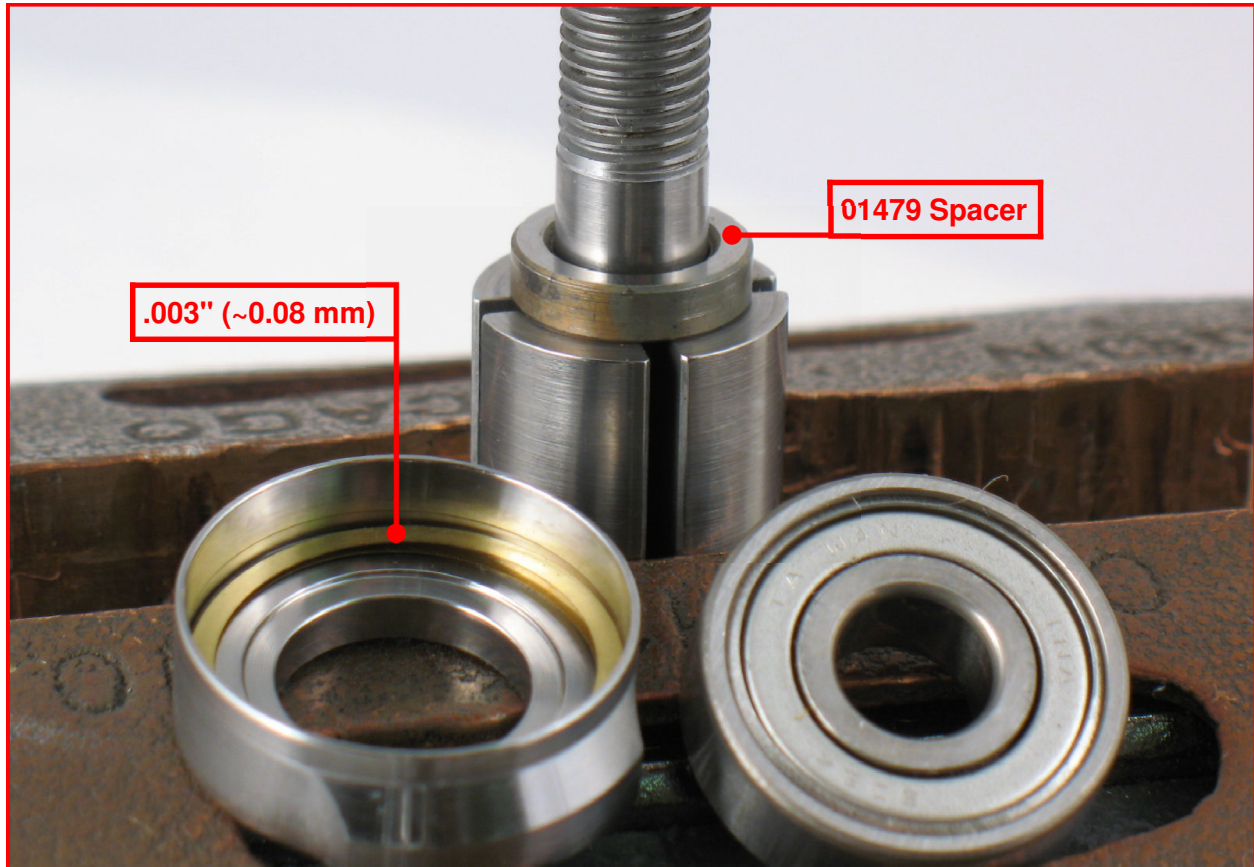


Assembly Instructions - 0.4 hp. Dynaflex II

Motor Assembly:



1. Fasten the rotor in a vise with aluminum or bronze jaws so that the rotor spindle is pointing up.
 - Install the **01479** Spacer onto the rotor.
 - Install .003" (~0.08 mm) shim thickness into the **01478** Front Bearing Plate.

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2. Install the **02649** Bearing into the front bearing plate.
 - Install the bearing and plate onto the rotor.
 - Install the **04117** Adapter, hand tight.
 - Remove assembly from vise.

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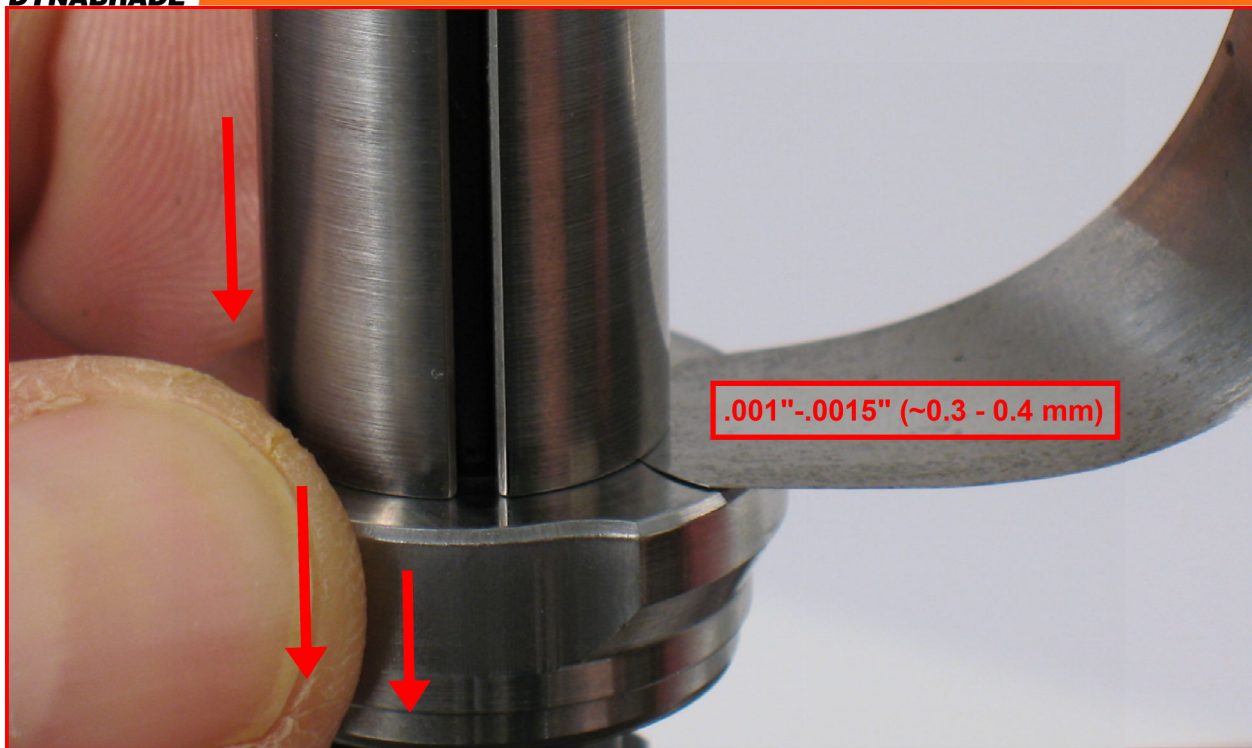
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3. Use a .001" (~0.3 mm) thick feeler gauge to check clearance between the front bearing plate and the front of the rotor.
 - Push down on the bearing plate to take movement out of the bearing.
 - The clearance should be .001"-.0015" (~0.3 - 0.4 mm). **Notice:** If the clearance needs further adjustment repeat steps 2-3. Add or remove shims as required.



4. Once the correct clearance is achieved, fasten rotor in vise and tighten the **04117** Adapter.
 - **T to 17 N•m/~150 in. lbs.**



Disassembly/Assembly Instructions



5. Lubricate the **01480** Vanes with the **95842** Dynabrade Air Lube 10W/NR or equivalent.
 - Install oiled vanes.

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6. Use the **RAISED OUTSIDE DIAMETER** of the **96242** Bearing Press Tool and the **94232** Arbor Press (#2) to install the **02696** Bearing into the **02673** Rear Bearing Plate.

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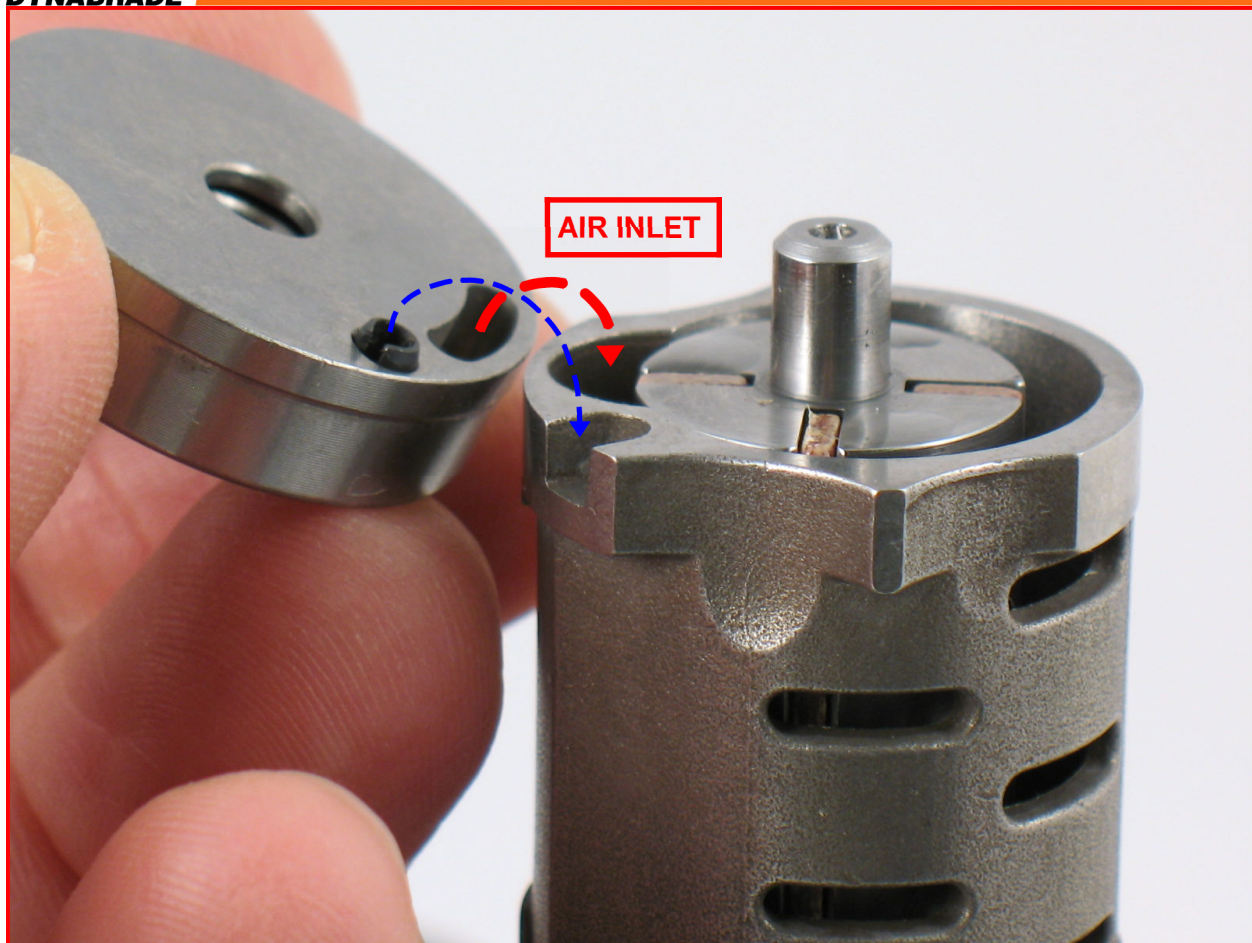
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7. Install the **01476** Cylinder so that the air inlet opening in the **02673** Rear Bearing Plate will line up with the air inlet opening of the cylinder.

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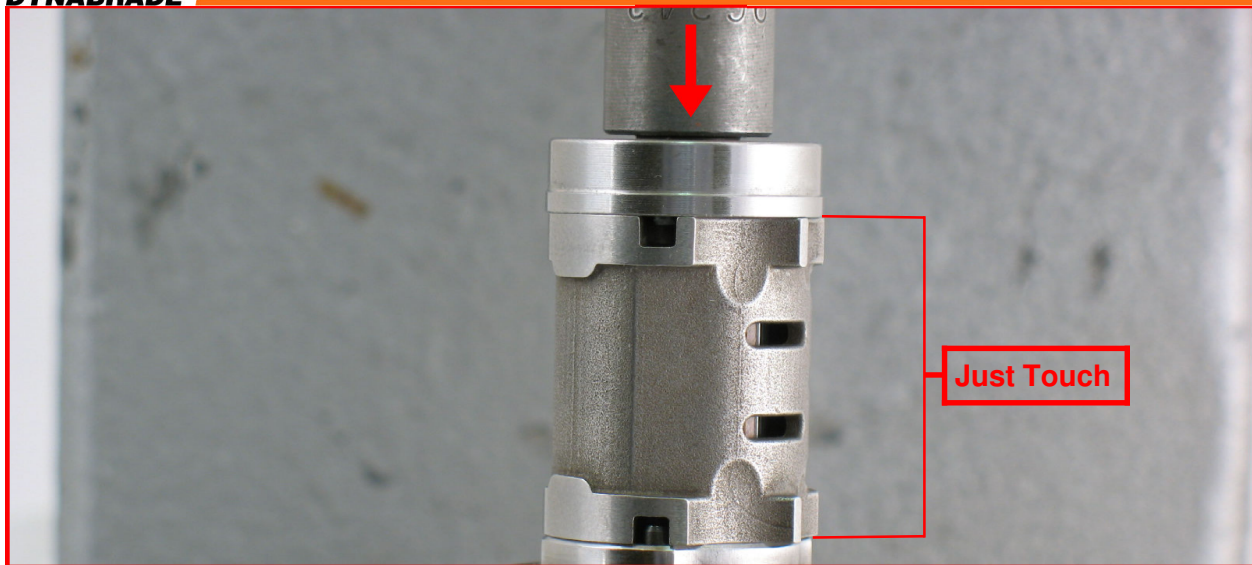
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Disassembly/Assembly Instructions



8. Use the **RAISED INSIDE DIAMETER** of the **96242** Bearing Press Tool and the arbor press to install the rear bearing and plate onto the rotor. **Notice:** Carefully press the bearing and plate down until it just touches the cylinder. This will establish a close fit between the bearing plates and the cylinder.

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Disassembly/Assembly Instructions



9. Apply a small amount of clean grease to the seal of the **02696** Bearing. **Notice:** The grease is used to hold the shield against the seal of the bearing.
 - Install the **02679** Shield.

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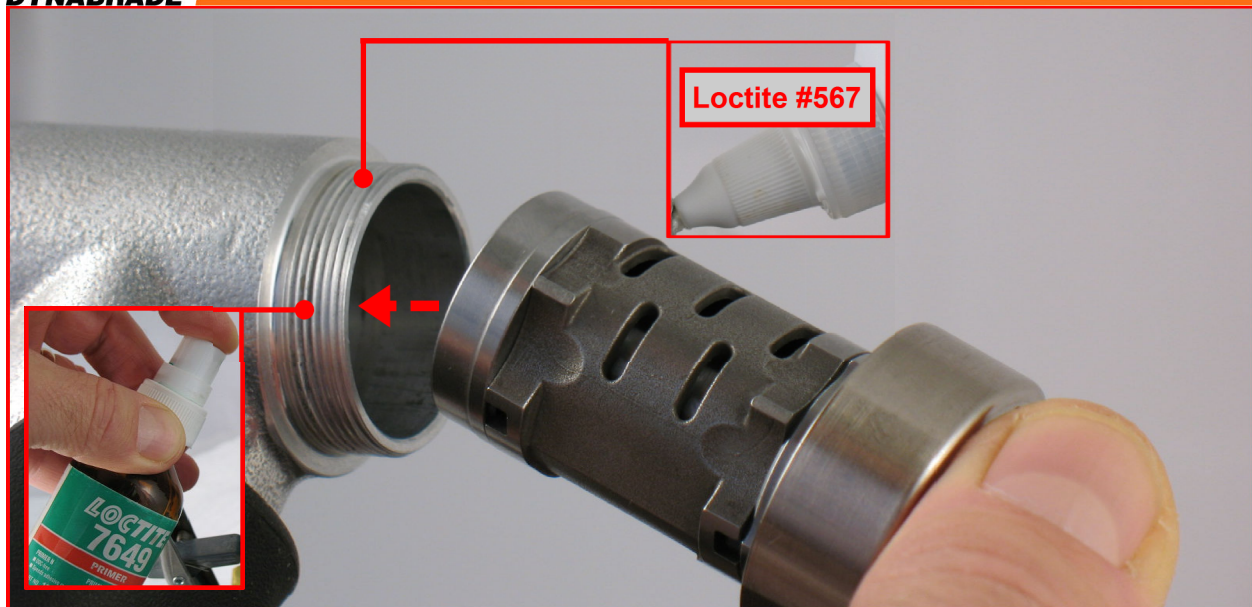
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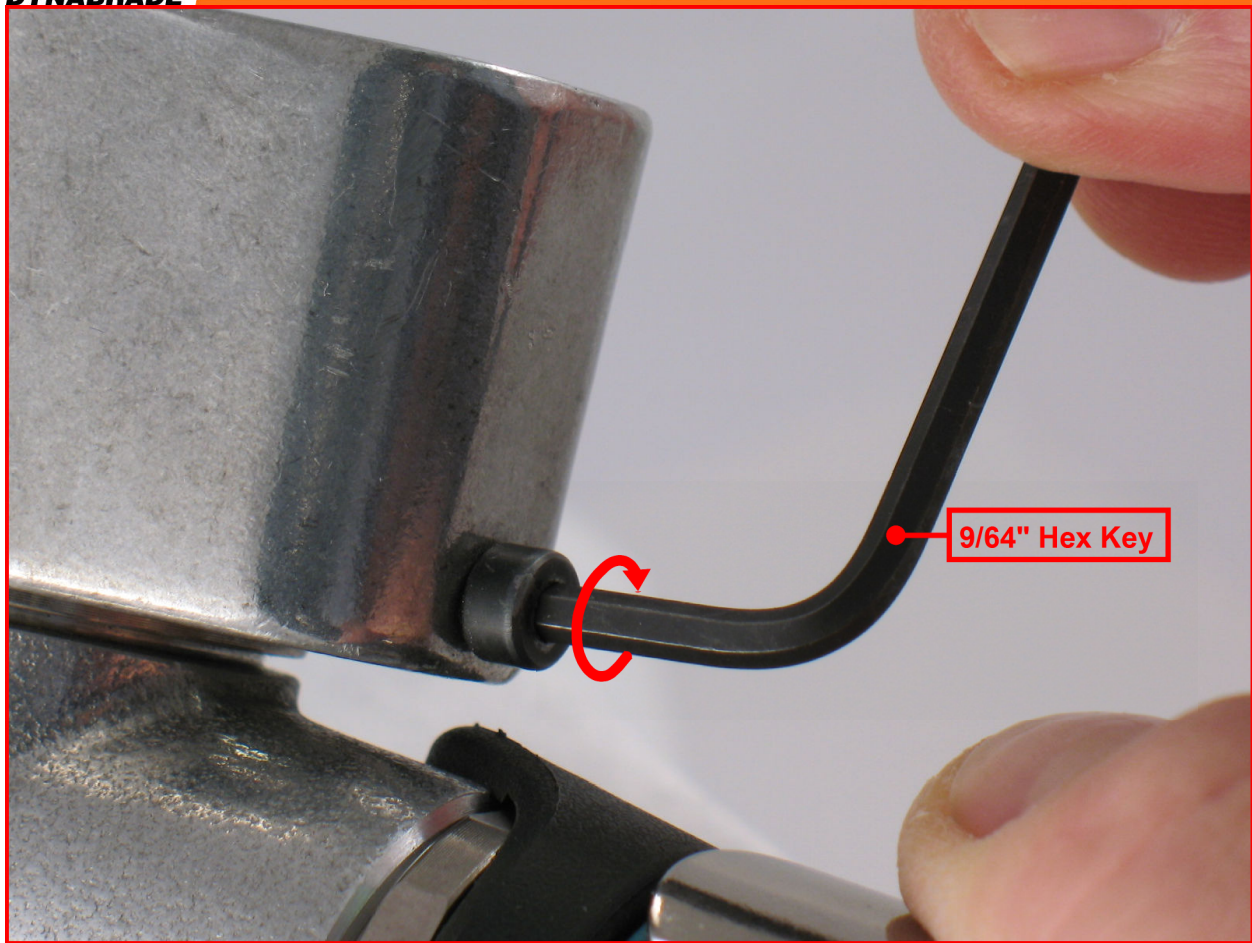
10. Carefully install the motor assembly into the **01546** Housing.
- Apply Loctite #7649 Primer or equivalent to the thread of the **01546** Housing.
 - Apply a small amount of Loctite #567 or equivalent to the **01546** Housing.



11. Carefully fasten the **01546** Housing in the vise with aluminum or bronze jaws so that the **04117** Adapter is pointing up. **Notice: Over tightening vise will damage housing.** Repair Collar **96461** (designed to protect the **01546** Housing) is available upon order.
- Use the **50971** Lock Ring Tool and a torque wrench, or an adjustable 3 mm pin spanner wrench to fasten the **04116** Exhaust Cover onto the **01546** Housing.
 - **T** to 28 N•m/~250 in. lbs.



Disassembly/Assembly Instructions



12. Install air motor into the belt housing assembly.
- Use a 9/64" hex key to tighten the **95311** Motor Lock Screw.
- Motor Assembly Completed.**

Notice: For belt housing, throttle body, and contact arm assemblies, refer to the exploded view and the additional instructions contained in the tool parts page or manual.

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