

SALES AND ENGINEERING DATA

7221-C POWER MOTOR

"0" SERIES

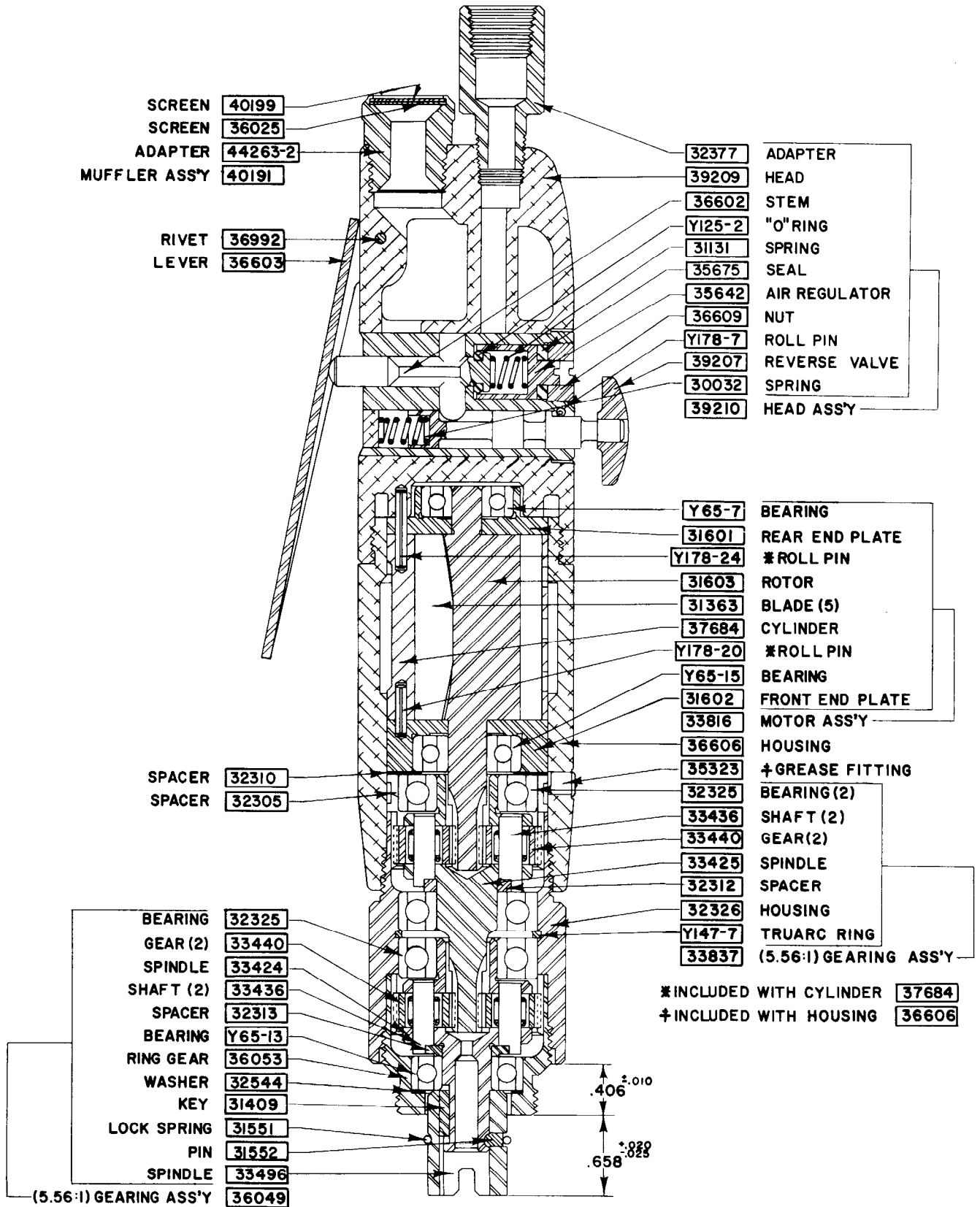
350 R.P.M.

FORM 1577-2

6/79

REVERSIBLE

LEVER THROTTLE



THE ARO CORPORATION
BRYAN, OHIO, U. S. A.



AIR AND LUBE REQUIREMENTS

AIR PRESSURE of 90 p.s.i.g. (6 bar, g) 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.

FILTER-REGULATOR-LUBRICATOR (F-R-L) assembly Model 128231-300 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 in-

sure proper lubrication.

GEARING should be grease lubricated to a minimum of once a month.

CAUTION: An excessive amount of Lubricant in a tool will affect the speed and power. Gearing should contain approx. 1/8 oz. (3.5 g) of grease per set of planetary gearing.

RECOMMENDED HOSE SIZE — 5/16" (8 mm) nominal inside diameter.

RECOMMENDED LUBRICANTS: Spindle Oil 39843, 1 qt. (.9 liter) container or 39844, 1 gal. (3.8 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

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 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 and 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 or parts adjacent "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, SERIAL NUMBER, PART NAME** and **MODEL NUMBER OF TOOL USE ONLY GENUINE ARO REPLACEMENT PARTS.**

DISASSEMBLY AND REASSEMBLY OF TOOL

DISASSEMBLY

GEARING — Remove Lock Spring (31551) and Key (31552) from Spindle. Remove Ring Gear (36053) and Gearing Assembly from tool. Tap end of Spindle to remove Gearing. Gearing should not be disassembled further unless necessary to replace a part as brinelling of the bearing races may occur making replacement necessary. To disassemble further remove Bearing(s) and Shafts releasing Gears. Remove Housing (32326) and Gearing Assembly from tool. Grasp Housing in one Hand tap threaded end of spindle with non-metallic hammer; Spindle and components will loosen from Housing.

MOTOR — The motor assembly can be removed from Housing after the removal of Gearing Assembly. Grasp Cylinder in one hand and tap splined end of Rotor with a non-metallic hammer; motor will come apart.

HEAD — Remove Head from Motor Housing. Remove Roll Pin (Y178-7), reverse valve components may be removed from Head. Remove Nut (36609) and Throttle components may be removed from Head. Remove Adapter (44263-2) and Adapter (32377).

REASSEMBLY

GEARING — Assemble Gears to Spindle, secure with Shafts, aligning notch in Shafts with Spacer (32312). Assemble Bearings (32325) to Spindle. Secure with

Truarc Ring and assemble in Housing (32326). Assemble Spacer (32310) and Spacer (32305) into Motor Housing and thread on Gearing assembly (32837). Assemble Gears to Spindle, secure with Shafts, aligning notch in Shafts with Spacer (32313). Assemble Bearings to Spindle. Assemble Washer (32544) and Gearing assembly into Ring Gear (36053). Assemble Ring Gear into Housing (32326). Assemble Spindle (33496) to Spindle (3424), place Pin into notch of Spindle and secure with Lock Ring (31551).

MOTOR — Assemble Bearings into End Plates and assemble End Plate (31601) to Rotor. Assemble Cylinder over Rotor aligning Roll Pin (Y178-24) with hole in End Plate. Assemble Blades to Rotor and assemble End Plate (31602) to Rotor and Cylinder aligning Roll Pin (Y178-20) with hole in End Plate. Insure Rotor does not bind. If Rotor binds tap Splined end of Rotor lightly with non-metallic hammer to loosen. Assemble to Housing.

HEAD — Assemble Spring (30032) to Reverse valve, assemble into Head and insert Roll Pin (Y178-7). Assemble "O" Ring (Y125-2), Stem (36602), Spring (31131), Air Regulator (35642), and Seal (35675) into Head. Secure with Nut (36609). Assemble Adapter (44263-2), and Adapter (32377) into Head.