

# ROLLING MILL SETUP AND ROLLER REPLACEMENT FOR MIL-280.10

## SETUP

1. Do NOT try to lift the mill by the T-bar. The T-bar will come out.
2. The crank handle is on backwards for shipping purposes. Loosen the black nut and remove the handle. Place the handle on the opposite site and secure with the black nut. Be sure to leave the plastic handle free to turn.
3. The mill comes with two flat rollers installed.
4. The rollers are covered with protective plastic. Remove the plastic before operating.
5. Do NOT extend the T-bar out of the top of the gears.

## PATTERN ROLLER REPLACEMENT

1. Remove the gear from the top roller and the key stock.
2. Loosen the four bolts on the mill head. Lift and remove the mill head. Place on a clean surface.
3. Slowly lift the top roller keeping it level and place it on a clean surface. Be careful not to lose the springs between the rollers.
4. Slide the holders off each end of the roller.
5. Replace the holders on the pattern roller making sure the oil holes are on the top.
6. Carefully replace the roller into the mill making sure the springs are in place and reassemble the mill.

## WIRE ROLLER REPLACEMENT

1. Remove the gear from the top roller and the key stock.
2. Remove the lower roller gears (big gear and little gear) and key stock.
3. Loosen the four bolts on the mill head. Lift and remove the mill head. Place on a clean surface.
4. Slowly lift the top roller keeping it level and place it on a clean surface. Be careful not to lose the springs between the rollers.
5. Loosen the set screws on the back of the mill frame.
6. Remove the lower roller the same way as the top roller.
7. The wire rollers are different lengths. The longer roller will be the lower roller.
8. Starting with the lower flat roller that is being replaced, remove the holders from the ends and put on the lower wire roller. Place the roller into the mill frame with the oil holes on top. Tighten the set screws. Be sure the springs are installed. Do the same with the upper roller.
9. Double check to be sure everything is correct and all oil holes are on top then replace the mill head.
10. Lube the mill as needed with oil.

## TROUBLESHOOTING

Always make sure the mill is secure to your work surface to avoid personal injury and damage to mill.

To insure the rollers are aligned:

1. Close rollers until the edges touch. Do not overtighten.
2. Shine a light between rollers in order to see if one side is higher than the other.
3. To adjust roller:
  - a. Remove the T-handle
  - b. Turn high side gear by hand until the rollers touch.
  - c. Check with light and adjust as needed.
  - d. Replace T-handle and test. This should be done any time handle is removed.
4. For drawing plain sheet metal, use a maximum 5 SWG gauge (3.75mm) and a minimum of 26 SWG gauge (0.45mm). For drawing wire, use a maximum 5 SWG gauge and a minimum of 20 SWG gauge. Always feed through the front of the rolling mill.



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