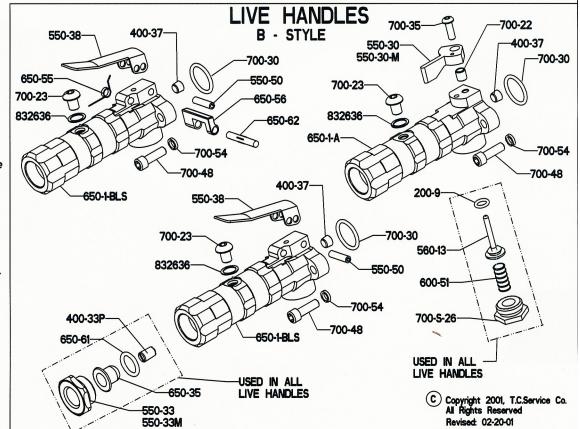
## Assembly

- 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. (Execpt in cases of abuse)
Please return the governor to the manufacturer for warranty repair or replacement.