

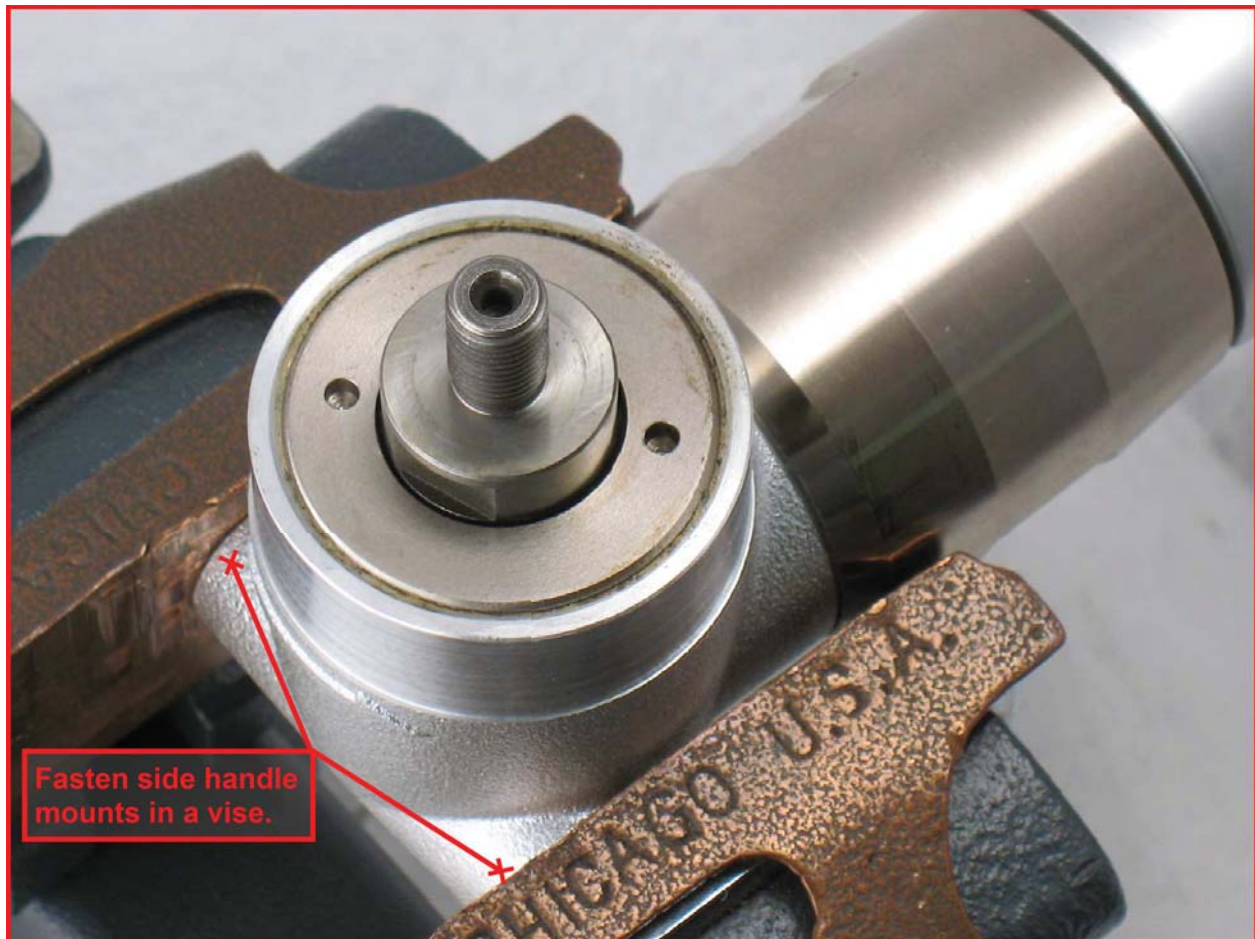
Disassembly Instructions - 1 hp. Right Angle Gears

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

Notice: To avoid damage to the motor housing, use the Special Repair Tools designed for the disassembly and assembly of this motor.

Disconnect the tool from the air supply. Use the appropriate wrenches to hold the work spindle stationary and remove the accessory. If necessary, remove guards or shrouds.

Right Angle Gear Disassembly:



1. Fasten the side handle mounts on the **53600** Right Angle Housing, in a vise with aluminum or bronze jaws, so that the work spindle is pointing up.

Visit Our Website: www.dynabrade.com

Email: 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. Use the **97782 Pin Wrench** or an adjustable pin spanner to remove the **50963 Retainer**.
Left Hand Thread - Turn counterclockwise.

Visit Our Website: www.dynabrade.com

Email: 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



3. Pull the spindle, bearing and gear assembly out of the housing.
 - Remove the seal,
 - Shims,
 - lubricant wick.

Visit Our Website: www.dynabrade.com

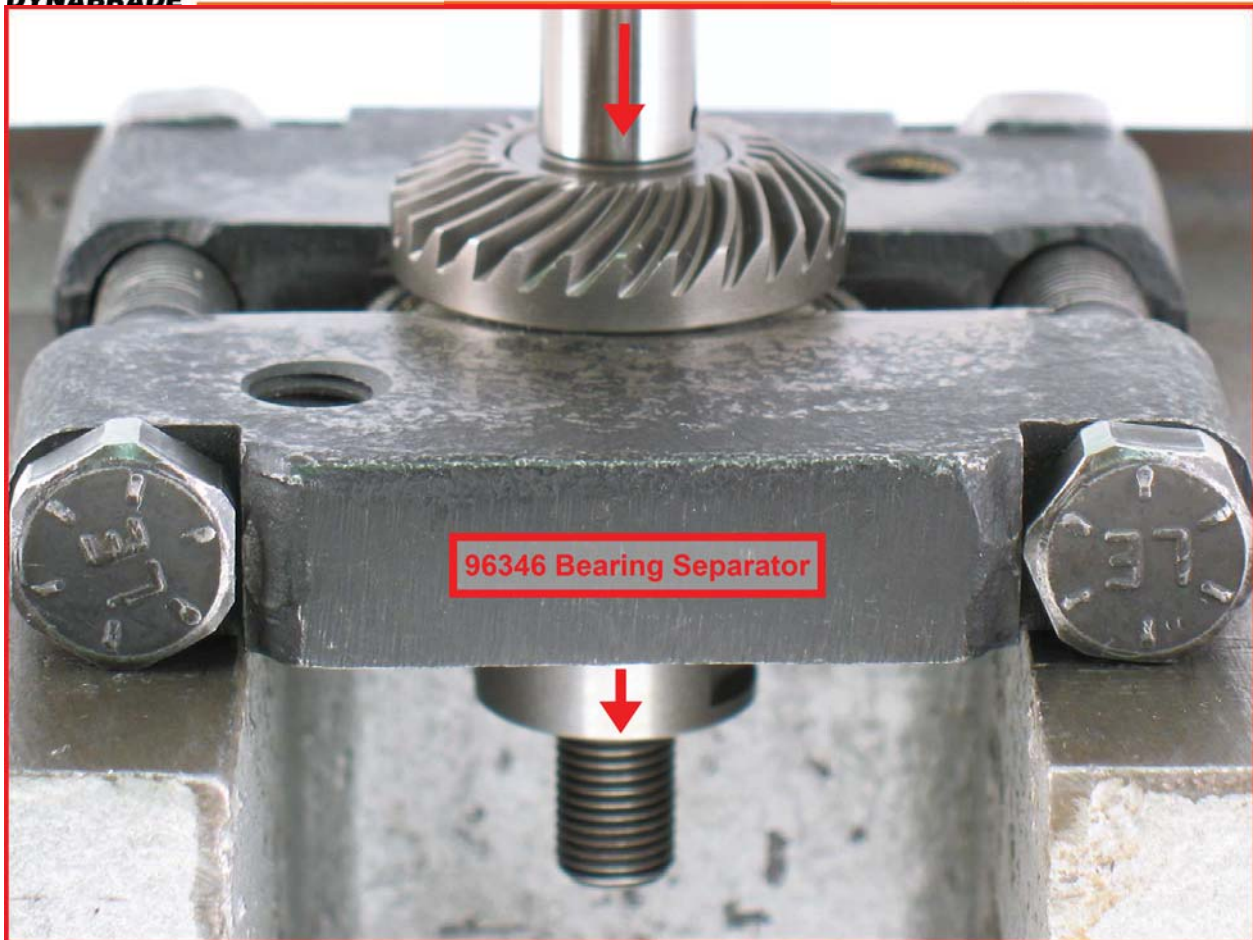
Email: customer.service@dynabrade.com

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

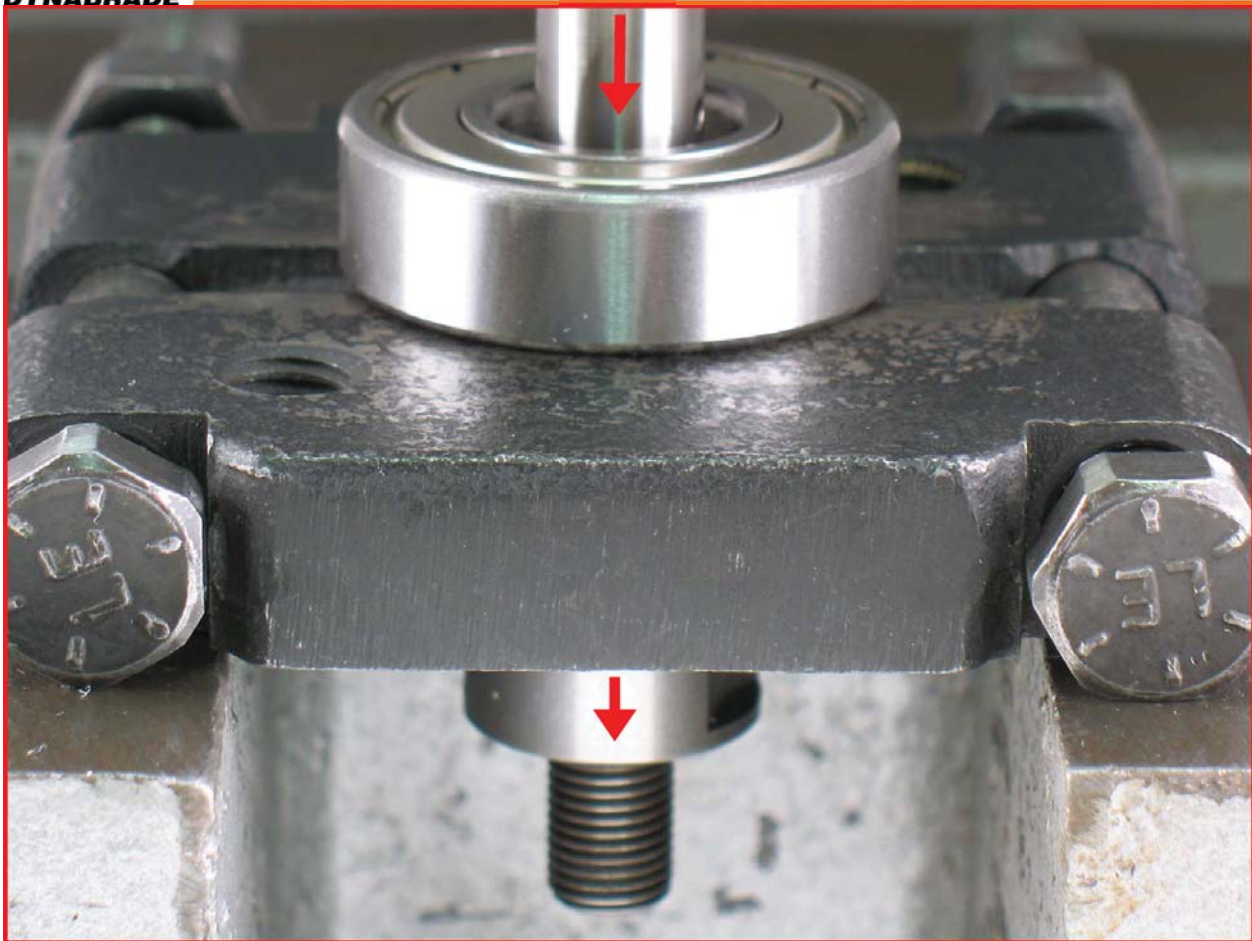
DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



4. Fasten the **96346** Bearing Separator (2") between **97679** Bearing and spiral bevel gear. Place the bearing separator along with the spindle, bearing and gear assembly on the table of the **96232** Arbor Press (#2) so that the spindle thread is pointing down.
 - Remove the gear from the spindle.



Disassembly/Assembly Instructions



- Remove the **97679** Bearing.

Visit Our Website: www.dynabrade.com

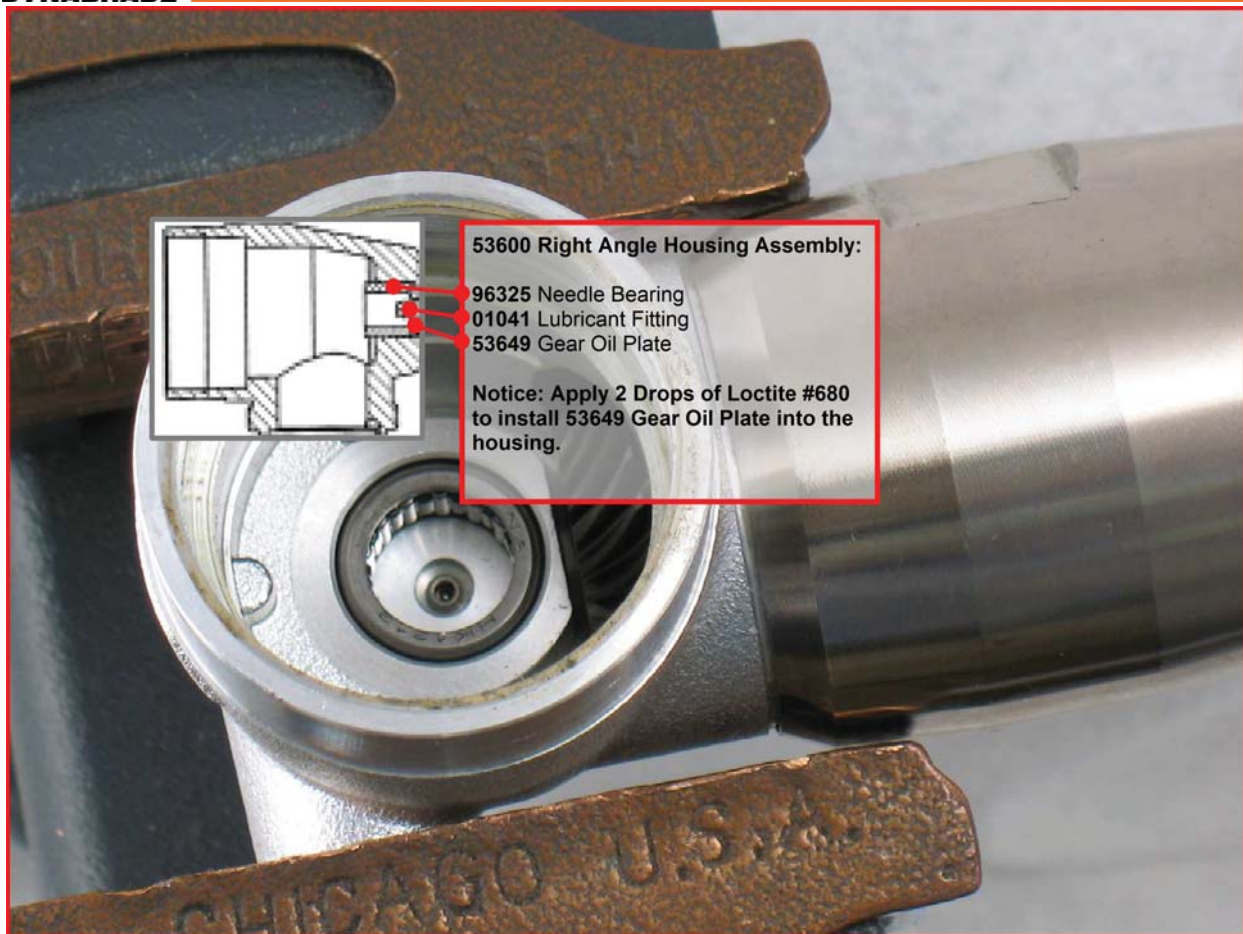
Email: customer.service@dynabrade.com

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. Notice:** The **96325** Needle Bearing rarely requires replacement. Only remove the **96325** Bearing, and the **53649** Gear Oil Plate when the bearing needs to be replaced.
 - Follow the instructions contained in the tool parts page or manual.

Visit Our Website: www.dynabrade.com

Email: 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



6. Use a HEAT GUN to warm the **53650** Lock Ring and soften the thread sealant.
 - Use a 45 mm ($\sim 1\text{-}^{25}/_{32}$ ") crowfoot or an adjustable wrench to remove the lock ring.
Left Hand Thread Turn clockwise.

Visit Our Website: www.dynabrade.com

Email: 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. Remove the **53651** Spacer.

- Remove the pinion gear, bearing and coupler from the housing.

Visit Our Website: www.dynabrade.com

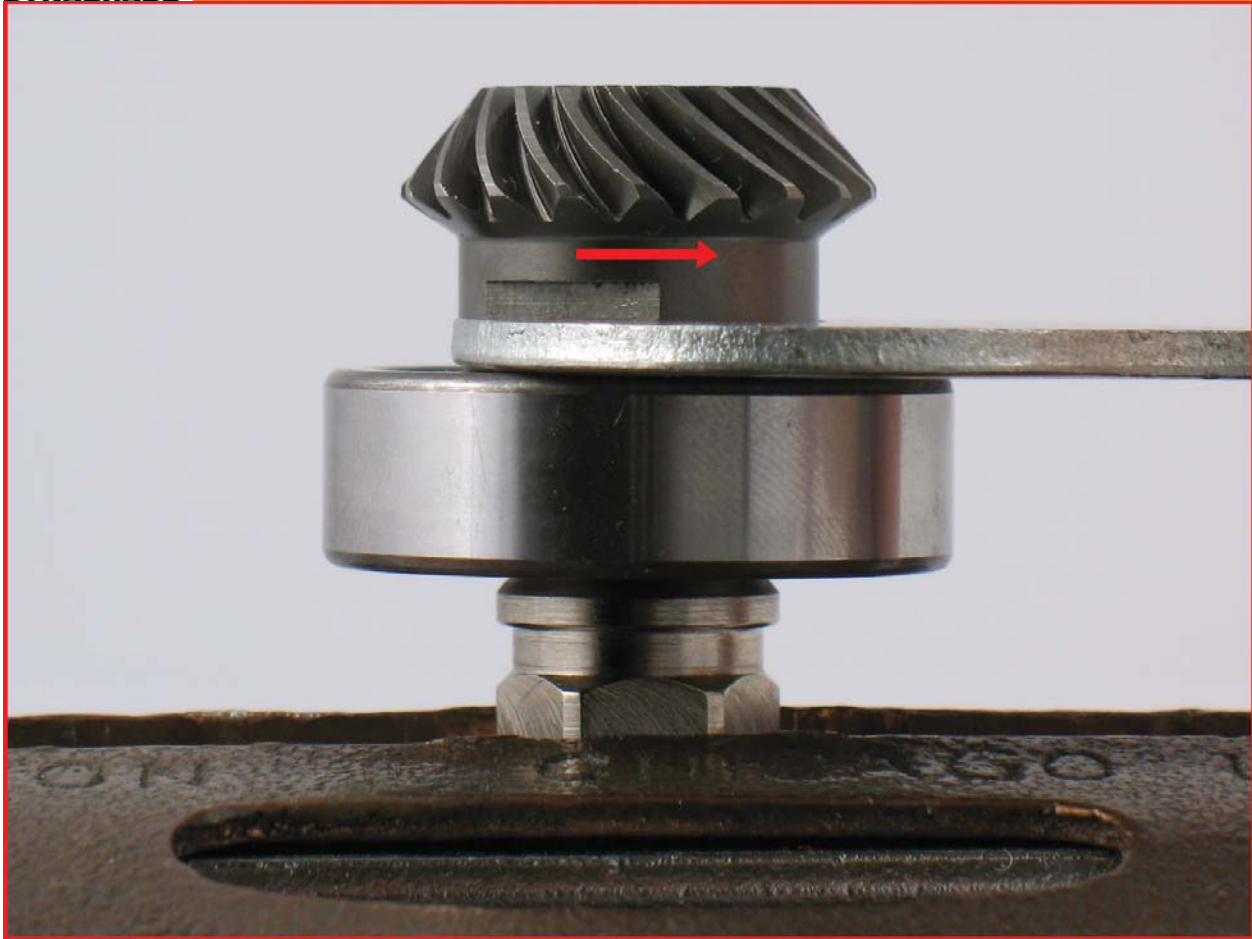
Email: customer.service@dynabrade.com

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



8. Fasten the **51969** Coupler Nut in the vise with aluminum or bronze jaws so that the pinion gear is pointing up. Use a 17 mm wrench to remove the pinion gear. Turn counterclockwise.

Visit Our Website: www.dynabrade.com

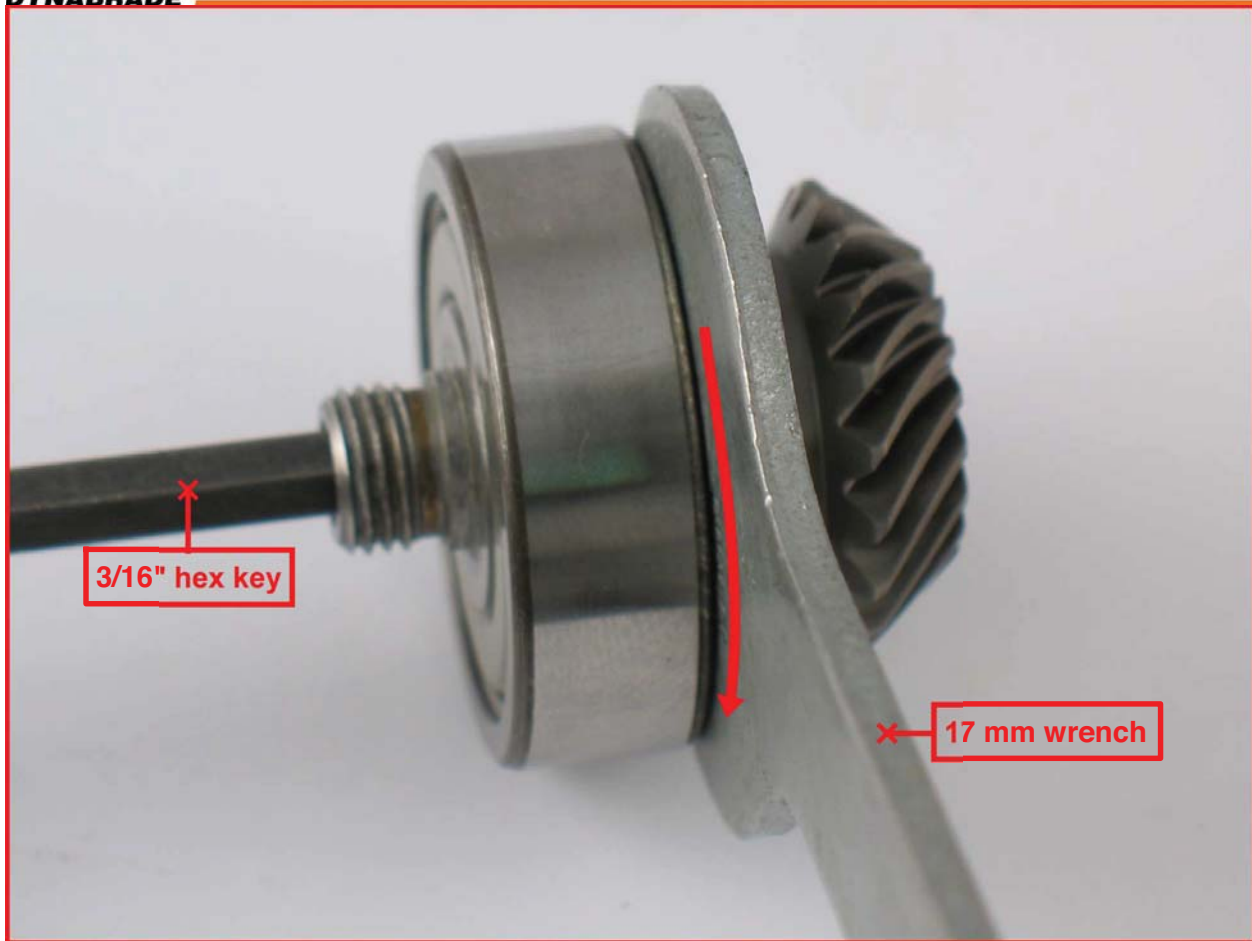
Email: customer.service@dynabrade.com

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

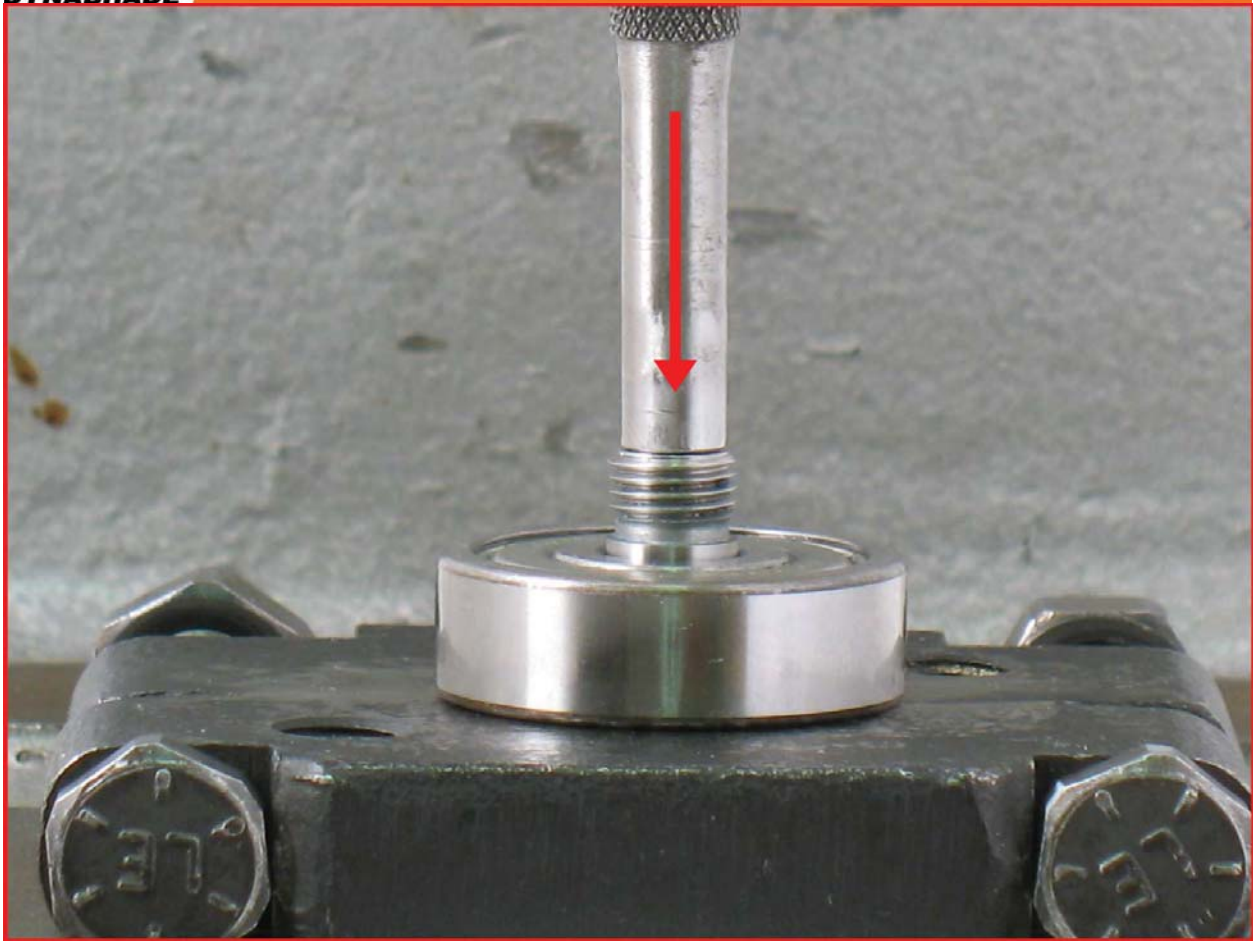
DYNABRADE INDIA ABRASIVE POWER TOOLS Pvt Ltd.
EL-54, TTC Industrial Area, M.I.D.C. Mahape, Electronic Zone, Navi Mumbai - 400705
Maharashtra, India • Telephone: +91 22 2763 2226 • Fax: +91 22 2763 2228



9. Use a 3/16" hex key to hold the **53635** Pinion Adapter stationary. Use the 17 mm wrench to remove pinion gear. Turn counterclockwise.



Disassembly/Assembly Instructions



10. Use the arbor press to push the **53635** Pinion Adapter from the **01266** Bearing.

Right Angle Gear Disassembly Completed.

Clean and inspect parts before assembly.

Visit Our Website: www.dynabrade.com

Email: 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 - 1 hp. Right Angle Gears

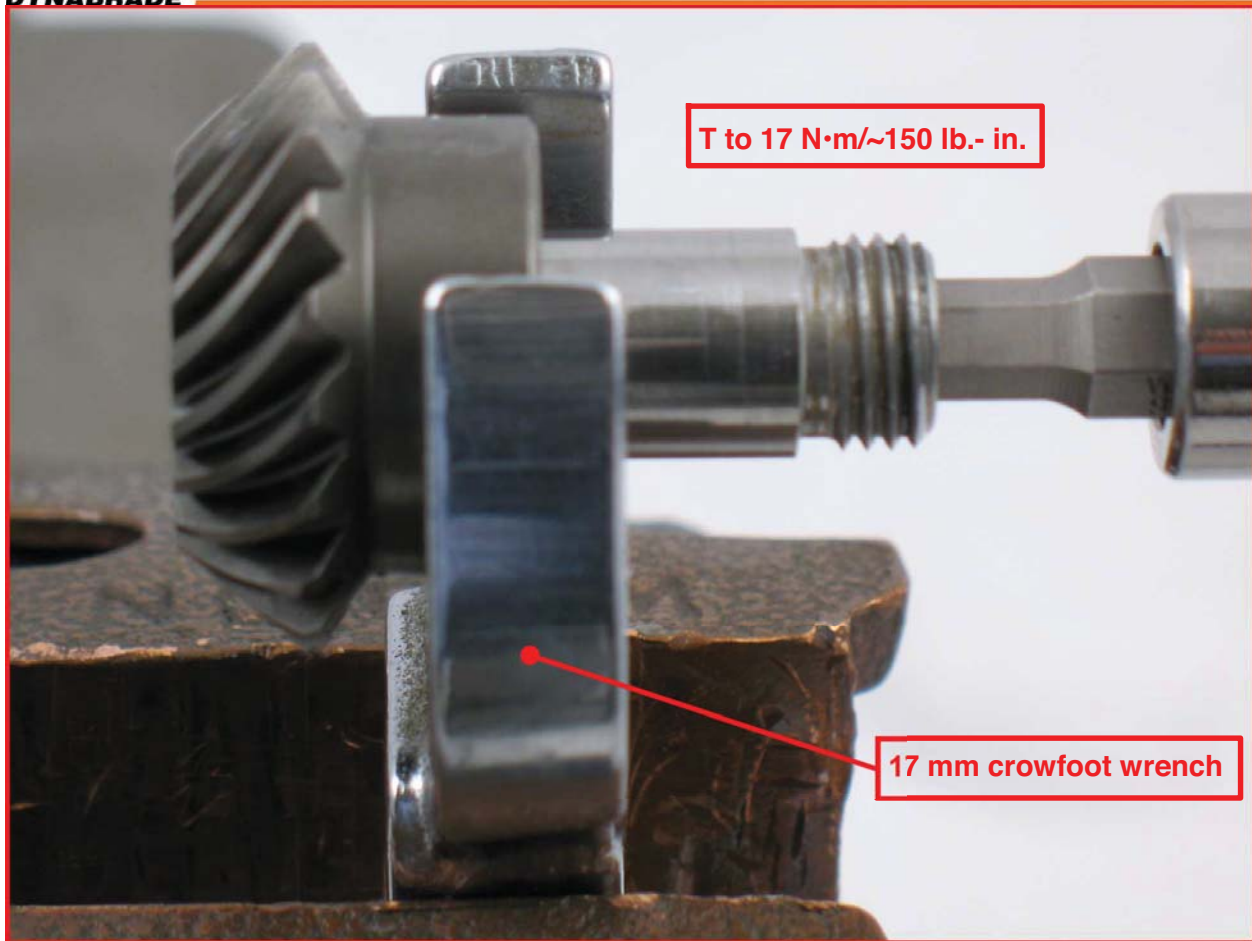
Right Angle Gear Assembly:



1. Identify the end of the **53635** Adapter without the 3/16" hex. Apply a small amount of Loctite #243 or equivalent to the thread on that end.



Disassembly/Assembly Instructions



- Use a 17 mm wrench, a 3/16" hex key bit and torque wrench to fasten the **53635** Adapter to the pinion gear. (T to 17 N·m/~150 lb.- in.)

Visit Our Website: www.dynabrade.com

Email: 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. Position the pinion gear on the table of the **96232** Arbor Press (#2) with the **53635** Adapter pointing up.
 - Use the **RAISED INSIDE DIAMETER** of the **96239** Bearing Press Tool to install the **01266** Bearing.

Visit Our Website: www.dynabrade.com

Email: 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



3. Apply a small amount of Loctite #243 or equivalent to the thread of the adapter.

Visit Our Website: www.dynabrade.com

Email: 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



- Use an adjustable wrench, a 3/16" hex key and torque wrench to install the **51969** Coupling. T to 17 N•m/~150 in. lbs.

Visit Our Website: www.dynabrade.com

Email: 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. Install the pinion gear assembly into the 53600 Right Angle Housing.

Visit Our Website: www.dynabrade.com

Email: 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



- Install the longer-end of the **53651** Spacer into the **53600** Right Angle Housing.
- Apply Loctite Primer #7649 or equivalent to threads of the **53600** Right Angle Housing.
- Apply a small amount of Loctite #567 or equivalent to threads of the right angle housing.

Visit Our Website: www.dynabrade.com

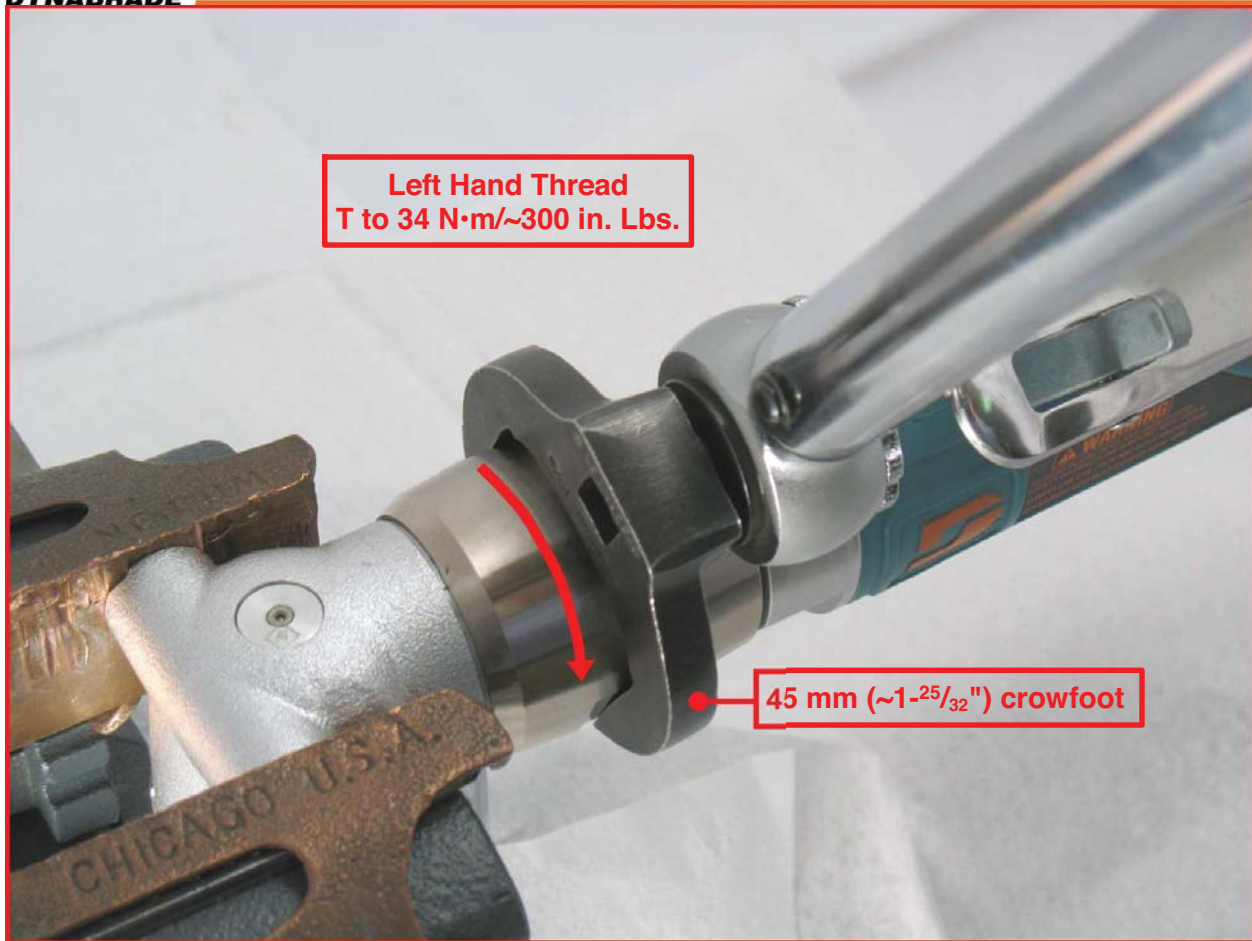
Email: customer.service@dynabrade.com

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. Install the **53650** Lock Ring along with the motor assembly onto the **53600** Right Angle Housing. **Left Hand Threads** Turn counterclockwise. **Notice:** Carefully join the **51969** Couplings and **50902** Coupling Insert, using the right hand and left hand thread connections.
 - With assemblies properly aligned, locate the throttle lever to the desired position.
 - Use a 45 mm (~1-25/32") crowfoot to tighten the lock ring. Turn counterclockwise. **T** to 34 N·m/~300 in. Lbs.



Disassembly/Assembly Instructions



6. Position the spindle in and the arbor press so that the threaded end is pointing down.
 - Use a 11/16" or 18 mm deep well socket as a press tool to install the **97679** Bearing onto the spindle. Push it all the way down against the step.

Visit Our Website: www.dynabrade.com

Email: 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



- Use a 11/16" or 18 mm deep well socket as a press tool to install the bevel gear onto the spindle. Push it all the way down against the bearing.

Visit Our Website: www.dynabrade.com

Email: 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



7. Soak the **53608** Wick in the **95848** Gear Oil and install the wick into the right angle housing with the flat edge towards pinion gear.

Visit Our Website: www.dynabrade.com

Email: 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



8. Install the **53609** Felt Seal onto the spindle and gear assembly.
Notice: Do not install shims at this point.

Visit Our Website: www.dynabrade.com

Email: 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



9. Apply downward force on the spindle and rotate the spindle forwards and backwards to check the amount of backlash or free movement between the gear teeth. There should be a minimal amount of free movement between the teeth.
- By hand, use the **97782** Pin Wrench or an adjustable pin wrench to fasten the **50963** Retainer into the housing. **LEFT HAND THREAD** Turn counterclockwise.
 - Check rotation of the spindle and gear assembly 360°. The correct fit should have minimal backlash without any restricted movement between the gear teeth.
 - Add or remove shims to adjust the correct gear fit (amount of backlash).

Visit Our Website: www.dynabrade.com

Email: 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



10. Use the 97782 Pin Wrench and torque wrench to fasten 50963 Retainer. **Left Hand Thread**
Turn counterclockwise. (T to 34 N·m/~300 in. lbs.)
Right Angle Gear Assembly Completed.

Initially, use the 95541 Lubricant Gun to apply two plunges of the 95848 Gear Oil through the 01041 Lubricant Fitting. Continue to apply two plunges of gear oil after every eight hours of use.

Refer to the tool parts page or manual and follow directions for checking RPM before installing any accessories.

- If necessary, install guards or shrouds.
- Use the appropriate wrenches to hold the work spindle stationary to install accessories.