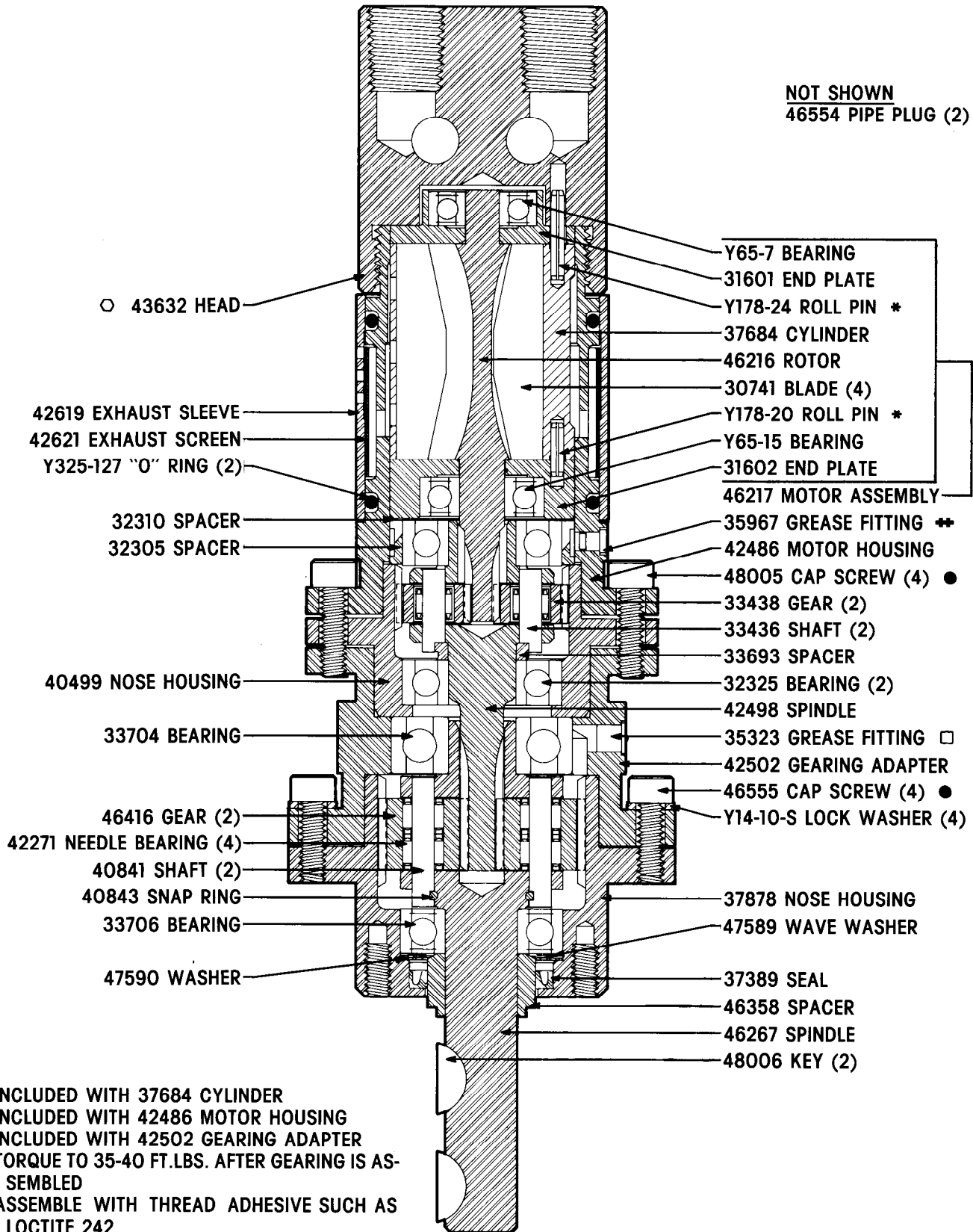


PARTS LIST

MODEL 7954 (EP2681-L1)
O/2200 SERIES POWER MOTOR
REVERSIBLE

FORM 3208-2

10-30-87



NOT SHOWN
46554 PIPE PLUG (2)

- 43632 HEAD
- 42619 EXHAUST SLEEVE
- 42621 EXHAUST SCREEN
- Y325-127 "O" RING (2)
- 32310 SPACER
- 32305 SPACER
- 40499 NOSE HOUSING
- 33704 BEARING
- 46416 GEAR (2)
- 42271 NEEDLE BEARING (4)
- 40841 SHAFT (2)
- 40843 SNAP RING
- 33706 BEARING
- 47590 WASHER
- Y65-7 BEARING
- 31601 END PLATE
- Y178-24 ROLL PIN *
- 37684 CYLINDER
- 46216 ROTOR
- 30741 BLADE (4)
- Y178-20 ROLL PIN *
- Y65-15 BEARING
- 31602 END PLATE
- 46217 MOTOR ASSEMBLY
- 35967 GREASE FITTING **
- 42486 MOTOR HOUSING
- 48005 CAP SCREW (4) ●
- 33438 GEAR (2)
- 33436 SHAFT (2)
- 33693 SPACER
- 32325 BEARING (2)
- 42498 SPINDLE
- 35323 GREASE FITTING □
- 42502 GEARING ADAPTER
- 46555 CAP SCREW (4) ●
- Y14-10-S LOCK WASHER (4)
- 37878 NOSE HOUSING
- 47589 WAVE WASHER
- 37389 SEAL
- 46358 SPACER
- 46267 SPINDLE
- 48006 KEY (2)

- * INCLUDED WITH 37684 CYLINDER
- ** INCLUDED WITH 42486 MOTOR HOUSING
- INCLUDED WITH 42502 GEARING ADAPTER
- TORQUE TO 35-40 FT.LBS. AFTER GEARING IS ASSEMBLED
- ASSEMBLE WITH THREAD ADHESIVE SUCH AS LOCTITE 242



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 pressure when 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 128231-800 is recommended for use with this Air Tool. The capacity of the individual Filter-Lubricator 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" (8mm) 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 the press fit to the mating part; if this is not practiced, Brinelling of the bearing races may 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 complete; 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 re-lubricating 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 REASSEMBLY OF TOOLS

DISASSEMBLY

DRIVE GEARING — Remove accessory and keys from spindle. Remove cap screws (46555) and washers (Y14-10-S) releasing drive gearing from auxiliary gearing. Tap drive end of spindle with a soft-faced hammer; spindle and components will loosen from nose housing (37878). NOTE: Do not disassemble further unless damage is evident. To disassemble, remove bearing (33706) and rotate snap ring to allow removal of shafts. Remove shaft (40841) releasing gear (46416). Repeat for removal of opposite shaft and gear.

AUXILIARY GEARING — Remove drive gearing. Remove cap screws (48005) releasing gearing. Tap drive end of spindle with a soft-faced hammer; spindle and components will loosen from nose housing (40499). NOTE: Do not disassemble further unless damage is evident. To disassemble, remove spacer (33693) and bearing. Remove shafts releasing gears. Place shafts in spindle and alternately tap ends of shafts to loosen bearing from spindle.

MOTOR — Remove gearing. Place flats of head in a suitable holding device. Unthread and remove motor housing. Remove motor assembly from housing. Grasp cylinder in one hand and tap splined end of rotor with a soft-faced hammer; motor will come apart.

HEAD — To remove "O" rings (Y325-127) or screen (42621), remove head and sleeve (42619).

REASSEMBLY

HEAD — Grease and assemble "O" rings to motor housing. Assemble screen (42621) to housing, securing with sleeve (42619).

MOTOR — Assemble bearing (Y65-7) to end plate (31601) pressing

on outer race of bearing. Assemble end plate to rotor pressing on inner race of bearing. Coat blades with spindle oil and assemble to rotor slots — straight side out. Coat i.d. of cylinder with spindle oil and assemble to end plate (31601) aligning roll pin (Y178-24) with hole in end plate. Assemble bearing (Y65-15) to end plate (31602) pressing on outer race of bearing. Assemble end plate to cylinder pressing on inner race of bearing. Insure rotor does not bind. Place head (43632) in a suitable holding device with motor end upward. Place motor assembly on head aligning roll pin (Y178-24) with hole in head. Slip motor housing over motor and secure to head. Assemble spacers (32310 and 32305) to housing.

AUXILIARY GEARING — Pack bearings and lubricate gears liberally with ARO 33153 grease when assembling. Assemble bearing and spacer (33693) to splined end of spindle. Assemble gears (33438) to spindle securing with shafts (33436). Assemble bearing to spindle securing shafts. Assemble spindle to nose housing (40499). Assemble nose housing (40499) and gearing adapter (42502) to motor housing, securing with cap screws (48005). After assembly, torque head (43632) to 35-40 ft. lbs.

DRIVE GEARING — Pack bearings and lubricate gears liberally with ARO 33153 grease when assembling. Assemble snap ring (40843) to spindle and position to allow assembly of shaft (40841). Assemble two needle bearings to gear (46416) and assemble to spindle, securing with shaft. Assemble other gear and needle bearings, securing with shaft. Rotate snap ring 90° to secure shafts. Assemble bearings to spindle. Assemble seal (37389), washer (47590), wave washer (47589) and spindle to nose housing (37878). Assemble nose housing to tool, securing with lock washers and cap screws (46555). Assemble spacer (46358) and keys (48006) to spindle.