



Rev. 02-12-2020

## **Bevel Gear Turret Drive Conversion Bracket**

Part No. **PPP-BGTDC-B**

Pkg of 1



Installation time - 30 minutes.

1. Remove power from pinsetter electrical box.
  2. Remove long turret drive belt tension spring and set aside.
  3. Remove and discard existing long turret drive belt.
  4. Using a 1/2 socket, extension bar and ratchet, remove all 4 bolts attaching bevel gear drive aluminum housing to the elevator frame.
  5. Using a 9/16 socket or wrench, remove bolt, lock washer, and special flat washer from foul line side of jackshaft. **DO NOT DISCARD THE SPECIAL FLAT WASHER.** Discard the bolt and lock washer.
  6. Remove nylon pinion gear from jackshaft.
  7. Remove and discard rectangular key from jackshaft.
  8. Placed between the nylon pinion gear and cross conveyor drive pulley is 1 or 2 special spacers (washers). Remove spacer(s) from the jackshaft, but **DO NOT DISCARD** at this time.
  9. Place new drive pulley on jackshaft, with boss or set screw side of pulley toward foul line. **DO NOT install** key on shaft at this time. Slide pulley onto jackshaft until it contacts cross conveyor drive pulley. The face of the turret drive pulley should be even with or up to 3/16" from end of jackshaft. If this dimension is correct, then move to step 10 - if not place a spacer that was removed in step 8 in between the cross conveyor drive pulley and the new turret belt drive pulley to obtain this dimension.
  10. Remove turret drive pulley and install supplied key on the jackshaft. Align keyways on the pulley and jackshaft and install drive pulley on jackshaft over key.
  11. Install supplied 3/8-16 x 3/4 bolt, lock washer and special flat washer that was removed in step 5 to the end of jackshaft. It is recommended to tighten Allen head set screw in turret drive pulley with a 5/32" Allen wrench after tightening the 3/8" bolt.
  12. The bevel gear aluminum housing used 4 mounting holes to attach it to the elevator frame. Locate the 2 **LOWER** mounting holes in elevator frame. You will be using the lower set of holes to attach new idler pulley bracket / pulleyassy. to frame. The 2 upper mounting holes in elevator frame will no longer be used.
  13. Place supplied 5/16-18 x 3/4" bolts and lock washers into the 2 (see OPTIONAL below) upper slotted mounting holes positioning the "V" pulley to the 10-pin side of machine – **lightly secure**.
- \* **OPTIONAL** - For convenience, a centrally located lower slotted hole is provided - mechanics' preference only. An additional threaded hole must be provided (in pinsetter frame) to use this mounting hole.
14. Route supplied long turret belt onto turret drive, drive, and idler pulleys. See page 139 of the [green Brunswick service parts catalog](#) for proper positioning. Position idler bracket in slotted holes for best belt transfer angle (to idler pulleys) and secure.
  15. Reinstall idler pulley tension spring. Refer to the Brunswick A-2 service manual for proper belt tension.
  16. Restore pinsetter power and check for proper belt tracking.