

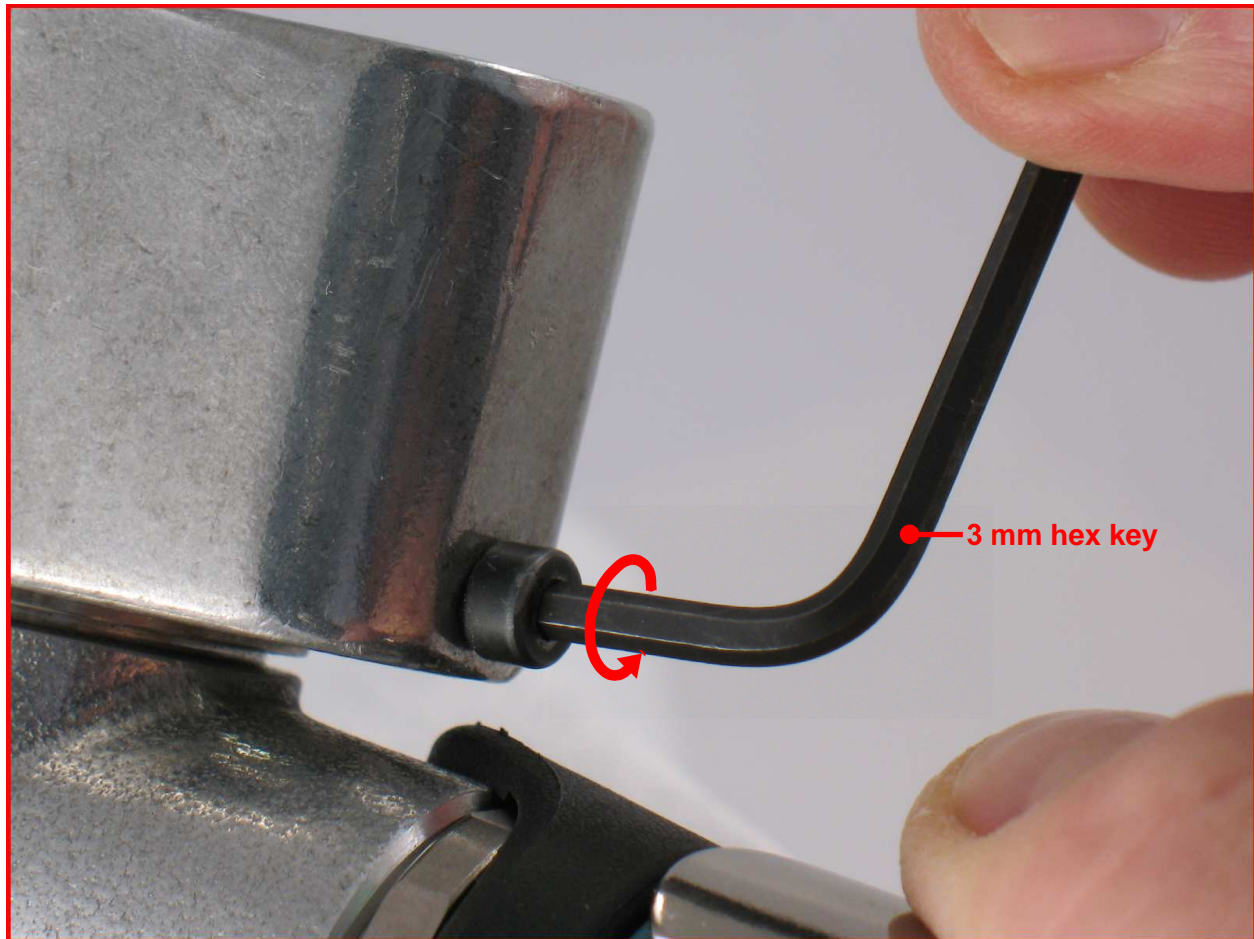
### **Disassembly Instructions - 0.4 hp. Mini-Dynaflex II**

**Important:** Use these instructions along with the tool parts page or manual.

**Notice:** Shut off the air supply and depress throttle lever to deplete the remaining air.

• Carefully disconnect the tool from the air supply hose. • Remove the abrasive belt and contact arm assembly. • Use the Special Repair Tools designed for the disassembly and assembly of this motor.

#### **Motor Disassembly:**



1. Use a 3 mm hex key to loosen the **01788** Motor Lock Screw. Remove the **15060** Housing Assembly from the air motor.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

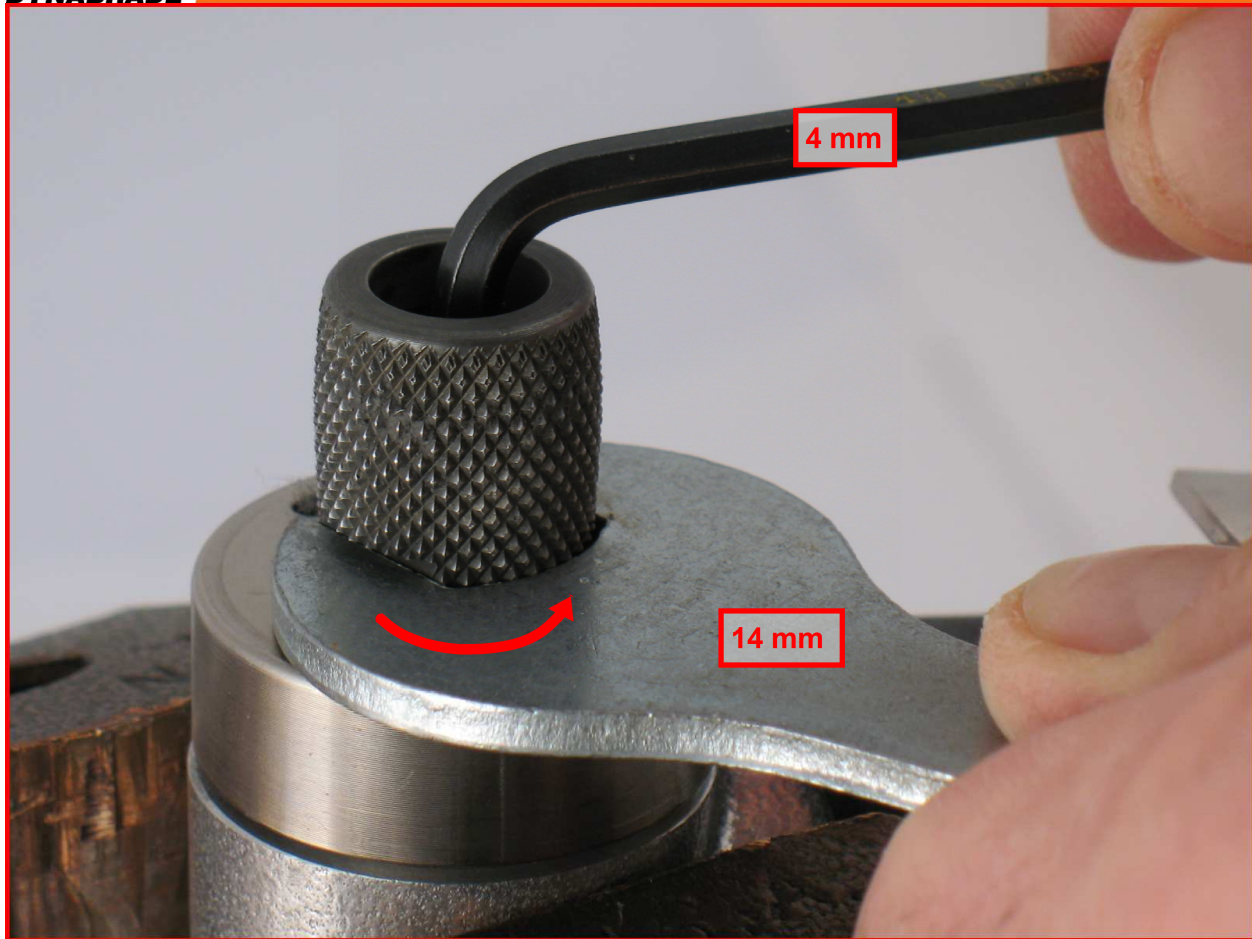
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



2. Carefully fasten the **01546** Housing in a vise with aluminum or bronze jaws so that the drive wheel 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 **95262**, 14 mm Wrench and a 4 mm hex key to remove the **15118** Drive Wheel. **Notice: If the drive wheel cannot be removed, or the optional rubber drive wheel, 40378 has been installed, refer to Step #3.**



3. Use the **50971** Lock Ring Tool or an adjustable 3 mm pin spanner wrench to remove the **15106** Exhaust Cover. Turn counterclockwise.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

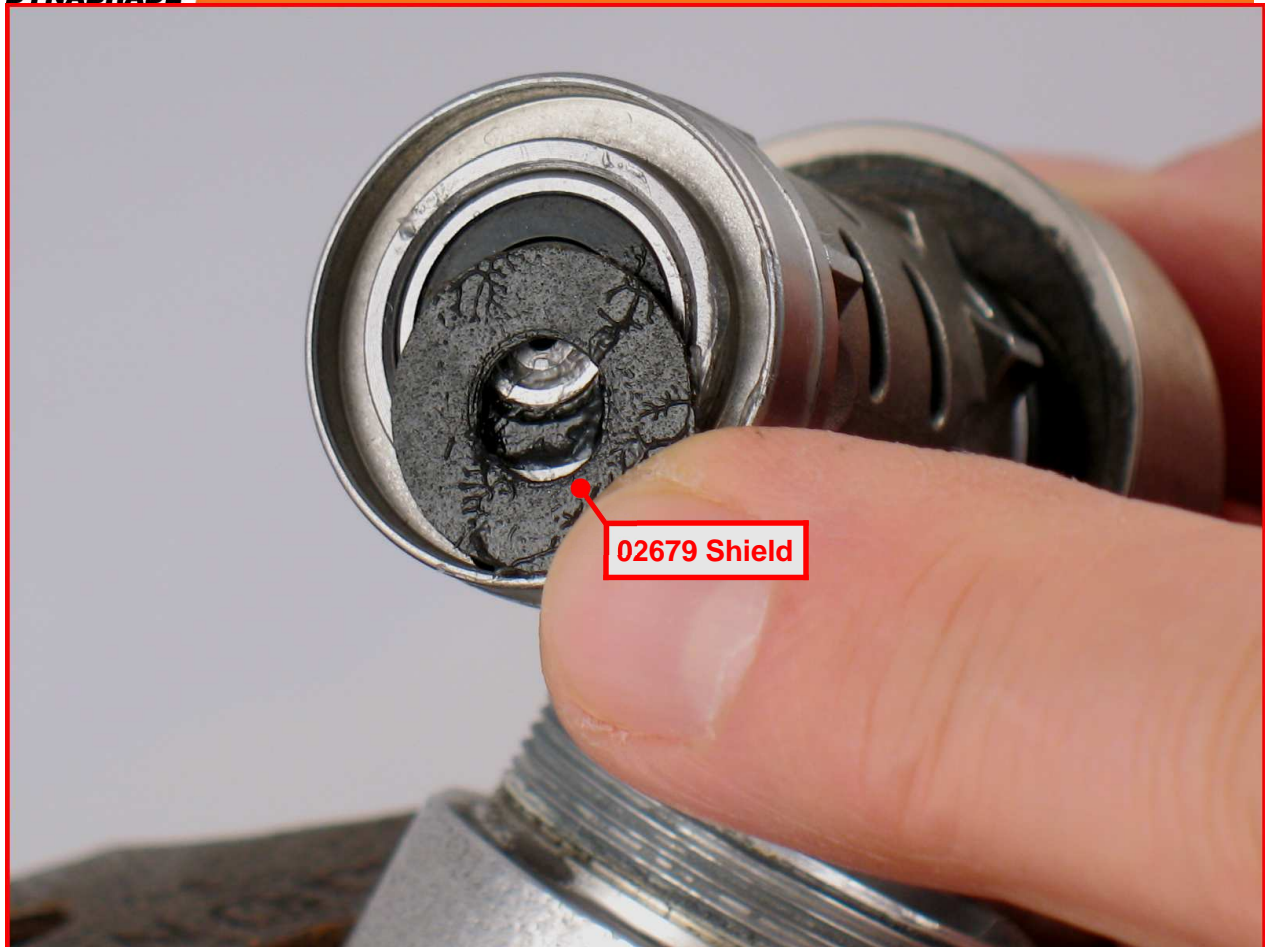
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



4. Loosen the vise and carefully pull the motor out of the **01546** Housing.
  - Remove the **02679** Shield.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

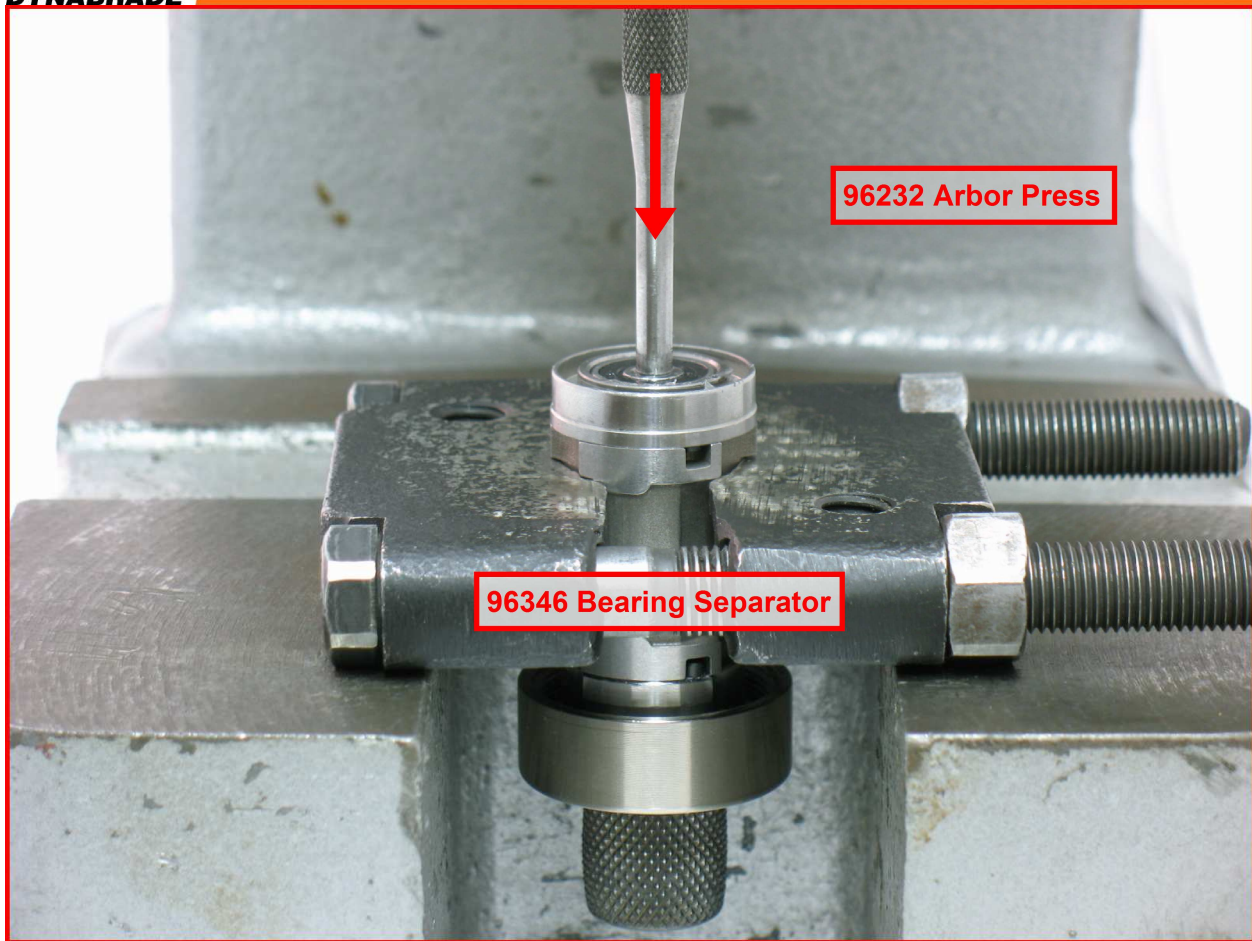
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

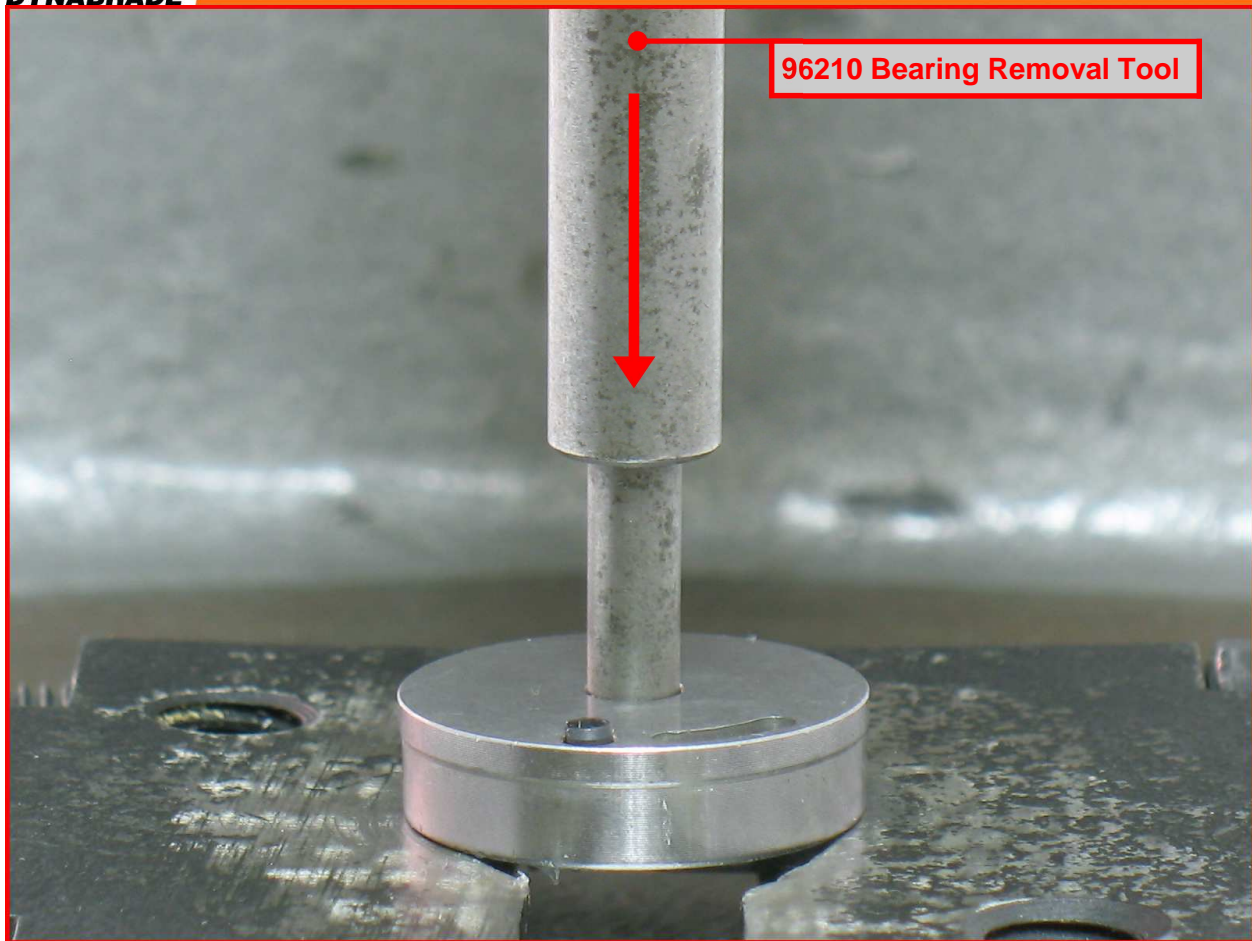
**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



5. Fasten the **96346** Bearing Separator (2") around the **01476** Cylinder.
- Place the bearing separator in the **96232** Arbor Press (#2) so that the drive wheel is pointing down.
  - Use a 3/16" or 5 mm diameter flat end drive punch as a press tool and push the rotor out of the **02696** Bearing.



## Disassembly/Assembly Instructions



6. Use the **96210** Bearing Removal Tool and the arbor press to remove the **02696** Bearing from the rear bearing plate.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



7. Fasten the rotor in the vise with aluminum or bronze jaws so that the drive wheel is pointing up.
  - Use the **95262**, 14 mm Wrench, or groove pliers to remove the drive wheel. Turn counterclockwise.
  - Remove the exhaust cover, felt silencers, bearing, plate, shims and the **01479** Spacer.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



## ***Disassembly/Assembly Instructions***



**Motor Disassembly Complete.**

**Clean and inspect parts before assembling.**

*Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)*

*Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)*

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

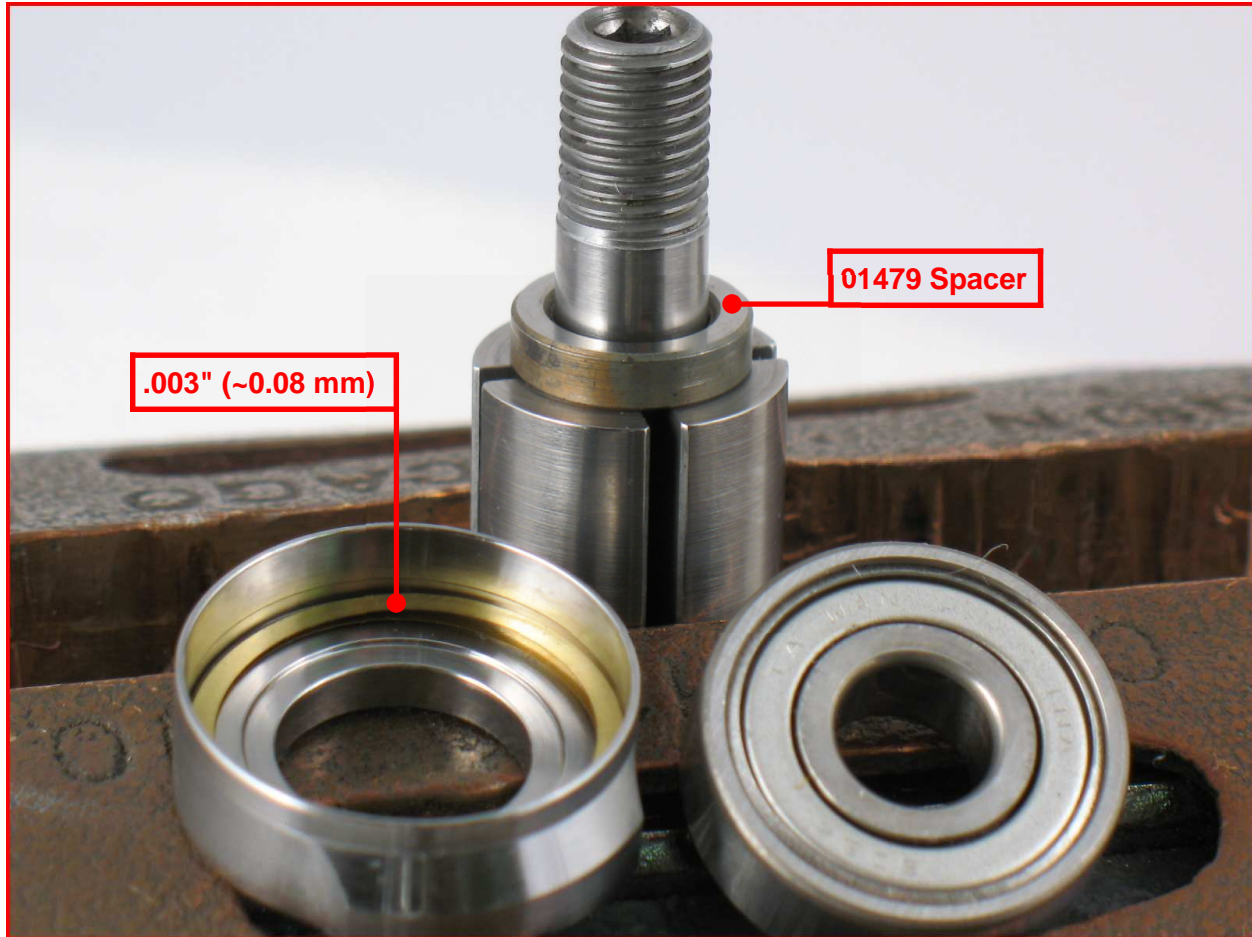
**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



### Assembly Instructions - 0.4 hp. Mini-Dynafile 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.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



2. Install the **02649** Bearing into the front bearing plate.
  - Install the bearing and plate onto the rotor.
  - Install the drive wheel hand tight.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

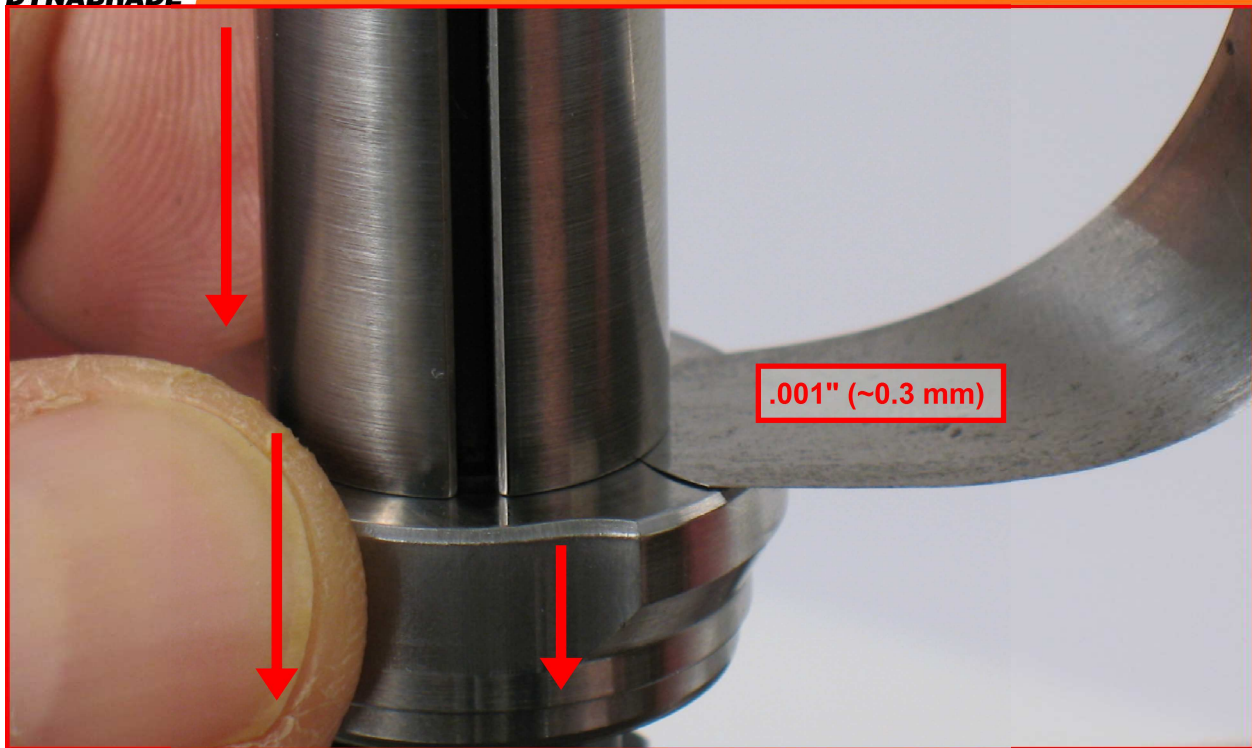
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

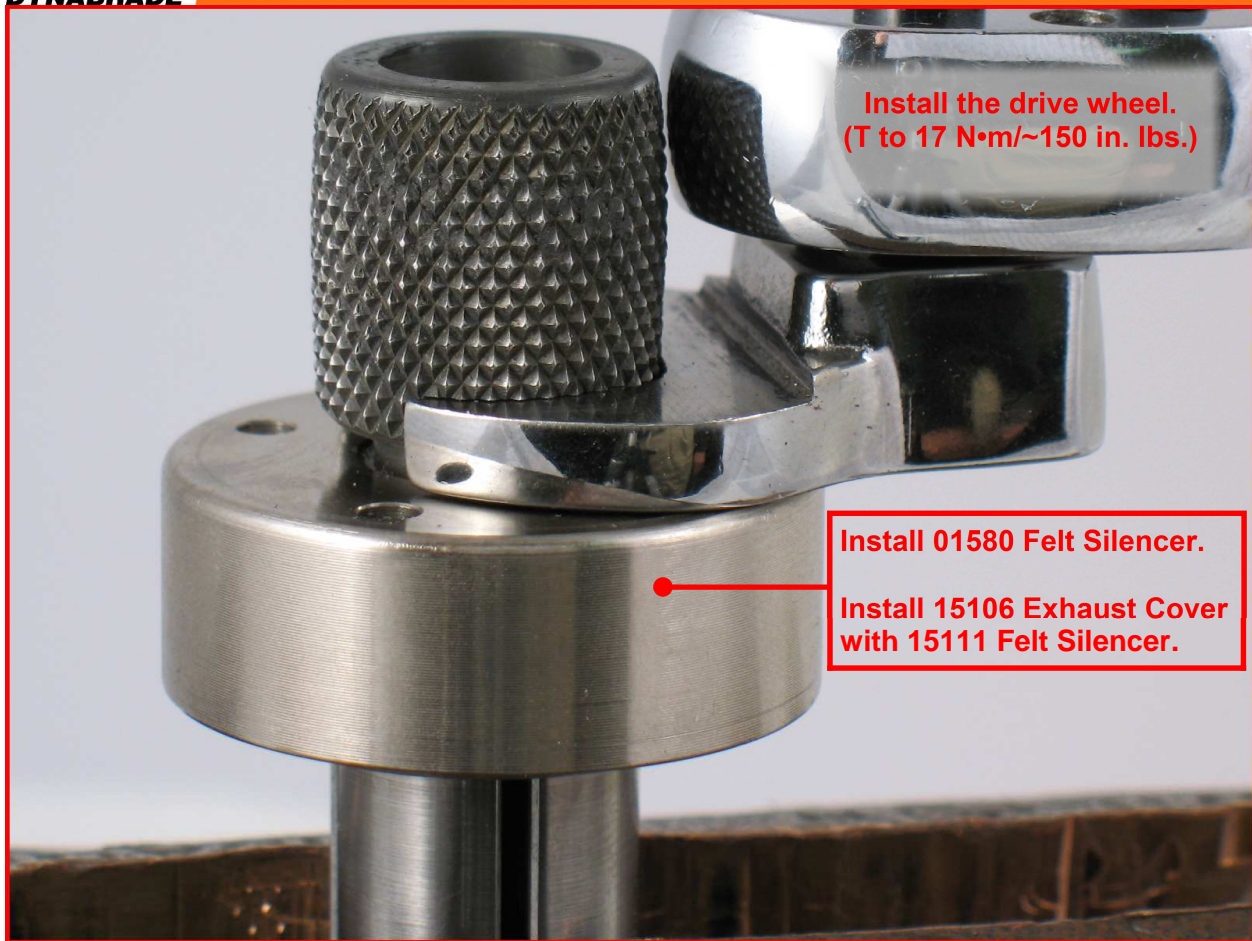
**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



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.

## Disassembly/Assembly Instructions



4. Once the correct clearance is achieved, remove the drive wheel and install the **01580** Felt Silencer around the rotor spindle.
  - Install the **15111** Felt Silencer into the **15106** Exhaust Cover and place these onto the rotor.
  - Install the drive wheel. (T to 17 N•m/~150 in. lbs.)

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



## Disassembly/Assembly Instructions



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

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



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.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

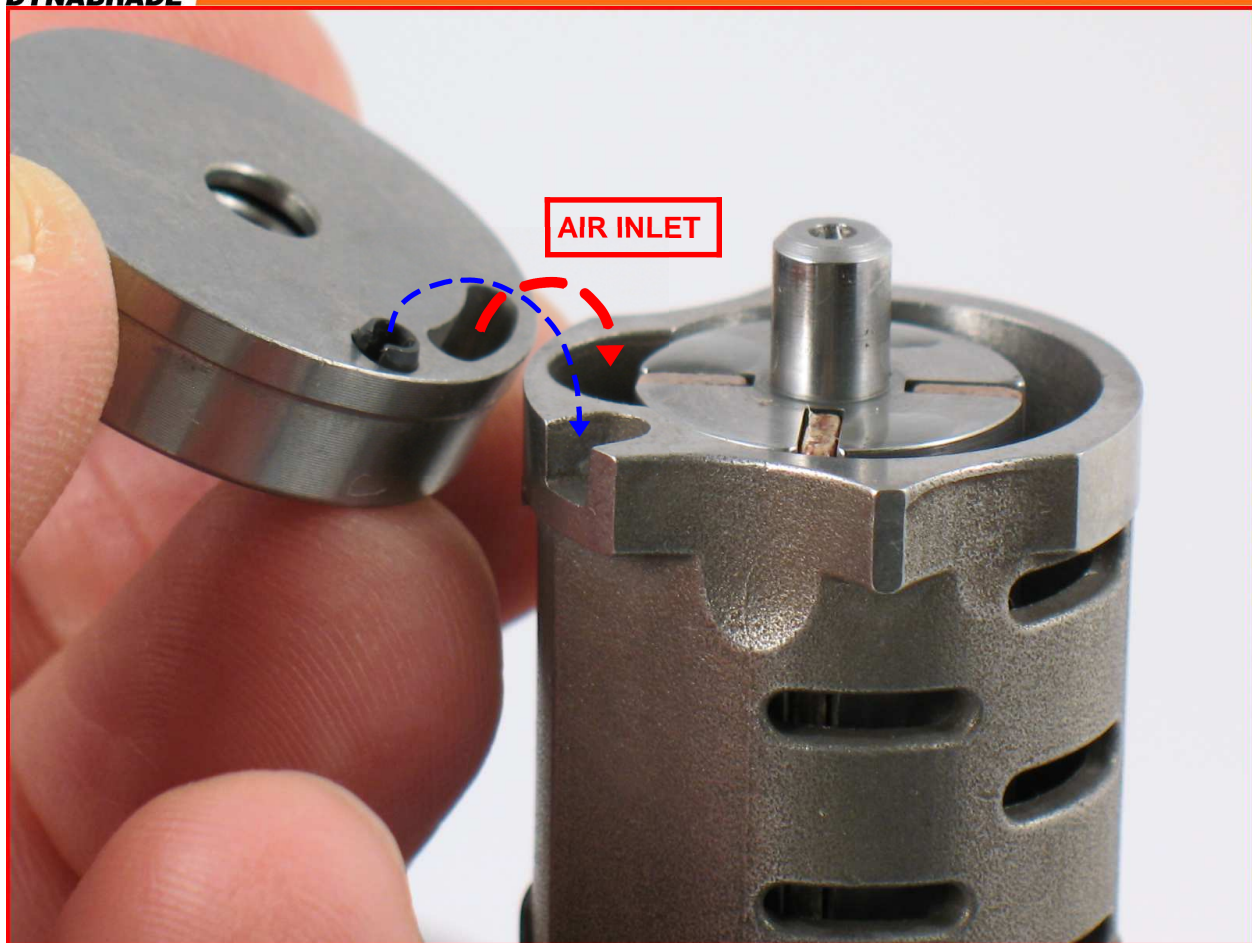
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



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.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

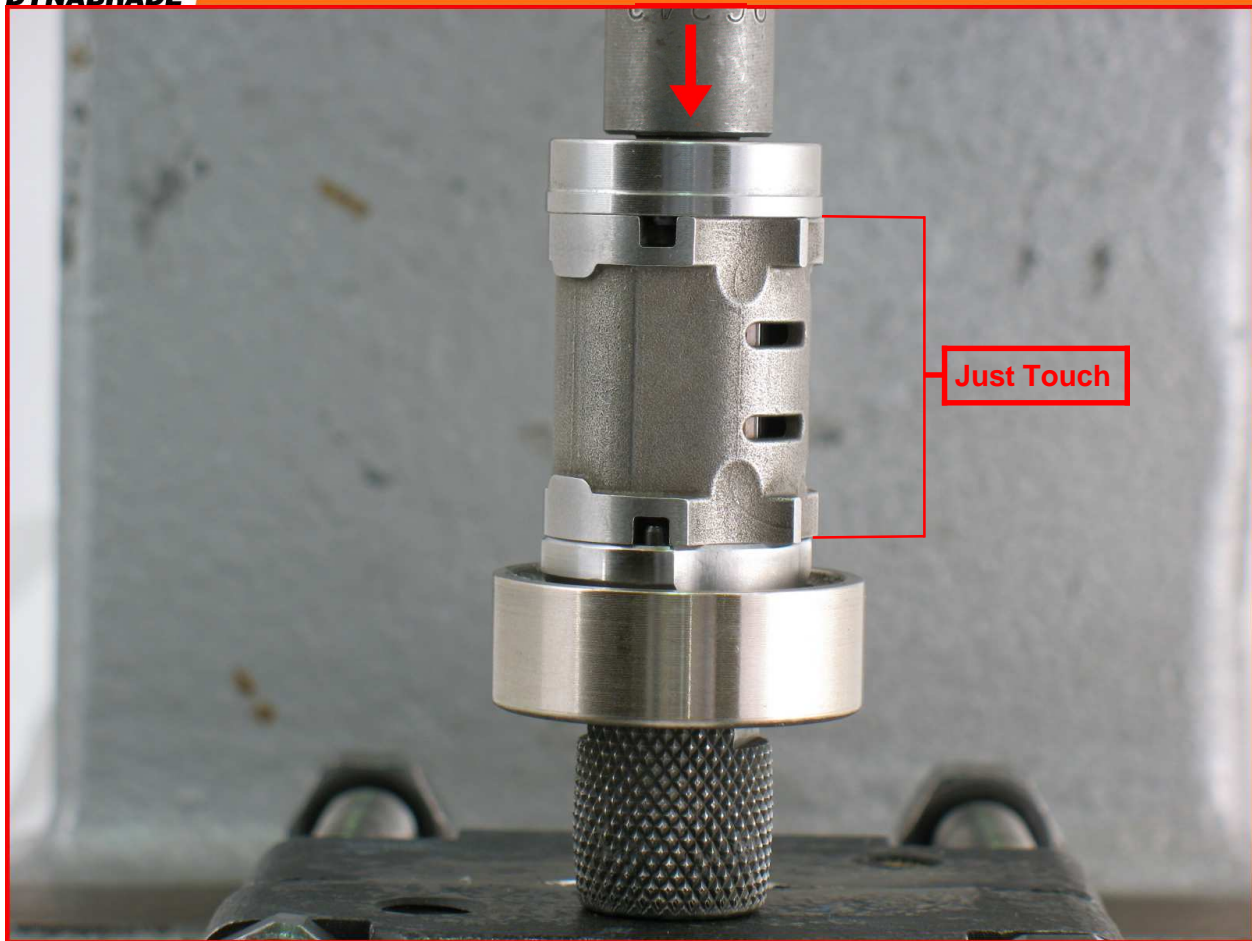
**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



## 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.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**

8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**

Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**

Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**

EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228

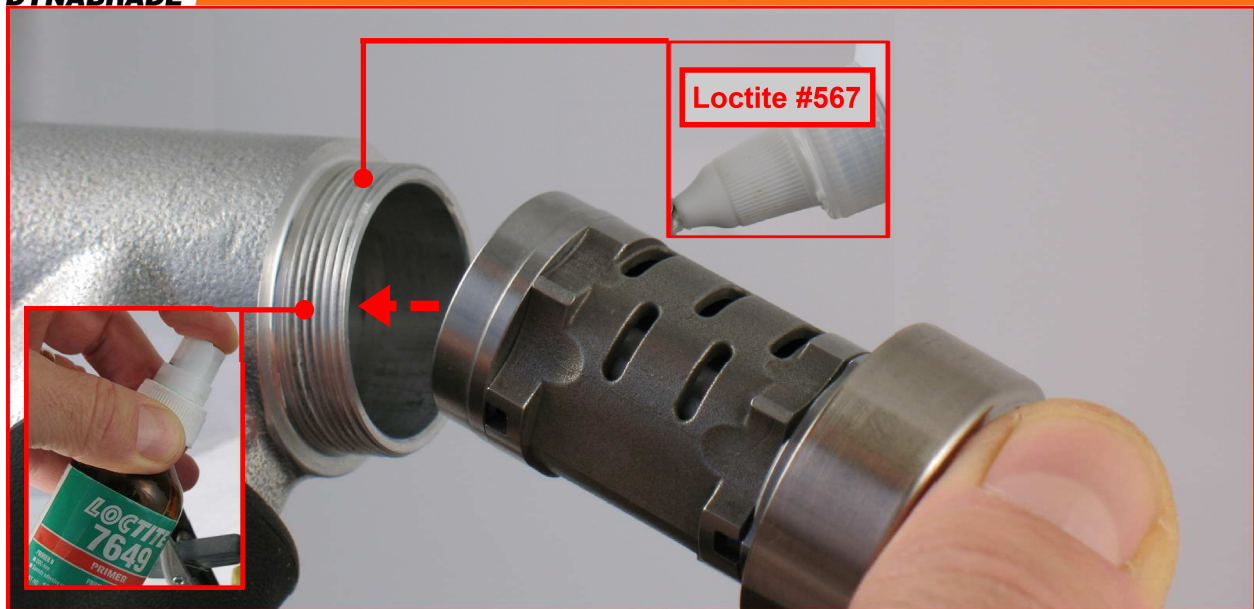




9. Apply a small amount of clean grease to the seal of the **02696** Bearing. **Notice:** The grease is used to hold the shield against the seal of the bearing.
  - Install the **02679** Shield.



## Disassembly/Assembly Instructions



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.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



## Disassembly/Assembly Instructions



11. Carefully fasten the **01546** Housing in the vise with aluminum or bronze jaws so that the drive wheel 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 **15106** Exhaust Cover onto the **01546** Housing.
- **T** to 28 N•m/~250 in. lbs.

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

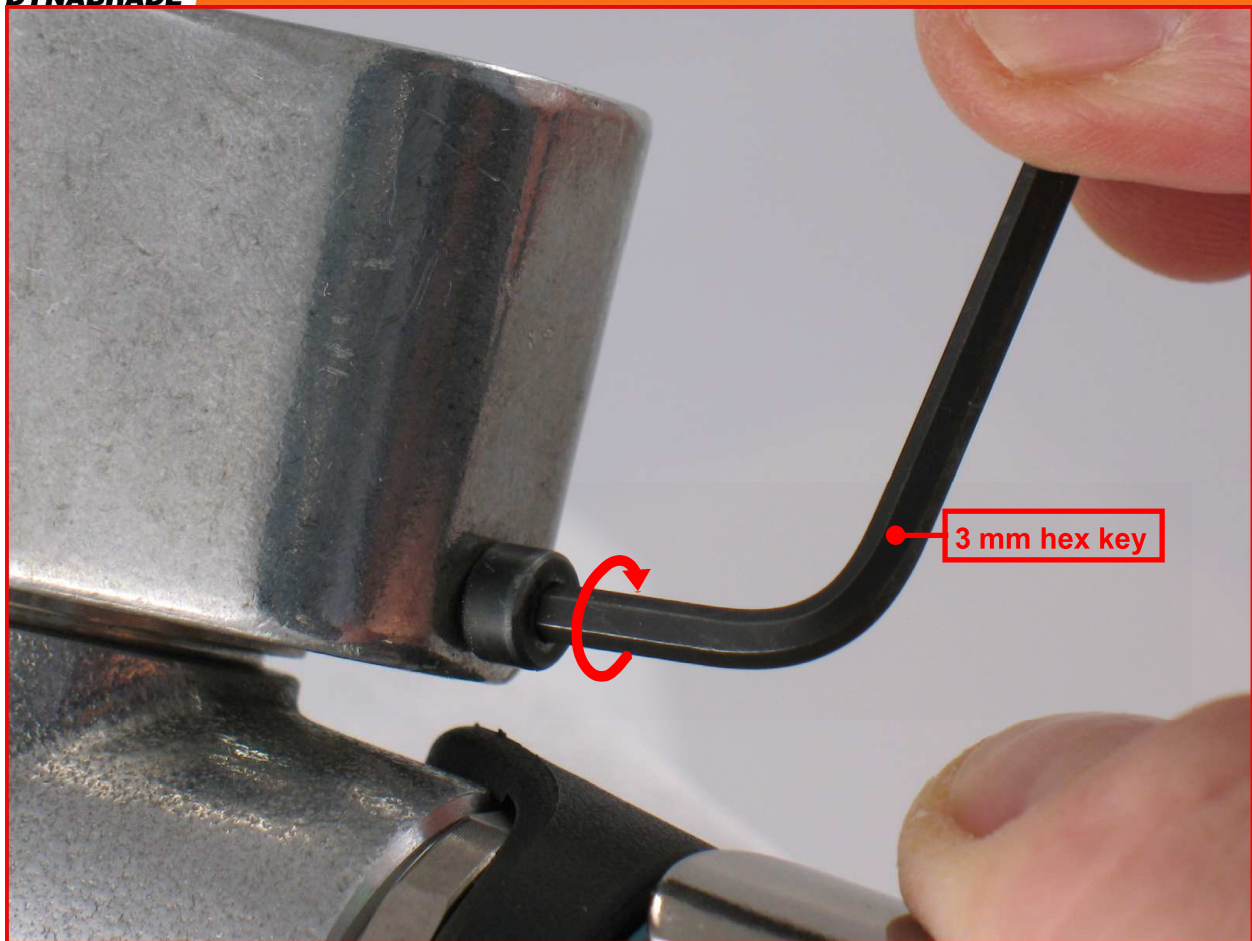
Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



12. Install air motor into the **15060** Housing Assembly.
- Use a 3 mm hex key to tighten the **01788** Motor Lock Screw.
- Motor Assembly Completed.**

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

Visit Our Website: [www.dynabrade.com](http://www.dynabrade.com)

Email: [customer.service@dynabrade.com](mailto:customer.service@dynabrade.com)

**DYNABRADE, INC. • DYNABRADE INTERNATIONAL**  
8989 Sheridan Drive, Clarence, New York 14031-1490 USA  
Telephone: (716) 631-0100 • Fax: 716-631-2073 • Int'l Fax: 716-631-2524

**DYNABRADE DO BRASIL**  
Rua Oneda, 632, Sao Bernardo do Campo • SP – CEP 09895-280  
Telephone: 55-11-4390-0133 • Fax: 55-11-4399-1067

**DYNABRADE EUROPE S.à.r.l.**  
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.**  
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705  
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228