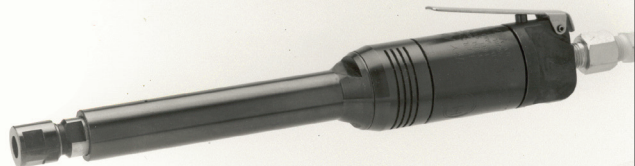
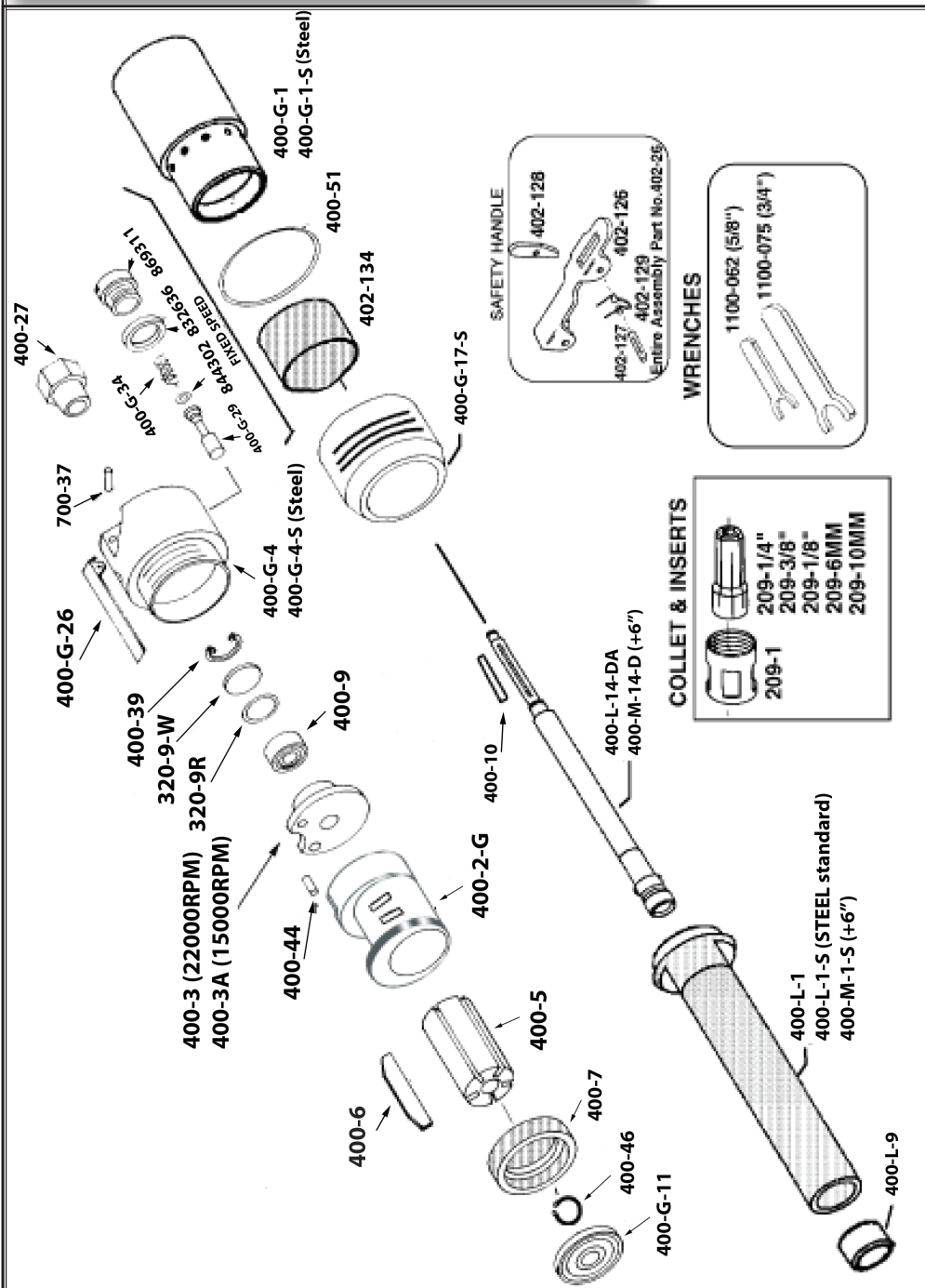


General Operators Instructions and Service Manual



Models  
40-GHERLS

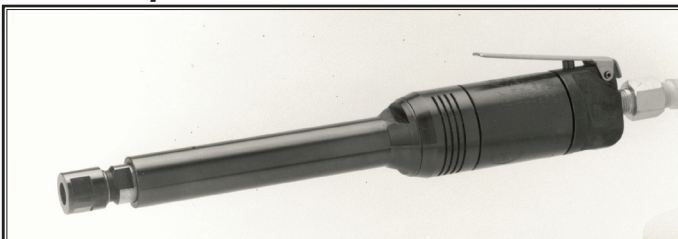
Old Style see note below



**Note: This tool has been discontinued and replaced with an updated model 40-EHL Series grinder. Henry Tools will continue to stock all parts for this model tool indefinitely.**

**THE HENRY TOOL CO. MANUFACTURED BY HENRY TOOLS**  
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Models  
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**Old Style see note  
below**

Part Number	Description
209-1	Nut
209-1/4	1/4" Insert
209-3/8"	3/8" Insert
209-1/8"	1/8" Insert
209-6mm	6mm Insert
209-10MM	10mm Insert
320-9R	O-Ring
320-9-W	Wafer
400-10	Key
400-2	Cylinder 15000RPM
400-27	Bushing
400-2-G	Cylinder(18000RPM STANDARD)
400-3	Rear Plate(Standard)
400-39	Lock Ring (844941)
400-3A	Rear Plate(15000RPM)
400-44	Pin
400-46	Snap Ring
400-5	Rotor
400-51	O-Ring
400-51	O-Ring
400-6	Blade(5 req'd)
400-7	Front Thrust
400-9	Rear Bearing (Sealed) (590004)
400-G-1	Case (Alum.) (412431)
400-G-11	Bearing(2 Req'd)
400-G-17	Alum. Exhaust Sleeve
400-G-17-S	Steel Exhaust Sleeve
400-G-1-S	Case (STEEL)
400-G-26	Valve Lever
400-G-29	Valve (412451)
400-G-34	Spring

Part Number	Description
400-G-4	Alum.Coupling
400-G-4-S	Steel Backhead Coupling
400-L-1	Alum. Front Extension
400-L-14-DA	Short Spindle (standard)
400-L-1-S	Steel Front Extension
400-L-9	Needle Bearing
400-M-14-D (+6")	Extended Length Spindle
400-M-1-S	Steel Front Extension Extended Length
700-37	Lever Pin
832636	T.V. Cap Gasket
869311	Throttle Valve Cap
402-26	Safety Lever Assembly complete
402-126	Safety Lever Assembly complete
402-127	Pin
402-128	Safety Latch
402-129	Spring
<b>ACCESSORIES</b>	
1100-062	Wrench 5/8"
1100-075	Wrench 3/4"
402-134	Muffler Screen

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40-GHERLS

**Old Style see note  
below**

This tool is designed to operate on 90 psig(6.2 bar) maximum air pressure with 1/4"(8mm) hose. Do not use any wheel having an operating speed lower than actual free speed on grinder.

### SAFETY

1. Check speed of tool with tachometer before every wheel & burr change or daily (which ever one is more frequent). If RPM exceeds rated speed stamped on tool, servicing is required.
2. At least on-half of the mandrel length (i.e. mounted wheel, ubrr, etc.) must be inserted into the collet. Secure collet chuck tightly.
3. Before mounting or removing a carbide burr or mounted point disconnect grinder from air supply. The carbide burr should fit properly on arbor; do not use bushings or wheel flanges to adapt a wheel to any arbor unless recommended by manufacturer.
4. Wear safety goggles and other protective clothing. Continuous exposure to vibration may cause injury to hands and arms.
5. Properly maintained air tools are less likely to fail or cause accidents. If tool vibrates unusually or produces an unusual noise, repair immediately.

### LUBRICATION

Check for wet or dirty air. Excessive moisture in the air supply tends to wash lubricant away from the working parts of the tool and rust or corrode the interior. Grit will damage the interior by scoring closely fitted parts, and impede the action of the tool. If the conditions above are found, disconnect the tool and pour a liberal amount of recommended oil or

an SAE #10 oil cut with an equal quantity of kerosene into the air inlet.

Operate the tool to allow lubricant to flush accumulated gum and grit out the exhaust.

If outside factors are not to blame, disassemble the tool, thoroughly clean and inspect all parts and replace those worn or broken. Coat parts with air tool oil and reassemble.

### DISASSEMBLY

1. Disconnect air and remove all wheels and accessories from the grinder.
2. Clamp tool in vise on backhead (400-G-4) flats.
3. Unscrew front housing (400-L-1). Remove from vise.
4. Remove snap ring (400-39) from within (400-3) plate with type 01 pliers.
5. Remove wafer (320-9W), o-ring (320-9R), and snap ring (59022) IF PRESENT.
6. Place assembly into vise collet end down. Clamp lightly onto cylinder (400-2-G).

7. Use 1/8" Punch to tap spindle (400-L-14-DA) out of rear bearing (400-9). Remove from vise.
8. Remove blades, rotor (400-5), key (400-10), plate (400-7), and snap ring (400-46) from assembly.
9. Place assembly in drill block (collet end down). Press spindle through bearing (400-G-11) with arbor press.
10. Place housing onto drill block (bearing down). Press bearing (400-L-9) out of front housing.
11. To check throttle valve, unscrew plug (869311). Remove gasket (832636), spring (400-G-34) and throttle valve (400-G-29). Replace O-ring (844302) if cracked or worn.

### ASSEMBLY

1. Be sure all parts are clean and free from abrasives.
2. Press bearing (400-L-9) into end of housing (400-L-1) with arbor press or tap LIGHTLY with a RUBBER HAMMER. Be sure front flare of bearing is forward and flush with front of housing.
3. Lubricate bearing with clean grease. Place spindle (400-L-14-DA) through front of housing.
4. Press bearing 400-G-11) onto rear of spindle with arbor press and bearing driver.
5. Replace snap ring (400-46), end plate (400-7), key (400-10), and rotor(400-5).
6. Place 5 blades into slots of rotor. Replace cylinder with cylinder pin towards rear of tool.
7. Place endplate(400-3) onto end of cylinder with pin in smallest hole.
8. Press bearing (400-9) into end of endplate with bearing driver and arbor press. Replace snap ring (400-39).
9. Place o-ring (400-51), muffler (402-134), and exhaust deflector (400-G-17-S) over smaller end of case (400-G-1). Slip motor assembly into case and tighten by hand.
10. Place backhead (400-G-4) into vise. Tighten assembly onto backhead). Assemble collet & insert.(209-1).



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