

# Henrytools

Industrial Tools at Work

**MODELS**  
**4125 GL**  
**4125 GLS**  
**Series**

## General Safety and Maintenance Manual



Model 4125GL die grinder shown with light-weight aluminum case.

**ORIGINAL  
 STYLE**

Pre-Year 2009 Original Style model



**CAPACITY**

Mounted points and carbide burrs.

### 4125G Series Die Grinders

Model Number	Exhaust Direction	Throttle Type	Speed	Power Output	Case Material	Weight		Length	Diameter	Air Consumption	Collet Size
						Aluminum	Steel				
4125GL	Side	(L) Lever or (K) Safety Lever	15000 to 22000 R.P.M. (18000RPM is Standard)	0.9 H.P. 675 W	Steel or Aluminum	1.6 lb/0.7 Kg	2.0 lb/0.9 Kg	5 1/2" 140mm	1.6 inches 41 mm	25cfm 11.8 L/S	1/4"
4125GLS											



**THE HENRY TOOL CO., MANUFACTURED BY HENRY TOOLS**

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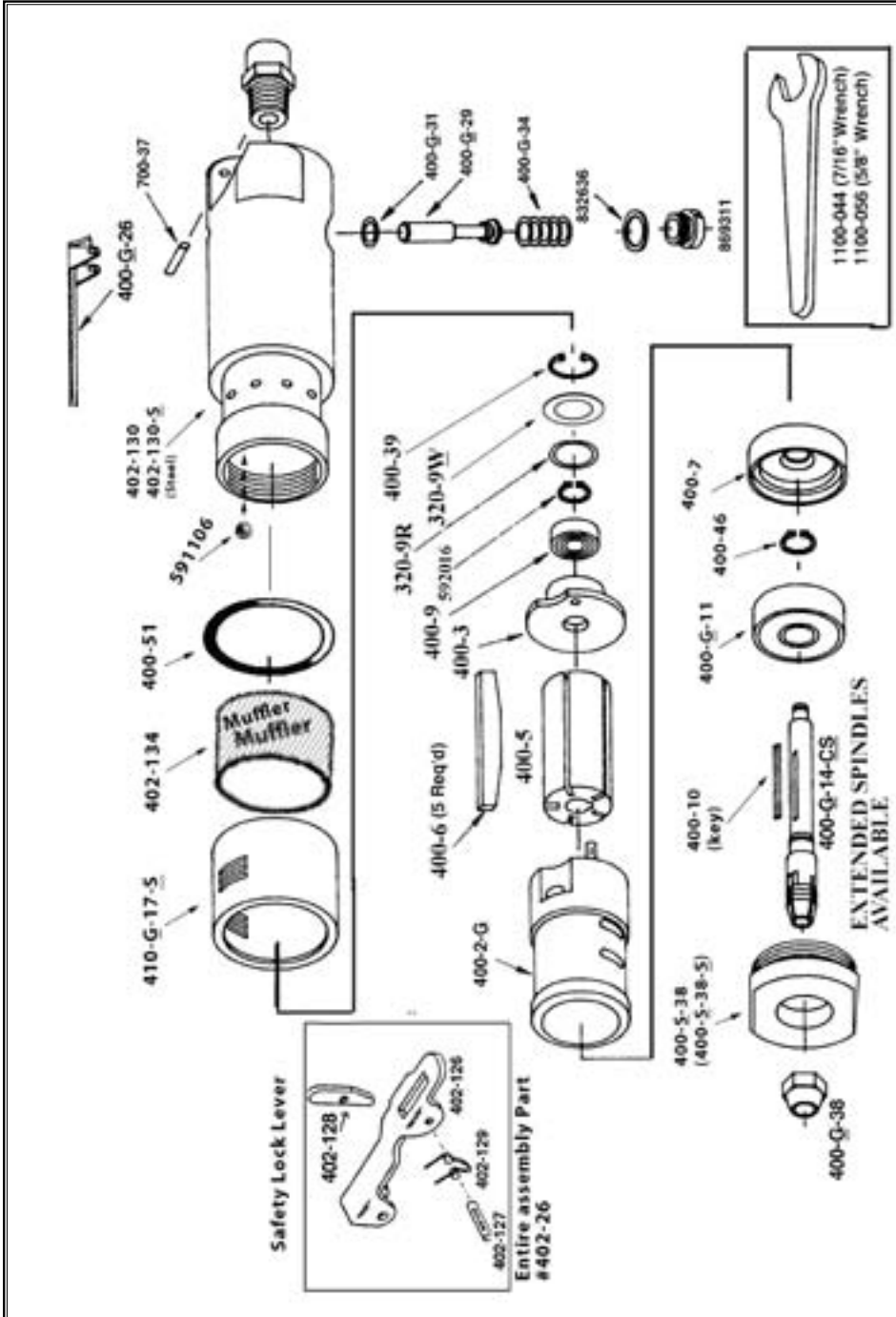
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**4125 GL**  
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Model 4125GLSK Die grinder shown with a safety lock handle. Features a built-in 1/4" collet. Show with a mounted stone.

**ORIGINAL  
 STYLE**





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PART	DESCRIPTION
320-9R	O-RING
320-9W	BEARING COVER
400-G-11	FRONT BEARING
400-G-14-CS	COLLET SPINDLE
400-G 14-CS+3	3" EXTENDED SPINDLE
400-G 14-CS+6	6" EXTENDED SPINDLE
400-G-26	THROTTLE LEVER
400-G-29	THROTTLE VALVE-INCLUDES 844302
400-G-34	SPRING
400-S-38	ALUMINUM MOTOR RETAINER
400-S-38-S	STEEL MOTOR RETAINER
400-2G	CYLINDER
400-2GR	REVERSE ROTATION CYLINDER
400-10	KEY
400-3	REAR ENDPLATE
400-39	O-RING
400-3R	REVERSE ROTATION REAR ENDPLATE(Special)
400-44	ROLL PIN
400-46	SNAP RING
400-5	ROTOR
400-51	O-RING
400-6	BLADE (5 REQ)
400-7	FRONT ENDPLATE
400-9	REAR BEARING
402-126	SAFETY LEVER
402-127	SAFETY LEVER PIN
402-128	LOCKOUT LEVER
402-129	SAFETY LEVER SPRING
402-130	ALUMINUM CASE (SPECIFY SPEED)
402-130-S	STEEL CASE (SPECIFY SPEED)
402-134	MUFFLER SCREEN
410-G-17-S	STEEL SIDE EXHAUST SLEEVE
540129	STEEL MOTOR RETAINER (Same as 400-S-38-S)
700-37	THROTTLE LEVER PIN
591106	SET SCREW (SPECIFY SPEED)

PART	DESCRIPTION
592016	SNAP RING
832636	GASKET
841553	3/8 NPT TO 1/4 NPT BUSHING
844302	O-RING
869311	THROTTLE VALVE CAP
<b>WRENCHES</b>	
1100-044	7/16" WRENCH
1100-063	5/8" Wrench
<b>ASSEMBLIES</b>	
510075	REPAIR KIT
402-26	SAFETY LEVER ASSY.
AA-402-130	ALUMINUM CASE ASSY.
AA-402-130-S	STEEL CASE ASSY.
AA-402-130-SK	STEEL SAFETY CASE ASSY.
	SPECIFY SPEED FOR CASE ASSY.
<b>REPAIR KITS</b>	
510075	REPAIR KIT INCLUDES ALL BEARINGS, ROTOR BLADES and SNAP RINGS

FAULT	CAUSE	SOLUTION
Insufficient Power	Air pressure too low	Minimum air pressure <i>should</i> be 90 PSI for maximum performance
	Restriction in air hose	Remove bends or other restrictions
	Hose I.D. is too small	Use required hose I.D.
	Worn vanes	Exchange vanes (400-6)
	Screen Support clogged	Clean screen support or exchange with new one
Machine does not start	No air, shut-off valve is closed.	Open shut-off valve
	Worn vanes due to lack of oil or vanes are jammed	Exchange vanes . (cylinder might also be worn out)
Grinder does not want to stop	Worn O-Ring	Replace o-ring in handle (844302) for example.
Spindle wobbles or vibrates.	Bearings worn out . Danger!!	Disconnect tool from the air supply. <i>Immediate</i> servicing is required.

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**SAFETY**

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.

1. Before operation check spindle speed with a tachometer. If the RPM's exceed the rated speed stamped on tool, servicing is required.
2. The 4125 series die grinders are intended for use with mounted wheels, points and carbide burrs. They are not guarded for type 1 wheels. If you have a type 1 wheel application, please purchase another model tool.
3. At least one-half of the mandrel length (i.e. mounted wheel, burr, etc.) must be inserted into the collet. Secure collet chuck tightly.
4. Safety levers (402-26) are available from the manufacturer Henrytools, Inc..
5. **CAUTION:** Before mounting or removing a Mounted point or carbide burr disconnect grinder from air supply.
6. Wear safety goggles and other protective clothing (when necessary).(See regulations.)
7. Properly maintained air tools are less likely to fail or cause accidents. If the 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.
3. Keep screen handle bushing in tool.

**DISASSEMBLY**

1. **CAUTION:** Disconnect air supply. Remove collet nut (400-G-38) with 5/8 " wrench and 7/16" wrench.
2. Clamp backhead [402-130(S)] in a vise. Using a wrench, unscrew case lock nut(540129 or 420-130). Next replace (400-G-38)on spindle. Grab collet nut with vise and pull out motor package. Remove collet nut.
3. Remove snap ring(400-39). Remove wafer (320-9W) and O-Ring (320-9R). Remove snap ring (592016).
4. With brass or aluminum jawed vise, grasp the O.D. of the cylinder(400-2G) 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.
7. (OPTIONAL STEP): To check throttle valve. unscrew plug (869311) and lift out valve spring (400-G-34)

and plunger (400-G-29). Remove o-ring (400-G-31) and replace if cracked or worn.

**REASSEMBLY**

1. Support front bearing (400-G-11) on suitable drill block. Press spindle [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]. (Carefully locate cylinder in the smaller hole of the rear thrust plate.)
5. Place bearing (400-9) in rear thrust and tap bearing in with a suitable bearing driver.
6. Place snap ring (592016) on spindle groove. Drop o-ring(320-9R) and washer (320-9W) in rear thrust. Place snap ring(400-39) into groove of endplate (400-3).
7. Slip entire motor assembly in case (402-130(S)). Put backhead in vise and replace exahust sleeve(410-G-17(S)). Replace Lock nut(540129 or 420-130) and tighten.

**CAUTION: CHECK TOOL FOR SPEED WITH TACHOMETER. THE SPEED STAMPED ON TOOL MUST BE AT OR ABOVE THE ACTUAL SPEED OF THE TOOL.**

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<b>Insufficient Power</b>	<b>Air pressure too low</b>	<b>Minimum air pressure <i>should</i> be 90 PSI for maximum performance</b>
	<b>Restriction in air hose</b>	<b>Remove bends or other restrictions</b>
	<b>Hose I.D. is too small</b>	<b>Use required hose I.D.</b>
	<b>Worn vanes</b>	<b>Exchange vanes (400-6)</b>
	<b>Screen Support clogged</b>	<b>Clean screen support or exchange with new one</b>
<b>Machine does not start</b>	<b>No air, shut-off valve is closed.</b>	<b>Open shut-off valve</b>
	<b>Worn vanes due to lack of oil or vanes are jammed</b>	<b>Exchange vanes . (cylinder might also be worn out)</b>
<b>Grinder does not want to stop</b>	<b>Worn O-Ring</b>	<b>Replace o-ring in handle (844302) for example.</b>
<b>Spindle wobbles or vibrates.</b>	<b>Bearings worn out . Danger!!</b>	<b>Disconnect tool from the air supply. <i>Immediate</i> servicing is required.</b>

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