



1200 SERIES

STRAIGHT DIE GRINDER



AIR TOOL SERVICE COMPANY

A DIVISION OF HY-TECH MACHINE

25 LEONBERG ROAD

CRANBERRY TOWNSHIP, PA 16066

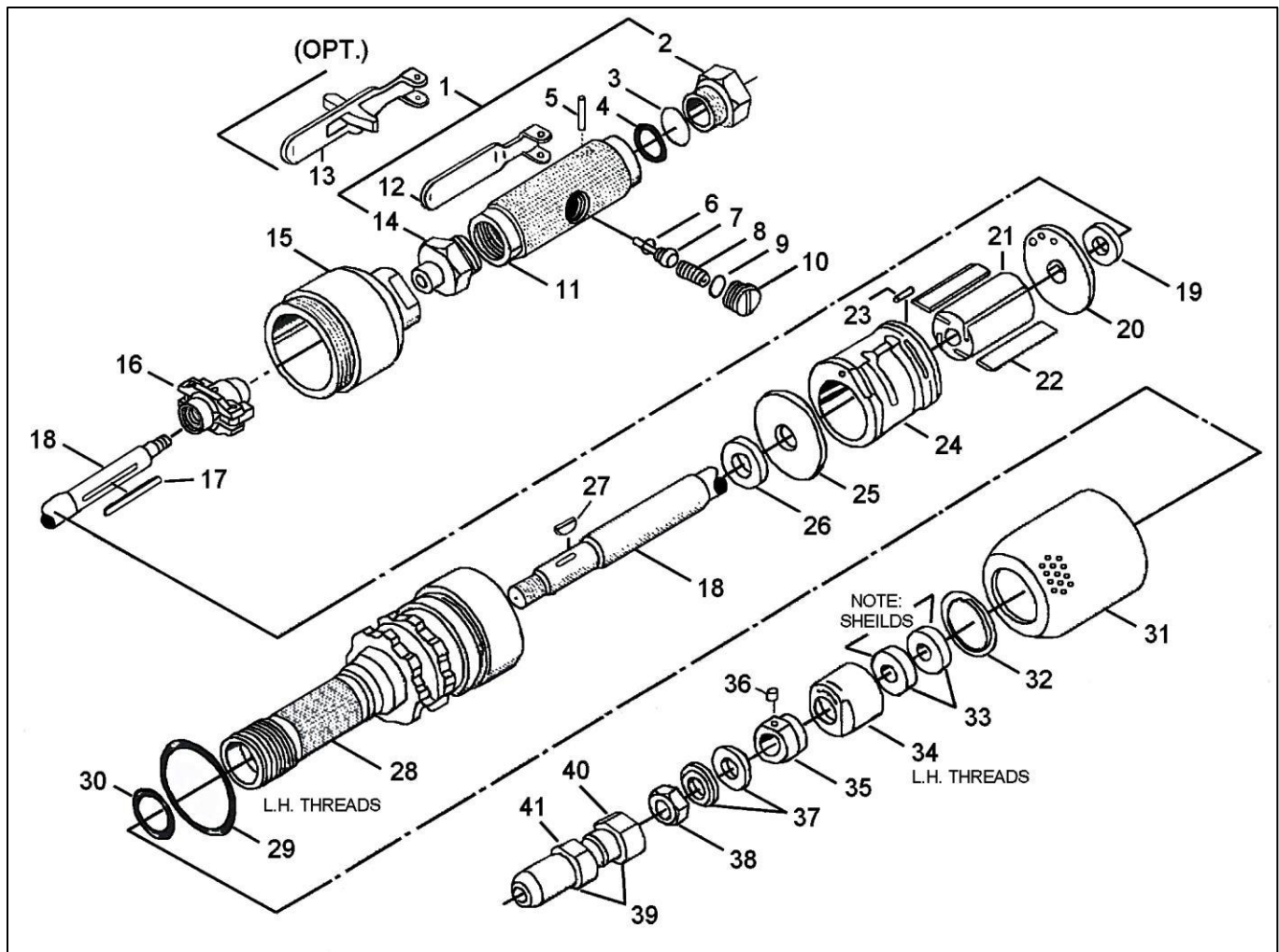
1-800-321-3554

www.onlineatp.com

Email: info@hy-techinc.com

ATSCO 1200 SERIES

DIE GRINDER



AIR TOOL SERVICE COMPANY

A DIVISION OF HY-TECH MACHINE

25 LEONBERG ROAD

CRANBERRY TOWNSHIP, PA 16066

1-800-321-3554

www.onlineatp.com

Email: info@hy-techinc.com

ATSCO 1200 SERIES GRINDER

1200 SERIES PARTS			NOT ILLUSTRATED (IN BUILD)	
ITEM #	ATSCO #	DESCRIPTION	ATSCO #	DESCRIPTION
1	69A-650	THROTTLE HANDLE ASSY (INCL. #2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 13, 14)	2093-0750	TOGGLE PIN (#13)
2	45-640	INLET BUSHING	31-640S	THROTTLE LEVER (#13)
3	95-602	SCREEN	82A-640S	TOGGLE LEVER (#13)
4	93-116	O-RING	97-640S	SPRING (#13)
5	2187-0875	THROTTLE LEVER PIN	230-WS4	1/2" THICK SPACER
6	93-9	O-RING	269-G12B	WRENCH (QTY: 2)
7	25-650	THROTTLE VALVE (INCL. #6)	254-11G	CONE WHEEL ADAPTOR (5/8")
8	26-640	THROTTLE VALVE SPRING	235-1S120	3" TYPE 1 WHEEL GUARD
9	93-13	THROTTLE VALVE SEAL	235-650	4" TYPE 1 WHEEL GUARD
10	30-650	THROTTLE VALVE CAP	226-650	BEARING NUT (1218 MODELS ONLY)
11	69-650	THROTTLE BODY	226B-650	SPACER (1218 MODELS ONLY)
12	31-640	THROTTLE LEVER (STD.)	93-10	O-RING
13	31A-640S	THROTTLE LEVER ASSY (SAFETY OPT.)	SERVICE INSTRUCTIONS	
14	63-640	REDUCING BUSHING	Before the tool is put into service, check for any possible shipping damage and free spindle rotation. Select the proper wheel for the type spindle installed in the tool. Be sure that the "DO NOT EXCEED" speed of the wheel is at least as high as the rated tool speed. Do not operate the tool without the required wheel guard and adequate eye and ear protection. Pour about one tablespoon of "Blue Magic" in the tool inlet. Provide a supply of clean dry compressed air @ 90 PSI thru the hose with minimum inside diameter of 3/8". Use a larger hose if the length exceeds 8 feet. Line filters and oilers will add many hours to the life of the tool and we highly recommend their use.	
15	87-6500	BACKHEAD (STD.)		
16	245-G13A	GOVERNOR ASSY (9,000-12,000 RPM)		
	245-G13B	GOVERNOR ASSY (15,000 RPM)		
17	215-640-1	ROTOR KEY		
18	201-G13B	SPINDLE		
	201-6500T	SPINDLE (1218S-1/2-13 ONLY)		
19	222-21	REAR ROTOR BEARING		
20	203-650	REAR END PLATE		
21	206-640	ROTOR		
22	200-640	ROTOR BLADE (QTY: 4)	LUBRICATION	
23	2125-0375	ROLL PIN	ATSCO grinders should be lubricated with "Blue Magic" Lubricant. It not only lubricates but also helps keep the tool clean and free of sludge and buildup, which can cause any air tool to lose its performance and efficiency. Airline filters and automatic line lubricators properly installed on your airline will improve productivity and extend tool life.	
24	90-6500	CYLINDER (INCL. #23)		
25	202-6500	FRONT END PLATE		
26	222-2	FRONT ROTOR BEARING		
27	8-G12B	WHEEL COLLAR KEY		
28	90A-650S	MOTOR HOUSING	BEARINGS	
29	93-1000	O-RING	All ATSCO grinders are equipped with the best bearings obtainable. They should be checked regularly for signs of wear. If wear in the bearings is indicated, they should be replaced. Bearings are a comparatively low cost item, and the replacement before failure may prevent damage to more expensive parts.	
30	93-123	O-RING		
31	36-6500	EXHAUST DEFLECTOR	ROTOR BLADES	
32	4100-131	SNAP RING	The rotor blades are subject to wear. Replacement should be made when they show approximately 10% wear from their original size. It is suggested that a spare set of blades be kept on hand at all times. Proper lubrication will greatly prolong the life of the rotor blades. Portable air tools are mechanical devices which are often subjected to severe usage and abuse. Many users have found it advantageous to maintain a minimum stock of normal wearing parts so that minor repairs can be made in their own plant. Your ATSCO representative will welcome the opportunity to instruct your repairman and to help prepare a minimum list of parts.	
33	222-3	FRONT BEARING SET (SOLD IN PAIR)		
34	207-G12B	BEARING NUT		
	207-6500T	BEARING NUT (1218S-1/2-13 ONLY)		
35	210-G13B	WHEEL COLLAR (INCL. #36)		
	210-6500T	WHEEL COLLAR (1218S-1/2-13 ONLY)		
36	80-G12B	WHEEL COLLAR SET SCREW		
37	209-602	WHEEL WASHER (QTY: 2) (3" GUARD)		
	209-TS1	WHEEL WASHER (4" GUARD)		
38	212-602	WHEEL NUT (3/8") (3" GUARD)		
	210-TS2	WHEEL SUPPORT HEX NUT (4" GUARD)	ORDERING INFORMATION	
39	214A-602	1/4" COLLET ASSY (INCL #40, 41)	Always include tool model, description, and quantity required when ordering.	
	214A-640	3/8" COLLET ASSY (INCL #40, 41)		
40	213-602	1/4" COLLET BODY		
	213-640	3/8" COLLET BODY		
41	214-602	1/4" COLLET NUT		
	214-640	3/8" COLLET NUT		

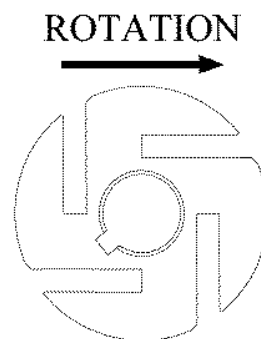
ATSCO 1200 SERIES GRINDER

ASSEMBLY AND DISASSEMBLY INSTRUCTIONS

1. To facilitate service and to prevent needless damage to the motor housing, it is suggested that the serviceman make a set of hardwood blocks to properly hold the tool.
2. Remove collet or wheel from the spindle using the wrenches provided.
3. Clamp spindle end in SOFT jawed vise and unscrew wheel collar unit.
4. Using wood blocks described above, clamp the tool in a vise and remove the bearing nut.
(NOTE: LEFT HAND THREAD)
5. With suitable spreader pliers, remove snap ring that is directly in front of the exhaust deflector and muffler if equipped.
6. Clamp tool in vise, with blocks, small end down, unscrew throttle handle and backhead. Slide the governor assembly off the rear end of the spindle. Light pressure with a pair of screw drivers may be required for this operation.
7. Remove tool from vise and tap the wheel off the spindle with a soft hammer until the motor assembly is out of the housing.
8. The rotor will easily slide off from the spindle, and the rotor key must be removed for further dismantling.

(NOTE: THE ROTOR SHOULD BE A CLOSE SLIDING FIT. IF IT BINDS, IT CAN CAUSE SCORING OF ONE OF THE END PLATES.)

For reassembly, always install the rotor so that the slots point in the direction of rotation. Install blades with chamfered edge out and match the outside contour of the rotor.



9. Thoroughly wash all parts in a suitable solvent, except bearings, and replace any that indicate damage or excessive wear. Bearings and vanes are high wear items, and unless that tool has had minimal use, we recommend their replacement whenever the tool is serviced. Reassemble in reverse order.
10. Remove throttle valve plug and inlet bushing from throttle handle. Replace all worn parts. Be sure to clean or replace screen. Reassemble and test for air flow. A minimum of 50 CFM should pass through the handle at 90 PSI.
11. Assemble tool and test speed with an accurate tachometer. If all worn parts have been replaced and the tool is assembled correctly, the speed should be correct without any adjustment. As governors seldom go out of adjustment, do not attempt resetting unless you are sure everything else is correct.

Do not return the tool to the plant until you are sure tool speed is the same or slightly less than the rated speed stamped on the tool. Make sure the correct guard is on the tool if required.

AIR TOOL SERVICE COMPANY

A DIVISION OF HY-TECH MACHINE
25 LEONBERG ROAD
CRANBERRY TOWNSHIP, PA 16066
1-800-321-3554
www.onlineatp.com
Email info@hy-techinc.com

NORMAL AIR CONSUMPTION

RPM	NO LOAD	FULL LOAD	STALL LEAK
9,000	10 CFM	30 CFM	8 CFM
12,000	18 CFM	35 CFM	8 CFM
15,000	30 CFM	38 CFM	8 CFM