

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 aside¹. Turn clockwise. **Left Hand Thread.**

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

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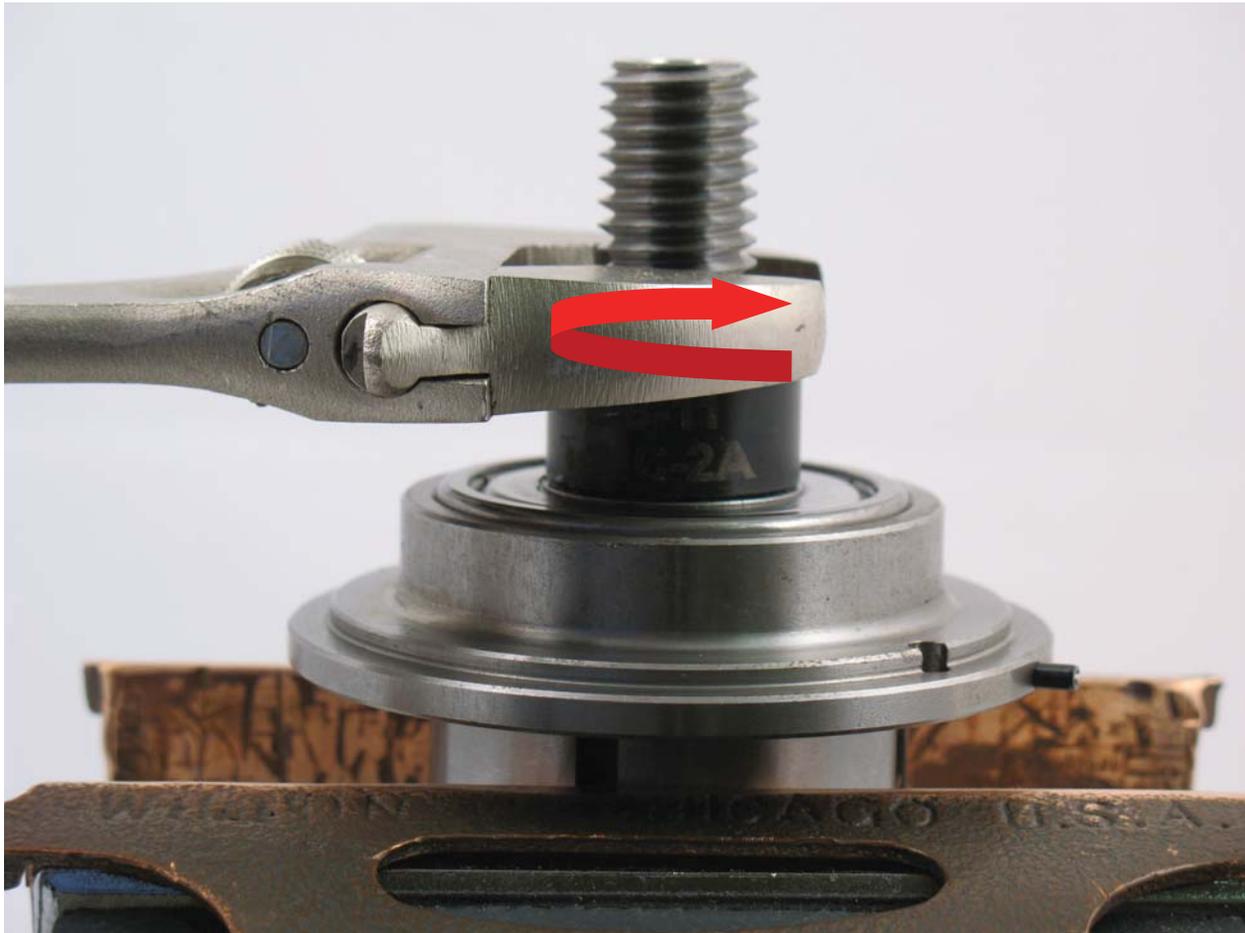
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5. Loosen vise, invert assembly and fasten rotor in vise with spindle pointing up.
 - Use an adjustable wrench to remove **55236** Nut. Turn counterclockwise.

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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.

- 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.

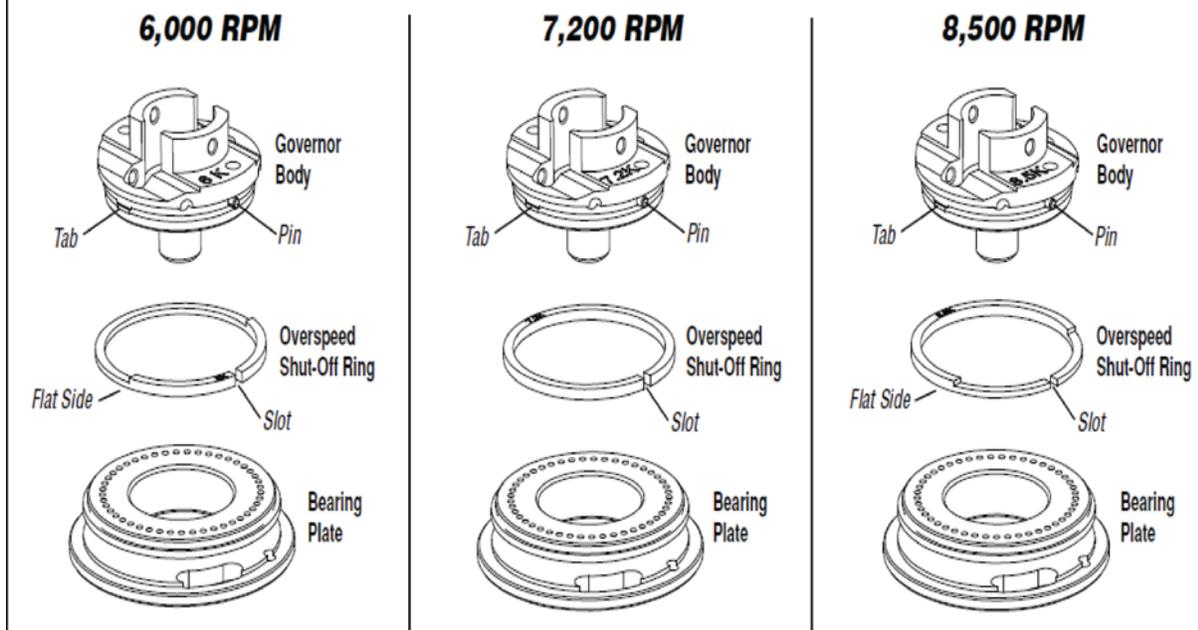
OVERSPEED SHUT-OFF RING

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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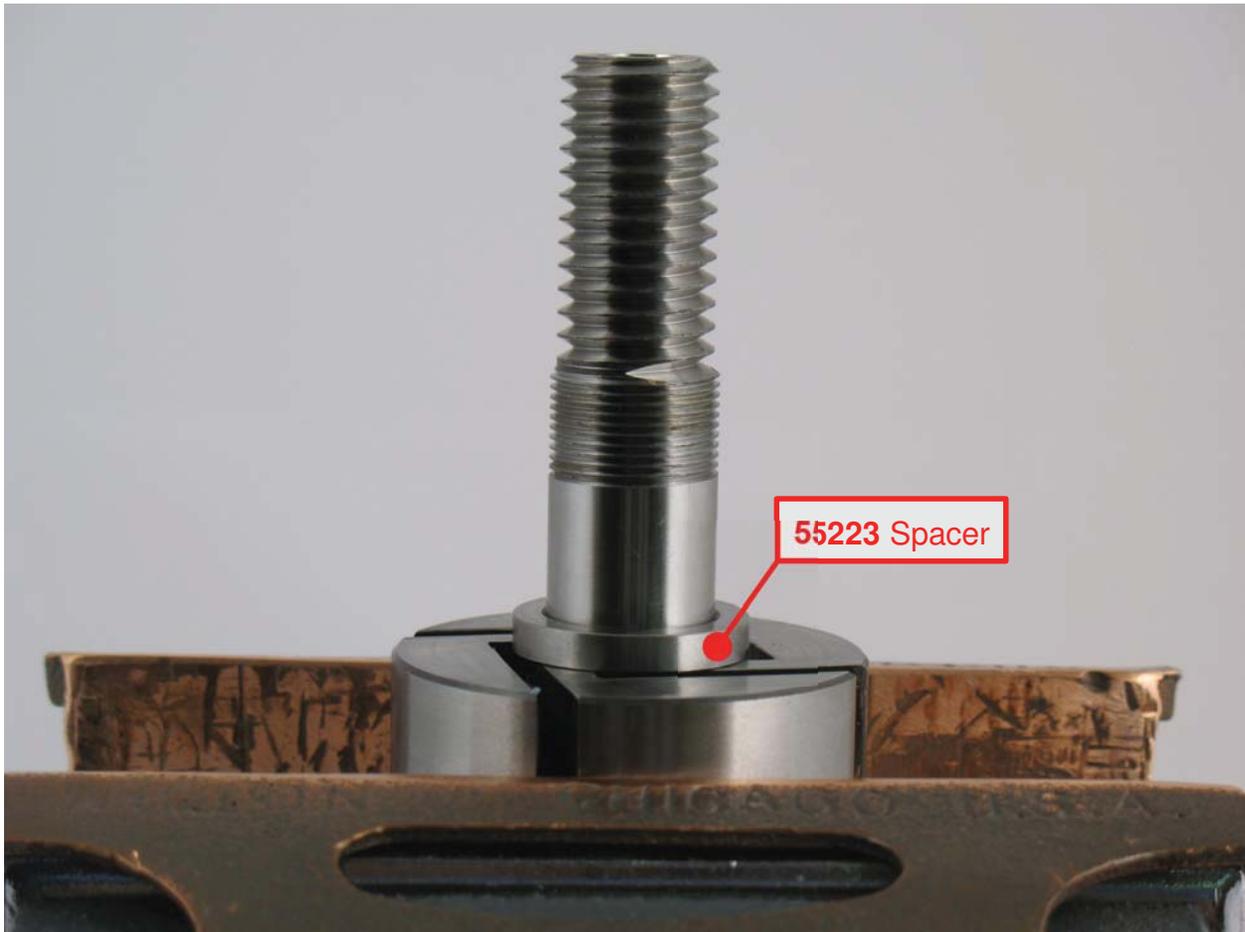
Disassembly/Assembly Instructions

Clean and inspect parts for wear or damage before assembling.

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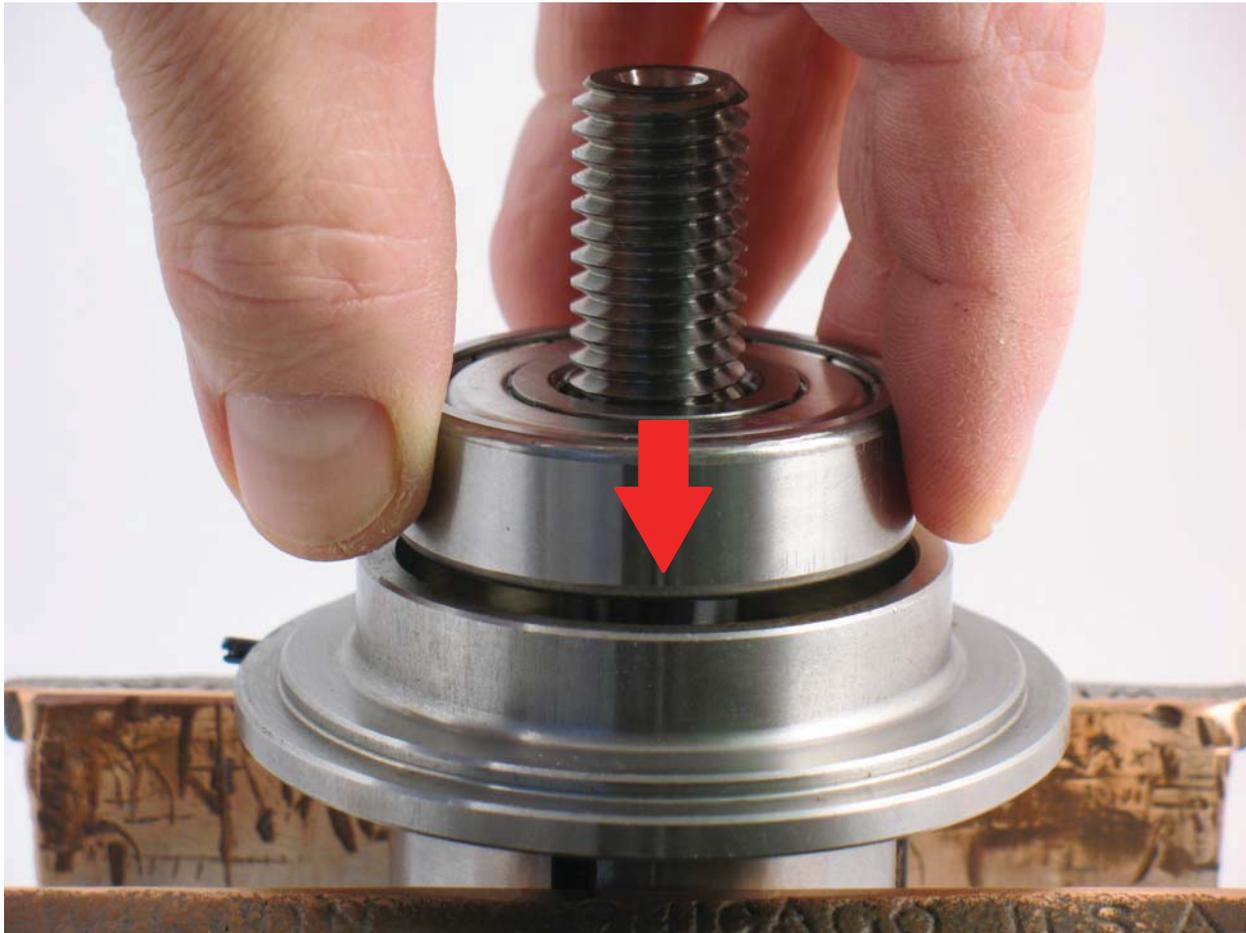
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3. Install front bearing and plate onto rotor.
 - Install **55236** Nut.
 - Remove assembly from vise.

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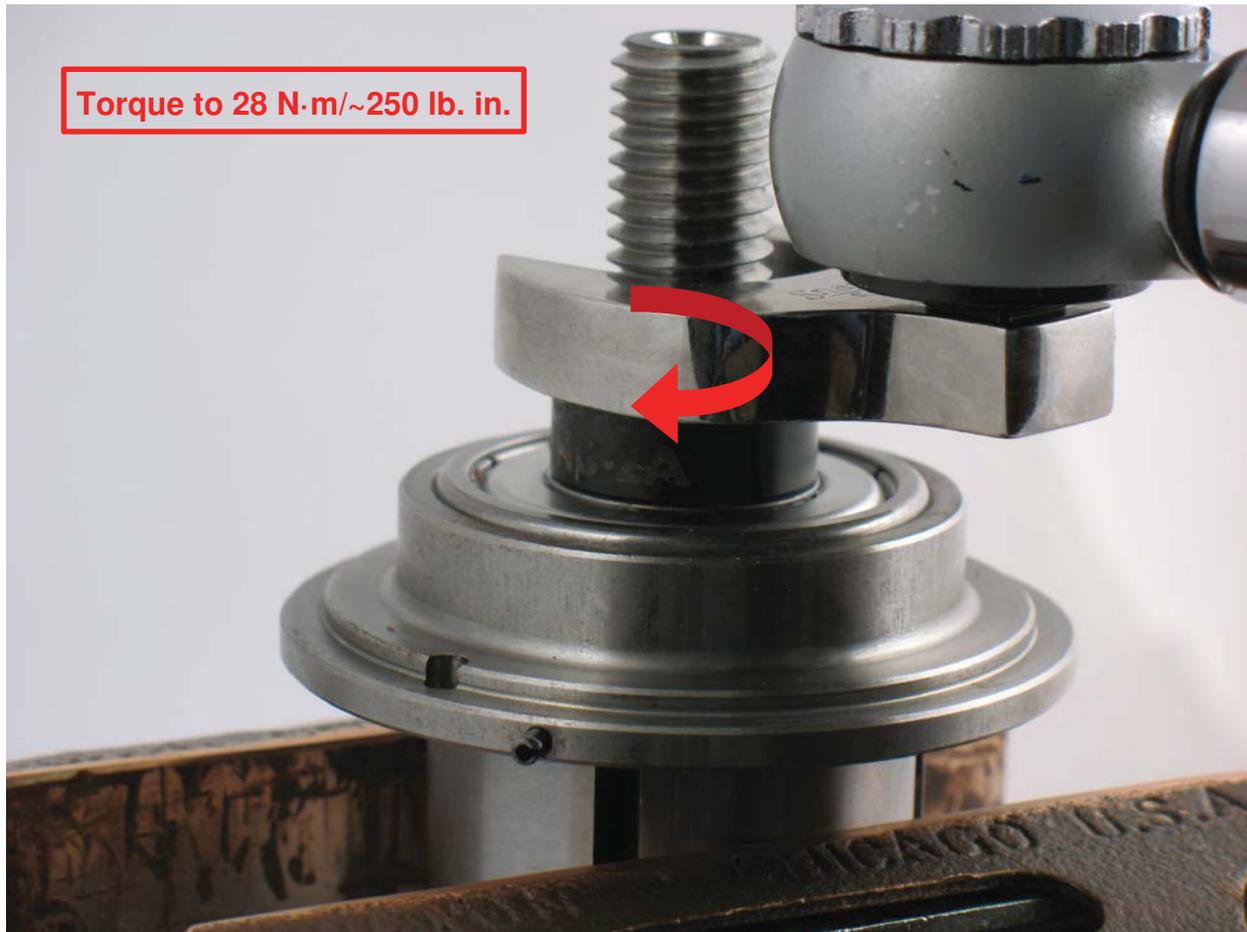


4. Place end rotor spindle on a flat surface. Push down on bearing plate, and use a .001" (~0.03 mm) thick feeler gauge to check clearance between front bearing plate and rotor.

 - **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.



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.



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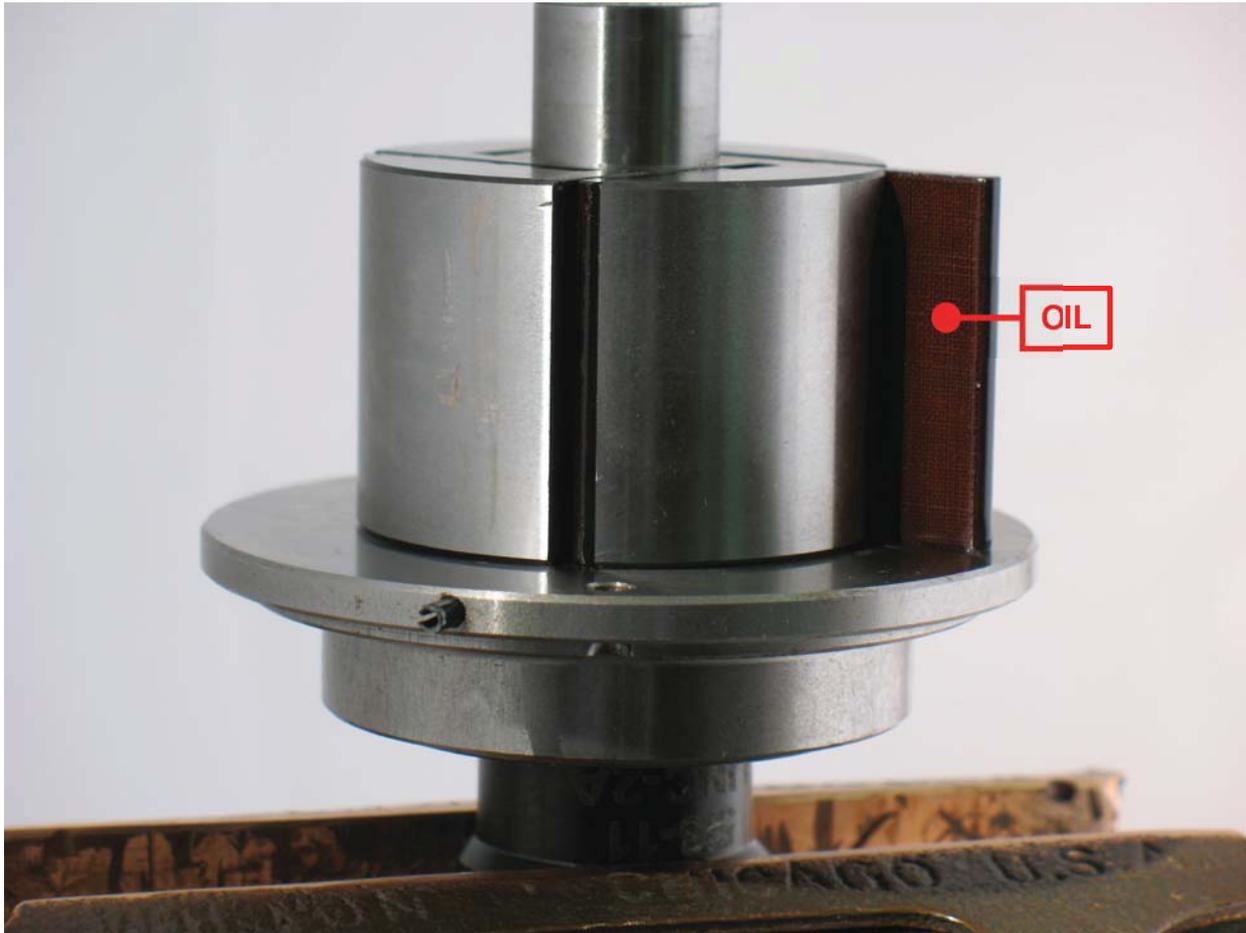
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7. Remove assembly from vise, invert, and fasten flats of **55236** Nut in vise.
 - Oil vanes with **95842** Dynabrade Air Lube, or equivalent.
 - Install vanes in rotor.

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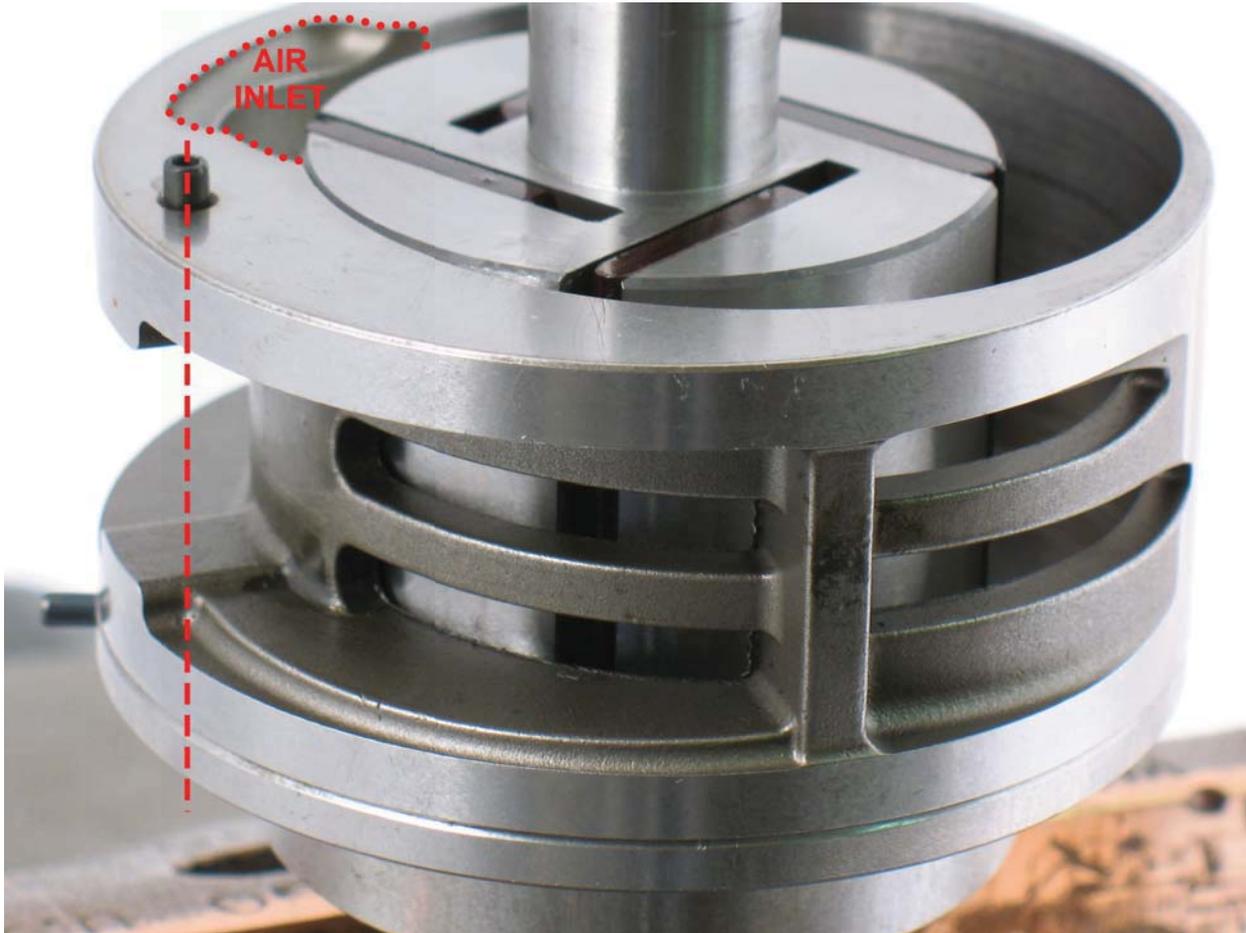
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8. Install cylinder over rotor so that air inlet of cylinder lines-up with air inlet opening in **55202** Rear Bearing Plate.

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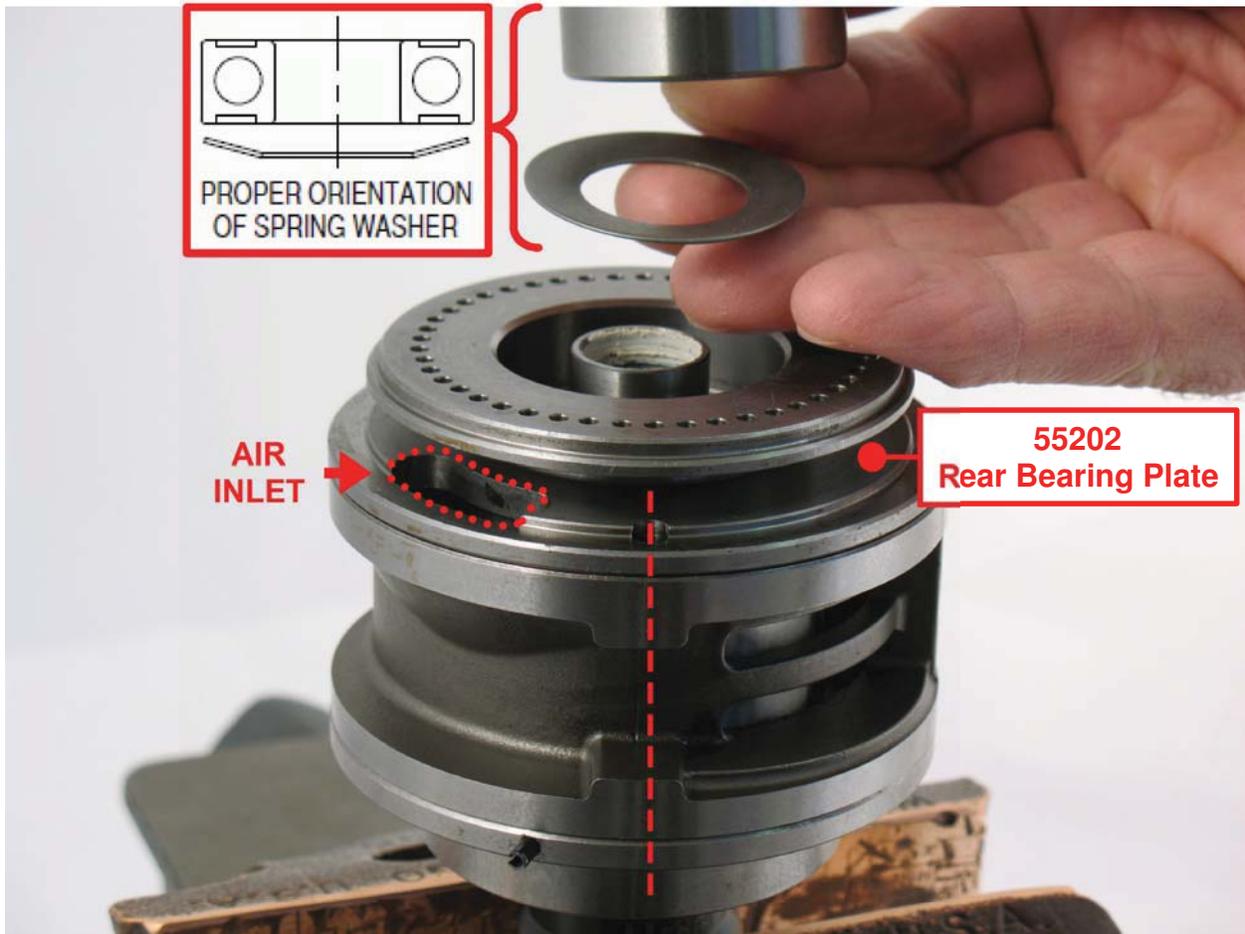
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9. Install **55202** Rear Bearing Plate.
 - Install **55216** Washer with cupped-side facing up.
 - Install **02552** Bearing.



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

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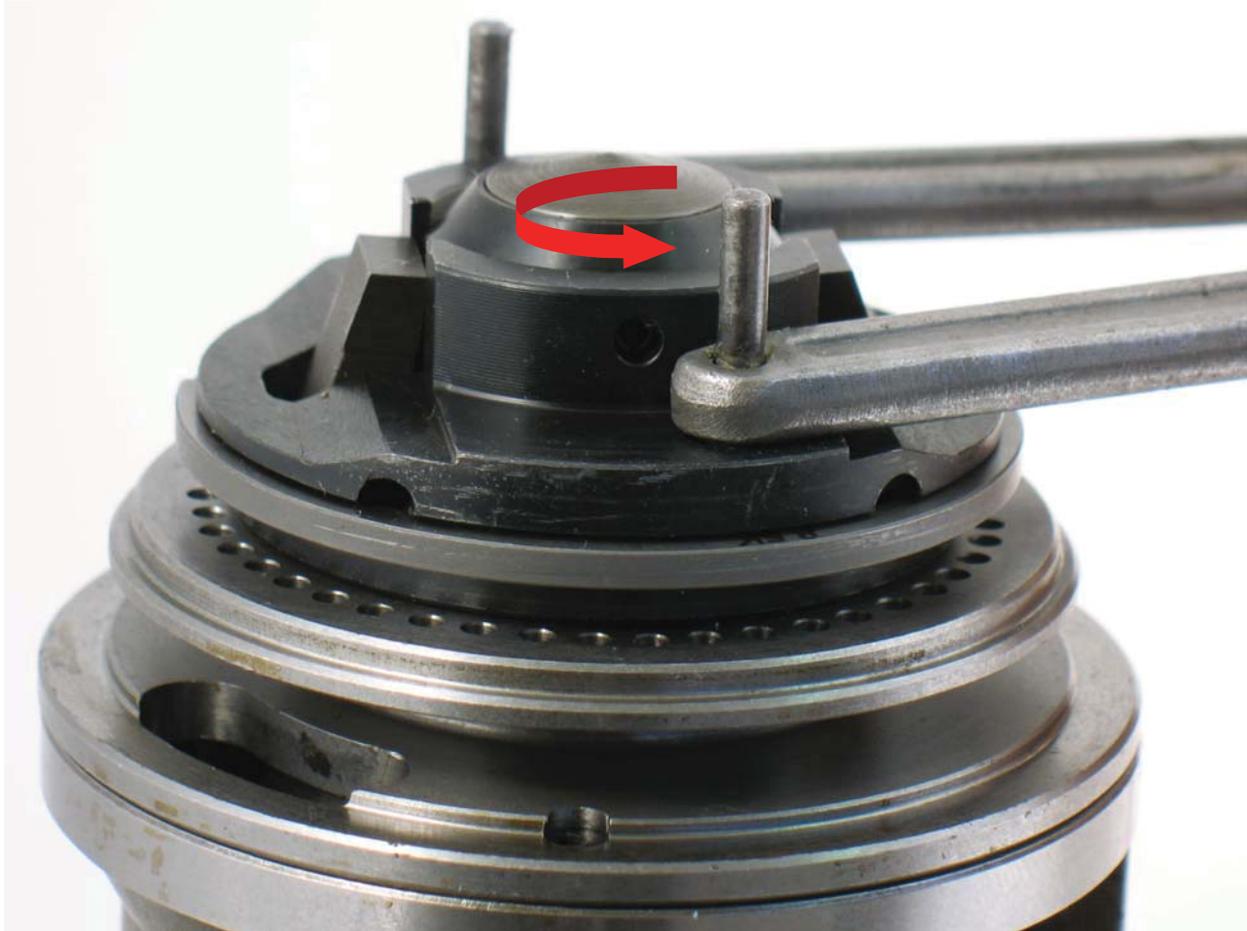
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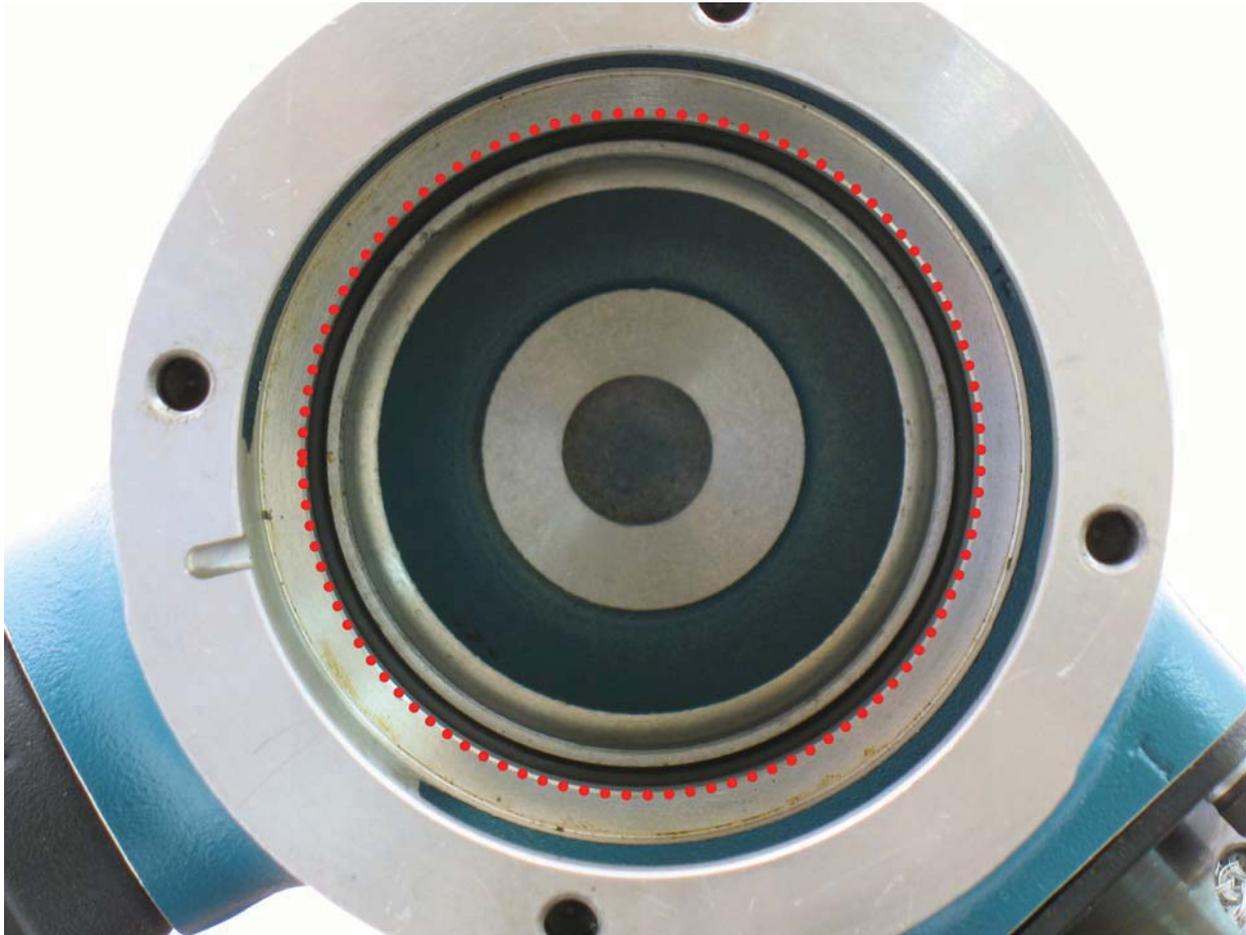
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11. Install governor. Turn counterclockwise. **Left Hand Thread.**
 - Use 5 mm pin spanner wrench to fasten governor. **Torque to 25 N·m/~220 lb. in.**



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

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13. Carefully install motor in housing.

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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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