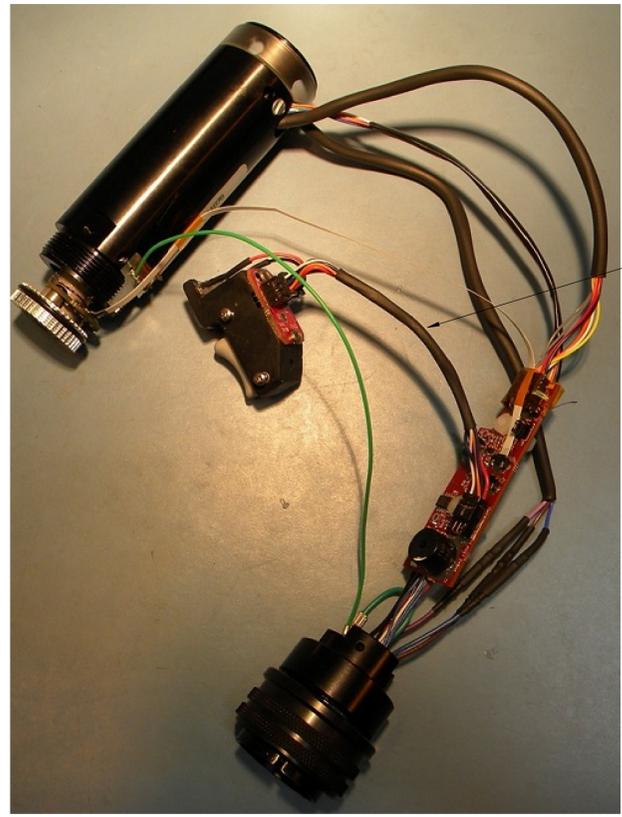


SINGLE STEP MODELS



PRE-WIRE PISTOL AND PROGRAM TID TO TEST MOTOR, CABLING AND TID BOARD BEFORE ASSEMBLING INTO HANDLE

REQUIRED TOOLING	
SNAP-ON CROWFOOT WRENCH, 1/2" SQ. DR. X 1-3/8" OPENING	SNAP-ON PART NUMBER SC044
MAGNETIC VISE JAWS - PART NUMBER 1000-100	
LOCTITE #243 BLUE	
TORQUE WRENCH, 1/2" DRIVE	
LOCTITE #262 RED	



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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'

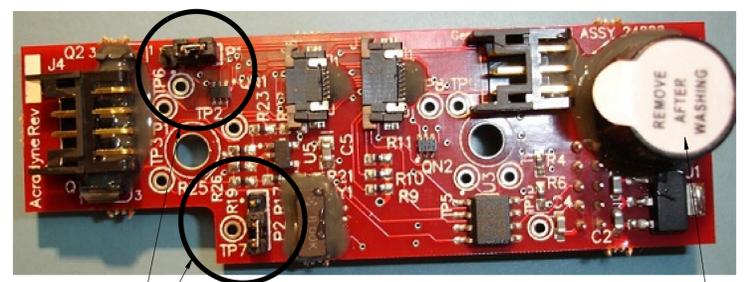
REMOVE BURRS AND SHARP EDGES: R.015 MAX
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AEP4A120_BQ PISTOL NUTRUNNER, Q.C. GEN IV, 1000 SERIES		
SIZE D	PART / DRAWING NUMBER AEP4A120_BQ	REVISION G
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2

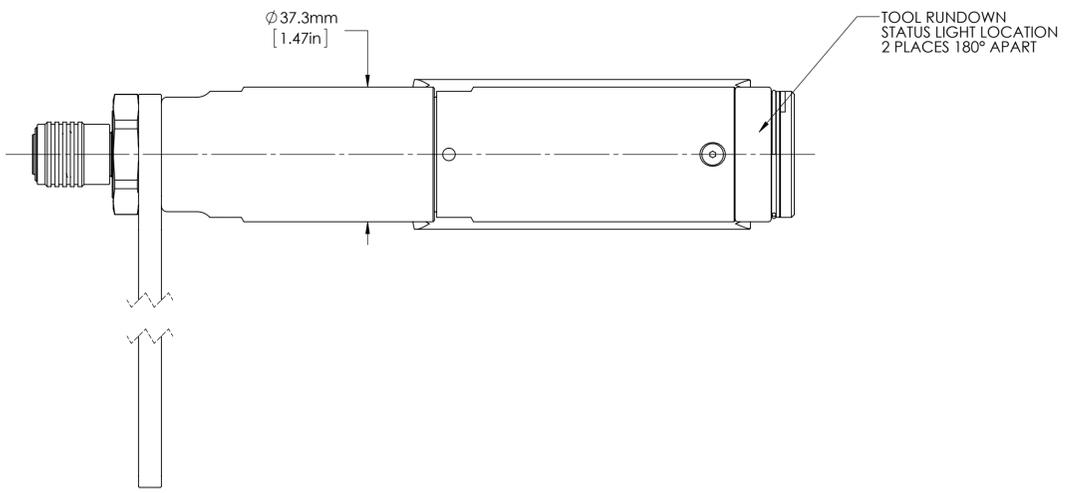
COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25803	1	PISTOL MOTOR ASM.
	2	26599	1	LED PCB ASSY, PISTOL
	3	27016	2	NUT, HEX, 4-40 UNDERSIZED, STEEL ZINC
	4	24780	1	MOTOR COUPLER SUB-ASM.
	5	25763	1	TRANSDUCER ADAPTOR
	6	SEE CHART	1	TRANSDUCER SUB-ASM.
	7	SEE CHART	1	GEAR CASE SUB-ASM.
	8	SEE CHART	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

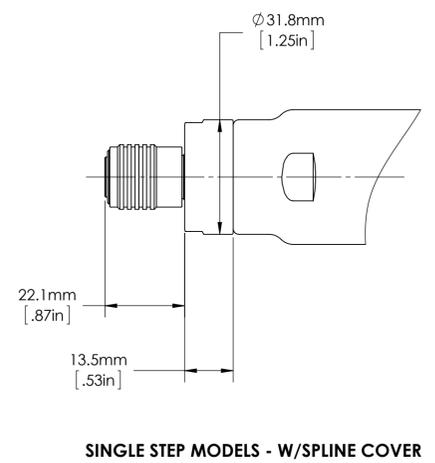
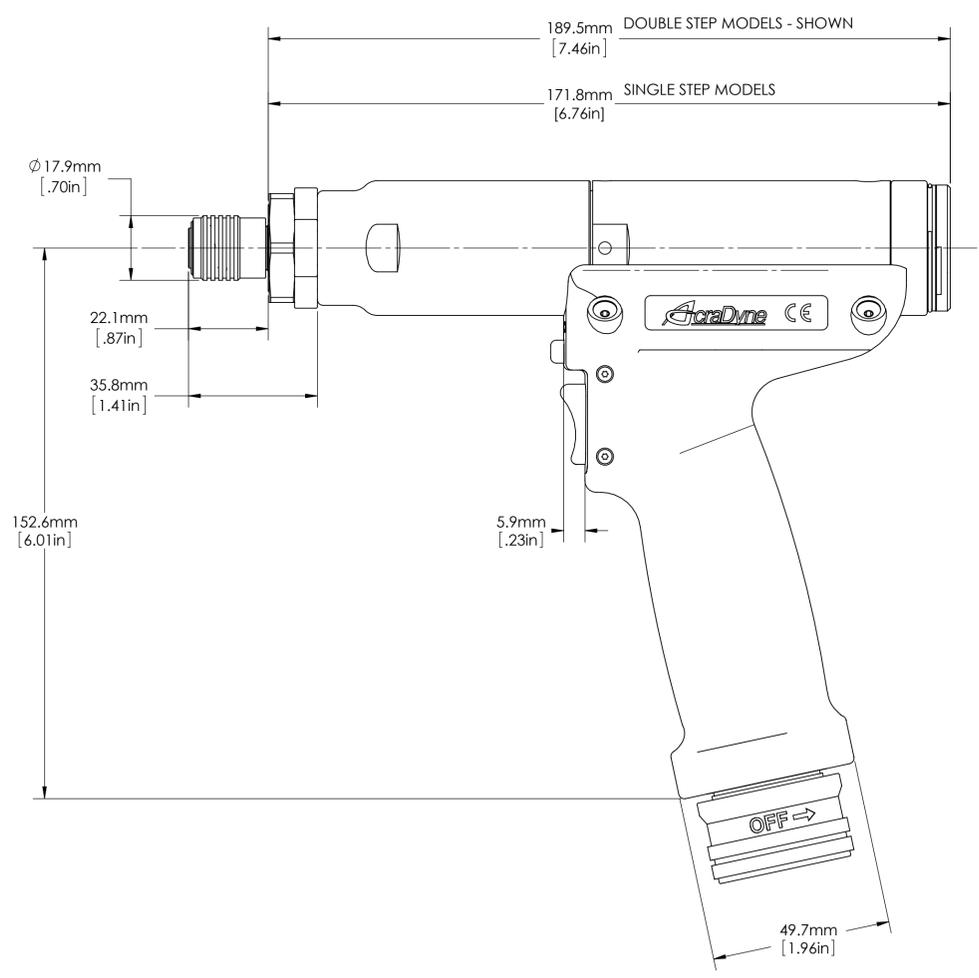
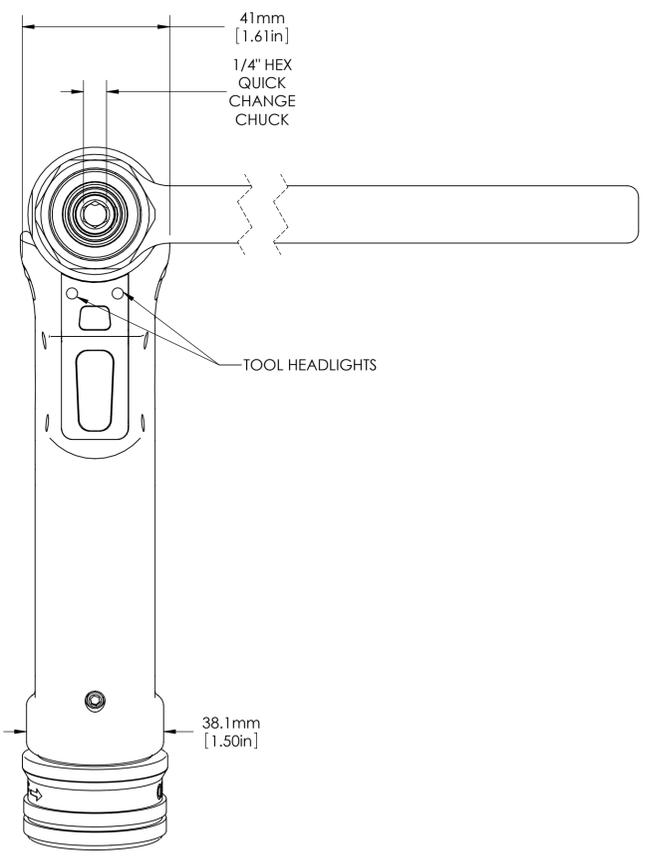


ASSEMBLY INSTRUCTIONS
 SUB-ASSEMBLY

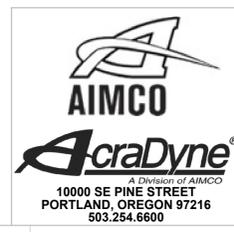
- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
- O-RINGS: LUBRICATE WITH O-RING LUBE
- TIGHTEN TO 1.0 Nm (9IN-LBS) LOCTITE 243 (BLUE)



MODEL NO.	
1/4" HEX Q.C. MODELS SINGLE STEP	AEP4A12003BQ AEP4A12006BQ
1/4" HEX Q.C. MODELS DOUBLE STEP	AEP4A12011BQ AEP4A12014BQ



SINGLE STEP MODELS - W/SPLINE COVER



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ACRADYNE MECHANICAL ENGINEERING

**AEP4A120_BQ
 OUTLINE DRAWING
 GEN IV, 1000 SERIES**

SIZE D	PART / DRAWING NUMBER AEP4A120_BQ	REVISION G
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2