AUTOMOTIVE

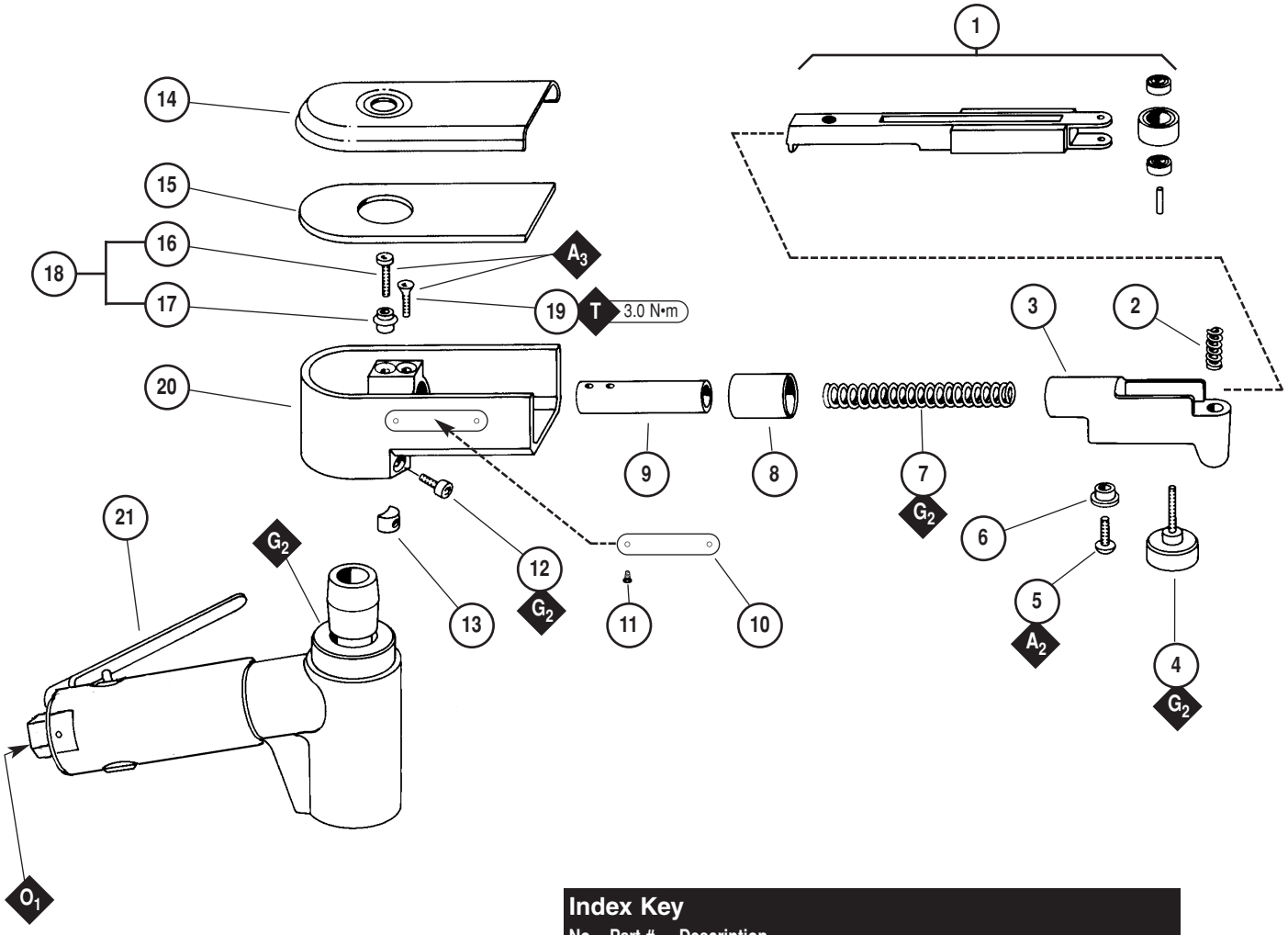
Parts Page Reorder No. APD07•08
Effective October, 2007
Supersedes: APD06•07

"4-in-1" Kit

Model:
18025

Air Motor and Machine Parts

WARNING **Always operate, inspect and maintain this tool in accordance with the Safety Code for portable air tools (ANSI B186.1) and any other applicable safety codes and regulations. Please refer to Dynabrade's Warning/Safety Operating Instructions for more complete safety information.**



KEY

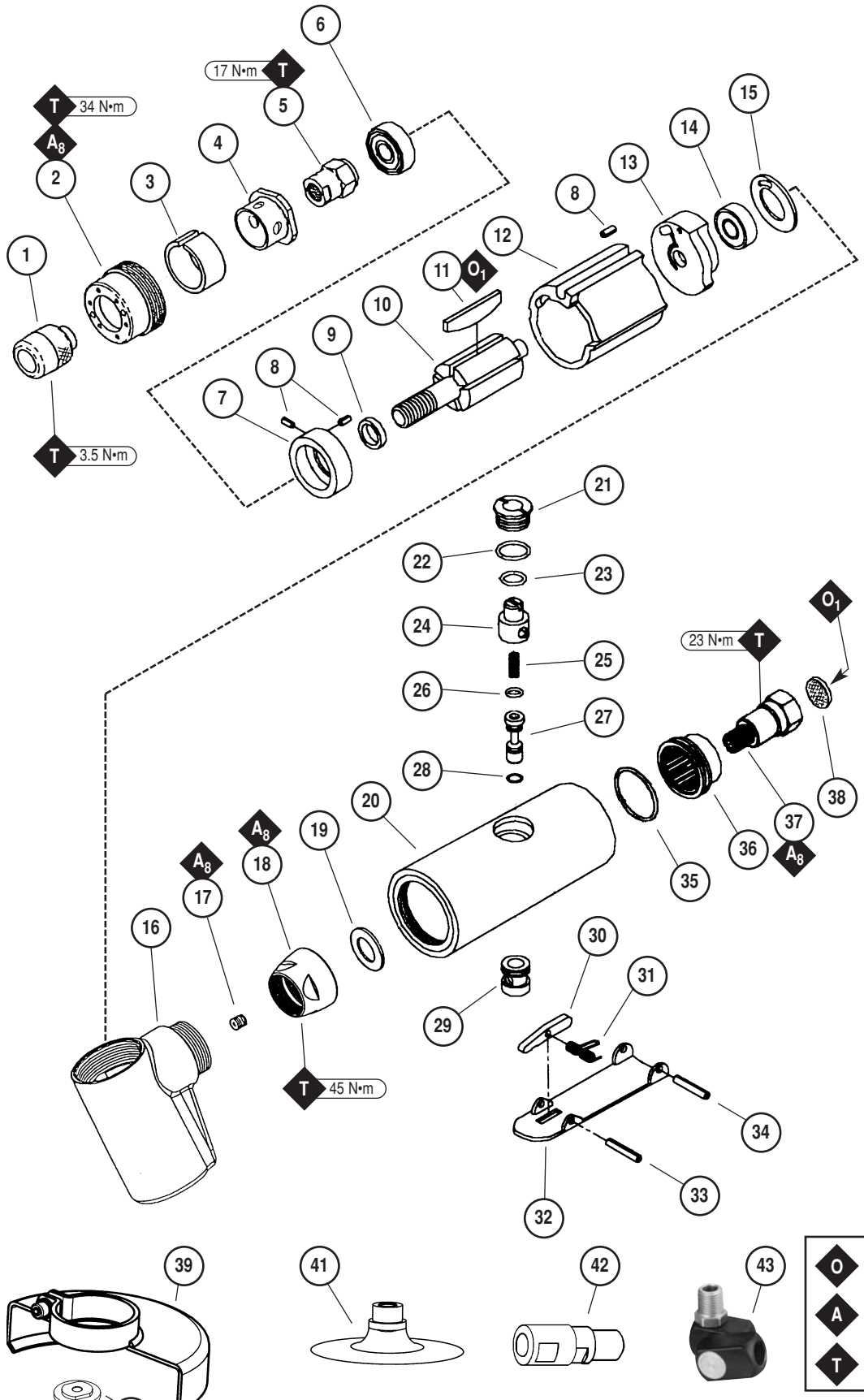
- O — Oil: O_1 = Air Lube
- G — Grease: G_2 = Loctite #771
- A — Adhesive: A_2 = Loctite #271, A_3 = Loctite #242
- T — Torque: N•m x 8.85 = In. - lbs.

Index Key

No.	Part #	Description
1	**11206**	Contact Arm Assembly
2	**11040**	Spring
3	**40361**	Tension Arm
4	**95218**	Knob
5	**95427**	Screw
6	**40366**	Guide
7	**95426**	Spring
8	**40367**	Dust Cover
9	**40362**	Support Rod
10	**18130**	Label
11	**95442**	Stick Screws (2)
12	**95311**	Screw
13	**40029**	Motor Lock
14	**40365**	Belt Guard (Incl. **40371** Gasket)
15	**40371**	Gasket
16	**95425**	Screw
17	**40025**	Button
18	**40314**	Button Latch Assembly
19	**95217**	Screw
20	**40360**	Housing
21	**18851**	Air Motor

See reverse side for Important Operating, Maintenance and Safety Instructions.

“4-in-1” Kit Air Motor Assembly



Index Key		
No.	Part #	Description
1	**18860**	Drive Wheel
2	**18864**	Lock Ring
3	**18863**	Silencer
4	**18862**	Air Control Ring
5	**18861**	Rotor Nut
6	**18827**	Bearing
7	**18874**	Front End Plate
8	**18821**	Pin (3)
9	**18825**	Rotor Spacer
10	**18870**	Rotor
11	**18823**	Rotor Blade (4/pkg.)
12	**18822**	Cylinder
13	**18820**	Rear End Plate
14	**18819**	Bearing
15	**18869**	Gasket
16	**18865**	7˚ Housing
17	**18867**	Plug
18	**18446**	Lock Ring
19	**18866**	Washer
20	**18400**	Housing
21	**18420**	Valve Screw
22	**18419**	O-Ring
23	**18418**	O-Ring
24	**18417**	Regulator
25	**18416**	Spring
26	**18415**	O-Ring
27	**18413**	Valve Stem
28	**18414**	O-Ring
29	**18412**	Valve Bushing
30	**18411**	Stop Rod
31	**18410**	Safety Lever Spring
32	**18408**	Throttle Lever
33	**18409**	Spring Pin
34	**18407**	Lever Pin
35	**18403**	O-Ring
36	**18868**	Exhaust Plug
37	**18405**	Air Inlet
38	**18439**	Filter
39	**50292**	3" Guard
40	**50269**	Flange Set
41	**51347**	Back-Up Pad
42	**50010**	1/4" Collet
43	**94300**	Dynaswivel®

KEY

- O Oil: **O_1 = Air Lube**
- A Adhesive: **A_8 = Loctite #567**
- T Torque: **N•m x 8.85 = In. - lbs.**

Autobrade Red Important Operating, Maintenance and Safety Instructions

Carefully read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool.
Warning: Hand, wrist and arm injury may result from repetitive work motion and overexposure to vibration.
Important: All Dynabrade air tools must be used with a Filter-Regulator-Lubricator to maintain all warranties.

Operating Instructions:

Warning: Eye, face, respiratory, sound and body protection must be worn while operating power tools. Failure to do so may result in serious injury or death. Follow safety procedures posted in workplace.

1. With power source disconnected from tool, securely fasten abrasive/accessory on tool.
2. Install air fitting into inlet bushing of tool. **Important:** Secure inlet bushing of tool with a wrench before attempting to install the air fitting to avoid damaging valve body housing.
3. Connect power source to tool. Be careful not to depress throttle lever in the process.
4. Check tool speed with tachometer. If tool is operating at a higher speed than the RPM marked on the tool or operating improperly, the tool should be serviced to correct the cause before use.
5. Air tools are not intended for use in explosive atmospheres and are not insulated for contact with electrical power sources. Sanding/Grinding certain materials can create explosive dust. It is the employers responsibility to notify the user of acceptable dust levels. Sanding/Grinding can cause sparks which can cause fires or explosions. It is the users responsibility to make sure the work area is free of flammable materials.

Maintenance Instructions:

1. Check tool speed regularly with a tachometer. If tool is operating at a higher speed than the RPM marked on the tool, the tool should be serviced to correct the cause before use.
2. Some silencers on air tools may clog with use. Clean and replace as required.
3. All Dynabrade rotary vane style air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example: if the tool specifications state 40 SCFM, set the drip rate of your filter-lubricator at 4 drops per minute). Dynabrade Air Lube (P/N **95842**: 1 pt. 473 ml.) is recommended.
4. An Air Line Filter-Regulator-Lubricator must be used with this air tool to maintain all warranties. Dynabrade recommends the following: **11405** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components. Operates 40 SCFM @ 100 PSIG has 3/8" NPT female ports.
5. Use only genuine Dynabrade replacement parts. To reorder replacement parts, specify the **Model #**, **Serial #**, and **RPM** of your machine.
6. Mineral spirits are recommended when cleaning the tool and parts. Do not clean tool or parts with any solvents or oils containing acids, esters, keytones, chlorinated hydrocarbons or nitro carbons.
7. DO NOT clean or maintain air tools with chemicals that have a low flash point (example: WD-40®).

Safety Instructions:

Products offered by Dynabrade should not be converted or otherwise altered from original design without expressed written consent from Dynabrade, Inc.



- **Important:** User of tool is responsible for following accepted safety codes such as those published by the American National Standards Institute (ANSI).
- Operate machine for one minute before application to workpiece to determine if machine is working properly and safely before work begins.
- Always disconnect power supply before changing abrasive/accessory or making machine adjustments.
- Inspect abrasives/accessories for damage or defects prior to installation on tools.
- Please refer to Dynabrade's Warning/Safety Operating Instructions Tag (Reorder No. **95903**) for more complete safety information.
- **Warning:** Hand, wrist and arm injury may result from repetitive work, motion and overexposure to vibration.

Autobrade Red Tool Warranty

Following the reasonable assumption that any inherent defect which might prevail in a product will become apparent to the user within **6 months** from the date of purchase, "Autobrade Red" tools are warranted against defects in workmanship and materials under normal use and service.
We shall, at our option, repair or replace at our factory, any "Autobrade Red" tool which shall, within 6 months after delivery to the original purchaser, indicate upon our examination to have been defective.

Our obligation is contingent upon proper use of "Autobrade Red" tools in accordance with factory recommendations, instructions and practices.
The warranty shall not apply in these cases:

1. Normally wearable parts such as bearings, rotor blades, etc.
2. Consumables such as sanding pads, etc.
3. Misuse, neglect in maintaining tool or tool modification.
4. Lack of lubrication or evidence of rust, dirt or corrosion.
5. Tools requiring normal tune-up or cleaning.
6. Tools being used after they are badly worn such as using ratchet with worn yoke.
7. Ratchets, anvils damaged by excessive hand torquing.
8. Use in production-type applications.

Products to be considered for warranty must be sent back to our factory, transportation prepaid by the user. Please send tool back to attention of "Repair Department" with note fully explaining the nature of the problem along with a copy of original invoice indicating model and serial number.

Return product to:
Dynabrade, Inc.
Attn: Repair Department
8989 Sheridan Dr.
Clarence, NY 14031



Visit Our Web Site: www.dynabrade.com

DYNABRADE®

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