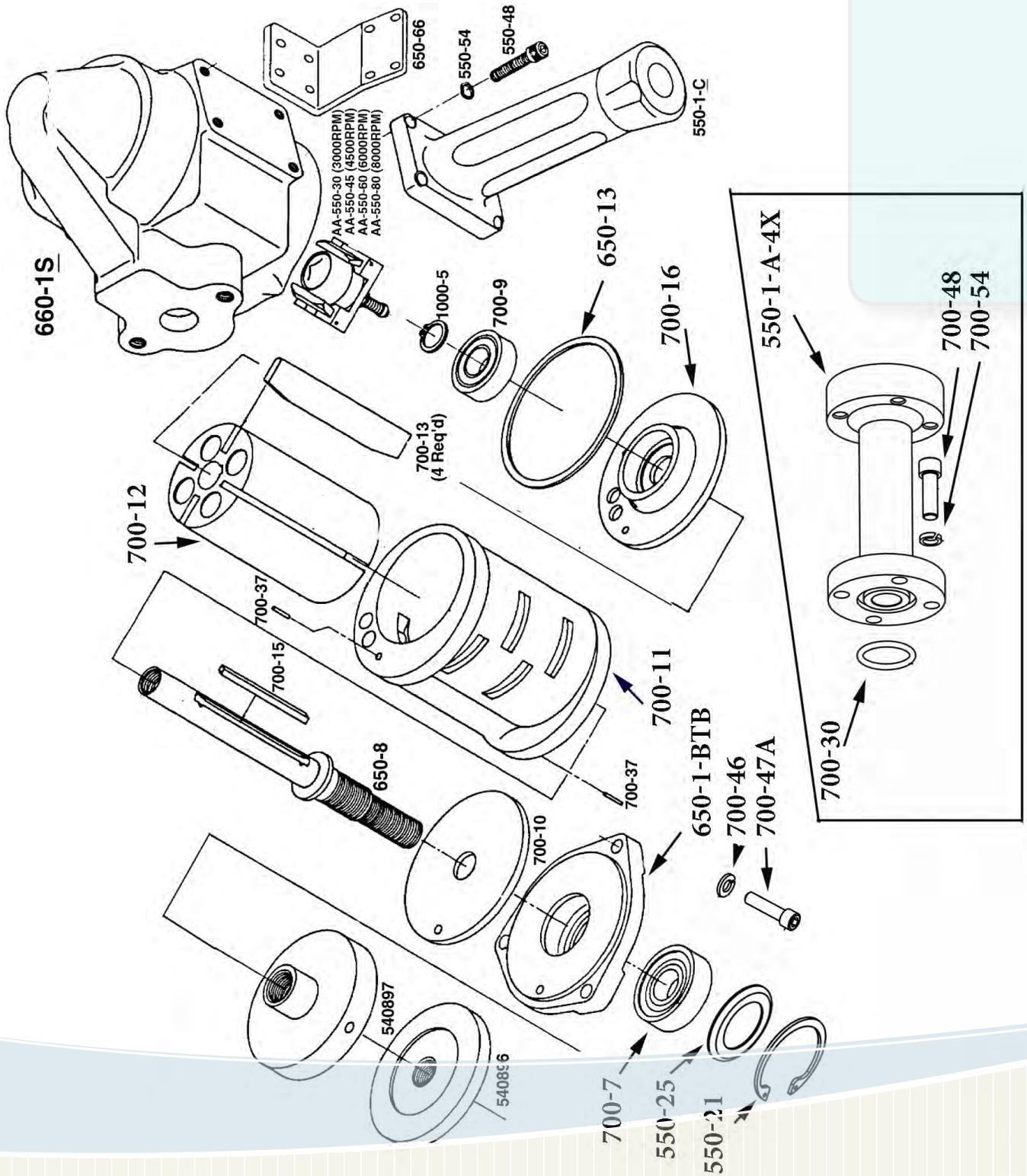


Models

65 VBW

4 H.P. Vertical Air Saw



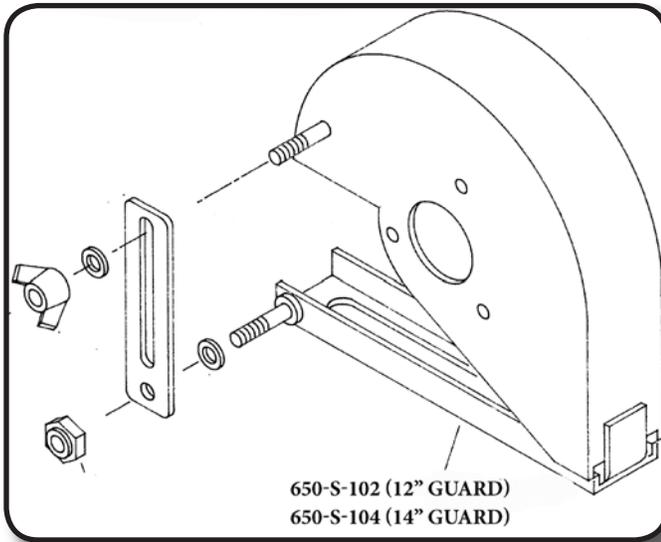
HENRY AIR TOOLS



Models

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4 H.P. Vertical Air Saw

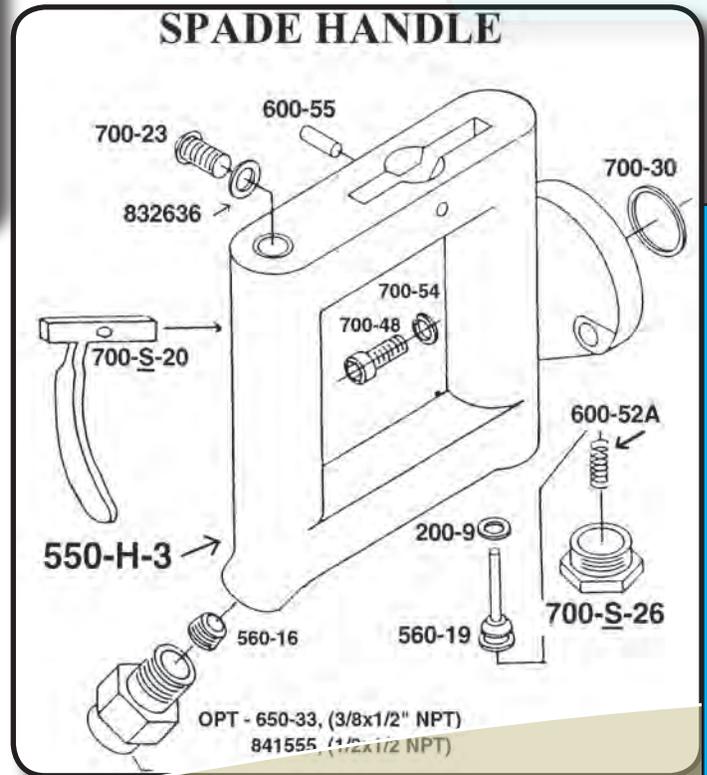


SPADE HANDLE PARTS & DESCRIPTION

- 200-9 O-Ring (413056)
- 550-H-3 Spade Handle (Bare)

- 560-19 Throttle Valve(For SPADE Handle)
- 600-51 Plunger Spring
- 600-55 Pin (for Spade Handle)
- 650-33 Screen Handle Bushing 1/2Mx3/8F

- 700-23 Screw (For Spade Handle)
- 700-30 "O"-Ring
- 700-48 Cap Screw (For Live Handle)(2 Reqd)
- 700-54 Lock Washer (High Collar)(2 reqd)
- 700-S-20 Trigger for Spade Handle
- 700-S-26 Plug (413290) (Thr. Valve)
- 832636 T.V. Cap Gasket
- 841555 Screen Handle Bushing 1/2x1/2



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PART NUMBER	DESCRIPTION
200-9	O-RING
550-1-C	DEAD HANDLE
540896	WHEEL FLANGE
540897	WHEEL WASHER FLANGE
550-H-3	D-HANDLE BODY
550-1-A-4X	HANDLE EXTENSION
550-21	SNAP RING
550-25	BEARING COVER
550-48	SCREW
550-49	PIN
550-54	WASHER (4 REQ.)
560-19	VALVE WITH O-RING INSTALLED
600-55	LEVER PIN
660-1-5	Case (Bare)with RPM tag installed
650-1-BTB	BEARING SUPPORT (new style)
650-1-BTG	GASKET (3 holed)
650-8	SPINDLE
650-13	GASKET
650-33	3/8-1/2 BUSHING
600-52A	SPRING
650-66	BRACKET
700-S-10	LEVER
700-6	LOCK RING (OLD STYLE) still supported by Henrytools
700-7	BEARING
700-9	BEARING
700-10	END PLATE
700-11	CYLINDER (with pins installed)
700-12	ROTOR
700-13	BLADE (4 are Req'd)
700-15	KEY
700-16	REAR END PLATE
700-23	SCREW

PART NUMBER	DESCRIPTION
700-30	O-RING
700-37	CYLINDER PIN
700-46	WASHER (4-8 REQ.)
700-47A	SCREW (4 REQ.)
700-48	SCREW
700-49	SCREW (Old Style)
700-54	WASHER
700-S-26	CAP
1000-5	SNAP RING
841555	1/2x1/2 BUSHING
GUARDS	
650-S-102	12" GUARD
650-S-104	14" Guard
WRENCHES	
1100-200	2" WRENCH
ASSEMBLIES	
AA-660-1-5	MOTOR CASE WITH ALL SCREWS INSTALLED
510124	REPAIR KIT
GOVERNORS	
AA-550-45	GOV. ASSY(4500RPM)
AA-550-60	GOV. ASSY(6000RPM)
AA-550-72	GOV. ASSY(7200RPM)
AA-550-80	GOV. ASSY(8000RPM)
• OTHER SPEEDS AVAILABLE	
ACCESSORIES	
AA-660-1-5	CASE WITH ALL SCREWS INSTALLED

REPAIR KIT	
510124	REPAIR KIT Includes the following:
	(1) 700-7 Bearing
	(1) 700-9 Bearing
	(1) 1000-5 Snap Ring
	(1) 650-13 Gasket
	(1) 650-1-BTG Gasket
	(4) 700-13 Blades
** We recommend Purchasing a 700-11 cylinder with your repair kit to restore your grinder to a new like condition.	

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SAFETY FIRST!

ALWAYS COMPLY WITH:

- 1.General Industry Safety & Health Regulations, Part 1910, OSHA 2206, available from: Sup't of Documents; Government Printing Office; Washington DC 20402
- 2.Safety Code for Portable Air Tools, ANSI B186.1 available from: American National Standards Institute, Inc.; 1430 Broadway; New York, NY 10018
- 3.State and Local regulations.

Portions of the above codes and regulations are listed below for quick reference.

THESE EXCERPTS ARE NOT INTENDED TO BE ALL INCLUSIVE - STUDY AND COMPLY WITH ALL REGULATIONS!

- 1.TOOL INTENT - Tools shall be used only for purposes intended in their design (refer to product catalog).
- 2.AIR SUPPLY - Test and operate tools at 90 PSIG maximum unless tool is marked otherwise. Use recommended airline filters-regulators-lubricators.
- 3.UNUSUAL SOUND or VIBRATION - If tool vibrates or produces an unusual sound, repair immediately for correction.
- 4.OPERATOR PROTECTIVE EQUIPMENT - Wear goggles or face shield at all times tool is in operation. Other protective clothing shall be worn, if necessary. SEE REGULATIONS.
- 5.SAFETY MAINTENANCE PROGRAM - Employ a safety program to provide inspection and maintenance of all phases of tool operation and air supply equipment in accordance with "Safety Code for Portable Air Tools."

WARNING: The signal word 'Warning' identifies all notes on safe work practices in this operating instruction, alerting to hazards for life and health of people. Observe these notes and proceed with special care in the cases described. Pass all safety instructions on to other operators. In addition to the safety instructions in this operating instruction, the general local safety and accident prevention rules must be observed.

Important Notes

CAUTION The signal word "caution!" identifies all portions of this operating instruction meriting special attention to ensure that guidelines, rules, hints and the correct work procedures are observed; and, to prevent damage to and destruction of the machine and/or parts.

A recommended spare part (or set) for every five (5) tools. Small, low cost or easily lost parts should be stocked as 3-4 per 10 tools.

WARNING' Disconnect the air supply hose before servicing the tool.

INSTALLATION

For most efficient operation, 90 psig (620 kPa) of clean dry air is required at the tool with the tool running, with-out extreme fluctuation. Minimum recommended hose size is 3/8" I.D. when the length of the hose is eight feet or less. An air line filter and lubricator, should be used. Hose should be blown out before attaching to the tool.

Loss of Power

A loss of power may not be related to the tool. First, check the air line pressure. It should be 90 psi at the tool while operating.

LUBRICATION

Lubricate the motor with an air line lubricator, using a light air motor oil. Adjust the lubricator to dispense one drop per cycle or three drops per minute.

CAUTION Do not use substitutes for oil and grease. This could result in damage to the tool.

MAINTENANCE

1. Proper and continuous lubrication.
2. Blow out air hose to assure a clean air supply.
3. Be sure the air filter and line lubricator are clean.
4. Fill the line lubricator before operation.
5. Place a few drops of oil into the air inlet of the tool before attaching the air line.
6. Use moisture separators to remove water from the air line.
7. **CAUTION** Do not use solvent on bearings or on any parts made of a synthetic material.
8. Do not remove bearings unless replacement is necessary; bearings are a press fit.

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DISASSEMBLY

1. Disconnect air and remove all wheels and accessories from grinder.
2. Secure the dead handle (550-1-C) of the grinder in a vice. Remove the three socket head screws (700-47A) and remove wheel guard.
3. Grasp the wheel flange (540897) and pull the complete motor assembly from the case. If the case is too tight, put 5/8-11 hex nut (700-34) on shaft and grip firmly in vise; using soft hammer, remove case assembly by tapping alternately at live and dead handle joints.
4. Put the flats of the wheel flange in the vise and remove governor. (NOTE: LEFT HAND THREAD)
5. Remove lock ring (1000-5). Holding the cylinder (700-11) in the left hand, place a long tap pin in the hole left by the removal of the governor. With a small hammer, tap lightly on the end of this pin, which separates the spindle (650-8) from the rear bearing (700-9) and the rear thrust (700-16). Remove cylinder (700-11), rotor blades (700-13) and rotor (700-12). Do not remove key (700-15) at this time.
7. Clamp spindle holder in vise vertically. Line up the keyway in the holder and slide the spindle assembly through. Remove wheel flange (right hand thread) with suitable wrench.
8. Remove spindle assembly from vice or holder. Remove key and press spindle out of bearing support. (650-1-BTB). Support bearing (700-7) and press spindle through. 9. Remove 550-21 snap ring with snap ring pliers. Remove spacer 550-25 and bearing 700-7.
10. To check throttle valve, unscrew plug (700-S-26) and lift out valve spring and plunger. Remove the "o" ring (200-9) with a sharp tool and replace with a new ring.

REASSEMBLY

1. Seat (700-7) bearing in bearing support (650-1-BTB), place 550-25 spacer rounded edges facing toward bearing and secure with 550-21 snap ring.
2. Press spindle into bearing support & through the (700-7) bearing.
3. Place key (700-15) into spindle keyway. 4. Clamp spindle holder in vise vertically. Line up the keyway in the holder and slide the assembly through.
5. Thread wheel flange (540897) clockwise by hand until wheel flange bottoms on bearing. Tighten down with suitable wrench. Remove assembly from spindle holder. Clamp wheel flange in vise.
6. Line up cylinder pin holes in the bearing support (650-1-BTB) and the front thrust (700-10).
7. Put key (700-15) in spindle keyway and slide rotor (700-12) down arbor and insert blades (700-13). Put cylinder (700-11) into place (NOTE: Numerous holes on top of cylinder face upwards toward you).
10. Slip rear bearing (700-9) in rear thrust (700-16) and press on spindle. (Press on inner race of bearing.) Be sure that short dowel pin in cylinder goes into hole in rear thrust (700-16).
11. Put lock ring (1000-5) on spindle. (There is no groove.)
12. Prior to reassembly inspect governor for gouges, nicks or dents. Screw governor (AA-550-XX) tight in rear spindle. (NOTE: THIS IS LEFT HAND THREAD) Oil governor and inside of motor.
13. Place gasket (650-13) in rear face of case.
14. Place gasket (650-1-BTG) over holes in the case of (660-1-S). Then

drop motor assembly package in case and line up holes in front bearing support with those in front of case.

15. Replace the guard by lining up guard holes with the motor holes. Install the three bolts (700-47A) and lockwashers (700-46). Tighten bolts down until snug then back off 1/2 turn.
16. Connect tool to air supply and apply air in several short bursts.
17. Now run tool and tighten down bolts evenly. (Alternating from corner to corner).
18. CHECK RPM WITH A RELIABLE TACHOMETER. TOOL MUST RUN AT OR BELOW SPEED THAT IS STAMPED ON THE TOOL.

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