

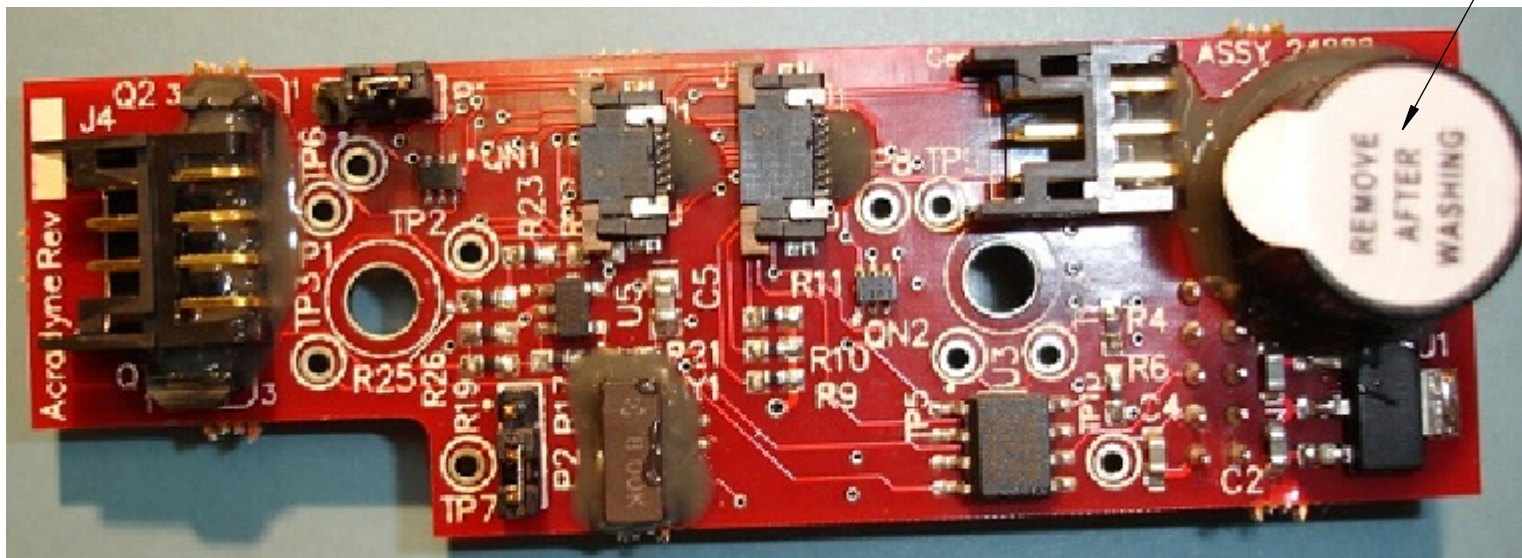


**AEP4_12_ _BR PISTOL
RIV-NUT NUTRUNNER
GEN 4, 1000 SERIES**

BLOCK TOLERANCING PER DECIMAL:
X = $\pm .030$ XX = $\pm .010$ XXX = $\pm .005$ XXXX = $\pm .0005$

SIZE D	PART / DRAWING NUMBER AEP4A120__BR	REVISION B
SCALE 1 : 1	DO NOT SCALE DRAWING	SHEET 1 OF 3

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 #263 RED



- 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 NM (9 IN-LBS.)
LOCTITE 243 (BLUE)



AIMCO
AcraDyne®
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 10000 SE PINE STREET
 PORTLAND, OREGON 97216
 503.254.6600

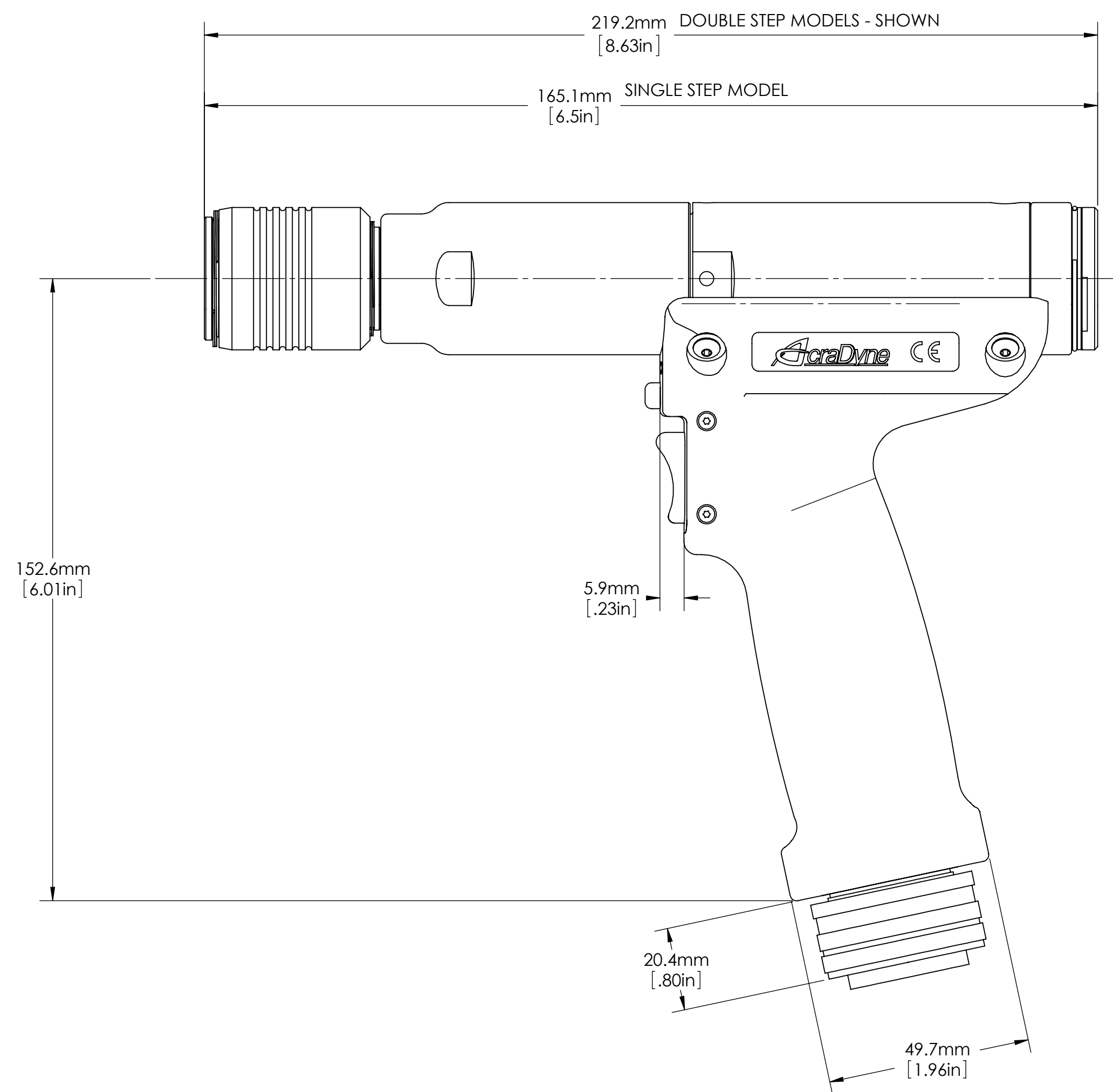
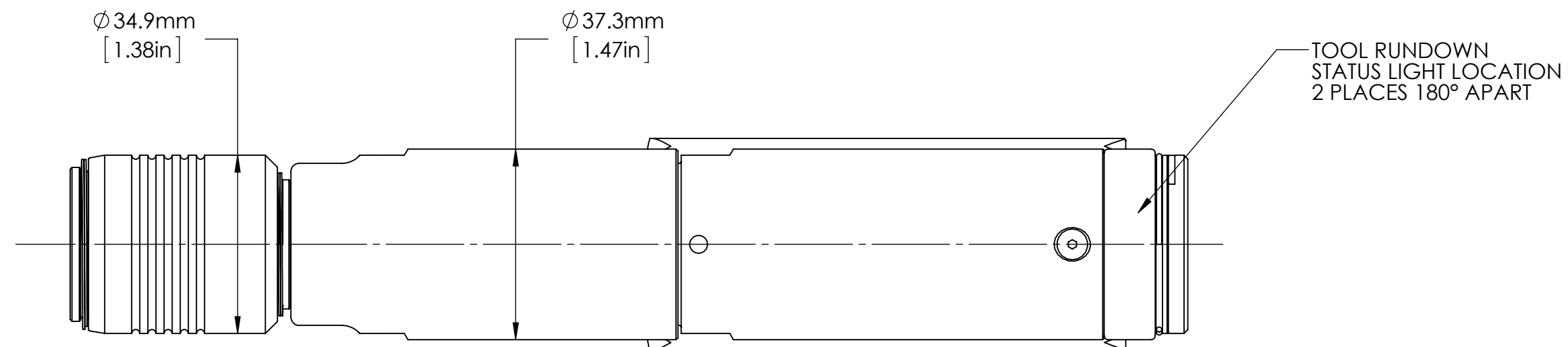
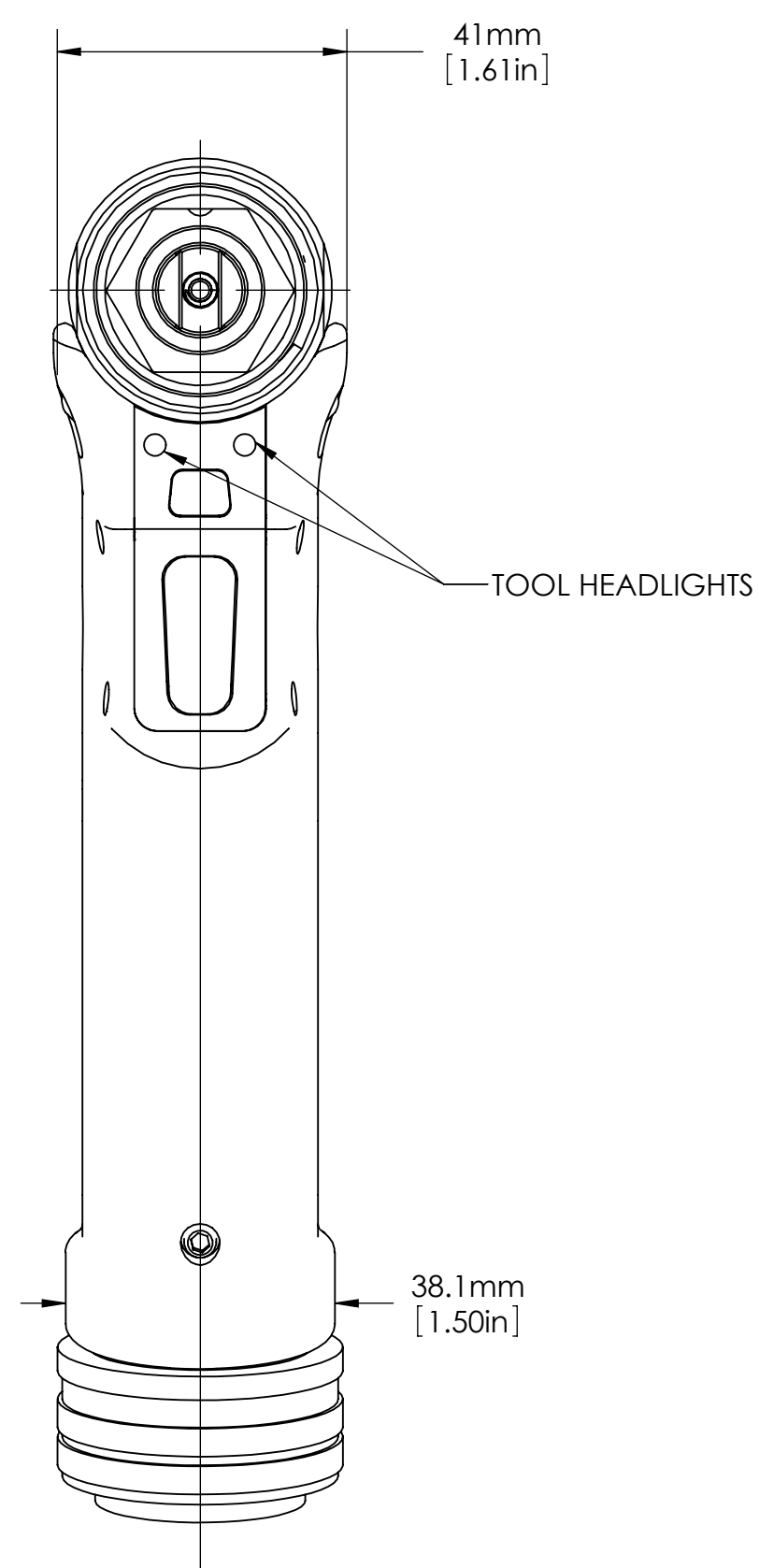
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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
REVISION BLOCK				



GEARING STEPS	MODEL NO.
SINGLE STEP	AEP4A12006BR
DOUBLE STEP	AEP4A12014BR
	AEP4A12022BR



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

**UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN INCHES**
DIMENSIONS AND TOLERANCING PER ANSI Y14.5
SURFACE ROUGHNESS PER ANSI Y14.36

BLOCK TOLERANCING PER DECIMAL:
 $.X = \pm .030$ $.XX = \pm .010$ $.XXX = \pm .005$ $.XXXX = \pm .0005$

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_BR
OUTLINE DRAWING
GEN 4, 1000 SERIES


SIZE D	PART / DRAWING NUMBER AEP4A120__BR	REVISION B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 3


87654321

D
C
B
A



SIZE CODE CHART				
SIZE	NOSE PIECE ASM.		SIZE	NOSE PIECE ASM.
4mm	27051		8-32	27055
5mm	27034		10-24	27056
6mm	27052		10-32	27057
8mm	27053		1/4-20	27058
10mm	27054		5/16-18	27059
			3/8-16	27060


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

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

AEP4_12__BR PISTOL
RIV-NUT NUTRUNNER

SIZE	PART / DRAWING NUMBER	REVISION
B	AEP4A120__BR	B
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 3 OF 3

87654321

A