

**BRIDGEPORT  
STEP PULLEY  
("J" HEAD)  
REBUILD  
INSTRUCTIONS**

**H&W MACHINE REPAIR  
AND REBUILDING INC.  
2119 MEYER ROAD  
FORT WAYNE, IN 46803  
(800) 285-5271  
[www.machinerypartsdepot.com](http://www.machinerypartsdepot.com)**

# Bridgeport "J" (Step Pulley) Head Rebuild

1. All listed parts can be found on page 12 of our catalog. Parts are listed as (item/part) in the following instructions.
2. Loosen the **Motor Locknut** (40/1155-03) and pull the motor forward.
3. Remove the handle from the **Motor Locknut Assembly** (40/1155-03).
4. Remove the **Locknut** (40/1155-03) from the motor stud.
5. Remove the **Hex Jam Nut** (38/1264) from the opposing side of the motor.
6. Work the **Drive Belt** (22/1256) down to below the **Motor Pulley** (43/1268).
7. Remove the Motor and **Motor Pulley** (43/1268).
8. Remove the two small **Set Screws** (10/1254) from the top of the **Spindle Pulley Bearing Sleeve** (11/1128). *\*The set screws are set against the Cam Ring Pins (30/1143) and must be removed for easier removal of the Cam Ring Pins (30/1143).*
9. Remove the two **Cam Ring Pins** (31/1109) from the **Cam Ring** (30/1143).
10. Remove the **Cam Ring** (30/1143).
11. Drop the Quill Assembly to its lowest point using the Quill Downfeed Handle.
12. Remove the six **Socket Head Cap Screws** (60/1286) from the bottom of the **Gear Housing** (57/1283).
13. Remove the **Belt Housing** (41/1266) from the **Gear Housing** (57/1283).
14. Remove the **Drive Belt** (22/1256) and the **Timing Belt** (23/1115).
15. Support the **Belt Housing** (41/1266) and remove the **Spindle Pulley Bearing Sleeve** (11/1128) assembly through the bottom of the belt housing.
16. Remove the **Hex Jam Nut** (27/1258) from the top of the **Timing Belt Pulley** (25/1146).
17. Remove the **Timing Belt Pulley** (25/1146).
18. Remove the five **Round Head Screws** (45/1270) from the top of the **Gear Housing Cover** (44/1269).
19. Remove the **Gear Housing Cover** (44/1269).
20. Remove the three **Hex Nuts** (65/1291) and the three **Washers** (67/1496) from the bottom of the **Gear Housing** (57/1283).
21. Turn the **Gear Housing** (57/1283) over and remove the three **Vertical T-Bolts** (66/1292).
22. Relieve the **Lock Washer** (63/1289) for removal.
23. Remove the **Bearing Locknut** (64/1290) and the **Lock Washer** (63/1289).
24. Remove the **Splined Gear Hub** (49/1160) and **Large Bull Gear** (50/1276) from the **Gear Housing** (57/1283).
25. Drive out the **Dowell Pin** (58/1281) from the bottom of the **Gear Housing** (57/1283). Pin is located on the small flat area on the bottom of the housing.
26. Remove the **Back Gear Shifter Fork** (56/1282) and the **Small Bull Gear** (54/1276). These parts may fall out when you remove the pin.
27. Remove the large **Snap Ring** (62/1288) from the bottom of the **Gear Housing** (57/1283).

28. From the top side of the **Gear Housing** (57/1283) press the two **Bearings** (61/1287) through the bottom.
29. Remove the **Bearing** (51/1277) from the **Spindle Bull Gear** (54/1276) Assembly.
30. Remove the bottom **Bearing** (51/1277) from the **Gear Housing** (57/1283). This bearing may be hard to get out and will require a puller to get under it to remove it.
31. Inspect the four **Compression Springs** (9/1108) and the **Brake Block Assembly** (18/1111) in the bottom side of the **Belt Housing** (41/1266) for damage or excessive wear.
32. Clean all components Install the new bearings and belts and reassemble in the reverse direction.

***Spindle Pulley Bearing Sleeve (11/1128) Assembly:***

1. Remove the **Upper Bearing Locknut** (3/1141) by turning it counter clockwise using a spanner wrench.
2. Remove the **Bearing Sleeve Locknut** (4/1142) by turning it counter clockwise using a spanner wrench.
3. Remove the **Spindle Pulley Hub** (20/1116) by pressing through the assembly.
4. Press the two **Bearings** (5/1251) and the **Bearing Spacers** (7/1252) through the assembly.
5. Clean the assembly components install the new bearings and reassemble.

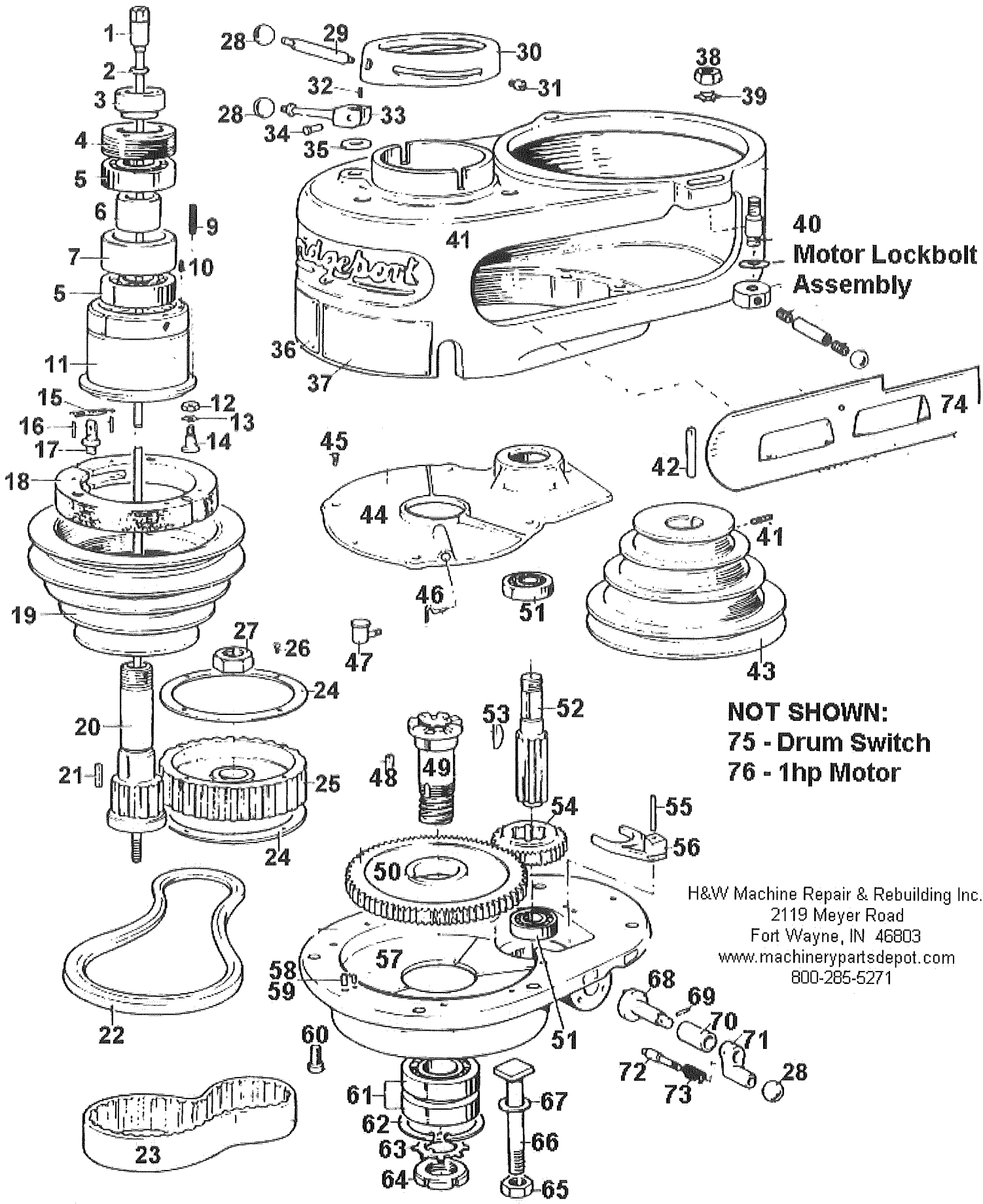
**If you run into any problems or need additional parts please call:**

**Barry Walker  
H&W Machine Repair & Rebuilding Inc.  
2119 Meyer Road  
Fort Wayne, IN 46803  
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# J Head Top Housing Assembly

Item #	H&W Number	Description
1	1028	Drawbar Assembly
2	6001	Drawbar Washer
3	1141	Upper Bearing Locknut
4	1142	Bearing Sleeve Locknut
5	1251	Ball Bearing
6	1252	Bearing Spacer Set
7	1252	Bearing Spacer Set
8	6014	Button Head Screw
9	1108	Compression Spring
10	1254	Socket Set Screw
11	1128	Spindle Pulley Bearing Sleeve
12	1132-03	Jam Nut
13	1132-02	External Lock Washer
14	1132-01	Brake Ring Screw
15	1111-02	Extension Spring
16	6015	Roll Pin
17	1107	Brake Lock Stud
18	1111	Brake Shoe Set
19	1255	Spindle Pulley
20	1116	Spindle Pulley Hub
21	1125	Spindle Pulley Key
22	1256	"V" Belt
23	1115	Timing Belt
24	1144	Timing Belt Pulley Flange
25	1146	Timing Belt Pulley
26	1257	Flat Head Screw
27	1258	Hex Jam Nut
28	1259	Black Plastic Ball
29	1100	Spindle Clutch Lever
30	1143	Cam Ring
31	1109	Cam Ring Pin
32	1260	Socket Set Screw
33	1261	Brake Lock Handle
34	1262	Brake Lock Pin
35	1200	Brake Lock Washer
36	1075	Spindle Speed Nameplate
37	1074	Operating Instruction Plate
38	1264	Hex Jam Nut
39	1265	Lock Washer

Item #	H&W Number	Description
40	1155-03	Motor Locknut Assembly
41	6019	Socket Set Screw
42	1268-01	Square Key
43	1268	Motor Pulley
44	1269	Gear Housing Cover
45	1270	Round Head Screw
46	6020	Oil Wick
47	1273	Oil Cup
48	1530	Bull Gear Key
49	1160	Splined Gear Hub
50	1276	Spindle Bull Gear
51	1277	Ball Bearing
52	6023	Countershaft
53	1275	Woodruff Key
54	6024	Countershaft Gear
55	1281	Dowell Key
56	1282	Back Gear Shifter Fork
57	1283	Gear Housing
58	1284	Dowell Pin
59	1285	Roll Pin
60	1286	Socket Head Cap Screw
61	6025	Disengage Feed Ins. Plate
62	1287	Ball Bearing
63	1288	Snap Ring
64	1289	Lockwasher
65	1290	Locknut
66	1291	Lock Nut
67	1292	Vertical Tee Bolt
68	1496	Vertical Tee Washer
69	1294	Back Gear Shift Crank
70	1295	Roll Pin
71	1296	Back Gear Shift Bushing
72	1297	Shift Crank
73	1299	Gearshift Plunger
74	1300	Compression Spring
75	1301	Belt Guard
76	1466	Drum Switch
77	1600	1 HP Motor (New)



**40  
Motor Lockbolt  
Assembly**

**NOT SHOWN:  
75 - Drum Switch  
76 - 1hp Motor**

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