

HENRY TOOLS

Industrial Airtools at Work

Models
 40-EHL
 40-BEHL
 40-EHLS
 40-BEHS
 40-EHS+6
 40-EH+6



General Safety and Maintenance Manual



Extended Length Die Grinder



Model Number	Exhaust Direction	Spindle Type and collet sizes	Throttle Type	Speed	Power Output	Case Material	Weight		Length	Diameter	Air Consumption
							Aluminum	Steel			
40EHL	Side	Erickson collet type: your choice of 1/8", 1/4", 5/16", 3/8" collet insert sizes	(L) Lever or (K) Safety Lever	15000-22000 R.P.M. (18000PM is standard)	0.9 H.P .675 W	(S) Steel or Aluminum	2.3 Lb	3.5 Lb (1.6 Kg)	12.7 inch (232 mm)	1.6 inches 41 mm	25 cfm (11.8 L/S)
							5/16", 3/8"				
40EHL+6"								4.5 Lb (2.1 Kg)	18.7 inch (475 mm)		

THE HENRY TOOL CO., MANUFACTURED BY HENRY TOOLS

498 So. Belvoir Blvd., South Euclid, OH 44121 U.S.A.

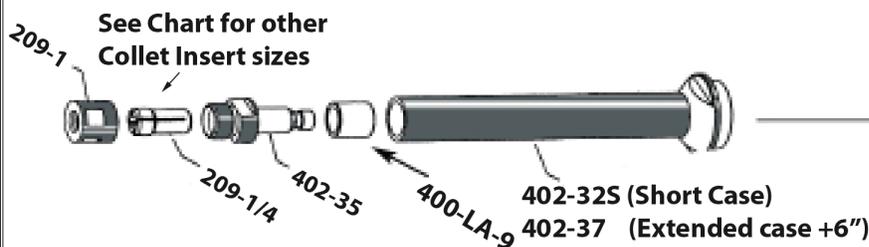
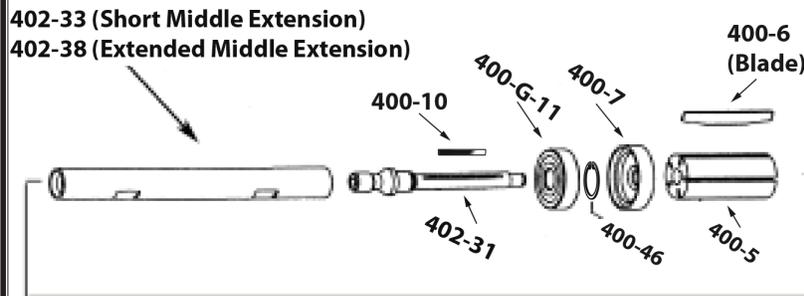
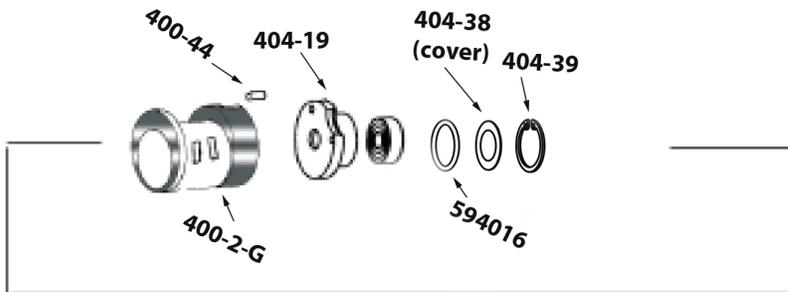
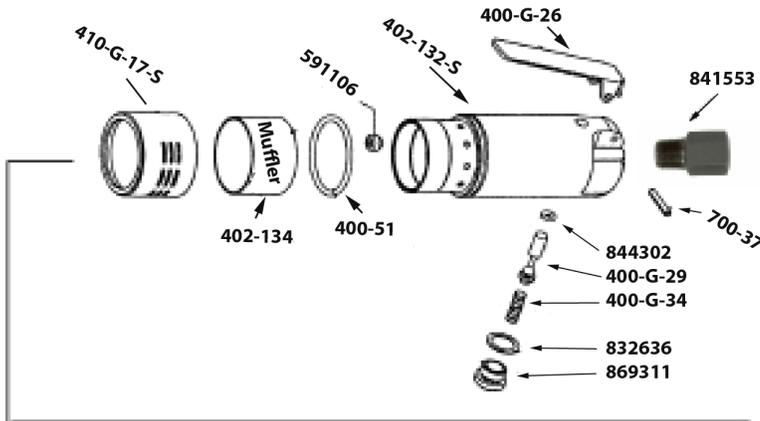
Ph: (216) 291-1011 or (800) 826-5257 • Fax: (216) 291-5949 or (800) 303-2800

Email: daviidh@msn.com • Website: www.Henrytools.com

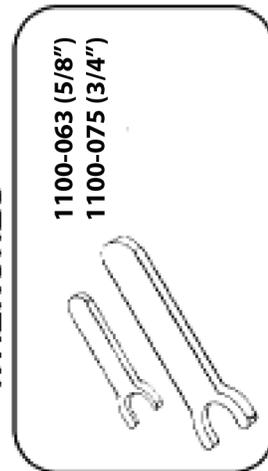
General Operators Instructions and Service Manual



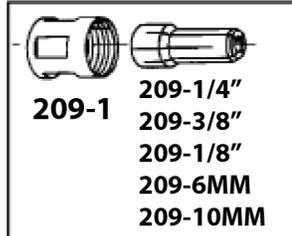
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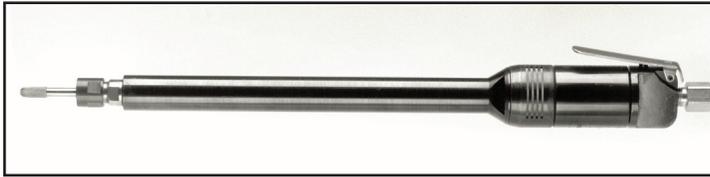
WRENCHES



COLLET & INSERTS



General Operators Instructions and Service Manual

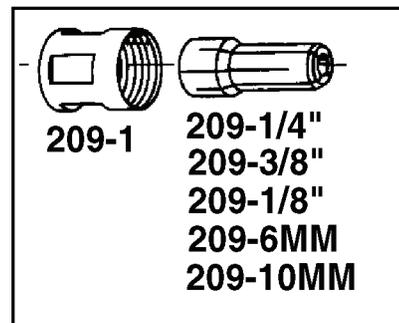


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PART NUMBER	DESCRIPTION
209-1	COLLET NUT
209-1/8	1/8" INSERT
209-1/4	1/4" INSERT
209-3/8	3/8" INSERT
400-G-11	FRONT BEARING
400-G-26	THROTTLE LEVER
400-G-29	THROTTLE VALVE-IN-CLUDES 844302
400-G-34	SPRING
400-LA-9	BEARING
400-2G	CYLINDER
400-5	ROTOR
400-6	BLADE (5 REQ)
400-7	FRONT ENDPLATE
400-10	KEY
400-44	ROLL PIN
400-46	SNAP RING
400-51	O-RING
402-31	MOTOR SPINDLE
402-32S	STEEL SHORT FRONT CASE
402-33	SHORT MIDDLE EXTENSION SPINDLE
402-35	DOUBLE ANGLE OUTPUT SPINDLE
402-37	STEEL LONG FRONT CASE
402-38	LONG MIDDLE EXTENDED SPINDLE
402-126	SAFETY LEVER
402-127	SAFETY LEVER PIN
402-128	LOCKOUT LEVER
402-129	SAFETY LEVER SPRING
402-132-S	STEEL CASE (SPECIFY SPEED)
402-134	MUFFLER
404-9	REAR BEARING
404-19	REAR ENDPLATE
404-38	BEARING COVER

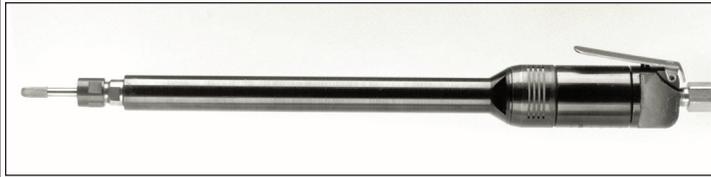
PART NUMBER	DESCRIPTION
404-39	SNAP RING
410-G-17-S	STEEL SIDE EXHAUST SLEEVE
700-37	THROTTLE LEVER PIN
591106	SET SCREW (SPECIFY SPEED)
592016	SNAP RING
594016	O-RING
832636	GASKET
841552	3/8 NPT TO 3/8 NPT BUSHING
841553	3/8 NPT TO 1/4 NPT BUSHING
844302	O-RING
869311	THROTTLE VALVE CAP
1100-063	5/8" WRENCH
1100-075	3/4" WRENCH
ASSEMBLIES	
510242	REPAIR KIT
402-26	SAFETY LEVER ASSY.
AA-402-132-K	ALUMINUM SAFETY CASE ASSY.
AA-402-132-S	STEEL CASE ASSY.
AA-402-132-SK	STEEL SAFETY CASE ASSY.
	SPECIFY SPEED FOR CASE ASSY.

COLLET & INSERTS



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DISASSEMBLY

1. Disconnect the air and remove all mounted points, and or grinding wheels from the grinder.
2. Secure tool in vise vertically clamping onto the (402-132-5) flats toward the rear of that housing.
3. Unscrew extension housing (402-32{5}) from motor housing. Remove exhaust deflector (410-G-17-5). Remove from vise.
4. Remove snap ring (404-39) from rear endplate (404-19) with use of snap ring pliers.
5. Lift out bearing cover 404-38) and o-ring (594016) if present.
6. Remove retaining ring (592016) if present.
7. Install brass jaws on vise. Secure motor assembly into vise vertically with output oriented toward the downward direction. Clamp lightly the outside diameter of the cylinder (400-2G) and endplate (404-19).
8. Use a 3/16" punch to tap spindle carefully out of rear bearing (404-9). Remove from vise.
9. Use a small punch to press the rear bearing from the rear endplate.
10. Remove 5 blades (400-6) and the rotor (400-5)
11. Unscrew and remove collet body (402-35) or motor spindle (402-31). Remove front extension housing. If spindle came apart between collet body and extension, remove extension spindle (402-33 or 402-38) from motor spindle. Remove from vise.
12. Remove key (400-10) and front endplate (400-7) from spindle. Remove snap ring (400-46) from spindle using snap ring pliers.
13. Support motor spindle assembly vertically on a suitable drill block. Press bearing (400-G-11) off of spindle.
14. If extension spindle is not still attached to output spindle, slip extension spindle back into housing and re-thread extension to output spindle.
15. Place extension housing in vise with output facing downward. Using a 3/16" punch, drive the spindle with bearing from extension housing (take care not to damage the threads in extension, or to drop the assembly when it becomes free).
16. Using 2 wrenches, unscrew the extension spindle from the output spindle. Remove needle bearing (400-LA-9).

ASSEMBLY

1. Be sure that all parts are clean and free of any abrasive.
2. Support front bearing (400-G-11) on a suitable drill block. Press the motor spindle (402-31) through bearing with an arbor press until it bottoms on the shoulder. Install snap ring (400-46) into groove on spindle using snap ring pliers.
3. Slide front endplate (400-7) over spindle and onto front bearing.
4. Grease front needle bearing (400-LA-9). Press bearing into front of extension housing (402-375) until bearing is flush with housing.
5. Place key (400-10) in keyway of spindle.
5. Clamp a suitable spindle holder in vise vertically. Slip spindle assembly into holder with threaded end toward upward direction. Thread extension spindle (402-33)

- onto rotor. Slip extension housing over extension spindle and against front motor bearing. Install output spindle (402-35) through needle bearing and thread into extension spindle. Tighten spindles onto rotor. Remove assembly from vise. Check that spindle turns freely.
6. Secure motor assembly into vise vertically with output oriented toward the downward direction. Clamp onto the flats at base of the front extension housing.
 8. With key still in place, slide rotor (400-5) over spindle.
 9. Place 5 blades (400-6) into slots of rotor.
 10. Slip cylinder (400-2G) over rotor. The locating pin should point toward back of tool.
 11. Install rear endplate (404-19) onto top of cylinder. Locate cylinder pin into small hole of rear endplate.
 12. Place bearing (404-9) in rear endplate and tap in place with a suitable bearing driver.
 13. Install snap ring (592016) in spindle groove.
 14. Place o-ring (594016) and bearing cover (404-38) into rear endplate.
 15. Install snap ring (404-39) into groove of rear endplate with snap ring pliers. Remove from vise.
 13. Secure motor housing (402-132) in vise vertically with output of tool oriented toward the upward direction. Clamp onto the flats toward the rear of the motor housing
 14. Place o-ring (400-51), exhaust screen (402-134) and exhaust deflector (410-G-17-5) onto motor housing.
 15. Slide front extension with motor assembly into motor housing. Tighten assemblies together.
 16. Check the operating speed with a reliable tachometer. The speed must be at or below the stamped speed on the tool.

This tool is designed to operate on 90 psig(6.2 bar) maximum air pressure with 1/4"(8mm) hose. Do not use any wheel having an operating speed lower than actual free speed on grinder.

GENERAL SAFETY

1. Check speed of tool with tachometer before every wheel & burr change or daily (which ever one is more frequent). If RPM exceeds rated speed stamped on tool, servicing is required.
2. At least on-half of the mandrel length (i.e. mounted wheel, carbide burr, etc.) must be inserted into the collet. Secure collet chuck tightly.
3. Before mounting or removing a mounted point or carbide burr disconnect grinder from air supply. The wheel should fit properly on arbor; do not use bushings or wheel flanges to adapt a wheel to any arbor unless recommended by manufacturer.
4. Wear safety goggles and other protective clothing. Continuous exposure to vibration may cause injury to hands and arms.
5. Properly maintained air tools are less likely to fail or cause accidents. IF TOOL VIBRATES UNUSUALLY OR PRODUCES AN UNUSUAL NOISE, REPAIR IMMEDIATELY.