

KEY

O	Oil	G	Grease
L	Loctite/Hernon: L ₂ = Hernon #940		
T	Torque: N•m x 8.85 = In. - lbs. T ₂ = 17 N•m, T ₃ = 23 N•m		

Parts Page Reorder No. PD97•01
Effective January, 1997
Supersedes PD92•27

Dynafile®

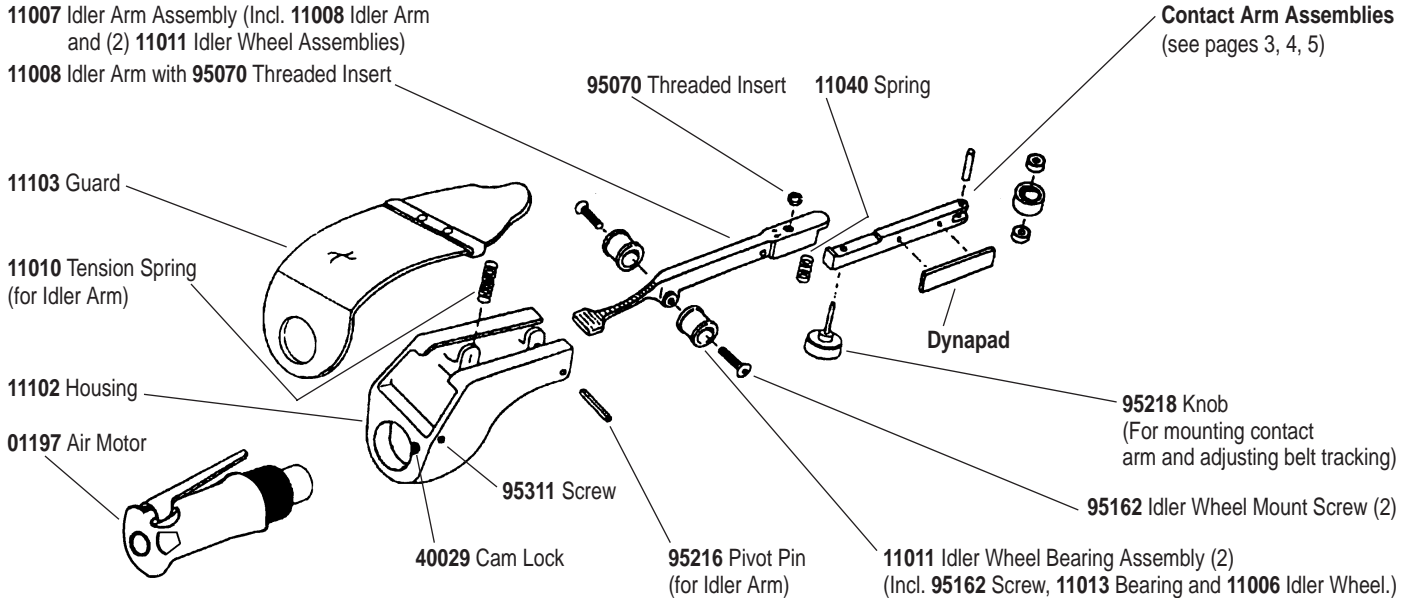
Abrasive Belt Machine.

For serial number 89292 and higher.

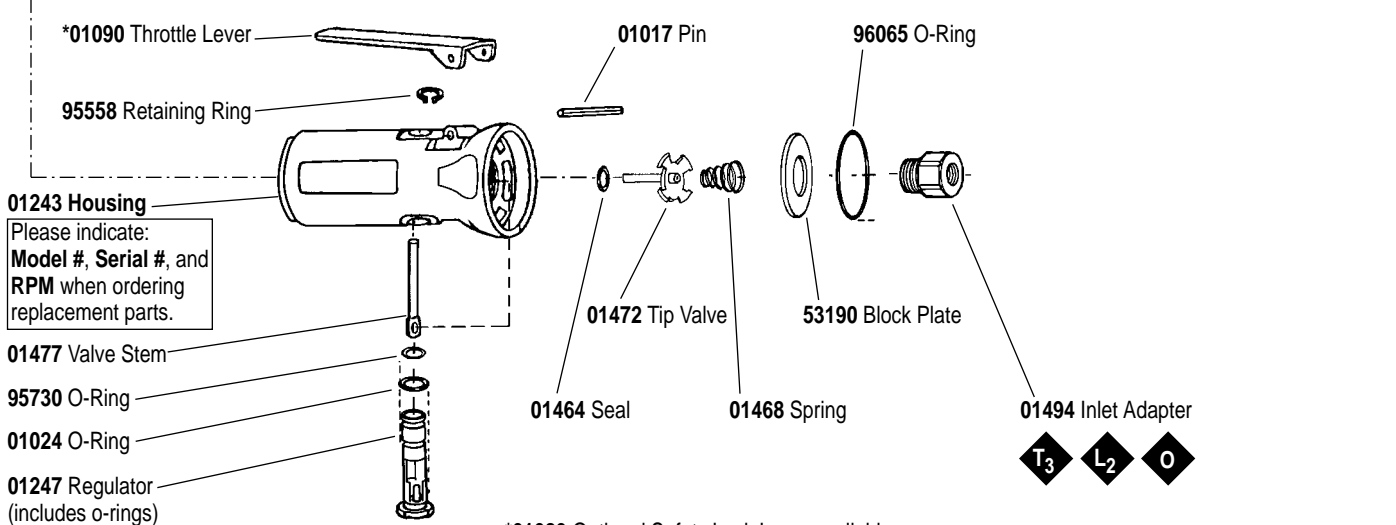
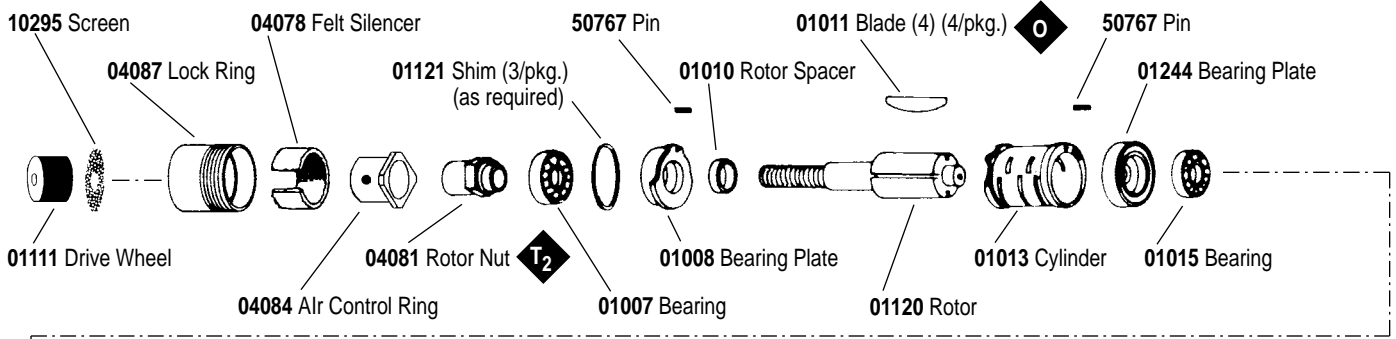
Model:
11000
11001 Versatility Kit
11003 w/Benchmount

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.



01197 Air Motor with 01111 Drive Wheel



*01089 Optional Safety Lock Lever available.

Note: 50971 Lock Ring Wrench is available for removal/installation of 04102 Lock Ring. See inside for Important Operating, Maintenance and Safety Instructions before operating tool.

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 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.

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 air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example : if the tool specification state 40 SCFM, set the drip rate of your filter-lubricator at 4 drops per minute). Dynabrade Air Lube (P/N **95842**: 1pt. 473ml.) is recommended.
4. An air line filter-regulator-lubricator must be used with this air tool to maintain all warranties. Dynabrade recommends the following: **11289** Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components. Operates 29 SCFM @ 90 PSI has 1/4" NPT female ports.
5. Use only genuine Dynabrade replacement parts. To reorder replacement parts, specify the **Model #**, **Serial #**, and **RPM** of your machine.
6. A motor tune-up kit (P/N **96044**) is available which includes assorted parts to help maintain motor in peak operating condition.
7. 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.

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.

Notice

All Dynabrade motors use the highest quality parts and metals available and are machined to exacting tolerances. The failure of quality pneumatic motors can most often be traced to an unclean air supply or the lack of lubrication. Air pressure easily forces dirt or water contained in the air supply into motor bearings causing early failure. It often scores the cylinder walls and the rotor blades resulting in limited efficiency and power. Our warranty obligation is contingent upon proper use of our tools and cannot apply to equipment which has been subjected to misuse such as unclean air, wet air or a lack of lubrication during the use of this tool.

One Year Warranty

Following the reasonable assumption that any inherent defect which might prevail in a product will become apparent to the user within one year from the date of purchase, all equipment of our manufacture is warranted against defects in workmanship and materials under normal use and service. We shall repair or replace at our factory, any equipment or part thereof which shall, within one year after delivery to the original purchaser, indicate upon our examination to have been defective. Our obligation is contingent upon proper use of Dynabrade tools in accordance with factory recommendations, instructions and safety practices. It shall not apply to equipment which has been subject to misuse, negligence, accident or tampering in any way so as to affect its normal performance. Normally wearable parts such as bearings, sanding pads, rotor blades, etc., are not covered under this warranty.

Machine Number	Length Inch (mm)	Height Inch (mm)	Weight Pound (kg)	Abrasive Belt Size Inch (mm)	Air Flow Rate SCFM (LPM)	Hose Size	Sound Level	Motor HP (W)	Motor RPM	Max. SFPM (SMPM)
11000	15" (381)	4" (102)	3 lbs. (1.4)	1/8" - 1/2" (3-13) W x 24" (610) L	29 (821)	3/8" (9 mm)	84 dBA	.5 (373)	20,000	5,800 (1,762)

Tool also meets these specifications: Air Inlet Thread 1/4" (6 mm) NPT • Air Pressure 90 PSI (6.2 Bars)

Disassembly/Assembly Instructions - Dynafile®

Important: Manufacturer's warranty is void if tool is disassembled before warranty expires.

Notice: A complete tune-up kit, part number **96044**, is available which includes assorted parts to help maintain motor in peak condition. These instructions are for use in conjunction with part number **11288** Dynafile Repair Kit, which includes special tools for proper disassembly/assembly of tool.. Please refer to parts breakdown for part identification.

To Disassemble:

1. Disconnect tool from power source.
2. Secure **11102** Housing in padded vise.
3. Remove **11103** Guard, abrasive belt, and contact arm assembly.
4. Remove **95216** Pivot Pin, using 8" long, 1/8" diameter drive pin punch (this will release the **11007** Idler Arm Assembly).
5. Remove **11010** Tension Spring.
6. Using 9/64" allen wrench loosen **95311** Screw and remove **01197** Air Motor from **11102** Housing.

Motor Disassembly:

1. Secure **01197** Air Motor in padded vise.
2. Remove **01111** Drive Wheel by inserting a 3/16" hex key through the drive wheel into the end of the **01120** Rotor.
3. Using a pipe wrench or pliers, twist **01111** Drive Wheel counter-clockwise and remove.
4. With an adjustable pin wrench remove **04087** Lock Ring by turning counter-clockwise. Remove **04078** Felt Silencer and air control ring.
5. Remove rotor nut from rotor shaft by inserting a 3/16" hex wrench through body and into rotor shaft. Twist rotor nut from shaft.
6. Pull motor assembly from housing.
7. Remove **01013** Cylinder, blades (4) and spacer from rotor. **Note: 01007** Bearing, **01008** Front Bearing Plate and spacer are a slip fit into rotor.
8. Press rotor from **01014** Rear Bearing Plate. Press **01015** Bearing from bearing plate.

Motor disassembly is complete.

Valve Body Disassembly:

1. Position valve body in padded vise using with air inlet facing up.
2. Remove air fitting by securing **01494** Inlet Adapter with a wrench and twist air fitting from inlet adapter.
Important: 01494 Inlet Adapter must be secured before attempting to remove air fitting to avoid damaging valve body housing.
3. Remove **53190** Block Plate.
4. Using needle nose pliers, remove **01468** Spring, **01472** Tip Valve and seal.
5. Using a 2.5mm drift pin, tap **01017** Pin from housing and remove throttle lever.
6. Remove **95558** Retaining Ring using retaining ring pliers.
7. Push **01247** Regulator from valve body housing and remove O-rings.

Disassembly is complete.

Motor Reassembly:

Important: Be sure parts are clean and in good repair before reassembly.

1. Place **01120** Rotor in padded vise with a threaded spindle facing upwards.
2. Slip **01010** Spacer onto rotor.
3. Place a .002" shim into front bearing plate as an initial spacing and slip **01007** Bearing into plate. Note: **01121** Shim Pak contains .001" and .002" shims.
4. Install bearing/bearing plate assembly onto rotor.
5. Install **04081** Rotor Nut onto assembly.
6. Tighten rotor nut onto rotor (torque to 17 N•m/150 in. - lbs.).
7. Check clearance between rotor and bearing plate by using a .001" feeler gauge. Clearance should be at .001" to .0015". Adjust clearance by repeating steps 1-4 with different shim if necessary.
8. Once proper rotor/gap clearance is achieved, install well lubricated **01011** Blades (4) into rotor slots. Dynabrade air lube P/N **95842** is recommended for lubrication.
9. Install cylinder over rotor. Be sure air inlet holes of cylinder face away from bearing plate.
10. Press **01015** Rear Bearing into **01014** Rear Bearing Plate. Press bearing/bearing plate assembly onto rotor. Be sure that pin and air inlet holes line-up with pin slot and air inlet holes in cylinder.
Important: Fit must be snug between bearing plates and cylinder. If too tight, rotor will not turn freely. Rotor must then be lightly tapped at press fit end so it will turn freely while still maintaining a snug fit. A loose fit will not achieve the proper preload of motor bearings.
11. Secure motor housing in padded vise so motor cavity faces upwards.
12. Install motor assembly into housing. Be sure motor drops all the way into housing.
13. Insert air control ring and **04078** Felt Silencer into **04087** Lock Ring and install onto motor housing (torque 17 N•m/150 in. - lbs.).
14. Motor adjustment must now be checked. With motor housing still mounted in vise, pull end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then increase preload or remove shim. Also, push end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then deload or add shim.
15. Install **10295** Screen and **01111** Drive Wheel.
16. Place **01102** Housing in a padded vise and install **01197** Air Motor.
17. Tighten **95311** Screw with 9/64" allen wrench.

(continued on next page)

Disassembly/Assembly Instructions - Dynafile®

18. Install **11010** Tension Spring, **11007** Idler Arm Assembly, and **95216** Pivot Pin
Important: Use 8" long, 1/8" diameter drive pin punch to line-up **11007** Idler Arm Assembly with **01102** Housing.
19. Install **11103** Guard, contact arm assembly and abrasive belt .

Valve Body Reassembly:

1. Insert **01247** Speed Regulator Assembly with O-rings into valve body. Secure with **95558** Retaining Ring.
2. Secure valve body in padded vise with air inlet facing upwards.
3. Insert **01464** Seal into housing.
4. Line up hole in valve stem with hole in housing (looking past brass bushing). Insert **01472** Tip Valve so that the metal pin passes through the hole in the valve stem. Install **01468** Spring (small end towards tip valve).
5. Install **53190** Block Plate into housing.
7. Apply Herson #940 PST Pipe Sealant to threads of **01494** Inlet Adapter and install valve body (torque 34 N•m/200 in. - lbs.).
8. Install **01093** Throttle Lever and **01017** Pin.

Tool Assembly is complete. Please allow 30 minutes for adhesives to cure before operating tool.

Important: Motor should now be tested for proper operation at 90 PSI. If motor does not operate properly or operates at a higher RPM than marked on the tool, the tool should be serviced to correct the cause before use. Before operating, place 2-3 drops of Dynabrade Air Lube (P/N **95842**) directly into air inlet with throttle lever depressed. Operate tool for 30 seconds to determine if tool is operating properly and to allow lubricating oils to properly penetrate motor. Loctite® is a registered trademark of Loctite Corp.

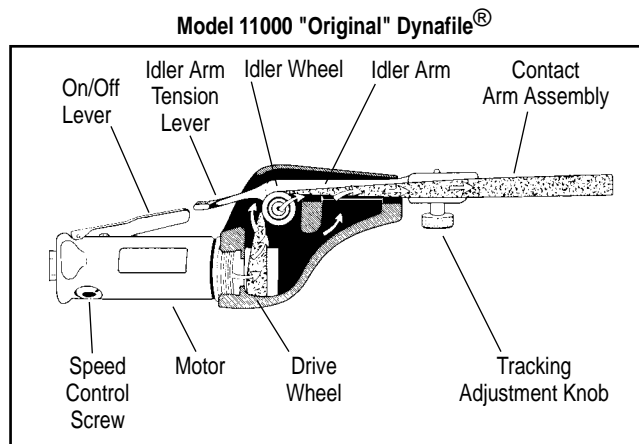
Abrasive Belt Change and Removal:

To Remove Belt:

1. Remove **11103** Guard by lifting front "lip" and unhooking latches.
2. Gently pull guard back off idler arm to expose internal workings of tool.
3. Depress idler arm lever and pull belt away from the contact wheel.
4. Slip belt over contact wheel.

To Replace Belt:

1. Create a loop with belt by pinching together the sides of belt in the middle.
2. Slip one loop under the **01111** Drive Wheel and around the idler arm.
3. Depress idler arm lever and pull belt toward the contact wheel.
4. Slip belt over contact wheel.
5. Connect tool to power source.
6. Adjust belt tracking using **95218** Knob.



Optional Accessories



Dynaswivel®

Swivels 360° at two locations which allows an air hose to drop straight to the floor, no matter how the tool is held.

- **95460** - 1/4" NPT
- **95461** - 3/8" NPT
- **95460** - 1/2" NPT
- **95734** - 1/4" NPT Flow Control
- **95852** - 1/8" NPT x 1/4" NPT



96044 Motor Tune-Up Kit:

- Includes assorted parts to help maintain motor in tip-top shape.

Dynaflex® Standard Contact Arms

Standard Contact Arms allow for a 4" workable reach.

11212

File round openings as small as 7/16".
45 PSI maximum.



Belt Size: 1/4" W x 24" L.

11066 Contact Wheel: 5/16" diameter x 1/8" wide, steel.

11034 Platen: 1/4" wide.

11213

See 11239 for heavy-duty version.
45 PSI maximum.



Belt Size: 1/2" W x 24" L.

11068 Contact Wheel: 5/16" diameter x 3/8" wide, steel.

11027 Platen: 1/2" wide.

11214

Work on contact wheel or Dynapad®.
45 PSI maximum



Belt Size: 1/2" W x 24" L.

11070 Contact Wheel: 7/16" diameter x 3/8" wide, rubber.

11025 Platen: 1/2" wide.

11215

Enter 1/2" x 1/2" openings.



Belt Size: 1/4" W x 24" L.

11072 Contact Wheel: 7/16" diameter x 1/8" wide, brass.

11034 Platen: 1/4" wide.

11216

Enter 5/16" x 3/4" openings.



Belt Size: 1/4" W x 24" L.

11074 Contact Wheel: 5/8" diameter x 1/8" wide, rubber.

11032 Platen: 1/4" wide.

11217

Enter channels as narrow as 9/16".



Belt Size: 1/2" W x 24" L.

11076 Contact Wheel: 7/16" diameter x 3/8" wide, steel.

11027 Platen: 1/2" wide.

11218

Standard arm on model 11000.
See 11228 for heavy-duty version.



Belt Size: 1/2" W x 24" L.

11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.

11025 Platen: 1/2" wide.

11219

No platen due to offset design.
Grind radiuses, slack polish.



Belt Size: 1/4" or 1/2" W x 24" L.

11080 Contact Wheel: 1" diameter x 3/8" wide, radiused rubber.

No Platen

11228 Heavy-Duty Steel

Optional 11028 Steel Platen
available for grinding.



Belt Size: 1/2" W x 24" L.

11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.

11025 Platen: 1/2" wide.

11231

See 11243 for heavy-duty version.



Belt Size: 1/2" W x 24" L.

11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.

11135 Platen: 1/2" wide.

11232 For 1/8" Wide Belts

V-Tapered

No platen due to offset design.
Grind corners, strap polish.



Belt Size: 1/8" or 1/4" W x 24" L.

11086 Contact Wheel: 1" diameter x 3/8" wide, tapered urethane.

No Platen.

11239 Heavy-Duty Steel

Grind in narrow areas.
45 PSI maximum.



Belt Size: 1/2" W x 24" L.

11068 Contact Wheel: 5/16" diameter x 3/8" wide, steel.

11027 Platen: 1/2" wide.

11243 Heavy-Duty

Grind over contact wheel or Dynapad®.



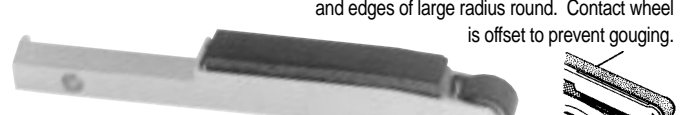
Belt Size: 1/2" W x 24" L.

11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.

11135 Platen: 1/2" wide.

11262 "Offset Arm"

For flat grinding using platen at or near corners
and edges of large radius round. Contact wheel
is offset to prevent gouging.



Belt Size: 1/2" W x 24" L.

11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.

11026 Platen: 1/2" wide.

Dynafile® Specialized Contact Arms

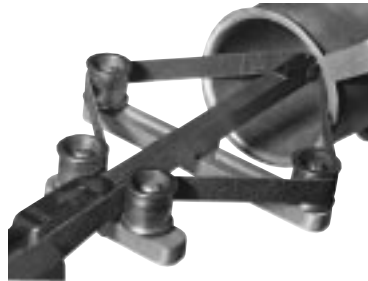
Designed to solve tough production problems.

11237 and 11238 Turbine Blade Arms



11237: 1/4" wide x 24" long belts.
11066 Contact Wheel: 5/16" dia. x 1/8" wide steel wheel.
11238: 1/2" wide x 24" long belts.
Contact Wheel: 1/4" dia. x 3/8" wide steel wheel.

11255 Cross-Bow Arm



- I.D. polishing or deburring with one 180° wrist turn.
- Deburr leading radius of 1" to 4" round openings.

Belt Size: 1/2" W x 34" L.

11234 Double-Burrer Arm



- Deburrs both edges of workpiece simultaneously.
- Contact wheels adjust for material 1/8" to 5/8" thick.

Belt Size: 1/2" wide x 34" long.
11080 Contact Wheels: 1" diameter x 3/8" wide, rubber.

11257, 11178 and 11179 Spear Arms



11257: Custom-made. Specify usable length up to 32". Specify **11068** - 5/16" diameter steel or **11078** - 5/8" diameter rubber contact wheel.

11178: Has 9" reach with 11068 - 5/16" diameter steel contact wheel.
Belt Size: 1/2" W x 34" L (45 PSI Max.).

11179: Has 9" reach with **11078** - 5/8" diameter rubber contact wheel.
Belt Size: 1/2" W x 34" L.

11240, 11241, 11244 and 11245 Extra-Length Arms



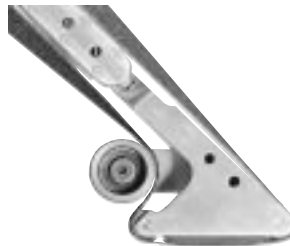
9" Workable Reach:

11240 Arm: **Belt Size:** 1/2" W x 34" L belts.
11078 Contact Wheel: 5/8" dia. x 3/8" wide, rubber.
11241 Arm: **Belt Size:** 1/4" W x 34" L belts.
11074 Contact Wheel: 5/8" dia. x 1/8" wide, rubber.

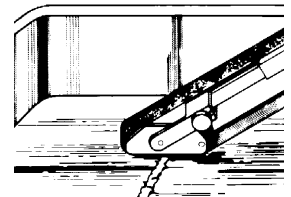
14" Workable Reach:

11244 Arm: **Belt Size:** 1/2" W x 44" L belts.
11078 Contact Wheel: 5/8" dia. x 3/8" wide, rubber.
11245 Arm: **Belt Size:** 1/4" W x 44" L belts.
11074 Contact Wheel: 5/8" dia. x 1/8" wide, rubber.

11258 Stroke Sander Arm



Blend stainless steel.



Belt Size: 1/2" W x 24" L.
11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.
Platen: 1/2" W x 7/8" L.

11254 Big Wheel Arm



- Grinds and polishes deep slots or narrow groves.
- 1/4" to 1/2" wide wheels, 2-1/8" to 4-3/4" diameter (specify size).

Belt Size: 1/4" to 1/2" W x 34" L.

11253 Arms (specify width)

11377 Contact Wheel: 2-1/8" dia. x 1/2" wide, urethane.
11378 Contact Wheel: 2-1/8" dia. x 1/4" wide, urethane.

11254 Arms (specify width)

11375 Contact Wheel: 4-3/4" dia. x 1/2" wide, urethane.
11375 Contact Wheel: 4-3/4" dia. x 1/4" wide, urethane.

11297 Guide-Cut Arm



- Guide wheels prevent undercutting.
- Removes raised material within .020" or less.
- Use 60 to 80 grit abrasive belts with this arm.

Belt Size: 1/2" W x 24" L, 60 to 80 grit.
11090 Contact Wheel: 5/8" diameter x 3/8" wide rubber.

Dynaflex® Standard Contact Arm Assemblies

Part Number	Abrasive Belt Size	Contact Wheel Description	Comments	Contact Wheel Assembly	Contact Wheel Only	Bearing (2) Req.	Shaft
11178	1/2" x 34"	5/16" Dia. x 3/8" W Steel	9" Reach	11068	11067	11051	11054
11179	1/2" x 34"	5/8" Dia. x 3/8" W Rubber	9" Reach	11078	11077	11052	11054
11212	1/4" x 24"	5/16" Dia. x 1/8" W Steel	1/4" W Platen	11066	11065	11051 (1)	11056
11213	1/2" x 24"	5/16" Dia. x 3/8" W Steel	1/2" W Platen	11068	11067	11051	11054
11214	1/2" x 24"	7/16" Dia. x 3/8" W Rubber	1/2" W Platen	11070	11069	11051	11054
11215	1/4" x 24"	7/16" Dia. x 1/8" W Brass	1/4" W Platen	11072	11071	11052 (1)	11053
11216	1/4" x 24"	5/8" Dia. x 1/8" W Rubber	1/4" W Platen	11074	11073	11052 (1)	11053
11217	1/2" x 24"	1/2" Dia. x 3/8" W Steel	1/2" W Platen	11076	11075	11052	11054
11218	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen	11078	11077	11052	11054
11219	1/4" or 1/2" x 24"	1" Dia. x 3/8" W Radiused Rubber	No Platen	11080	11079	11052	11054
11228	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	H.D. Version of 11218 Arm	11078	11077	11052	11054
11231	1/2" x 24"	3/4" Dia. x 1/2" W Rubber	1/2" W Platen	11084	11083	11052	11055
11232	1/8" or 1/4" x 24"	1" Dia. x 3/8" W Tapered Urethane	No Platen	11086	11085	11052	11054
11234	1/2" x 34"	1" Dia. x 3/8" W Radiused Rubber	Double Burrer Arm	11080 (2)	11079 (2)	11052	N/A
11237	1/4" x 24"	1/4" Dia. x 1/8" W Steel	Polish Turbine Blades	11066	11065	11051 (1)	11053
11238	1/2" x 24"	1/4" Dia. x 3/8" W Steel	Polish Turbine Blades	11051 (3) and 11054	11051 (3)	N/A	11054
11239	1/2" x 24"	5/16" Dia. x 3/8" W Steel	H.D. Version of 11213 Arm	11068	11067	11051	11054
11240	1/2" x 34"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen - 9" Reach	11078	11077	11052	11054
11241	1/4" x 34"	5/8" Dia. x 1/8" W Rubber	1/4" W Platen - 9" Reach	11074	11073	11052 (1)	11053
11243	1/2" x 24"	3/4" Dia x 1/2" W Rubber	H.D. Version of 11231 Arm	11084	11083	11052	11055
11244	1/2" x 44"	5/8" Dia. x 3/8" W Rubber	1/2" W Platen - 14" Reach	11078	11077	11052	11054
11245	1/4" x 44"	5/8" Dia. x 1/8" W Rubber	1/4" W Platen - 14" Reach	11074	11073	11052 (1)	11053
11254	1/2" or 1/4" x 34"	4-3/4" or 2-1/8" Dia. to 1/4" or 1/2" W	Grind in Deep Narrow Slots	Variable	Variable	11013 (1)	95162
11255	1/2" x 34"	5/8" Dia. x 3/8" W Rubber	Deburr I.D. 1" to 4"	11078	11077	11052	11054
11257	1/2" Wide	5/16" Dia. x 3/8" W Steel or 5/8" Dia. x 3/8" W Rubber	"Spear-Arm" - Specify length up to 32"	11068 Steel 11078 Rubber	11067 Steel 11077 Rubber	11051 Steel 11052 Rubber	11054
11258	1/2" x 24"	1/2" Dia. x 3/8" W Steel and 5/8" Dia. x 3/8" W Rubber	Platen Between 2 Contact Wheels	11076 Steel 11078 Rubber	11075 Steel 11077 Rubber	11052 (4)	11054 (2)
11261	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	"Banana Arm" - For in-line scratch pattern.	11078	11077	11052	11054
11262	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	"Offset Arm" - Contact wheel is offset to prevent gouging.	11078	11077	11052	11054
11297	1/2" x 24"	5/8" Dia. x 3/8" W Rubber	Contains two 11395 Guide Wheels. Prevents undercutting	11090	11077	11052	95610



Toll Free (USA) 1-800-828-7333
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Toll Free (Can.) 1-800-344-1488