

### **Disassembly Instructions - 0.4 hp. Planetary Reduction Gears**

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

#### **Planetary Gear Disassembly:**

- 1. Important:** To separate the planetary adapter or gear case from the housing core, view and follow the "**Disassembly Instructions - 0.4 hp. Air Motor (Straight)**".
- 2.** Fasten the flats of the planetary adapter or gear case in a vise with aluminum or bronze jaws.

Use a **HEAT GUN** to warm the rear exhaust cover, planetary housing or lock nut to soften the thread adhesive.

Use the **50971 Lock Ring Tool** or adjustable wrench to separate the rear exhaust cover, planetary housing or lock nut from the adapter or gear case.



- 3.** Use a 2 mm or 5/64" hex key to remove the setscrew(s).



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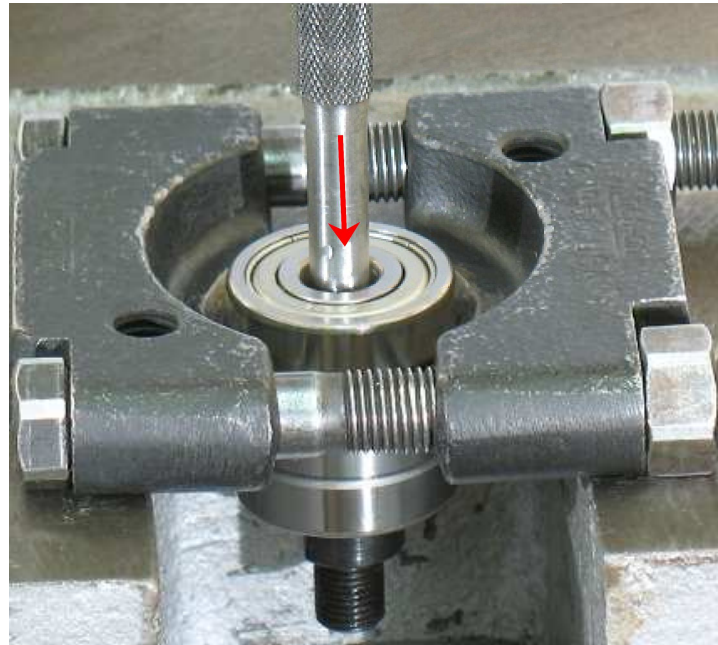
4. Remove the planetary reduction.
5. **Important:** Fasten the **96346** Bearing Separator (2") with the **FLAT SIDE** facing the RING GEAR and the **BEVELED SIDE** facing the "REAR" **54520** Bearing. Place the bearing separator and the planetary reduction in the **96232** Arbor Press (#2) with the **50782** Adapter or pinion gear pointing down.



6. Use a 5/16" flat-end drive punch as a press tool to push the planetary carrier out of the **54520** Bearing.



7. Remove the ring gear, shafts, and planet gears.



**Notice:** Gently tap the carrier on a hard surface. The shafts and gears will fall out of the carrier.

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8. Use a **HEAT GUN** to warm the **50782** Adapter or pinion gear to soften the thread adhesive.

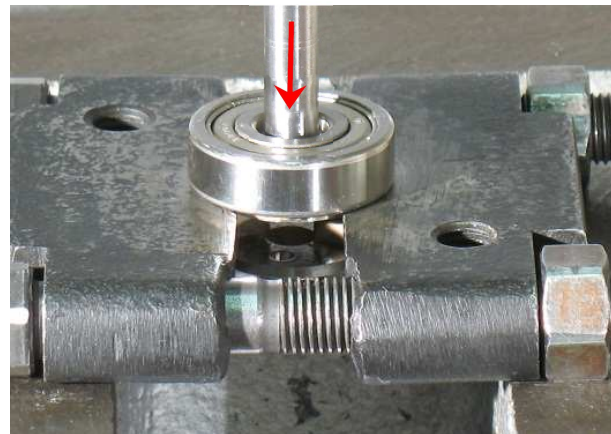
With the planetary carrier pointing up, carefully fasten the adapter or pinion in the vise with aluminum or bronze jaws.

Insert a screwdriver through the carrier and turn counterclockwise to remove the adapter or pinion.



9. Use the arbor press, and a 5/16" flat-end drive punch as a press tool to push the planetary carrier out of the remaining **54520** Bearing.

**Planetary Gear Disassembly Complete.**



**Clean and inspect parts before assembling.**

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