

3" Extension Flapper

Models:
53514 — 18,000 RPM

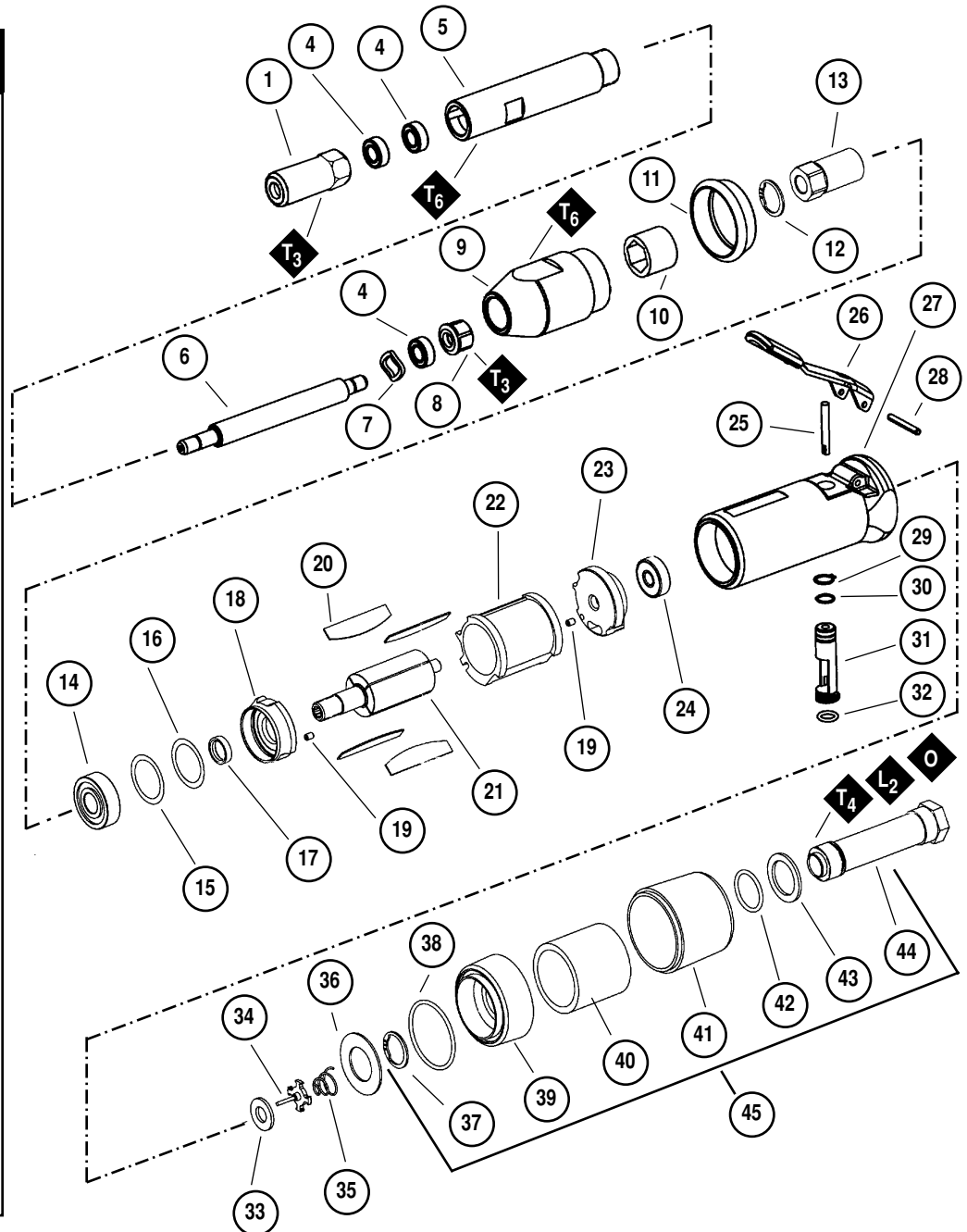
Air Motor and Machine Parts



Always operate, inspect and maintain this tool in accordance with the Safety Code for portable air tools (ANSI B186.1) and any other applicable safety codes and regulations. Please refer to Dynabrade's Warning/Safety Operating Instructions for more complete safety information.

Index Key

No.	Part	Description
1	01484	Collet Cap
4	51078	Bearing (3)
5	53558	Housing Spindle
6	53556	Spindle
7	51075	Wavy Washer
8	53551	Coupling Nut
9	53550	Adapter
10	51072	Coupler
11	53175	Collar
12	95711	Snap Ring
13	51066	Rotor Nut
14	01007	Bearing
15	01121	Shim (as req.)
16	01121	Shim (as req.)
17	01010	Spacer
18	01008	Front Bearing Plate
19	50767	Pin (2)
20	01011	Blades (4/pkg.)
21	01148	Rotor
22	01013	Cylinder
23	01245	Rear Bearing Plate
24	01015	Bearing
25	01477	Valve Stem
26	57344	Throttle Lever Assembly
27	53499	Housing - 53514
28	01017	Spring Pin
29	95558	Retaining Ring
30	95730	O-Ring
31	01247	Speed Regulator
32	01024	O-Ring
33	01464	Seal
34	01472	Tip Valve
35	01468	Spring
36	01642	Air Control Ring
37	95711	Retaining Ring
38	95438	O-Ring
39	94521	Muffler Base
40	94528	Muffler
41	94522	Muffler Cap
42	95375	O-Ring
43	94526	Spacer
44	94523	Inlet Adapter
45	94519	Muffler Assembly



KEY

O	Oil	G	Grease
L	Loctite/Hernon: L ₂ = Loctite #271 L ₃ = Loctite #380, L ₄ = Loctite #567		
T	Torque: N•m x 8.85 = In. - lbs. T ₂ = 8.5 N•m, T ₃ = 17 N•m, T ₄ = 23 N•m, T ₅ = 28 N•m, T ₆ = 34 N•m		

Important Operating, Maintenance and Safety Instructions

Carefully read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool.

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

Important: All Dynabrade air tools must be used with a Filter-Regulator-Lubricator to maintain all warranties.

Operating Instructions:

Warning: Eye, face and body protection must be worn while operating power tools. Failure to do so may result in serious injury or death. Follow safety procedures posted in workplace.

1. With power source disconnected from tool, securely fasten abrasive/accessory on tool.
2. Install air fitting into inlet bushing of tool. **Important:** Secure inlet bushing of tool with a wrench before attempting to install the air fitting to avoid damaging valve body housing.
3. Connect power source to tool. Be careful not to depress throttle lever in the process.
4. Check tool speed with tachometer. If tool is operating at a higher speed than the RPM marked on the tool or operating improperly, the tool should be serviced to correct the cause before use.

Maintenance Instructions:

1. Check tool speed regularly with a tachometer. If tool is operating at a higher speed than the RPM marked on the tool, the tool should be serviced to correct the cause before use.
2. Some silencers on air tools may clog with use. Clean and replace as required.
3. All Dynabrade air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example : if the tool specification state 40 SCFM, set the drip rate of your filter-lubricator at 4 drops per minute). Dynabrade Air Lube (P/N 95842: 1pt. 473ml.) is recommended.
4. An air line filter-regulator-lubricator must be used with this air tool to maintain all warranties. Dynabrade recommends the following: **11299** 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 100 CFM @ 100 PSI has 1/2" NPT female ports.
5. Use only genuine Dynabrade replacement parts. To reorder replacement parts, specify the **Model #**, **Serial #** and **RPM** of your machine.
6. A motor tune-up kit (P/N 96007) is available which includes assorted parts to help maintain motor in peak operating condition. Please refer to Dynabrade's Preventative Maintenance Schedule for a guide to expectant life of component parts.
7. Mineral spirits are recommended when cleaning the tool and parts. Do not clean tool or parts with any solvents or oils containing acids, esters, keytones, chlorinated hydrocarbons or nitro carbons.

Safety Instructions:

Products offered by Dynabrade should not be converted or otherwise altered from original design without expressed written consent from Dynabrade, Inc.

- **Important:** User of tool is responsible for following accepted safety codes such as those published by the American National Standards Institute (ANSI).
- Operate machine for one minute before application to workpiece to determine if machine is working properly and safely before work begins.
- Always disconnect power supply before changing abrasive/accessory or making machine adjustments.
- Inspect abrasives/accessories for damage or defects prior to installation on tools.
- Please refer to Dynabrade's Warning/Safety Operating Instructions Tag (Reorder No. 95903) for more complete safety information.
- **Warning:** Hand, wrist and arm injury may result from repetitive work, motion and overexposure to vibration.

Notice

All Dynabrade motors use the highest quality parts and metals available and are machined to exacting tolerances. The failure of quality pneumatic motors can most often be traced to an unclean air supply or the lack of lubrication. Air pressure easily forces dirt or water contained in the air supply into motor bearings causing early failure. It often scores the cylinder walls and the rotor blades resulting in limited efficiency and power. Our warranty obligation is contingent upon proper use of our tools and cannot apply to equipment which has been subjected to misuse such as unclean air, wet air or a lack of lubrication during the use of this tool.

One Year Warranty

Following the reasonable assumption that any inherent defect which might prevail in a product will become apparent to the user within one year from the date of purchase, all equipment of our manufacture is warranted against defects in workmanship and materials under normal use and service. We shall repair or replace at our factory, any equipment or part thereof which shall, within one year after delivery to the original purchaser, indicate upon our examination to have been defective. Our obligation is contingent upon proper use of Dynabrade tools in accordance with factory recommendations, instructions and safety practices. It shall not apply to equipment which has been subject to misuse, negligence, accident or tampering in any way so as to affect its normal performance. Normally wearable parts such as bearings, contact wheels, rotor blades, etc., are not covered under this warranty.

Machine Number	Length Inch (mm)	Tool Diameter Inch (mm)	Weight Pound (kg)	Spindle Thread	Air Flow Rate SCFM (LPM)	Sound Level	Motor HP (W)
53514	15" (381)	1-3/4" (44)	3.44 (1.53)	5/16"-24 male	28 (793)	75 dBA	.43 (321)

Additional specifications: Air Inlet Thread 1/4" (6 mm) NPT • Hose Size 3/8" (9 mm) • 90 PSI (6.2 Bars)

Disassembly/Assembly Instructions - Extension Flapper

Important: Manufacturer's warranty is void if tool is disassembled before warranty expires.

Please refer to parts breakdown for part identification.

Motor Disassembly:

1. Disconnect tool from power source. Remove collet cap and abrasive.
2. Using an adjustable wrench, remove **51076** Housing Spindle by turning counter-clockwise.
3. Remove **53552** Spindle by securing **53551** Coupling Nut in a vise, and loosening **01435** Collet Body.
4. Secure motor housing using padded vise with motor spindle facing upwards.
5. Using an adjustable wrench, remove **53550** Adapter, roll back **53175** Collar.
6. Pull **51072** Coupler from housing. Remove **51066** Rotor Nut with an adjustable wrench, twist rotor nut from shaft.
7. Grab onto **01148** Rotor and pull motor assembly from motor housing.
8. Press **01148** Rotor from **01245** Rear Bearing Plate. Press **01015** Rear Bearing from rear bearing plate.
9. Remove **01013** Cylinder and **01011** Rotor Blades from rotor.
10. Press rotor through **01007** Front Bearing and **01008** Front Bearing Plate.
11. Remove front bearing shims and **01010** Spacer

Motor disassembly complete.

Housing Disassembly:

1. Position housing in padded vise with air inlet facing up.
2. Remove air fitting by securing **94523** Inlet Adapter with a wrench and twist air fitting from inlet adapter.
Important: **94523** Inlet Adapter must be secured before attempting to remove air fitting to avoid damaging valve body housing.
3. Remove **94523** Inlet Adapter.
4. Remove **95711** Retaining Ring from inlet adapter and separate **94521** Muffler Base from **94522** Muffler Cap. Remove **94528** Felt Muffler.
5. Remove **01642** Air Control Ring from housing.
6. Using a 2.5mm drift pin, tap **01017** Pin from housing and remove throttle lever assembly.
7. Remove **95558** Retaining Ring using retaining ring pliers.
8. Push **01247** Regulator from valve body housing and remove O-Rings.

Disassembly complete.

Motor Reassembly:

Important: Be sure parts are clean and in good repair before reassembly. Follow all grease, oil, and torque specifications.

1. Place **01148** Rotor in padded vise with spindle facing upwards.
2. Slip **01010** Spacer onto **01148** Rotor.
3. Place a .002" shim into **01008** Front Bearing Plate as an initial spacing and slip **01007** Bearing into plate. **Note:** **01121** Shim Pak contains .001" and .002" shims.
4. Slip bearing/bearing plate assembly onto rotor, torque **51066** Rotor Nut onto rotor shaft.
5. Check clearance between rotor and bearing plate by using a .001" feeler gauge. Clearance should be at .001" to .0015". Adjust clearance by repeating steps 2-4 with different shim if necessary.
6. Once proper rotor gap clearance is achieved, install well lubricated **01001** Blades (4) into rotor slots. Dynabrade recommends using their **95842** Air Lube.
7. Install cylinder over rotor. Be sure air inlet holes of cylinder face away from **01008** Front Bearing Plate.
8. Press **01015** Rear Bearing into **01245** Rear Bearing Plate. Press bearing/bearing plate assembly onto rotor. Be sure that pin and air inlet holes line up with pin slot and air inlet holes in cylinder.
Important: Fit must be snug between bearing plates and cylinder. If too tight, rotor will not turn freely. Rotor must then be lightly tapped at press fit end so it will turn freely while still maintaining a snug fit. A loose fit will not achieve the proper preload of motor bearings.
10. Secure motor housing in padded vise so motor cavity faces upwards. Install motor assembly into housing. Be sure motor inlet is facing the handle and it drops all the way into housing
11. Motor adjustment must now be checked. With motor housing still mounted in vise, pull end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then increase preload or remove shim. Also, push end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then deload or add shim.
12. Install **95711** Retaining Ring onto **51066** Rotor Nut using retaining ring pliers, and slip **51072** Coupler on to motor assembly.
13. Install **53550** Adapter into housing and torque 28 N•m/250 in. - lbs.
14. Install **53552** Spindle and **51076** Spindle Cover onto housing to secure motor (torque 28 N•m/250 in. - lbs.).

Motor Reassembly Complete.

Valve Body Reassembly:

1. Insert **01247** Speed Regulator Assembly with o-rings installed into housing. Secure with **95558** Retaining Ring.
2. Secure valve body in vise with air inlet facing upwards.
3. Insert **01464** Seal into housing.
4. Line-up the hole in the **01477** Valve Stem with the hole in the housing (looking past brass bushing). Insert **01472** Tip Valve so that the metal pin passes through the hole in the valve stem. Install **01468** Spring (small end first).
5. Reassemble muffler assembly. Slip **94523** Inlet Adapter through muffler assembly and secure with **95711** Retaining Ring.
6. Install air control ring into valve body housing.

(continued on next page)

Disassembly/Assembly Instructions (continued)

7. Apply Hernon #940 PST Pipe Sealant (or equivalent) to threads of inlet bushing and install muffler assembly onto valve body (torque 23.0 N•m/200 in. - lbs.).
8. Install throttle lever and **12132** Pin. Remove from vise.

Tool Reassembly is complete. Please allow 30 minutes for adhesives to cure before operating tool.

Important: Motor should now be tested for proper operation at 90 PSI. If motor does not operate properly or operates at a higher RPM than marked on the tool, the tool should be serviced to correct the cause before use.

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Optional Accessories



Dynaswivel®

Swivels 360° at two locations which allows an air hose to drop straight to the floor, no matter how the tool is held.

- **94300** Composite Swivel 1/4" NPT.
- **95461** 3/8" NPT.
- **95462** 1/2" NPT.



96007 Motor Tune-Up Kit

- Includes assorted parts to help maintain motor in tip-top shape.

Visit our new Web Site at <http://www.dynabrade.com>



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