

**Hydraulic  
Die Grinder  
also for underwater use  
Type 1 5080 0010, 0020, 0050**



Illustration can differ from the original

**Repair Instruction  
and Spare Parts List**

Only allow qualified personnel repairing your tool. This hydraulic machine complies with the present safety requirements.

Repairs should be executed only by qualified personnel by using original spare parts, otherwise there may be serious risk for the user.

## REPAIR INSTRUCTION

Prior to repairing, check the grinder according to the table „troubleshooting“ on page 10 of the operation instruction.

Disassembly and re-assembly should be executed according to the sectional drawings only.

### Disassembly/ Re- assembly Motor

Before starting the disassembly of the motor, mark the installation position of the parts motor housing item 1 to rear cover item 2 and motor housing item 1 to front cover item 4.

Unscrew output housing item 44 with item 45 to item 54 completely with a wrench (wrench size 32 mm). Remove two of the four screws item 11. Take out snap ring item 42.

Screw one of the screws item 11 in the plug-in pinion item 39 with bevel ball bearing item 40. Then clamp the screw item 11 with a vice and pull out item 4 by hitting slightly with a plastic hammer on the cover.

Then unscrew another two of the four screws item 11. Separate motor completely from the valve housing item 16. Loosen screws item 10.

Turn the screw item 11 in the threaded hole of both pockets in the cover item 4. By constant screwing, the cover is pushed from the motor housing item 1.

Remove snap ring item 13, replace shaft sealing ring item 12 and pay attention to the installation position.

For removing cylinder pin item 8, clamp the motor housing item 1 in a vice and hit slightly with a plastic hammer on the housing.

To separate the rear cover item 2 from the motor housing item 1, clamp the cover in a vice. Hit with a 4 mm – ejector drift in the drillings, where the cylinder pins item 8 were located.

If necessary, replace the DU- bushings item 3 and 5 in the front cover item 4 and rear cover item 2. Use a special puller for this (companies SKF, Gedore, etc.).

Re- assemble motor with new O-rings item 9, 14 and 15 and screw it to the valve housing item 16 with the screws item 11.

### Disassembly/ Re-assembly Valve

The valve consists of the components switch valve, valve lever and throttle valve.

Unscrew the throttle valve completely from the valve housing. Remove snap ring item 32. Take item 28 to 31 out of the current control housing, check pressure spring item 28 for cracks, replace, if necessary.

Assemble item 28 to 31 in the current control housing and lock with snap ring item 32.

Equip throttle valve completely with new O-rings item 25, 26 and 27 and screw it in.

Remove the valve lever item 37 for disassembling the switch valve.

For this, drive out centre grooved pin item 38. Unscrew switch valve bushing item 17 with item 18-22. Check pressure spring item 23 for cracks. Screw in switch valve with new O-rings item 18,19, 21 and 22.

Check function of valve lever item 37 (spring, safety lever), replace, if necessary.

Assemble valve lever item 37 with centre grooved pin item 38 with valve housing item 16.

### Disassembly/ Re-assembly Output Housing

Unscrew output housing item 44 completely with item 45- 54 from the front cover item 4 with a wrench (wrench size 32 mm).

Remove snap ring item 52. Drive grinding shaft item 45 with items 46, 47, 48, 52 and 54 out of the output housing item 44. Remove grooved ball bearing item 51 and spacer tube item 47.

Remove snap ring item 54 and dismount grooved ball bearing item 48. Replace O-ring item 50 and mount grinding shaft with items 46, 47, 48, 51 and 54. Replace O-ring item 49 in the output housing item 44.

Mount grinding shaft with items 46,47,48, 51 and 54 to the output housing and screw it with a wrench (wrench size 32 mm) to the front cover item 4.

After finishing the re-assembly, check axial grinder for leakproofness.

### **Spare Parts**

Only original spare parts may be used. There is no warranty for damages and liability is disclaimed, if non-original spare parts and accessories are used.

## Spare Parts List

Description:

**Hydraulic Die Grinder  
for underwater use**

Part and drawing number:

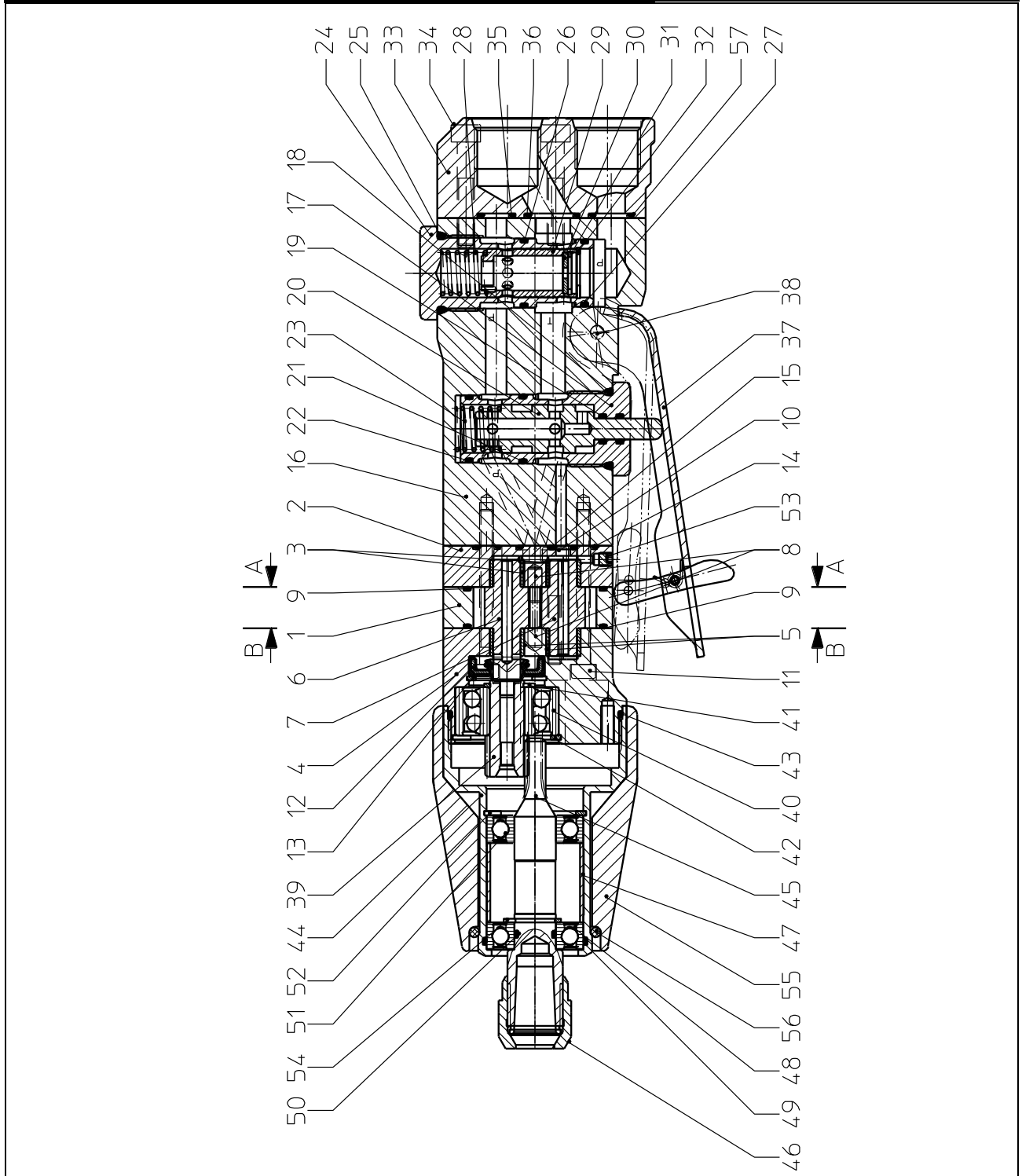
**1 5080 0010-0020, 0050**

Item.	Qty.	Description	Part and drawing no.	Remarks
	1	Hydraulic die grinder		
		1 5080 0010 consisting of:		
	1	Hydraulic die grinder	1 5080 0000	see extra list
	1	Collet	9 2912 0140	Ø 6 mm
	1	Spanner AF14	9 1301 0050	
	1	Spanner AF19	9 1301 0080	
	1	Multi-Oil-Spray	9 9902 0120	
	1	Hydraulic hose set	1 5080 9020	
	1	Hydraulic die grinder		
		1 5080 0020 consisting of:		
	1	Hydraulic die grinder	1 5080 0000	see extra list
	1	Collet	9 2912 0180	Ø 1/4"
	1	Spanner AF14	9 1301 0050	
	1	Spanner AF19	9 1301 0080	
	1	Multi-Oil-Spray	9 9902 0120	
	1	Hydraulic hose set	1 5080 9020	
	1	Hydraulic die grinder		
		1 5080 0050 consisting of:		
	1	Hydraulic die grinder	1 5080 0000	see extra list
	1	Collet	9 2912 0160	Ø 8 mm
	1	Spanner AF14	9 1301 0050	
	1	Spanner AF19	9 1301 0080	
	1	Multi-Oil-Spray	9 9902 0120	
	1	Hydraulic hose set	1 5080 9020	

<b>Spare Parts List</b>					
Description: <b>Hydraulic Die Grinder Body</b>				Part and drawing number: <b>1 5080 0000</b>	
Item.	Qty.	Description	Part and drawing no.		Remarks
1	1	Motor housing	1 5080 1010		
2	1	Rear Cover	1 5080 1110		
3	2	Bushing	9 1029 0820	*	
4	1	Front cover	1 5080 1100		
5	2	DU- bushing	9 1029 0820	*	
6	1	Gear shaft I	1 5080 1030		
7	1	Gear shaft II	1 5080 1020		
8	4	Cylinder pin	9 1631 0190		
9	2	O-ring	9 1921 1690	*	
10	4	Socket head screw	9 1110 2020		
11	4	Socket head screw	9 1110 2200		
12	1	Shaft sealing ring	9 1925 1050		
13	1	Snap ring	9 1703 0030		
14	5	O-ring	9 1901 2080	*	
15	2	O-ring	9 1921 1560	*	
16	1	Valve housing	1 5080 3610		
17	1	Control valve bushing	1 5080 3310		
18	1	O-ring	9 1901 6020	*	
19	2	O-ring	9 1921 1670	*	
20	1	Control piston	1 5080 3320		
21	1	O-ring	9 1921 1360	*	
22	1	O-ring	9 1921 1360	*	
23	1	Pressure spring	9 1803 1700		
	1	Throttle valve, assy.	1 5080 3500		Pos. 24- 32
24	1	Control housing	1 5080 3510		
25	1	O-ring	9 1901 6020	*	
26	1	O-ring	9 1921 1360	*	
27	1	O-ring	9 1921 1360	*	
28	1	Pressure spring	9 1803 1700		
29	1	Governor piston valve	2 1317 3320		
30	1	Gate	1 5080 3550		
31	1	Snap ring	9 1703 0260		

32	1	Snap ring	9 1703 0610		
<b>Spare Parts List</b>					
Description:			Part and drawing number:		
<b>Hydraulic Die Grinder Body</b>			<b>1 5080 0000</b>		
Item.	Qty.	Description	Part and drawing no.		Remarks
33	1	Connecting plate	1 5080 3670		
34	4	Socket head screw	9 1110 3030		
35	1	O-ring	9 1921 1560	*	
36	1	O-ring	9 1921 1230	*	
37	1	Valve lever, assy.	5 5010 3940		
38	1	Grooved pin	9 1627 0090		
39	1	Plug-in pinion	1 5080 1040		
40	1	Angular contact ball bearing	9 1009 0010	*	
41	1	Snap ring	9 1702 0040		
42	1	Snap ring	9 1703 0080		
43	1	O-ring	9 1921 1700	*	
44	1	Output unit housing	1 5080 7010		
45	1	Grinding shaft	1 5080 7020		
46	1	Clamping nut	9 1225 0350		
47	1	Spacer pipe	1 5080 7080		
48	1	Grooved ball bearing	9 1003 0690	*	
49	1	O-ring	9 1901 2380	*	
50	1	O-ring	9 1901 2560	*	
51	1	Grooved ball bearing	9 1003 0370	*	
52	1	Snap ring	9 1703 0070		
53	1	Threaded pin with inner hexagon	9 1140 2030		
54	1	Snap ring	9 1702 0050		
55	1	Cap	1 5080 7070		
56	1	O-ring	9 1901 4160	*	
57	1	O-ring	9 1901 0130	*	
		* Wear parts to be stored in case of			
		continuous use			

<b>Spare Parts List</b>	
Description:	Part and drawing number:
<b>Hydraulic Die Grinder for underwater use</b>	<b>1 5080 0000</b>



### Spare Parts List

Description:

**Hydraulic Die Grinder  
for underwater use**

Part and drawing number:

**1 5080 0000**

A - A

B - B

