

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

**H&W MACHINE REPAIR
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***If at any time during your rebuild you find broken parts, they are obsolete. Please give us a call for possible used parts. We can supply a few new parts such as the belt, bearings, and drawbar. You can also visit our website for the full list of new parts we can supply.**

1. Loosen both motor hex jam nuts (14) and pull the motor forward.
2. Work the belt (10) down to below the motor pulley (11).
3. Remove both motor hex jam nuts (14) and washers (15).
4. Remove the motor and motor pulley from the belt housing.
5. Drop the quill to its lowest position using the quill downfeed handle.
6. Loosen the tightening bolt (27) on the belt housing so that it can move back and forth.
7. Remove the belt housing from the quill housing using a soft head hammer and tapping upwards on the bottom of the housing.
8. Remove the spindle pulley locknut (7). Use vise to keep hold of the hex head portion of the assembly. Use locknut socket (P/N D3442N06) to remove the locknut.
9. Press the front pulley shaft (1) out from the bottom of the pulley (2).
10. Remove all six socket head cap screws that are holding the pulley in place on the belt housing.
11. The drive pulley (2) can then be removed through the motor hole in the belt housing.
12. The drive pulley bearing housing (5) will lift off the pulley.
13. Remove the bearing housing locknut (3) using a spanner wrench.
14. Press the two bearings out of the bearing housing. You can use a manual press or a punch and a hammer.
15. Remove the micrometer nut (60,62) and the micrometer screw (66). This just unscrews from the quill housing using a large flat head screwdriver up from the bottom.
16. Make sure the quill lock is not engaged. Tap down on the spindle with a soft head hammer until the quill assembly drops out of the housing. Make sure you are able to catch it once it falls out.
17. Remove the spindle nose piece (86). It has a right hand thread. Use a vise with copper covers to prevent scoring the surface of the quill.
18. Using the same vise, hold the top of the spindle in place so you can remove the spindle locknut (73) and washer (74). Use a punch and a hammer in order to spin the lock nut off.

19. Have the vise hold the quill in place once more. Hammer the spindle out through the bottom of the quill. The spindle will drop out of the quill so make sure you are there to catch it.
 20. Press the two bottom spindle bearings off the spindle using a press or a hammer.
 21. You will need an extra long punch in order to remove the upper two spindle bearings from the quill.
- ❖ Reassemble using the parts inside this kit

If you run into any issues please call or e-mail:

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