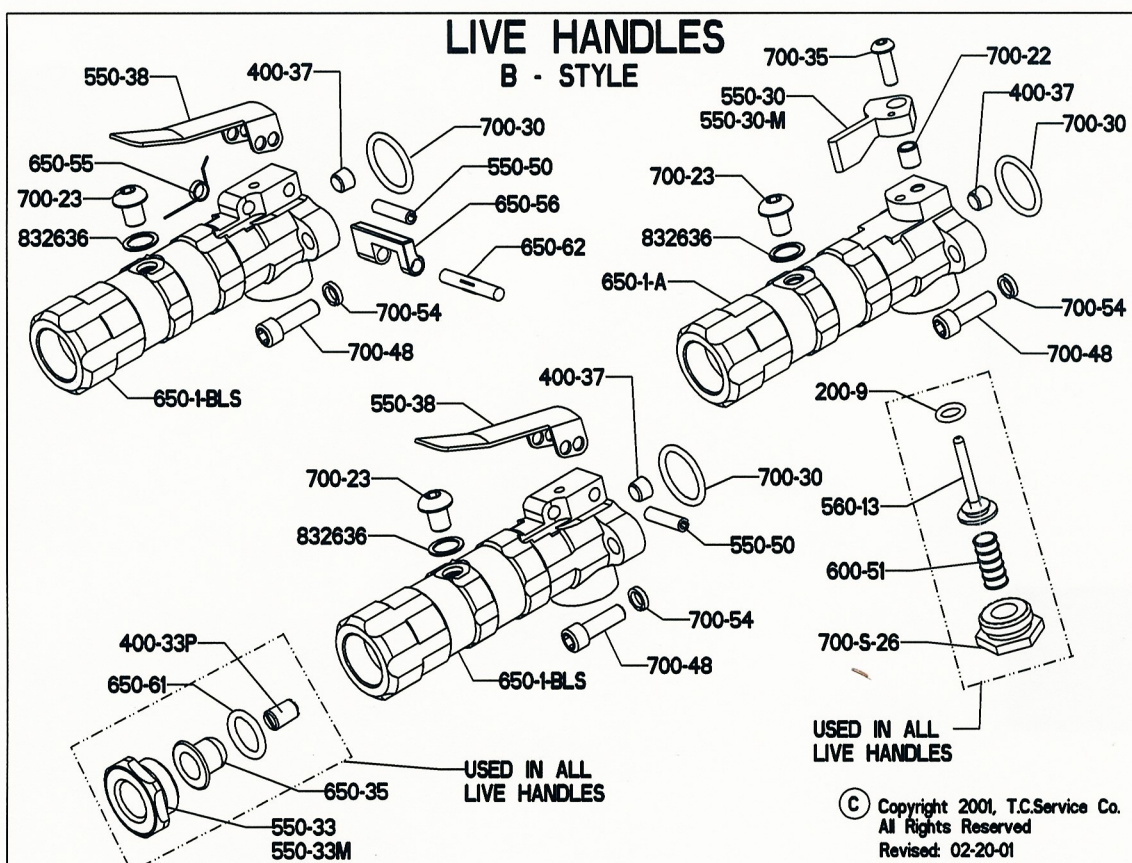


Assembly

1. Be sure all parts are clean and free of any abrasive.
2. Press front bearing (700-7) into front bearing support (550-1-BTB).
3. Slip bearing cover (550-25) into front bearing support and onto front bearing.
4. Install snap ring (550-21) into groove of front bearing support with use of snap ring pliers.
5. Support front bearing assembly on a suitable drill block. Press the spindle (550-8) through the bearing up to the shoulder with an arbor press.
6. Slide front endplate (550-7) over spindle and up to front bearing support.
7. Place key (550-10) into key slot of spindle.
8. Clamp spindle holder (1100-650) in vise vertically. Align key slot in holder with key of spindle and slide spindle assembly through.
9. Thread wheel flange (550-12B) onto spindle threads and tighten. Remove from vise.
10. Secure motor assembly into vise vertically with rear of motor toward upward direction. Clamp onto flats of wheel flange (550-12B).
11. Align the cylinder pin hole in bearing support (550-1-BTB) and front endplate (550-7).
12. Slide rotor (550-5) over spindle and key.
13. Insert five blades (550-6).
14. Place cylinder (550-2) over rotor with long dowel pin toward downward direction. Dowel pin goes through hole in front endplate and front bearing support.
15. Place rear endplate (550-3) over cylinder. Locate the short dowel pin of the cylinder in the small hole of rear endplate.
16. Press bearing (700-9) into rear endplate with bearing driver (1100-808).
17. Install lock ring (1000-5) onto spindle with use of snap ring pliers. (There is no groove.)
18. Prior to reassemble inspect governor for gouges, nicks or dents. Oil the governor and inside of motor. Screw governor (AA-550-XX) into end of spindle and tighten with governor wrench (1100-825). (left hand thread).
19. Assemble live handle if this was inspected or repaired.
20. Install live and dead handles to case (560-1).
21. Secure tool in a vise with motor axis in horizontal position. Clap onto the dead handle (550-1C) of grinder.
22. Place gasket (550-13) in rear face of case.
23. Slide the motor assembly into case. The motor assembly must be kept straight to install into the case easily. Try to maintain alignment as best as possible.
24. Line up guard with motor holes. Install as shown on page 8 of this booklet. Install 4 bolts (700-47A) and lock washers (700-46). Tighten bolts down until snug then back off 1/2 turn.
25. Connect tool to air supply and apply air in several short bursts.
26. Now run tool and tighten down bolts evenly. (Alternating from corner to corner.)
27. Check RPM with a reliable tachometer. Tool must run at or below speed stamped on the tool.

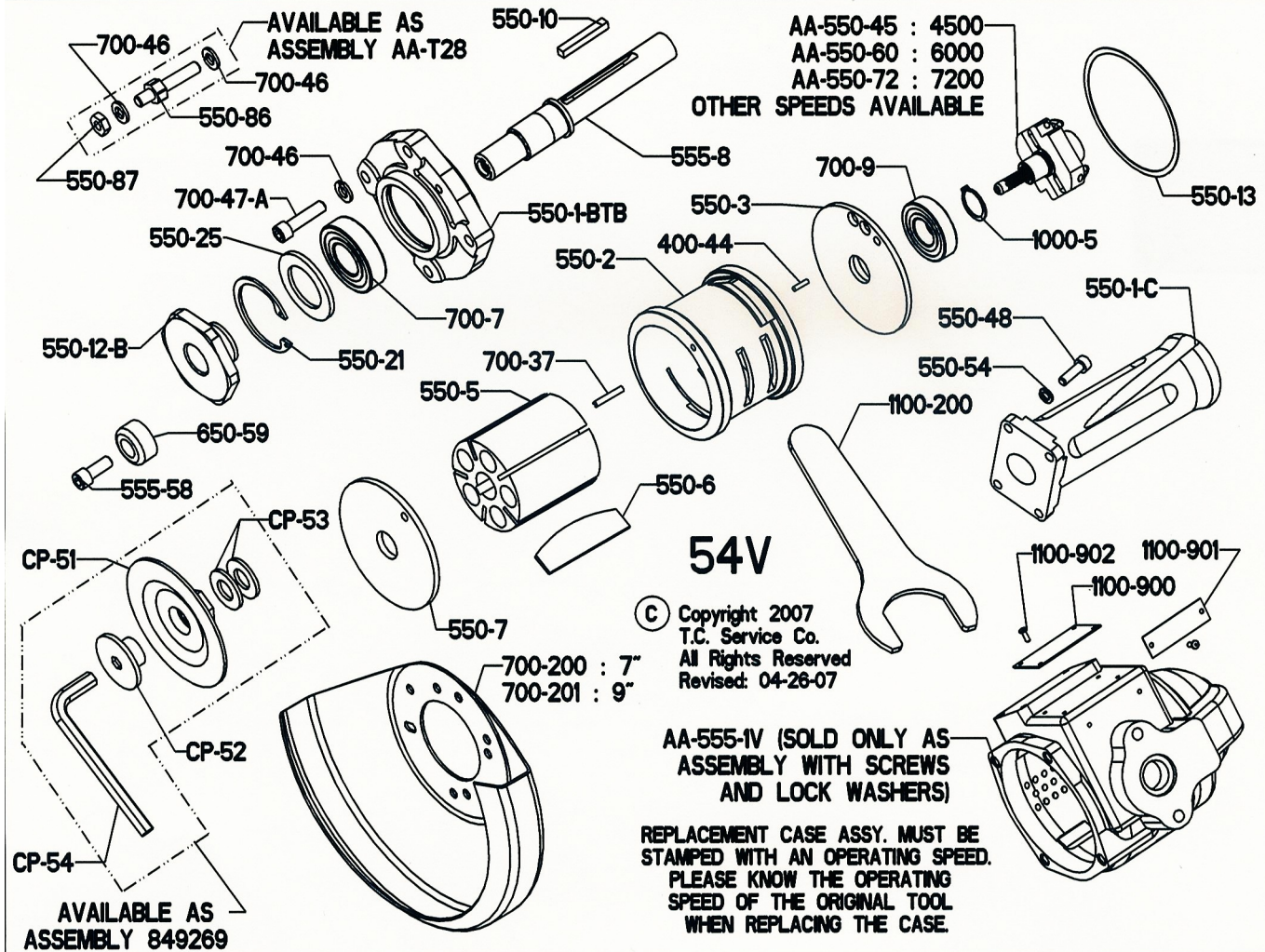
Governors

The governors are warranted for the life of the tool. (Except in cases of abuse) Please return the governor to the manufacturer for warranty repair or replacement.



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Revised: 02-20-01

Maintenance



Disassemble

1. Disconnect tool from air supply and remove all wheels and accessories.
2. Secure tool in a vise with motor axis in horizontal position. Clamp onto the dead handle (550-1C) of grinder.
3. Remove four screws (700-47A), four lock washers (700-46) and wheel guard (700-200, 700-201 or 412988).
4. Grasp motor output and pull complete motor assembly from case. The motor assembly must be kept straight to pull from case easily. Try to maintain alignment as best as possible. Remove case from vise.
5. Secure motor assembly into vise vertically with governor toward upward direction. Clamp onto flats of wheel flange (550-12B).
6. Remove governor (AA-550-XX) with use of governor wrench (1100-825). (Left-hand thread)
7. Remove lock ring (1000-5) with use of snap ring pliers. Remove from vise.
8. Hold motor assembly by the cylinder in one hand. Place a punch in the hole left by the removal of governor. Tap lightly onto the punch with small hammer. This will drive the spindle (550-8) through the rear bearing (700-9) and rear endplate (550-3). (Take care not to damage threads inside spindle, or to drop the spindle assembly when it becomes free.)
9. Use a small screwdriver to push the rear bearing out of the rear endplate.
10. Remove the cylinder (550-2), the rotor blades (550-6) and the rotor (550-5). Leave the key (550-10) in the key slot for now.
11. Clamp spindle holder (1100-650) into vise vertically. Align key slot in holder with key of spindle and slide spindle assembly through.
12. Remove wheel flange (550-12B). Remove from vise.
13. Remove key (550-10) and lift off front end plate (550-7).
14. Support front bearing assembly on a suitable drill block. Press spindle (550-8) through front bearing (700-7) with arbor press.
15. Remove snap ring (550-21) with use of snap ring pliers.
16. Lift out bearing cover (550-25).
17. Press out front bearing (700-7) from front bearing support (550-1-BTB).
18. To check throttle valve, unscrew throttle valve cap (700-S-26). Lift out valve spring (600-51) and throttle valve (560-13). Replace