



## Disassembly/Assembly Instructions

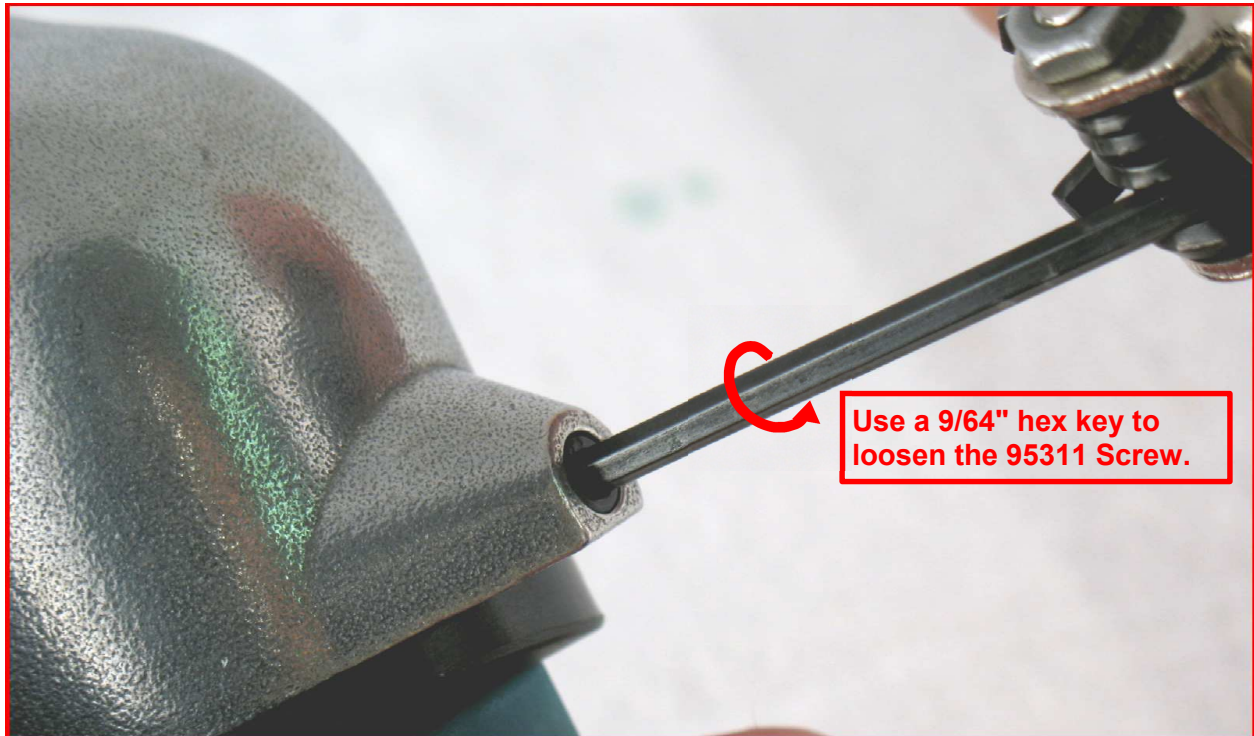
### Disassembly Instructions - 0.5 hp. 14000 Dynafile

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

**Notice:** Shut off the air supply and depress throttle lever to dissipate 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 9/64" hex key to loosen the **95311** Screw. Remove the **01197** Air Motor along with the **11424** Wave Spring and the **11419** Cover.

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2. Fasten the housing flats of the **01197** Air Motor in a vise with aluminum or bronze jaws so that the drive wheel is pointing up.
  - Insert a 3/16" hex key through the **01111** Drive Wheel and into the end of the **01120** Rotor to hold it stationary. Grasp the drive wheel and turn it counterclockwise to remove.
  - Remove the **10295** Screen.

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3. Use the **50971** Lock Ring Wrench to remove the **04087** Lock Ring. Turn counterclockwise.
  - Remove the **04084** Air Control Ring and the **04078** Felt Silencer.
  - Pull the motor out of the housing.

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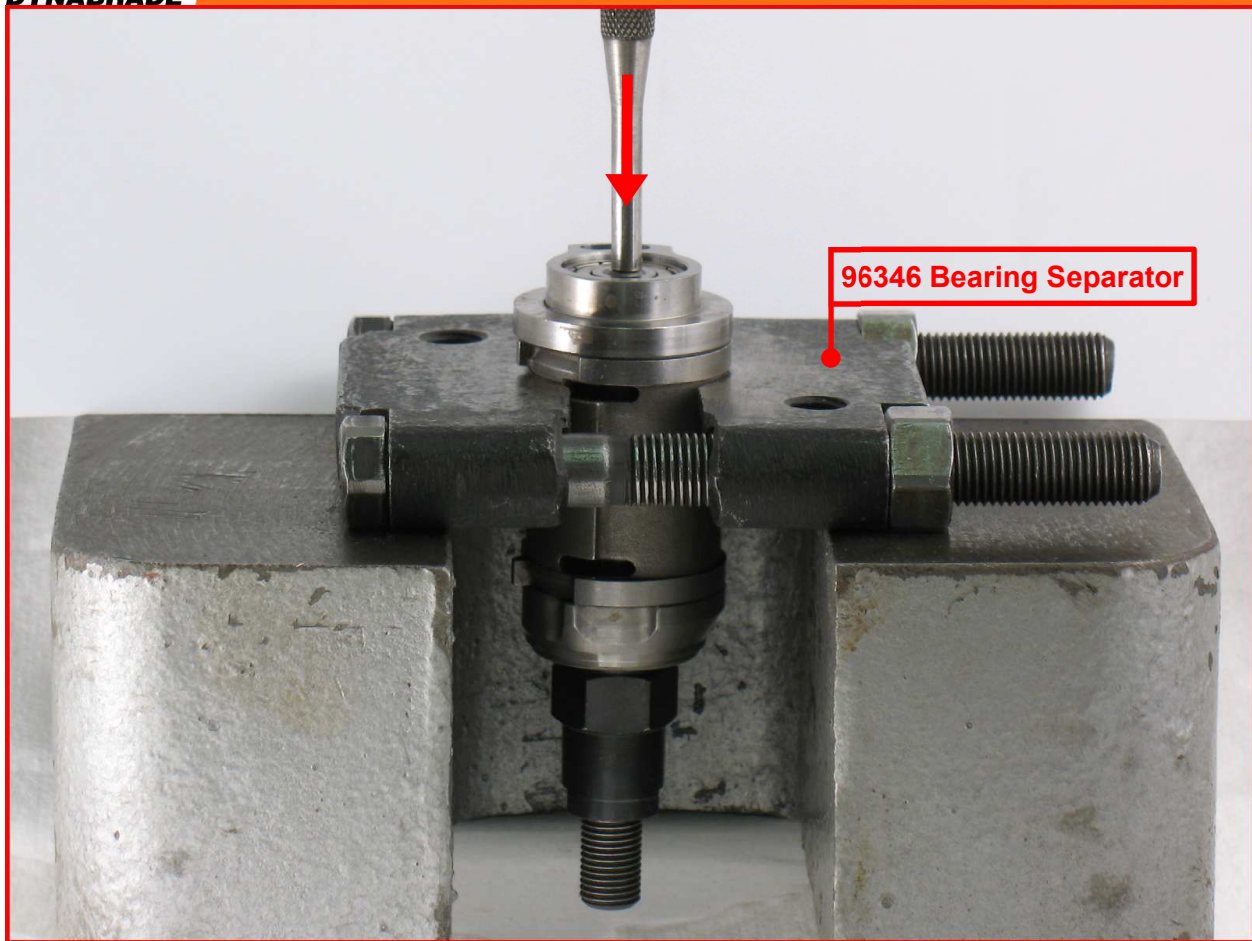
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4. Fasten the **96346** Bearing Separator (2") around the **01013** Cylinder. Place the separator and the motor in the **96232** Arbor Press (#2) so that the rotor spindle is pointing down.
  - Use a 3/16" or 5mm diameter flat end drive punch to push the rotor out of the **01015** Bearing.

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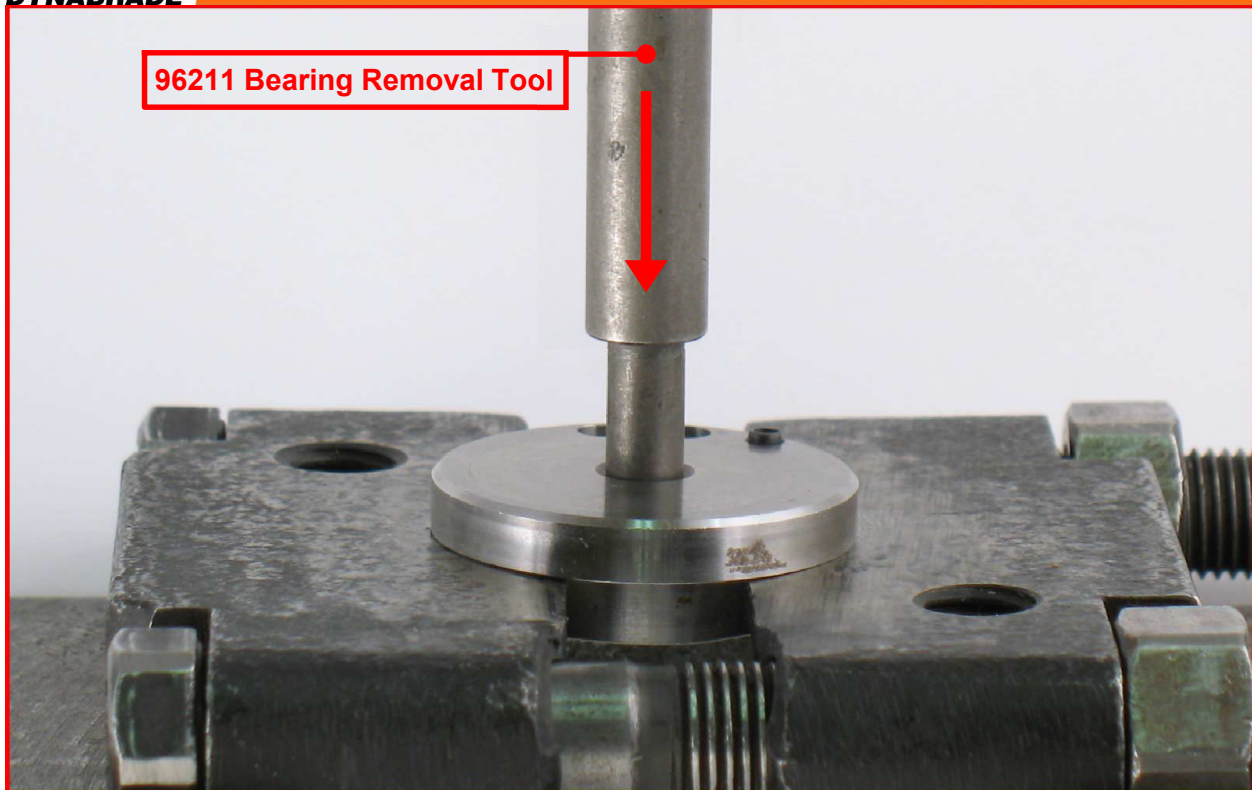
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5. Use the **96211** Bearing Removal Tool and the arbor press to remove the **01015** Bearing from the rear bearing plate.

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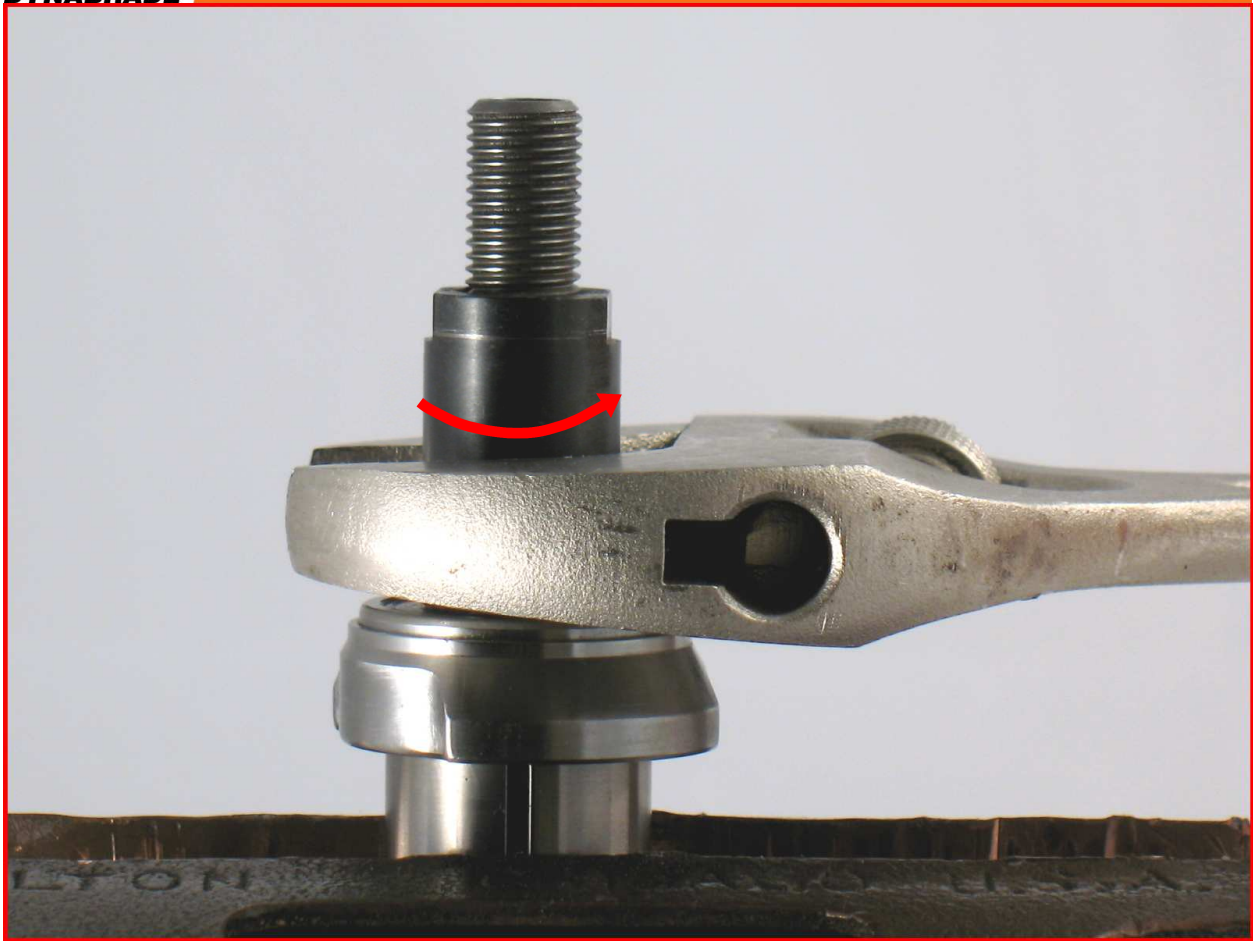
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6. Fasten the **01120** Rotor in the vise with aluminum or bronze jaws and use an adjustable wrench to remove the **04081** Rotor Nut. Turn counterclockwise.
  - Remove the **01007** Bearing, **01008** Bearing Plate, shims, and **01010** Spacer.

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**Motor Disassembly Completed.**

**Clean and inspect parts before assembling.**

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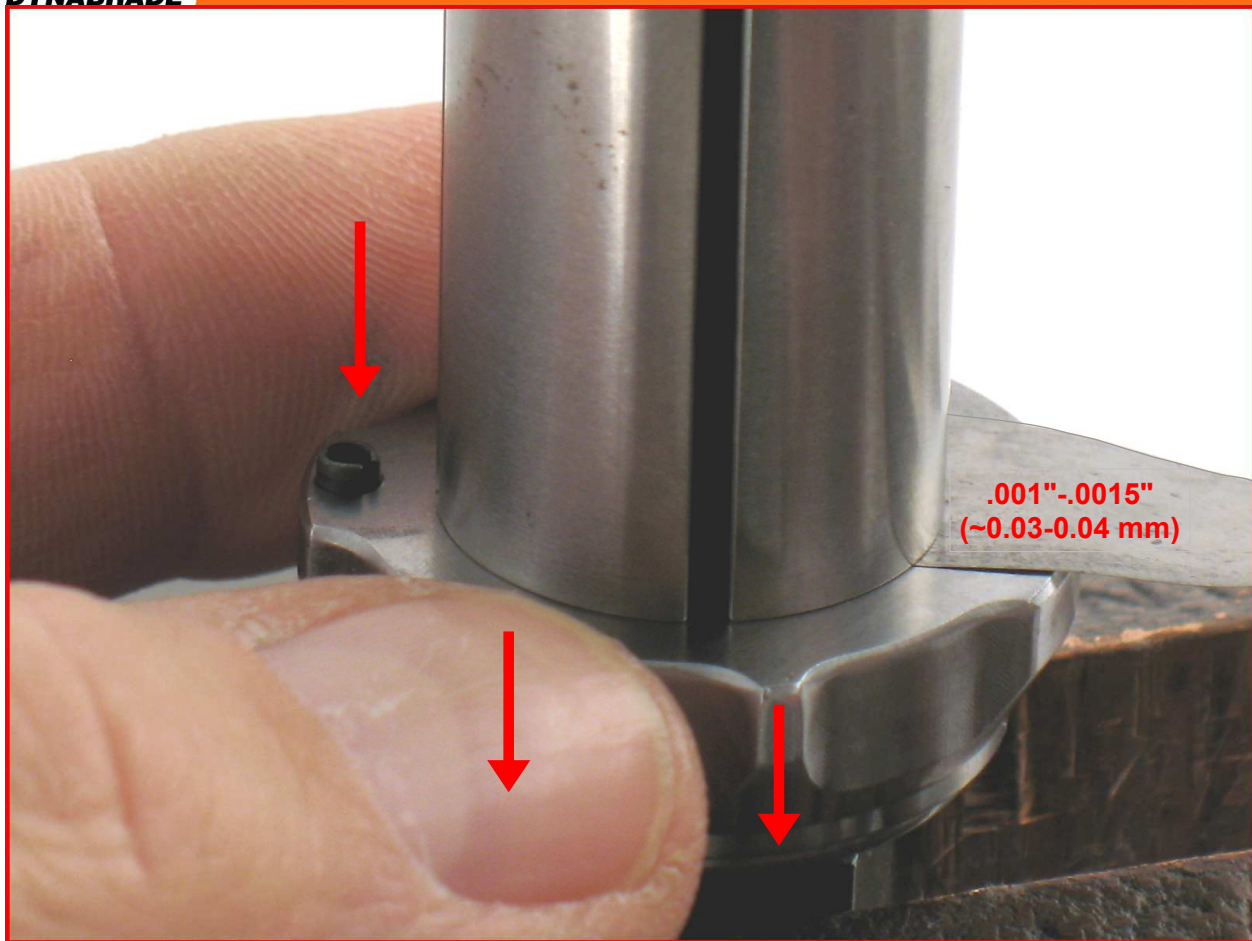
### Assembly Instructions - 0.5 hp. 14000 Dynafile

#### Motor Assembly:



1. Install the **01010** Spacer onto the rotor.
  - Install .003" (~0.80 mm) shim thickness into the **01008** Front Bearing Plate.
  - Install the **01007** Bearing into the front bearing plate.
  - Install the bearing and plate onto the rotor.





2. By hand, install the **04081** Rotor Nut. Pull the front bearing plate forward to take movement out of the bearing. Check the clearance between the rotor and plate.
  - Use a .001" (~0.03 mm) thick feeler gauge. **Notice:** The clearance should be .001"-.0015" (~0.03-0.04 mm). If the rotor/plate clearance needs adjustment, repeat steps 1 and 2. Remove or add shims as required.



## Disassembly/Assembly Instructions



3. Use a 17 mm socket or crowfoot, and a torque wrench to tighten the **04081** Rotor Nut. (T to 17 N•m/~150 in. lbs.)

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4. Apply the **95842** Dynabrade Air Lube, 10W/NR or equivalent to the **01011** Vanes and install them into the rotor.

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5. Use the **RAISED OUTSIDE DIAMETER** of the **96241** Bearing Press Tool and the arbor press to install the **01015** Bearing. **Notice:** Press the bearing all the way into the plate.

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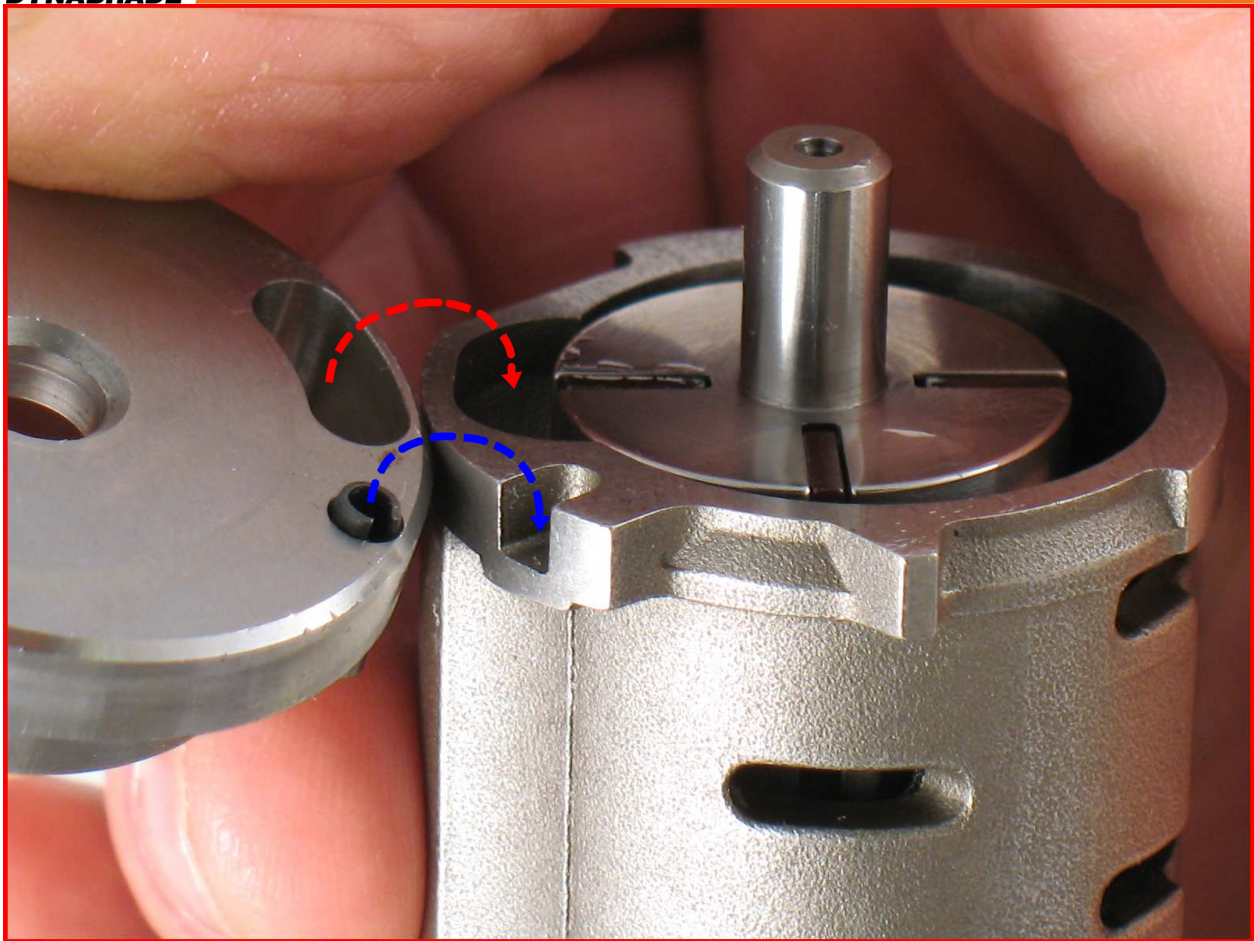
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6. Install the cylinder and the rear bearing plate so that the air inlet openings line-up with each other.

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7. Use the **RAISED INSIDE DIAMETER** of the **96241** Bearing Press Tool and the arbor press to install the bearing and plate.

**Important:** Press the bearing and plate down until the rear bearing plate just touches the 01013 Cylinder. Doing so, will produce a close fit between the bearing plates and the cylinder and establish proper preload on the motor bearings.

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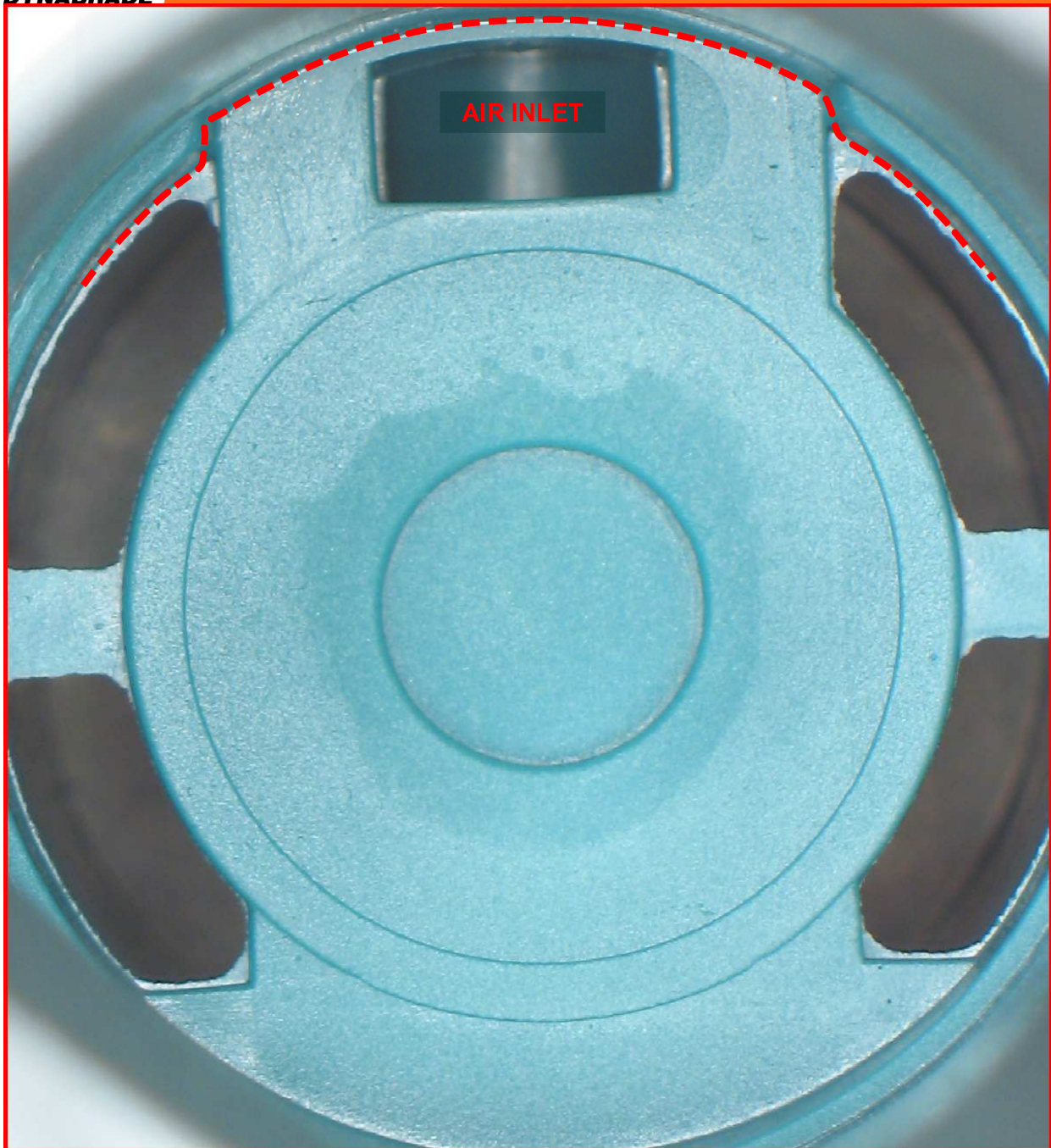
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- 8. Important:** Line-up the air inlet of the rear bearing plate with the air inlet in the housing.
- Install the motor assembly.

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9. Fasten the housing flats of the **01197** Air Motor in the vise with aluminum or bronze jaws so that the rotor spindle is pointing up.
  - Install the **04078** Felt Silencer around the **04084** Air Control Ring and install these into the **04087** Lock Ring.
  - Apply Loctite #7649 Primer to the thread of the **04087** Lock Ring.
  - Apply a small amount of Loctite #567 or equivalent to the **04087** Lock Ring.
  - Use the **50971** Lock Ring Tool and a torque wrench to install the **04087** Lock Ring.
  - T to 23 N·m/~200 in. lbs.

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10. Insert a 3/16" hex key through the **01111** Drive Wheel and into the end of the **01120** Rotor to hold it stationary.
- By hand, install the drive wheel.
- IMPORTANT: Use a tachometer to check motor speed and to verify proper operation.**
- Once the proper RPM has been verified, remove the drive wheel and install the **10295** Screen.

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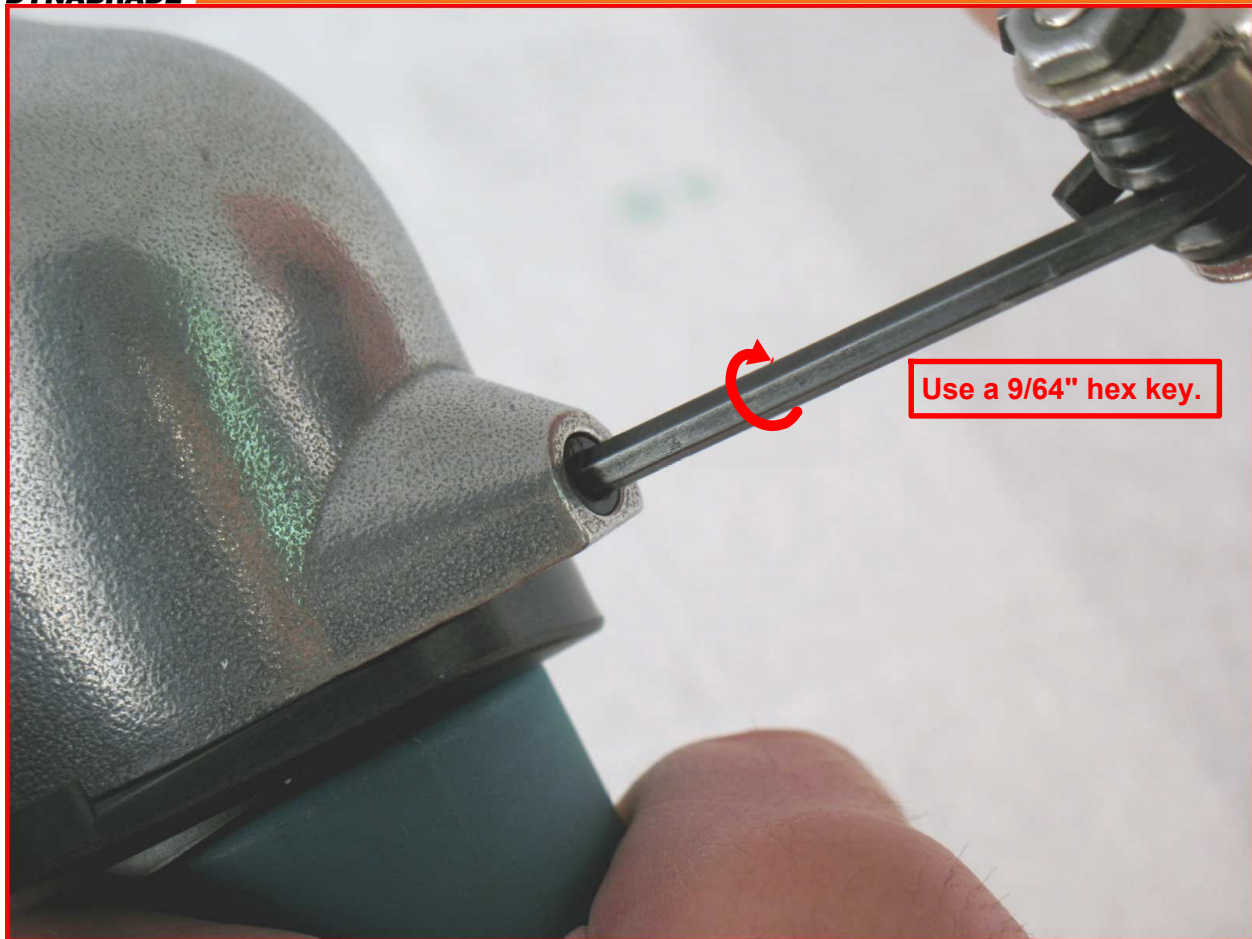
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## Disassembly/Assembly Instructions



11. Install the **11424** Wave Spring and the **11419** Cover onto the **01197** Air Motor.
- Insert the **01197** Air Motor into the **11418** Housing.
  - Use a 9/64" hex key to fasten the motor with the **95311** Screw and **40029** Cam Lock.
- Motor Assembly Completed.**

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

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