

**Disassembly Instructions - 2 & 3 hp. Vertical Sanders & Grinders**

**Models:** 53232, 53233, 53234, 53235, 53242, 53243, 53244, 53245, 53249, 53251, 53252, 53253, 53261, 53262, 53263

**Important:** Use these instructions along with tool parts page or manual.

**Notice:** Shut off air supply and depress throttle lever to deplete remaining air.

- Disconnect tool from air supply hose.
- Remove all accessories (abrasive product, backup disc, and flanges).

**Motor Disassembly:**

1. Use 10 mm socket wrench to remove **50508** Screws.
- Remove housing cover or guard.

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2. Remove **95881** O-Ring and motor from housing.

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3. Fasten **55236** Nut in vise with aluminum or bronze jaws so that governor assembly is pointing up.
  - Use 5 mm pin spanner wrench to remove governor assembly and it set aside<sup>1</sup>. Turn clockwise. **Left Hand Thread.**

<sup>1</sup> See Step #7. Governor Instructions.  
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4. Remove **55202** Rear Bearing Plate, bearing, cylinder, and vanes.

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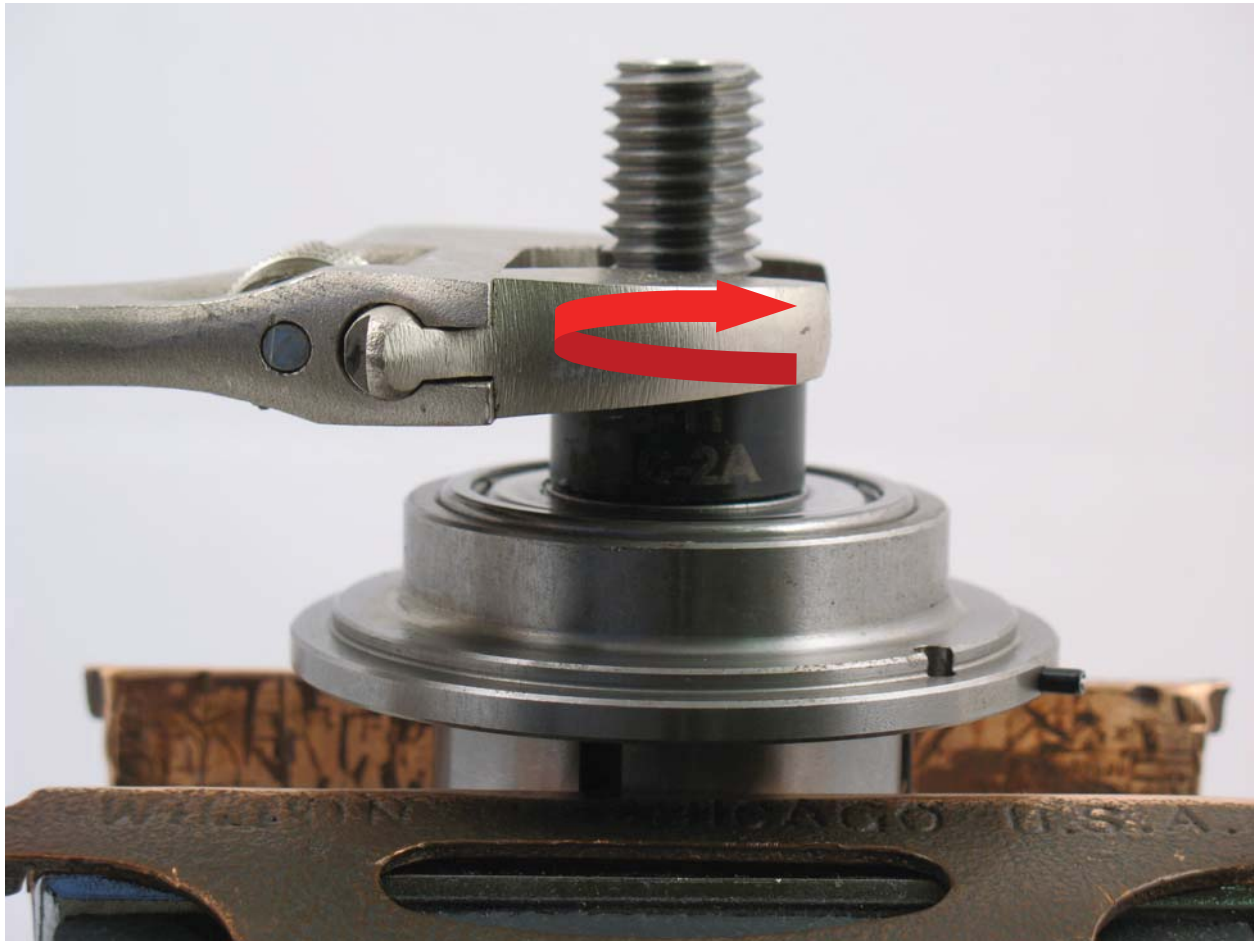
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5. Loosen vise, invert assembly and fasten rotor in vise with spindle pointing up.
  - Use an adjustable wrench to remove **55236** Nut. Turn counterclockwise.

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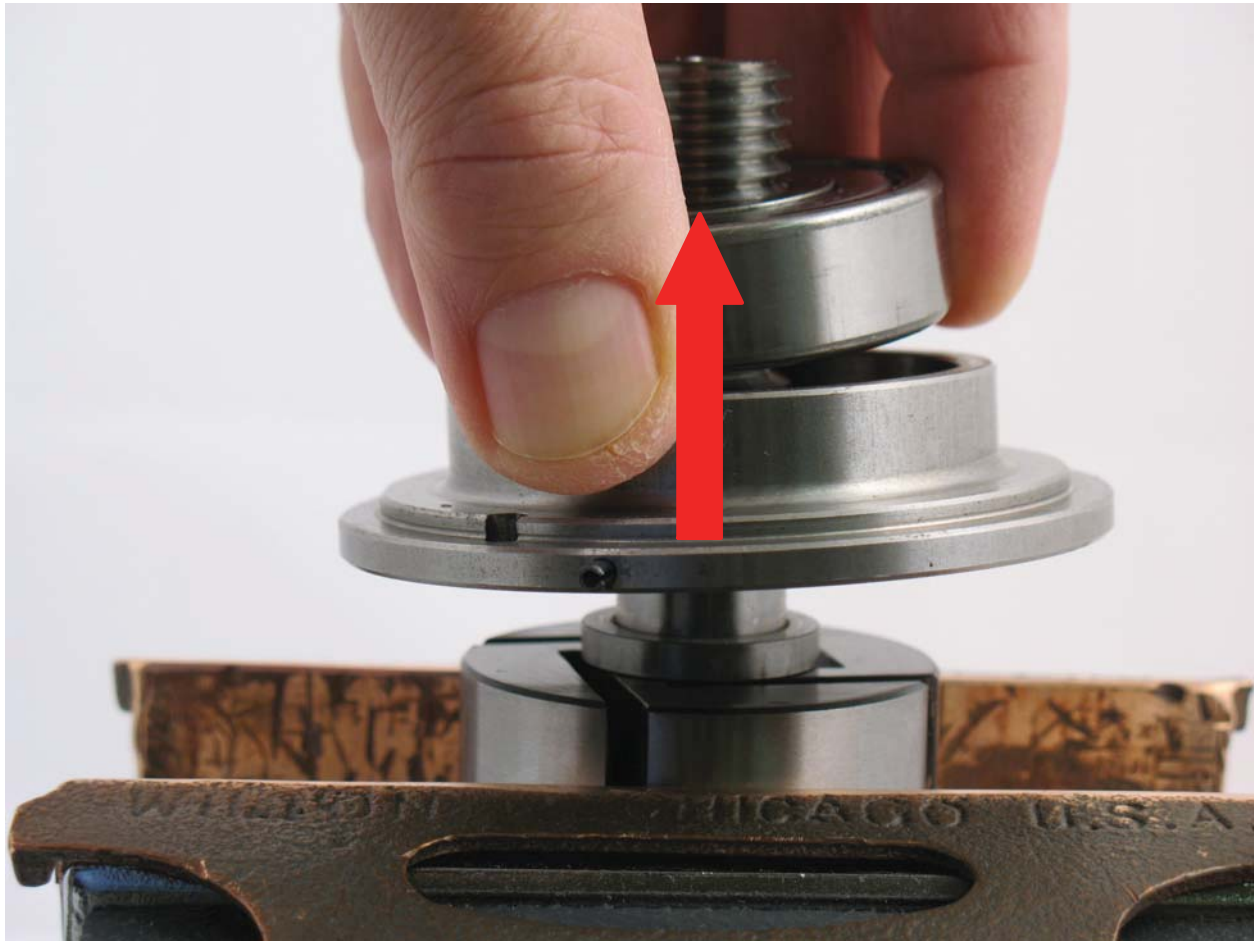
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6. Remove front bearing plate, bearing, shims and **55223** Spacer from rotor.

**Motor disassembly completed.**

#### **Valve/Throttle Handle and Muffler Disassembly:**

Refer to tool parts page or manual. Follow exploded view instructions to disassemble valve and muffler components.

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- 7. Governor Instructions:** Inspect governor components for wear or damage.
- A.** If governor components are worn or damaged, return complete air tool to factory for repair.
  - B.** If Overspeed Shut-Off Ring has been activated, reset ring according to instructions.

### OVERSPEED SHUT-OFF RING

If the tool stops suddenly or does not reach the rated tool speed, the overspeed shut-off ring may have activated, closing off the inlet air supply. The tool must be serviced to correct the problem and the overspeed shut-off ring must be properly reinstalled for safe use.

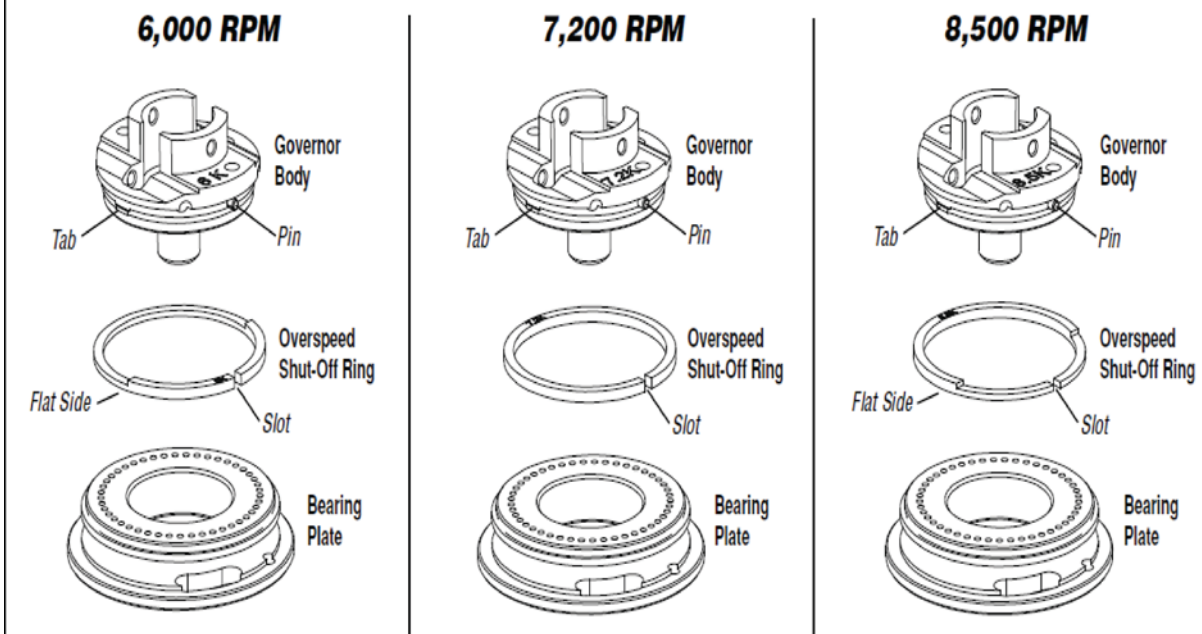
**DANGER**

**IMPROPER INSTALLATION OR SERVICING OF OVERSPEED SHUT-OFF RING MAY RESULT IN SERIOUS INJURY OR DEATH.  
BEST SERVICED BY FACTORY**

### GOVERNOR ASSEMBLY - PROPER ORIENTATION OF OVERSPEED SHUT-OFF RING

INSTALL SHUT-OFF RING OVER BOTH TAB FEATURES ON THE GOVERNOR BODY WITH SLOT FEATURE CENTERED ON THE PIN.

**IMPORTANT:** ORIENT FLAT SIDE OF SHUT-OFF RING TOWARD BEARING PLATE.



- Important:** With overspeed shut-off ring reset and governor assembly properly fastened onto motor assembly, check freespeed of tool without any accessory or abrasive product attached to tool. Use a tachometer to check RPM.
- Notice:** Check air line pressure with gauge. (**max. 90 PSIG or 6.2 Bar operating pressure at the air inlet of the tool.**)

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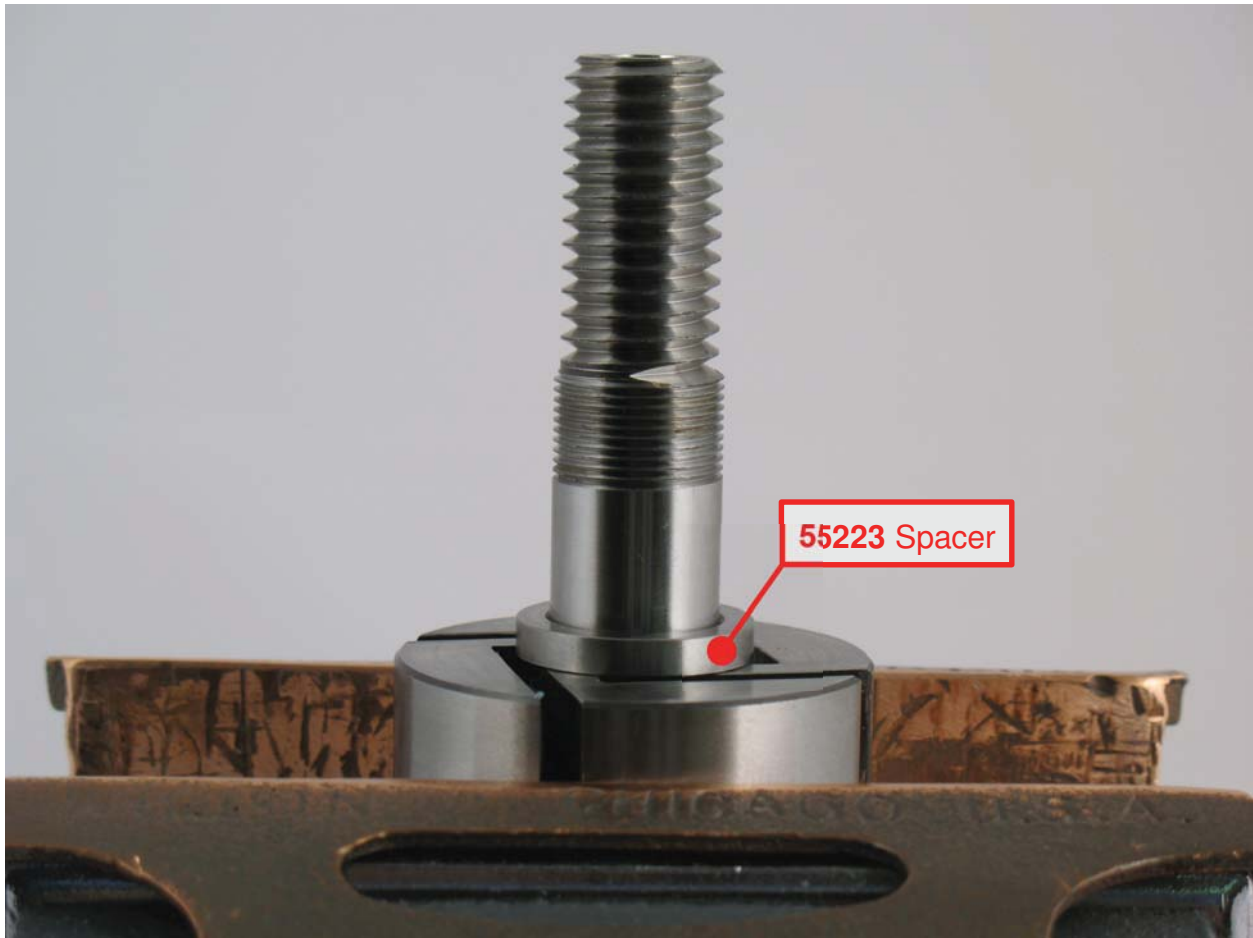
## ***Disassembly/Assembly Instructions***

Clean and inspect parts for wear or damage before assembling.

### **Assembly Instructions - 2 & 3 hp. Vertical Sanders & Grinders**

**Models:** 53232, 53233, 53234, 53235, 53242, 53243, 53244, 53245, 53249, 53251, 53252, 53253, 53261, 53262, 53263

#### **Motor Assembly:**



1. Fasten rotor in vise with aluminum or bronze jaws so that spindle is pointing up.
  - Install **55223** Spacer onto rotor.

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2. Install **52470** Shim (.003" or ~0.08 mm, thick).
  - Place shim in **55203** Front Bearing Plate.

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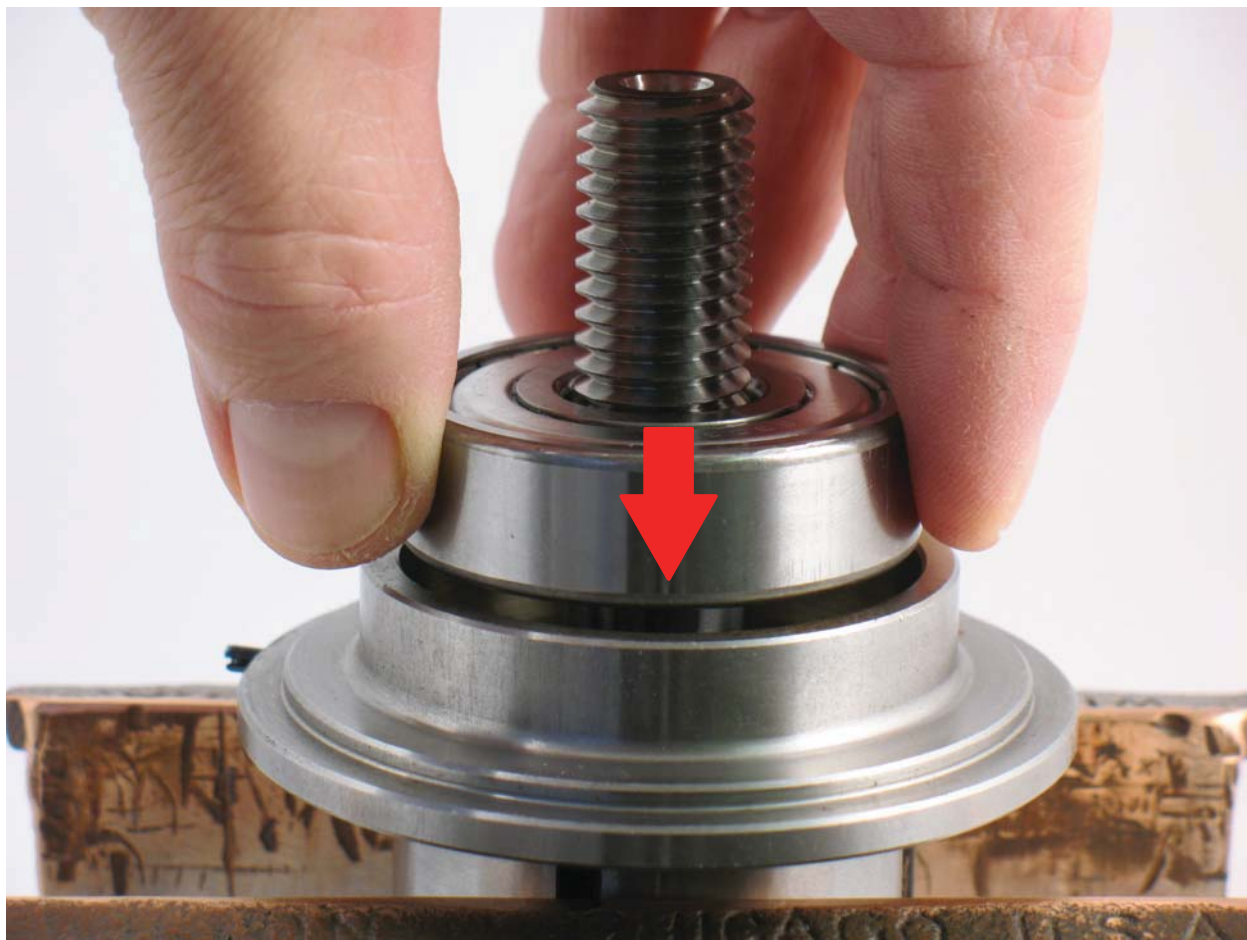
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3. Install front bearing and plate onto rotor.
  - Install **55236** Nut.
  - Remove assembly from vise.

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4. Place end rotor spindle on a flat surface. Push down on bearing plate, and use a .001" (~0.03 mm) thick feeler gauge to check clearance between front bearing plate and rotor.
- **Notice:** The amount of clearance should be .001"-.0015" (~0.03-0.04 mm).
- If necessary, repeat steps **2 - 4** and use shims as required to set clearance.

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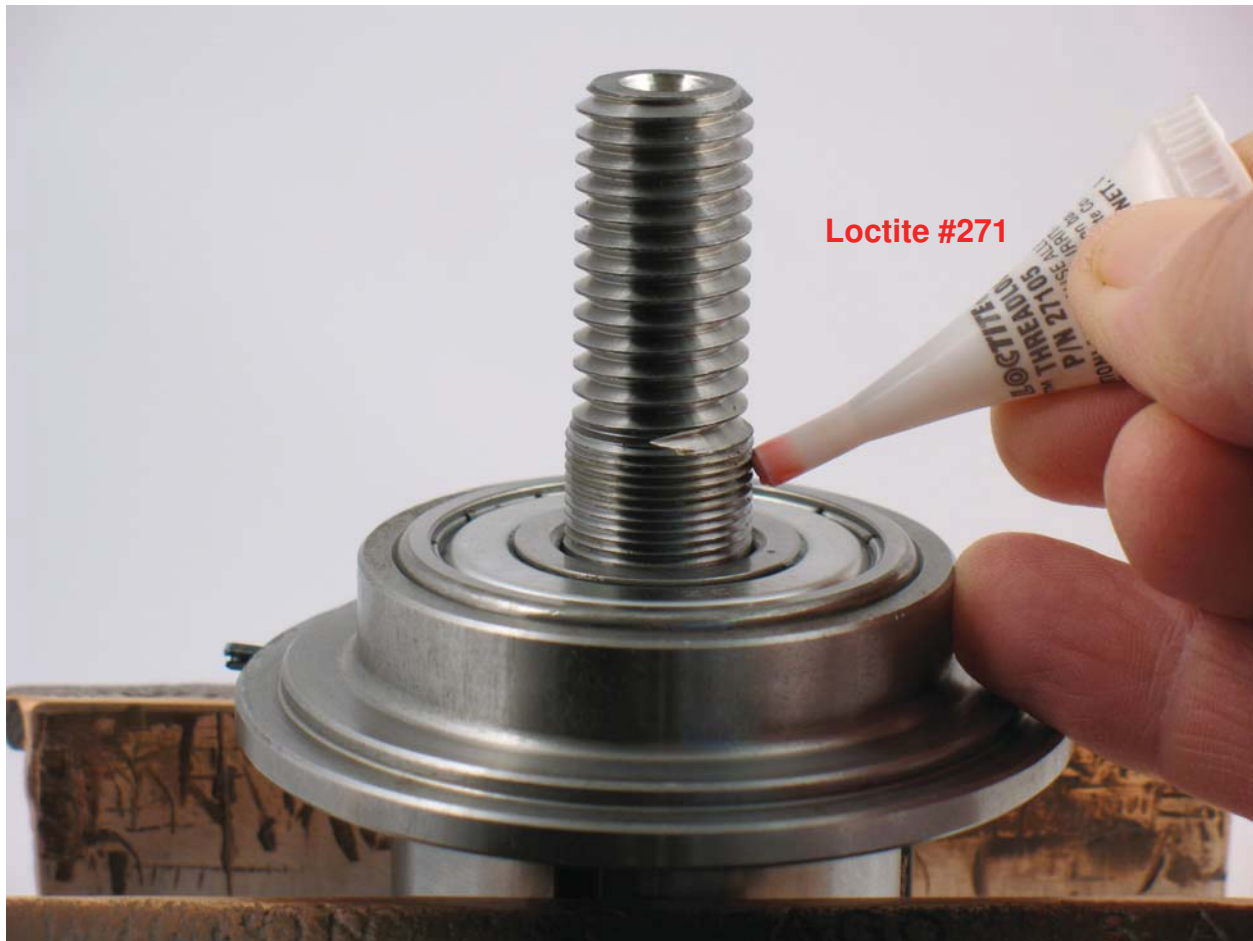
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5. Fasten rotor in vise with spindle pointing up.
  - Remove **55236** Nut, and apply a small amount of Loctite #271, or equivalent to rotor threads for nut.

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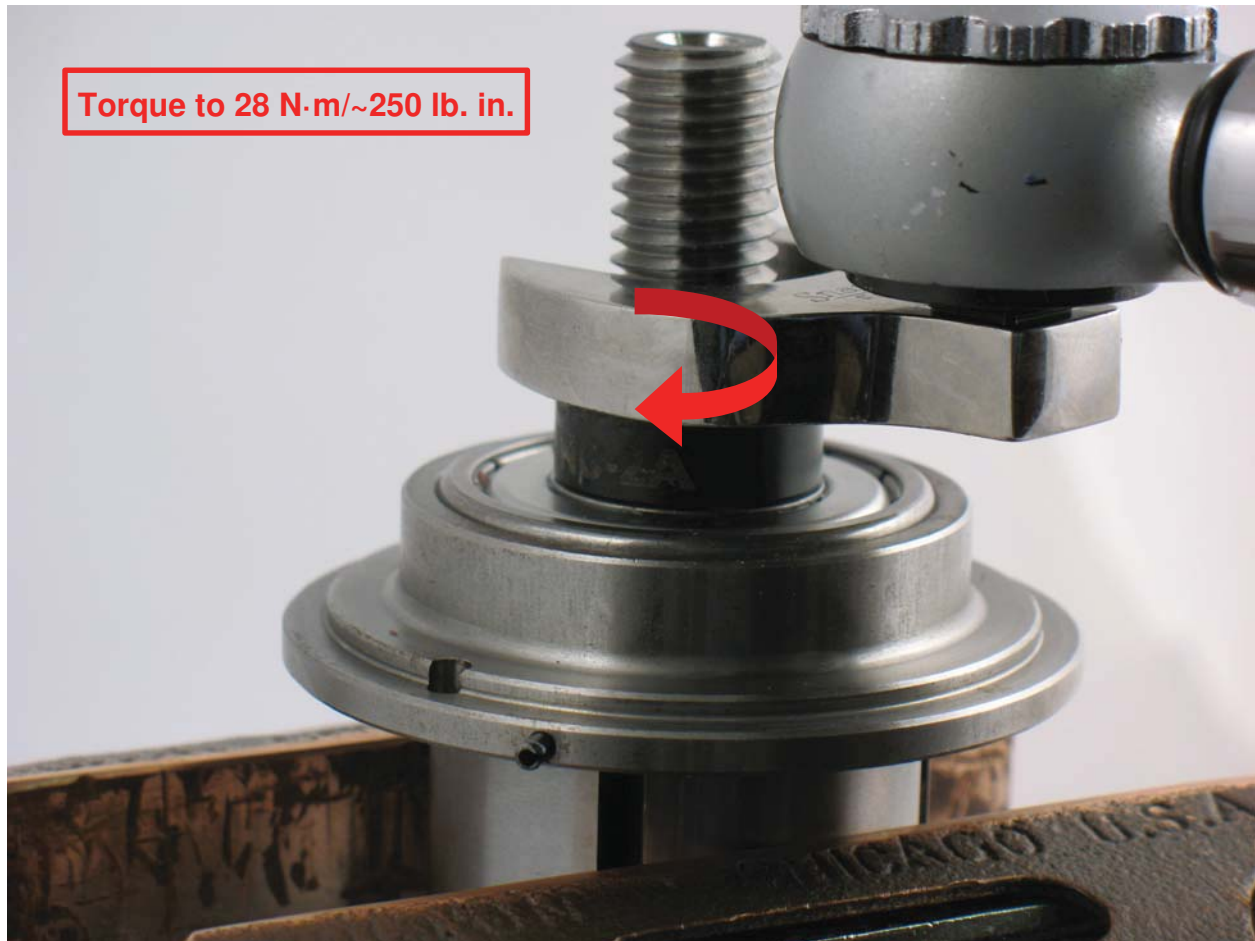
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6. Use a 24 mm crowfoot and torque wrench to fasten **55236** Nut onto rotor.  
**Torque to 28 N·m/~250 lb. in.**

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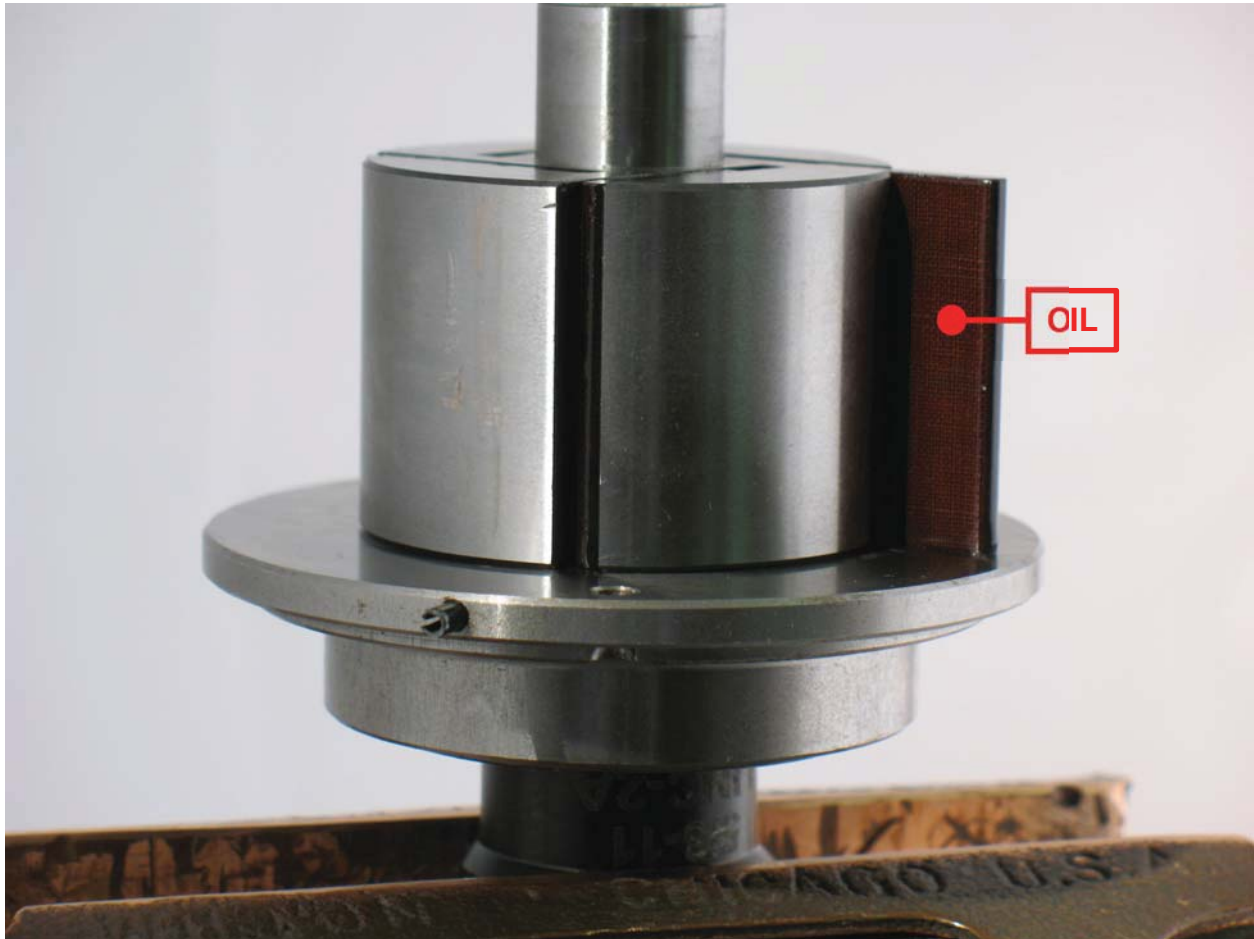
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7. Remove assembly from vise, invert, and fasten flats of **55236** Nut in vise.
  - Oil vanes with **95842** Dynabrade Air Lube, or equivalent.
  - Install vanes in rotor.

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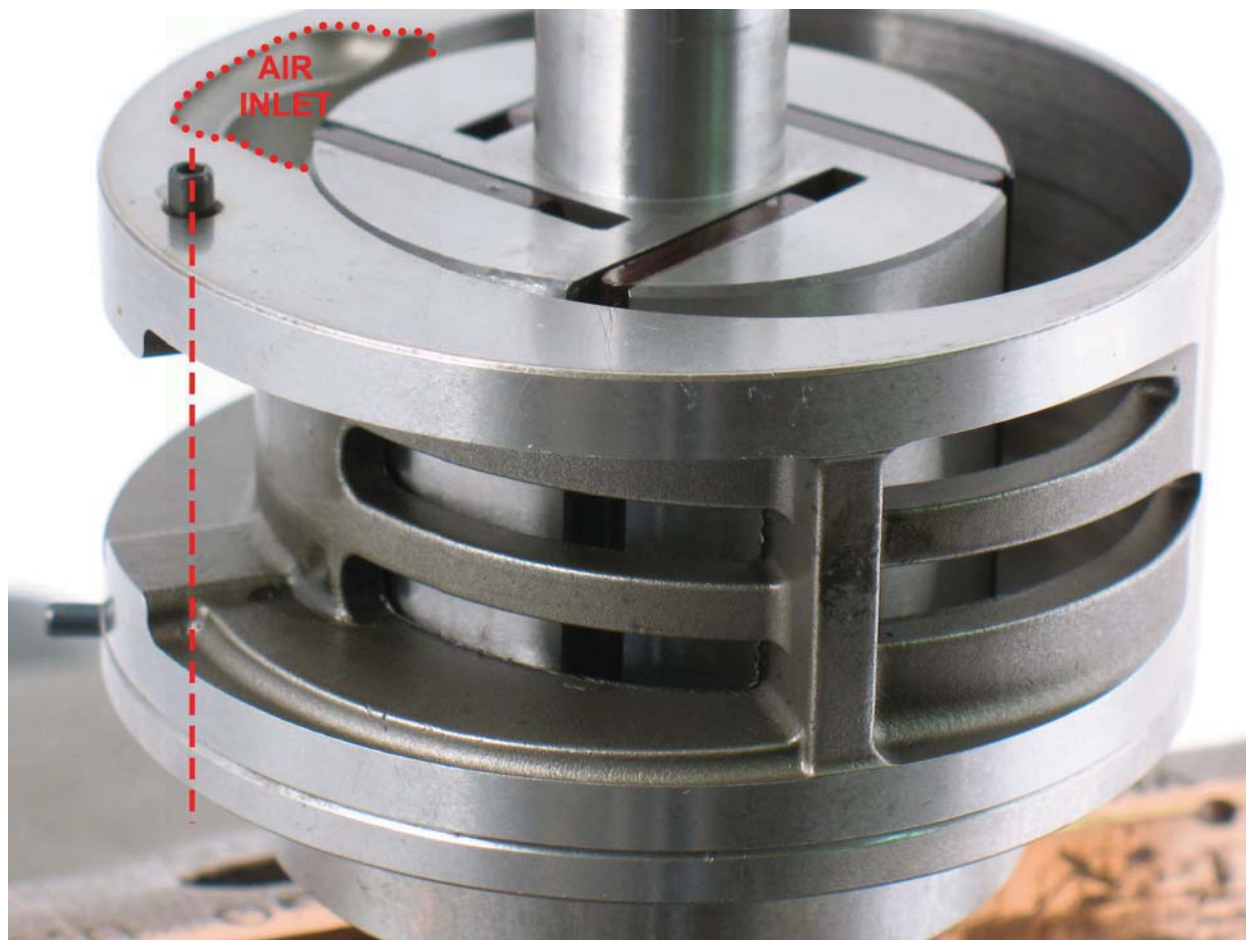
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8. Install cylinder over rotor so that air inlet of cylinder lines-up with air inlet opening in **55202** Rear Bearing Plate.

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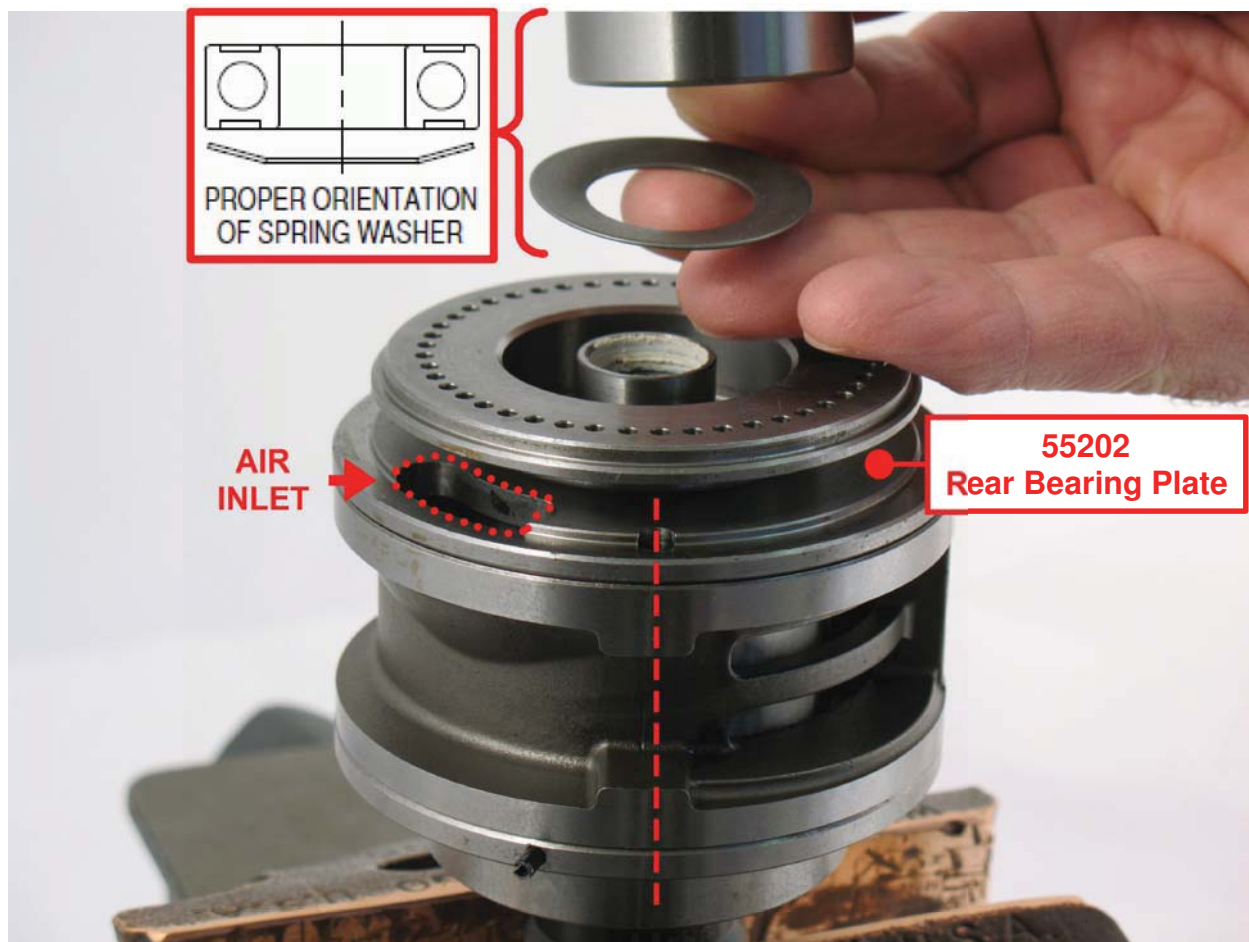
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9. Install **55202** Rear Bearing Plate.
  - Install **55216** Washer with cupped-side facing up.
  - Install **02552** Bearing.



10. Apply a small amount of Loctite #567, or equivalent to threads of governor.

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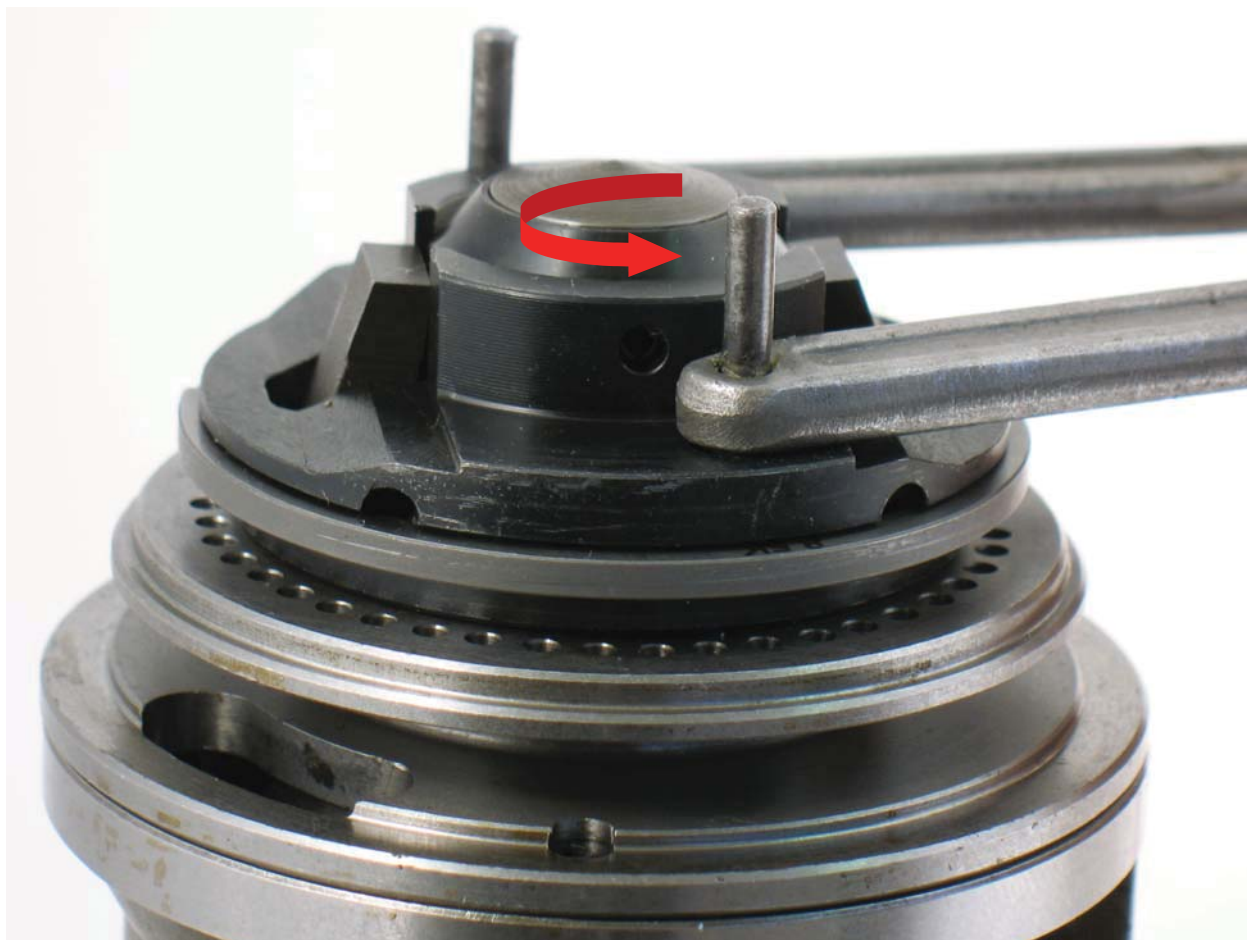
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- 11. Install governor. Turn counterclockwise. Left Hand Thread.**
- Use 5 mm pin spanner wrench to fasten governor. **Torque to 25 N·m/~220 lb. in.**

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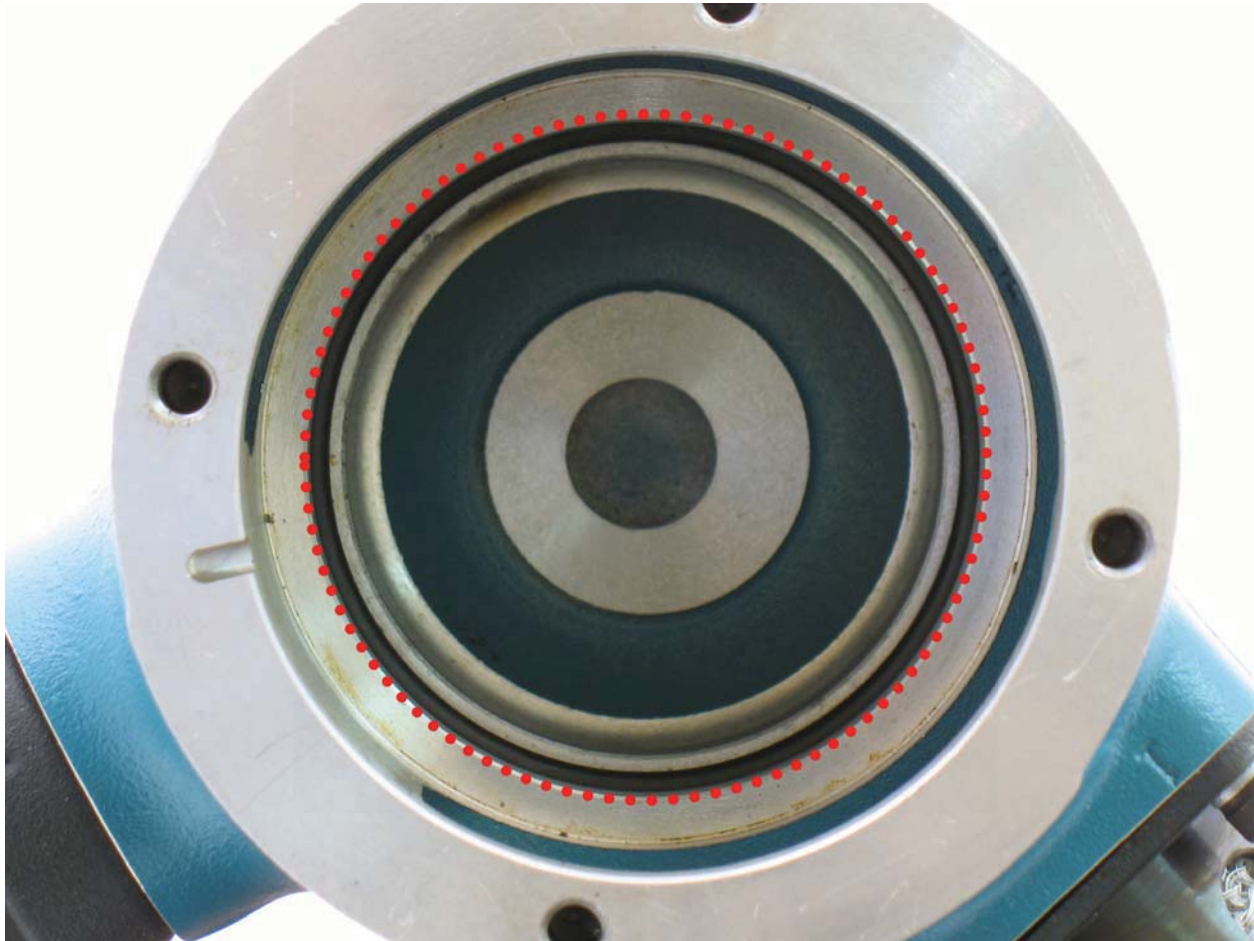
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**12.** Install **95880** O-Ring in housing.

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**13.** Carefully install motor in housing.

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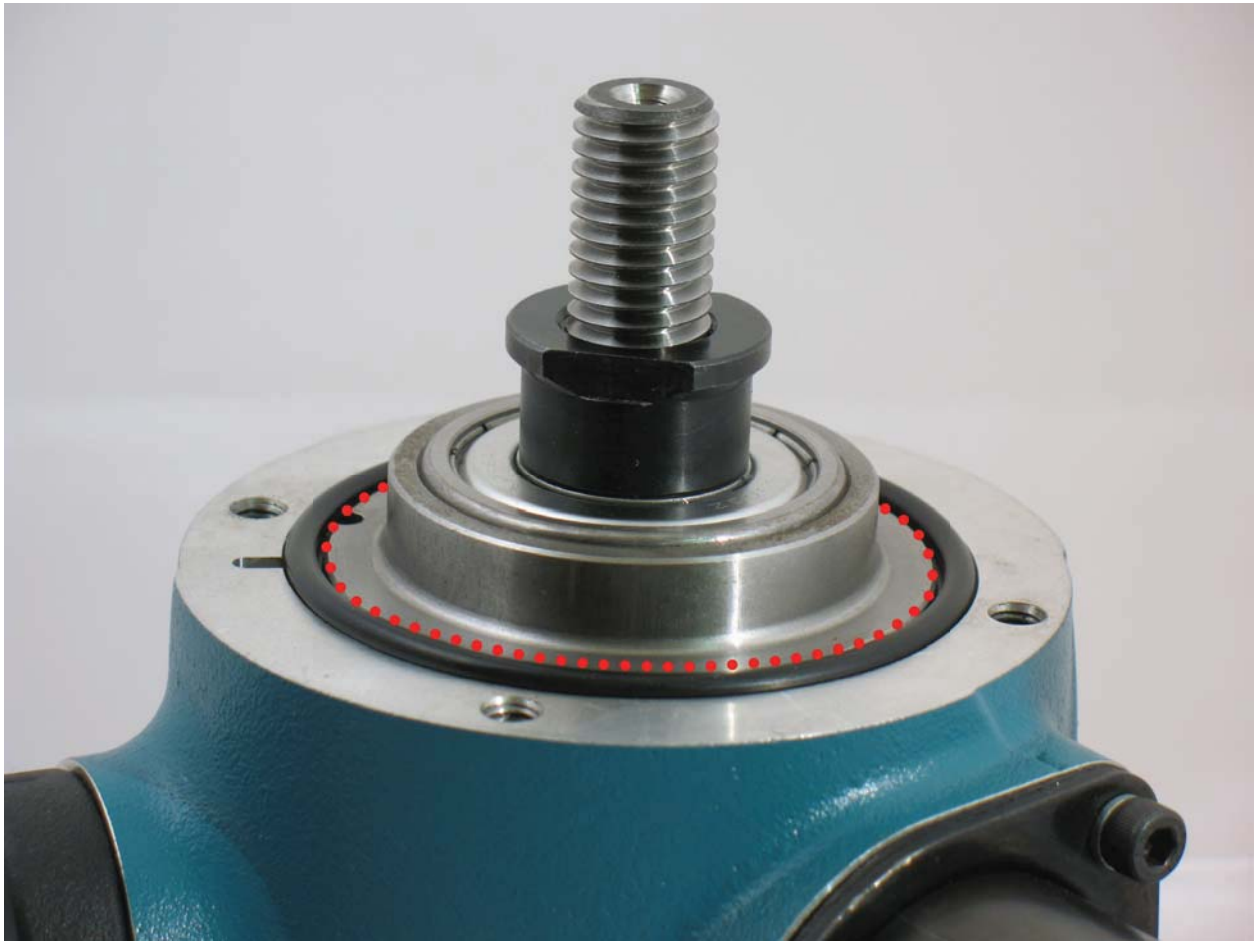
*Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)*

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- 14.** Install **95881** O-Ring against front bearing plate.

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15. Install housing cover or guard. Fasten with **50508** Screws and **95757** Washers.  
**Torque to 17 N·m/~150 lb. in.**

**Important:**

- ***Without an accessory installed***, check spindle speed of tool with **max. 90 PSIG or 6.2 Bar** operating air pressure at the air inlet of the tool.
- Use a tachometer to check RPM. **Notice:** Unless otherwise stated, the no-load speed may not exceed the maximum rated speed.

**Motor assembly completed.**

**Install proper backup disc, and/or flanges.**

**Valve/Throttle Handle and Muffler Assembly:**

Refer to tool parts page or manual. Follow exploded view instructions to assemble valve and muffler components.

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