



AIMCO

AcraDyne®
A Division of AIMCO

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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 = ° ' 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**

SIZE	PART / DRAWING NUMBER	REVISION
D	AEP4A120__BQ	G
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25803	1	PISTOL MOTOR ASM.
	2	26599	1	LED PCB ASSY, PISTOL
	3	27016	2	NUT, HEX, 4-40 UNDERSIZED, STEEL ZINC
	4	24780	1	MOTOR COUPLER SUB-ASM.
	5	25763	1	TRANSDUCER ADAPTOR
	6	SEE CHART	1	TRANSDUCER SUB-ASM.
	7	SEE CHART	1	GEAR CASE SUB-ASM.
	8	SEE CHART	1	STRAIGHT OUTPUT ASSY, Q.C.
	9	24687	1	O-RING, LIGHT RING, LEVER
	10	24873	1	LIGHT RING
	11	24686	1	RETAINING RING, LEVER LIGHT RING
	12	26667	1	PISTOL HANDLE, 1000 SERIES
	13	25871	1	SWITCH SUB-ASSEMBLY
	14	25424	1	GROUND WIRE ASM.
	15	25814	2	SCREW, PAN HEAD PHILLIPS, 4-40 x 3/16, STAR WASH, SS
	16	25849	1	T.I.D. BOARD ASM., PISTOL
	17	25788	1	CABLE, TRIGGER, GEN 4 PISTOL
	18	24870	1	CONNECTOR SLEEVE, PISTOL HANDLE
	19	25271	1	SHIM. - .002
	20	25272	1	SHIM. - .005
	21	25273	1	SHIM. - .010
	22	24935	2	SOC HD CAP SCREWS
	23	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	24	SEE CHART	1	REACTION BAR, ALUMINUM, 1000 SERIES
	25	26792	4	SCREW, BHSC 6-32X.50, STEEL, BLACK OXIDE
	26	26791	4	WASHER, FLAT, NO 6 SCREW, STEEL, BLACK OXIDE
	27	26602	1	TOOL CONNECTOR ASSEMBLY
	28	24871	1	END CAP, PISTOL MOTOR

	MODEL NO.	TRANSDUCER ASM.	GEAR CASE ASM.	OUTPUT ASM.	REACTION BAR
1/4" HEX Q.C. CHUCK MODELS	AEP4A12003BQ	25759.001	24860	24896	N/A
	AEP4A12006BQ	25760.002	24860	24896	N/A
	AEP4A12011BQ	25761.003	24709	27043	24696
	AEP4A12014BQ	25761.005	24792	27043	24696



 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
- 4) TIGHTEN TO 1.0 Nm (9IN-LBS) LOCTITE 243 (BLUE)

