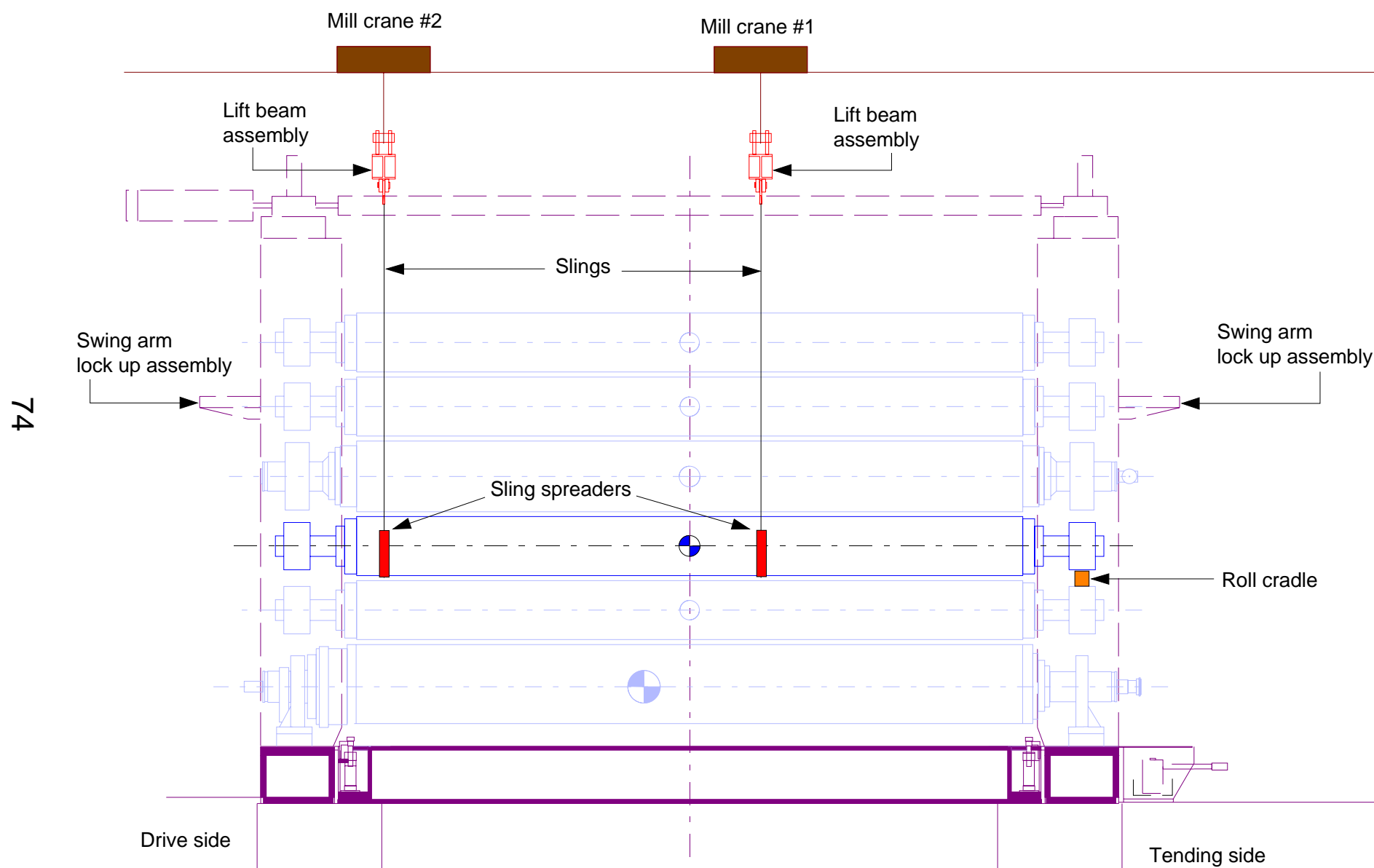


Note: Roll 3 is used as an example.  
Rolls 2, 4, and 5 are removed similarly.



**REMOVING ONLY #2-, #3-, #4-, OR #5-POSITION ROLL.**

**DANGER! The S-roll (#4) weighs 29,500 lbs. and the Tri-Pass rolls (#2, 3, 5, & 6) weigh 21,000 lbs. Use slings of the proper capacity for lifting these rolls.**

1. Follow the preliminary procedures as described in 5.1.1.
2. If removing a temperature-controlled (Tri-Pass) roll, install lock-up device on drive-side and tending-side bearing housings (part #749265).
3. Install roll cradle on tending-side bearing housing of the roll beneath the one being removed. See Figure 5.1.
4. Attach slings as shown and take up roll weight.
5. Note: If removing rolls 2 or 3, use the sling spreader as shown in Figure 5.1.
6. Remove bearing housing hold-down bolts.

*Turn to the next page.*

**Figure 5.3a. Sequence for Removing Only #2-, #3-, #4-, or #5-Position Roll.**

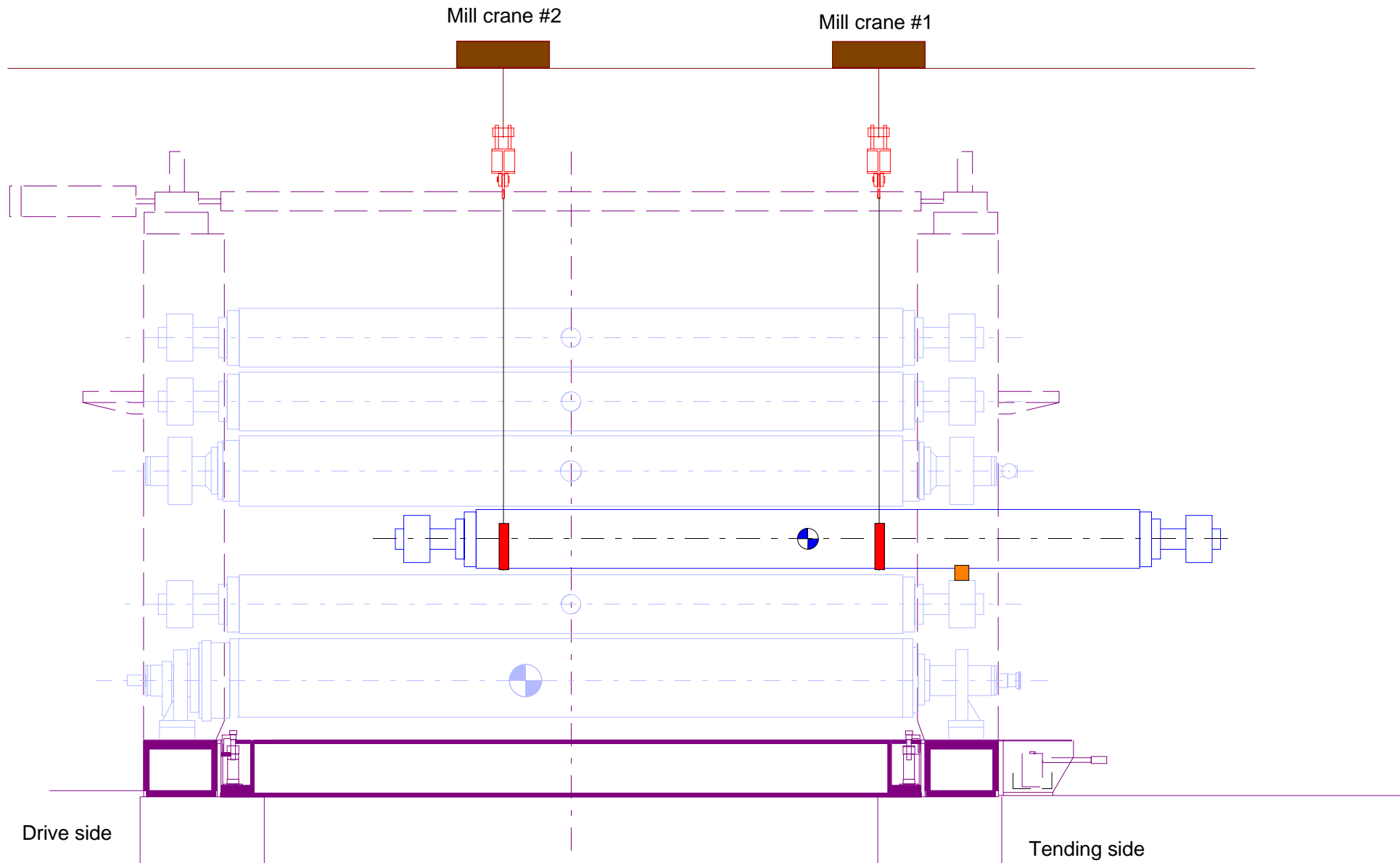
Note: Roll 3 is used as an example.  
Rolls 2, 4, and 5 are removed similarly.

7. Move roll out as shown.

8. Lower crane hook #1 so roll rests in cradle.

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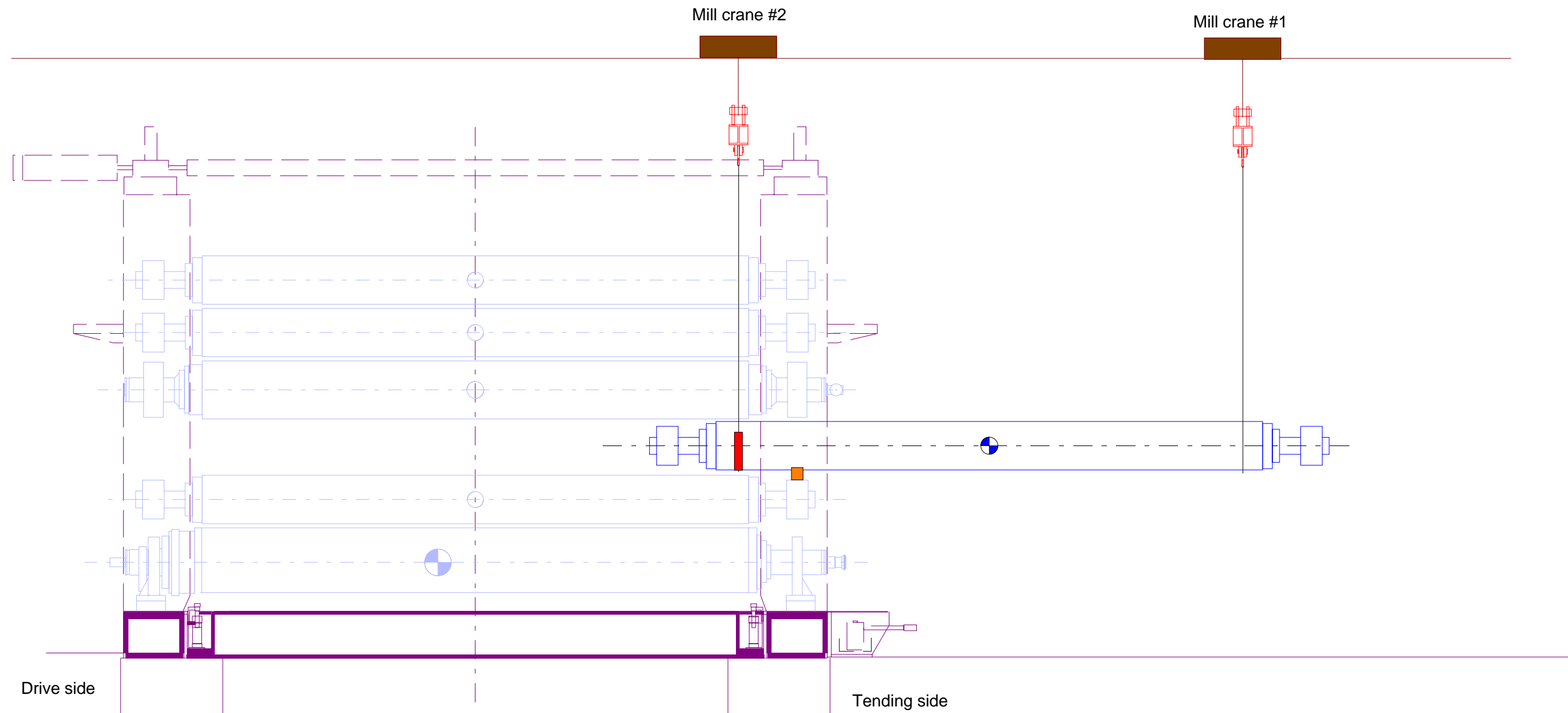


**Figure 5.3b. Sequence for Removing Only #2-, #3-, #4-, or #5-Position Roll.**

Note: Roll 3 is used as an example.  
Rolls 2, 4, and 5 are removed similarly.

9. Attach slings as shown.
10. Move roll out as shown.
11. Lower crane hook #2 so roll rests in cradle.

*Turn to the next page.*



**Figure 5.3c. Sequence for Removing Only #2-, #3-, #4-, or #5-Position Roll.**

Note: Roll 3 is used as an example.  
Rolls 2, 4, and 5 are removed similarly.

12. Attach slings as shown.
13. Move roll out of machine.

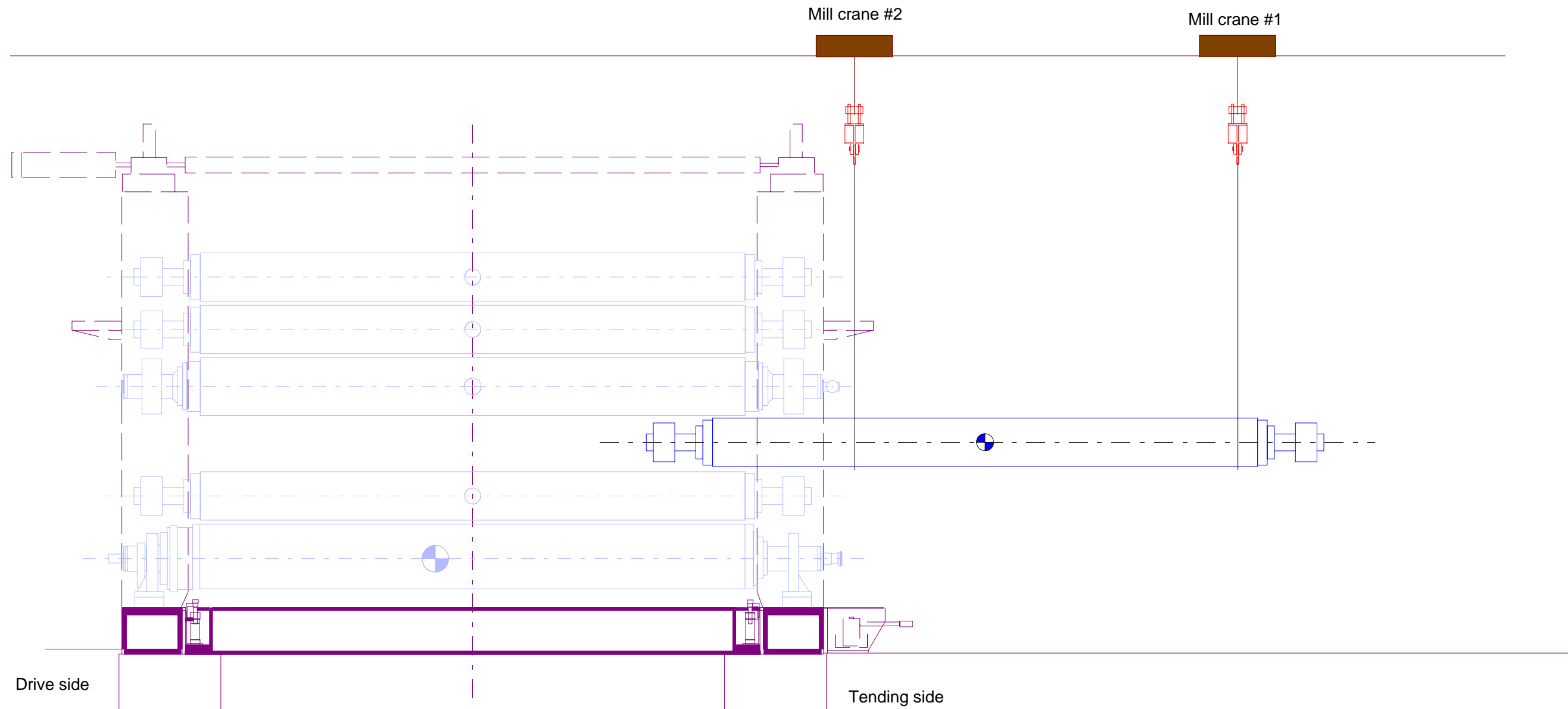


Figure 5.3d. Sequence for Removing Only #2-, #3-, #4-, or #5-Position Roll.

## REMOVING ROLL #6 OR ALL ROLLS

**DANGER!** The #1 S-roll weighs 37,000 lbs., the #4 S-roll weighs 29,500 lbs., and the Tri-Pass rolls (2, 3, 5, & 6) weigh 21,000 lbs. Use slings of the proper capacity for lifting these rolls.

Note: Sling spreaders, lift beam assembly, and roll cradles are not required when removing roll #6 or all rolls.

1. Follow the preliminary procedures as described in 5.1.1.
2. If removing a temperature-controlled (Tri-Pass) roll, install lock-up device on drive-side and tending-side bearing housings (part #749265).
3. Loosen swing bolts on tending side upper cross beam and swing the beam open.
4. Attach slings as shown and take up roll weight.
5. Remove bearing housing hold-down bolts.

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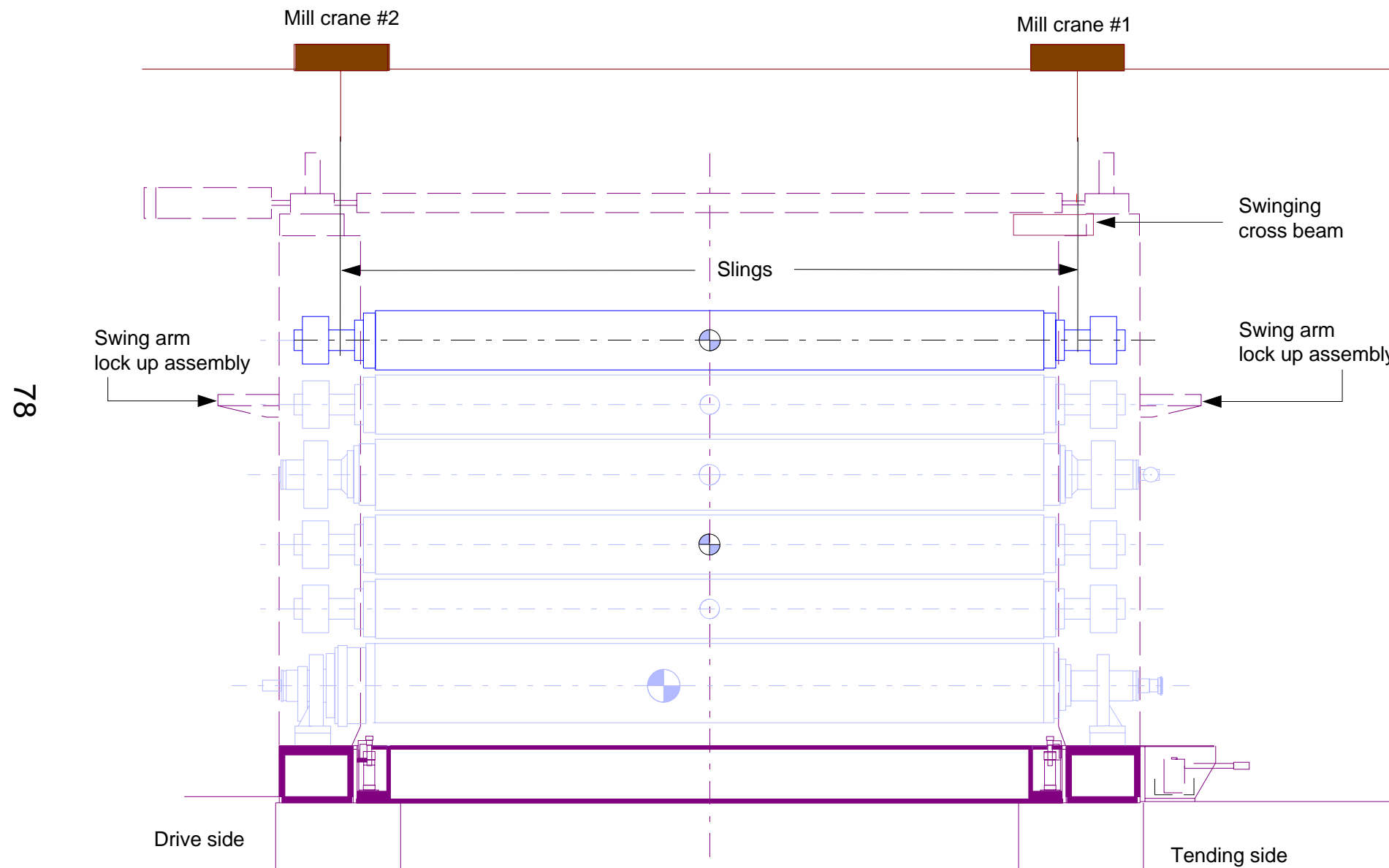


Figure 5.4a. Sequence for Removing Only #6-Position Roll or All Rolls.

6. Move roll out of the machine.

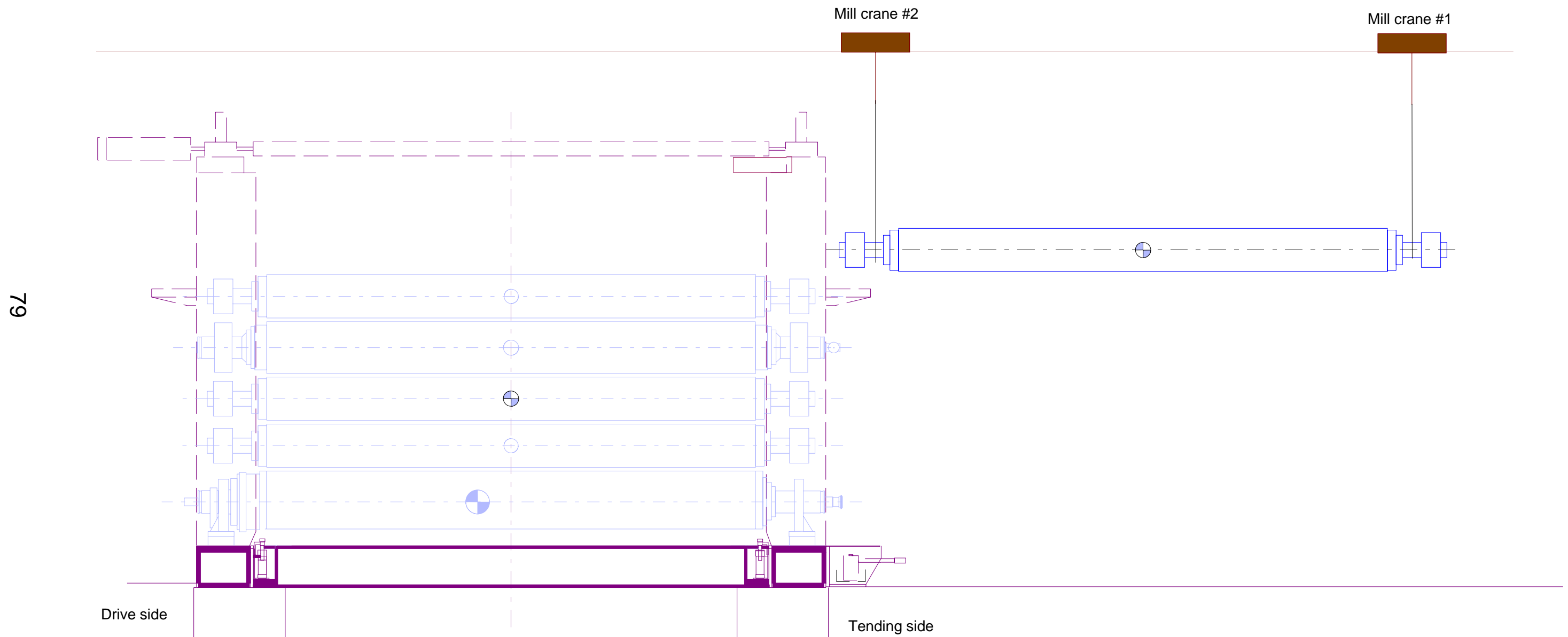


Figure 5.4b. Sequence for Removing Only #6-Position Roll or All Rolls.