



## Disassembly/Assembly Instructions

### Assembly Instructions - 0.4 hp. 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



## Disassembly/Assembly Instructions



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.

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.**

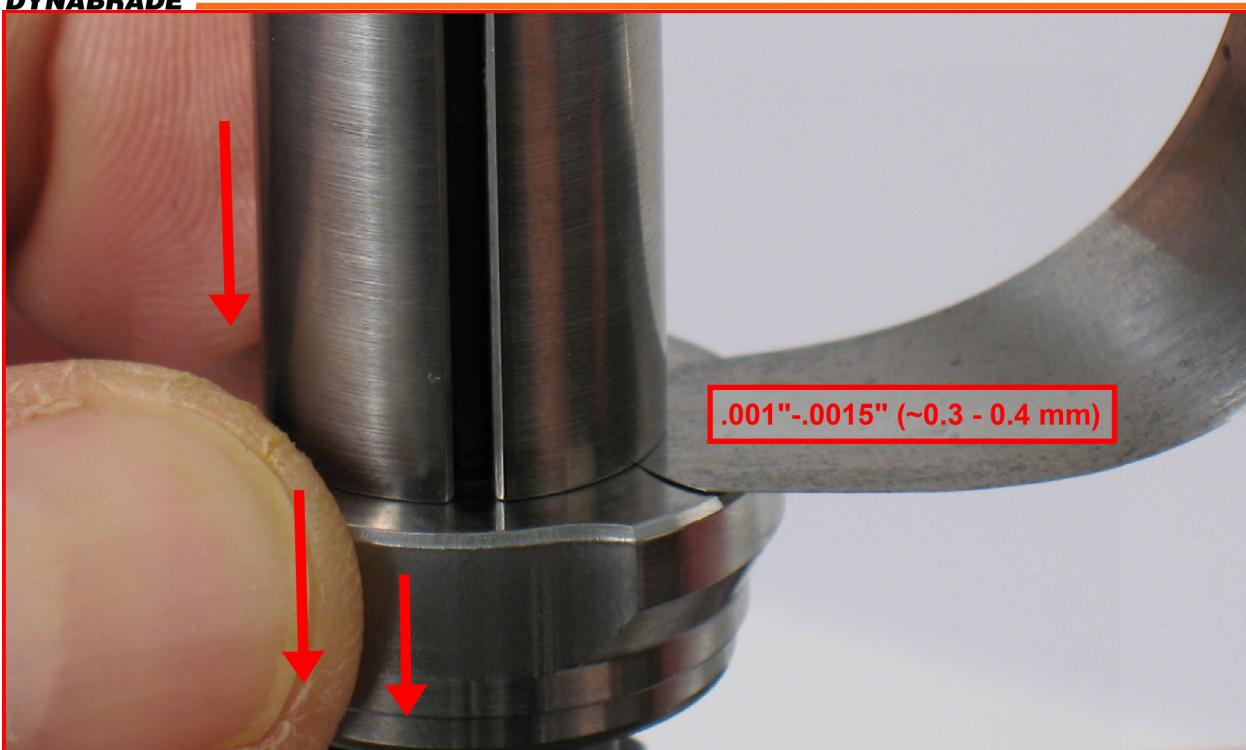
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**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



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.

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.**

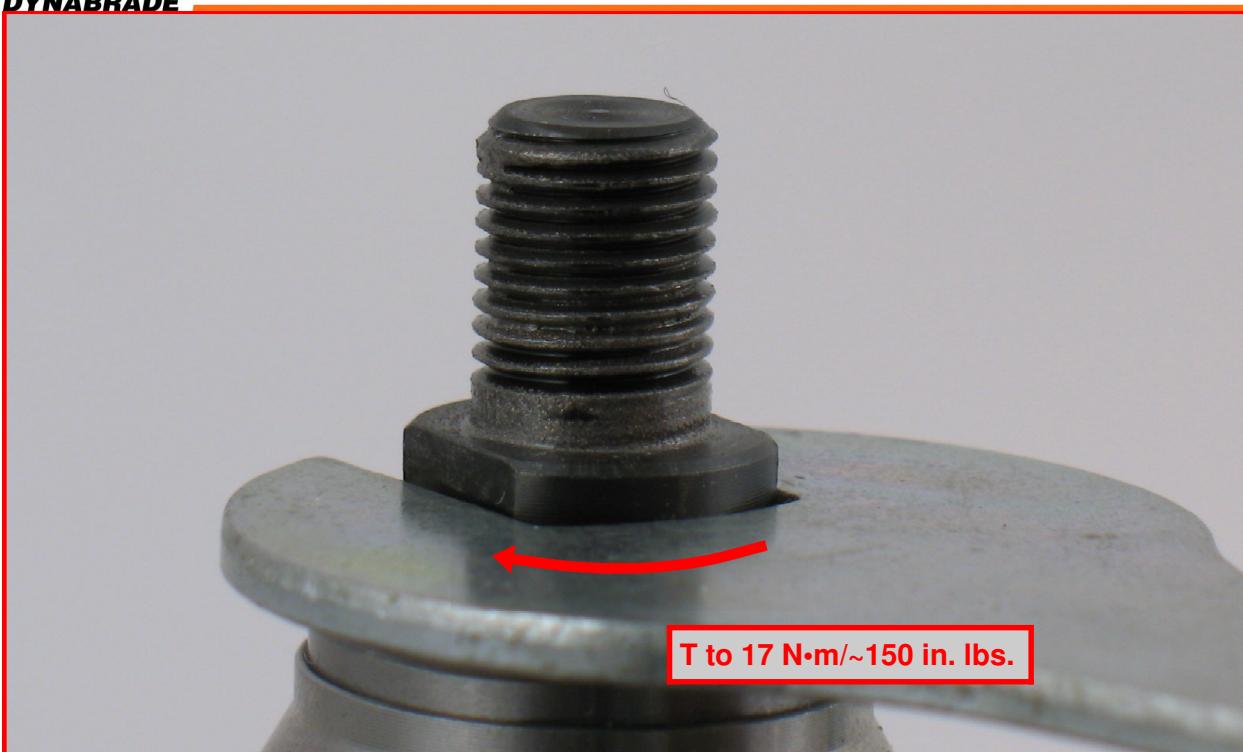
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**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



4. Once the correct clearance is achieved, fasten rotor in vise and tighten the **04117** Adapter.
  - 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



## Disassembly/Assembly Instructions



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



## Disassembly/Assembly Instructions



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.**

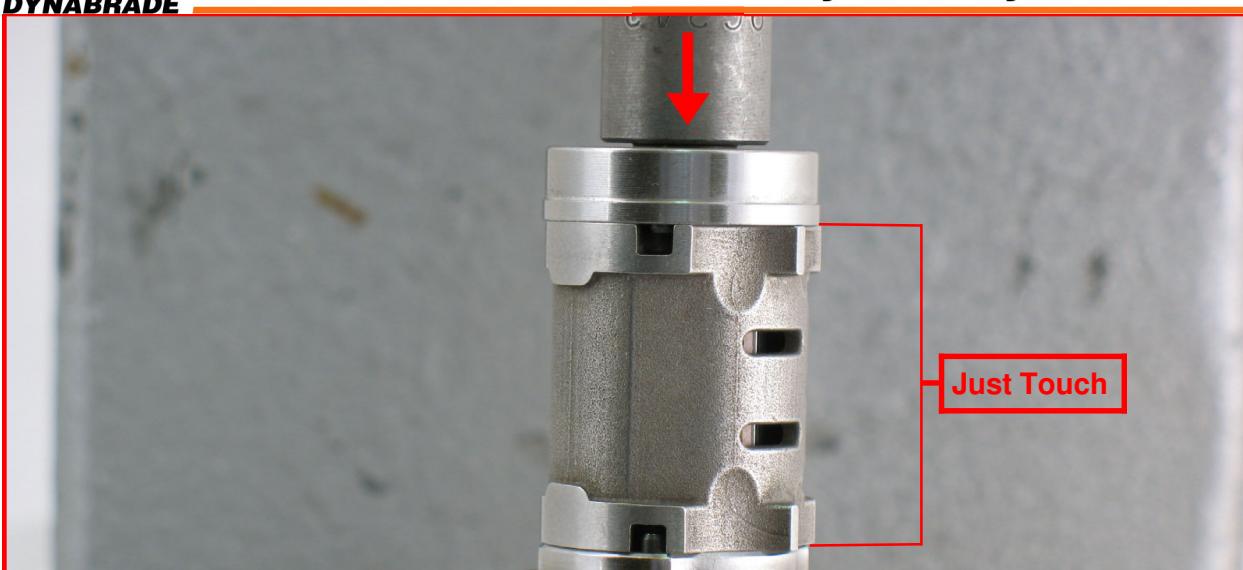
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**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



## 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.

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



### 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 **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.**

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.**

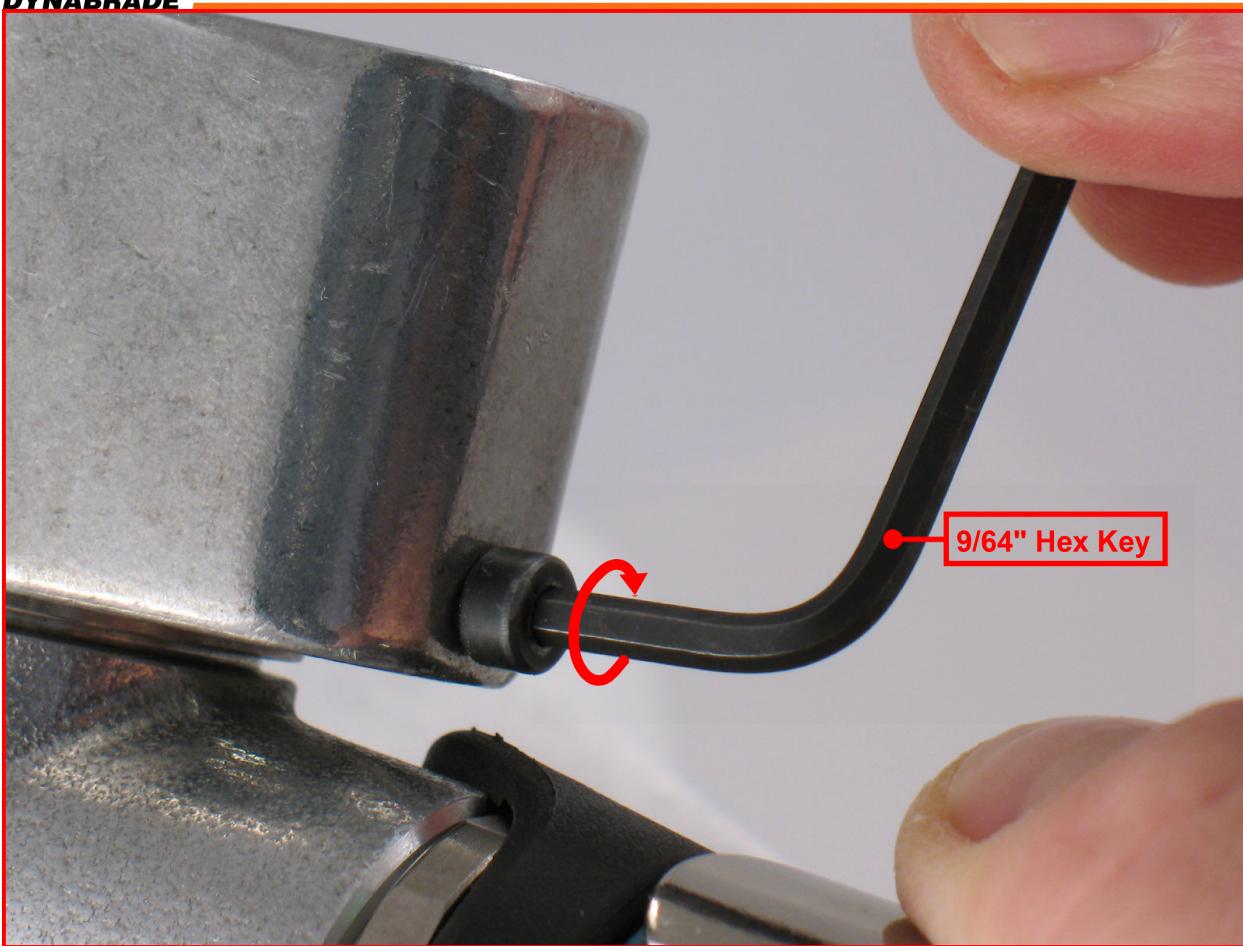
Zone Artisanale, L-5485 Wormeldange—Haut, Luxembourg  
Telephone: +352 768 494 1 • Fax: +352 768 495

**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



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.

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