Williams & Hussey
July 15, 2020

INSTRUCTIONS FOR REPLACING FEED ROLLS

Item#: P-123, P-160, P-123-K, P-160-K, P-170-K

P-123-K, P-160-K and P-170 Kits Include:

(2)	54-16	Screw, Rest, 9/16"
(2)	P-123 or P-160	Feed Roll, Yellow or Green
(2)	P-122	Axle, Outfeed, Post Side, 1⅝"
(1)	P-124	Axle, Infeed, Open End, 3¼
(1)	P-224	Axle, Outfeed, Open End, 3¾"
(1)	P-242	Thread Locker (use on 54-15, 54-16 & P-122 parts)

P-123 or P-160 Roll Only

(1)	P-123 or P-160	Feed Roll, Yellow or Green

Tools Needed:

- Long Screw Driver
- Vise
- Hammer
- Wrench
- Safety Glasses

REMOVE INFEED SWING ARM ASSEMBLY (follow same instructions for outfeed swing arm)

1. Disconnect power source.
2. Remove the 54-3 Chip Deflector.
3. Loosen T-Handle and raise the molder head to its highest position.

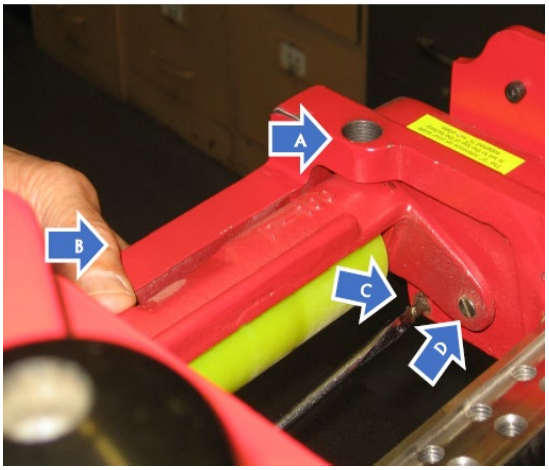
Remove Infeed Swing Arm

A. Remove (2) pressure screw assemblies

B. Lift swing arm assembly up

C. Using a flat head long screwdriver remove the 54-16 rest screw

D. Using a flat head screwdriver remove (2) 54-15 pivot screws



4. Release chain off roller sprocket, **leaving chain engaged on drive sprocket inside chain guard.**

5. Remove infeed swing arm assembly

6. Remove the P-111 sprocket off the P-124 Infeed axle by loosening the set screw, set aside.

7. Removing the axles from the swing arm. Place the roll in a vise lengthwise, vertical. The P-122 axle will be flush with the casting and in many cases tough to remove. Fit a flat head screw driver into the P-122 axle slot and give it a good whack with a hammer, this should loosen the thread locker so the axle can be removed. The P-224 axle does not have thread locker it should come out easier. If not, follow the same method as the P-122. These can be re-used if they are in good condition and not bent.

   IF the axles will not release from the threaded hole use a hack saw and cut the axles. New axles have been provided for this reason.

8. Follow the same instructions for the outfeed swing arm if you're also replacing the outfeed roll. Removing the P-122 & P-224 outfeed axles and removing the P-111 or VF-3 sprocket from the P-224 outfeed axle.

INSERT NEW ROLL TO SWING ARM (follow same instructions for outfeed roll)

Items Needed: Infeed Swing Arm, P-122 Axle, 1⅝, P-124 Axle, 3¼, P-111 or VF-3 Sprocket, Thread Locker, Vise

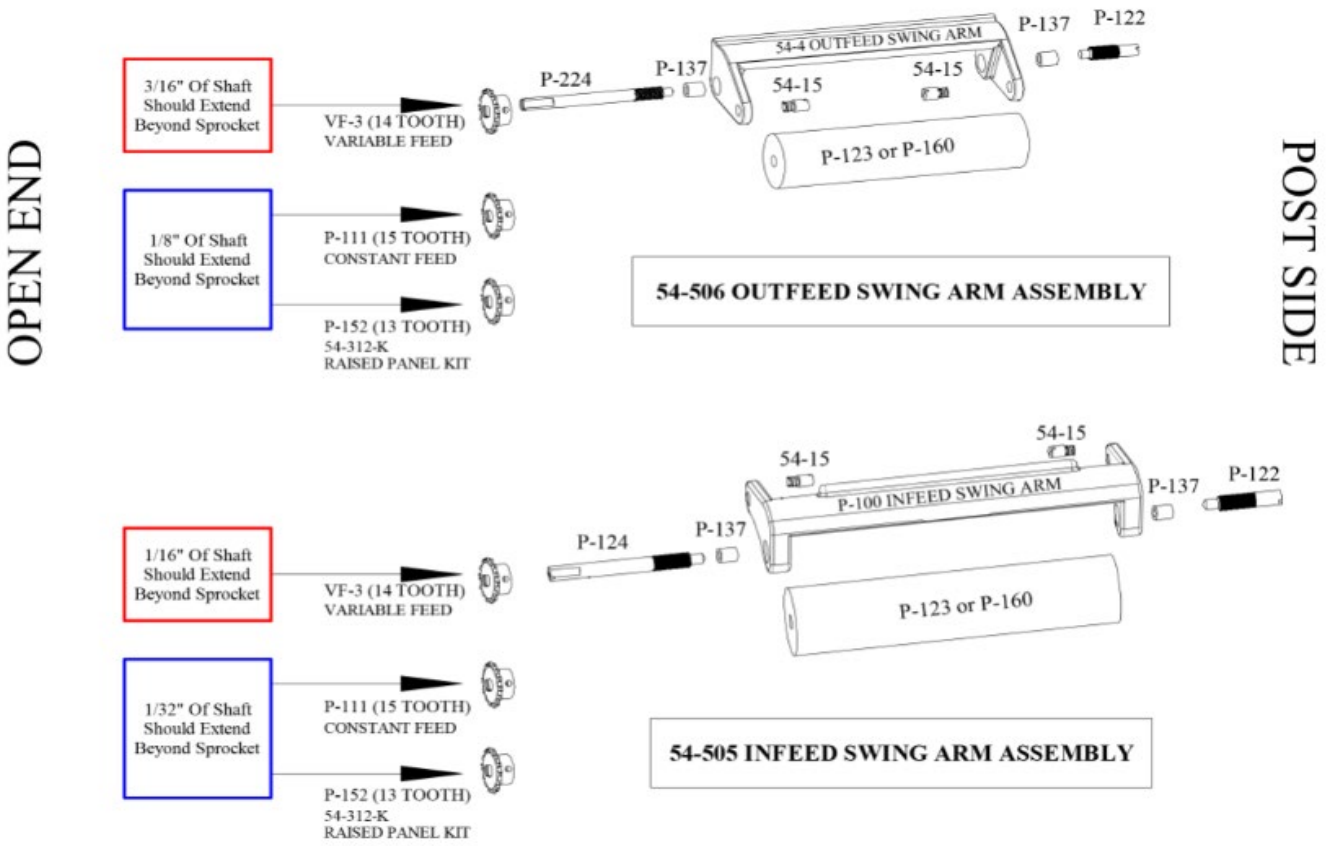
1. Very Important: Each side of the feed roll has a different threaded depth. The roll side marked in RED has ¼" depth reamed section. This is the post side. Using a drop or two of thread locker on the P-122 axle (1-⅝") insert the axle through the infeed swing arm into the roll and tighten.

2. Insert the P-124 axle (3¼") through the outfeed swing arm and into the roll, tighten.

3. Place the P-124 axle side in a vise with the flat on the shaft against one of the jaws. The roller will be standing up vertically and tighten.

4. Use a drop of thread locker on the sprocket set screw. Replace the P-111 or VF-3 sprocket on the P-124 axle, align set screw on FLAT of axle, tighten. Sprocket hub should be facing in toward the swing arm leaving a **1/32"** of the shaft exposed beyond the sprocket for P-111 or P-152 OR **1/16" for VF-3 sprockets**. See diagram on Page 3 for sprocket placement.

5. Outfeed roll – Same as Step #1 for P-122 axle, use thread locker. Step #2 use P-224 axle (3-¾). Step #3 same. Step #4 same with P-224 axle leaving **1/8"** of the shaft exposed for the P-111 or P-152 sprocket and leaving **3/16" for the VF-3 sprockets**.



W&H Part	Variable Speed Model 206, 209	11 Feet Per Minute Model 154CE 54-310-K, 11 FPM Kit	11 Feet Per Minute 54-312-K Raised Panel Kit	15 Feet Per Minute 154, Original, W7S
CHAINS	VF-4 (36 Pitch)	P-155 (30 Pitch)	P-155 (30 Pitch)	P-112 (32 Pitch)
	VF-5 (54 Pitch)	P-156 (56 Pitch)	P-156 (56 Pitch)	P-212 (58 Pitch)
FEED ROLL SPROCKETS	VF-3 (14 Tooth)	P-111 (15 Tooth)	P-152 (13 Tooth)	P-111 (15 Tooth)

INFEED ASSEMBLY			OUTFEED ASSEMBLY		
54-15	Screw, Pivot, ⅝	2	54-15	Screw, Pivot, ⅝	2
P-100	Swing Arm, Infeed	1	P-100	Swing Arm, Infeed	1
P-122	Axle, Post Axle	1	P-122	Axle, Post Axle	1
P-124	Axle, Infeed, 3-¼	1	P-124	Axle, Infeed, 3-¼	1
P-224	Axle, Outfeed, 3-¾	1	P-224	Axle, Outfeed, 3-¾	1
P-123	Feed Roll, Yellow	1	P-123	Feed Roll, Yellow	1
P-160	Feed Roll, Green	1	P-160	Feed Roll, Green	1
P-137	Bushing, Bronze, ½" OD	2	P-137	Bushing, Bronze, ½" OD	2
VF-3 (206/209)	Sprocket, 14 Tooth	1	VF-3 (206/209)	Sprocket, 14 Tooth	1
P-111 (154,154CE)	Sprocket, 15 Tooth	1	P-111 (154,154CE)	Sprocket, 15 Tooth	1

INSTALL BOTH SWING ARM ASSEMBLIES TO MOLDER HEAD

Items Needed: Infeed Swing Arm Assembly, Outfeed Swing Arm Assembly, (4) 54-15 Pivot Screws, (2) 54-16 Rest Screws, Long Screwdriver, Thread Locker

1. Insert the Infeed Swing Arm Assembly into the infeed side of the head casting from the underside of the head casting. Attach swing arm with (2) 54-15 pivot screws, use thread locker, tighten screws.

2. Engage the short chain that is dangling from the drive sprocket inside the chain guard on to the P-111or VF-3 feed roll sprocket. The chain should be in a straight path from the inside chain guard sprocket to the feed roll sprocket. Tip: short chain should be on the right-side drive sprocket located inside the chain guard.

3. Pulling the swing arm up, insert the 54-16 rest screw into the head casting, use thread locker, tighten screw. The swing arm should be resting on the rest screw and the chain is engaged on both sprockets.

4. Insert the Outfeed Swing Arm Assembly into the outfeed side of the head casting from the underside of the head casting. Attach with (2) 54-15 Pivot Screws, use thread locker, tighten screws.

5. Engage the long chain that is dangling from the drive sprocket inside the chain guard onto the P-111or VF-3 feed roll sprocket. The chain should be in a straight path from the inside chain guard sprocket to the feed roll sprocket. Tip: long chain should be on the left-side drive sprocket located inside the chain guard.

6. Pulling the swing arm up, insert the 54-16 rest screw into the head casting, use thread locker, tighten screws. The swing arms should be resting on the rest screw and the chain is engaged on both sprockets.

INSTALL PRESSURE SCREW ASSEMBLIES

1. Thread (1) 54-40 or 54-51 check nut onto (1) 54-25 pressure screw, insert the NEW 54-24 Rev A spring inside the pressure screw then the 54-26 spring guide (see image). Insert the pressure screw assembly into one of the 2 threaded holes on top of the head, screw in and tighten. Insert the remaining assembly, equally tightening the pressure screws. **TIP**: The bottom of the spring guide should be sitting on top of the swing arm. *Image shown with old 54-40 check nut.*

Planing with Multi-Pass

Loosen the (4) 54-25 pressure screws exposing ¼" of thread when planing. This will give you proper roller pressure. Failure to do so will cause feeding difficulties and feed system damage. **Tighten pressure screws back when running moldings!**

If your molder does NOT have Multi-Pass, do NOT loosen pressure screws when planing.

TIP: If your (4) springs are 1-¾" in length, loosen pressure screws when planing.

If your (4) springs are 1-½" in length, do NOT loosen pressure screws when planing.