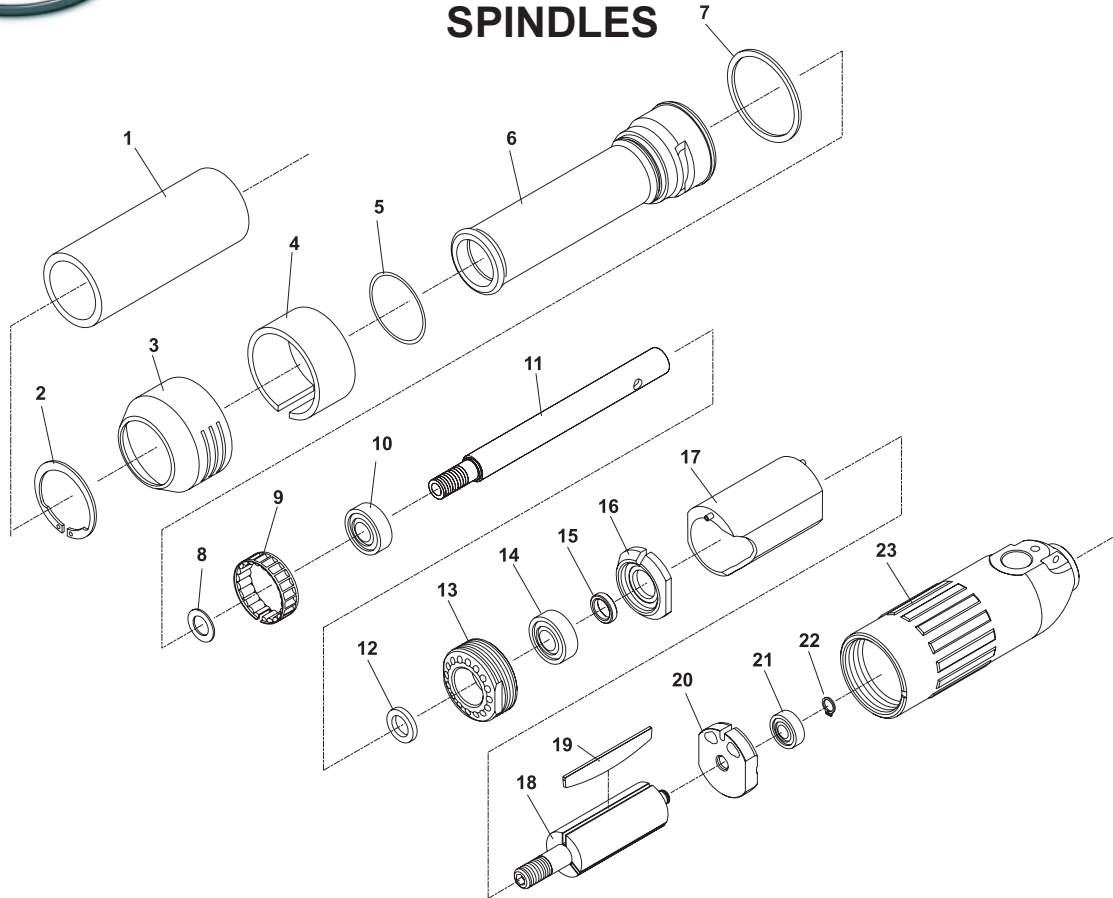




SERVICE INSTRUCTIONS FOR 1954HPEXT, 1955HPEXT, 1956HPEXT SPINDLES

Form Z560
Date 5-99/A
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DISASSEMBLY OF EXTENSION

1. Remove collet and nut (not shown).
2. Remove the washer (8).
3. Remove sleeve (1).
4. Remove retaining ring (2), deflector (3), and silencing pad (4).
5. Place a pin through the exhaust slot of the front housing (6) and the hole in the spindle extension (11). Unscrew the collet body (not shown) from the spindle extension. Remove the pin.
6. Unscrew the front housing (6) from the motor retainer (13).
7. Remove the washer (7).
8. Remove the motor retainer (13).
9. Remove the spindle extension/motor assembly from the housing (23).
10. Remove the rear snap ring (22).
11. Remove the rear end plate (20), bearing (21), cylinder (17) and vanes (19).
12. Clamp the rotor (9) in padded vice jaws.
13. Place a pin through the hole in the spindle extension (11) and unscrew from the rotor (18).
14. Press the bearing (10) off of the spindle (11).

ASSEMBLY OF EXTENSION

1. With the washer (12), bearing (14), spacer (15) and front end plate (16) assembled to the rotor (18) and with the rotor

- clamped in padded vice jaws, screw the spindle extension (11) onto the rotor. Secure the spindle extension to the rotor by placing a pin through the hole in the extension and tightening.
2. Assemble the remaining parts of the motor in the reverse order they were removed.
3. Install the spindle extension/motor assembly into the housing.
4. Install the motor retainer (13).
5. Install the tolerance ring (9) into the front housing (6).
6. Install the washer (7) on the motor retainer (13).
7. Screw the front housing (6) onto motor retainer (13).
8. Place the bearing (10) onto the spindle extension (11) and press into the front housing by pressing on the inner race only. Press the bearing until it bottoms on the spindle.
9. Place a pin through the exhaust slot of the front housing (6) and the hole in the spindle extension (11). Screw the collet body (not shown) onto the spindle extension. Remove the pin.
10. Install the silencing pad (4), deflector (3), and retaining ring (2).
11. Install the washer (8).
12. Install collet and nut (not shown).
13. Install sleeve (1).
14. If the spindle does not turn freely, tap the rear of the tool with a soft blow mallet to free up the spindle.

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