

Robotic Wheel Grinders

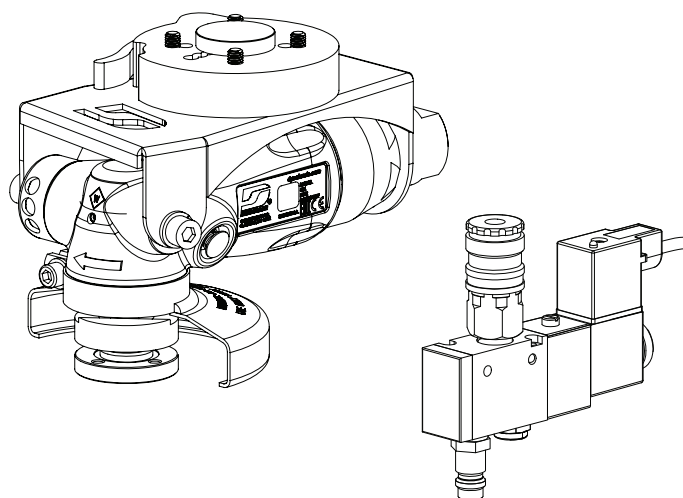
4", 4-1/2" & 5" Type 27 Right Angle Grinders

Safety, Operation and Maintenance – Save This Document and Educate All Personnel

Model	Wheel Size	RPM	Spindle Thread	Description
52630BK	4"	13,500	3/8"- 24	Kit
52630B	4"	13,500	3/8"- 24	Tool Only
52632BK	4-1/2"	13,000	5/8"- 11	Kit
52632B	4-1/2"	13,000	5/8"- 11	Tool Only
52633BK	5"	12,000	5/8"- 11	Kit
52633B	5"	12,000	5/8"- 11	Tool Only

GRINDER

**LIFETIME
WARRANTY**



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! WARNING

Read and understand this tool manual before operating your air tool. Follow all safety rules for the protection of operating personnel as well as adjacent areas. Always operate, inspect and maintain this tool in accordance with the American National Standards Institute (ANSI). Safety Requirements for abrading materials with coated abrasive systems – ANSI B7.1, and for abrading materials with coated abrasive systems – ANSI B7.7, Compressed Air and Gas Institute (CAGI) Safety Code for Portable Air Tools – B186.1, Code of Federal Regulation – CFR 29 Part 1910, International Organization for Standardization (ISO) Hand Held Non-Electric Power Tools – Safety Requirements and applicable State and Local Regulations.



Read and understand tool manual before work starts to reduce risk of injury to operator, visitors, and tool.



Eye protection must be worn at all times, eye protection to conform to ANSI Z87.1.



Ear protection to be worn when exposure to sound, exceeds the limits of applicable Federal, State or local statutes, ordinances and/or regulations.



Practice safety requirements. Work alert, have proper attire, and do not operate tools under the influence of alcohol or drugs.



Respiratory protection to be used when exposed to contaminants that exceed the applicable threshold limit values required by law.



Air line hazard, pressurized supply lines and flexible hoses can cause serious injury. Do not use damaged, frayed or deteriorated air hoses and fittings.

Some dust created by sanding, grinding, drilling, and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints
- Crystalline silica from bricks and cement and other masonry products
- Arsenic and chromium from chemically treated lumber

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

SAFETY and OPERATING INSTRUCTIONS



Carefully Read and Understand the General and Grinder sections found in Tool Safety and Operating Guidelines (PN00001676) Before Handling or Using Tool.

Carefully Read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool. Products offered by Dynabrade are not to be modified, converted or otherwise altered from the original design.

Tool Intent: 4", 4-1/2" and 5" Right Angle Grinders are ideal for material removal using Type 27 depressed center grinding wheels, or Type 27 abrasive flap disc wheels and is intended to be mounted and used on a robot only.

DO NOT USE Tool for Anything Other Than Its Intended Applications.

Training: Proper care, maintenance, and storage of your air tool will maximize tools performance and reduce chance for accident.

Employer's Responsibility: Provide operators with safety instructions and training for safe use of tools and accessories.

Report to Your Supervisor any Condition of the Tool, Accessories or Operation you Consider Unsafe.

MAINTENANCE INSTRUCTIONS

Important: To keep tool safe, a Preventative Maintenance Program is recommended. The program should include inspection of the tool and all related accessories and consumables, including air lines, pressure regulators, filters, oilers, etc. (refer to CAGI B186.1 for additional maintenance information). If accessory or tool breakage occurs, investigate failure to determine the cause and correct before issuing tool for work. Use the following schedule as a starting point in developing a Preventative Maintenance Program. If tool does not operate properly (RPM, vibration, start/stop) after these scheduled checks or at any time, the tool must be repaired and corrected before returning tool to use.

INSTALLATION

- To ensure long life and dependable service, use a Closed Loop Air System and Filter-Regulator-Lubricator (FRL) as diagramed below.
- Each tool should have its own dedicated hose connected to an air supply FRL. Quick disconnects should be installed at the FRL in an effort to reduce contamination into the tool. Securely affix all fittings and hose assemblies.
- It is strongly recommended that all Dynabrade rotary vane air tools be used with a Filter-Regulator-Lubricator to minimize the possibility of misuse due to unclean air, wet air or insufficient lubrication. Dynabrade recommends the following: **10690** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components.
- Dynabrade recommends 1 drop of air lube per minute for each 20 SCFM (example: if the tool specification states 40 SCFM, set the drip rate on the filter-lubricator to 2 drops per minute). **95842** Dynabrade Air Lube is recommended.

MAINTENANCE SCHEDULE

Maintenance schedules depend on the type and style of tool. Refer to page 3 to reference symbols associated with specific maintenance items/areas. Match maintenance schedules accordingly. See page 4 for any additional maintenance information.

Note: Turbine style air motors do not require oil.

Daily (every 8 hours):

- Inspect tool and accessories for damage or broken parts. Replace items as necessary to ensure proper operation and safety.
- **O** Lubricate motor as recommended. Use **95842** Dynabrade Air Lube (10W/NR). Apply 1 drop/minute of air lube per 20 SCFM.
- Check air line pressure with a gage. (MAX. 90 PSIG or 6.2 Bar operating pressure at the air inlet of the tool.)
- **W** Lubricate wick system and right angle gears through gear case fitting. Apply 3 plunges of **95848** Gear Oil. Use **95541** Lubricant Gun (Prime lubricant gun before use).
- Check tool for proper operation: If operating improperly or demonstrates unusual vibration, the tool must be serviced and problem corrected before further use.

Every 20 Hours/Once a Week (which ever comes first):

- Measure RPM (speed) by setting air pressure to 90 PSIG (6.2 Bar) at tool inlet, without accessory mounted, while the tool is running. Using tachometer, check spindle speed of the tool. Unless otherwise stated the

no-load speed may not exceed the rated speed. If tool speed exceeds maximum rated RPM, service as required and correct before use.

- If tool is running too fast: look for worn, damaged or missing governor, air control rings and silencer(s). Service as required.
- If tool is running too slow: look for malfunctioning governor, clogged inlet screen, silencer(s) or air stream. Service as required.

Note: Special care must be taken when servicing governors. Refer to specific tool manual for governor instructions and/or speed control devices. Governor assemblies made from molded plastic components are non-serviceable and must be replaced.

Every 50 Hours:

- **G** Lubricate planetary gears through gear case fitting with 3 plunges of **95544** Grease. Use **95541** Lubricant Gun. (Prime lubricant gun before use).

REPAIR

- Use only genuine Dynabrade replacement parts to ensure quality. To order replacement parts, specify Model#, Serial# and RPM of your air tool.
- Mineral spirits are recommended when cleaning the tool and parts. Do not clean tool or parts with any solvents or oils containing acids, esters, ketones, chlorinated hydrocarbons or nitro carbons.
- A Motor Tune-Up Kit is available which includes high wear and medium wear motor parts.
- Air tool markings must be kept legible at all times, if not, reorder housing and replace. User is responsible for maintaining specification information.

- After maintenance is performed on tool, add a few drops of **95842** Dynabrade Air Lube to the tool inlet and start the tool a few times to lubricate air motor. Verify RPM (per 20 hr maintenance schedule), vibration and operation.

HANDLING & STORAGE

- Use of tool rests, hangers and/or balancers is recommended.
- Protect tool inlet from debris (see Notice below).
- **Do Not** carry tool by air hose or near the tool throttle lever.
- Store accessories in protective racks or compartments to prevent damage.
- Follow the handling instructions outlined in the operating instructions when carrying the tool and when changing accessories.
- Protect accessories from exposure to water, solvents, high humidity, freezing temperature and extreme temperature changes.

END OF USE/DISPOSAL

When tool has reached its end of useful service, disassemble tool into its primary components (i.e. steel, aluminum and plastic) and recycle or discard per local, state and/or federal regulations as to not harm the environment.

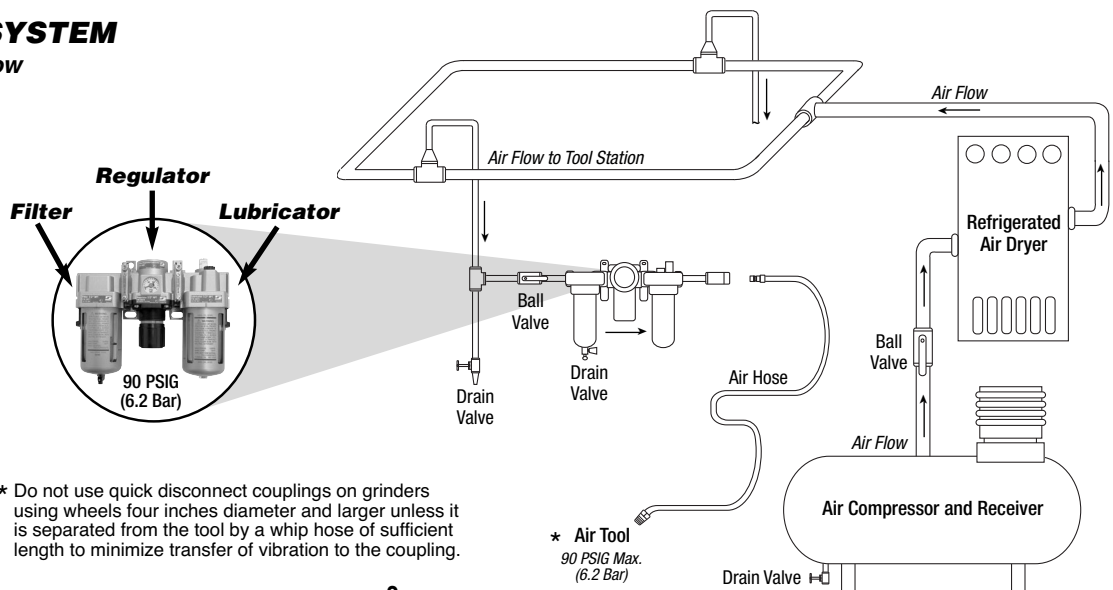
NOTICE

All Dynabrade air motors use the highest quality parts available and are manufactured to exacting tolerances. Air motor failures are often traced to lack of lubrication or unclean air supply. Compressed air can force dirt and other contaminants into motor bearings causing early failure. Contaminants can score cylinder wall and vanes resulting in reduced efficiency and power. Our warranty obligation is contingent upon proper use of our tools. Air motors which have been subjected to misuse, contaminated air or lack of lubrication will void warranty.

CLOSED LOOP AIR SYSTEM

Sloped in Direction of Air Flow

- Dynabrade Air Power Tools are designed to operate at 90 PSIG (6.2 Bar) maximum air pressure at the tool inlet, when the tool is running. Use recommended regulator to control air pressure.
- Ideally the air supply should be free from moisture. To facilitate removing moisture from air supply, the installation of a refrigerated air dryer after the compressor and the use of drain valves at each tool station is recommended.



Lubricator Setting

1 Drop/Minute per 20 SCFM

4", 4-1/2" & 5" Type 27 Right Angle Wheel Grinders

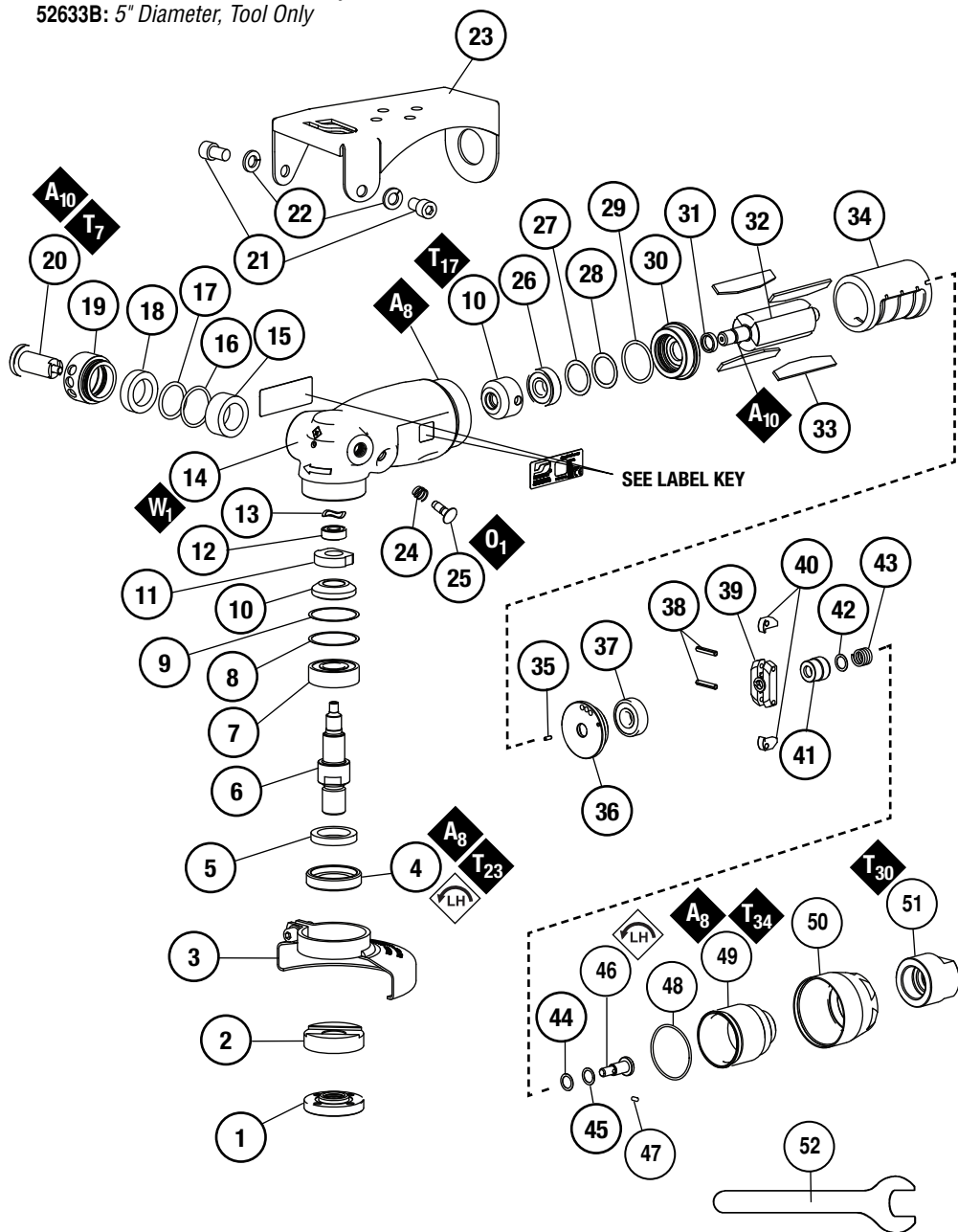
Dynabrade Grinders for Robots

Models

52630B: 4" Diameter, Tool Only

52632B: 4-1/2" Diameter, Tool Only

52633B: 5" Diameter, Tool Only



LABEL KEY

25285 - S/N, RPM Label

25286 - GRINDER WARNING

KEY

O Oil: O₁ = Air Lube

A Adhesive: A₈ = Loctite #567
A₁₀ = Loctite #243

T_x X = Torque Value (N•m)
(N•m x 8.85 = lb•in.)

W₁ Gear Oil: W₁ = 95848

Always follow adhesive manufacturers
cleaning and priming recommendations.

ITEM	P/N	DESCRIPTION	QTY.
45	25299	SHIM	AR
46	25292	GOVERNOR SPINDLE	1
47	25295	PIN	1
48	66435	O-RING	1
49	25256	GOVERNOR HOUSING	1
50	25257	CUP NUT	1
51	25307	ADAPTOR NUT INCLUDES 51938 SCREEN (2)	1
52	96148	4" MODEL - PIN SPANNER WRENCH	1
	94925	4 1/2" & 5" MODEL - PIN SPANNER WRENCH	1

ITEM	P/N	DESCRIPTION	QTY.
1	50318	4" GRINDER - LOCK FLANGE	1
	53696	4 1/2" & 5" GRINDER - LOCK FLANGE	1
2	50359	4" GRINDER - BACKUP FLANGE	1
	25262	4 1/2" & 5" GRINDER - BACKUP FLANGE	1
3	25214	4" GUARD ASSEMBLY - TYPE 27	1
	25212	4 1/2" GUARD ASSEMBLY - TYPE 27	1
	25215	5" GUARD ASSEMBLY - TYPE 27	1
4	25265	RETAINER, SPINDLE	1
5	53609	FELT SEAL	1
6	25268	4" GRINDER - 3/8-24" SPINDLE	1
	25270	4 1/2" & 5" GRINDER - 5/8-11" SPINDLE	1
7	01036	BEARING	1
8	98287	SHIM	AR
9	98288	SHIM	AR
10	25230	BEVEL GEAR SET	1
11	25264	WICK	1
12	02057	BEARING	1
13	98243	WAVE SPRING	1
14	HOUSING (INCLUDES 01041 GEAR OIL FITTING & 25275 BUSHING) 25309 25310 25305	4" MODEL 4 1/2" MODEL 5" MODEL	1
15	25283	SILENCER	1
16	98282	O-RING	1
17	98281	O-RING	1
18	25282	SILENCER	1
19	25278	MUFFLER COVER	1
20	25281	MUFFLER STEM ASSY	1
21	95492	SCREW	2
22	95042	WASHER	2
23	25306	MOUNTING BRACKET	1
24	98285	SPRING, SPINDLE LOCK	1
25	25273	PLUNGER ASSEMBLY INCLUDES 96156 O-RING	1
26	01007	BEARING	1
27	01293	SHIM	AR
28	01294	SHIM	AR
29	98242	O-RING	1
30	25236	FRONT END PLATE	1
31	01010	SPACER	1
32	25233	ROTOR	1
33	25234	MOTOR VANE SET	4
34	25235	CYLINDER	1
35	96441	COIL SPRING PIN	1
36	25237	REAR END PLATE	1
37	01206	BEARING	1
38	98279	PIN	2
39	25290	GOVERNOR CAGE	1
40	25291	GOVERNOR WEIGHT	2
41	25293	GOVERNOR VALVE	1
42	25297	SHIM: MODEL 52630B & 52632B ONLY	1
43	25294	GOVERNOR SPRING	1
44	25298	SHIM	AR

AR - "As Required"

4", 4-1/2" & 5" Type 27 Right Angle Wheel Grinder Kits

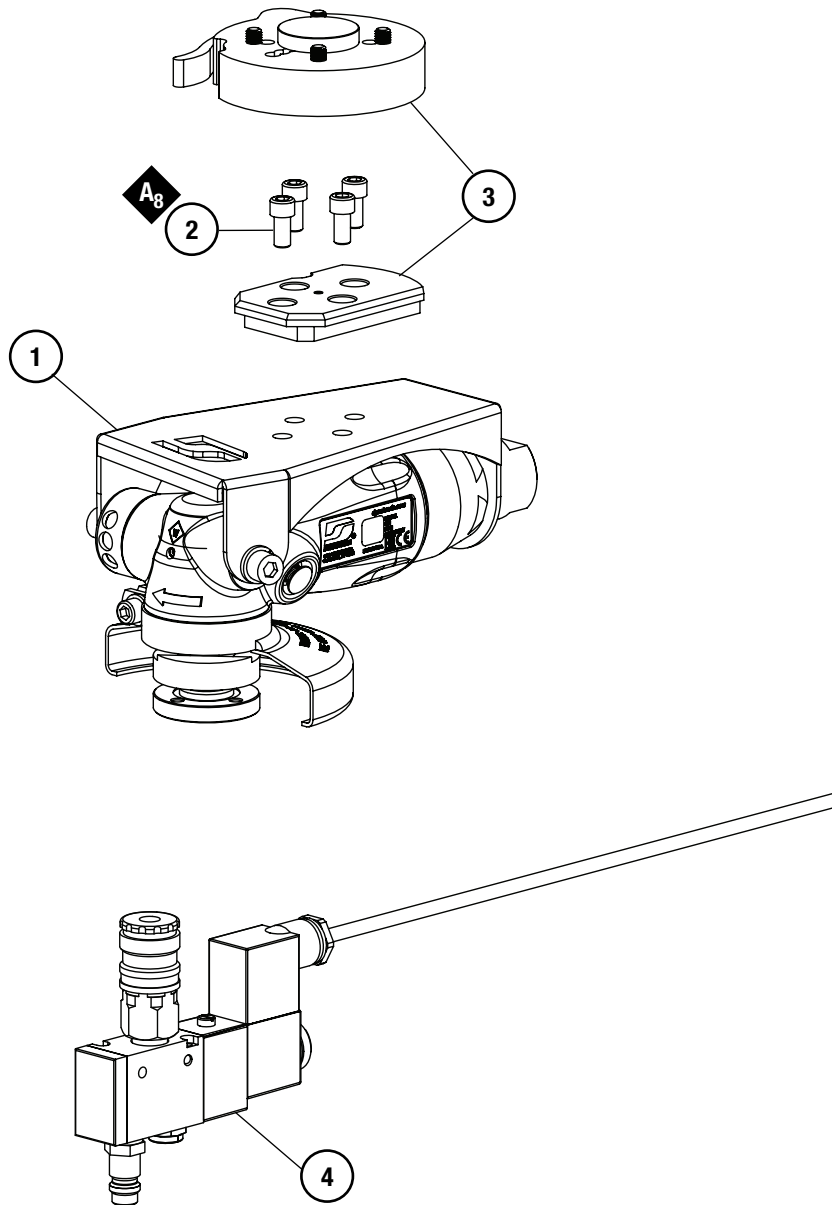
Dynabrade Grinders for Robots

Models

52630BK: 4" Diameter, Kit

52632BK: 4-1/2" Diameter, Kit

52633BK: 5" Diameter, Kit



ITEM	P/N	DESCRIPTION	QTY.
1	52630B	4" ROBOTIC GRINDER – RIGHT ANGLE – 13.5 K	1
	52632B	4 1/2" ROBOTIC GRINDER – RIGHT ANGLE – 13 K	1
	52633B	5" ROBOTIC GRINDER – RIGHT ANGLE – 12 K	1
2	95335	SCREW	4
3	58160	MILLIBAR TOOL CHANGER ASSEMBLY	1
4	58150	VALVE ASSEMBLY, SOLENOID – ROBOTIC	1

0	Oil: O ₁ = Air Lube	KEY
A	Adhesive: A ₈ = Loctite #567 A ₁₀ = Loctite #243	
T_x	X = Torque Value (N•m) (N•m x 8.85 = lb•in.)	
W₁	Gear Oil: W ₁ = 95848	
Always follow adhesive manufacturers cleaning and priming recommendations.		

LIFETIME WARRANTY

To validate Dynabrade Lifetime Warranty, you must register each tool at: www.dynabrade.com. Registration of each tool at website is required. Dynabrade will not honor Lifetime Warranty on unregistered tools. Please view the entire Lifetime Warranty Policy at : www.dynabrade.com.

MACHINE SPECIFICATIONS

Model	Wheel Size	Speed	Power	Air Consumption	Spindle Thread	Weight	Length	Height
52630BK	4"	13,500 RPM	1.3 hp (969 W)	43 SCFM (1218 LPM)	3/8" - 24	4.9 lbs. (2.2 kg)	7" (187 mm)	4.7" (119 mm)
52630B						4.2 lbs. (1.9 kg)		3.9" (99 mm)
52632BK	4-1/2"	13,000 RPM			5/8" - 11	5.1 lbs. (2.3 kg)		5" (127 mm)
52632B						4.4 lbs. (2.0 kg)		4.2" (106 mm)
52633BK	5"	12,000 RPM				5.3 lbs. (2.4 kg)		5" (127 mm)
52633B						4.6 lbs. (2.1 kg)		4.2" (106 mm)

Additional Specifications: Air Inlet Thread 3/8" NPT • Hose I.D. 3/8" (10 mm)
Visit dynabrade.com for your model's current vibration and sound data.

OPTIONAL ACCESSORIES



Motor Tune-Up Kit

Part No. 96815

- Includes assorted parts to help maintain and repair motor.



Male Plug - 3/8" NPT

Part No. 98263: 3/8" Body

Part No. 96005: 1/4" Body

- Provides up to twice the air flow compared to standard plug design.
- Plug has "ported" design to prevent "starving" of the air tool.



Backup Flange

Part No. 53697

- Mount high profile flap disc wheels with 7/8" center hole.



Dynabrade Air Lube

Part No. 95842: 1 pt. (473 ml)

Part No. 95843: 1 gal. (3.8 L)

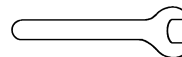
- Formulated for pneumatic equipment.
- Absorbs up to 10% of its weight in water.
- Prevents rust and formation of sludge.
- Keeps pneumatic tools operating longer with greater power and less down time.



Gear Oil

Part No. 95848: 2.5 oz.

- Formulated for Dynabrade geared tools utilizing a wick-type lubrication system.



Wrenches

98283 - Open End (1-5/8")

95281 - Open End (19mm)

95049 - Hex Key (3/16")



Push-type Grease/Oil Gun

Part No. 95541

- One-hand operation.

SPECIAL GREASE INSTRUCTIONS



Lubricate wick system through the angle gear oil fitting with 2-3 plunges for every 24 hours of use, to achieve maximum gear life. Prime pump to insure good oil flow.

Important: Use only the recommended angle gear oil for the wick system. Do not contaminate the wick with any other oil or grease product. Insure that all 3 plunges of oil are injected through the fitting. (Order **95848** Gear Oil and **95541** Gun)

REFERENCE CONTACT INFORMATION

American National Standards Institute (ANSI)

www.ansi.org

Compressed Air & Gas Institute (CAGI)

www.cagi.org

European Committee for Standardization (PNEUROP)

www.pneurop.org

International Organization of Standards (ISO)

www.iso.org

U.S. Government Publishing Office (GPO)

www.gpo.gov

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