For Serial No. 9K2915 and Higher

Models:

40320 – Standard Machine
40321 – Versatility Kit (1/4")
40324 – Versatility Kit (6mm)
40326 – 20-1/2" Long Belt Machine
40330 – Vacuum Machine
40335 – "NWN" Dynafile® II

KEY

- O — Oil: O_1 = Air Lube
- G — Grease: G_2 = Loctite #771
- A — Adhesive: A_2 = Loctite #271, A_3 = Loctite #242, A_9 = Loctite #587
- T — Torque: N•m x 8.85 = In - lbs.

Parts Page Reorder No. PD00•05R
Effective January, 2000
Supercedes PD95•54

Dynafile® II

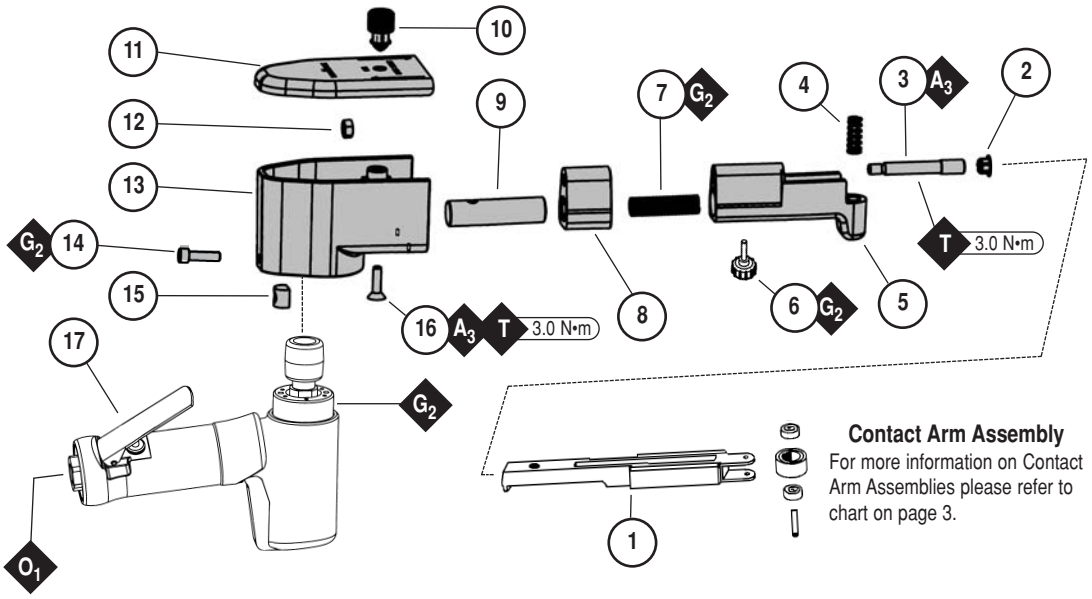
Air Motor and Machine Parts

WARNING **Always operate, inspect and maintain this tool in accordance with the Safety Code for portable air tools (ANSI B186.1) and any other applicable safety codes and regulations. Please refer to Dynabrade's Warning/Safety Operating Instructions for more complete safety information.**

Models: 40320 Standard Machine, 40335 "NWN" Machine

Index Key

No.	Part #	Description
1	**11206**	Contact Arm Assy.
2	**96334**	Plug
3	**15308**	Guide Post
4	**11040**	Spring
5	**15306**	Tension Arm
6	**95218**	Knob Assy.
7	**95426**	Spring
8	**15309**	Dust Cover
9	**15307**	Tension Shaft
10	**15329**	Screw
11	**15312**	Belt Guard
12	**96335**	Hex Nut
13	**15354**	Housing (Standard)
	15363	NWN Housing
	15365	20-1/2" Housing
14	**95311**	Screw
15	**40029**	Motor Lock
16	**95217**	Screw
17	**05027**	Air Motor
	05028	Air Motor



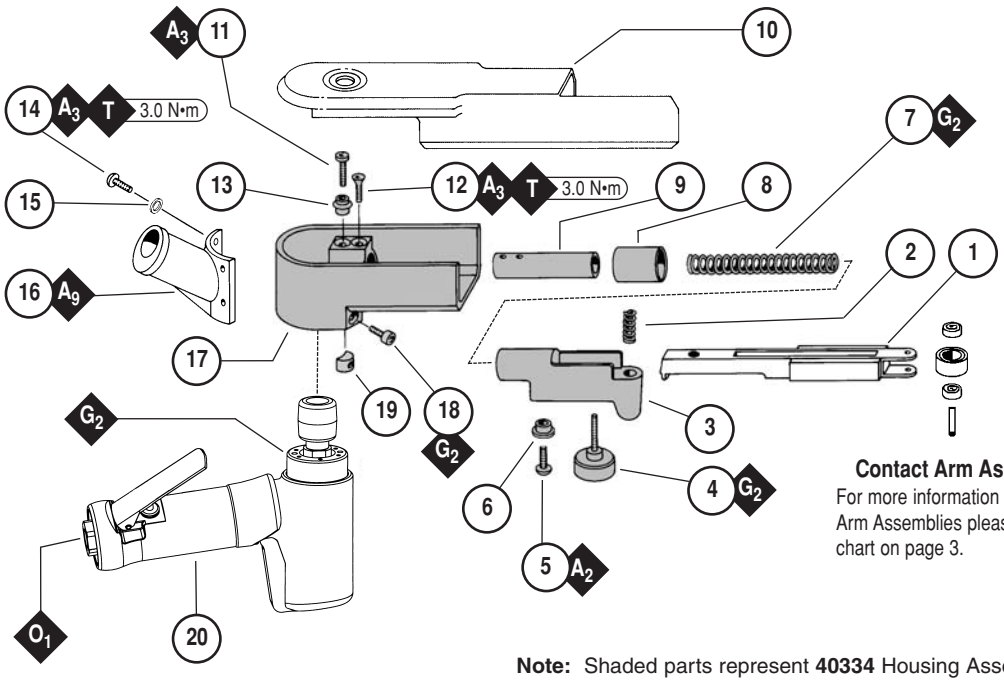
Contact Arm Assembly
For more information on Contact Arm Assemblies please refer to chart on page 3.

Note: Shaded parts represent **15355** Housing Assembly.

Model: 40330 Vacuum Machine

Index Key

No.	Part #	Description
1	**11206**	Contact Arm Assy.
2	**11040**	Spring
3	**40361**	Tension Arm
4	**95218**	Knob Assy.
5	**95427**	Screw (Self-Tap Screw)
6	**40366**	Guide
7	**95426**	Spring
8	**40367**	Dust Cover
9	**40362**	Support Rod
10	**40370**	Belt Guard
11	**95425**	Screw
12	**95217**	Screw
13	**40025**	Button
14	**95437**	Screw (4)
15	**95337**	Washer (4)
16	**40368**	Adapter
17	**40369**	Housing
18	**95311**	Screw
19	**40373**	Motor lock
20	**05025**	Air Motor



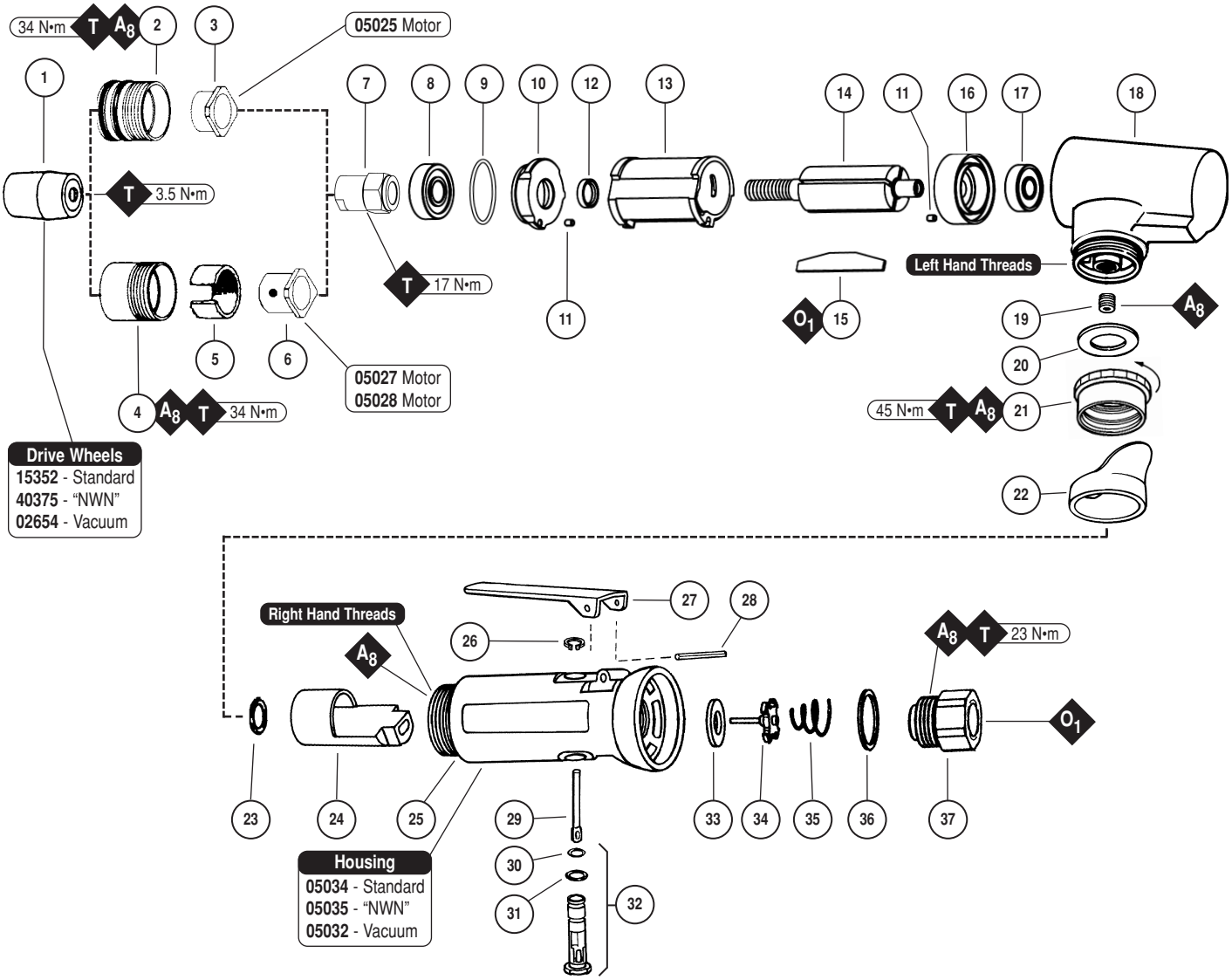
Contact Arm Assembly
For more information on Contact Arm Assemblies please refer to chart on page 3.

Note: Shaded parts represent **40334** Housing Assembly.

See page 2 for 05025, 05027 and 05028 Motor Assemblies.

05027 — Air Motor for Standard Machine
05028 — Air Motor for "NWN" Machine
05025 — Air Motor for Vacuum Machine

US PAT. D-265, 172; 4,368,597; 4,411,106



Index Key

No.	Part #	Description
1	**Drive Wheel**	(See Chart)
2	**04085**	Lock Ring (Incl. (2) **95438** O-Ring)
3	**04086**	Exhaust Control Spacer
4	**04087**	Lock Ring
5	**04078**	Fabric Silencer
6	**04084**	Exhaust Control Spacer
7	**04081**	Nut
8	**01007**	Bearing
9	**01121**	Shim Pack (3/pkg.)
10	**01008**	Bearing Plate
11	**01009**	Pin (2)
12	**01010**	Spacer
13	**01013**	Cylinder
14	**01120**	Rotor
15	**01011**	Blade (4/pkg.)
16	**01014**	Bearing Plate
17	**01015**	Bearing
18	**01447**	Motor Housing
19	**01437**	Plug
20	**01548**	Gasket
21	**01461**	Lock Nut
22	**01558**	Collar
23	**95523**	O-Ring
24	**01470**	Insert
25	**Housing**	(See Chart)
26	**95558**	Retaining Ring
27	**01448**	Throttle Lever
	01462	Safety Lever (optional)
28	**12132**	Pin
29	**01449**	Valve Stem
30	**95730**	O-Ring
31	**01024**	O-Ring
32	**01469**	Speed Regulator Assy.
33	**01464**	Seal
34	**01472**	Tip Valve
35	**01468**	Spring
36	**01564**	Spacer
37	**01494**	Inlet Bushing

KEY

- **O** Oil: **O_1 = Air Lube**
- **A** Adhesive: **A_8 = Loctite #567**
- **T** Torque: **N•m x 8.85 = In.-lbs.**

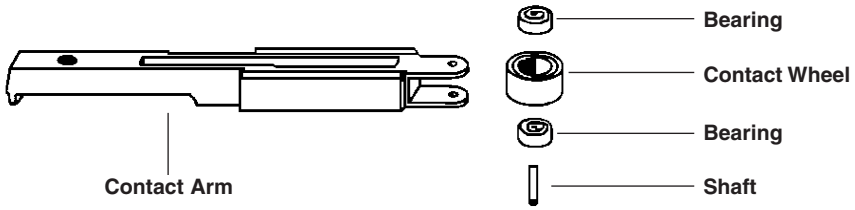
ATTENTION

The "NWN" tool is specifically designed for use with abrasive impregnated "non-woven nylon" belts and is equipped with a **40375** Rubber-Coated Drive Wheel. Use with coated abrasive belts tends to gouge the rubber drive wheel and is not recommended.

Versatile Air Motors detach from tools in seconds. Convert to Die Grinder by adding optional 1/4" collet (**50010**). Convert to Drill by adding a 1/4" chuck (**53032**). See page 7 for Conversion Instructions.

Dynafile® II Contact Arm Assemblies

Contact Wheel Assembly–Includes wheel, bearing and shaft.



Dynafile® II Standard Contact Arms							
Part Number	Abrasive Belt Size	Contact Wheel Description	Comments	Contact Wheel Assembly	Contact Wheel Only	Bearing (2) Req.	Shaft
11200	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	"Stroke-Sander" Arm; 1/2" W Platen	11088 (2)	11077 (2)	11052 (4)	11055 (2)
***11201**	1/2" x 18"	5/16" Dia. x 3/8" W Steel	1/2" W Platen	11068	11067	11051	11054
11202	1/4" x 18"	5/8" Dia. x 1/8" W Rubber	1/4" W Platen	11074	11073	11052	11053
11203	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen	11078	11077	11052	11054
11204	1/4" or 1/2" x 18"	1" Dia. x 3/8" W Radiused Rubber	Loose Belt Application	11080	11079	11052	11054
11206	5/8" or 3/4" x 18"	3/4" Dia. x 5/8" W Rubber	3/4" W Platen	11282	11281	11052	11285
***11220**	5/8" or 3/4" x 18"	5/16" Dia. x 5/8" W Steel	Polish Turbine Blades	11352	11353	11051	11285
11280	1/4" x 18"	1" Dia. x 3/8" W Tapered Urethane	No Platen/Offset Design	11086	11085	11052	11054
11286	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen	11078	11077	11052	11054
11287	5/8" or 3/4" x 20-1/2"	3/4" Dia. x 5/8" W Rubber	3/4" W Platen	11282	11281	11052	11285
***11300**	1/2" x 18"	1/4" Dia. x 3/8" W Steel	Polish Turbine Blades	11332	11333	11334	11335
***11301**	1/2" x 18"	5/16" Dia. x 3/8" W Steel	Polish Turbine Blades	11068	11067	11051	11054
11304	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	"Stroke-Sander" Arm-1/2" W Platen	11078	11077	11052	11054
11312	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	H.D. Version of 11203 Arm	11078	11077	11052	11054
11320	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	"Offset Arm" – prevent gouging.	11078	11077	11052	11054
11322	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	Contains two 11395 Guide Wheels – Prevents Undercutting	11090	11077	11052	95610
11325	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	1/2" W Steel Platen	11078	11077	11052	11054
11326	5/8" or 3/4" x 18"	3/4" Dia. x 5/8" W Rubber	H.D. Version of 11206 Arm	11282	11281	11052	11285
11329	1/2" x 44"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen/17" Reach	11078	11077	11052	11054
***11341**	1/2" x 18"	5/16" Dia. x 3/8" W Rubber	Polish Turbine Blades	11342	11343	11334	11335
***11350**	3/4" x 34"	5/16" Dia. x 5/8" W Steel	Bus Bar Arm/11" Reach	11352	11353	11051	11285
11360	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	No Platen/Offset Design	11078	11077	11052	11054
****42642**	5/8" or 3/4" x 18"	3/4" Dia. x 5/8" W Rubber	3/4" W Platen	42652	11281	01187	11285
****42644**	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	"Stroke-Sander" Arm-1/2" W Platen	42653	11077	01187	11054
****42646**	1/4" or 1/2" x 18"	1" Dia. x 3/8" W Radiused Rubber	No Platen/Offset Design	42654	11079	01187	11054
****42650**	1/2" x 18"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen	42653	11077	01187	11054

*Run at 45 PSIG. Not recommended for Electric Dynafile® II. **For use with Wet Dynafile® II. Contains sealed bearings.

See page 6 for Dynafile® II Abrasives and Accessories.

Assembly/Disassembly for Dynafile® II

Important: A #2 Arbor Press is recommended for assembly/disassembly.
Manufacturers warranty is void if tool is disassembled before warranty expires.

To Disassemble:

Housing Assembly: Non-Vacuum

1. Unscrew **15329** Screw and remove **15312** Belt Guard Assembly, abrasive belt and contact arm assembly.
2. Loosen **95311** Screw and remove air motor.
3. Remove **96334** Plug.
4. Remove **15308** Guide Post and **96335** Hex Nut, this will release **15306** Tension Arm and **95426** Spring. (Heating of **96335** Nut may be required.)
   Warning: 15306 Tension Arm is spring loaded, use caution when removing **15308** Guide Post.
5. Remove **15309** Dust Cover, **95217** Screw and **15307** Tension Shaft. (Heating of **95217** Screw may be required.)

Housing Assembly: Vacuum

1. Remove **40370** Belt Guard, abrasive belt and contact arm assembly.
2. Loosen **95311** Screw and remove air motor.
3. Loosen **95427** Screw and remove **40366** Guide, this will release **40361** Tension Arm and **95426** Spring.
   Warning: 40361 Tension Arm is spring loaded, use caution when loosening **95427** Screw.
4. Remove **40367** Dust cover.
5. Remove **95217** Screw and **40362** Support Rod. (Heating of **95217** Screw may be required. Remove **40025** Button before heating).

Motor Assembly:

1. Secure Air Motor in a padded vise using **52296** Repair Collar.
   Important: Do not over-tighten vise or housing could be damaged.
2. Remove drive wheel by inserting a 3/16" hex key through drive wheel and into the end of the **01120** Rotor/Drive Shaft.
3. Using a wrench or pliers, twist the drive wheel counterclockwise and remove.
4. Use a pin wrench to remove **04087/04085** Lock Ring (twist counterclockwise). Remove exhaust control spacer and silencer (if equipped).
5. Pull motor assembly from housing.
6. Press **01120** Rotor/Drive Shaft from **01015** Bearing and **01014** Bearing Plate.
7. Press **01015** Bearing from **01014** Bearing Plate.
8. Remove **01013** Cylinder and blades.
9. Secure **01120** Rotor in a padded vise and remove **04081** Rotor Nut (twist counterclockwise).
10. Slip off **01010** Spacer, **01008** Bearing Plate, shims and **01007** Bearing from **01120** Rotor.

Valve Stem/Body Assembly:

1. Secure motor housing in padded vise using **52296** Repair Collar with air inlet bushing facing upwards.
2. Unscrew **01494** Inlet Bushing from valve body and remove **01564** Air Control Ring.
3. Using needle nose pliers, remove **01468** Spring and **01472** Tip Valve. Pick out **01464** Seal.
4. Using a 2.5 mm dia. drift pin, tap out **12132** Pin and remove throttle lever.
5. Remove **95558** Retaining Ring using retaining ring pliers.
6. Push **01469** Speed Regulator from housing.
7. Remove **01470** Insert Assembly and **95523** O-Ring.

To Assemble:

Important: Make sure parts are clean and in good condition before assembling.

Valve Stem/Body Assembly:

1. Install **95523** O-Ring onto **01470** Insert Assembly.
2. Install **01470** Assembly into valve body housing.
3. Insert **01469** Speed Regulator Assembly into valve body housing. Secure with **95558** Retaining Ring.
4. Secure valve body assembly in padded vise using **52296** Repair Collar with air inlet facing upward and throttle lever accessible.
5. Insert **01464** Seal into housing.
6. Line up the hole in **01449** Valve Stem with the hole in the housing (looking past brass bushing). Using needle nose pliers, insert **01472** Tip Valve so that the metal pin passes through the hole in the **01449** Valve Stem.
7. Install **01468** Spring (small end first) over tip valve.
8. Install **01564** Air Control Ring, onto **01494** Inlet Bushing.

9. Apply small amount of #567 Loctite® (or equivalent) to threads of **01494** Inlet Bushing and install into valve body. (Torque 23 N•m/200 in. lbs.).
10. Install **01448** Throttle Lever and **12132** Pin. Remove valve body assembly from vise.

Motor Assembly:

1. Place **01120** Rotor in a padded vise.
2. Slip **01010** Spacer onto **01120** Rotor.
3. Place a .002 shim into **01008** Bearing Plate as an initial spacing (**Note: 01121** Shim Packs contain .001 and .002 shims) and slip **01007** Bearing into plate.
4. Install **01007**, **01008** Bearing/Bearing Plate onto **01120** Rotor.
5. Tighten **04081** Rotor Nut onto **01120** Rotor, torque to 150 in. lbs.
6. Check the clearance between rotor and bearing by using a .001 feeler gauge, clearance should be at .001 to .0015. Adjust clearance by repeating steps 1–5 with different shim if necessary.
7. Once proper rotor/rate clearance is achieved, install well-lubricated **01011** Blades into **01120** Rotor. Dynabrade Air Lube P/N **95842** is recommended for lubrication.
8. Install **01013** Cylinder so it rests against the **01007** Bearing Plate. (Make sure that air inlet holes of cylinder are facing away from **01007** Bearing Plate).
9. Press **01015** Bearing into **01014** Bearing Plate. Press these parts onto **01120** Rotor. Be sure that pin and air inlet holes in bearing plate line-up with pin slot and air holes in cylinder. **Important:** Fit must be snug between bearing plates and cylinder. If too tight, rotor will not turn freely. Rotor must then be lightly tapped at press fit end so it will turn freely, while still maintaining a snug fit. A loose fit will not achieve the proper preload of motor bearings.
10. Install motor assembly in housing, make sure motor drops all the way into housing. Line-up air inlet holes in **01014** Bearing Plate with air inlet holes in housing.
11. Install exhaust control spacer, silencer and o-rings (if equipped) into lock ring. Install lock ring (small amount #567 Loctite® or equivalent) onto housing and torque to 34 N•m/300 in. lbs.
12. Motor adjustment must now be checked. With motor still mounted in vise, pull end of **01120** Rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt then increase preload or remove shim (see instructions 1–6). Also push end of **01120** Rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt then deload or add shim.
13. Motor should now be tested for proper operation at 90 PSIG. If motor does not operate properly, make necessary adjustments (see step 12).
14. Install drive wheel. (Torque to 3.5 N•m/30 in. lbs.)

Housing Assembly: Non-Vacuum

1. Place **15307** Tension Shaft into housing.
2. Apply one drop of #242 Loctite® (or equivalent) to **95217** Screw and tighten (torque to 3 N•m/28 in. lbs.). (Refer to housing diagram for proper location of **95217** Screw).
3. Install **15309** Dust Cover onto **15307** Tension Shaft.
4. Lubricate (#771 Loctite® or equivalent) inside of **15307** Tension Shaft and inside larger diameter of **15306** Tension Arm.
5. Install **95426** Spring into **15307** Tension Shaft and place **15306** Tension Arm over **95426** Spring.
6. Place **15308** Guide Post into **15306** Tension Arm, apply one drop of #242 Loctite® (or equivalent) to screw threads.
7. Compress tension arm and secure in place with **96335** Nut. (Torque to 3.0 N•m/28 in. lbs.)
8. Assemble **96334** Plug to **15306** Tension Arm.
9. With **40029** Motor Lock in place, install air motor assembly into housing and secure in place with lubricated (#771 Loctite® or equivalent) **95311** Screw.
10. Complete assembly by installing contact arm assembly, abrasive belt and place **15312** Belt Guard Assembly over housing, tighten **15329** Screw into housing.

Housing Assembly: Vacuum

1. Place **40362** Tension Shaft into housing.
2. Apply one drop of #242 Loctite® (or equivalent) to **95217** Screw and tighten (torque to 3.0 N•m/28 in. lbs.). (Refer to housing diagram for proper location of **95217** Screw).
3. Install **40637** Dust Cover onto **40362** Support Rod.
4. Lubricate (#771 Loctite® or equivalent) inside of **40362** Tension Arm.
5. Install **95426** Spring into **40362** Support Rod and place **40361** Tension Arm over **95426** Spring.
6. Place **40366** Guide Post into **95427** Screw, apply one drop of #271 Loctite® (or equivalent) to screw threads.
7. Compress tension arm and secure in place with **40366** Guide/**95427** Screw.
8. Adjust **95427** Screw so that **40361** Tension Arm slides freely, but not to loose.
9. Press **40025** Button onto **95425** Screw and apply one drop of #242 Loctite® (or equivalent) to threads.
10. Place **40365** Belt Guard over **40360** Housing, tighten **95425** Screws with **40025** Button into **40360** Housing (make sure guard does not slide around, yet loose enough to remove or install without difficulty).
11. With **40029** Motor Lock in place, install air motor assembly into housing and secure in place with **95311** Screw.

(continued on next page)

Assembly/Disassembly for Dynafile® II (continued)

12. Complete assembly by installing contact arm assembly, abrasive belt and **40370** Belt Guard.

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

Note: Motor should operate at between 18,000 and 20,000 RPM at 90 PSIG (6.2 Bar). RPM should be checked with a tachometer. Before operating, we recommend that 2-3 drops of Dynabrade Air Lube P/N – **95842** (or equivalent) be placed directly into the air inlet with the throttle lever depressed.

Important: The regular maintenance of any air tool will contribute to greater efficiency of tool and will prolong tool life. The failure of quality pneumatic air 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. Frequent drainage of water traps in air lines is recommended. Each tool on each drop should also be equipped with a secondary air processing unit. This consists of an in-line Filter-Regulator-Lubricator. All Dynabrade air tools must be used with a Filter-Regulator-Lubricator to maintain all warranties. Our warranty obligation is contingent upon proper use of our tools and cannot apply to equipment which has been subject to misuse such as unclean air, wet air or a lack of lubrication during the use of the tool.

Loctite® is a registered trademark of the Loctite Corp.

Abrasive Belts

Coated Aluminum Oxide

18" Long/Unit = 200 Belts

Grit	1/4" W	1/2" W	5/8" W	3/4" W
40	90220	90240	90260	90250
60	90221	90241	90261	90251
80	90222	90242	90262	90252
120	90223	90243	90263	90253
180	90224	90244	90264	90254
220	90225	90245	90265	90255
320	90226	90246	90266	90256
500	90227	90247	90267	90257

20-1/2" Long/Unit = 200 Belts

Grit	1/4" W	1/2" W	5/8" W	3/4" W
60	90303	90317	90341	90331
80	90304	90318	90342	90332
120	90305	90319	90343	90333

34" belts are used with optional 11350 Contact Arm Assembly. →

24" Long/Unit = 200 Belts

Grit	1/4" W	1/2" W
40	90415	90441
60	90417	90443
80	90419	90445
100	90420	90446
120	90421	90447
180	90423	90449
220	90424	90451
320	90425	90453
500	90426	90455

34" Long/Unit = 200 Belts

Grit	3/4" W
40	90366
60	90367
80	90368
100	90369
120	90370

Coated Aluminum Zirconia

18" Long/Unit = 200 Belts

Grit	1/4" W	1/2" W	5/8" W	3/4" W
60	90166	90168	90170	90172
80	90167	90169	90171	90173

24" Long/Unit = 200 Belts

Grit	1/4" W	1/2" W
60	90577	90579
80	90582	90583

24" Long Silicon Carbide/Unit = 200 Belts

Grit	1/4" W	1/2" W
60	90563	90567
80	90564	90568

Abrasive Impregnated Non-Woven Nylon

18" Long/Unit = 12 Belts

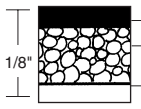
Grit	1/4" W	1/2" W	5/8" W	3/4" W
Super fine	90158	90159	90160	90161
Very fine	90228	90248	90249	90258
Medium	90229	90292	90293	90294
Coarse	90296	90297	90298	90299

24" Long/Unit = 12 Belts

Grit	1/4" W	1/2" W
Super fine	90397	90398
Very fine	90403	90400
Medium	90433	90434
Coarse	90460	90461

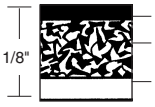
Dynapad® Platen Pads

Soft
For deburring and polishing contoured pieces.



11025 – 1/2" W x 7" L x 1/8" Thk. – 5/pkg.
11119 – 3/4" W x 7" L x 1/8" Thk. – 5/pkg.

Hard
For heavy deburring and polishing.



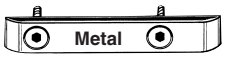
11026 – 1/2" W x 7" L x 1/8" Thk. – 5/pkg.
11109 – 3/4" W x 7" L x 1/8" Thk. – 5/pkg.

Thin
For aggressive grinding.



11027 – 1/2" W x 7" L x 1/32" Thk. – 5/pkg.
11129 – 3/4" W x 7" L x 1/32" Thk. – 5/pkg.

Metal
For flat grinding and heavy stock removal; bolts to contact arm.



11024 – 1/2" W x 3" L (for Dynafile I I I11286 Arm only)

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 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. Connect power source to tool. Be careful **not** to depress throttle lever in the process.
3. 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.
4. Always work off the return side of the abrasive belt. This will ensure superior tracking and reduce down time of tool.

Abrasive Belt/Contact Arm Change Instructions:

To Change Belt:

1. Disconnect power source.
2. Remove cover.
3. Pull back on tension arm assembly.
4. Remove and replace abrasive belt and cover.
5. Connect power source.
6. Adjust belt tracking by turning **95218** Rough Adjustment Knob to the left or right accordingly while machine is running.

To Change Contact Arm Assembly:

1. Disconnect power source.
2. Remove cover.
3. Pull back on tension arm assembly and remove abrasive belt.
4. Remove **95218** Rough Adjustment Knob.
5. Remove contact arm and replace with desired arm, making sure that the tab on the end of the arm is facing downward.
6. Replace **95218** Knob.
7. Install abrasive belt and cover.
8. Connect power source and adjust belt tracking by turning **95218** Knob to the left or right accordingly while machine is running.

Housing Angle Adjustment:

To pivot housing, loosen **95311** Screw on housing with the supplied 9/64" hex wrench (P/N – **95134**). Pivot housing to desired angle and retighten **95311** Screw.

Conversion of Air Motor to Die Grinder or Drill:

1. Remove cover and abrasive belt.
2. Loosen **95311** Screw.
3. Twist and pull housing from motor. Amount of force required may vary.
4. Slip **95049** – 3/16" Hex Wrench (supplied in Dynafile II Kits only) through the drive wheel and into the end of the drive shaft to prevent the drive shaft from rotating.
5. Using a wrench or pliers, twist the drive wheel counterclockwise and remove.
6. Hold the drive shaft with a 14 mm wrench (supplied in Dynafile II Kits only) and attach collet or drill chuck (see accessories on back page).
7. Use a 19 mm wrench (supplied in Dynafile II Kits only) to loosen and tighten collet cap.

Maintenance Instructions:

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

1. All Dynabrade air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example: if the tool specification 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.
2. An Air Line Filter-Regulator-Lubricator must be used with this air tool to maintain all warranties. Dynabrade recommends the following: **11405** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and positive-drip lubrication of pneumatic components. Operates 28 CFM @ 90 PSIG has 3/8" NPT female ports.
3. Frequent drainage of water traps in air lines is recommended.
4. Some silencers on air tools may clog with use. Clean and replace as required.
5. A Motor Tune-Up Kit (P/N **96044**) is available which includes assorted parts to help maintain and repair motor.

Safety Instructions:

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



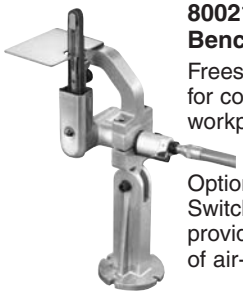
- **Warning:** Eye, face, respiratory, sound and body protection must be worn while operating power tools. Failure to do so may result in serious injury or death. Follow safety procedures posted in workplace.
- **Important:** User of tool is responsible for following accepted safety codes such as those published by the American National Standards Institute (ANSI).
- Tool RPM must never exceed abrasive/accessory RPM rating, regardless of tool capacity.
- Operate machine for 30 seconds before application to workpiece to determine if machine is working properly and safely before work begins.
- Always use proper guards. Make sure guards are in proper position, secure and in good repair.
- Always disconnect power supply before changing abrasive or making machine adjustments.
- Inspect abrasives and 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.

Machine Specifications

Model Number	Motor HP (W)	Motor RPM	Sound Level	Abrasive Belt Size Inch (mm)	Maximum Air Flow CFM/SCFM (LPM)	Max. SFPM (SMPM)	Weight Pound (kg)	Length Inch (mm)	Height Inch (mm)
40320	.5 (373)	20,000	80 dB(A)	1/4-3/4 (6-19) W x 18- 24 (457-610) L	4/28 (793)	4,550 (1,382)	2.5 (1.1)	14-1/4 (362)	4-7/8 (124)
40326	.5 (373)	20,000	80 dB(A)	1/4-3/4 (6-19) W x 18- 24 (457-610) L	4/28 (793)	4,550 (1,382)	2.5 (1.1)	14-1/4 (362)	4-7/8 (124)
40335	.5 (373)	20,000	80 dB(A)	1/4-3/4 (6-19) W x 18- 24 (457-610) L	4/28 (793)	4,550 (1,382)	2.5 (1.1)	14-1/4 (362)	4-7/8 (124)

Additional Specifications: Air Inlet Thread 1/4" NPT • Hose I.D. Size 3/8" or 10mm • Air Pressure 90 PSIG (6.2 Bars)

Accessories

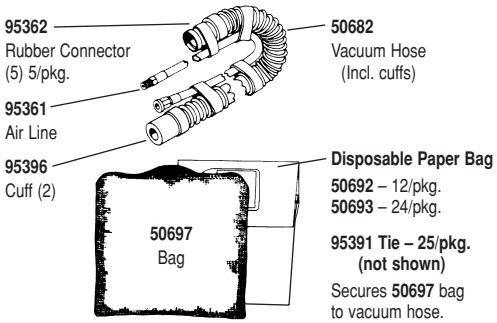


80021 Dynamount Benchmount

Frees an operators hands for complete control of a workpiece.

Optional **80015** Foot Switch and hose assembly provides on-off foot control of air-tool operation.

Vacuum Attachment for 40330 Vacuum Model Dynafile® II





Dynaswivel®

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
- **95461** 3/8" NPT
- **95462** 1/2" NPT



50010 1/4" Collet Assembly
50015 6mm Collet Assembly

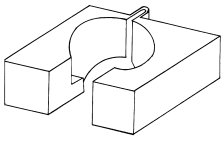
Optional:

50039 8 mm Collet Insert
Fits inside 50015 Collet

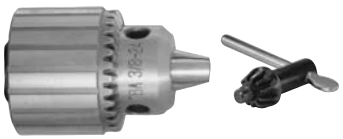
50065 1/8" Collet Insert
Fits inside 50010 Collet

52296 Repair Collar

- Specially designed collar for use in vise.



53032 1/4" Drill Chuck



Includes: 53052 Mated Chuck Key



96044 Motor Tune-Up Kit

Includes assorted parts to help maintain and repair motor.

Visit Our Web Site: www.dynabrade.com

Email: Customer.Service@Dynabrade.com

DYNABRADE®

DYNABRADE, INC., 8989 Sheridan Drive • Clarence, NY 14031-1490 • Phone: (716) 631-0100 • Fax: 716-631-2073 • International Fax: 716-631-2524
DYNABRADE EUROPE S.àr.l., Zone Artisanale • L-5485 Wormeldange—Haut, Luxembourg • Telephone: 352 76 84 94 1 • Fax: 352 76 84 95 1

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