

HENRY TOOLS

Industrial Airtools at Work

Models
40-GP
41-GP



General Safety and Maintenance Manual



Do not use type 1 or 27 wheels on Model 40GP, it is not within the design of this airtool.



Model Number	Exhaust Direction	Throttle Type	Speed	Power Output	Weight	Height	Diameter	Air Consumption	Spindle Type
					Aluminum				
40GP	Side	Push Button	15000 to 18000 R.P.M. (18000RPM is Standard)	0.9 H.P. 675 W	1.8 lb (0.8 Kg)	5.3 inch (135 mm)	1.8 inches (46 mm)	25 cfm (11.8 L/S)	1/4" Collet
41GP									3/8-24 X 1.0 Inch (3/8-24 X 25 mm)

THE HENRY TOOL CO., MANUFACTURED BY HENRY TOOLS

498 So. Belvoir Blvd., South Euclid, OH 44121 U.S.A.

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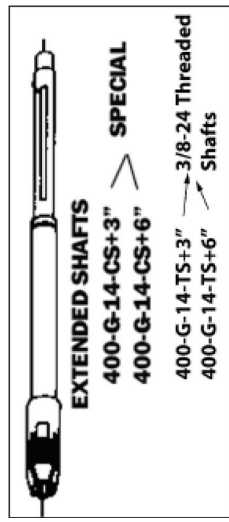
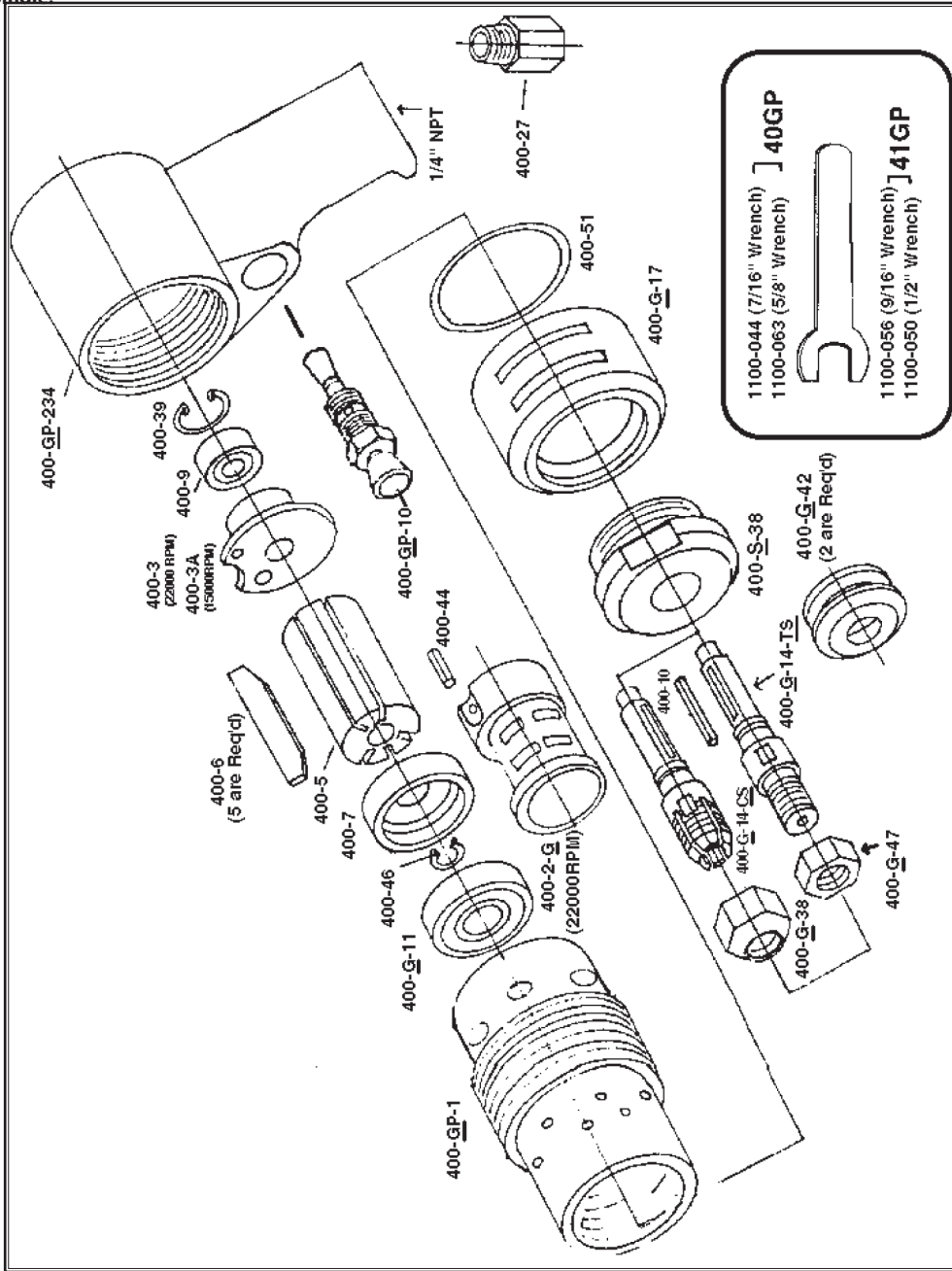
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General Operators Instructions and Service Manual



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Pistol Type Grinder
shown with Collet type
spindle.



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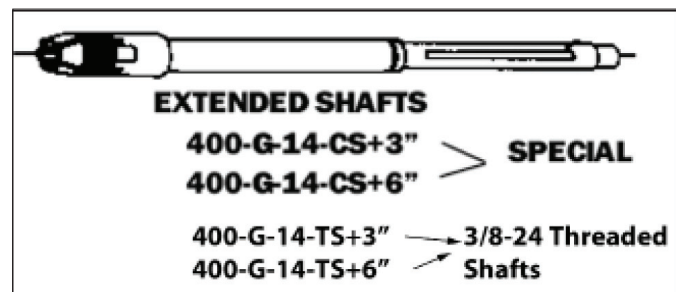


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Pistol Type Grinder shown with Collet type spindle.

PART NUMBER	DESCRIPTION
540129	Cap
832636	T.V. Cap Gasket
841553	Bushing
869311	T. Valve Cap
320-9R	O-Ring(Optional)
320-9-W	Rear Wafer(Optional)
400-10	Key
400-2-G(w/400-44)	Cylinder with pin
400-3	Rear End Plate
400-39	Snap Ring
400-44	Pin
400-46	Snap Ring
400-5	Rotor
400-51	O-Ring
400-6	Blade(5 req'd)
400-7	Front Thrust
400-9	Rear Bearing
400-G-1	Case (Aluminum)
400-G-11	Bearing
400-G-14-CS	Collet Shaft (Standard Length)
400-G-14-CS+3"	Extended shaft 3"
400-G-14-CS+6"	Extended shaft 6"
400-G-14-TS	3/8-24 Threaded Spindle (Standard Length)
400-G-14-TS+3"	Extended Shaft +3" (3/8-24 Thread)
400-G-14-TS+6"	Extended Shaft +6" (3/8-24 Thread)
400-G-17	Alum.Exhst Sleeve
400-G-17-S	Steel Exhst Sleeve
400-G-1-S	Case (Steel)
400-G-26	Valve Lever
400-G-29	Throttle Valve
400-G-31	O-Ring
400-G-34	Spring

PART NUMBER	DESCRIPTION
400-G-38	Collet Nut
400-G-42	Flange for wheel Mounting
400-G-47	Nut
400-GP-1	Pistol Motor Case
400-GP-10	Pistol Valve Assembly
400-GP-234	Pistol Handle
400-S-38	Aluminum Cap
400-S-38-S	Steel Cap
700-37	Roll Pin
ACCESSORIES	
1100-056	9/16" Wrench
1100-050	1/2" Wrench
1100-063	5/8 Wrench
1100-044	7/16" Wrench
510075	Repair Kit



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DISASSEMBLY

1. DISCONNECT AIR SUPPLY. Model 41GP or 40GP remove all grinding wheels or mounted points from the tool.
2. Clamp pistol handle in a vise. Remove (540129) or (400-G-38) using a wrench. Remove entire motor assembly from the tool.
3. Remove snap ring (400-39) with type 01 pliers. Lift out wafer (320-9W) and o-ring (If Present) (320-9R). Remove snap ring (592016) (If Present).
4. With brass or aluminum jawed vise, grasp the O.D. of the cylinder (400-2-G) and end plate (400-3) firmly. Use a 3/16" punch and tap spindle out of rear bearing (400-9), being careful not to drop spindle assembly when it is free.
5. Remove the rotor (400-5), blades (400-6), key (400-10) and front thrust plate (400-7).
6. Remove snap ring (400-46) with type 02 pliers. Place bearing and spindle assembly (threaded end down) on suitable drill block. Press spindle through the bearing with an arbor press.

REASSEMBLY

1. Support front bearing (400-G-II) on suitable drill block. Press spindle [400-G-14-(TS)] or (400-G-14-CS) through bearing until it bottoms on shoulder.
2. With type 02 pliers place the snap ring (400-46) into the groove. Slide on front thrust (400-7) over the arbor and on the front bearing.
3. Place the key (400-10) into the slot in the spindle. Slide rotor (400-5) over spindle, aligning the keyway in the rotor with the key in spindle.
4. Place five blades (400-6) in slots of rotor. Slip cylinder [400-2(G)] over rotor. Install rear thrust [400-3(A)]. (Locate cylinder in the smaller hole of the rear thrust plate.)
5. Place bearing in rear thrust and tap bearing in with suitable bearing driver.
6. Place snap ring (592016) on spindle groove. If desired, drop o-ring (320-9R) and washer (320-9W) in rear thrust. Place snap ring (400-39) into groove.
7. Slide entire motor assembly back into the case. Place exhaust (400-G-17) on case. Screw on cap (400-5-38), hand tighten till snug. Tighten backhead onto case (400-G-1) with a strap wrench.
8. Re-attach guard if your particular model uses a guard.

Additional information on safety is available in the "American National Safety Code for Portable Air Tools" (ANSI B186.1). This bulletin is available from

the American Standards Institute, Inc., 1430 Broadway, New York, N.Y. 10018. This tool is designed to operate on 90 psig (6.2 bar) maximum air pressure with 1/4 (8 mm) hose.

Do not use a grinder without the recommended wheel guard. Do not use any wheel for which the operating speed listed is lower than the actual free speed of the grinder.

SAFETY

1. NEVER MODIFY ANY PART OF THIS TOOL (SAFETY DEVICES OR ACCESSORIES).
2. Before operation check spindle speed with a tachometer. If the RPM's exceed the rated speed stamped on tool, servicing is required.
3. Inspect grinding wheels for bends, chips, nicks, cracks or severe wear. If the wheel has any of these, or has been soaked in liquids do not use. On brushes check for loose wires that may fly off in operation.
4. Start new grinding wheels under a steel bench. Run at full throttle for one minute. Defective wheels usually come apart immediately. When starting a cold wheel apply to the work slowly, and allow wheel to warm up gradually.
5. The 41GP die grinders can be used for mounted wheels, points and carbide burrs only if a collet is purchased from the manufacturer.
6. The 41GP can be guarded for 1 wheel applications.
7. If you have a type 1 wheel application please purchase a wheel guard (4503,4504).
8. The 41GL die grinders are not equipped with a guard from the manufacturer. A guard is not needed for: a.) mounted wheels two inches (50 mm) or smaller; b.) Grinders used for internal work, while within the work being ground.
9. If a collet is purchased (HT-1010), at least one-half of the mandrel length (i.e. mounted wheel, burr, etc.) Must be inserted into the collet. Secure collet chuck tightly.
10. Before mounting or removing a wheel disconnect grinder from air supply. The wheel should fit properly on arbor; do not use bushings or wheel flanges to adapt a wheel to any arbor unless recommended by manufacturer. (Wheel flanges should be at least 1/3 the diameter of the grinding wheel.)
11. Wear safety goggles and other protective clothing (when Necessary). (See regulations.)
12. Properly maintained air tools are less likely to fail or cause accidents. If tool vibrates or produces an unusual sound, repair immediately.

LUBRICATION

1. An air line filter-regulator-lubricator should be located as closely as possible to the tool.
2. Clean out dirt and moisture from air hoses daily. Keep screen handle bushing in tool.
3. OIL TOOLS DAILY.

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