



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



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:
 $X = \pm .030$ $.XX = \pm .010$ $.XXX = \pm .005$ $.XXXX = \pm .0005$
ANGLE = $\pm 0^\circ 30'$

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

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ACRADYNE MECHANICAL ENGINEERING**

SIZE D	PART / DRAWING NUMBER AEP4R120__BV	REVISION G
SCALE 1:2	DO NOT SCALE DRAWING	SHEET 1 OF 2

MODEL NO.	TRANSDUCER ASM.	GEAR CASE ASM.	SPLINE COVER	REACTION BAR
AEP4R12003BV	25759.001	24860	24759	N/A
AEP4R12006BV	25760.002	24860	24759	N/A
AEP4R12011BV	25761.003	24709	N/A	24696
AEP4R12014BV	25761.005	24792	N/A	24696
AEP4R12018BV	25761.008	24710	N/A	24696
AEP4R12022BV	25761.010	24781	N/A	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 (9 IN-LBS) LOCTITE 243 (BLUE)

