

- ◆ ASSEMBLY INSTRUCTIONS
 ◡ SUB-ASSEMBLY
- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
 - BEARINGS: LUBRICATE WITH CHEVRON SRT GREASE
 - O-RINGS: LUBRICATE WITH O-RING LUBE

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	SEE CHART	1	MOTOR ASM., 8000-SERIES
	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	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	6	29338	1	TID WIRE INSULATOR
	7	25574	1	STANDOFF M-F, 4-40X1/4, 3/16 HEX, SS
	8	25573	4	SCREW PHP 4-40 X 3/16 18-8 SS
	9	24859	3	LHSC 10-32 X 1/4 BLK OXIDE
	10	25490	2	LENS, LED
	11	25225	1	END GRIP CAP, HT TOOLS
	12	27063	1	TOOL CONNECTOR CLIP
	13	26015	1	SCREW, BHSC, 10-32 X .313, SS
	14	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	15	SEE CHART	1	GEAR BOX ASM.
	16	27978	1	SLIP RING INNER PLATE
	17	28278	1	SLIP RING OUTER PLATE SUB-ASM.
	18	27714	2	O-RING 3" ID
SEE WORK INSTRUCTIONS	19	27983	1	SLIP RING SET
	20	27994	6	DOWEL PIN, Ø.0938 X .1875 LG., STEEL
	21	28000	1	CABLE TIE-MOUNT
	22	28257	4	CABLE TIE, 1.65MM W X 71MM LG
	23	27993	6	SCREW, FHPM, 2-56, 18-8SS, PLAIN
	24	27953	1	O-RING, 70 DURO BUNA N, -042
	25	28174	8	SPRING, COMPRESSION
	26	20105	8	DETENT BALL
	27	24940	1	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	28	25745	2	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	29	25969	2	BEARING, BALL, Ø42mm X Ø30mm X 7mm
	30	25961	1	BEARING RETAINER, INNER
	31	25962	1	BEARING RETAINER, OUTER
	32	27980	1	SLIP RING PINION ADAPTER
	33	26080	1	O-RING, LED LIGHT RING COVER
	34	25229	1	AXIAL HANDLE, HT TOOLS
	35	25985	1	TRANSDUCER WIRE COVER FOR MOD 25232
	36	25984	1	TRANSDUCER WIRE TRAY
	37	25564	3	WASHER SHIM .093THK .25ID .375OD
	38	29284	3	SCREW, BHSC, TORX, 10-32 X 1/2, STEEL
	39	29279	9	SCREW, BHSC, TORX, 10-32 X 3/8, STEEL
	40	25212	1	SWITCH SUB-ASSEMBLY
NOT SHOWN	41	25582	1	TRIGGER CABLE
	42	25569	6	SCREW LHCS 10-32 X 3/8 18-8 SS
	43	25507	1	TOOL CONNECTOR ASM HERC PISTOL
	44	28203	1	HT TOOL TRANSDUCER SLEEVE
	45	25218	3	SCREW, BHSC, 6-32 X 5/16, SS
	46	26898	1	CHOOSE REACTION BAR
	47	25579	1	PLUG 3/8"
	48	24858	1	PLUG 1 3/16"

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

MODEL NO.	MOTOR ASM.	GEARBOX ASM.	SLIP RING SET
AEJ4B884200B	25224	28112	27983.002
AEJ4B884200B1		28113	
AEJ4W884650B		28112	27983.003
AEJ4W884650B1	26160	28113	
AEJ4B885000B		28112	27983.004
AEJ4B885000B1		28113	



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.

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 = 30°

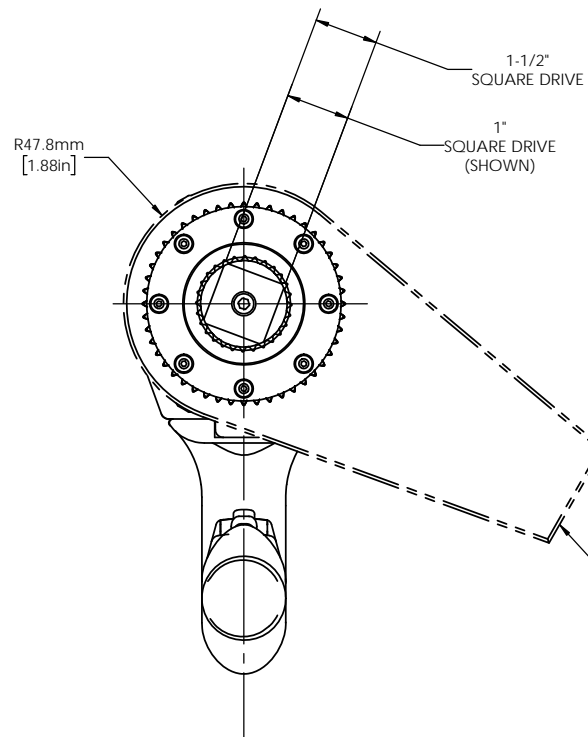
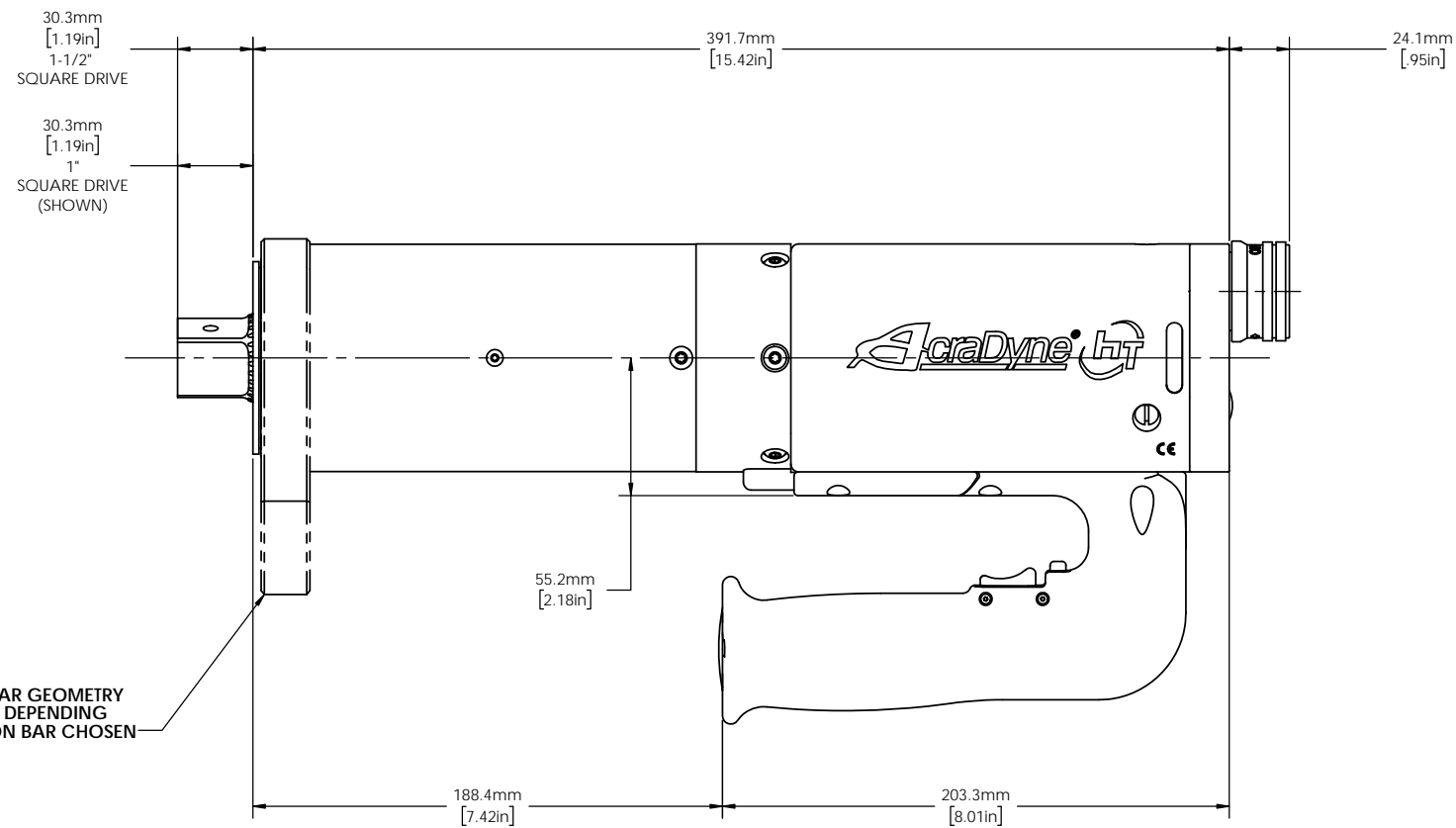
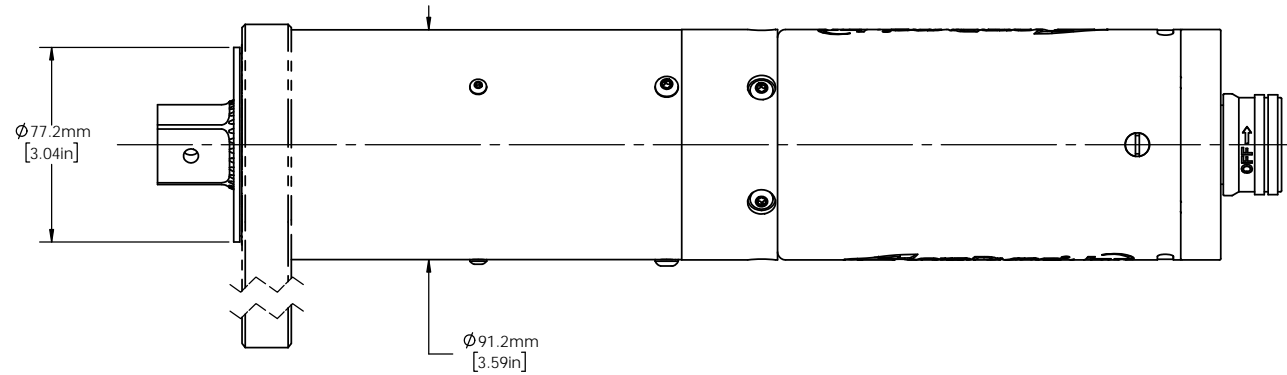
REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINING SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

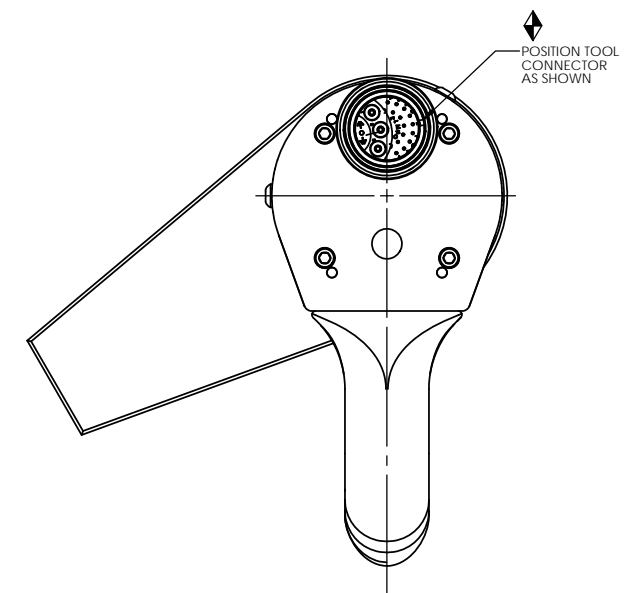
"J" HANDLE NUTRUNNER W/SLIP RING CLUTCH 8000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEJ4_88__ _ _ B_	B

SCALE 1:8 DO NOT SCALE DRAWING SHEET 1 OF 2



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



MODEL NO.	SQUARE DRIVE
AEJ4B884200B	1-1/2"
AEJ4B884200B1	1"
AEJ4W884650B	1-1/2"
AEJ4W884650B1	1"
AEJ4B885000B	1-1/2"
AEJ4B885000B1	1"



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.

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

**"J" HANDLE NUTRUNNER
W/SLIP RING CLUTCH
8000 SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
D	AEJ4_88_ _ _ _ B_	B

SCALE 1:8 DO NOT SCALE DRAWING SHEET 2 OF 2