ASSEMBLING OF THE ROLLERS

1. Front nut M30x200
2. Thick washer
3. 55mm Upper roller
4. 40mm Upper roller
5. 25mm Upper roller
6. 55mm Lower rollers
7. 40mm Lower rollers
8. 25mm Lower rollers

IMPORTANT NOTE:
The clamping nut of the rollers should never be tightened with a wrench and only by hand. If pipe rollers are being used, the nuts must be loose.