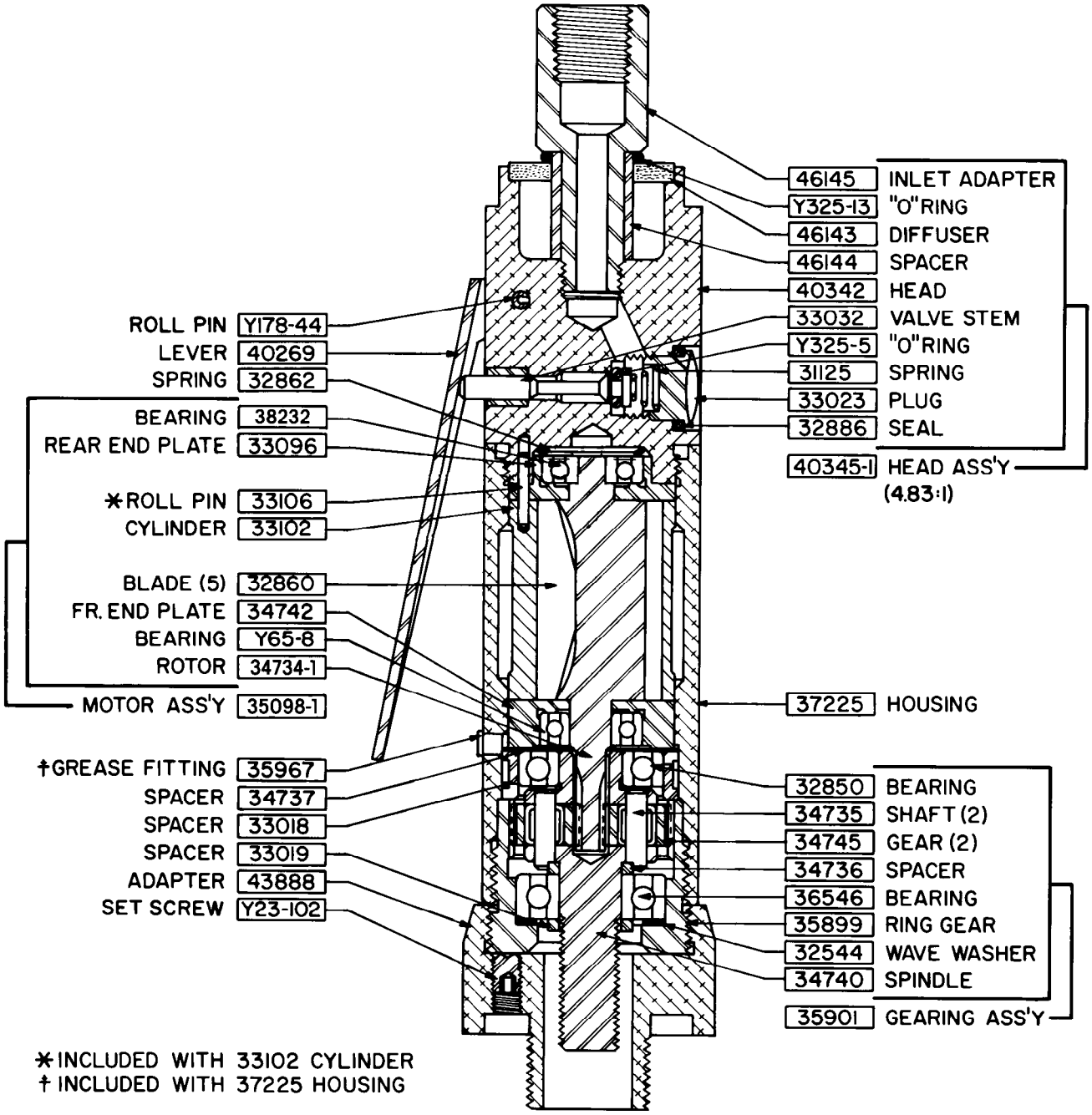
PARTS LIST

MODEL 8625-A
"000" SERIES POWER UNIT
4.83:1 REDUCTION 4400 R.P.M.

FORM 3285-2

4-1-88



*INCLUDED WITH 33102 CYLINDER
† INCLUDED WITH 37225 HOUSING

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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 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.

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

CAUTION: An excessive amount of lubricant in a tool will affect the speed and power. Each set of planetary gearing should contain approximately 1/16 oz. (1.8 g) of grease.

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 maintenance or service 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, 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, PART NAME, MODEL NUMBER AND SERIAL NUMBER OF TOOL. USE ONLY GENUINE ARO® REPLACEMENT PARTS.

DISASSEMBLY AND REASSEMBLY OF TOOLS

DISASSEMBLY

GEARING – Using a strap wrench on housing (37225) and wrench on flats of adapter (43888), unthread and remove gearing assembly (35901) from tool. Remove spindle (34740) and components from ring gear (35899). Remove bearing (32850). Alternately tap ends of shafts (34735) to remove bearing (36546) and spacer (33019) from spindle. Remove shafts (34735) to remove gears (34745) from spindle. Adapter (43888) may be removed from ring gear (35899) by loosening set screw (Y23-102) and unthreading adapter from ring gear. NOTE: A hard drying adhesive is used on threads of adapter and ring gear when assembled. It may be necessary to heat area slightly to facilitate loosening of parts.

MOTOR – Place head of tool in a suitable holding device, locating on flats of head. Using a strap wrench on motor housing (37225), unthread and remove from head. Remove motor assembly. Grasp cylinder in one hand and tap splined end of rotor with a non-metallic hammer; motor will come apart.

HEAD – Remove screw plug (33023) with seal (32886). Valve parts may now be removed from head. To remove diffuser (46143), remove inlet adapter (46145).

REASSEMBLY

HEAD – Assemble valve stem (33032) with "O" ring (Y325-5) and spring (31125) into head and secure with seal (32886) and screw plug (33023). Assemble spacer (46144), diffuser (46143) and "O" ring (Y325-13) to head and secure with inlet adapter (46145).

MOTOR – Assemble bearings into end plates. (NOTE: Bearing (38232) must be assembled to end plate with bearing identification markings to the outside.) Assemble rear end plate (33096) to rotor. Assemble cylinder (33102) over rotor aligning roll pin (33106) with hole in end plate. Assemble blades (32860) to rotor and assemble front end plate (34742) to rotor and cylinder. Insure motor does not bind. With head of tool held in a suitable holding device – motor end up – assemble spring spacer (32862) and motor assembly (35098-1) on head, aligning roll pin (33106) with hole provided in head (.078 dia. x 5/16 deep hole). Slip housing (37225) over motor and secure to head. Assemble spacers (34737) and (33018) and gearing to tool.

GEARING – Assemble spacers (34736) and bearings (36546) to spindle. Assemble gears (34745) to spindle and secure with shafts (34735), aligning notch in end of shafts with spacer (34736). Assemble bearing (32850) to spindle and assemble with spacer (33019) and wave washer (32544) into ring gear (35899). NOTE: Gearing should be lubricated using approximately 1/16 oz. grease. Assemble gearing (35901) with adapter to motor and housing (37225).