

Dynafire® II

MODEL 40320 — STANDARD MACHINE

MODEL 40330 — VACUUM MACHINE

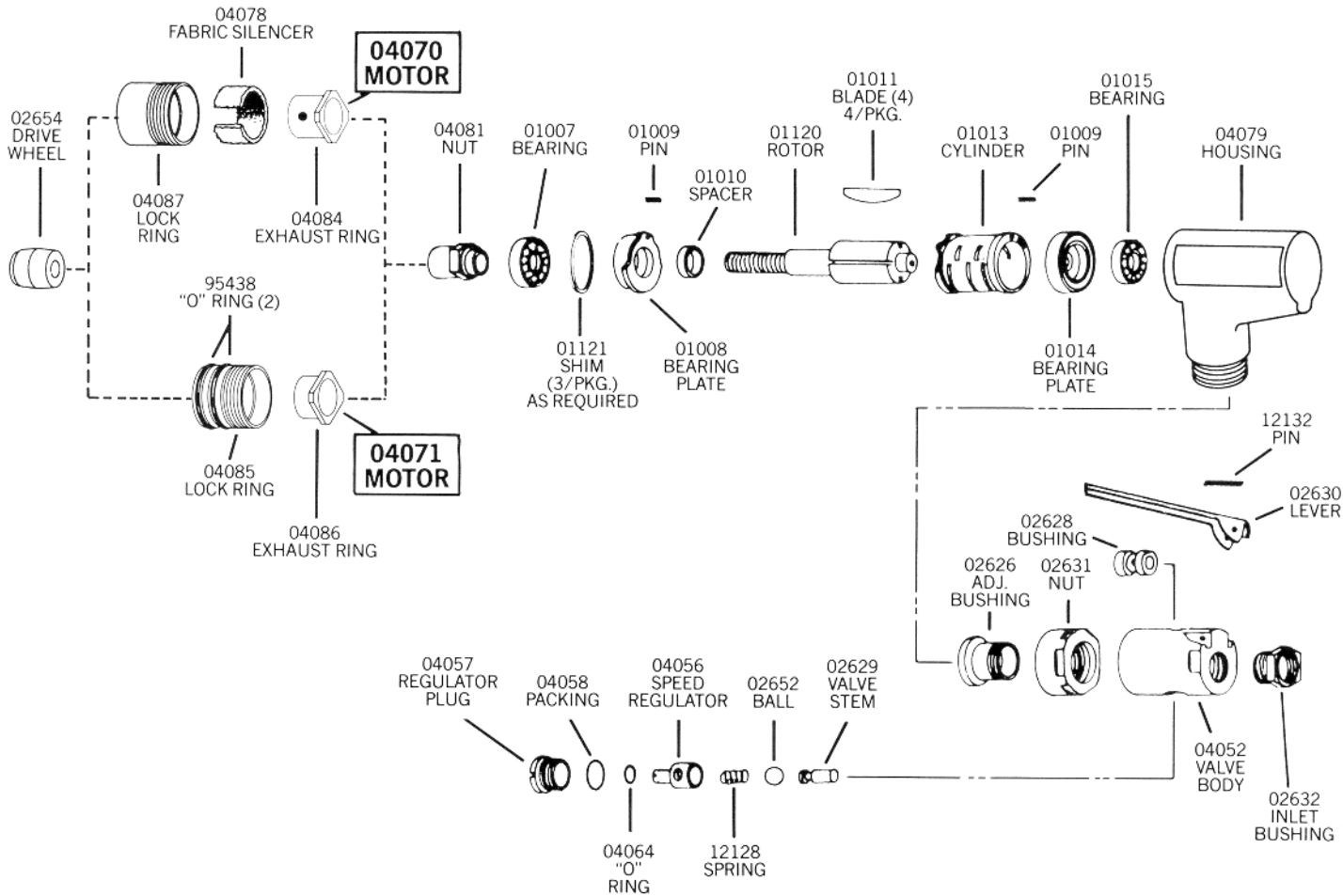
PARTS

EFFECTIVE AUGUST, 1985

04070 AIR MOTOR FOR STANDARD MACHINE

04071 AIR MOTOR FOR VACUUM MACHINE

U.S. PAT. D-265,172; 4,368,597; 4,411,106



Versatile 04070 air motor detaches from tool in seconds. Convert to Die Grinder by adding optional 1/4" collet (50056). A 1/8" collet bushing (50034) also available. Convert to Drill by adding a 1/4" chuck (53032). Chuck and collet mount with spacer (95435). (See basic operating instructions, page 4.)

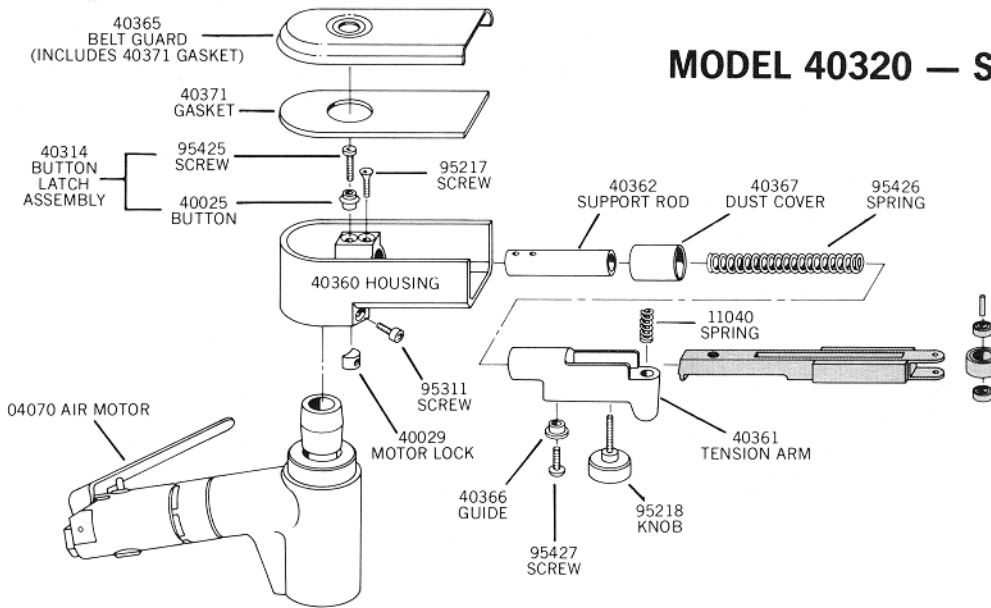
NOTE: 40321 Dynafire® II versatility kit includes model 40320 Dynafire® II, 3 contact arms (11203, 11204, 11206), and 50056 1/4" collet.

IMPORTANT: ALL DYNABRADE AIR TOOLS MUST BE USED WITH A FILTER-REGULATOR-LUBRICATOR TO MAINTAIN ALL WARRANTIES.

▶ TO ORDER REPLACEMENT PARTS SPECIFY THE MODEL AND SERIAL NUMBER OF YOUR MACHINE.

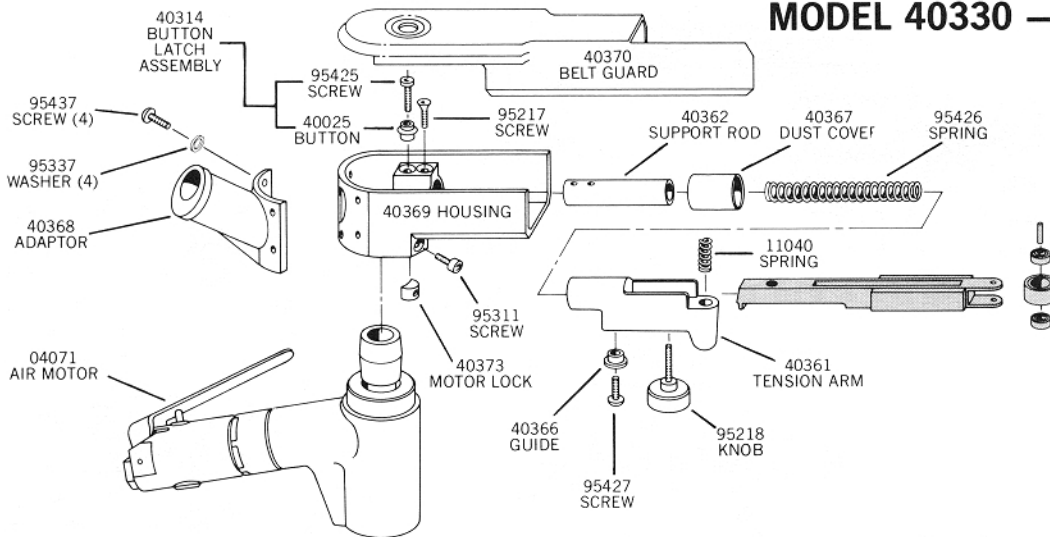
Dynafile® II BASIC ASSEMBLY

MODEL 40320 — STANDARD MACHINE

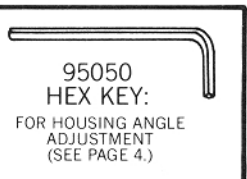


SHADED PARTS INDICATE CONTACT ARM ASSEMBLY

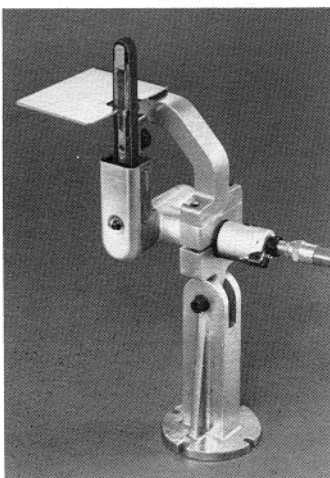
MODEL 40330 — VACUUM MACHINE



SHADED PARTS INDICATE CONTACT ARM ASSEMBLY



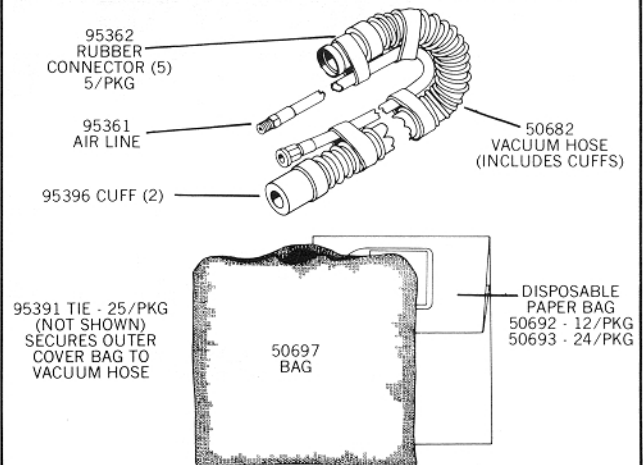
DYNAMOUNT™ BENCH MOUNT MODEL 80017



Optional 80015 foot switch and hose assembly which provides on-off foot control of air-tool operation is also available.

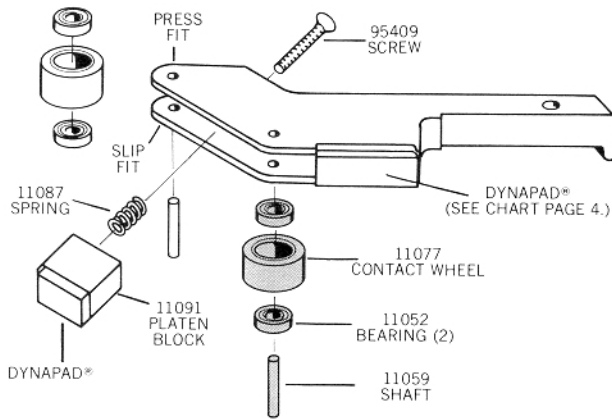
Frees an operator's hands for complete control of a workpiece.

VACUUM ATTACHMENT FOR 40330 VACUUM MODEL DYNAFILE® II



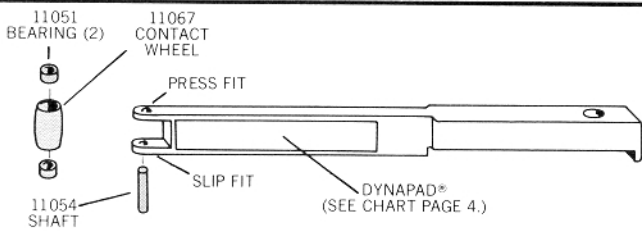
Dynaflex® II CONTACT ARM ASSEMBLIES

(ALL DYNAPLEX® II CONTACT ARMS UTILIZE 18" LONG ABRASIVE BELTS UNLESS OTHERWISE NOTED)



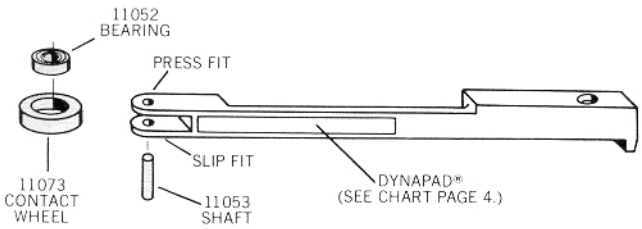
11200 STROKE SANDER

SHADED PARTS INDICATE 11088 CONTACT WHEEL ASSEMBLY (2).



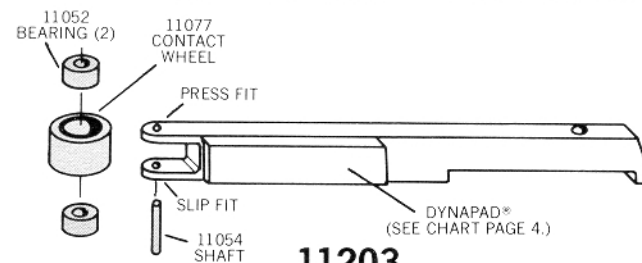
11201

SHADED PARTS INDICATE 11068 CONTACT WHEEL ASSEMBLY.



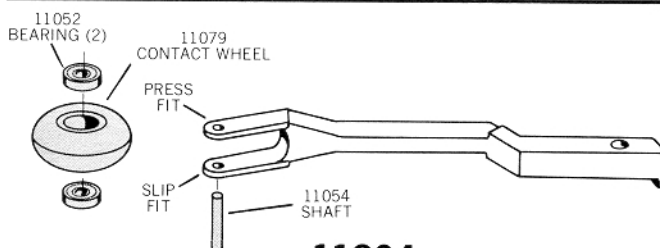
11202

SHADED PARTS INDICATE 11074 CONTACT WHEEL ASSEMBLY.



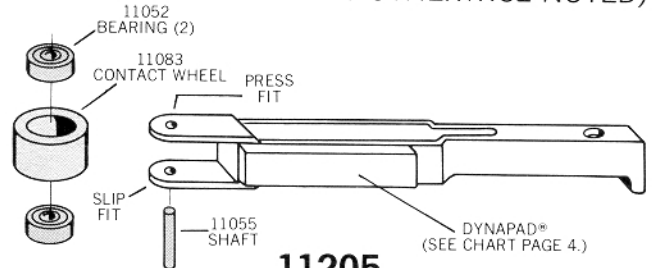
11203

SHADED PARTS INDICATE 11078 CONTACT WHEEL ASSEMBLY.



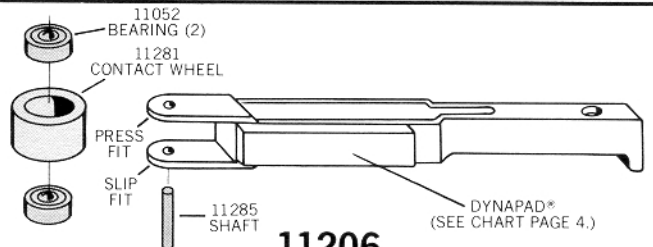
11204

SHADED PARTS INDICATE 11080 CONTACT WHEEL ASSEMBLY.



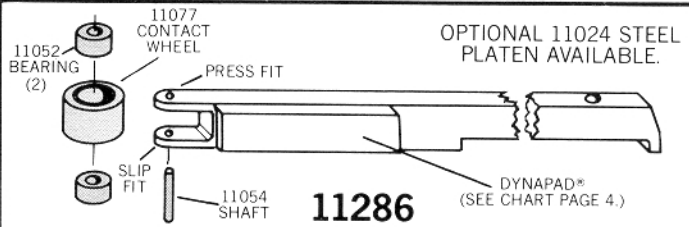
11205

SHADED PARTS INDICATE 11084 CONTACT WHEEL ASSEMBLY.



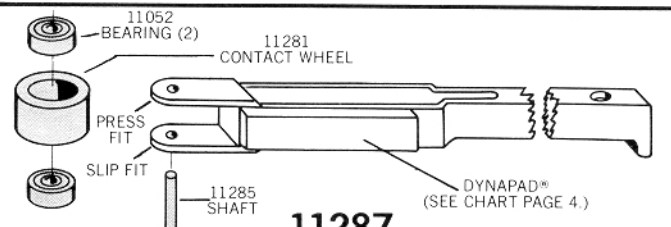
11206

SHADED PARTS INDICATE 11282 CONTACT WHEEL ASSEMBLY.



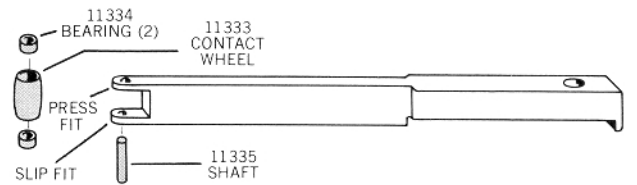
11286

(FOR USE WITH 24" LONG ABRASIVE BELTS)
SHADED PARTS INDICATE 11078 CONTACT WHEEL ASSEMBLY.



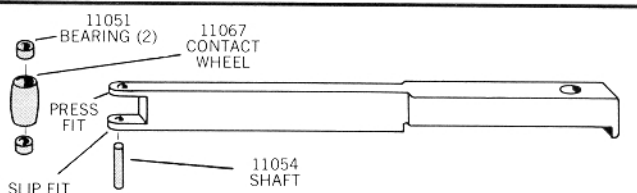
11287

(FOR USE WITH 20½" LONG ABRASIVE BELTS)
SHADED PARTS INDICATE 11282 CONTACT WHEEL ASSEMBLY.



11300

SHADED PARTS INDICATE 11332 CONTACT WHEEL ASSEMBLY.



11301

SHADED PARTS INDICATE 11068 CONTACT WHEEL ASSEMBLY.

Dynaflex® II BASIC OPERATING INSTRUCTIONS

ABRASIVE BELT CHANGE

TO REMOVE BELT

1. Remove "pop-off" cover.
2. Pull back on belt tension bar and hold.
3. Lift belt off contact wheel and release tension bar.

TO REPLACE BELT

1. Slide back of belt over the drive wheel.
2. Pull back on belt tension bar and hold.
3. Position belt over contact wheel.
4. Release belt tension bar. Replace cover.
5. Adjust belt tracking using rough adjustment knob.

BELT TRACKING ADJUSTMENT

Adjust belt tracking by turning 95218 rough adjustment knob while unit is running. Tightening the knob makes the belt track closer to the knob, loosening the knob makes the belt move away. Adjust until the belt tracks on the center of the contact wheel.

HOUSING ANGLE ADJUSTMENT

To pivot housing, loosen the 95311 head clamping screw on housing with the supplied 95050 5/64" hex wrench. Pivot housing to desired working angle and tighten hex screw.

CHANGING CONTACT ARM

1. Disconnect air supply from unit, pull back on belt tension bar and remove abrasive belt.
2. Remove rough adjustment knob.
3. Remove arm and install desired arm in its place, making sure tab on end of arm is in "down" position on tension arm.
4. Assemble rough adjustment knob into contact arm. Install appropriate abrasive belt.
5. Follow instructions for belt tracking adjustment before using.

CONVERSION OF 04070 AIR MOTOR TO DIE GRINDER OR DRILL

1. Remove abrasive belt.
2. Loosen 95311 motor lock screw.
3. Twist and pull housing and motor apart. Amount of force needed may vary.
4. Slip 95049 3/16" hex key wrench (supplied with Dynaflex® II kits only) through the drive wheel into the end of the drive shaft to prevent drive shaft from revolving.
5. Using a wrench or pliers, twist the drive wheel counterclockwise and remove.
6. Mount 95435 threaded spacer using hex key to hold drive shaft and 95262 14mm wrench (supplied with Dynaflex® II kits only) to tighten spacer. Be sure spacer is tight against motor shoulder.
7. Mount collet or drill chuck using 14mm wrench or chuck key, respectively.

Dynaflex® II ABRASIVE BELTS AND ACCESSORIES

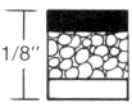


ALUMINUM OXIDE				
18" LONG/UNIT = 200 BELTS				
Grit	Part Numbers			
	¼"W	½"W	¾"W	1"W
40	90220	90240	90260	90250
60	90221	90241	90261	90251
80	90222	90242	90262	90252
120	90223	90243	90263	90253
180	90224	90244	90264	90254
220	90225	90245	90265	90255
320	90226	90246	90266	90256
500	90227	90247	90267	90257
NON-WOVEN NYLON				
18" LONG/UNIT = 12 BELTS				
very fine	90228	90248	90249	90258
med.	90229	90292	90293	90294
coarse	90296	90297	90298	90299

ALUMINUM OXIDE	
24" LONG UNIT = 200 BELTS	
Grit	Part No.
	½"W
40	90441
60	90443
80	90445
100	90446
120	90447
180	90449
220	90451
320	90453
500	90455

SILICON CARBIDE	
24" LONG UNIT = 200 BELTS	
Grit	Part No.
	½"W
60	90567
80	90568
ALUMINA ZIRCONIA	
24" LONG UNIT = 200 BELTS	
60	90579
80	90583
NON-WOVEN NYLON	
24" LONG UNIT = 12 BELTS	
very fine	90400
med.	90434
coarse	90461

NOTE: 24" long abrasive belts are to be used on contact arm 11286.

Coated abrasive belts 20½" long are available in selected grits to be used on contact arm 11287.

PSA DYNAPAD® PLATEN PADS	
<p>Mount on contact arm to provide a flat support for the abrasive belt. Easily trimmed to size.</p> <p>SOFT — (Sponge) For deburring and polishing contoured pieces.</p>  <p>1/8"</p> <p>11025 — 1/2"W x 5½"L — 6/pkg. 11119 — 3/4"W x 7"L — 6/pkg. 40060 — 11/16"W x 3½"L — 6/pkg.</p>	
<p>HARD — (Cork) For heavy deburring and polishing.</p>  <p>1/8"</p> <p>11026 — 1/2"W x 5½"L — 6/pkg. 11109 — 3/4"W x 7"L — 6/pkg. 40061 — 11/16"W x 3½"L — 6/pkg.</p>	
<p>THIN For aggressive grinding</p>  <p>1/32"</p> <p>11027 — 1/2"W x 5½"L — 6/pkg. 11129 — 3/4"W x 7"L — 6/pkg.</p>	

ALL ABRASIVE PRODUCTS AND FILES ARE ASSORTABLE IN COMPLETE UNIT QUANTITIES FOR BEST PRICE.



DYNABRADE, INC.

72 EAST NIAGARA STREET, TONAWANDA, NEW YORK 14150, 716-694-4600/TELEX 646540 "DYNABRADE, TWDA"

ABRASIVE POWER TOOLS