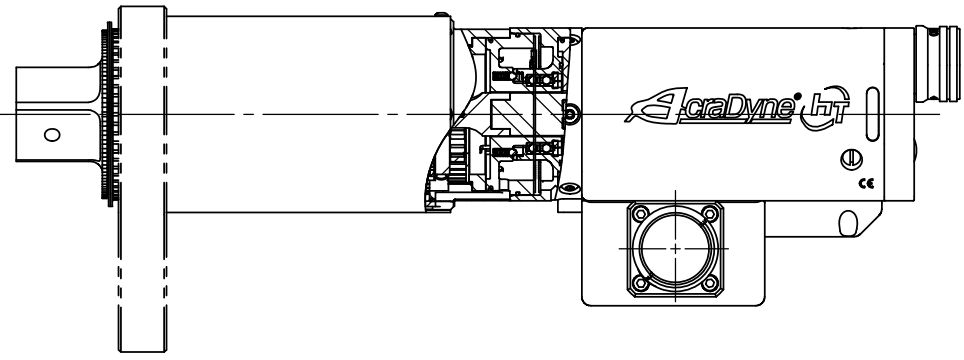
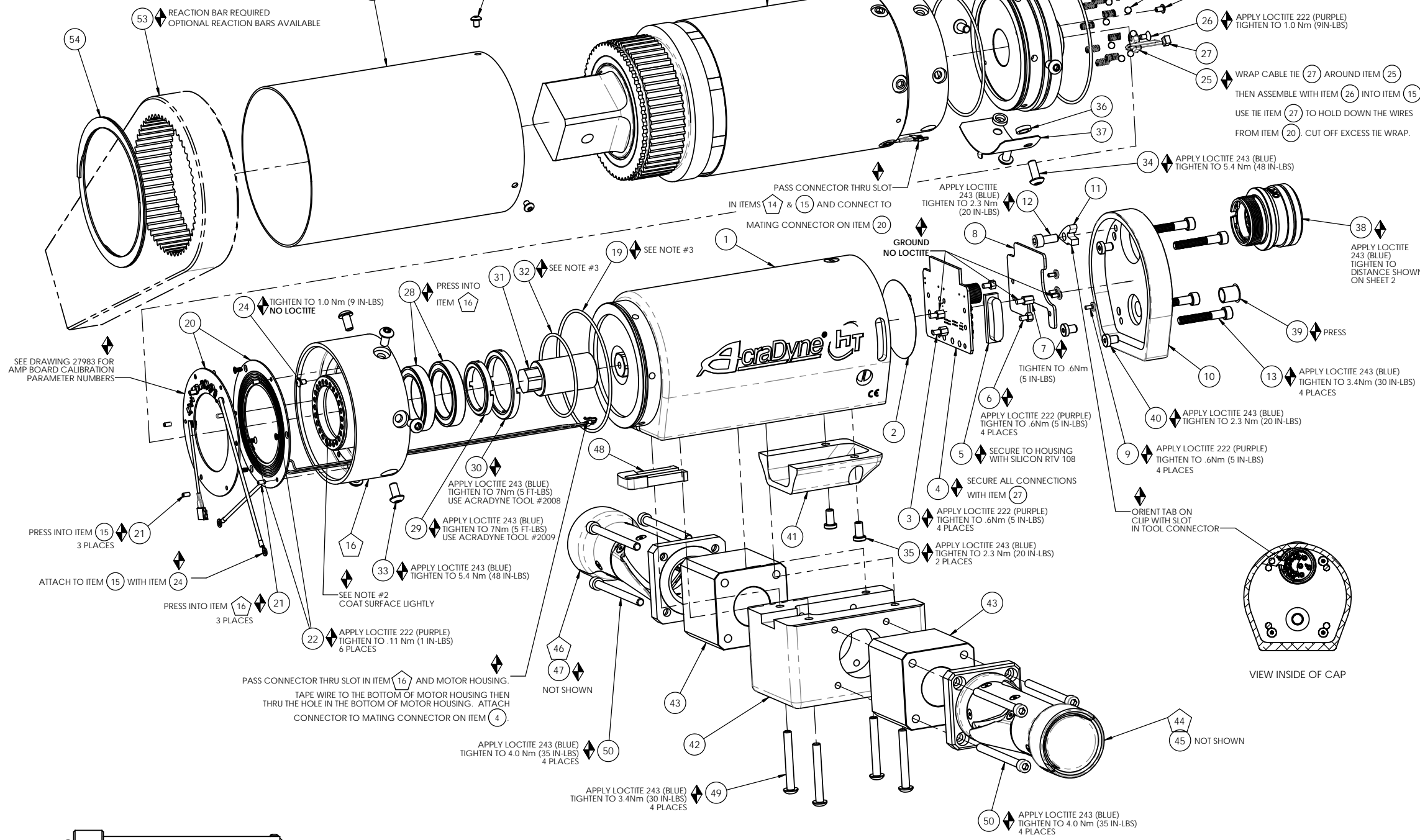


- ◆ ASSEMBLY INSTRUCTIONS
- ◻ SUB-ASSEMBLY

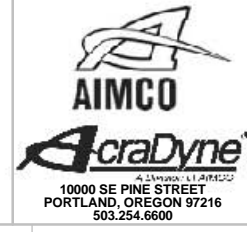
- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
- O-RINGS: LUBRICATE WITH O-RING LUBE



◆ NOTE:
SEE WORK INSTRUCTION DOCUMENT "EWI-011"
FOR COMPLETE ASSEMBLY INSTRUCTIONS.

MODEL NO.	GEARBOX ASM.	SLIP RING SET
AEF4B896500BDL	28114	27983.005
AEF4B898100BDL	28115	27983.006

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26160	1	MOTOR ASM.
	2	24840	1	FOIL SEAL 2" DIA
	3	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	4	27797	1	TID BOARD, POPULATED W/O AMP CIRCUIT
	5	25490	2	LENS, LED
	6	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	7	25574	1	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
	8	29338	1	TID WIRE INSULATOR
	9	25573	4	SCREW PHP 4-40 X 3/16 18-8 SS
	10	25225	1	END GRIP CAP, HT TOOLS
	11	27063	1	TOOL CONNECTOR CLIP
	12	26458	1	SCREW, SHC 10-32 X .44 LG., STEEL, BLACK OXIDE
	13	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	14	SEE CHART	1	GEAR BOX ASM.
	15	27978	1	SLIP RING INNER PLATE
	16	28278	1	SLIP RING OUTER PLATE SUB-ASM.
	17	28174	8	SPRING, COMPRESSION
	18	20105	8	DETENT BALL
	19	27714	2	O-RING 3" ID
SEE WORK INSTRUCTIONS	20	SEE CHART	1	SLIP RING SET
	21	27994	6	DOWEL PIN, Ø.0938 X .1875 LG., STEEL
	22	27993	6	SCREW, FHPM, 2-56, 18-8SS, PLAIN
	23	27953	1	O-RING, 70 DURO BUNA N, -.042
	24	25745	2	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	25	28000	1	CABLE TIE-MOUNT
	26	24940	1	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	27	28257	4	CABLE TIE, 1.65MM W X 71MM LG
	28	25969	2	BEARING, BALL, Ø42mm X Ø30mm X 7mm
	29	25961	1	BEARING RETAINER, INNER
	30	25962	1	BEARING RETAINER, OUTER
	31	27980	1	SLIP RING PINION ADAPTER
	32	26080	1	O-RING, LED LIGHT RING COVER
	33	29279	10	SCREW, BHSC, TORX, 10-32 x 3/8, STEEL
	34	29284	2	SCREW, BHSC, TORX, 10-32 x 1/2, STEEL
	35	25569	2	SCREW LHCS 10-32 X 3/8 18-8 SS
	36	25564	2	WASHER SHIM .093THK .25ID .375OD
	37	28204	1	RING GEAR COVER, 8100Nm
	38	25507	1	TOOL CONNECTOR ASM HERC PISTOL
	39	25579	1	PLUG 3/8"
	40	24859	3	LHSC 10-32 X 1/4 BLK OXIDE
	41	29503	1	TRAY, WIRE, HT TOOLS, DUAL LEVER
	42	28060	1	HANDLE BLOCK, HT DUAL LEVER
	43	28059	2	HANDLE SPACER, HT DUAL LEVER
	44	28070	1	HANDLE ASM., DUAL LEVER, MFB DISABLED
NOT SHOWN	45	29674	1	TRIGGER CABLE
NOT SHOWN	46	28066	1	HANDLE ASM., DUAL LEVER
NOT SHOWN	47	29678	1	TRIGGER CABLE
	48	24838	1	TRANSDUCER CABLE CHASE
	49	26228	4	SCREW, BHSC 10-32X1.50, STEEL, BLACK OXIDE
	50	28002	8	SCREW, SHC, 10-32 X 2.5, STEEL
	51	26636	1	GEAR CASE COVER
	52	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	53	26899	1	CHOOSE REACTION BAR
	54	26436	1	RETAINING RING, SPIRAL, Ø3.833 X Ø3.293 X .111



DOCUMENT CONTROL
PRINTED COPIES OF THIS DOCUMENT ARE CONSIDERED TO BE UNCONTROLLED DOCUMENTS. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL
THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL TO ACRADYNE/AIMCO. IN THE ABSENCE OF EXPRESSED WRITTEN PERMISSION, ACRADYNE/AIMCO HAS LOANED THIS COPY WITH THE MUTUAL UNDERSTANDING THAT (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN FOR THAT IN WHICH IT WAS PROVIDED, (B) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS, (C) IT WILL NOT BE REPRODUCED, AND (D) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL

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'

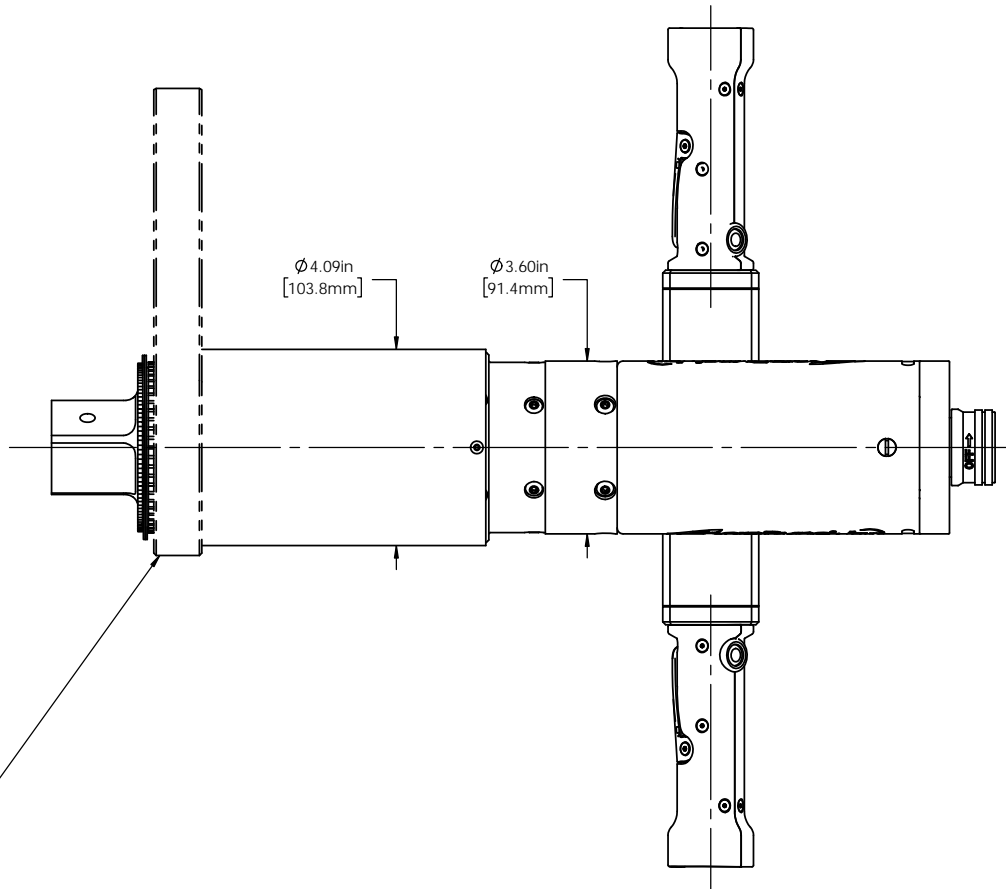
REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

FIXTURED NUTRUNNER W/SLIP RING CLUTCH DUAL LEVER 8000 SERIES

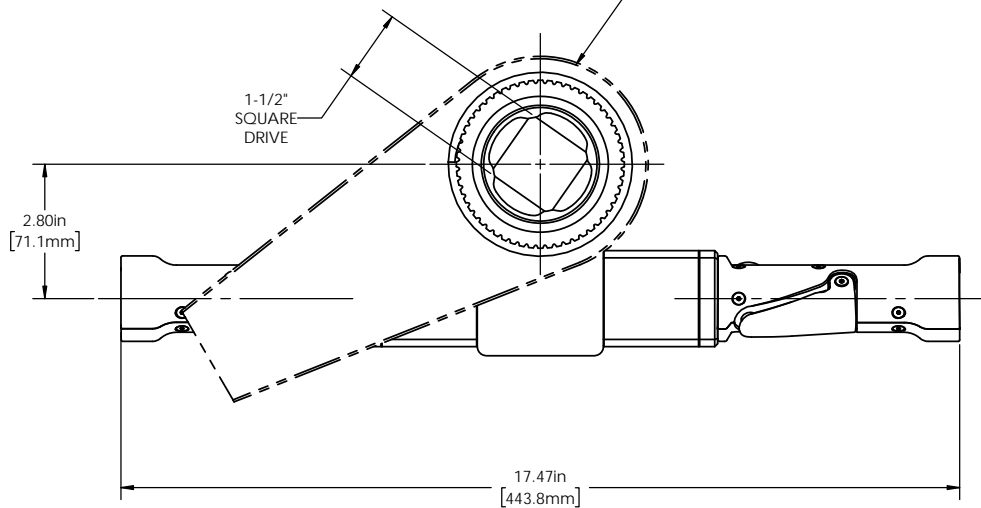
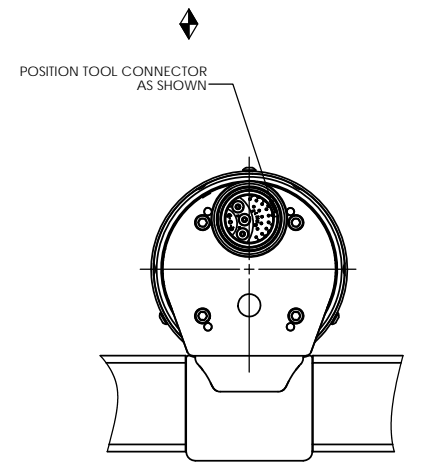
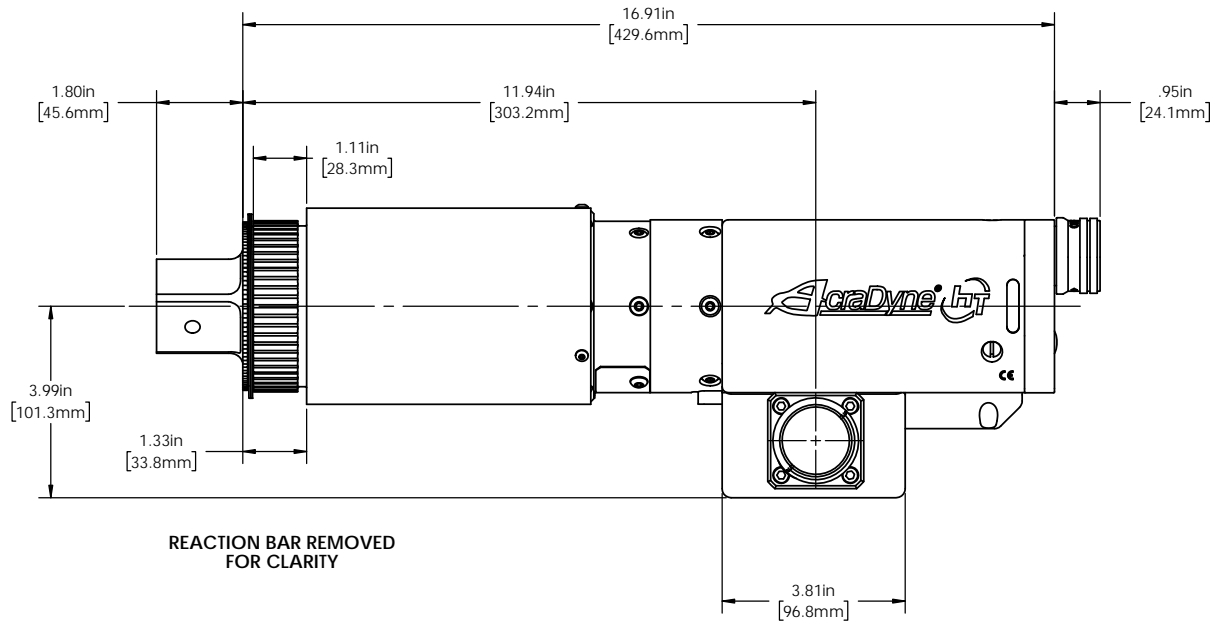
SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4B89_00BDL	A

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



MODEL NO.
AEF4B896500BDL
AEF4B898100BDL

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



REACTION BAR REMOVED
FOR CLARITY



DOCUMENT CONTROL
PRINTED COPIES OF THIS DOCUMENT ARE CONSIDERED TO BE UNCONTROLLED DOCUMENTS. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL
THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL TO ACRADYNE/AIMCO. IN THE ABSENCE OF EXPRESSED WRITTEN PERMISSION, ACRADYNE/AIMCO HAS LOANED THIS COPY WITH THE MUTUAL UNDERSTANDING THAT (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN FOR THAT IN WHICH IT WAS PROVIDED, (B) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS, (C) IT WILL NOT BE REPRODUCED, AND (D) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

FIXTURED NUTRUNNER W/SLIP RING CLUTCH DUAL LEVER 8000 SERIES		
SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4B89_00BDL	A
SCALE 1:2	DO NOT SCALE DRAWING	SHEET 2 OF 2