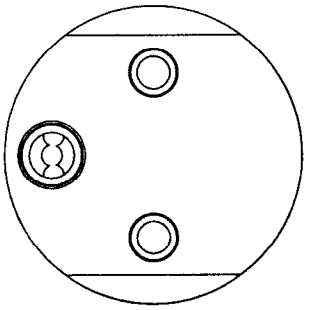
ARO Tool Products

SALES AND ENGINEERING DATA

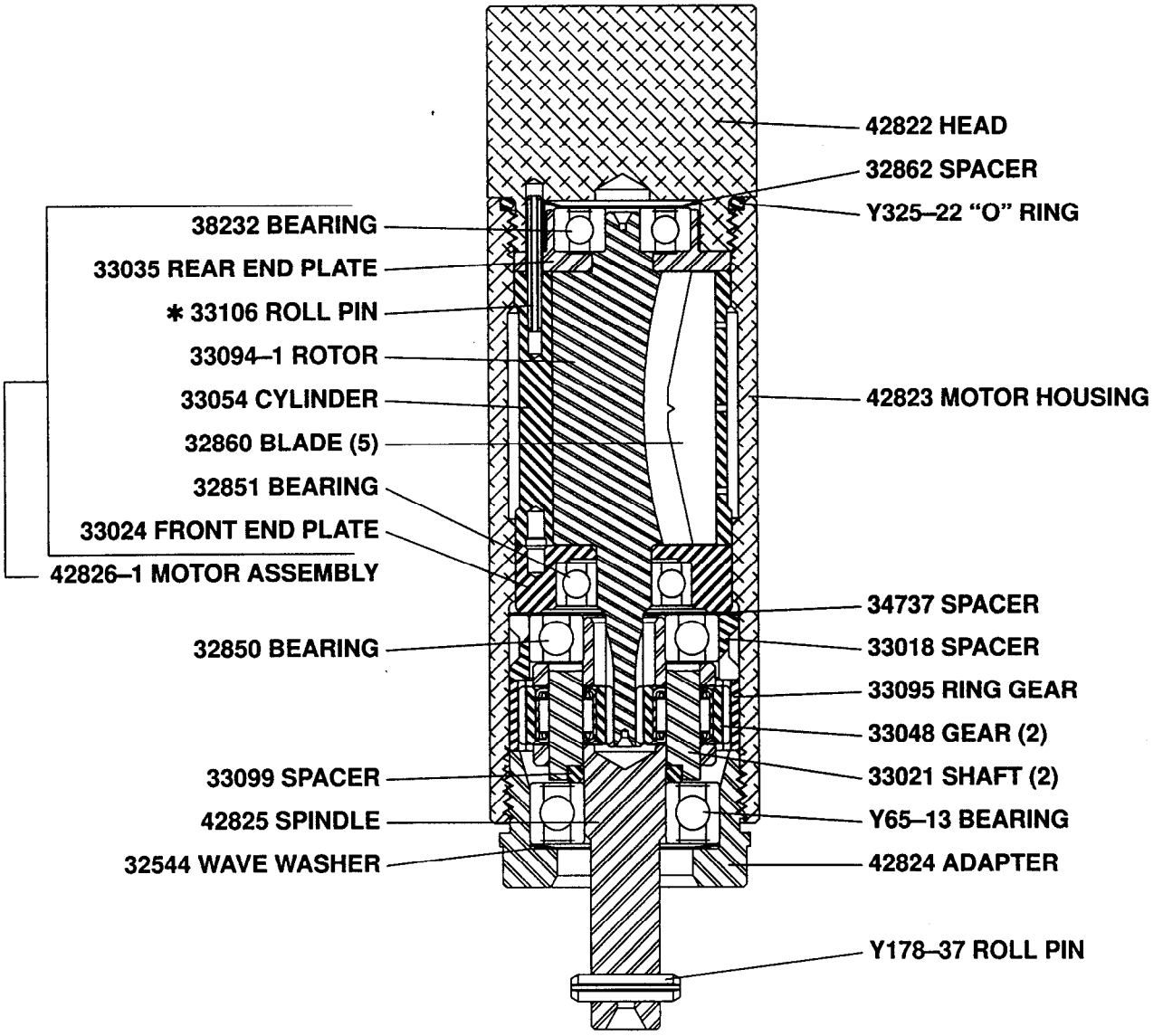
"OOO" SERIES POWER MOTOR
MODEL 8469–A
1,500 R.P.M.

FORM: 5666

DATE: 11–10–95



* INCLUDED WITH 33054 CYLINDER



For parts and service information, contact your local ARO distributor, or the Customer Service Dept. of the Ingersoll–Rand Distribution Center, White House, TN at PH: (615) 672–0321, FAX: (615) 672–0801.

ARO Tool Products

Ingersoll–Rand Company
1725 U.S. No. 1 North • P.O. Box 8000 • Southern Pines, NC 28388–8000

AIR AND LUBE REQUIREMENTS

Air pressure of 90 p.s.i.g. (6 bar) at the air inlet of the tool is required for maximum motor efficiency. If necessary, an air regulator should be installed to maintain this air pressure when the tool is in operation.

Filtered and oiled air will allow the tool to operate more efficiently and yield a longer life to operating parts and mechanisms. A line filter capable of filtering particles larger than 50 microns should be used with a line oiler.

Filter–Regulator–Lubricator (F–R–L) assembly model C28231–810 is recommended for use with this air tool. The capacity of this F–R–L is adequate to provide clean (40 micron) oiled and regulated air for the tool.

Flush tool with a solution of three parts cleaning solvent and one part light oil after each 40 hours of operation. After flushing, apply a small amount of spindle oil in air inlet and run free for one minute to insure proper lubrication.

Recommended hose size – 5/16" (8 mm) nominal inside diameter.

Recommended lubricants: spindle oil 29665, 1 qt. (.9 liter) container for oiler and air inlet; grease 33153, 5 lb. (2.3 kg) can for gears and bearings, "O" ring lubricant 36460, 4 oz. (113 g) tube for lubrication and installation of "O" rings.

MAINTENANCE

Disconnect air supply from tool or shut off air supply line to tool and exhaust (drain) air line to tool of compressed air before performing service or maintenance to tool.

Air tools are made of precision parts and should be handled with reasonable care when servicing. Excessive pressure exerted by a holding device may cause distortion of a part. Apply pressure evenly when disassembling (or assembling) parts which have a press fit. When removing or installing bearings, apply pressure to the bearing race that will be press fit to the mating part; if this is not practiced, Brinelling of the bearing races will occur, making replacement necessary. It is important that the correct tools and fixtures are used when servicing this air tool.

Disassembly should be done on a clean work bench with a clean cloth spread to prevent the loss of small parts. After disassembly is completed, all parts should be thoroughly washed in a clean solvent, blown dry with air and inspected for wear levels, abuse and contamination.

Double sealed or shielded bearings should never be placed in solvent unless a good method of relubricating the bearing is available. Open bearings may be washed but should not be allowed to spin while being blown dry. When replacement parts are necessary, consult drawing containing the part for identification.

Before reassembling, lubricate parts where required. Use 33153 grease, or equivalent, in bearings. Use 36460 lubricant for "O" ring assembly. When assembling "O" rings, care must be exercised to prevent damage to the rubber sealing surfaces. A small amount of grease will usually hold steel balls and other small parts in place while assembling.

When ordering parts, be sure to list **part number, part name, model number** and **serial number of tool.** Use only genuine ARO® replacement parts

DISASSEMBLY AND ASSEMBLY OF TOOLS

DISASSEMBLY

GEARING – Remove adapter (42824) and pull gearing from housing. Remove bearing (32850) and shafts (33021) to remove gears (33048). To remove bearing (Y65–13), insert shafts in spindle and alternately tap shafts to loosen bearing and spacer.

MOTOR – The motor assembly may be removed by first removing gearing or by removing head. Grasp cylinder in one hand and tap splined end of rotor with a soft face hammer; motor will come apart.

ASSEMBLY

MOTOR – Pack bearings with ARO 33153 grease and assemble bearing (38232) into end plate (33035) with shielded side out. NOTE: Press on outer race of bearing. Assemble end plate (33035) to rotor, pressing on inner race of bearing. Assemble cylinder (33054) over rotor to end plate, aligning pin (33106) with hole in end plate. Assemble blades to rotor – straight side out. Assemble bearing (32851) to end plate (33024), pressing on outer race of bearing. Assemble end plate (33024) to rotor, pressing on inner race of bearing. Be sure motor does not bind. Assemble motor, with spacer (32862), to head and housing with pin (33106) aligned to proper hole in head (small hole). Assemble spacers (34737 and 33018) and gearing to housing.

GEARING – Assemble spacer (33099) and bearing (Y65–13) to spindle. Assemble gears (33048) to spindle and secure with shafts (33021). Align notch in shafts with spacer. Assemble bearing (32850) to spindle. Assemble ring gear (33095) to gears and assemble gearing to housing. Assemble wave washer (32544) to adapter and assemble adapter to housing, securing gearing. NOTE: Lubricate gearing using approximately 1/16 oz. of grease upon assembly.