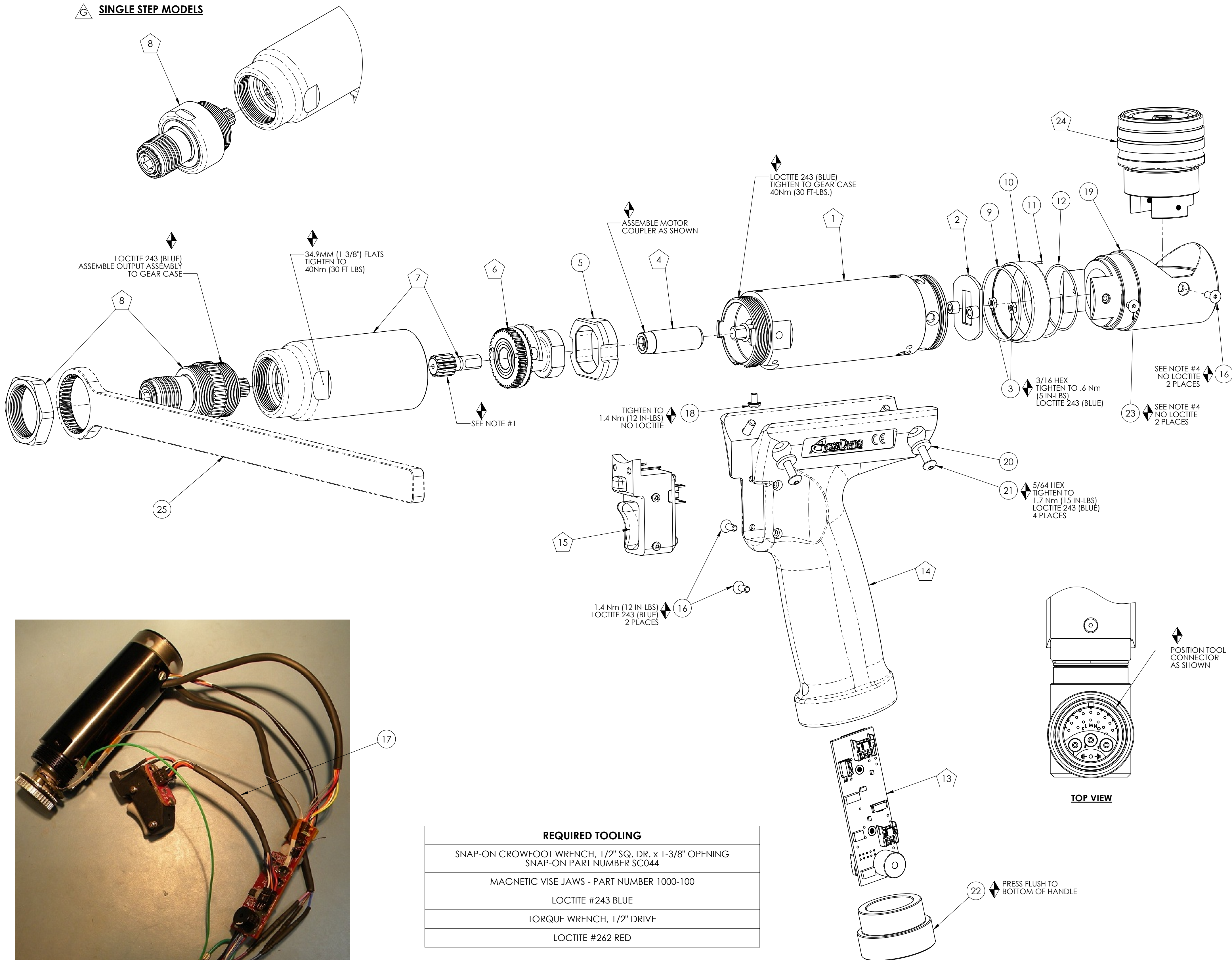
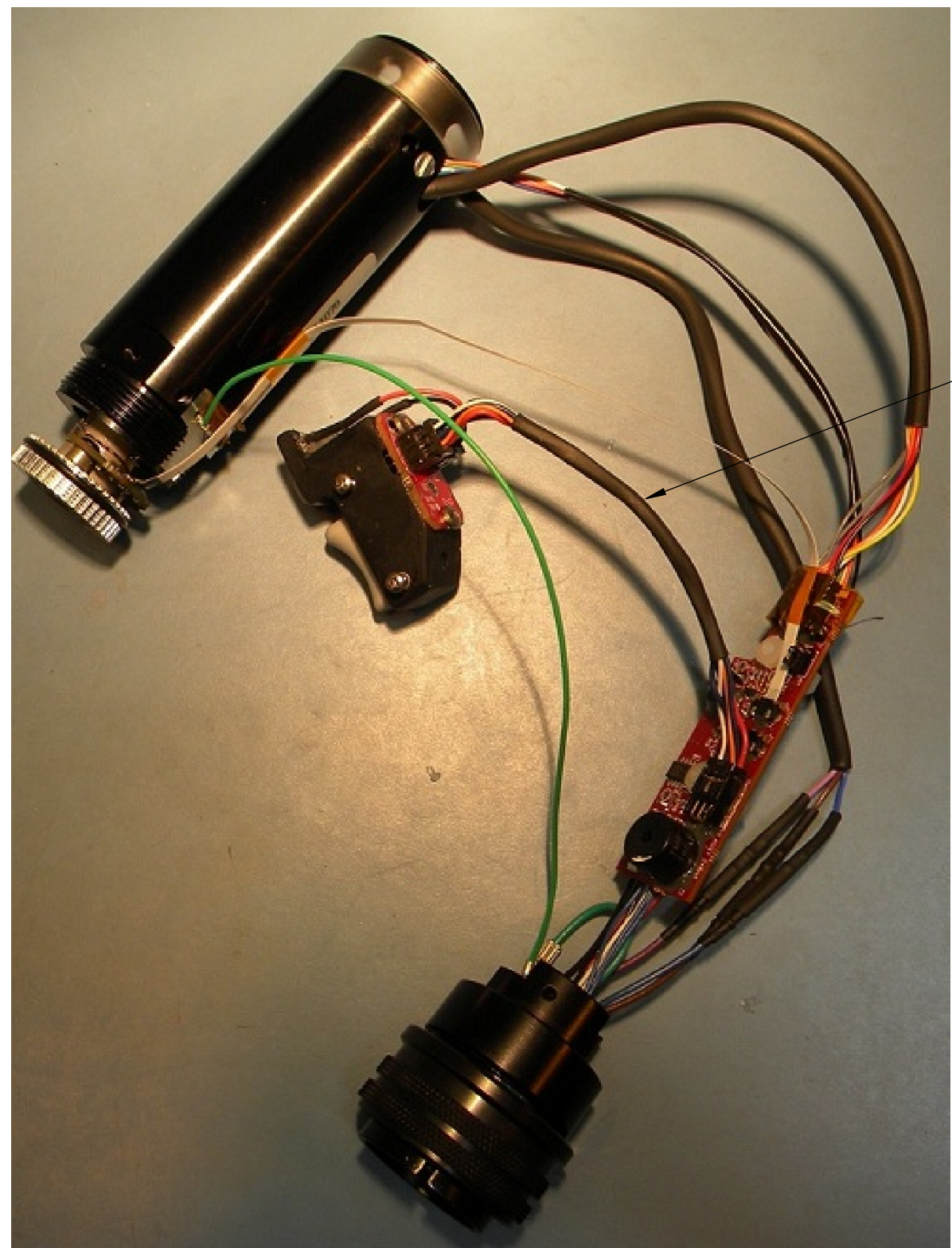


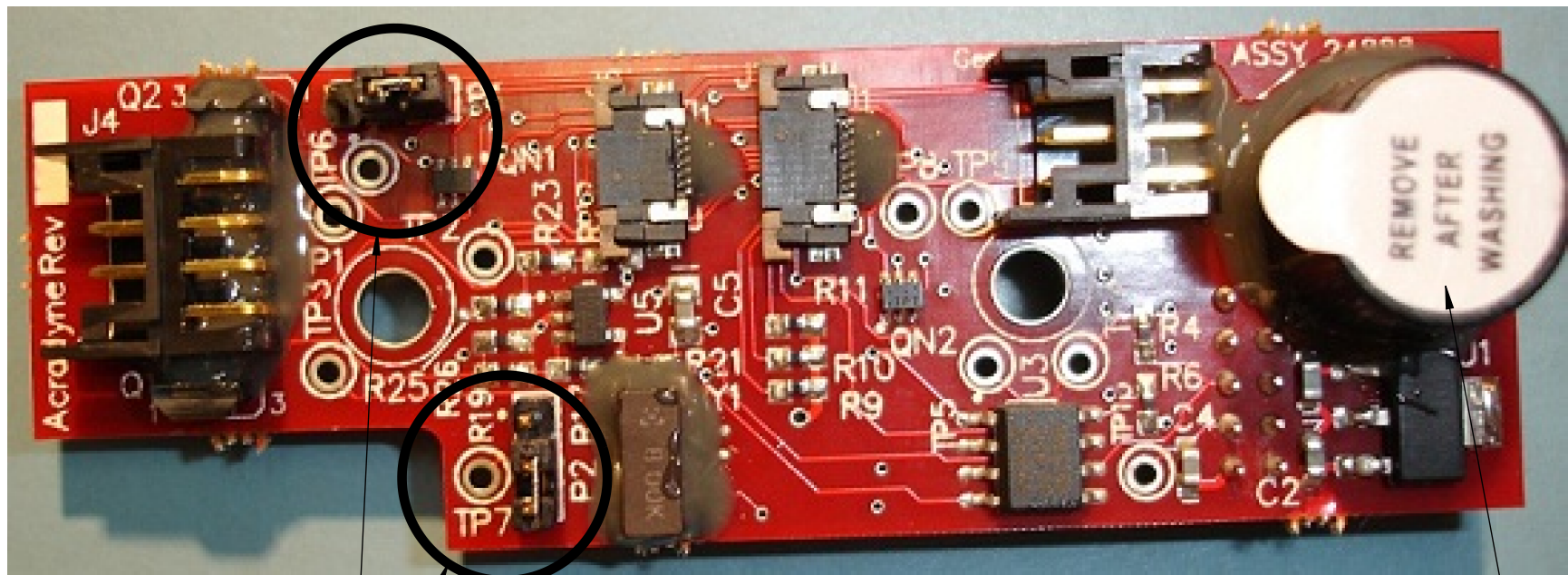
 SINGLE STEP MODELS



REQUIRED TOOLING
SNAP-ON CROWFOOT WRENCH, 1/2" SQ. DR. x 1-3/8" OPENING SNAP-ON PART NUMBER SCO44
MAGNETIC VISE JAWS - PART NUMBER 1000-100
LOCTITE #243 BLUE
TORQUE WRENCH, 1/2" DRIVE
LOCTITE #262 RED




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



-CHECK TID JUMPER CONNECTIONS
PIN 2 TO PIN 3, BOTH LOCATIONS

 REMOVE THIS STICKER 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)

**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**

AEP4T120__BQ
PISTOL NUTRUNNER, Q.C.
GEN IV, 1000-SERIES

SIZE	PART / DRAWING NUMBER	REVISION
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D	AEP4T120__BQ
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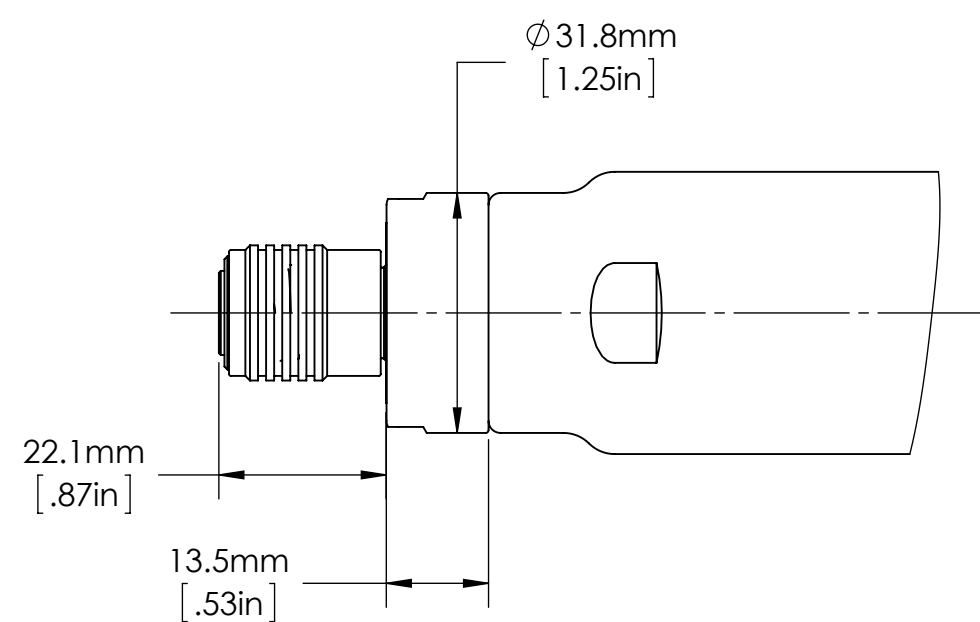
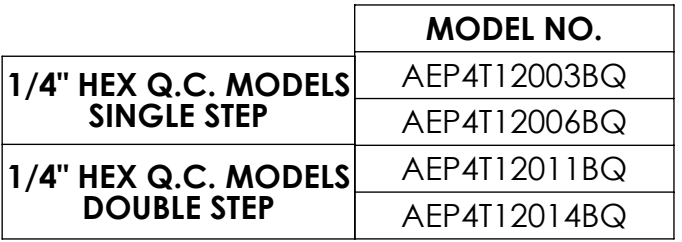
SCALE 1:2	DO NOT SCALE DRAWING	SHEET 1 OF 2
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A

REVISION

G

SHEET 1 OF 2



SINGLE STEP MODELS - W/SPLINE COVER

