

## 315 Sander Timing Procedure

*Any time the drive the drive board is removed from the sander, the piston pinion gears, and reverse valve pinion must be timed in order for the tool to function properly. An improperly timed tool can cause damage to the front and back heads.*

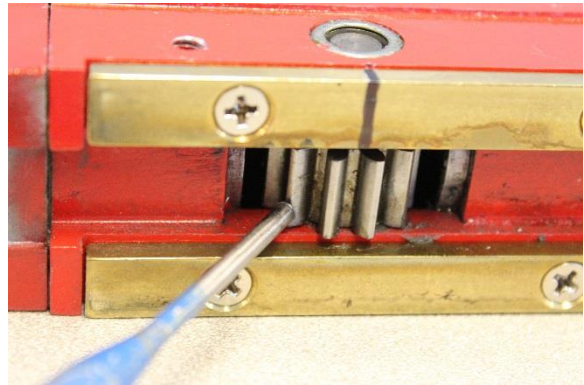
Step 1) Lay the tool on its right side, with the front of the tool pointing to the left. Make a mark on each wear plate, in line with the center of the piston pinion gear shafts.



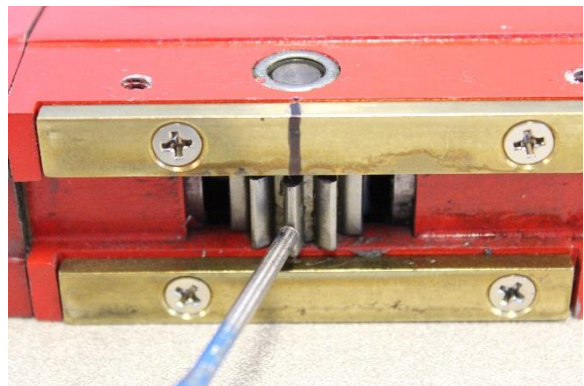
2) Rotate both piston pinion gears towards the front of the tool (clockwise when viewed from above) until they stop.



3) Locate the left-most gear tooth that is not inside the body of the tool.



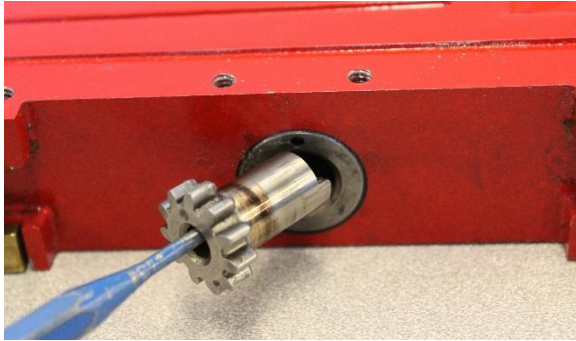
4) Rotate the gear counterclockwise, until this tooth lines up with the mark made on the wear plate. **Rotate the gear counterclockwise an additional 3 teeth, and stop.**



5) Repeat steps 3 and 4 for the other piston pinion gear.

*(Continued on next page)*

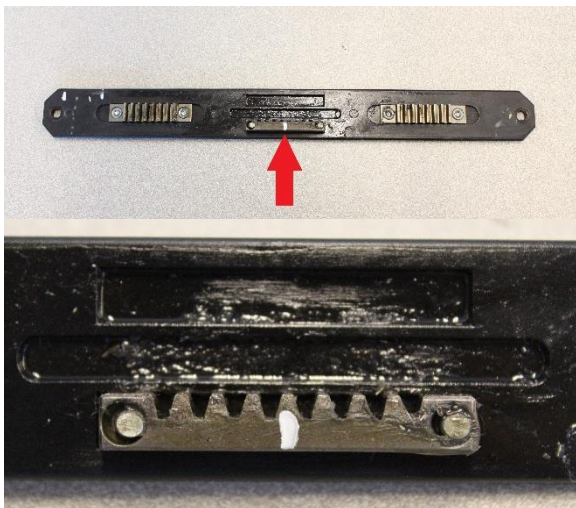
6) Insert the Reverse Valve Pinion into the valve bushing, making sure it is fully seated and engaged into the reverse valve.



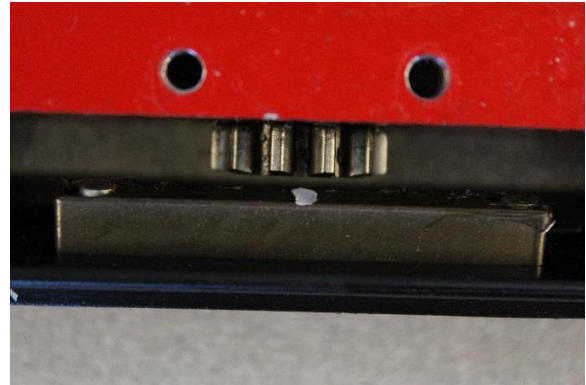
7) Align the timing dots on the pinion and the bushing.



8) Mark the center tooth of the reverse valve rack gear (center gear on drive board)



9) Ensure that all gear teeth are still aligned properly with their marks, and align the marked gear tooth with the timing dot on the reverse valve pinion.



10) Seat the pinion gears with the rack gears on the drive board. If the gears are aligned properly, the drive board will seat with little to no movement of the gears. Install both guide plates.

