

## AIR AND LUBE REQUIREMENTS

Air pressure of 90 p.s.i.g. (6 bar) at the air inlet of the tool is required for maximum motor efficiency. If necessary, an air regulator should be installed to maintain this air pressure when the tool is in operation.

Filtered and oiled air will allow the tool to operate more efficiently and yield a longer life to operating parts and mechanisms. A line filter capable of filtering particles larger than 50 microns should be used with a line oiler.

Filter-Regulator-Lubricator (F-R-L) assembly model 128231-800 is recommended for use with this air tool. The capacity of this F-R-L is adequate to provide clean (40 micron) oiled

and regulated air for the tool.

Flush tool with a solution of three parts cleaning solvent and one part light oil after each 40 hours of operation. After flushing, apply a small amount of spindle oil in air inlet and run free for one minute to insure proper lubrication.

Recommended hose size – 5/16" (8 mm) nominal inside diameter.

Recommended lubricants: spindle oil 29665, 1 qt. (.9 liter) container for oiler and air inlet; grease 33153, 5 lb. (2.3 kg) can for gears and bearings, "O" ring lubricant 36460, 4 oz. (113 g) tube for lubrication and installation of "O" rings.

## MAINTENANCE

Disconnect air supply from tool or shut off air supply line to tool and exhaust (drain) air line to tool of compressed air before performing service or maintenance to tool.

Air tools are made of precision parts and should be handled with reasonable care when servicing. Excessive pressure exerted by a holding device may cause distortion of a part. Apply pressure evenly when disassembling (or assembling) parts which have a press fit. When removing or installing bearings, apply pressure to the bearing race that will be press fit to the mating part; if this is not practiced, Brinelling of the bearing races will occur, making replacement necessary. It is important that the correct tools and fixtures are used when servicing this air tool.

Disassembly should be done on a clean work bench with a clean cloth spread to prevent the loss of small parts. After disassembly is completed, all parts should be thoroughly washed in a clean solvent, blown dry with air and inspected for wear levels, abuse and

contamination.

Double sealed or shielded bearings should never be placed in solvent unless a good method of relubricating the bearing is available. Open bearings may be washed but should not be allowed to spin while being blown dry. When replacement parts are necessary, consult drawing containing the part for identification.

Before reassembling, lubricate parts where required. Use 33153 grease, or equivalent, in bearings. Use 36460 lubricant for "O" ring assembly. When assembling "O" rings, care must be exercised to prevent damage to the rubber sealing surfaces. A small amount of grease will usually hold steel balls and other small parts in place while assembling.

When ordering parts, be sure to list **part number, part name, model number** and **serial number of tool**. Use only genuine ARO® replacement parts

## DISASSEMBLY AND ASSEMBLY OF TOOLS

### DISASSEMBLY

**DRIVE GEARING** – Remove accessory and keys from spindle. Remove cap screws (Y154-52) and remove gearing assembly from tool. Tap end of spindle with a soft face hammer to remove spindle and components from housing. Remove bearing and rotate snap ring to allow the removal of one shaft and gear. Repeat for opposite side.

**AUXILIARY GEARING** – Remove drive gearing. Remove cap screws (Y154-52) holding auxiliary gearing to motor housing and remove gearing from tool. Tap splined end of spindle with a soft face hammer to remove spindle and components from housing. Remove bearing and rotate snap ring to allow the removal of one shaft and gear. Repeat for opposite side.

**MOTOR** – The motor assembly may be removed from either end of housing after the removal of the head or gearing. After removing motor from housing, remove nut (33694) and sems fastener (33700). Grasp cylinder in one hand and tap drive end of rotor with a soft face hammer; motor will come apart.

### ASSEMBLY

**MOTOR** – Assemble bearings into end plates and assemble end plate (34485), with spacer (33701), to rotor. NOTE: Bearing (33709) is flush face type and must be assembled to end plate with bearing identification markings to the outside. Assemble cylinder (35679) over rotor and to end plate. Assemble blades to rotor. Assemble end plate (33712), with bearing, to rotor and cylinder. Assemble sems fastener (33700) and nut (33694) to motor. NOTE: Torque fastener to 28 in. lbs and nut to 9 – 12 ft lbs. Insure motor does not bind (if rotor binds, lightly tap splined end with a soft face hammer to loosen) and assemble to tool.

**AUXILIARY GEARING** – Assemble snap ring to spindle and rotate opening of ring to allow installation of shaft. Assemble gear to spindle and secure with shaft. Repeat for opposite side. After gears and shafts are assembled to spindle, rotate snap ring so open portion is 90° from either shaft, locking shafts in place. Assemble bearings to spindle and assemble with retaining ring into housing.

**DRIVE GEARING** – Assemble snap ring to spindle and rotate opening of ring to allow installation of shaft. Assemble gear to spindle and secure with shaft. Repeat for opposite side. After gears and shafts are assembled to spindle, rotate snap ring so open portion is 90° from either shaft, locking shafts in place. Assemble bearings to spindle and assemble, with seal (37389), washer (47590), wave washer (47589) and spacer (33697) to housing.