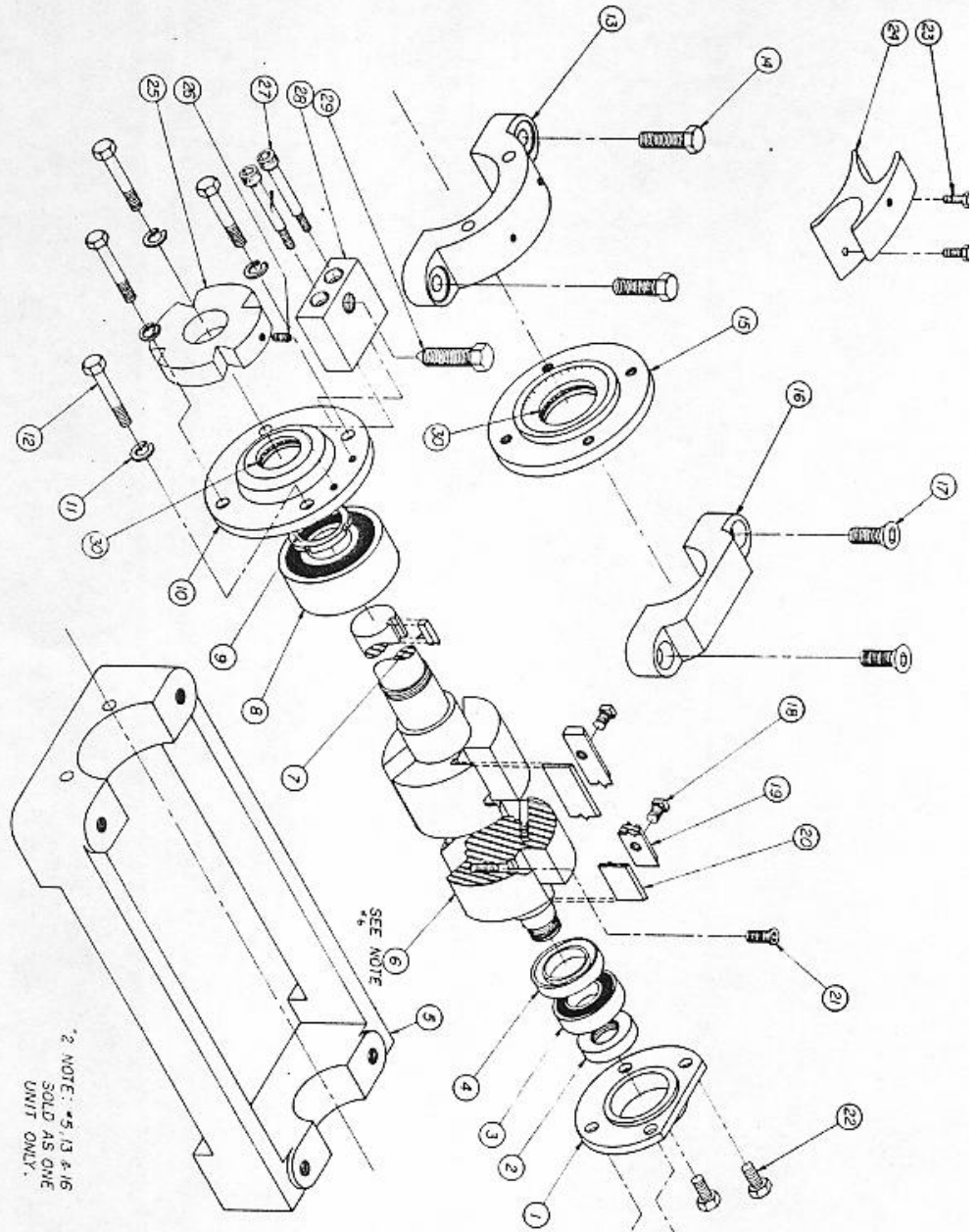


CHANGING BIG BEARING ON BELT DRIVE JOINTER YOKES

1. Shut off power to machine. Observe lockout/tagout procedures.
2. Remove belt guard, remove belts and remove pulley on cutterhead shaft.
3. Remove 25-435 Knife grinder index block (if any).
4. Remove the four 3/8" Hex Head bolts that hold the bearing covers in place and remove the JA-37 outside bearing cover.
5. Cut a wood wedge that can be driven between the 4" cutterhead body and the in feed side rails of the cutterhead yoke. This is to keep the cutterhead from turning when you remove the (right-hand thread) bearing nut. Using the factory-supplied bearing nut tan wrench, remove the bearing nut by rotating the wrench counter-clockwise.
6. The J-17 large bearing cap can be removed by removing the two 1/2" Hex Head bolts.
7. At this point, reinstall two of the 3/8" Hex Head bearing cover bolts in the lower holes and use them to stabilize the JA-38 inside bearing cover. This will be used to stabilize the cutterhead while the bearing is removed. Leave the bolts 1/4" loose.
8. A long-arm, 2-wing bearing puller* can be used to pull the 308 bearing off of the cutterhead shaft. Be sure to use the center hole protector on the puller screw to protect the 60° center in the end of the cutterhead shaft. ***(Most long-arm pullers have enough flexibility in the arm, where you can grab the bearing above the centerline of the bearing.)**
9. Before installing the new bearing, cut a wood block that fits between the end of the cutterhead and the inside of the cutterhead yoke by the small bearing. This is to prevent the cutterhead from shifting when you drive the new bearing out of the shaft.
10. With the new bearing slid onto the cutterhead shaft, get the outer race positioned in the yoke lower bearing bore. With the bearing on the shaft and laying in the yoke bore, drive the bearing on to the shaft until the inner race contacts the shoulder on the cutterhead shaft.
11. Replace the J-17 large bearing cap, but do NOT tighten the bolts yet.
12. Reinstall the bearing nut and tighten with the tang wrench. This time, drive the wood wedge in on the out feed side as you will be tightening by turning clockwise.
13. Remove the two 3/8" Hex Head bolts that were stabilizing the inside cover and reinstall the outside cover. Lightly tighten all four 3/8" bolts. This will position the large bearing cap so that its 1/2" Hex Head bolts can be tightened.
14. Reinstall the index plate, pulley, belts and belt guard.

*1 NOTE: FIND 6
 12- 3 KNIFE HEAD PART # 12-240
 12- 3 KNIFE HEAD PART # 12-241
 18- 3 KNIFE HEAD PART # 18-124
 18- 4 KNIFE HEAD PART # 18-125



*2 NOTE: *5, 13 & 16
 SOLD AS ONE
 UNIT ONLY.

QTY	PART #	DESCRIPTION	UNIT
1	30	12-292 FELT	1
1	24	29-398 INDEX STOP SCREW	1
1	25	435 INDEX BLOCK	1
2	27	COML COML 4x.4x.4 SHCS	2
1	25	25-30825-556 BRASS HD. SET SCREW	1
1	25	25-384 25-384 INDEX RING-4 KNIFE	1
1	25	NOG-134 NOG-134 INDEX RING-3 KNIFE	1
1	24	164-12 164-12 BEAR GUARD HOLDER	1
2	23	COML COML CAP SCREW 1/2x.3	2
2	21	23-412-234 KNIFE LEVELING SCR.	2
1	19	12-222 12-222 CUTTING KNIVES	1
2	17	12-187 12-187 SET SCREW	2
1	16	12-186 12-186 SET SCREW	1
2	15	1-15 1-15 SMALL BRG CAP 1/2x.3	2
1	14	JA-38 1/4-38 BRG INSIDE COVER	1
2	13	1-17 1-17 LARGE BRG CAP 1/2x.3	2
4	12	12-183 12-183 MACH SCREW	4
4	11	12-184 12-184 LOCK WASHER	4
1	10	JA-37 1/4-37 BRG OUTSIDE COVER	1
1	9	12-132 12-132 BRG RETAINING NUT	1
1	8	12-130 12-130 BEARING	1
1	7	12-235 12-235 KEY 3/8x.25	1
1	6	SEE NOTE #1	1
1	5	12-29 16-11 YOKE SEE NOTE #2	1
1	4	12-229 12-229 SEAL	1
1	3	12-131 12-131 BEARING	1
1	2	12-133 12-133 BRG RETAINING NUT	1
1	1	JA-40 1/4-40 SMALL BRG COVER	1

ASSEMBLY	DESCRIPTION	UNIT
BELT DRIVE		
JOINTER	12x.16" YOKE ASSY	1
	12-249	1