



INSTRUCTION GUIDE FOR 74922 SERVICE KIT
(For removing a 64186 backing hub from a damaged rotor
on a SPS10P Pistol Sander)

Form Z816
 Date 2012June28/A
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Note:

The fixture is intended to be used as a solution to remove a 64186 backing hub from a 74026 rotor in the case that the rotor's hexagonal broach has either stripped away, or has broken. The following procedure should only be conducted by tool maintenance professionals. Wear safety glasses.

Tools Needed:

- Service fixture & levers
- Vise
- Pliers (Needle-nose)
- Hand-held drill
- Size "P" Drill bit (.323 inch diameter)
- Cutting Fluid for Steel (preferred, not needed)

Explanation of Procedure:

The following procedure explains how to use the fixture to drill out the damage rotor threads using a hand-held drill. Upon being affixed properly, as described in the following steps, the fixture acts as an alignment tool to guide a drill bit directly into the rotor. Once the threaded area of the rotor is drilled out, a pair of needle-nose pliers can be used to easily separate the backing hub from the rotor.

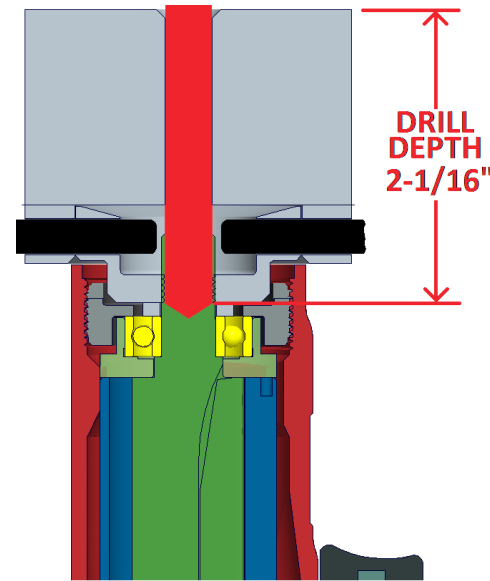

Process:	
<p>STEP 1</p> <p>Install the fixture onto the tool as shown. Note: The levers are inserted like alignment pins so that they pass through the fixture, and into the holes in the backing hub.</p>	
<p>Note: The backing hub should not be able to move. IF the backing hub is worn down, the hub could be able to rock back-and-forth in the fixture. Eliminate the slack by packing an even layer of cardboard, or even paper, into the fixture to compensate for the worn surface (see image). Any material is suitable as long as a drill bit can pierce through without any hesitation.</p>	<div style="display: flex; justify-content: space-around;">   </div> <p>MAKE SPACER IF NEEDED TO STABILIZE A HEAVILY WORN BACKING HUB IN THE FIXTURE</p> <p>SPACER INSTALLED</p>
<p>STEP 2</p> <p>Mount the fixture in a vice securely.</p>	



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<p>STEP 3</p>	<p>Use a hand-held drill equipped with a size "P" drill bit to drill out the threaded end of the damaged rotor. The drilling process may take a few minutes.</p> <p>Drill down to approximately 2-1/16" from the top of the fixture.</p> <p>Note: Using a cutting fluid will improve drilling speed and drill bit wear (preferred, but not needed).</p> <p>Caution: The pistol housing may fall freely from the fixture once the drill bit reaches the depth specified above.</p> <p>IF the backing hub remains on the tool after drilling, it is likely that a small amount of material is still present inside the drill path. If this occurs, remove the SPS tool from the fixture; stick the end of a pin/lever into one of the backing hub's side holes and rock the hub back and forth until it breaks free from the rotor.</p>	 
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The backing hub should now be removed.



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This pdf incorporates the following model numbers:

74922, 64186, SPS10P