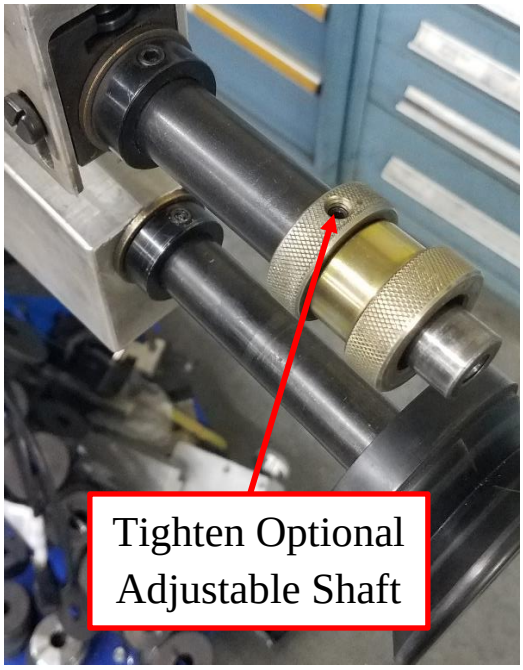

Figure 17

18. Line up the motor coupler and reinsert the two (2) socket head cap screws into the motor plate and spacer and thread them into the bead roller frame as shown in **Figure 18**. Tighten the screws back down to secure the more plate.

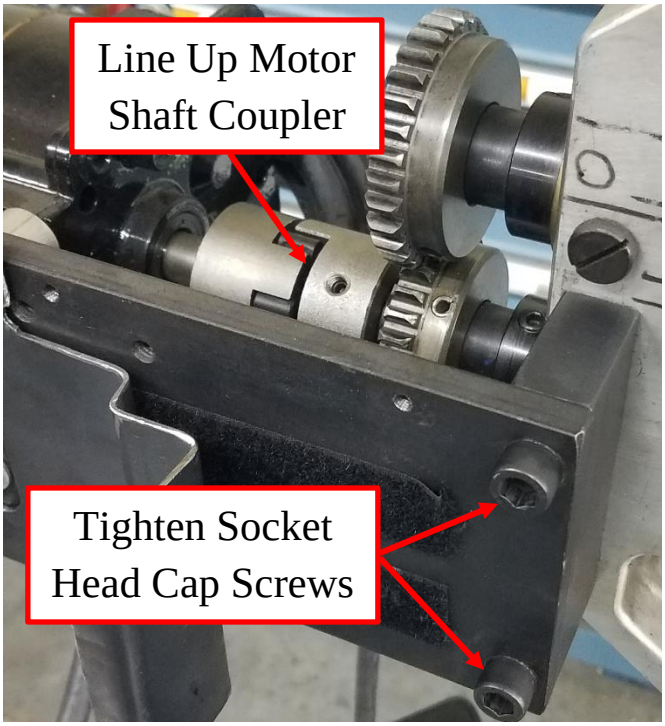

Figure 18

19. Place the gear guard back over the gears and insert the four (4) button head cap screws back into the motor plate. Tighten the screws back down to secure the guard back on the motor plate as shown in **Figure 19**.

Figure 19

This concludes the procedure for replacing the threaded insert in the bead roller frame.

Please contact Mittler Bros. Machine & Tool @ 636-745-7757 for any other questions regarding this procedure.

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