

**ASSEMBLY MACHINE MOTORS
NONREVERSIBLE**

MODELS 4801M2, 4801P2, 4801Q2, 4801S2, 4801T2 AND 4801U2

MODELS 4811P2, 4811Q2, 4811S2, 4811T2 AND 4811U2

Always operate, inspect and maintain this tool in accordance with American National Standards Institute Safety Code for Portable Air Tools (ANSI B186.1) and any other applicable safety codes and regulations.

FOR TOP PERFORMANCE AND MAXIMUM DURABILITY OF PARTS, OPERATE THIS TOOL AT 90 psig (6.2 bar/620 kPa) AIR PRESSURE WITH 3/4" (19 mm) AIR SUPPLY HOSE.

WARNING

Always turn off the air supply and disconnect the air supply hose before installing, removing or adjusting any accessory on this tool, or before performing any maintenance on this tool. Failure to do so could result in injury.

LUBRICATION

Oil: Ingersoll-Rand No. 50 Lubricant or a good quality SAE 20 or 20W motor oil.

Grease: Ingersoll-Rand No. 28 Lubricant or a good quality No. 2 cup grease.

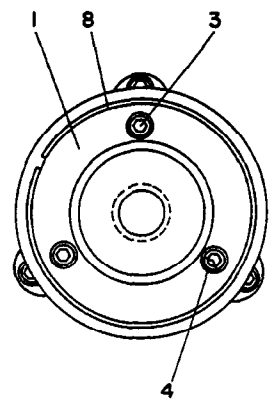
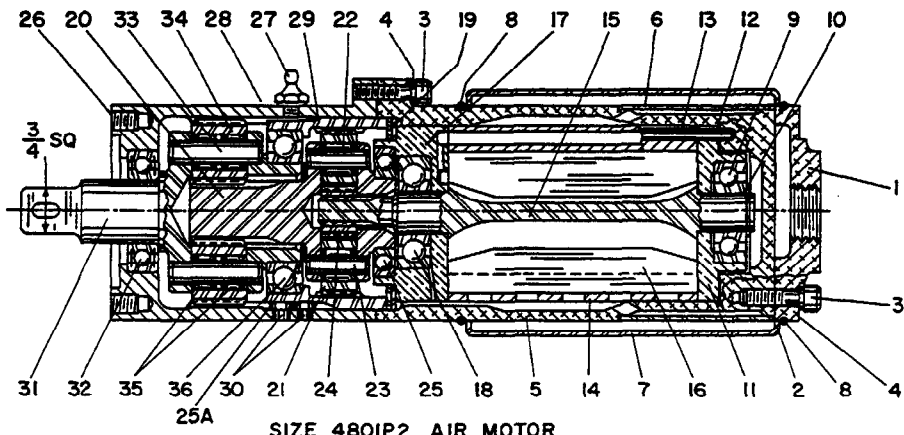
We recommend the use of an air line lubricator in the air supply line. Attach the unit as close to the tool as practical. Where the lubricator cannot be permanently mounted, we recommend using an Ingersoll-Rand No. 3LUB8 Lubricator. For permanent installations, we recommend using an Ingersoll-Rand NFLRU-8 Filter-Lubricator-Regulator unit. These units have 1/2" pipe tap inlet and outlet. The 3LUB8 has 1/6 pt. (79 mL) capacity; the NFLRU-8 has 1/2 pt (237 mL) capacity. Larger capacity units may be used, but do not use a unit having less than 1/2" pipe tap inlet and outlet. Adjust the lubricator so there is a slight oil mist in the exhaust.

After each forty hours of operation, or as experience indicates, inject 1.5 cc of the recommended grease into the Grease Fitting (14). Do not grease excessively. Too much grease in the Gear Case (13) will cause heating. Grease leakage from the spindle end is also an indication that an excessive amount of grease has accumulated within the Gear Case.

MAINTENANCE TOOLS

TOOL NUMBER FOR ORDERING	TOOL NAME FOR ORDERING	OPERATION
P25-228 50239	Grease Gun	Lubrication.
50240	Gear Head Planet Bearing Inserting Tool Spindle Planet Gear Bearing Inserting Tool (for P, Q, S and T ratios)	Pressing the Gear Head Planet Gear Bearings (22) into the Gear Head Planet Gears (20). Pressing the Spindle Planet Gear Bearings (35) into the Spindle Planet Gears (34).
D107249	Spindle Planet Gear Bearing Inserting Tool (for U ratio)	Pressing the Spindle Planet Gear Bearings (35) into the Spindle Planet Gears (34).

Notice: The use of other than genuine Ingersoll-Rand replacement parts may result in decreased tool performance and increased maintenance, and may invalidate all warranties.



25A
 SIZE 480IP2 AIR MOTOR
 CONSTRUCTION TYPICAL OF Q, S, T AND U RATIOS

(Dwg. TPB824)

PART NUMBER FOR ORDERING

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1	Backhead	R4800-102	26	Gear Case	
2	Backhead Gasket	R4800-283		for M ratio	R4800M-37
3	Backhead Cap Screw or Gear Case Cap Screw (6)	5080-638		for P, Q, S and T ratios	R4800P-37
4	1/4" Lock Washer (6)	8U-58		for U ratio	R4801U-A37
5	Motor Housing	R4800-40	27	Grease Fitting	R1-188
6	Muffler	R4800-175	28	Grease Fitting Washer	R3-92A
7	Exhaust Deflector	R4800-23	29	Internal Gear	R4800-406
8	Exhaust Deflector Retaining Ring (2)	R4800-323	30	Internal Gear Key	R4800-407
• 9	Rear Rotor Bearing	R2-24A		3/4" Spindle Assembly	
• 10	Rear Rotor Bearing Retainer	R4800-119		for P, Q and S ratios	
• 11	Rear End Plate	R4801-12		with Standard Length Spindle	R4800P-A8
12	Rear End Plate Gasket	R4801-739		with Transducer Spindle	R4801P-A408
13	Cylinder Dowel	R4800-98		for T ratio	
14	Cylinder	R4801-3		with Standard Length Spindle	R4801T-A8
15	Rotor			for U ratio	
	for M, P, S and T ratios			with Transducer Spindle	R4801U-A208
	(9 teeth)	R4801P-53	31	3/4" Square Drive Spindle	
	for Q ratio (13 teeth)	R4801Q-53		for M ratio (standard length)	R4800M-8
	for U ratio (7 teeth)	R4801U-53		for P, Q and S ratios	
• 16	Vane Packet (set of 6)	R4800-42-6		Standard Length Spindle	R4800P-8
• 17	Front End Plate	R4801-11		Transducer Spindle	R4801P-408
• 18	Front Rotor Bearing	R3H-24		for T ratio	
19	Motor Retaining Washer (2)	R4800-81		Standard Length Spindle	R4801T-8
	Gear Head Assembly			Transducer Spindle	R4801T-408
	for P ratio	R4800P-A216		for U ratio	
	for Q ratio	R4800Q-A216		Standard Length Spindle	R4801U-8
	for S ratio	R4800S-A216	• 32	Transducer Spindle	R4801U-408
	for T ratio	R4801T-A216		Spindle Front Bearing	
	for U ratio	R4801U-A216		for P, Q, S and T ratios	R4800-510
20	Gear Head			for U ratio	MR-988
	for P ratio	R4800P-216	33	Spindle Planet Gear Shaft (3)	
	for Q ratio	R4800Q-216		for P, Q, S and T ratios	R4800-190
	for S ratio	R4800S-216		for U ratio	R4801U-191
	for T ratio	R4801T-216	34	Spindle Planet Gear (3)	
	for U ratio	R4801U-216		for M ratio (31 teeth)	R4800M-9
21	Gear Head Planet Gear (2)			for P, Q and S ratios (16 teeth)	R4800P-9
	for P ratio (23 teeth)	R4800P-10		for T ratio (18 teeth; 1.220" o. d.)	R4801T-A9
	for Q ratio (25 teeth)	R4800Q-10		for U ratio (18 teeth; 1.232" o. d.)	R4801U-A9
	for S ratio (27 teeth)	R4800S-10	• 35	Spindle Planet Gear Bearing (2 for each Planet Gear)	
	for T ratio (27 teeth)	R4800S-10		for P, Q, S and T ratios (Torrington B-66 or its equivalent)	WWU10-510
	for U ratio (28 teeth)	R4801U-10		for U ratio	R4801U-510
• 22	Gear Head Planet Gear Bearing (Torrington B-59 or its equivalent) (1 for each Planet Gear)	R4800-654	• 36	Spindle Rear Bearing	R4800-97
23	Gear Head Planet Gear Shaft (2)	R4800-191	*	1" Square Drive Spindle Assembly (for U ratio)	R4801U-A208
24	Rotor Pinion (19 teeth) (for P ratio)	R4800P-17	*	1" Square Drive Spindle (for U ratio) (Also includes illustrated parts 32, 33 [3], 34 [3], 35 [6] and 36)	R4801U-208
• 25	Gear Head Bearing	W44-97	*	Air Strainer	R4800-565
25A	Gear Head Spacer	R4801-80			

* Not illustrated.

• To keep downtime to a minimum, it is desirable to have on hand certain repair parts. We recommend that you stock one (pair or set) of each part indicated by a bullet (•) for every four tools in service.