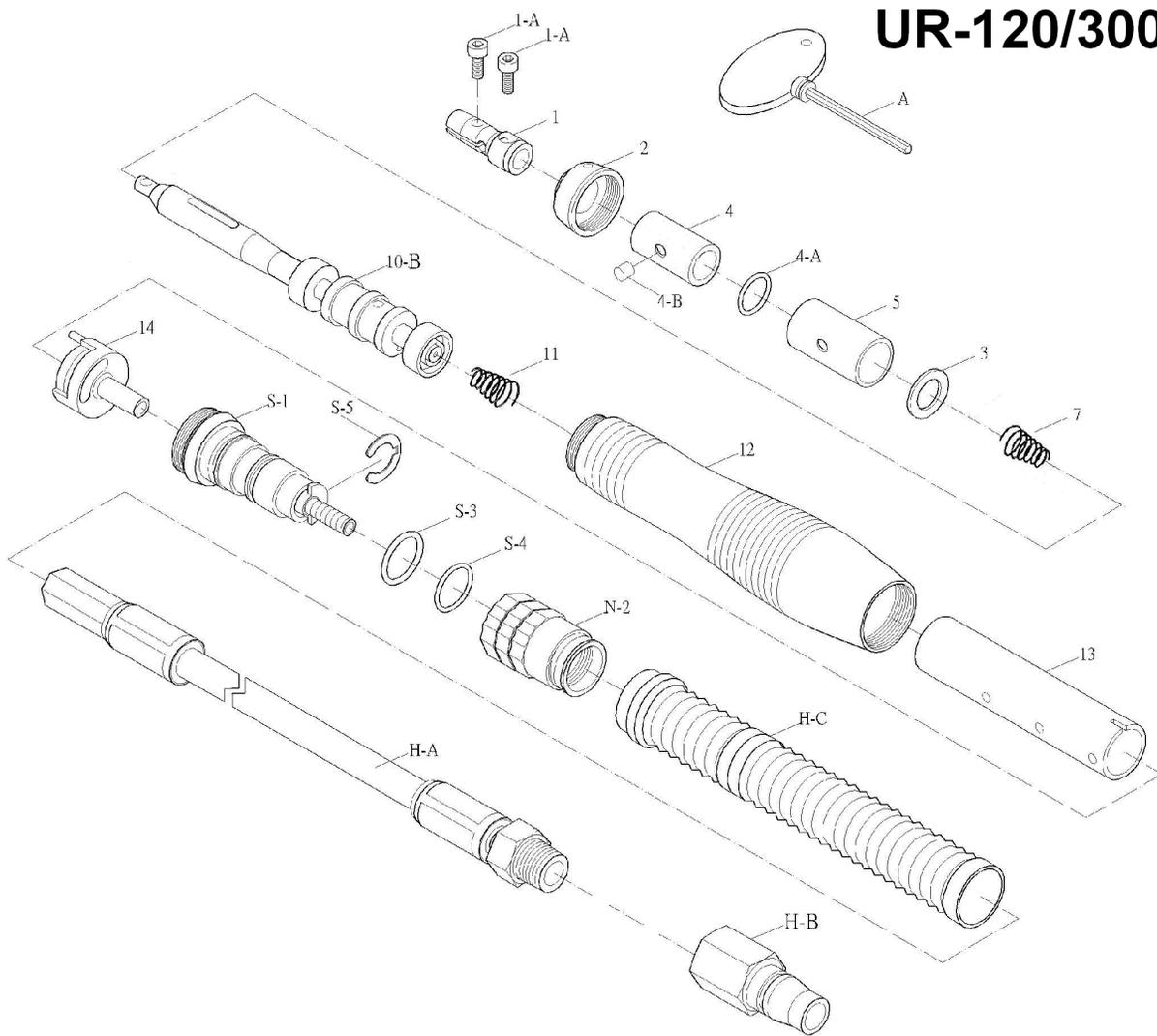


U-LAP



UR-120 & UR-300 Recipro Air Lappers Repair Manual

UR-300 Repair Parts List



UR-120/300

No.	Item	Description	List Price
A	50053	PROFILER, HEX WRENCH	\$ 2.10
1	50330	PROFILER, 3MM TIP HOLDER U-LAP 300/120	\$ 11.60
1-A	50331	PROFILER,SET SCREW (2 PK) U-LAP 300/120	\$ 2.10
2	50332	PROFILER, FRONT COVER U-LAP 300/120	\$ 19.00
3	50333	PROFILER, WASHER U-LAP 300/120	\$ 2.00
4	50323	PROFILER, BUSHING U-LAP 300/120	\$ 11.60
4-A	50324	PROFILER, O - RING U-LAP 300/120	\$ 1.00
4-B	50325	PROFILER, FIXED BALL U-LAP 300/120	\$ 7.00
5	50326	PROFILER, SLIDING BUSH U-LAP 300/120	\$ 11.25
7	50334	PROFILER, FRONT SPRING U-LAP 300/120	\$ 4.45
10-B	50328	PROFILER, MAIN SHAFT SET U-LAP 300/120	\$ 95.65
11	50345	PROFILER, BACK SPRING U-LAP 300/120	\$ 4.45
12	50335	PROFILER, BODY U-LAP 300/120	\$ 61.25
13	50329	PROFILER, CYLINDER PIPE U-LAP 300/120	\$ 49.00
14	50336	PROFILER, AIR INLET BODY U-LAP 300/120	\$ 16.25
S-1	50337	PROFILER, SWITCH BODY U-LAP 300/120	\$ 11.75
S-5	50338	PROFILER, C-RING U-LAP 300/120	\$ 1.45
S-3	50339	PROFILER, O-RING U-LAP 300/120	\$ 1.00
S-4	50340	PROFILER, O-RING U-LAP 300/120	\$ 1.00
N-2	50341	PROFILER, ON - OFF SWITCH U-LAP 300/120	\$ 11.75
H-C	50342	PROFILER, MUFFLER PIPE U-LAP 300/120	\$ 4.90
H-B	50343	PROFILER, QUICK JOINT U-LAP 300/120	\$ 3.25
H-A	50000	PROFILER,AIR HOSE SET	\$ 12.40

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[BORIDE Engineered Abrasives](http://www.boride.com) | 2615 Aero Park Dr. | Traverse City, MI 49686 | 231.929.2121

UR-300 Tools

 <p>J-011</p>	 <p>J-012</p>	 <p>J-013</p>	 <p>J-004</p>
 <p>J-014</p>	 <p>J-015</p>	 <p>J-016</p>	 <p>J-018</p>
 <p>J-017</p>	 <p>J-002</p>	 <p>J-007</p>	

NO	TOOL NO.	TOOL NAME	NO	TOOL NO.	TOOL NAME	NO.	TOOL NO.	TOOL NAME
1	J-011	2.5 mm Hex Key	5	J-015	Tapping-Modified Wrench	9	J-007	C- Shape Spanner
2	J-012	3.0 mm Rod	6	J-016	14 mm Collect	10	J-004	Extrusion Press
3	J-013	Desktop Collect Seat	7	J-017	Anaerobe	11	J-018	Air Admission Case Extrusion Stocks
4	J-014	Gas Gun	8	J-002	Long Nose Flier			

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• USE J-11 · Take off M3 screw ◦



• take off holder ◦



• use J-12 · insert to the front cover, and loose it with opposite direction (**CAUTION**) around 2 rounds then continue it ◦



• (**caution**) when loose it with opposite direction · at the same time (**pressure it**) the front nut to avoid it flip out ◦



• take off the front nut ◦



• take off the main shaft ◦



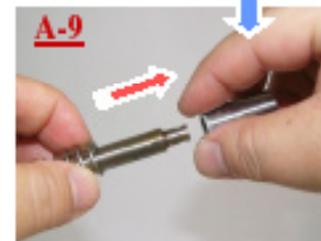
• take off the main shaft ◦



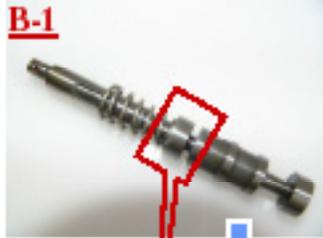
• use your finger to press it ◦



•Keep the last move and beat it, to let the bead come out, and take off the bead ◦



• take out the slide cover ◦



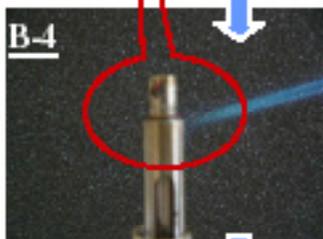
• The look of main shaft ◦



• Let the front of main shaft **14mm** ◦ insert to J-13 ◦ and screw it ◦



• Use J-14 ◦ point to the above of main shaft around 6 mm and heat it ◦



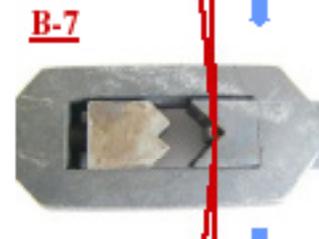
• The temp. must be 100~150°C ◦ let the glue soft ◦



• Use J-15 ◦ lock to the front of main shaft ◦ and tight it ◦



• Use the hand too to disassembly the front of main shaft



• Use J-15 ◦ aim each other ◦ and screw it ◦



• The part of front main shaft ◦



• Opposite Direction to loose out the main shaft ◦



• Take off the front of main shaft ◦



• Take off the front shaft and take off the front spring ◦



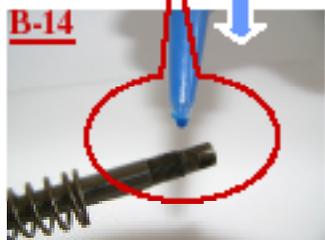
• to let the front spring out



• the drawing of the front and back spring



• please insert the spring to the main shaft in order.
• Before assemble the main shaft, please put on the glue in front of the screw



• To avoid it loose



• Use your hand to screw it approx.



• After Screw in the front main shaft



• Use J-15 ◦ Screw it according to the position of tenon ◦



• Screw it on



• Finish ◦



• Use J-02 › Clip the ring ◦



• Pull it out ◦



• Opposite Direction to loose switch to the valve ◦



• switch valve take off



• press out and change o-ring ◦



• Use J-07 › Insert Switch Valve ◦



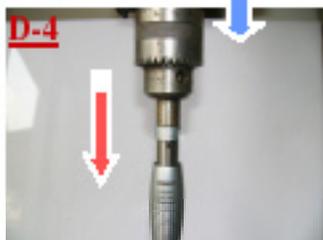
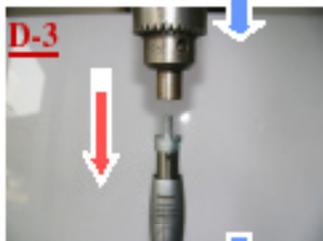
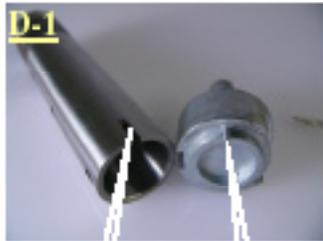
• Opposite Direction to loose out the valve ◦



• Take off the valve ◦

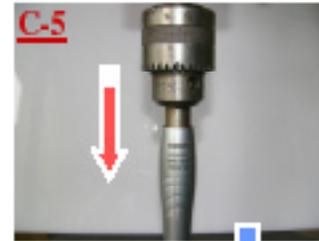


• Use J-28 › put on the extruding platform ◦
 • Use J-04 ◦
 • Point to the hole and press it down to let Cylinder cover separate to the cover



SKILL :

- Please point the Cylinder Cover to the Air Inlet Cover
- Please point the Cylinder Cover to the Air Inlet Cover
- USE J-04 ◦
- USE J-46 ◦ insert extruding platform clamping tool ◦
- point to the center ◦ and press it to the down ◦



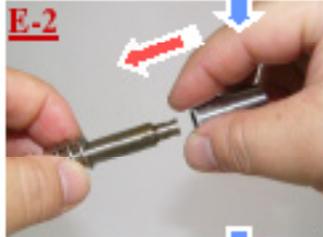
- Press it to the end ◦
- Use J-07 to insert the switch and screw it ◦
- Insert the switch valve ◦
- insert C type ring ◦ and point to tenon ◦
- finished ◦

UR-300 E.Assembly Main Shaft

TOOL :



• entering the filling piece ◦



•Loads the slippery set ◦



• Insert the back spring ◦



•Install the filling piece, as well as the slippery set, inner tube, and inspect whether skids smoothly ◦



•Screw on the nut ◦



skill :

• Please press the spring inside while you screw it ◦



• Insert 3 mm round point on the nut cover ◦ And screw it ◦



• Insert the holder ◦



• Insert 3 mm 6 angle screw, and screw it on ◦



• Finish ◦



• No.4 Orientate bead ◦



• No.5 Lasting grinding pipe ◦



• No.7 Front spring ◦



• No.11 back spring ◦