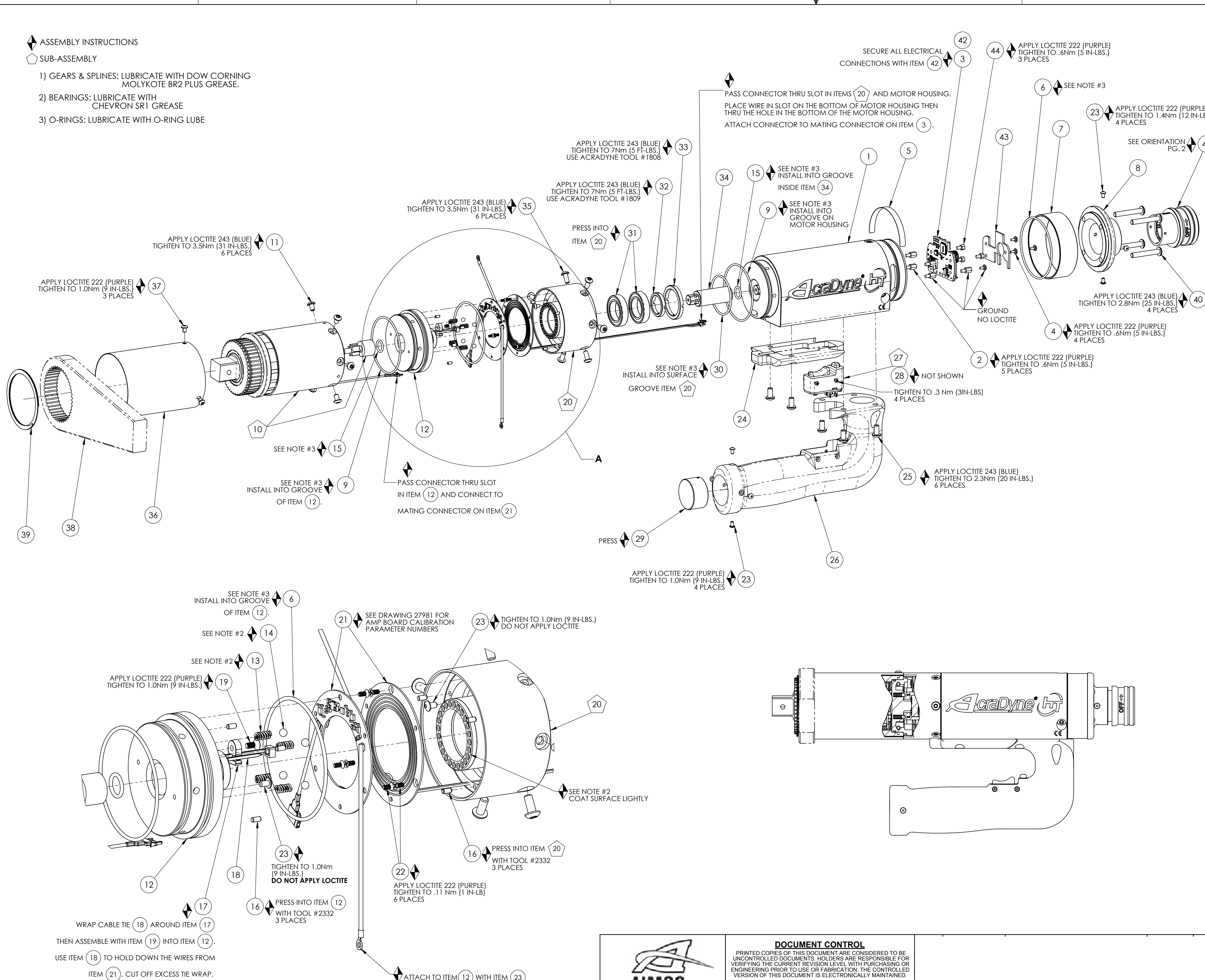


◆ ASSEMBLY INSTRUCTIONS
 ◊ SUB-ASSEMBLY

- 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



DETAIL A
SCALE 1 : 1

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26481	1	MOTOR ASM.
	2	25574	5	STANDOFF, M-F, 4-40x1/4, 3/16 HEX, SS
	3	27785	1	TID BOARD, POPULATED W/O AMP CIRCUIT
	4	25573	4	SCREW PHP 4-40 X 3/16 18-8 SS
	5	20534	1	SERIAL/MODEL LABEL
	6	26487	2	O-RING, LED COVER
	7	26483	1	LED COVER
	8	26462	1	END CAP, "J" HANDLE
	9	26488	2	O-RING, MOTOR HOUSING
	10	SEE CHART	1	GEARBOX ASM.
	11	29273	6	SCREW, BHSC, TORX 8-32 X .25, STEEL
	12	27972	1	CLUTCH PLATE, SLIP RING INNER
	13	28174	4	SPRING, COMPRESSION
	14	20105	4	DETENT BALL
	15	26299	2	O-RING, PINION
	16	27994	6	DOWEL PIN, Ø.0938 X .1875 LG., STEEL
	17	28000	1	CABLE TIE-MOUNT
	18	28257	4	CABLE TIE, 1.65MM W X 71MM LG
	19	24940	1	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	20	28276	1	SLIP RING OUTER PLATE SUB-ASM.
SEE WORK INSTRUCTIONS EWI-011	21	SEE CHART	1	SLIP RING SET
	22	27993	6	SCREW, FHPM, 2-56X.188, 18-8SS, PLAIN
	23	25745	10	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	24	26296	1	WIRE TRAY, "J" HANDLE
	25	26206	6	SCREW, BHSC 10-32 X .375, STEEL
	26	26276	1	"D" / "J" HANDLE
	27	25212	1	SWITCH SUB-ASSEMBLY
NOT SHOWN	28	26526	1	TRIGGER CABLE ASM.
	29	26239	1	"J" HANDLE PLUG
	30	27204	1	O-RING, OUTER CLUTCH PLATE
	31	20909	2	BALL BEARING, .7974 X 1.2598 X .2760 IN
	32	26887	1	BEARING RETAINER, INNER
	33	26884	1	BEARING RETAINER, OUTER
	34	27974	1	SLIP RING PINION ADAPTOR, CLUTCH
	35	29285	6	SCREW, BHSC, TORX, 8-32 X .38, STEEL
	36	26495	1	GEAR CASE COVER
	37	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	38	26896	1	CHOOSE REACTION BAR
	39	26514	1	RETAINING RING, SPIRAL, Ø2.441 X Ø2.105 X .078
	40	27401	4	SCREW, BHSC 10-32 X 1.25, STEEL, BLK OXIDE
	41	26280	1	TOOL CONNECTOR ASM., "J" HANDLE
NOT SHOWN	42	27464	A/R	TWISTED WAXED LINEN TWINE
	43	29336	1	TID BOARD WIRE INSULATOR
	44	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS

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

MODEL NO.	GEARBOX ASM.	SLIP RING SET
AEJ4B6250B	28658	27981.005
AEJ4B6425B	28798	27981.006
AEJ4B6625B	28108	27981.007
AEJ4B6925B	28109	27981.008



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

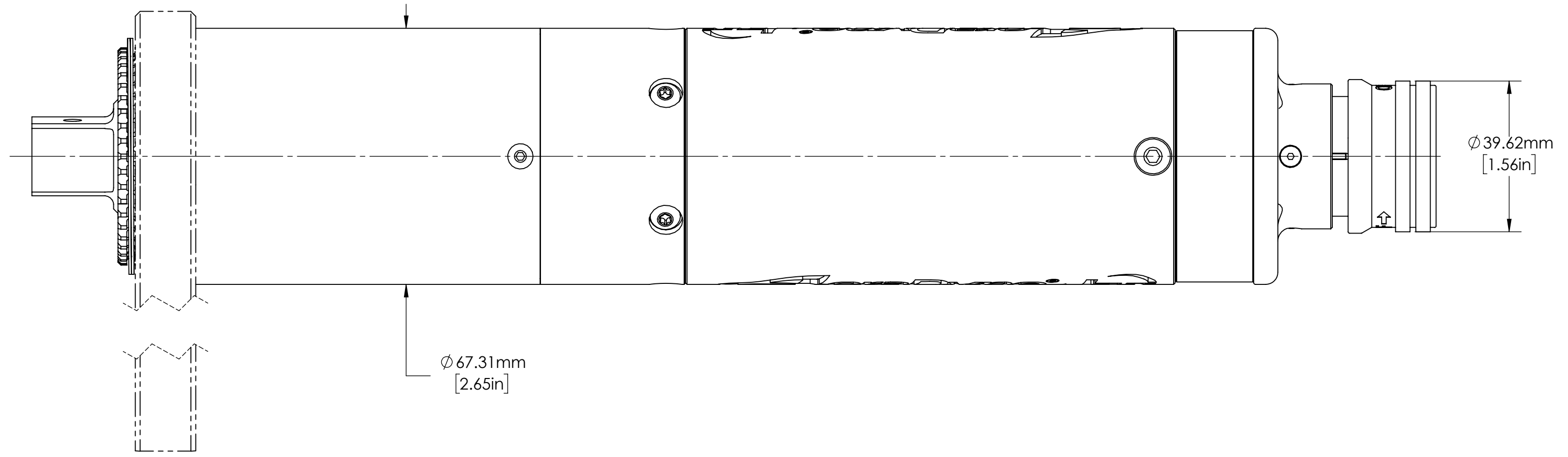
REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINE SURFACE FINISH: 125 RMS OR BETTER

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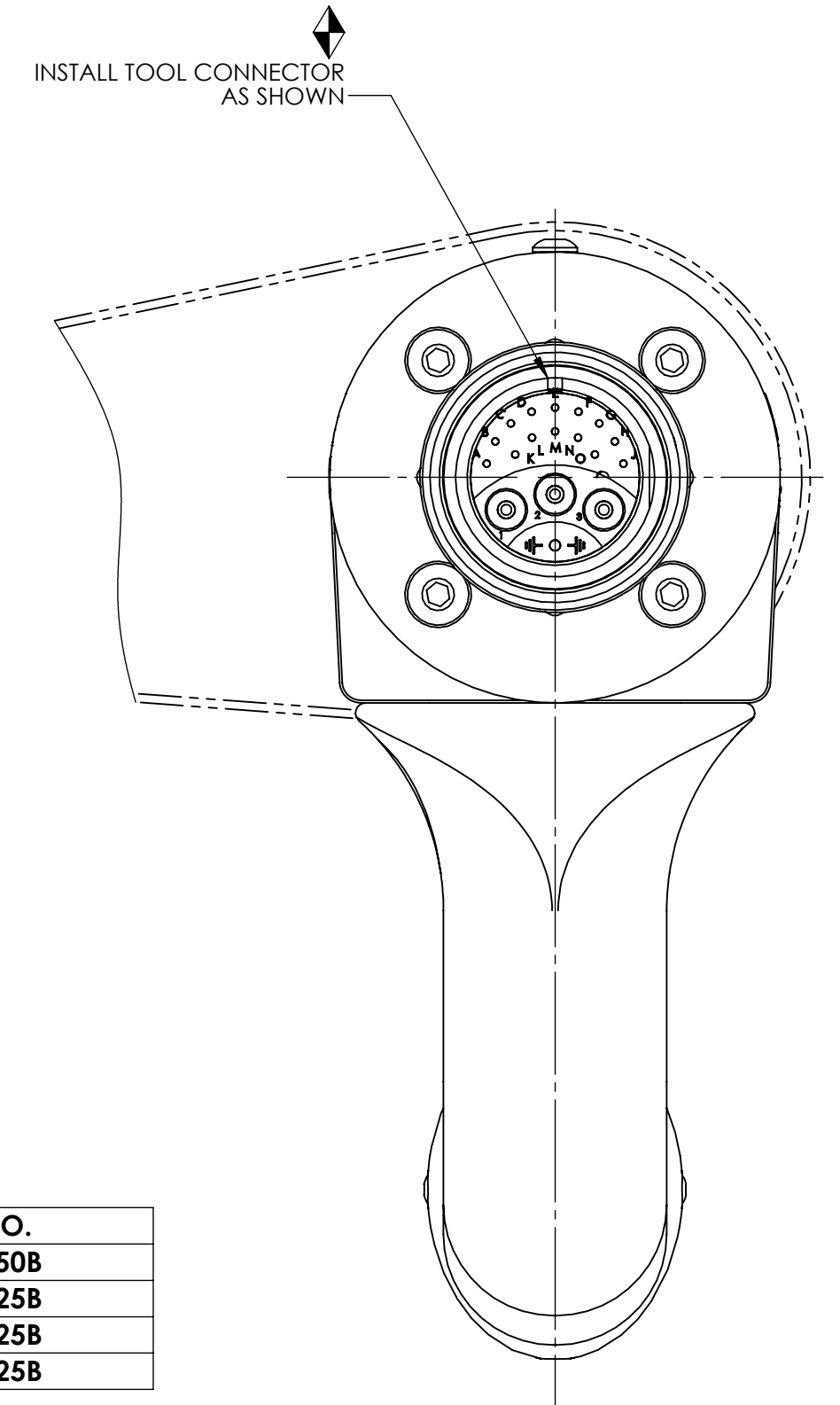
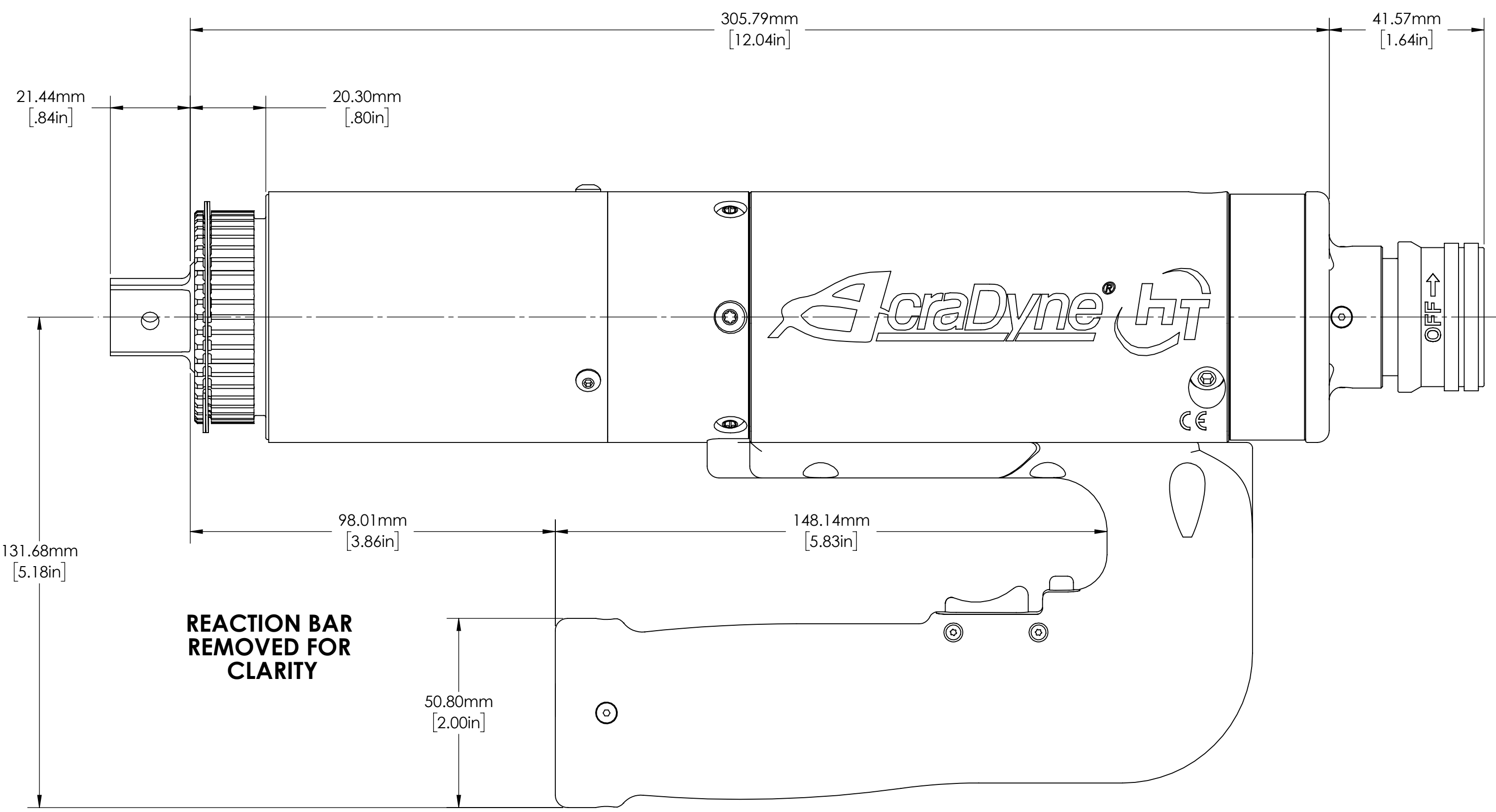
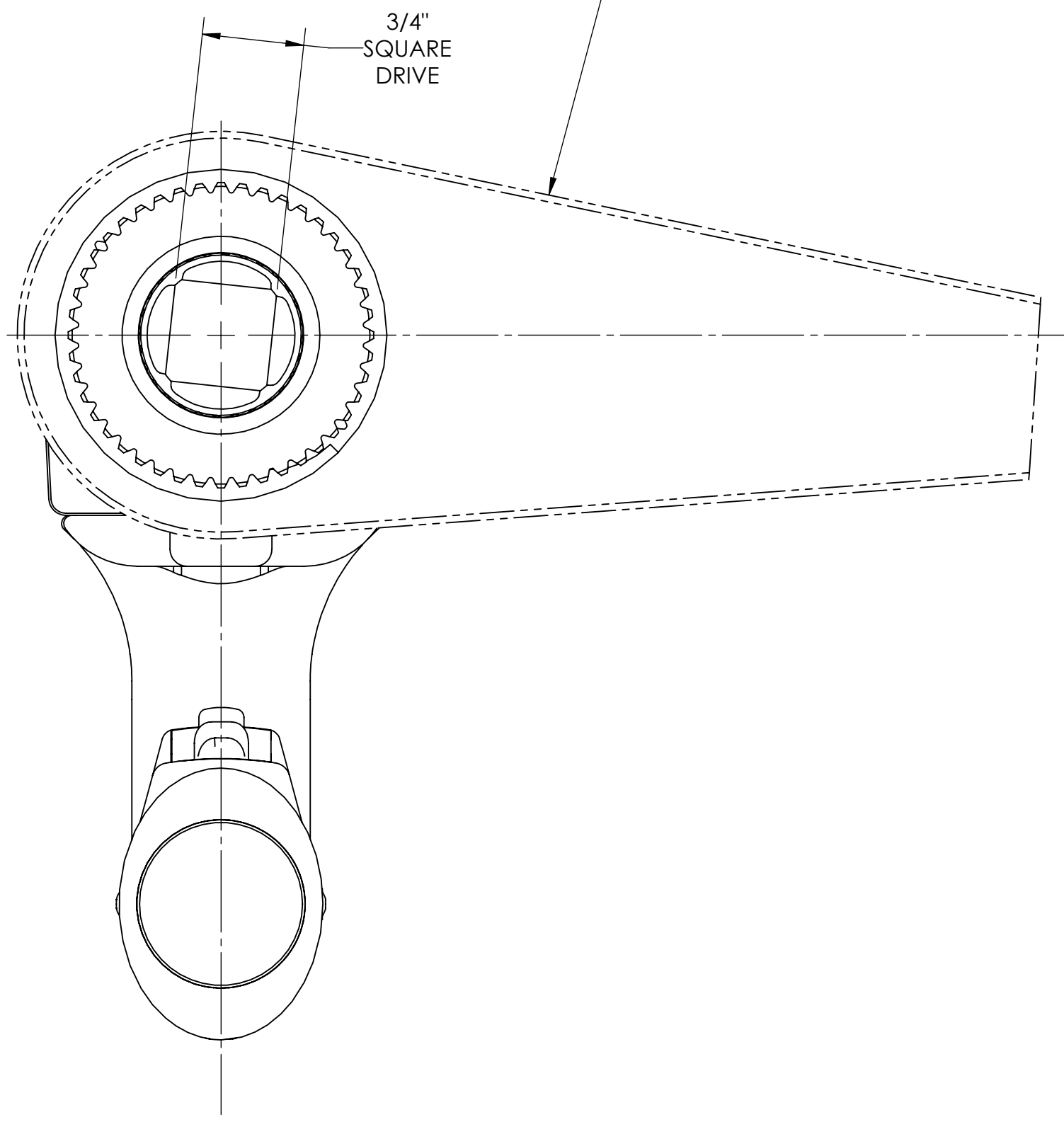
**"J" HANDLE NUTRUNNER
W/SLIP RING CLUTCH
6000 SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
D	AEJ4B66 _ B	A

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



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



MODEL NO.
AEJ4B66250B
AEJ4B66425B
AEJ4B66625B
AEJ4B66925B



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**DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING**

"J" HANDLE NUTRUNNER W/SLIP RING CLUTCH 6000 SERIES		
SIZE	PART / DRAWING NUMBER	REVISION
D	AEJ4B66 B	A
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2