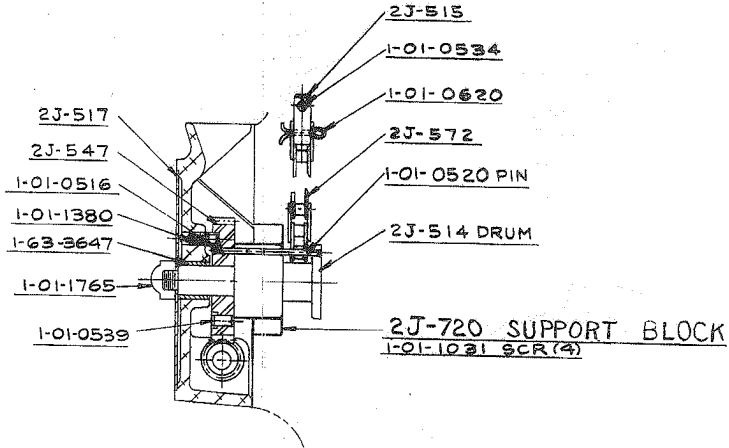


QUILL FEED DRIVEN PULLEY
PRIOR TO HEAD NO. J190265
MACHINE NO. CNC 160

Figure 6-15. Series I CNC Head, V-Ram (Sheet 1)



- 1-18-0107
- 77-0125
- (2) 1-01-1021
- 77-0126

- (3) STUD 77-0110
- (2) WASHER 1-18-1910
- (3) NUT 1-18-1732
- (3) PIN 1-01-0606

MOTOR H'SINK

77-0144

- (4) H.H.S. 1-01-1142
- (4) WASHER 1-65-1000
- (4) L.WASHER 1-19-1066

77-0140

PULLEY 2-77-0134

BELT 1-77-0232
1-01-1280 SSS

- EXTENSION 77-0258
- ADAPTER 66-5852
- DIAL 2D-112
- INDICATOR 66-5851
- (2) SHCS 1-01-1002
- (2) S.S.S. 1-01-1216
- (2) DR SCR 1-01-1555

(2) RM
(2) WASHER

COVER
(4) SCR

COVER
(2) SCR

(2) COVER
(4) SCR

REF { (2) STUD
(2) SPACER
(2) WASHER
(2) NUT
TIGHTEN
50 LBS-FI

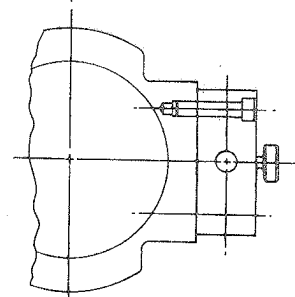
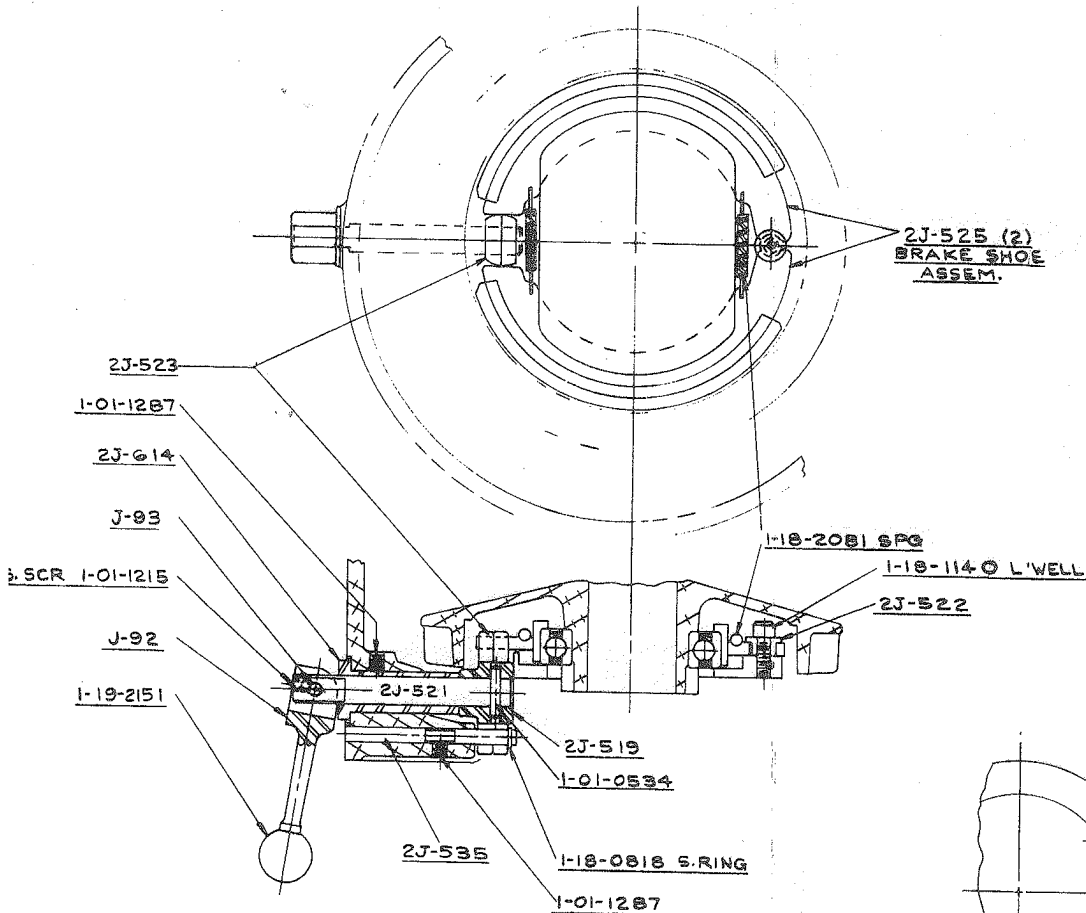
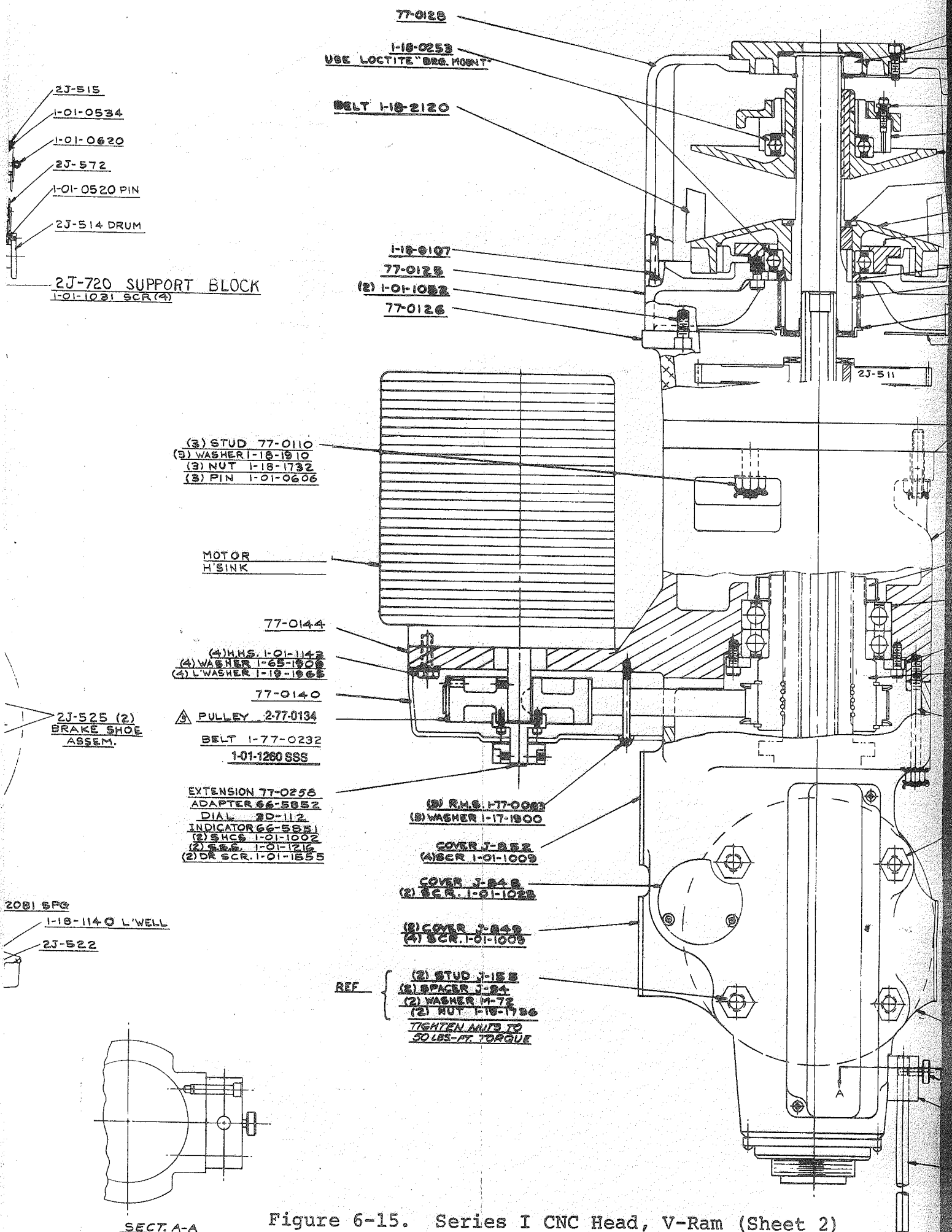


Figure 6-15. Ser



- 2J-515
- 1-01-0534
- 1-01-0620
- 2J-572
- 1-01-0520 PIN
- 2J-514 DRUM

2J-720 SUPPORT BLOCK
1-01-1021 SCR (4)

77-0128
1-18-0253
USE LOCTITE "BRG. MOUNT"

BELT 1-18-2120

1-18-0107
77-0125
(2) 1-01-1022
77-0126

(3) STUD 77-0110
(3) WASHER 1-18-1910
(3) NUT 1-18-1732
(3) PIN 1-01-0606

MOTOR
H'SINK

77-0144

(4) MHS. 1-01-1142
(4) WASHER 1-65-1900
(4) L'WASHER 1-19-1965

77-0140

⚠ PULLEY 2-77-0134
BELT 1-77-0232
1-01-1260 SSS

2J-525 (2)
BRAKE SHOE
ASSEM.

EXTENSION 77-0258
ADAPTER 66-5852
DIAL 20-112
INDICATOR 66-5851
(2) SHCS 1-01-1002
(2) SSS 1-01-1216
(2) DR SCR. 1-01-1555

(8) RMS. 1-77-0083
(8) WASHER 1-17-1900

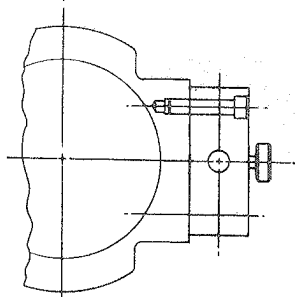
COVER J-842
(4) SCR. 1-01-1009

COVER J-843
(2) SCR. 1-01-1028

(8) COVER J-843
(4) SCR. 1-01-1009

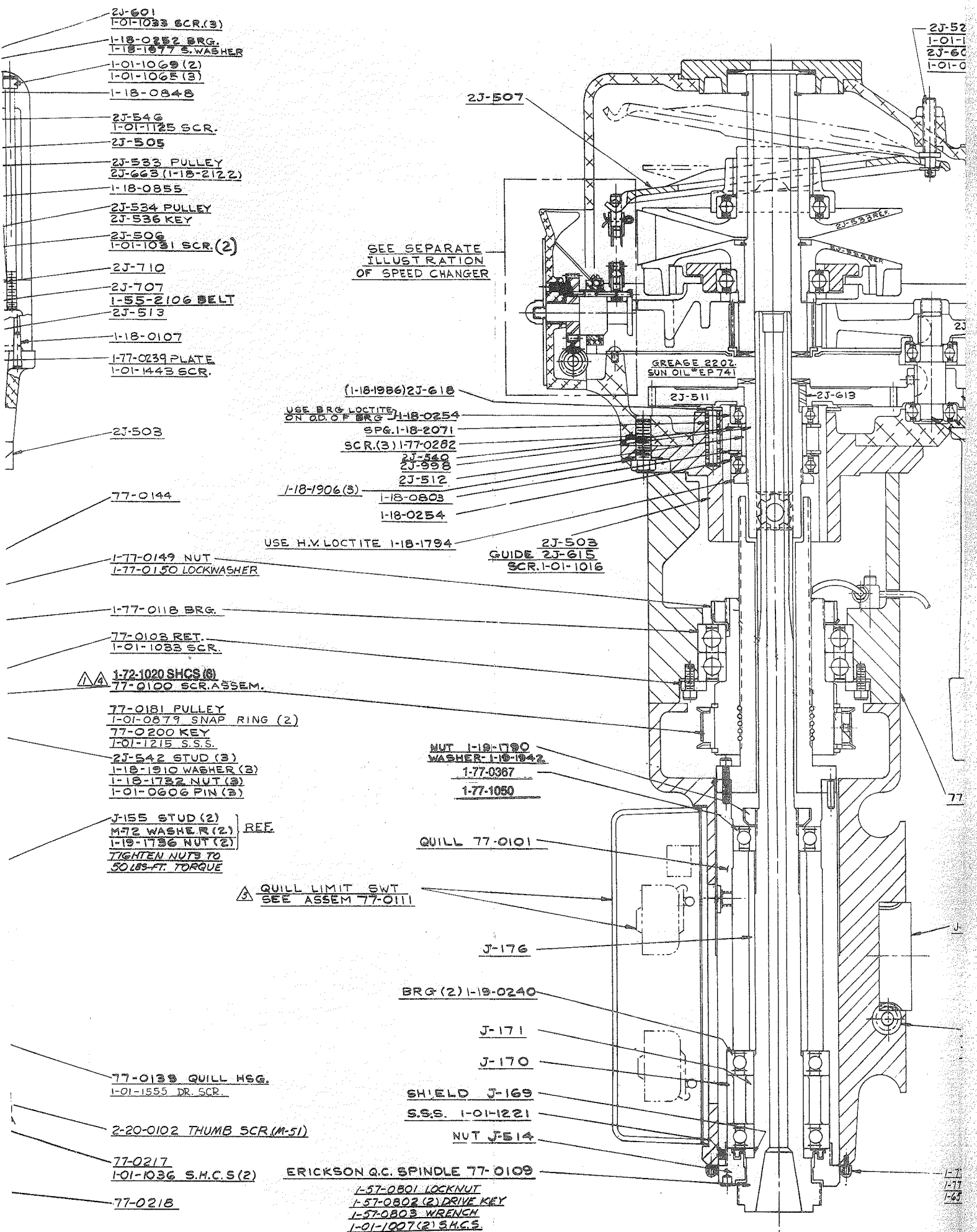
2081 SFG
1-18-1140 L'WELL
2J-522

REF { (2) STUD J-155
(2) SPACER J-84
(2) WASHER M-72
(2) NUT 1-18-1736
TIGHTEN UNITS TO
50 LBS.-FT. TORQUE



SECT. A-A

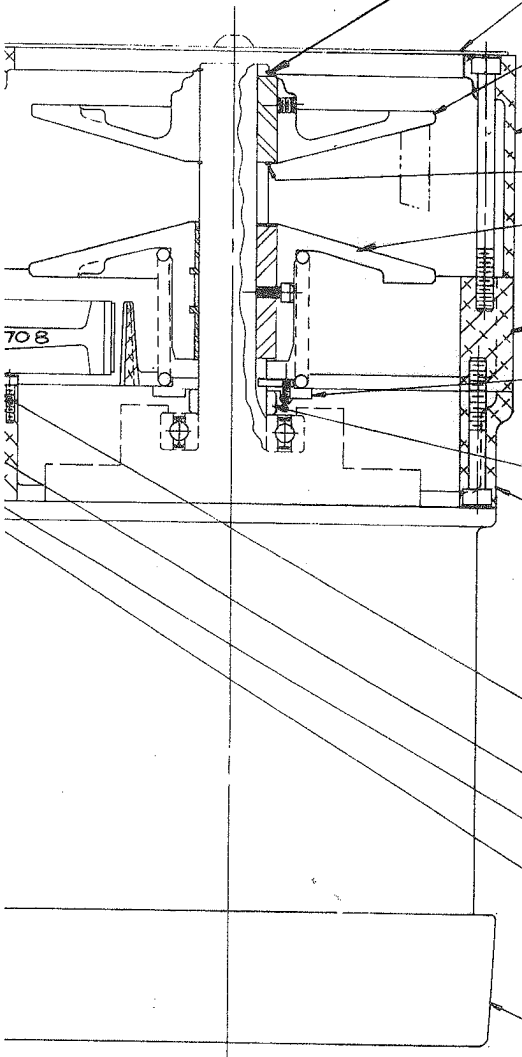
Figure 6-15. Series I CNC Head, V-Ram (Sheet 2)



A	ECN #1212	RM	5-2-76
B	ECN #1234	RM	5-2-76
C	ECN #1268	RM	5-10-76
D	ECN #1395	RM	5-10-76
E	ECN #1472	RM	5-2-76
F	ECN #1480	RM	10-5-76
G	ECN #1559	RM	5-2-76
H	ECN #1585	WLN	5-2-77
I	ECN #1586	RM	5-4-77
J	ECN #2039	DB	12-12-77
K	ECN #2107	DB	1-27-78
L	ECN #2180	DB	7-2-78

5 PIVOT
 1/45 NUT
 2 WASHER
 204 PIN

1-01-0880 SNAP RING (1)



77-0127 CAP
 1-28-0457 BHCS (2)

2-77-0182 PULLEY
 2J-647 KEY
 1-01-1222 S.S.S.

77-0128
 1-01-1069 SCR.(2)
 1-01-1065 SCR.(3) "SHOWN"
 1-11-0081 SNAP RING(1)

2J-642 PULLEY
 2J-648 BUSHING(2)
 2J-646 KEY
 1-01-1016 SCR.

77-0125
 2J-644 COLLAR
 2J-645 KEY
 1-01-1425 SCR.
 2J-661 SPRING

77-0143 SPACER

77-0126
 1-72-1060 SCR(3)

2J-528 CAP
 1-18-1975 SPG. WASHER(2)
 1-01-1011 SCR.

2J-529 GEAR
 1-01-1287 S.S.S.
 1-18-0235 BRG.(2)

2J-527 SHAFT
 1-19-1738 NUT
 1-01-3079 KEY

1-77-0101 MOTOR
 1-01-1150 SCR(2)
 1-19-1922 L.WASHER

0144 REF.

14 GEAR REF.

J-850 SHAFT
 I-140 GEAR
 01-3077 KEY

NOTES

- ▲ TORQUE TO ROTATE BALL QUILL EXT. NUT (77-0100) IS 13.4 OZ-IN. MAX. WHEN EXTENDING THE QUILL & 19.1 OZ-IN. MAX. WHEN RETRACTING THE QUILL. THIS IS EQUAL TO A 28 OZ. PULL ON DRIVE BELT (I-65-2110). EXTENDING THE QUILL & A 40 OZ. MAX. PULL, RETRACTING THE QUILL.
- ▲ BEND COPPER TUBE AS SHOWN IN SIDE VIEW TO DIRECT OIL INTO BALL QUILL EXTENSION (77-0100).
- ▲ ADJUST QUILL FEED DRIVE BELT (I-65-2110) TO HAVE 66 LBS. TENSION = 1/8 IN. DEFLECTION WITH 5 LB. FORCE APPLIED.
- ▲ BALL QUILL EXTENSION ASS'Y. INSPECTION AND CLEANING—SPEC. DWG. 77-0240, 77-0241, 77-0242
- ▲ QUILL DOWN FEED LIMIT SWITCH SETTING—SPEC. DWG. 77-0245.

CODE # 2770147

Bridgport MACHINES, INC. COMPANY			
BRIDGEPORT, CONN. U.S.A.			
MATL.	PAT. NO.	SERIES 1B	
M.T.		2 HP HEAD	
ASSY.	QTY.	ASSEMBLY	
SCALE FULL SIZE APPR.		REV.	
DR. SCS	DATE 1-30-78	REL'D.	77-0147 17

UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED TO BE IN INCHES
 ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED TO BE IN MILLIMETERS
 ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED TO BE IN MILLIMETERS
 ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED TO BE IN MILLIMETERS

0172
 0173
 1201(4) B.H.C.S.