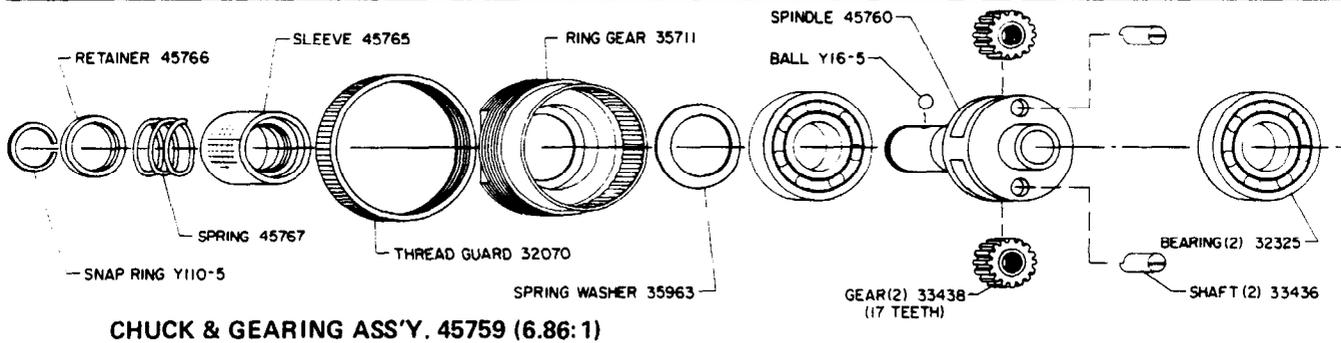
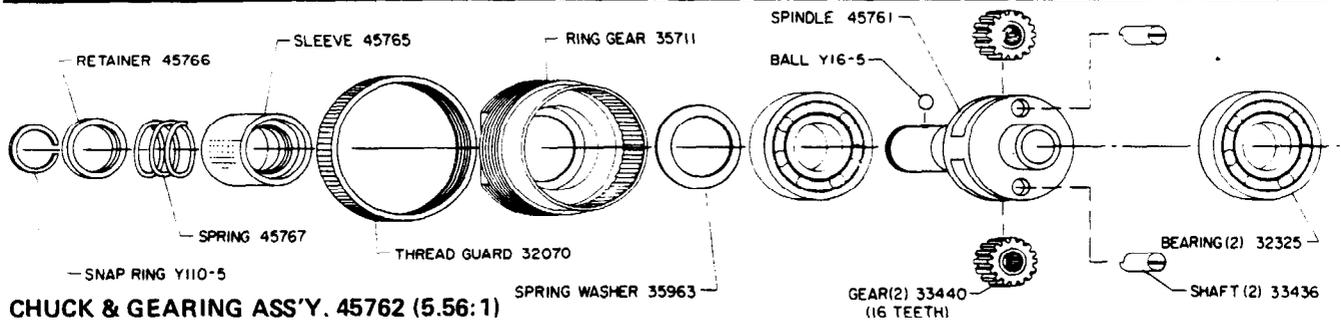
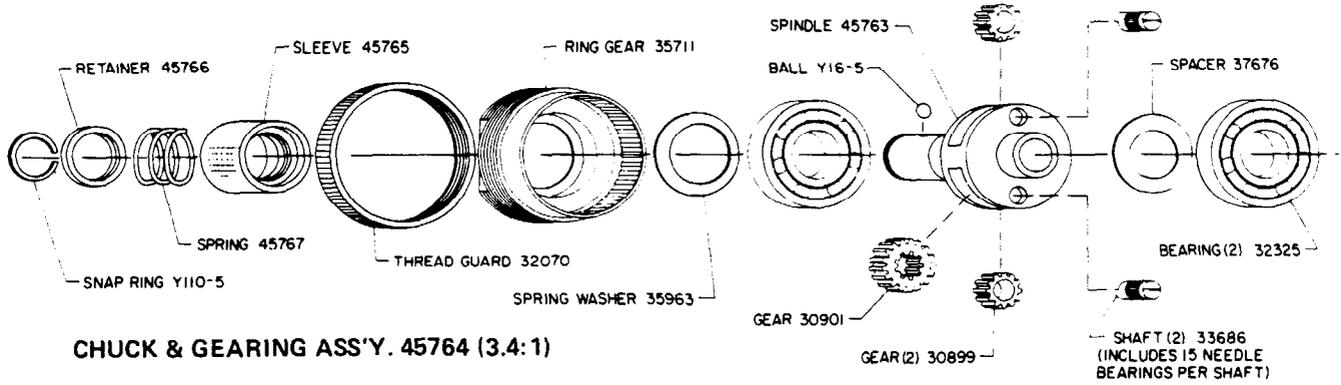


CHUCK AND GEARING ASSEMBLIES



DISASSEMBLY

- a. Depress Retainer (45766) and Sleeve (45765) and remove Snap Ring (Y110-5), Retainer (45766), Spring (45767), Sleeve (45765) and Ball (Y16-5).
 - b. Remove Thread Guard (32070) exposing flats on Ring Gear (35711). Using a suitable wrench on flats of Ring Gear unthread and remove gearing assembly from tool.
 - c. Grasp Ring Gear in one hand and tap drive end of Spindle with a non-metallic hammer; Spindle and components will loosen from Ring Gear.
- NOTE:** Gearing should not be disassembled further unless necessary to replace a part, as brinelling of the bearing races may occur making replacement of bearing necessary.
- d. To disassemble completely, remove Bearing (32325) from chuck end of Spindle. Alternately tap ends of Shafts loosening Bearing (32325) from opposite end of Spindle.
 - e. Remove Shafts to remove Gears from Spindle.

REASSEMBLY

- Pack ball bearings (lubricate needle bearings on shafts) and lubricate gears liberally with grease 33153, or equivalent, upon assembly. Gearing assembly should contain approximately 1/8 oz. grease.
- a. Assemble Gears to Spindle and secure with Shafts. Align notch in end of Shaft with flange on Spindle.
NOTE: Insure Shafts (33686) contain fifteen needle bearings per shaft.
 - b. Assemble Spacer (37676) where applicable, and Bearings (32325) to Spindle.
 - c. Assemble Washer (35963) to Ring Gear with small diameter of Washer facing bearing and assemble Spindle and components to Ring Gear.
 - d. Assemble gearing to tool and tighten securely. Assemble Thread Guard (32070) to Ring Gear.
 - e. Lubricate Ball (Y16-5) with grease and assemble Ball, Sleeve, Spring, and Retainer to Spindle and secure with Snap Ring (Y110-5).

**INDUSTRIAL AIR TOOLS
THE ARO CORPORATION**

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