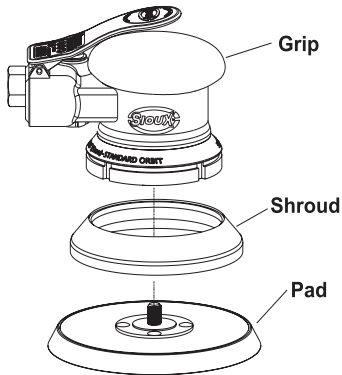


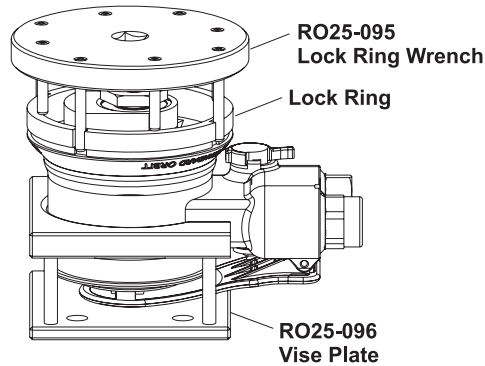


SIoux RO2512 SANDER SERIES DROP IN MOTOR KIT INSTRUCTIONS

Removing the motor



1. Remove Grip, Pad and Shroud.



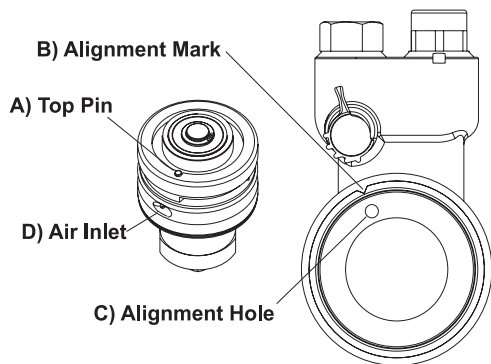
2. Secure Vise Plate by mounting to workbench or clamping in a vise.
3. Position tool in Vise Plate as shown.
4. Position Lock Ring Wrench on Lock Ring as shown. Use a 3/8" ratchet to remove Lock Ring.



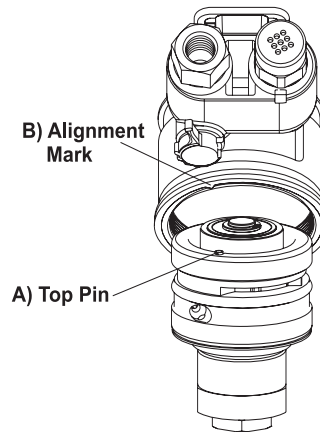
5. Remove Motor from Housing and remove Top Rubber Bushing from inside of Housing.

Installing the motor

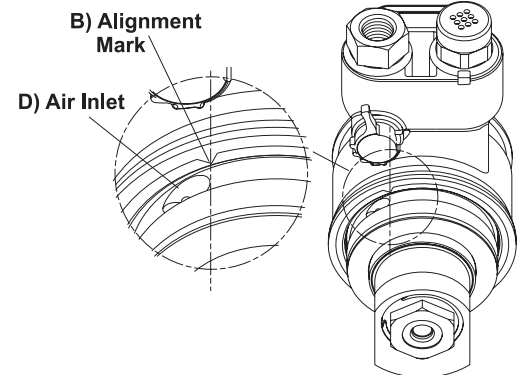
Important: Clean and inspect all parts prior to assembly. Replace any valve, exhaust, or vacuum components as necessary. Lubricate the motor o-ring and the sides of the top and bottom rubber bushings with Sioux No. 288 Air Motor Oil.



1. Observe the top pin on the motor assembly (A), the red alignment mark on the housing (B), and the alignment hole inside the housing (C).



2. Align the pin (A) with the mark (B) and gently insert the motor into the housing.



3. The edge of the motor's air inlet (D) should be tangent with the mark (B).

4. Add 2-3 drops of medium strength thread retaining compound to the threads of the Lock Ring.
5. Hand tighten the Lock Ring then use the Lock Ring Wrench and a torque wrench to tighten to 200 in-lb (22.5 N-m).
6. Reassemble the shroud, grip, pad and any vacuum components. ==> Lubricate the motor with with 3-4 drops of Sioux Air Motor Oil before connecting the sander to the air supply. Operate the sander for 30 seconds to assure proper operation and to disperse lubricant through the motor.

SIoux TOOLS INC.

250 SNAP-ON DRIVE ■ PO BOX 1596 ■ MURPHY, NC 28906 ■ USA ■

Printed In U.S.A.

This pdf incorporates the following model numbers:

RO25-RF, SPRO25-101, SPRO25-102, SPRO25-103, SPRO25-104, SPRO25-105,
SPRO25-106, SPRO25-107, SPRO25-108, RO1512