

# Right Angle Grinders

## 4", 4-1/2" & 5"

PD07-38R  
August, 2021  
Supercedes PD07-38

**Safety, Operation and Maintenance – Save This Document and Educate All Personnel**

Model	Wheel Size	RPM	Spindle Thread
52630	4"	13,500	3/8"- 24
52632	4-1/2"	12,000	5/8"- 11
52633	5"	12,000	5/8"- 11

**SANDER**



**LIFETIME  
WARRANTY**

Find The Most Current Offering of Support Documents and Accessories at [www.Dynabrade.com](http://www.Dynabrade.com)

## **⚠ WARNING**

Read and understand this tool manual before operating your air tool. Follow all safety rules for the protection of operating personnel as well as adjacent areas. Always operate, inspect and maintain this tool in accordance with the American National Standards Institute (ANSI). Safety Requirements for the Use, Care and Protection of Abrasive Wheels – ANSI B7.1, and Safety Requirements for Abrading Materials with Coated Abrasive Systems – ANSI B7.7, Compressed Air and Gas Institute (CAGI) Safety Code for Portable Air Tools – B186.1, Code of Federal Regulation – CFR 29 Part 1910, International Organization for Standardization (ISO) Hand Held Non-Electric Power Tools – Safety Requirements ISO 11148 series and applicable State and Local Regulations.



Read and understand tool manual before work starts to reduce risk of injury to operator, visitors, and tool.



Eye protection must be worn at all times, eye protection to conform to ANSI Z87.1.



Ear protection to be worn when exposure to sound, exceeds the limits of applicable Federal, State or local statutes, ordinances and/or regulations.



Practice safety requirements. Work alert, have proper attire, and do not operate tools under the influence of alcohol or drugs.



Respiratory protection to be used when exposed to contaminants that exceed the applicable threshold limit values required by law.



Air line hazard, pressurized supply lines and flexible hoses can cause serious injury. Do not use damaged, frayed or deteriorated air hoses and fittings.

Some dust created by sanding, grinding, drilling, and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints
- Crystalline silica from bricks and cement and other masonry products
- Arsenic and chromium from chemically treated lumber

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

## **SAFETY and OPERATING INSTRUCTIONS**



Carefully Read and Understand the General and Grinder sections found in Tool Safety and Operating Guidelines (PN00001676) Before Handling or Using Tool.

Carefully Read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool. Products offered by Dynabrade are not to be modified, converted or otherwise altered from the original design.

**Tool Intent:** 4", 4-1/2" and 5" Right Angle Grinders are intended to be used by professional operators and are ideal for material removal using reinforced Type 27, Type 42 Depressed Center Wheels and Flap Disc Wheel with 7/8" center hole.

**DO NOT USE Tool for Anything Other Than Its Intended Applications.**

**Training:** Proper care, maintenance, and storage of your air tool will maximize tools performance and reduce chance for accident.

**Employer's Responsibility:** Provide operators with safety instructions and training for safe use of tools and accessories.

**Report to Your Supervisor any Condition of the Tool, Accessories or Operation you Consider Unsafe.**

## OPERATING INSTRUCTIONS

**Warning:** Always wear eye protection. Operator of tool is responsible for following: accepted eye, face, respiratory, hearing and body protection. Always use wheel guard. Make sure it is positioned to best protect the operator and make sure it is securely fastened. Wheel guards that are worn, damaged or have been subject to a wheel breaking must be replaced.

**Caution:** Hand, wrist and arm injury may result from repetitive work, motion and overexposure to vibration.

- Keep hand and clothing away from working end of the air tool.

**Operation:** Be sure that any loose clothing, hair and all jewelry is properly restrained.

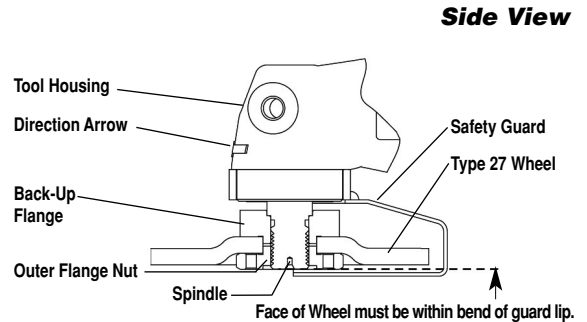
- Secure inlet bushing on air tool with a wrench before attempting to install the air fitting to avoid damaging housing assembly.
- **BEFORE MOUNTING A WHEEL,** after all tool repairs and whenever a grinder is issued for use, check tool RPM (speed) with tachometer with air pressure set at 90 PSIG while the tool is running. If tool is operating at a higher speed than the RPM marked on the tool housing, or operating improperly, the tool must be serviced and corrected before use.

**Warning:** Wheel speed rating must be approved for at least the tool RPM rating. Check accessory manufacturer for details on maximum operating speed or special mounting instructions.

### TYPE 27 Wheel Mounting

- Disconnect air source from the tool.
- Clean spindle and flange mounting surfaces. Inspect for nicks, cuts, sharp edges and thread wear.
- Use only Dynabrade model specific flanges. Install backup flange with raised boss facing outward as shown in diagram.
- **Warning: DO NOT** use bushings or adapters to mount wheels with larger holes.
- 4" Models: Thread backup flange onto spindle and firmly secure with a wrench.
- 4-1/2" & 5" Models: Slide backup flange onto spindle thread and align slot over wrench flats.
- Check for flange flatness and runout by rotating spindle.

- Inspect wheels for cracks and/or defects before mounting. Abrasive may have been dropped without notice. **Warning:** Never force a wheel onto raised boss.
- Before mounting wheel visually inspect for cracks and/or defects. **DO NOT** use a defective wheel.
- Install wheel center hole over the backup flange's raised boss as shown in diagram. Using spindle lock hand tighten wheel onto tool spindle, then secure firmly with wrench. For 1/8" thick wheels, mount outer flange with raised boss facing outward. **Warning:** Over tightening the flange can cause damage to the wheel and/or flanges.
- Remove flanges for threaded hub wheels. Thread wheel clockwise onto spindle. Check wheel is properly secure by engaging spindle lock and attempt to rotate wheel. (Opposite direction of arrow on tool housing.)
- Position guard to best protect the operator.



- Connect tool to air source. Be careful NOT to depress throttle lever in the process. **Do not expose air tool to inlet pressure above 90 PSIG or (6.2 Bars).**

**Warning:** After installing the accessory, make sure that no one is in the unguarded plane of the wheel before starting the grinder. IN A PROTECTED AREA, test run the wheel at a reduced speed to check for good balance. Gradually increase tool speed. DO NOT USE if tool vibration is excessive. Correct cause, and retest to insure safe operation. Test wheel at its free speed (RPM) in a protected area for at least one minute before applying the wheel to the work.

- DO NOT engage spindle lock while spindle is rotating.
- Make sure that work area is uncluttered, and visitors are at a safe range from the tools and debris.
- Air tools are not intended for use in explosive atmospheres and are not insulated for contact with electric power sources.
- Use a vise or clamping device to hold work piece firmly in place.
- Do not apply excessive force on tool or apply "rough" treatment to it.
- Always work with a firm footing, posture and proper lighting.
- Ensure that sparks and debris resulting from work does not create a hazard.
- Always be aware of bystanders in work areas.
- This tool has side exhaust. Rotate muffler cover by hand to desired exhaust direction. Exhaust may contain lubricants, vane material, bearing grease, and other materials flushed through the tool.

**Warning:** Grinding certain materials can create explosive dust. It is the employers responsibility to notify the user of acceptable dust levels.

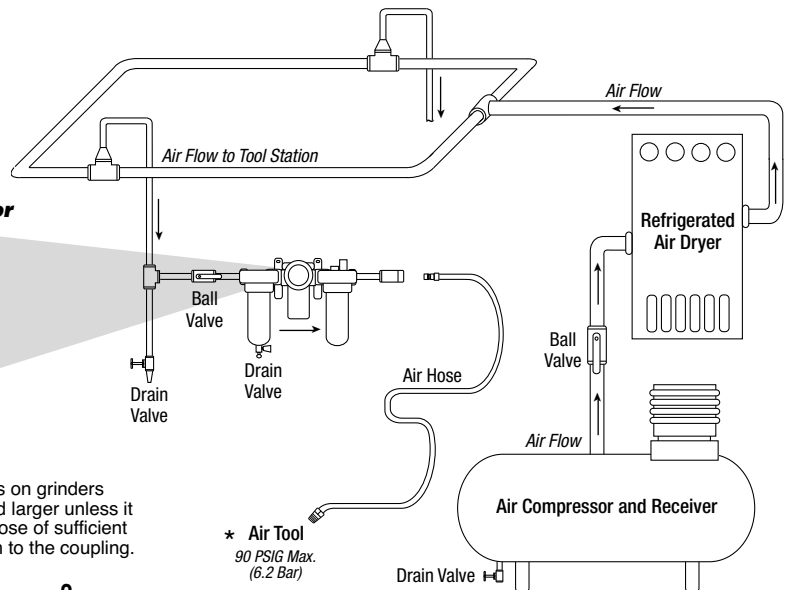
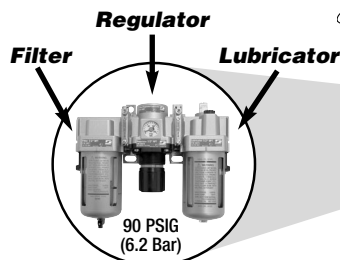
- Grinding can cause sparks which can cause fires or explosions. It is the users responsibility to make sure the work area is free of flammable materials.
- Use side handle provided to best control tool during grinding.

**Report to your supervisor any condition of the tool, accessories, or operation you consider unsafe.**

### CLOSED LOOP AIR SYSTEM

*Sloped in Direction of Air Flow*

- Dynabrade Air Power Tools are designed to operate at 90 PSIG (6.2 Bar) maximum air pressure at the tool inlet, when the tool is running. Use recommended regulator to control air pressure.
- Ideally the air supply should be free from moisture. To facilitate removing moisture from air supply, the installation of a refrigerated air dryer after the compressor and the use of drain valves at each tool station is recommended.



- \* Do not use quick disconnect couplings on grinders using wheels four inches diameter and larger unless it is separated from the tool by a whip hose of sufficient length to minimize transfer of vibration to the coupling.

\* Air Tool  
90 PSIG Max.  
(6.2 Bar)

#### Lubricator Setting

1 Drop/Minute per 20 SCFM

## MAINTENANCE INSTRUCTIONS

**Important:** To keep tool safe, a Preventative Maintenance Program is recommended. The program should include inspection of the tool and all related accessories and consumables, including air lines, pressure regulators, filters, oilers, etc. (refer to CAGI B186.1 for additional maintenance information). If accessory or tool breakage occurs, investigate failure to determine the cause and correct before issuing tool for work. Use the following schedule as a starting point in developing a Preventative Maintenance Program. If tool does not operate properly (RPM, vibration, start/stop) after these scheduled checks or at any time, the tool must be repaired and corrected before returning tool to use.

- Use only genuine Dynabrade replacement parts to insure quality. To order replacement parts, specify **Model#**, **Serial#** and **RPM** of your air tool.
- It is strongly recommended that all Dynabrade rotary vane air tools be used with a Filter-Regulator-Lubricator to minimize the possibility of misuse due to unclean air, wet air or insufficient lubrication. Dynabrade recommends the following: **11411** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components. Operates up to 55 SCFM @ 100 PSIG has 1/2" NPT female ports.
- **Lubricate wick system through the angle gear oil fitting with 2-3 plunges for every 24 hours of use, to achieve maximum gear life.**  
**Important:** Use only the recommended angle gear oil for the wick system. Do not contaminate the wick with any other oil or grease product. (Order **95848** Gear Oil and **95541** Gun) Always prime pump to insure good flow before lubricating gears.
- Dynabrade recommends one drop of air lube per minute for each 20 SCFM (example: if the tool specification states 40 SCFM, set the drip rate on the filter-lubricator to 2 drops per minute). Dynabrade Air Lube (P/N **95842**: 1 pt 473 ml) is recommended.

## ROUTINE PREVENTATIVE MAINTENANCE

- Check free speed of tool using a tachometer without abrasive accessory attached with 90 PSIG at inlet while tool is running. This governor controlled tool should be speed checked every 20 hours of use or weekly, whichever occurs more frequently. Always check tool speed after any maintenance or repair.
- Inspect wheel guard for wear or damage. Guards that are bent and severely worn or subject to a wheel breakage must be replaced.
- If wheel breakage occurs, investigate to determine the cause and correct before issuing tool for work.
- Mineral spirits are recommended when cleaning the tool and parts. Do not clean tool or parts with any solvents or oils containing acids, esters, ketones, chlorinated hydrocarbons or nitro carbons.
- **DO NOT** clean or maintain tools with chemicals that have a low flash point (example: WD-40®).
- A Motor Tune-Up Kit (P/N **96100**) is available which includes high wear and medium wear motor parts.
- Air tool labels must be kept legible at all times, if not, reorder label(s) and replace. User is responsible for maintaining specification information i.e.: **Model #**, **S/N**, and **RPM**. (See Assembly Breakdown)
- Blow air supply hose out prior to initial use.
- Visually inspect air hoses and fittings for frays, visible damage and signs of deterioration. Replace damaged or worn components.
- Refer to Dynabrade's Warning/Safety Operating Instructions Tag (Reorder No. **95903**) for safety information.

After maintenance is performed on tool, add a few drops of Dynabrade Air Lube (P/N **95842**) to the air line and start the tool a few times to lubricate air motor.

Check for tool vibration before mounting abrasive wheel accessory.

## HANDLING & STORAGE

- Use of tool rests, hangers and/or balancers is recommended.
- Protect tool inlet from debris (see Notice below).
- **DO NOT** carry tool by air hose. When carrying tool keep hands away from throttle lever to avoid accidental startup.
- Protect Type 27 wheel from exposure to water, solvents, high humidity, freezing temperature and extreme temperature changes.
- **DO NOT USE** Type 27 wheels that have been dropped or show signs of cracks, nicks or other defects.
- Store accessories in protective racks or compartments to prevent damage.

## END OF USE/DISPOSAL

When tool has reached its end of useful service, disassemble tool into its primary components (i.e. steel, aluminum and plastic) and recycle or discard per local, state and/or federal regulations as to not harm the environment.

## NOTICE

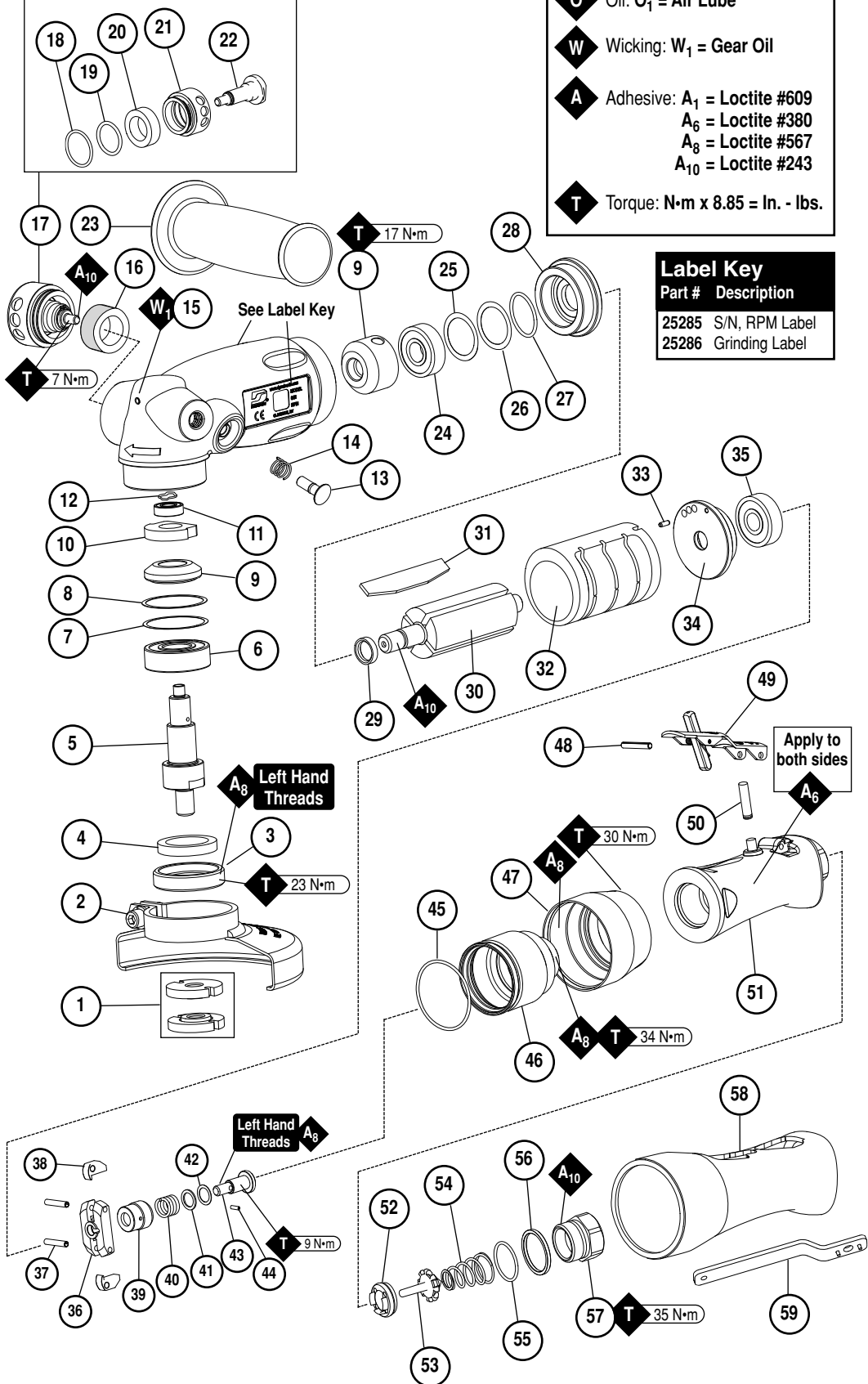
All Dynabrade air motors use the highest quality parts available and are manufactured to exacting tolerances. Air motor failures are often traced to lack of lubrication or unclean air supply. Compressed air can force dirt and other contaminants into motor bearings causing early failure. Contaminants can score cylinder wall and vanes resulting in reduced efficiency and power. Our warranty obligation is contingent upon proper use of our tools. Air motors which have been subjected to misuse, contaminated air or lack of lubrication will void warranty.

**For Models:**  
52630, 52632, 52633

## Right Angle Grinders Complete Assembly

ITEM	P/N	DESCRIPTION	QTY.
1	50318	LOCKING FLANGE - MODEL 52630	1
	50359	BACK-UP FLANGES - MODEL 52630	
	25262	BACK-UP FLANGE - MODELS 52632 & 52633	
	53696	LOCKING FLANGE - MODELS 52632 & 52633	
2	25214	GUARDS: 4" - MODEL 52630	1
	25212	4-1/2" - MODEL 52632	
	25215	5" - MODEL 52633	
3	25265	RETAINER	1
4	53609	FELT SEAL	1
5	25268	SPINDLES: 3/8-24" - MODEL 52630	1
	25270	5/8-11" - MODELS 52632 & 52633	
6	01036	BEARING	1
7	98288	SHIM	AR
8	98287	SHIM	AR
9	25230	BEVEL GEAR SET	1
10	25264	WICK	1
11	02057	BEARING	1
12	98243	WAVE SPRING	1
13	25273	PLUNGER ASSEMBLY (INCLUDES 96156 RING)	1
14	98285	SPRING	1
15		HOUSING ASSEMBLY (INCLUDES 01041 GEAR OIL FITTING & 25275 BUSHING)	1
	25223	MODEL 52630	
	25225	MODEL 52632	
	25226	MODEL 52633	
16	25283	SILENCER	1
17	25217	MUFFLER ASSEMBLY	1
18	98282	O-RING (2.5 MM)	1
19	98281	O-RING (1.5 MM)	1
20	25282	SILENCER	1
21	25278	MUFFLER COVER	1
22	25281	MUFFLER STEM ASSEMBLY	1
23	53134	VIBRATION DAMPENING HANDLE	1
24	01007	BEARING	1
25	01294	SHIM	AR
26	01293	SHIM	AR
27	98242	O-RING	1
28	25236	FRONT BEARING PLATE	1
29	01010	SPACER	1
30	25233	ROTOR	1
31	25234	VANE (4/PKG.)	1
32	25235	CYLINDER	1
33	96441	PIN	1
34	25237	REAR BEARING PLATE	1
35	01206	BEARING	1
36	25290	GOVERNOR CAGE	1
37	98279	PIN	2
38	25291	GOVERNOR WEIGHT	2
39	25293	GOVERNOR VALVE	1
40	25294	GOVERNOR SPRING	1
41	25298	SHIM (.25 MM THICK)	AR
42	25299	SHIM (.13 MM THICK)	AR
43	25297	SHIM (.8 MM THICK) - MODEL 52630	AR
44	25292	GOVERNOR SPINDLE	1
45	25295	PIN	1
46	66435	O-RING	1
47	25256	GOVERNOR HOUSING	1
48	25257	CUP NUT	1
49	12132	PIN	1
50	01950	HD SAFETY-LOCK LEVER	1
51	25247	VALVE STEM ASSEMBLY (INCLUDES 96443 O-RING)	1
52	25245	THROTTLE HANDLE (INCLUDES 25246 BUSHING)	1
53	51945	VALVE SEAT	1
54	25249	TIP VALVE	1
55	25250	SPRING	1
56	96442	O-RING	1
57	51940	SPACER	1
58	25213	INLET BUSHING (INCLUDES 51938 SCREEN)	2
59	25253	INSULATING COVER	1
59	96148 94925	PIN SPANNER WRENCH: MODEL 52630 MODELS 52632 & 52633	1

### 25217 Muffler Assembly



# DISASSEMBLY/ASSEMBLY INSTRUCTIONS - RIGHT ANGLE GRINDERS

**Important:** The Manufacturing Warranty is void if the tool is disassembled before the warranty expires by anyone other than a Dynabrade® Approved Repair Technician.

**Notice:** A 96100 Motor Tune-Up Kit is available. Also, the special repair tooling referred to in these instructions can be ordered through your Dynabrade® Distributor. Please refer to this tool manual for correct part number identification.

**Important:** Always follow these steps before servicing any part of this air tool.

1. Shut off the air supply, and depress throttle lever to dissipate the remaining air. Carefully disconnect the tool from the air supply hose.  
**Note:** Use a wrench to hold the air tool inlet bushing stationary when removing the air supply connection.
2. Remove any abrasive product, flanging, guard, and side handle.

## Motor Disassembly:

1. Use a 3mm drive punch to remove the throttle lever.
2. Roll back front edge of **25253** Insulating Cover just enough to expose wrench flats on **25257** Cup Nut.
3. Place padding around the housing and carefully hold the housing stationary in a vise. Use an adjustable wrench or **98283** Open End Wrench (sold separately) to loosen the **25257** Cup Nut. Turn counterclockwise. **Note:** Applying heat to cup nut will help loosen adhesive.
4. Carefully pull motor assembly out of the housing.
5. Hold pinion gear in a vise with aluminum or bronze jaws. Use an adjustable wrench or **95281** Open End Wrench (sold separately) to remove the governor assembly. LEFT HAND THREAD Turn clockwise.
6. Fasten **96346** 2" Bearing Separator around the portion of **25235** Cylinder that is closest to **25237** Rear Bearing Plate. Place the bearing separator motor on the table of the **96232** #2 Arbor Press with pinion gear pointing downward. Use a 3/16" or 4mm diameter flat end drive punch push rotor out of the **01206** Bearing.
7. Remove the vanes from rotor and **01206** Bearing from bearing plate.
8. Fasten the vane slot portion of rotor in a vise with aluminum or bronze jaws so that the pinion gear is pointing up.
9. Use a hook/pin spanner wrench unthread pinion gear from rotor. Turn counterclockwise.
10. Remove the front bearing plate, shims and **01010** Spacer.

## Motor Disassembly Complete.

## Spindle/Gear Disassembly:

1. Place padding around the housing and carefully hold the housing stationary in a vise with the spindle pointing up. Use the **97782** Pin Wrench (sold separately) or an adjustable pin wrench to remove **25265** Retainer. LEFT HAND THREAD Turn clockwise.
2. Remove **53609** Felt Seal from spindle or retainer.
3. Pull spindle and gear assembly out of the housing.
4. Fasten the **96346** 2" Bearing Separator under **02057** Bearing and press spindle through bearing. Remove **25264** Wick. Remove **98243** Wave Spring from the right angle housing.
5. Fasten the **96346** 2" Bearing Separator between **01036** Bearing and spiral bevel gear. Place the bearing separator along with the spiral bevel gear assembly on the table of the **96232** #2 Arbor Press so that the spindle thread is pointing down. Push the gear off the spindle.
6. Remove the **01036** Bearing the same way.
7. Remove the housing from vise.

## Spindle Disassembly Complete.

## Spindle Lock Disassembly:

1. Apply a small amount of the Dynabrade Air Lube 10W/NR (P/N **95842** or equivalent) around the **25273** Plunger Assembly.
2. Place padding around the housing and carefully hold the housing stationary in a vise with the plunger assembly facing up.
3. Use two flat blade screwdrivers to pry the plunger assembly out of the **25275** Spindle Lock Bushing.
4. Remove the **98285** Spring and the **97156** Ring from the plunger.

## Spindle Lock Disassembly Complete.

## Valve Disassembly:

1. Secure **25245** Throttle Handle in a vise using wrench flats so that the **25213** Inlet Bushing pointing upward.
2. Use an adjustable wrench, unthread **25213** Inlet Bushing. Turn counterclockwise.
3. Use needle nose pliers, pull **25249** Tip Valve from handle.
4. Use a small screwdriver to remove the **96443** O-Ring from the valve stem and remove the valve stem.
5. Position **25245** Throttle Handle in the vise with **25257** Cup Nut and **25256** Governor Housing pointing up. Use a 10 mm hex key to remove the **25256** and **25257**. Turn counterclockwise. **Note:** Applying heat to throttle handle will help loosen adhesive bond.
6. Push the **51945** Valve Seat out of the **25245** Throttle Handle.

## Valve Body Disassembly Complete.

**Important:** Clean and inspect all parts for wear before assembling. **Note:** Follow all lubricant, adhesive, and torque specifications.

## Valve Assembly:

1. Install **96443** O-Ring onto **25247** Valve Stem. Apply Dynabrade Air Lube to **96443** O-Ring and carefully install the valve stem and o-ring assembly into the throttle handle. **Note:** Rotating the valve stem while inserting prevents damage to the o-ring
2. Apply several drops of the Dynabrade Air Lube 10W/NR (P/N **95842** or equivalent) to valve seat pocket wall on the inside of the **25245** Throttle Handle before inserting the **51945** Valve Seat. Install the **51945** Valve Seat by aligning the 3 male prongs of the valve seat with three slots of the valve seat pocket in the throttle handle. **Note:** Use an arbor press and the **96241** Bearing Press Tool to support the valve seat and press it into the valve seat pocket. Make certain that the valve seat lays flat.
3. Use needle nose pliers install **25249** Tip Valve into the throttle handle.
4. Install **51940** Spacer onto **25213** Inlet Bushing, followed by the **96442** O-Ring. Install the larger end of the **25250** Spring into the inlet bushing. The smaller end of the spring fits against the back of the tip valve.
5. Apply a small amount of the Loctite® #243 (or equivalent) to the external threads of the **25213** Inlet Bushing and install it onto the throttle handle. Secure throttle handle in a vise using wrench flats. (Torque to 35N-m/310 lbs. in.)
6. Position the throttle handle in vise with the inlet bushing pointing downward.
7. Install the **66435** O-Ring onto the **25256** Governor Housing. Apply some Dynabrade Air Lube to the o-ring. Insert the governor housing through the **25257** Cup Nut. Apply a small amount of the Loctite® #567 (or equivalent) to the external threads of the governor housing. Use a 10 mm hex key to fasten the governor housing and cup nut onto the throttle handle. Turn clockwise. (Torque to 34N-m/300 lbs. in.) **Note:** The position of the throttle lever can be adjusted to any 360° location.
8. Apply a few drops of Loctite® #380 (or equivalent) to both sides of the throttle handle (as shown). Install the **25253** Insulating Cover and the **01462** Throttle Lever onto the throttle handle.

## Valve Assembly Complete.

(continued on next page)

## **DISASSEMBLY/ASSEMBLY INSTRUCTIONS - RIGHT ANGLE GRINDERS (CONT.)**

### **Spindle Lock Assembly:**

1. Install a new **97156** Ring onto the plunger and apply a small amount of the Dynabrade Air Lube 10W/NR (P/N **95842** or equivalent) to the o-ring and plunger.
2. Install **98285** Spring onto the housing bushing and insert the **25273** Plunger Assembly through the spring.
3. Install the plunger assembly into the spindle lock bushing. **Note:** Rotating the plunger while inserting prevents damage to the o-ring.

### **Spindle Lock Assembly Complete.**

### **Motor Assembly:**

1. Install **01010** Spacer onto the rotor front mandrel.
2. Select .003" (.08mm) thickness shims from the **01121** Shim Pack and install these into the **25236** Front Bearing Plate.
3. Install **98242** O-Ring into front bearing plate groove and install **01007** Bearing, into the front bearing plate.
4. Position the rotor in a vise with aluminum or bronze jaws so that the rotor spindle is pointing up. Install the front bearing/plate onto the rotor.
5. Apply a small amount of the Loctite® #243 (or equivalent) to the external threads on the rotor stem and install the pinion gear. (Torque to 17N·m/150 lbs. in.) Using a hook/pin spanner wrench. Remove the assembly from the vise.
6. Use a .001" (0.3mm) thick feeler gauge to check the clearance between the front bearing plate and the face of the rotor. The clearance should be .001"-.0015" (0.3-0.4mm).  
**Note:** If the clearance needs adjustment repeat steps 2-6 adding or removing shims as required.
7. Lubricate **25234** Vanes (4) with the **95842** Dynabrade Air Lube 10W/NR (or equivalent) and install these into the rotor.
8. Install **25235** Cylinder over the rotor so that the air inlet opening of the cylinder will line up with the air inlet opening on the **25237** Rear Bearing Plate.
9. Install **01206** Bearing into **25237** Rear Bearing Plate.
10. Use the raised inner diameter of **96244** Bearing Press Tool and the arbor press to install the rear bearing plate onto the rotor.  
**Note:** Carefully press the bearing/plate down until it just touches the cylinder. This will establish a snug fit between the bearing plates and the cylinder.
11. Fasten the pinion gear in a vise with aluminum or bronze jaws so that the rear bearing/plate pointing up.
12. Apply a small amount of the Loctite® #567 (or equivalent) to the external threads of governor assembly. Install it onto the rotor using an 19 mm crowfoot and torque wrench. LEFT HAND THREAD Turn counterclockwise. (Torque to 9N·m/80 lbs. in.)
13. Carefully slide the motor assembly into the housing.
14. Place padding around the housing and carefully hold the housing stationary in a vise. Apply a small amount of the Loctite® #567 (or equivalent) to housing external threads. Use an adjustable wrench tighten **25257** Cup Nut onto housing. Turn clockwise. (Torque to 30N·m/265 lbs. in.)

**Important: Allow 30 minutes for the adhesives to cure before operating the tool.**

**Run the tool to make sure that the air motor is functioning properly before installing the right angle gears. Motor Assembly Complete.**

### **Spindle/Gear Assembly:**

1. Position the spindle in the arbor press so that the threaded end is pointing down.
2. Use a 19/32" deep well socket as a press tool, install the **01036** Bearing onto the spindle and against the step.
3. Use a 19/32" deep well socket as a press tool and install the **25241** Bevel Pinion onto the spindle.
4. Prepare the **25264** Wick by soaking in **95848** Gear Oil and then install the wick onto the spindle.
5. Press **02057** Bearing using **96243** Press Tool (sold separately) onto spindle until the spindle is flush with the bearing top.
6. Place padding around the housing and carefully hold the housing stationary in a vise with the right angle spindle opening facing up.

**Important: Follow these steps to adjust the fit or "backlash" of the spiral bevel gear/pinion gear.**

7. Install the spindle assembly into the housing align wick shape to housing contour. Mesh bevel and pinion gears together.
8. Apply a small amount of downward force on the spindle and rotate the spindle 360°. The rotation should be smooth without any tight feel or binding of the gear teeth. Next, rotate the spindle forward and backward to check the amount of backlash (free movement between the gear teeth). The correct fit should be minimal backlash without any binding of the gear teeth. Add or remove shims to adjust the gear "backlash".
9. Place the **53609** Felt Seal into the **25265** Retainer recess bore.
10. Apply a small amount of the Loctite® #567 (or equivalent) to the threads of the retainer and use the **97782** Pin wrench to install the retainer onto the housing. LEFT HAND THREAD Turn counterclockwise. (Torque to 23N·m/203 lbs. in.)
11. Re-check the fit of the gears by hand before connecting the tool to the air supply. The correct fit should be minimal backlash without any binding of the gear teeth. Add or remove shims to adjust the gear fit if necessary.
12. Use the **95541** Lubricant Gun to apply the **95848** Gear Oil Lubricant required for the lubricating wick prime the plunger before adding gear oil to housing. Inject three full plunges of the gear oil into the **01041** Gear Oil Fitting on the front of housing.  
**Note:** Inject three full plunges of gear oil into the lubricant fitting after operating the tool every 24-hour interval of use.

### **Right Angle Assembly Complete:**

### **Muffler Assembly:**

1. Install **25282** Silencer (Cross section size: 7.5 mm) up and inside recess diameter of **25278** Muffler Cover.
2. Install the **98281** O-Ring (Cross section size: 2.4 mm) into the inside groove of the muffler cover.
3. Install the **98282** O-Ring (Cross section size: 2.0 mm) into the outside groove of the muffler cover.
4. Install **25278** Muffler Cover (the side with the smaller hole) onto **25281** Muffler Stem Assembly.
5. Install **25283** Silencer (Cross section size: 13 mm) into housing cavity.
6. Apply a small amount of the Loctite® #243 (or equivalent) to the external threads of the **25281** Muffler Stem Assembly. Install the **25217** Muffler Assembly onto the housing. Rotate **25281** Muffler Stem Assembly until slot aligns with housing raised boss. Thread socket head cap screw into housing using a 5/32" hex key (Torque to 7N·m/60 lbs. in.).

### **Muffler Assembly Complete.**

### **Final Assembly:**

**Important: Allow 30 minutes for the adhesives to cure before operating the tool. Install and properly position all guarding and auxiliary side handle. Before installing mounting flanges or any abrasive product, the air tool must be tested for proper operation. Follow these steps to verify the correct rated operating speed of the tool.**

1. Supply 3 drops of **95482** Dynabrade Air Lube 10W/NR (or equivalent) into the air inlet bushing of the tool while the throttle lever is depressed. Allowing the oil to flow into the air motor.
2. Release the throttle lever.
3. With the air supply valve in the OFF position, carefully connect the tool to the air supply hose. **Note:** Use a wrench to hold the air inlet bushing on the tool stationary when installing the air supply connection.
4. Once the tool is connected to the air supply, turn the supply valve to the ON position. Run the tool and use a tachometer to verify the rated operating speed (RPM) of the tool. The tool should operate within 5% of the maximum rated RPM. The tool RPM must never exceed the maximum rated RPM with the operating air supply pressure reading 90 PSIG (6.2 bar g) at the air inlet of the tool. To adjust free speed add or remove shims. Adding shims will increase the speed, removing shims will reduce the tool free speed. Once the correct rated operating speed for the tool is verified, disconnect the tool from the air supply and install the proper flanging and abrasive product.

### **Final Assembly Complete. Tool Assembly Complete.**

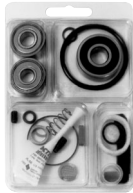
# PREVENTATIVE MAINTENANCE SCHEDULE

For Model All 4" - 5" Right Angle Grinders

This service chart is published as a guide to expectant life of component parts. The replacement levels are based on average tool usage over one year. Dynabrade Inc. considers one year usage to be 1,000 hours.

## Parts Common to all Models:

LEGEND	
<b>T</b>	Included in Tune-Up Kit
<b>X</b>	Type of wear, no other comments apply.
<b>L</b>	Easily lost. Care during assembly/disassembly.
<b>D</b>	Easily damaged during assembly/disassembly.
<b>R</b>	Replace each time tool is disassembled.



96100 – Motor Tune-Up Kit

Index #	Part Number	Description	Number Required	High Wear 100%	Medium Wear 70%	Low Wear 30%	Non-Wear 10%
1	See Note	Flanges	2				X
2	See Note	Guard	1				X
3	25265	Retainer	1				X
4	53609	Felt Seal	1		T		
5	See Note	Spindle	1				X
6	01036	Bearing	1		T		
7	98288	Shim	1		T		
8	98287	Shim	1		T		
9	25230	Bevel Gear Set	1			X	
10	25264	Wick	1		T		
11	02057	Bearing	1		T		
12	98243	Wave Spring	1			T	
13	25273	Plunger Assembly	1			T	
14	98285	Spring	1				X
15	See Note	Housing	1				X
16	25283	Silencer	1		T		
17	25217	Muffler Assembly	1				X
18	98282	O-Ring	1		T		
19	98281	O-Ring	1		T		
20	25282	Silencer	1		T		
21	25278	Muffler Cover	1				X
22	25281	Muffler Stem Assembly	1				X
23	53134	Vibration Dampening Handle	1				X
24	01007	Bearing	1		T		
25	01294	Shim	1		T		
26	01293	Shim	1		T		
27	98242	O-Ring	1		T		
28	25236	Front Bearing Plate	1		X		
29	01010	Spacer	1			X	
30	25233	Rotor	1				X
31	25234	Vane (4/pkg.)	1	T			
32	25235	Cylinder	1			X	
33	96411	Pin	1				X
34	25237	Rear Bearing Plate	1			X	
35	01206	Bearing	1		T		
36	25290	Governor Cage	1			X	
37	98279	Pin	2		X		
38	25291	Governor Weight	2			X	
39	25293	Governor Valve	1			X	
40	25294	Governor Spring	1			X	
41	25298	Shim	1			X	
42	See Note	Shim	1			X	
43	25292	Governor Spindle	1			X	
44	25295	Pin	1			X	
45	66435	O-Ring	1			T	
46	25256	Governor Housing	1			X	
47	25257	Cup Nut	1			X	
48	12132	Pin	1		T		
49	01462	Safety-Lock Lever	1			X	
50	25247	Valve Stem Assembly	1		T		
51	25245	Throttle Handle	1			X	
52	51945	Valve Seat	1			T	
53	25249	Tip Valve	1			T	
54	25250	Spring	1			T	
55	96442	O-Ring	1		T		
56	51940	Spacer	1			X	
57	25213	Inlet Bushing	1			X	
58	25253	Insulating Cover	1			X	

**Note:** Please refer to page 4 for specific part number and description.

## LIFETIME WARRANTY

To validate Dynabrade Lifetime Warranty, you must register each tool at: [www.dynabrade.com](http://www.dynabrade.com). Registration of each tool at website is required. Dynabrade will not honor Lifetime Warranty on unregistered tools. Please view the entire Lifetime Warranty Policy at : [www.dynabrade.com](http://www.dynabrade.com).

## MACHINE SPECIFICATIONS

Model	Speed	Power	Air Consumption	Spindle Thread	Weight	Length	Height
52630	13,500 RPM	1.3 hp (969 W)	43 SCFM (1218 LPM)	3/8"-24 Male	4.8 lbs. (2.2 kg)	10" (255 mm)	3.4" (88 mm)
52632	12,000 RPM			5/8"-11 Male	5.1 lbs. (2.3 kg)	10" (255 mm)	3.8" (96 mm)
52633	12,000 RPM			5/8"-11 Male	5.4 lbs. (2.5 kg)	10" (255 mm)	3.8" (96 mm)

Additional Specifications: Air Inlet Thread 3/8" NPT • Hose I.D. 3/8" (10 mm)  
Visit [dynabrade.com](http://dynabrade.com) for your model's current vibration and sound data.

## WHEEL SELECTION CHART

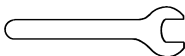
Dia. Wheel	Thru Hole Size	Min. RPM Rating	Spindle Thread	Wheel Thickness
4"	5/8"	13,500 RPM	3/8"-24 Male	1/8" - 1/4"
4-1/2"	7/8"	12,000 RPM	5/8"-11 Male	
5"	7/8"	12,000 RPM	5/8"-11 Male	

## OPTIONAL ACCESSORIES



### Backup Flange Part No. 53697

- Mount high profile flap disc wheels with 7/8" center hole.



### Wrenches

- 98283 - Open End (1-5/8")
- 95281 - Open End (19mm)
- 97782 - Pin Wrench
- 94925 - Pin Wrench - Mdl: 52632-33
- 96148 - Pin Wrench - Mdl: 52630
- 95049 - Hex Key (3/16")



### Motor Tune-Up Kit Part No. 96100

- Includes assorted parts to help maintain and repair motor.

### Additional Repair Tools (Not Shown)

- 96244 - Bearing Press Tool
- 96243 - Bearing Press Tool
- 96346 - Bearing Separator
- 96208 - Repair Collar

## SPECIAL GREASE INSTRUCTIONS



Lubricate wick system through the angle gear oil fitting with 2-3 plunges for every 24 hours of use, to achieve maximum gear life. Prime pump to insure good oil flow.

**Important:** Use only the recommended angle gear oil for the wick system. Do not contaminate the wick with any other oil or grease product. Insure that all 3 plunges of oil are injected through the fitting. (Order **95848** Gear Oil and **95541** Gun)

## REFERENCE CONTACT INFORMATION

American National Standards Institute (ANSI)  
[www.ansi.org](http://www.ansi.org)

Compressed Air & Gas Institute (CAGI)  
[www.cagi.org](http://www.cagi.org)

European Committee for Standardization (PNEUROP)  
[www.pneurop.org](http://www.pneurop.org)

International Organization of Standards (ISO)  
[www.iso.org](http://www.iso.org)

U.S. Government Publishing Office (GPO)  
[www.gpo.gov](http://www.gpo.gov)

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