

## ASSEMBLY INSTRUCTIONS



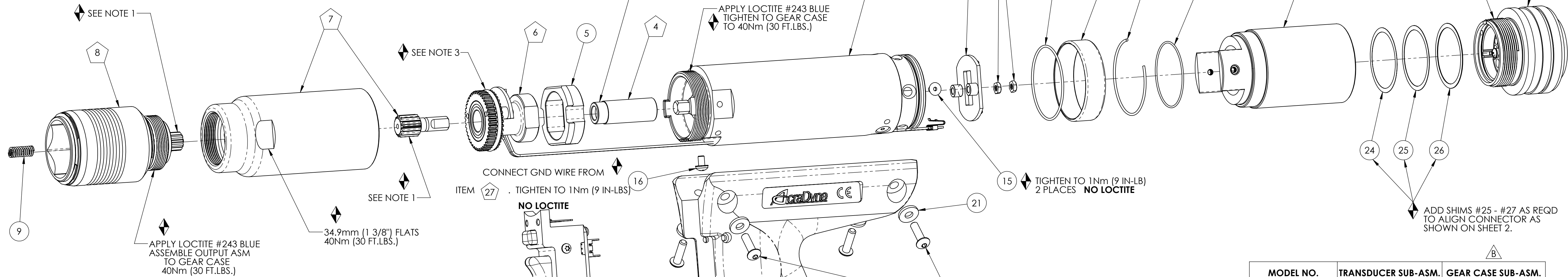
SUB-ASSEMBLY

- 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

NOTE: SEE SHEET 3 FOR NOSE PIECE NUMBERS FOR ORDERING



APPLY LOCTITE #243 BLUE  
ASSEMBLE OUTPUT ASM  
TO GEAR CASE  
40Nm (30 FT.LBS.)

-34.9mm (1 3/8") FLATS  
40Nm (30 FT.LBS.)

SEE NOTE 1.

SEE NOTE 3—



—ASSEMBLE MOTOR  
COUPLER AS SHOWN

—APPLY LOCTITE #243 BLUE  
TIGHTEN TO GEAR CASE  
TO 40Nm (30 FT.LBS.)

APPLY LOCTITE #243 BLUE  
TIGHTEN TO .6Nm (5 IN-LBS)  
1/4" HEX

SEE NOTE #3

APPLY LOCTITE #243 BLUE  
TIGHTEN TO 20Nm (15 FT-LBS)

CONNECT GND WIRE FROM   . TIGHTEN TO 1Nm (9 IN-LB.)

**NO LOCTITE**

5)  TIGHTEN TO 1Nm (9 IN-LB)  
2 PLACES **NO LOCTITE**

APPLY LOCTITE #243 BLUE  
1.7Nm (15 IN.LBS.)  
TYP 4 PLACES

 APPLY LOCTITE #243 BLUE  
TIGHTEN TO 1Nm (9 IN-LBS)

 REMOVE THIS STICKER

▶ PRESS FLUSH TO  
BOTTOM OF HANDLE

MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AEP4R22020BR	25761 (20Nm)	24709 (14T/14T)
AEP4R22030BR	25762 (40Nm)	24710 (8T/14T)
AEP4R22040BR	25762 (40Nm)	24781 (6T/14T)

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25806	1	PISTOL MOTOR ASSEMBLY
	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	27026	1	ADAPTOR ASM., RIV-NUT
	9	27023	1	SPRING, RIV-NUT SHAFT
	10	24687	1	O-RING, LIGHT RING, LEVER
	11	24873	1	LIGHT RING
	12	24686	1	RETAINING RING, LEVER LIGHT RING
	13	24731	1	O-RING, RING GEAR
	14	24909	1	STRAIGHT ADAPTOR, PISTOL TOOL CONNECTOR
	15	25138	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	16	25814	1	SCREW, PAN HEAD PHILLIPS, 4-40 x 3/16, STAR WASH, SS
	17	25849	1	T.I.D. BOARD ASM., PISTOL
	18	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	19	26685	1	PISTOL HANDLE, 2000 SERIES, MODEL B
	20	26792	4	SCREW, BHSC 6-32X.50, STEEL, BLACK OXIDE
	21	26791	4	WASHER, FLAT, NO 6 SCREW, STEEL, BLACK OXIDE
	22	25871	1	SWITCH SUB-ASSEMBLY
SEE WIRING PHOTO	23	25788	1	CABLE, TRIGGER, GEN 4 PISTOL
	24	25271	A/R	SHIM. - .002
	25	25272	A/R	SHIM. - .005
	26	25273	A/R	SHIM. - .010
	27	26141	1	TOOL CONNECTOR ASM., FIXTURED TOOLS
	28	25798	1	PLUG, PISTOL HANDLE

**NOTE:**  
**SEE SHEET 3 FOR NOSE PIECE ASM. PART NUMBERS FOR ORDERING**

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



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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 =  $\pm 0^{\circ} 30'$

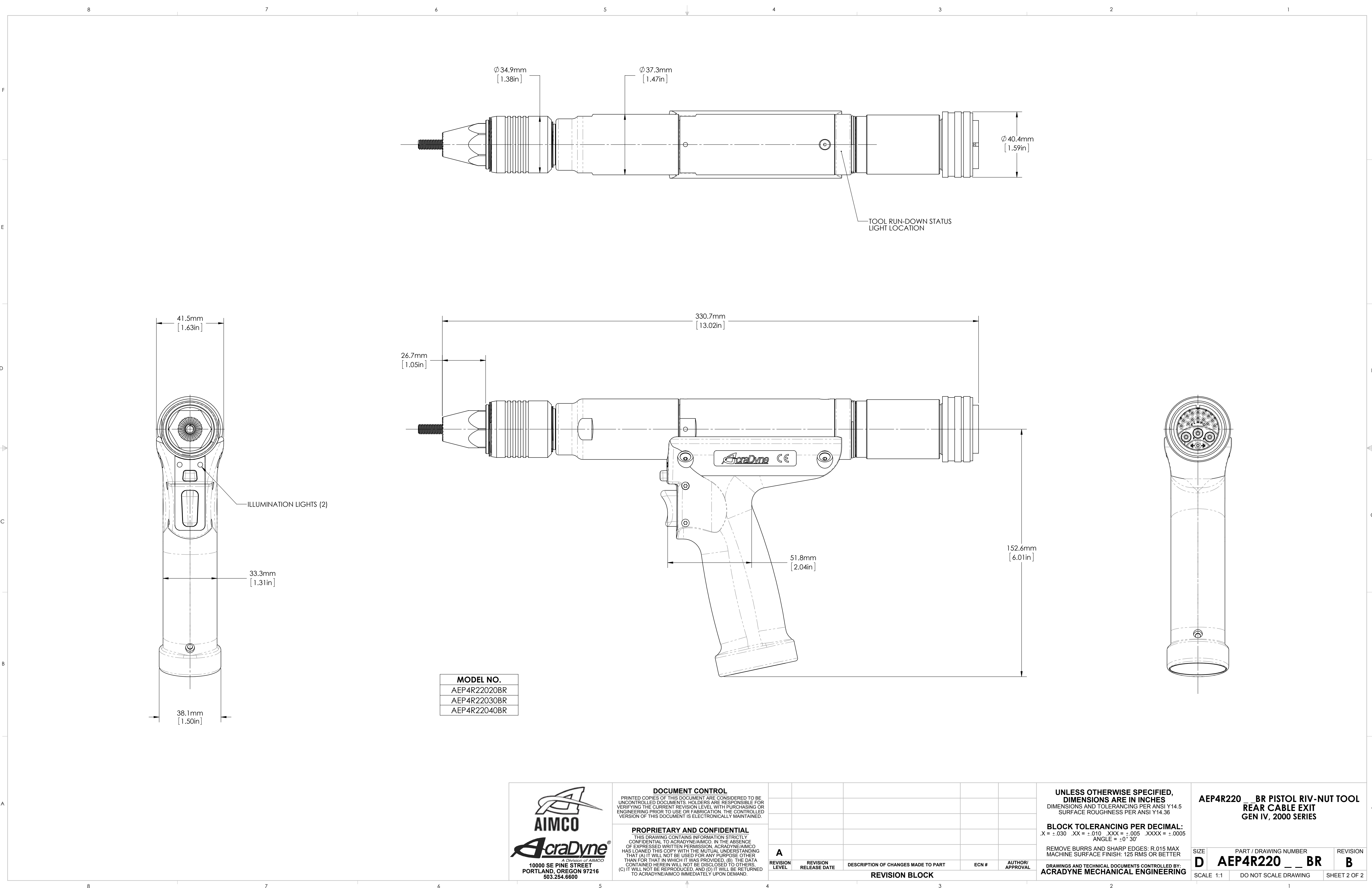
REMOVE BURRS AND SHARP EDGES: R.015 MAX  
MACHINE SURFACE FINISH: 125 RMS OR BETTER

**DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:  
ACRADYNE MECHANICAL ENGINEERING**

**AEP4R220 \_ BR PISTOL RIV-NUT TOOL  
REAR CABLE EXIT  
GEN IV, 2000 SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
<b>D</b>	<b>AEP4R220 _ _ BR</b>	<b>B</b>
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 3





MODEL NO.
AEP4R22020BR
AEP4R22030BR
AEP4R22040BR



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

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	

AEP4R220 __ BR PISTOL RIV-NUT TOOL		
REAR CABLE EXIT		
GEN IV, 2000 SERIES		
SIZE	PART / DRAWING NUMBER	REVISION
D	AEP4R220 __ BR	B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2