

Important Operating, Maintenance and Safety Instructions

Carefully read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool.

Warning: Hand, wrist and arm injury may result from repetitive work motion and overexposure to vibration.

Important: All Dynabrade rotary vane air tools must be used with a Filter-Regulator-Lubricator to maintain all warranties.

Operating Instructions:

Warning: Eye, face, respiratory, sound and body protection must be worn while operating power tools. Failure to do so may result in serious injury or death. Follow safety procedures posted in workplace.

1. With power source disconnected from tool, securely fasten abrasive/accessory on tool.
2. Install air fitting into inlet bushing of tool. **Important:** Secure inlet bushing of tool with a wrench before attempting to install the air fitting to avoid damaging valve body housing.
3. Connect power source to tool. Be careful not to depress throttle lever in the process.
4. Check tool speed with tachometer. If tool is operating at a higher speed than the RPM marked on the tool or operating improperly, the tool should be serviced to correct the cause before use.

Maintenance Instructions:

1. Check tool speed regularly with a tachometer. If tool is operating at a higher speed than the RPM marked on the tool, the tool should be serviced to correct the cause before use.
2. Some silencers on air tools may clog with use. Clean and replace as required.
3. All Dynabrade rotary vane air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example: if the tool specifications state 40 SCFM, set the drip rate of your filter-lubricator at 4 drops per minute). Dynabrade Air Lube (P/N 95842: 1 pt. 473 ml.) is recommended.
4. It is strongly recommended that all Dynabrade rotary vane air tools be used with a Filter-Regulator-Lubricator to minimize the possibility of misuse due to unclean air, wet air or insufficient lubrication. Dynabrade recommends the following: **11405** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components. Operates 40 SCFM @ 100 PSIG has 3/8" NPT female ports.
5. Use only genuine Dynabrade replacement parts. To reorder replacement parts, specify the **Model #**, **Serial #**, and **RPM** of your machine.
6. A Motor Tune-Up Kit (P/N 96047) is available which includes assorted parts to help maintain motor in peak operating condition.
7. Gear case of this Dynabrade air tool should be lubricated with one plunge for every 50 hours of use by Dynabrade's **95541** Grease Gun and **95542** Grease.

Safety Instructions:

Products offered by Dynabrade should not be converted or otherwise altered from original design without expressed written consent from Dynabrade, Inc.



- **Important:** User of tool is responsible for following accepted safety codes such as those published by the American National Standards Institute (ANSI).
- Operate machine for one minute before application to workpiece to determine if machine is working properly and safely before work begins.
- Always disconnect power supply before changing abrasive/accessory or making machine adjustments.
- Inspect abrasives/accessories for damage or defects prior to installation on tools.
- Please refer to Dynabrade's Warning/Safety Operating Instructions Tag (Reorder No. **95903**) for more complete safety information.
- **Warning:** Hand, wrist and arm injury may result from repetitive work, motion and overexposure to vibration.

Notice

All Dynabrade motors use the highest quality parts and metals available and are machined to exacting tolerances. The failure of quality pneumatic motors can most often be traced to an unclean air supply or the lack of lubrication. Air pressure easily forces dirt or water contained in the air supply into motor bearings causing early failure. It often scores the cylinder walls and the rotor blades resulting in limited efficiency and power. Our warranty obligation is contingent upon proper use of our tools and cannot apply to equipment which has been subjected to misuse such as unclean air, wet air or a lack of lubrication during the use of this tool.

One Year Warranty

Following the reasonable assumption that any inherent defect which might prevail in a product will become apparent to the user within one year from the date of purchase, all equipment of our manufacture is warranted against defects in workmanship and materials under normal use and service. We shall repair or replace at our factory, any equipment or part thereof which shall, within one year after delivery to the original purchaser, indicate upon our examination to have been defective. Our obligation is contingent upon proper use of Dynabrade tools in accordance with factory recommendations, instructions and safety practices. It shall not apply to equipment which has been subject to misuse, negligence, accident or tampering in any way so as to affect its normal performance. Normally wearable parts such as bearings, contact wheels, rotor blades, etc., are not covered under this warranty.

Model Number	Motor hp (W)	Motor RPM	Sound Level	Maximum Air Flow SCFM (LPM)	Spindle Thread	Air Pressure PSIG (Bars)	Weight Pound (kg)	Length Inch (mm)	Height Inch (mm)
53060	.7 (522)	3,400	84 dB(A)	33 (935)	1/2"-20 male	90 (6.2)	3.2 (1.4)	8-7/8 (224)	6-3/8 (163)
53090	.7 (522)	950	84 dB(A)	33 (935)	1/2"-20 male	90 (6.2)	4.8 (2.1)	10-1/2 (267)	6-3/8 (163)
53091	.7 (522)	950	84 dB(A)	33 (935)	1/2"-20 male	90 (6.2)	3.9 (1.8)	10-1/2 (267)	6-3/8 (163)
53095	.7 (522)	4,500	84 dB(A)	33 (935)	1/2"-20 male	90 (6.2)	3.2 (1.4)	8-7/8 (224)	6-3/8 (163)
53096	.7 (522)	20,000	84 dB(A)	33 (935)	3/8"-24 male	90 (6.2)	2.4 (1.1)	7 (180)	6-3/8 (163)

Additional Specifications: Air Inlet Thread 1/4" NPT • Hose Size 3/8" or 10mm

Disassembly/Assembly Instructions

Important: Manufacturer's warranty is void if tool is disassembled before warranty expires.
A motor tune-up kit is available (P/N 96047) is available to help maintain motor in peak operating condition.

Tool Disassembly:

1. Remove drill chuck and **53163** Side Handle.
2. Carefully secure the tool in a vise so that the spindle is pointing up. To avoid damaging the housing do not over tighten the vise.
3. Remove the **53185/55030/55029** Cover by turning it clockwise. (**Left Hand Thread**)
4. Pull the air motor from the housing.
5. Remove the **56028** Muffler Cap. To remove the **57066** Muffler Body use the **96034** 12mm Hex Key.

Motor Disassembly:

1. Secure a 2 in. bearing separator around the end of the cylinder closest to the rear bearing plate. Place the separator on the table of the **96232** Arbor press so that the front of the motor is pointing down.
2. Use a 5/32" dia. flat end drive punch as a press tool and push the rotor out of the **02649** Bearing.
3. Remove the **02649** Bearing from the rear bearing plate with the **96213** Bearing Removal Tool and the arbor press.
4. Front Bearing/Plate Removal:
 - A. To remove the front bearing/plate from the **04009** Rotor, use the 2 in. bearing separator and the arbor press by pushing the pinion end of the rotor out of the **01007** Bearing.
 - B. To remove the front bearing/plate from the **55025** Rotor, secure the body of the rotor in a soft aluminum or bronze jaw vise and remove the **55038** Spindle Nut by turning it counterclockwise. The **01007** Bearing and the **01010** Spacer are both a slip fit to the plate and the rotor.

Planetary Gear Disassembly: (Models: 53390, 53391, 53060 and 53095)

1. To remove the planetary gear assemblies from the **53185/55030** Cover remove the **04014** Set Screw(s).
2. Push the planetary assembly(ies) out of the **53185/55030** Cover. (Use the arbor press if needed.)
3. Fasten a 2 in. bearing separator between the rear **02552** Bearing(s) and place the separator on the arbor press so that the planetary carrier spindle/pinion points down. Use the larger end of the **96214** bearing Removal Tool to press the planetary carrier(s) out of the rear **02552** Bearing.
4. Remove the shafts and gears from the planetary carrier(s).
5. Use the bearing separator to also remove the front **02552** Bearing from the **53164** Planetary Carrier.
6. Carefully secure the **53165** Planetary Carrier in a soft aluminum or bronze jaw so that its' spindle is pointing up. Remove the **04114** Spindle Nut turning it counterclockwise.
7. Fasten a 2 in. bearing separator between the front **02552** Bearing and the **53165** planetary Carrier. Place these on the arbor press with the spindle pointing up and press the planetary carrier from the bearing.
8. Remove the **55031** Felt Seal from the cover.

Valve Disassembly:

1. Drive **96025** Pin from housing and pull the valve stem assembly from the housing.
2. To remove the **55051** Valve Stop use a 3/32" dia. flat end drive punch as a press tool, and with the aid of a small separator and an arbor press, push the **55052**.
3. Press **55052** Valve Stem through the second **55051** Valve Stop.

Valve Assembly:

1. Install **96069** Spring and slide **55039** Bushing (with o-rings) onto valve stem/trigger assembly.
2. Apply a small amount of #609 Loctite (or equivalent) onto **55052** Valve Stem and press the first **55051** Valve Stop with large end facing away from the **55039** Bushing.
3. Install **96147** O-Ring onto the second **55051** Valve Stop.
4. Apply a small amount of #609 Loctite (or equivalent) onto **55052** Valve Stem and press the second **55051** Valve Stop onto the valve stem with large end facing away from the **55039** Bushing. **Important:** Press the second valve stop onto the valve stem only until the large end of the valve stop is flush with the end of the valve stem.
5. Install the valve assembly into the housing and secure it with the **96055** Pin.

Motor Assembly:

Important: Clean and inspect all parts before assembling.

1. Install **01010** Spacer on the rotor.
2. Install .003" thickness of shims into **53183/55026** Front Bearing Plate. Install **01007** Bearing into the front bearing plate.
3. Front Bearing/Plate Installation:
 - A. Use the **96244** Bearing Press Tool and arbor press to install the **53183** Front Bearing Plate along with **01007** Bearing onto the **04009** Rotor. (Place the tool against the inner race of the bearing.)
 - B. Slip the **55026** Front Bearing Plate along with the **01007** Bearing onto the **55025** Rotor. Secure the body of the **55025** Rotor in a soft aluminum or bronze jaw vise and install the **55038** Spindle Nut. (Torque to 17 N•m/150 in.-lbs.)
4. Use a .001" feeler gage to check clearance between the front of the rotor body and the face of the front bearing plate. That clearance must be .001"-.0015". If it is necessary to adjust the clearance, do this by adding or removing the appropriate thickness in shims.
5. Apply Dynabrade Air Lube **95842** to the **01185** Blades and install these into the rotor slot.
6. Install the **01028** Cylinder so that the air inlet area lines up with the air inlet holes in the rear bearing plate.
7. Use the **96240** Bearing Press Tool and arbor press to install the **02649** Bearing into the **55027/01743** Rear Bearing Plate (press tool against the outer race of the bearing).
8. Use the **96240** Bearing Press Tool and arbor press to install the rear bearing/plate onto the **04009/55025** Rotor (press tool against the inner race of the bearing).
Important: The fit must be snug between the bearing plates and the cylinder. However, if its' too tight the rotor will turn freely. In that case the fit must be loosened so that the rotor will turn freely while still maintaining a snug fit.

Planetary Gear Assembly: (Models: 53390, 53391, 53060 and 53095)

1. Press the front **02552** Bearing onto the front of the **53164/53165** Planetary Carrier.
2. Install the **04114** Spindle Nut onto the **53165** Planetary Carrier. (Torque to 17 N•m/150 in.-lbs.)
3. Lubricate the planetary gears, needle bearings, and shafts with P/N **95542** Grease, and install these into the planetary carrier.

Disassembly/Assembly Instructions (continued)

4. Install the **53191** Ring Gear over the planetary carrier so that the set screw and grease fitting notches will orient correctly once placed into the **53185/55030** Cover.
5. Press the rear **02552** Bearing onto the rear of the planetary carrier until it touches the ring gear. **Important:** The fit must be snug between the bearings and the ring gear. However, if its' too tight the planetary carrier will not turn freely. In that case the fit must be loosened so that the planetary carrier will turn freely while still maintaining a snug fit.
6. Install the **55031** Felt Seal into the **53185/55030/55029** Cover.
7. Install the planetary carrier assembly(ies) into the **53185/55030** Cover so that the notches in the ring gear(s) align with the set screw and grease fitting openings in the cover. **Important:** For model **53090** and **53091** be certain to install the **53188** Spacer between the planetary carrier assemblies.
8. Apply a small amount of Loctite #567 (or equivalent) to the threads of the **04114** Set Screw(s) and install into the **53185/55030** Cover.
9. Lubricate the planetary gears through the grease fitting(s) applying 1 plunge at intervals of every 50 hours of use. Order and use the recommended Dynabrade **95542** Grease Gun to insure the maximum gear life.

Tool Assembly:

1. Carefully secure the housing in a vise so that the motor opening is facing up. To avoid damaging the housing do not over tighten the vise.
2. Install the air motor assembly into the housing.
3. Carefully align the cover and the planetary gear assembly(ies) to the housing and the air motor assembly. (**Left Hand Thread**), (Torque to 28 N•m/250 in.-lbs.).
4. Use the **96034** 12mm Hex Key to install the **57066** Muffler Body into the housing. Place the **56027** Muffler Insert into the **56028** Muffler Cap and install these onto the muffler body.
5. Install the drill chuck and the **53153** Side handle.

Tool Assembly Complete. Please allow 30 minutes for adhesives to cure before operating tool.

Important: Motor should now be tested for proper operation at 90 PSIG. If motor does not operate properly or operates at a higher RPM than marked on the tool, the tool should be serviced to correct the cause before use. Before operating, place 2-3 drops of Dynabrade Air Lube (P/N **95842**) directly into air inlet with throttle lever depressed. Operate tool for 30 seconds to determine if tool is operating properly and to allow lubricating oils to properly penetrate motor.

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Accessories



96047 Motor Tune-Up Kit

- Includes assorted parts to help maintain and repair motor.



Dynamswivel®

- Swivels 360° at two locations which allows an air hose to drop straight to the floor, no matter how the tool is held.
- **94300** 1/4" NPT.



Dynabrade Air Lube

- Formulated for pneumatic equipment.
- Absorbs up to 10% of its weight in water.
- Prevents rust and formation of sludge.
- Keep pneumatic tools operating longer with greater power and less down time.

95842: 1 pt. (473 ml)

95843: 1 gal. (3.8 L)



96034 12mm Hex Key

- This is used for the removal and installation of the **57066** Muffler Body.



Grease

- Multi-purpose grease for all types of bearings, cams, gears.
- High film strength; excellent resistance to water, steam, etc.
- Workable range 0° F to 300° F.

95541: Push-type Grease Gun (one-handed operation).

95542: 10 oz. (283.5 g) tube.



96213 Bearing Removal Tool

96214 Bearing Removal Tool

- This tool is designed to pass through the I.D. of the bearing plate and push against the I.D. of the bearing.



96240 Bearing Press Tool

96244 Bearing Press Tool

- Use with (#2) arbor press to achieve accurate press of bearings and motor parts.



96346 Bearing Separator 2 in.

- This is used to remove bearings, gears, and other components.

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