

Bridgeport "J" (Step Pulley) Head Single Phase Motor Installation

1. Disconnect power to the head and lock out.
2. Remove the Drum Switch from the side of the head
3. Remove the Motor Locknuts from the bottom of the motor and remove the motor from the head.
4. Loosen the set screw in the Motor Pulley and remove the pulley from the motor shaft.
5. Remove the two Motor Locknut Studs from the old motor.
6. Insert the two Motor Locknut Studs into the new Motor Flange.
7. Bolt the Motor Flange to the bottom of the new Motor using the 4 Hex Head Bolts and 4 Locking Washers provided.
8. Attach the provided motor switch plate to the New Motor using the 4 provided Socket Head Screws.
9. Attach the Drum Switch to the Motor Switch Plate by removing the 4 Hex Nuts, Installing the Drum Switch and locking down using the 4 Hex Nuts. NOTE: YOU MAY BE REQUIRED TO INSERT A HOLE INTO THE BACK OF YOUR DRUM SWITCH IF YOU DO NOT HAVE ONE THAT MATCHES UP WITH THE HOLE IN THE MOTOR SWITCH PLATE.
10. Follow the instructions provided in the hardware bag for wiring the switch to the new motor.
11. See below for instructions to modify you existing Motor Pulley for use on the new motor.
12. Install the Motor Pulley onto the motor shaft of the New Motor.
13. Install the new Motor onto the top of the head.
14. Reinstall the Motor Locknuts onto the motor studs.
15. Reconnect the power to the mill.

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

**Barry Walker
H&W Machine Repair and Rebuilding Inc.
2119 Meyer Road
Fort Wayne, IN 46803
(800) 285-5271**

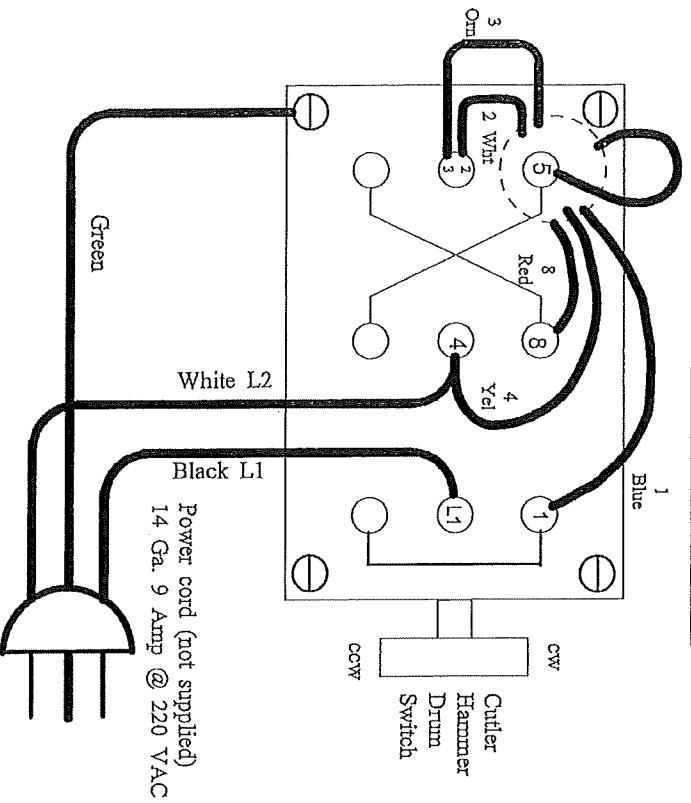
Directions for wiring Baldor Single Phase Motor to existing Drum Reversing Switch.

Use the adaptor plate as a pattern and drill a 3/4" hole in the drum switch to pass wires from the motor to the drum switch, or run a short, flexible conduit from the motor to the switch.

Pull the motor wires through the adaptor plate. Mount the adaptor plate to the motor connection box. Mount the drum switch to the adaptor plate then connect the numbered motor leads to the drum switch and power cord using corresponding numbers on the motor diagram.

Baldor wire numbers are as follows:

1 - Blue	5 - Black
2 - White	8 - Red
3 - Orange	
4 - Yellow	



230 VAC

230 VAC

230 VAC

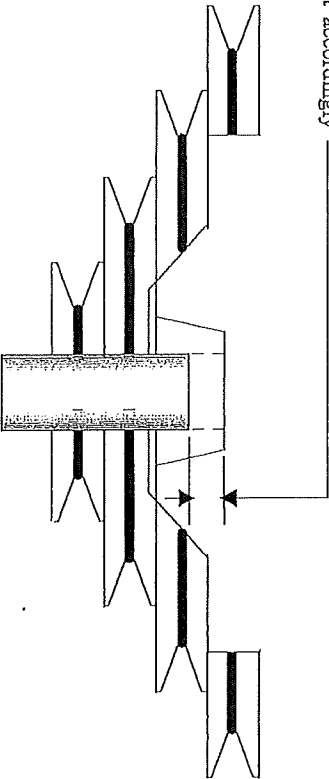
230 VAC

230 VAC

Your old pulley may need to be bored to fit the 7/8" shaft. We recommend .875 - .8765, and the keyway needs to be broached. (We can bore and broach your pulley for \$50.00.) For technical assistance, call (800) 285-5271.

IMPORTANT! The new motor output shaft will not completely fill the bore of your old pulley. Below is a good starting point for aligning your pulley. We have seen several different pulleys on the J-head mills and there are probably more out there, so you will have to install and check yours, then set the proper vertical spacing.

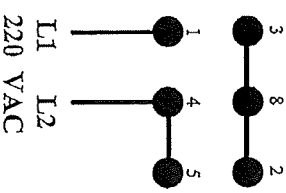
Start at .900", check alignment and adjust accordingly.



Parts List:

- 1 - Baldor motor - VL3514T
- 1 - Motor adaptor plate
- 1 - Switch adaptor plate w/screws attached
- 4 - 10/32 nuts
- 4 - 8/32 x 1/2" flat head screw
- 4 - 3/8"-16 x 1" hex head bolt
- 4 - 3/8" lock washers
- 5 - Blue wire terminals

6 Lead Motor Hi-Voltage



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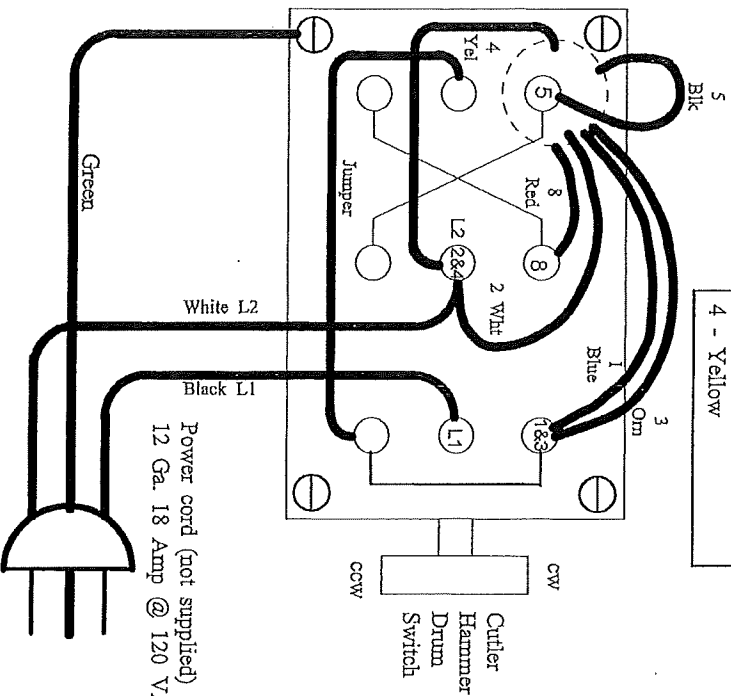
Directions for wiring Baldor Single Phase Motor to existing Drum Reversing Switch.

Use the adaptor plate as a pattern and drill a 3/4" hole in the drum switch to pass wires from the motor to the drum switch, or run a short, flexible conduit from the motor to the switch.

Pull the motor wires through the adaptor plate. Mount the adaptor plate to the motor connection box. Mount the drum switch to the adaptor plate then connect the numbered motor leads to the drum switch and power cord using corresponding numbers on the motor diagram.

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4 - Yellow	

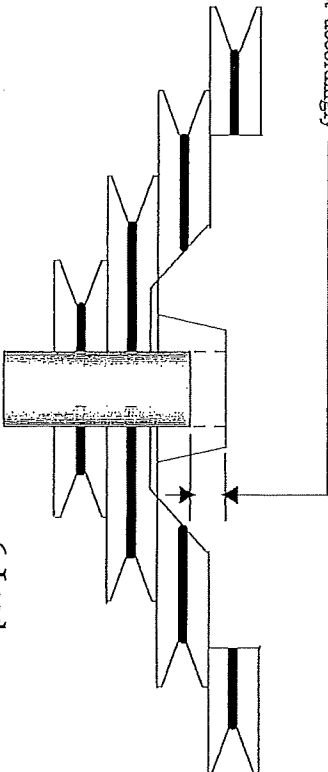


120 VAC 120 VAC 120 VAC 120 VAC 120 VAC

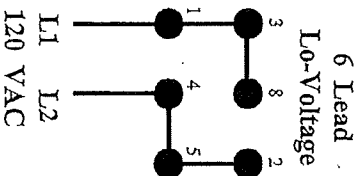
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 - 4 - 3/8" lock washers
 - 5 - Blue wire terminals
 - 1 - Wire nut



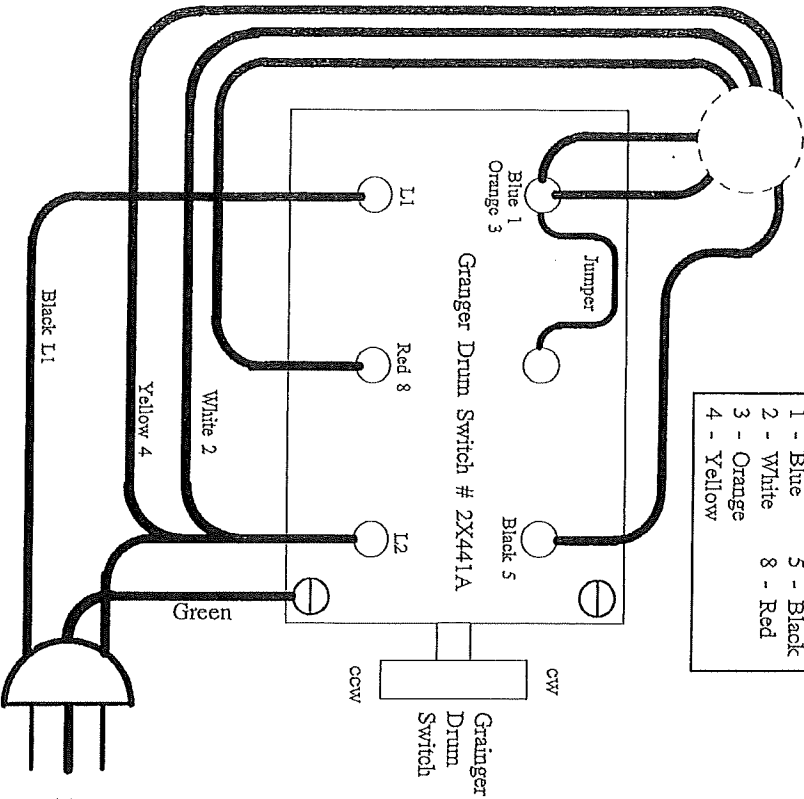
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Directions for wiring Baldor Single Phase Motor to Granger Drum Switch.

Pull the motor wires through the adaptor plate, then using the four 8/32 x 1/2" flat head screws, attach the adaptor plate to the junction box on the side of the motor.

Pull the motor wires through the hole in the bottom of the drum switch. Attach the drum switch to the adaptor plate using the two 1/4-20 button head screws. Connect the numbered motor leads to the drum switch and power cord using corresponding numbers on the motor diagram.

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120VAC SINGLE PHASE

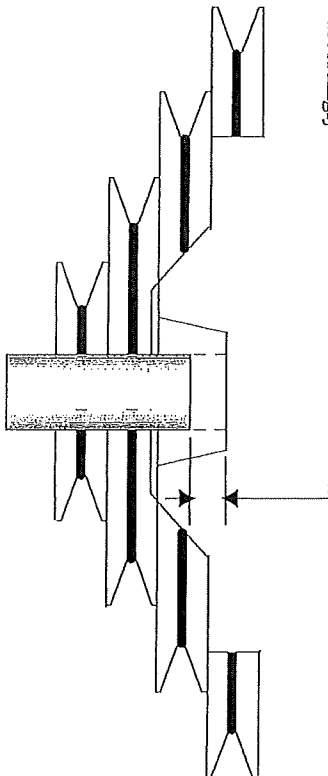
120 VAC SINGLE PHASE

Power cord
(not supplied)
12 Ga. 18 Amp
@ 120 VAC

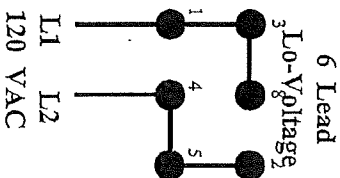
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- Parts List:**
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 - 1 - Motor adaptor plate
 - 1 - Switch adaptor plate
 - 2 - 1/4"-20 button head screws
 - 4 - 10/32 nuts
 - 4 - 3/8"-16 x 1" hex head bolt
 - 4 - 3/8" lock washers
 - 5 - Blue wire terminals
 - 1 - Wire nut



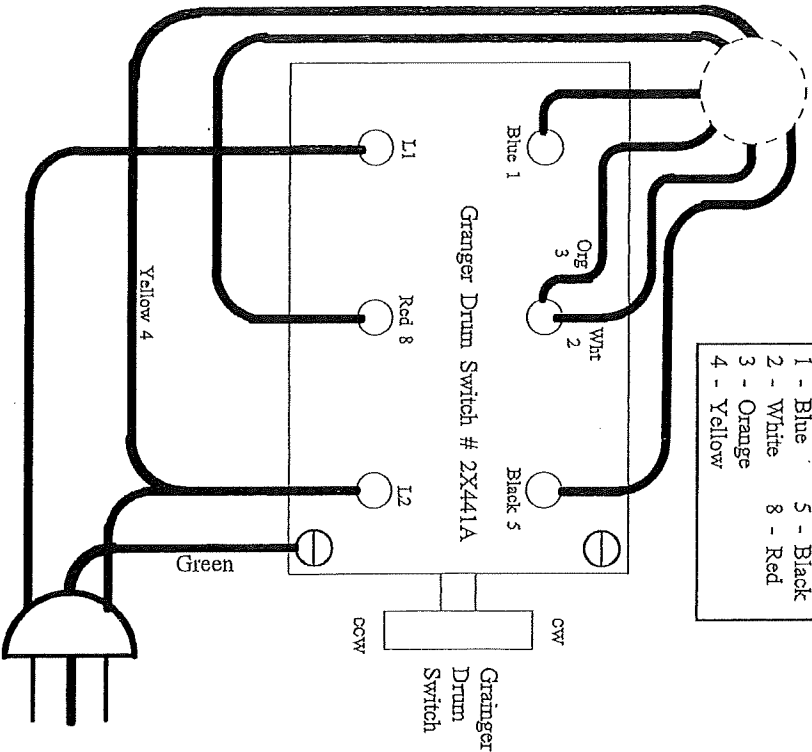
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Directions for wiring Baldor Single Phase Motor to Granger Drum Switch.

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Pull the motor wires through the hole in the bottom of the drum switch. Attach the drum switch to the adaptor plate using the two 1/4-20 button head screws. Connect the numbered motor leads to the drum switch and power cord using corresponding numbers on the motor diagram.

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230VAC SINGLE PHASE

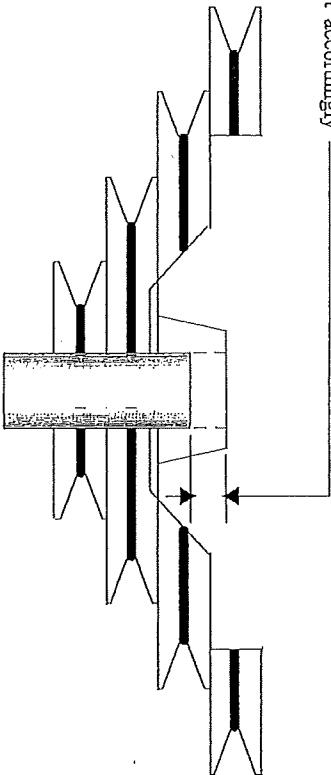
230 VAC SINGLE PHASE

Power cord
(not supplied)
14 Ga. 9 Amp
@ 230 VAC

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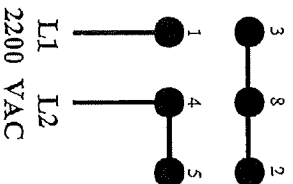
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6 Lead

Bi-Voltage

- Parts List:**
- 1 - Baldor motor - VL3514T
 - 1 - Motor adaptor plate
 - 1 - Switch adaptor plate
 - 2 - 1/4"-20 button head screws
 - 4 - 10-32 nuts
 - 4 - 3/8"-16 x 1" hex head bolts
 - 4 - 3/8" lock washers
 - 7 - Blue wire terminals
 - 1 - Wire nut



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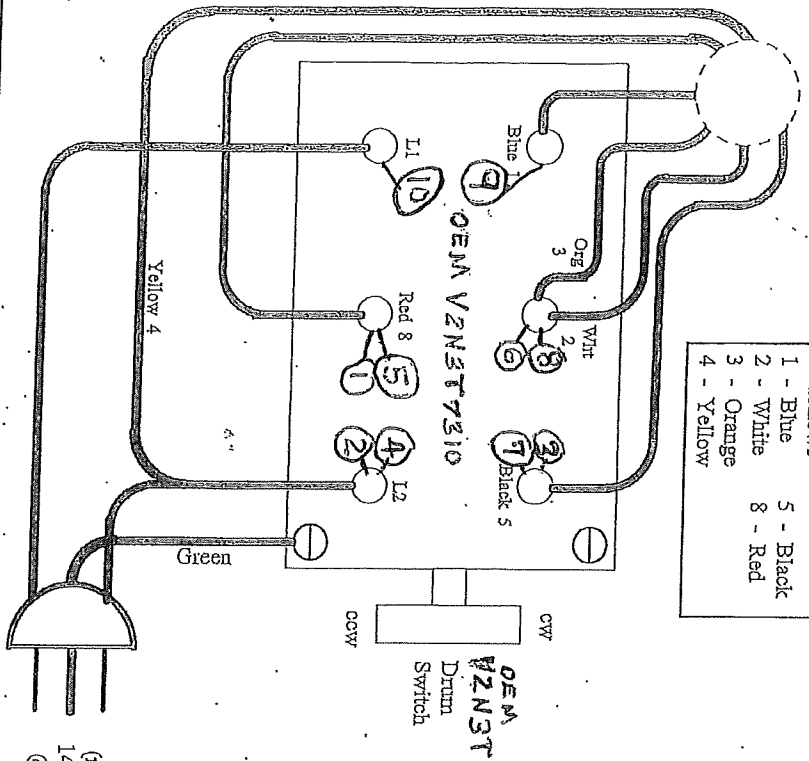
KRAUS & NAIMER STYLE

Directions for wiring Baldor Single Phase Motor to Grainger Drum Switch.

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Pull the motor wires through the hole in the bottom of the drum switch. Attach the drum switch to the adaptor plate using the two 1/4"-20 button head screws. Connect the numbered motor leads to the drum switch and power cord using corresponding numbers on the motor diagram.

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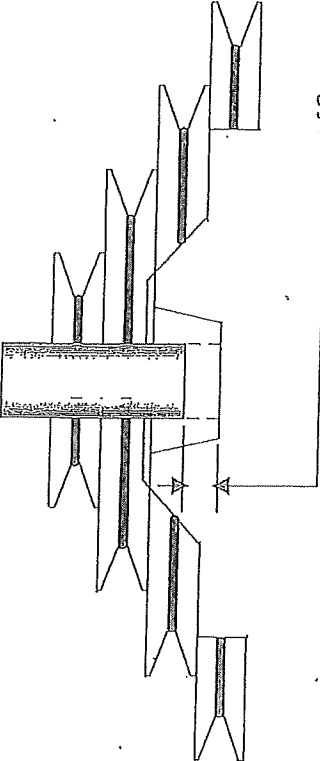
230VAC SINGLE PHASE 230 VAC SINGLE PHASE

Power cord (not supplied)
14 Ga. 9 Amp
@ 230 VAC

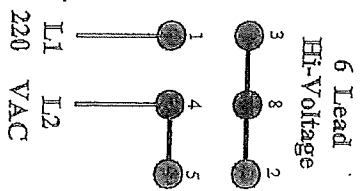
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 - 1 - Motor adaptor plate
 - 1 - Switch adaptor plate
 - 2 - 1/4"-20 button head screws
 - 4 - 10-32 nuts
 - 4 - 3/8"-16 x 1" hex head bolts
 - 4 - 3/8" lock washers
 - 7 - Blue wire terminals
 - 1 - Wire nut



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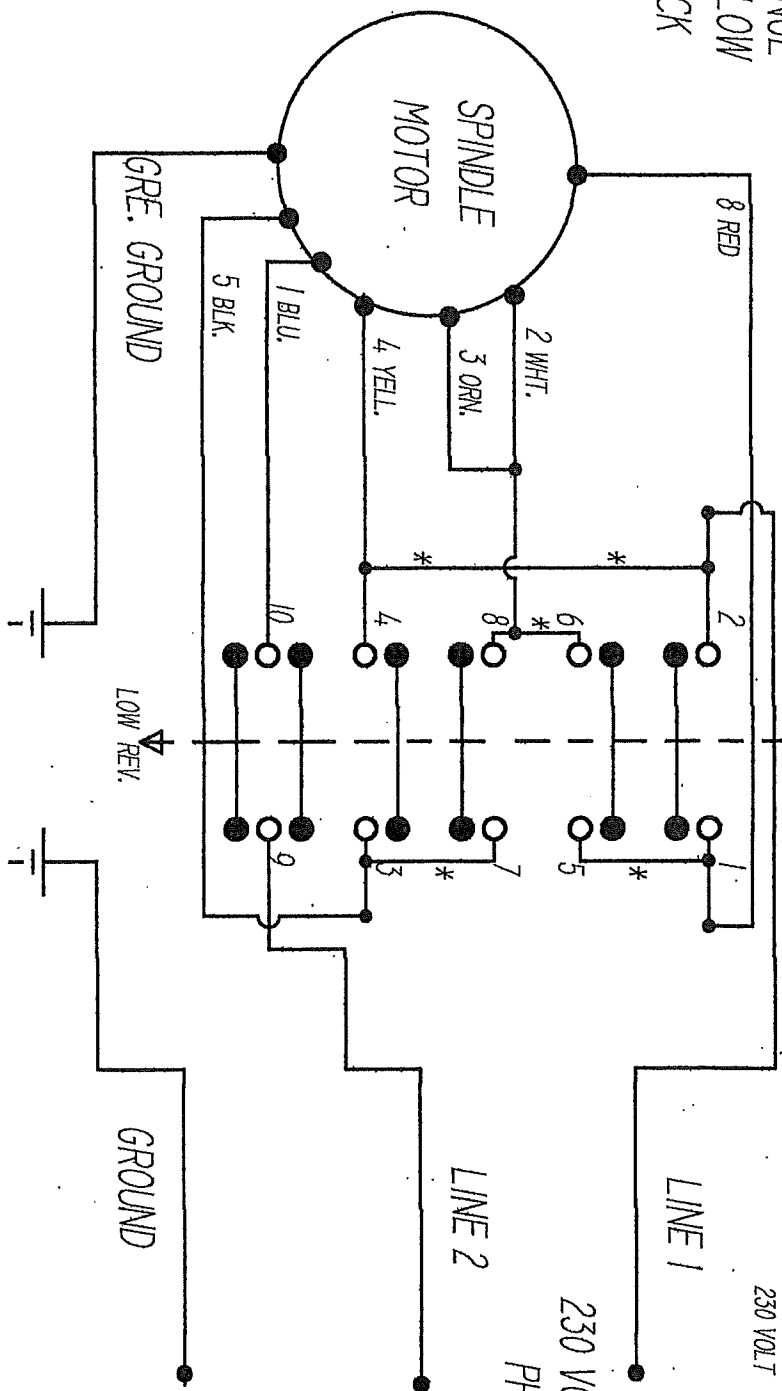
DRUM SWITCH KRAUS & NAIMER STYLE

6-LEAD 1-PHASE BALDOR

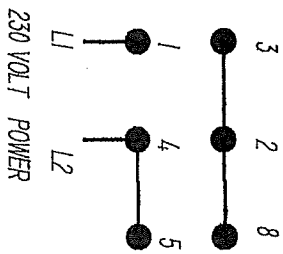
- 1-BLUE
- 2-WHITE
- 3-ORANGE
- 4-YELLOW
- 5-BLACK
- 8-RED

* INTERNAL JUMPER

HIGH FREQ.



6-LEAD BALDOR HI-VOLTAGE



230 VOLT SINGLE PHASE

H & W Machine Repair

TITLE DRUM SWITCH KRAUS & NAIMER

DATE DRUM SWITCH DWG.

QUESTIONS CALL (800-285-5271) ASK FOR JON OR WOODY

