

TOOL MODEL	GEAR BOX ASM.	GEAR CASE COVER
AES4A771200B	28110	26298
AES4A773000B	28111	26295

ASSEMBLY INSTRUCTIONS SUB-ASSEMBLY

1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.

SEE NOTE #3  $\bigcirc$  2

SEE NOTE #3  $\left(7\right)$ 

CONNECT FEMALE END TO CONNECTOR ON RING GEAR. ATTACH GROUND LUG TO TAPPED HOLE IN THE BOTTOM

MATING CONNECTOR ON ITEM (4)

OF MOTOR ASM. (1) WITH SCREW (5). FEED MALE END THRU THE BOTTOM HOLE IN MOTOR HOUSING AND ATTACH IT TO

APPLY LOCTITE 243 TIGHTEN TO 5.4 Nm (48 IN-LBS)

APPLY LOCTITE 222
TIGHTEN TO 1 Nm (9 IN-LBS)

2) BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE

REACTION BAR REQUIRED OPTIONAL REACTION BARS AVAILABLE

(32)

3) O-RINGS: LUBRICATE WITH O-RING LUBE

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REVISION REVISION DESCRIPTION OF CHANGES MADE TO PART

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

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

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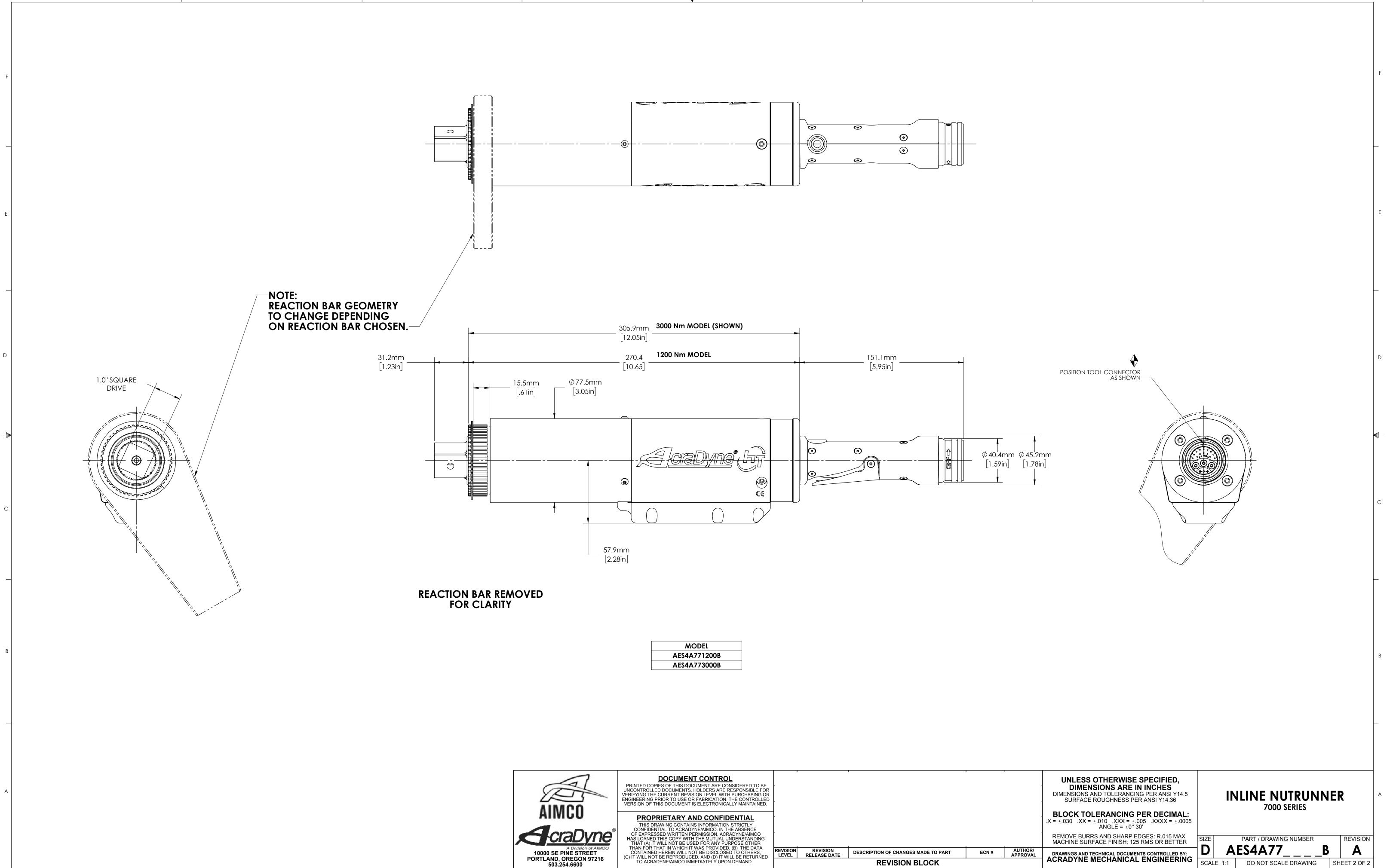
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