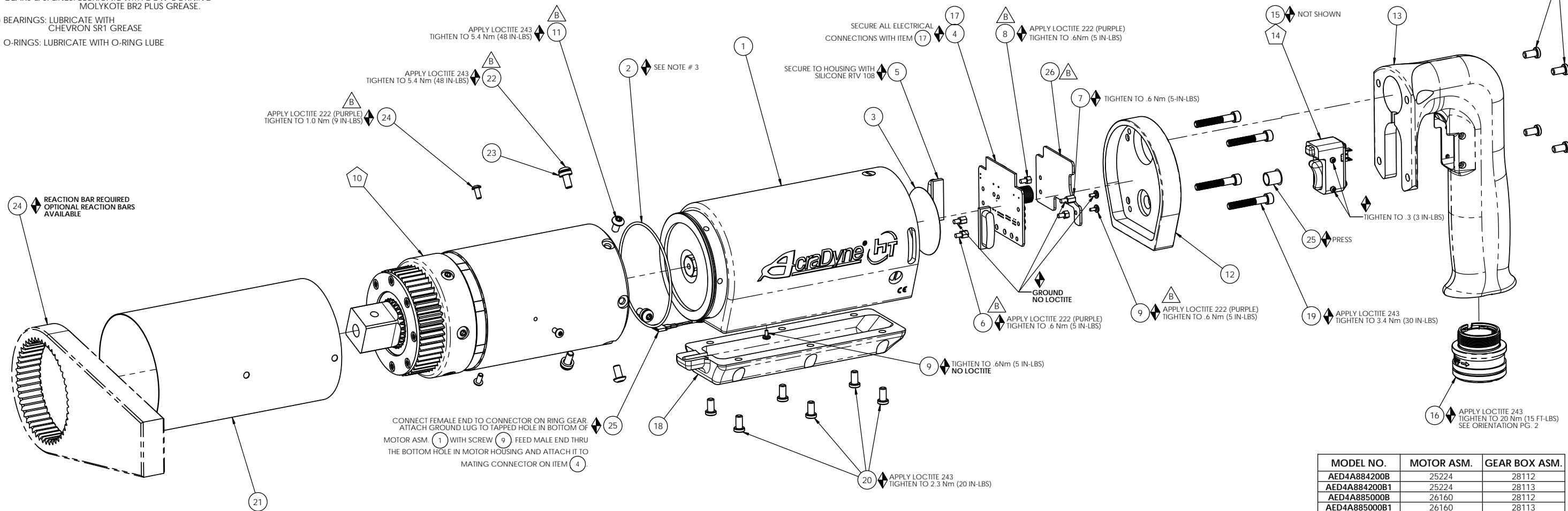


◆ ASSEMBLY INSTRUCTIONS

◇ SUB-ASSEMBLY

- 1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- 2) BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
- 3) O-RINGS: LUBRICATE WITH O-RING LUBE

24 ◆ REACTION BAR REQUIRED
OPTIONAL REACTION BARS
AVAILABLE



CONNECT FEMALE END TO CONNECTOR ON RING GEAR. ATTACH GROUND LUG TO TAPPED HOLE IN BOTTOM OF MOTOR ASM. (1) WITH SCREW (9) FEED MALE END THRU THE BOTTOM HOLE IN MOTOR HOUSING AND ATTACH IT TO MATING CONNECTOR ON ITEM (4)

MODEL NO.	MOTOR ASM.	GEAR BOX ASM.
AED4A884200B	25224	28112
AED4A884200B1	25224	28113
AED4A885000B	26160	28112
AED4A885000B1	26160	28113

COMMENTS	ITEM	PART NUMBER	QTY.	DESCRIPTION
	1	SEE CHART	1	MOTOR ASM.
	2	27714	1	O-RING 3" ID
	3	24840	1	FOIL SEAL 2" DIA
	4	27796	1	TID BOARD, POPULATED W/AMP CIRCUIT
	5	25490	2	LENS, LED
B	6	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	7	25574	1	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
B	8	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	9	25573	5	SCREW PHP 4-40 X 3/16 18-8 SS
	10	SEE CHART	1	GEARBOX ASM.
B	11	29279	3	SCREW, BHSC, TORX, 10-32 x 3/8, STEEL
	12	25225	1	END GRIP CAP, HT TOOLS
	13	25229	1	AXIAL HANDLE, HT TOOLS
	14	25212	1	SWITCH SUB-ASSEMBLY
	NOT SHOWN	25582	1	TRIGGER CABLE
	16	25505	1	TOOL CONNECTOR ASM HERC PISTOL
	NOT SHOWN	28257	A/R	CABLE TIE, 1.65MM W X 71MM LG.
	18	25231	1	TRAY, WIRE, END GRIP
	19	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	20	25569	10	SCREW LHCS 10-32 X 3/8 18-8 SS
	21	25284	1	HT TOOL TRANSDUCER SLEEVE
B	22	29284	3	SCREW, BHSC, TORX, 10-32 X 1/2, STEEL
	23	25564	3	WASHER SHIM .093THK .25ID .375OD
	24	25218	3	SCREW, BHSC, 6-32 X 5/16, SS
	25	25579	1	PLUG 3/8"
	24	26898	1	CHOOSE REACTION BAR
	25	28211	1	(4) LINE MALE/FEMALE JUMPER ASM.
B	26	29338	1	TID WIRE INSULATOR



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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
DIMENSIONS AND TOLERANCING PER ANSI Y14.5
SURFACE ROUGHNESS PER ANSI Y14.36

BLOCK TOLERANCING PER DECIMAL:
X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005
ANGLE = ±0°30'

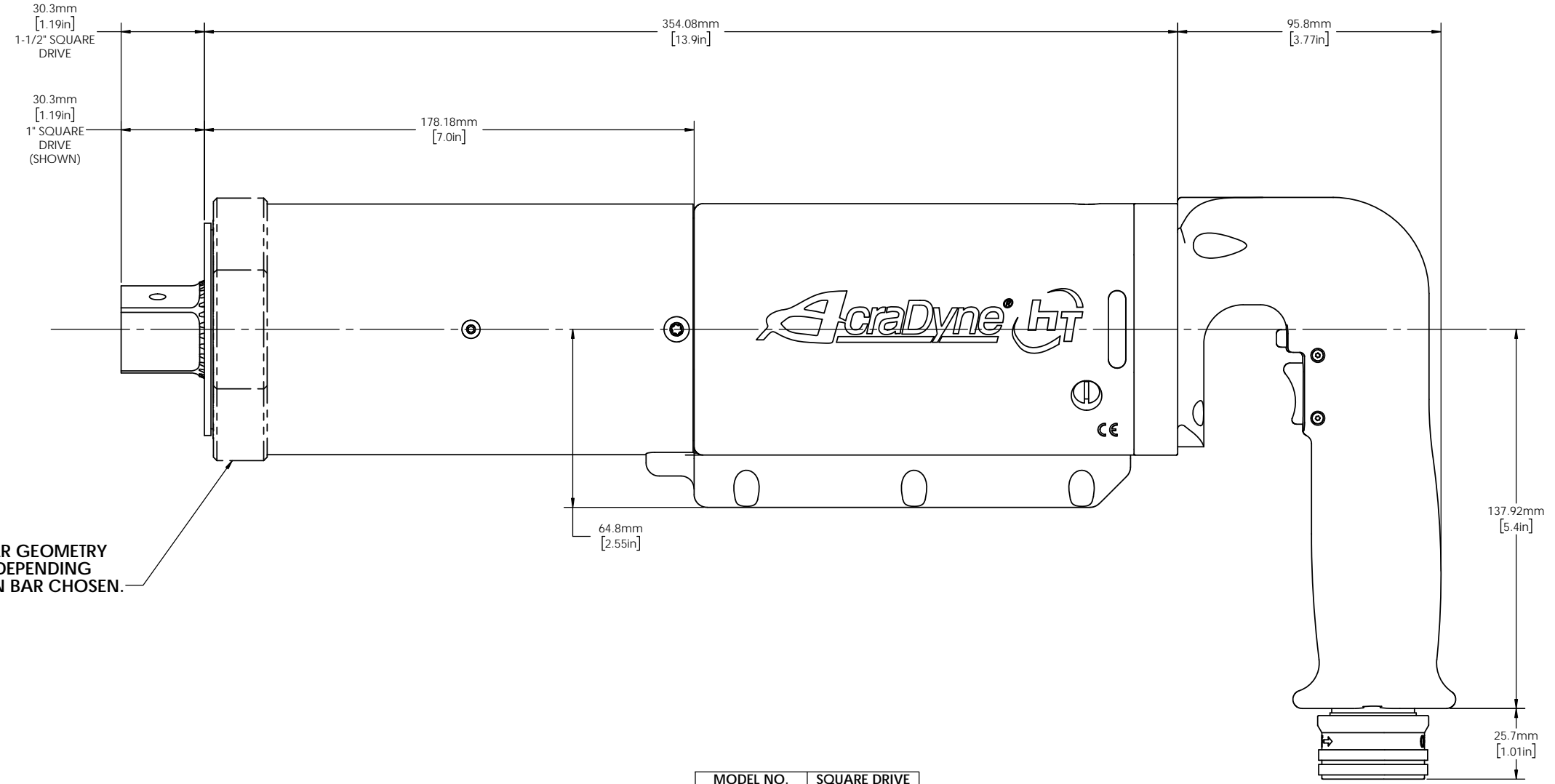
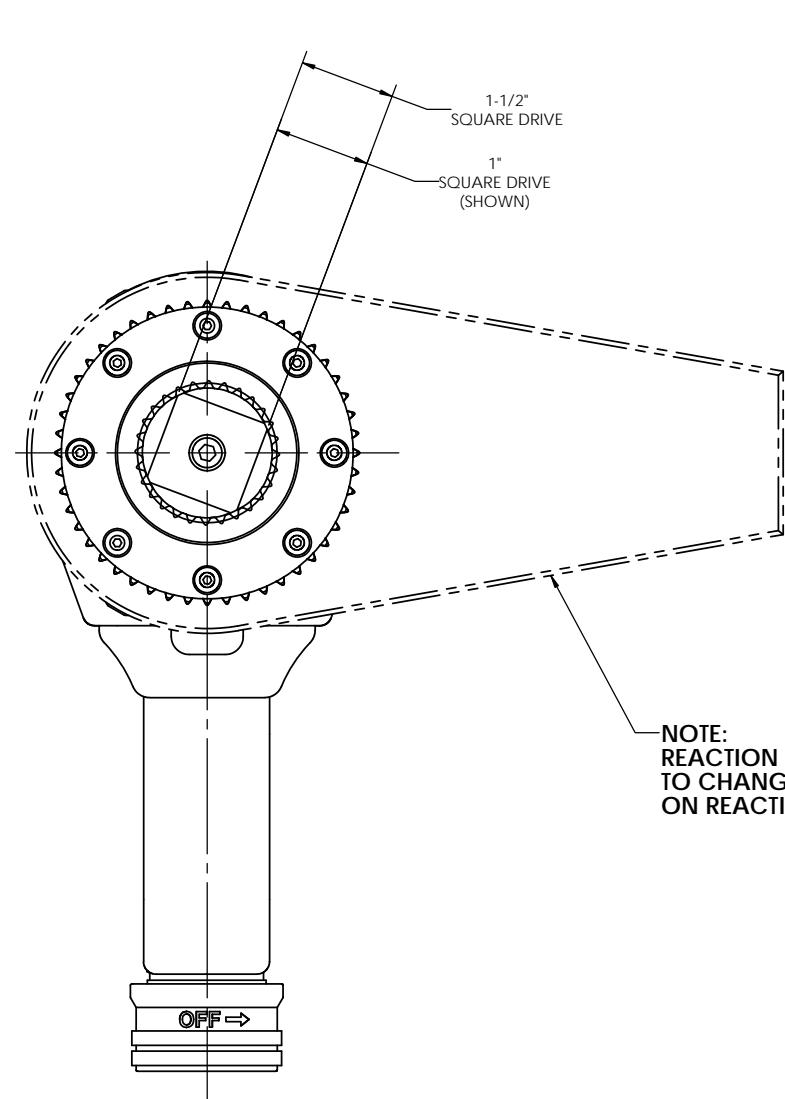
REMOVE BURRS AND SHARP EDGES: R.015 MAX
MACHINE SURFACE FINISH: 125 RMS OR BETTER

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ACRADYNE MECHANICAL ENGINEERING

AED4A88_ _ _ B_
"D" HANDLE NUTRUNNER
8000 SERIES

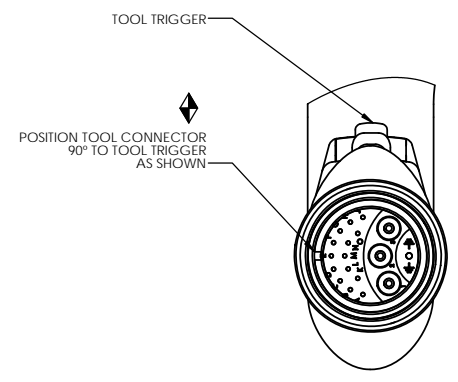
SIZE	PART / DRAWING NUMBER	REVISION
D	AED4A88_ _ _ B_	B

SCALE: 2:3 DO NOT SCALE DRAWING SHEET 1 OF 2



NOTE:
REACTION BAR GEOMETRY
TO CHANGE DEPENDING
ON REACTION BAR CHOSEN.

MODEL NO.	SQUARE DRIVE
AED4A884200B	1-1/2"
AED4A884200B1	1"
AED4A885000B	1-1/2"
AED4A885000B1	1"



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SIZE	PART / DRAWING NUMBER	REVISION
D	AED4A88__B	B

SCALE: 1:1 DO NOT SCALE DRAWING SHEET 2 OF 2