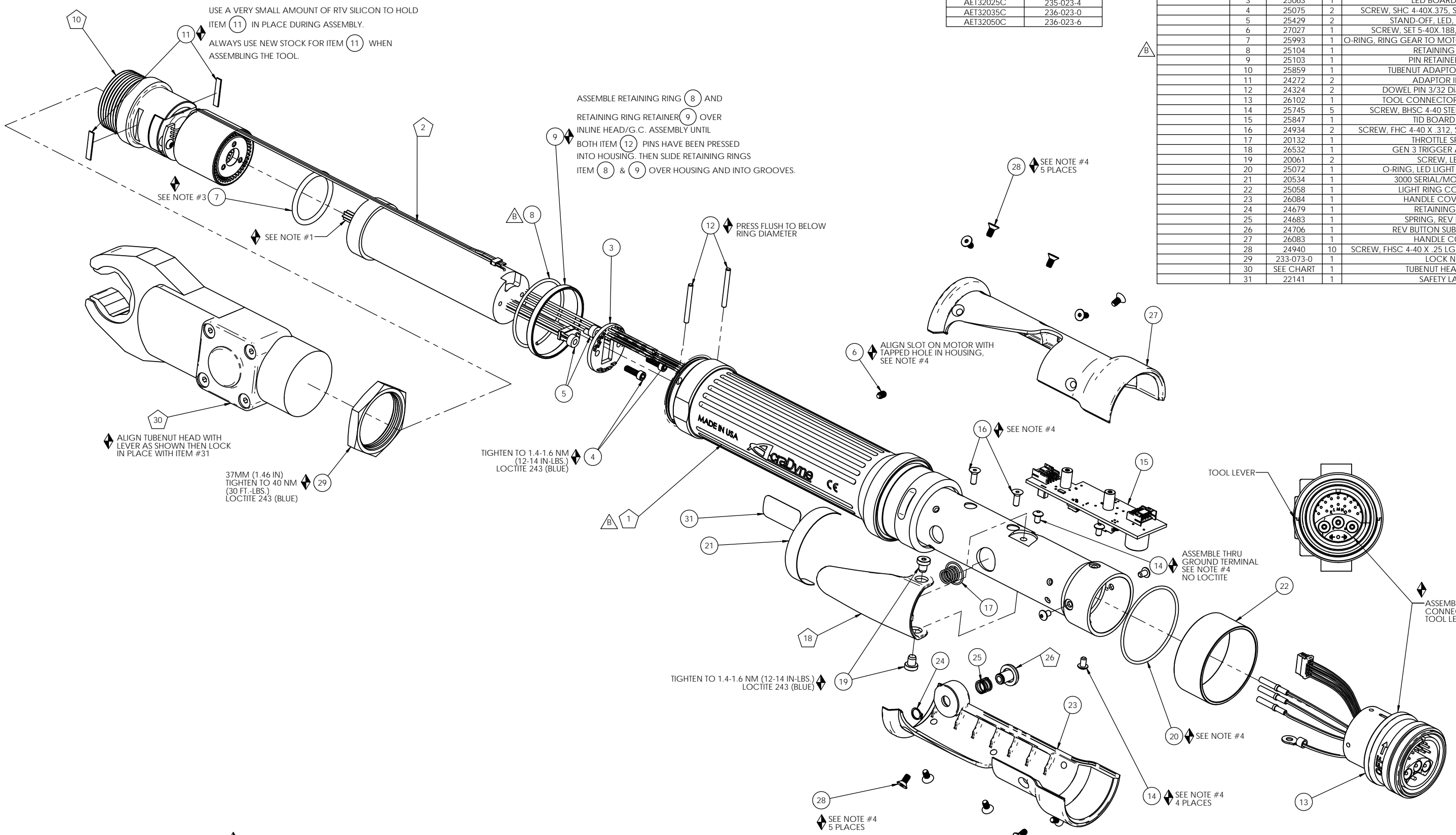


MODEL NUMBER	TUBENUT HEAD ASM
AET32020C	235-023-0
AET32025C	235-023-4
AET32035C	236-023-0
AET32050C	236-023-6

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	27030	1	HOUSING MOTOR/HANDLE ASSY
	2	25425	1	MOTOR ASM
	3	25063	1	LED BOARD ASM.
	4	25075	2	SCREW, SHC 4-40X.375, STEEL, BLACK OXIDE
	5	25429	2	STAND-OFF, LED, 2000 SERIES
	6	27027	1	SCREW, SET 5-40X.188, STEEL, BLK OXIDE
	7	25993	1	O-RING, RING GEAR TO MOTOR, GEN 3B 2000 SERIES
	8	25104	1	RETAINING RING
	9	25103	1	PIN RETAINER RING
	10	25859	1	TUBENUT ADAPTOR ASSEMBLY
	11	24272	2	ADAPTOR INSERT
	12	24324	2	DOWEL PIN 3/32 Dia x 7/8 LONG
	13	26102	1	TOOL CONNECTOR ASM., LEVER
	14	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	15	25847	1	TID BOARD ASM.
	16	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	17	20132	1	THROTTLE SPRING
	18	26532	1	GEN 3 TRIGGER ASSY, CAST
	19	20061	2	SCREW, LEVER
	20	25072	1	O-RING, LED LIGHT RING COVER
	21	20534	1	3000 SERIAL/MODEL LABEL
	22	25058	1	LIGHT RING COVER, LED
	23	26084	1	HANDLE COVER, MFB
	24	24679	1	RETAINING RING
	25	24683	1	SPRING, REV BUTTON
	26	24706	1	REV BUTTON SUB-ASSEMBLY
	27	26083	1	HANDLE COVER
	28	24940	10	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	29	233-073-0	1	LOCK NUT
	30	SEE CHART	1	TUBENUT HEAD ASM.
	31	22141	1	SAFETY LABEL



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

REQUIRED TOOLING
LOCTITE 243 (BLUE)
1/16 HEX WRENCH
5/64 HEX WRENCH
3/32 HEX WRENCH
SNAP RING PLIERS - EXTERNAL TYPE
37mm OPEN END CROWFOOT



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
B	10/8/15	RETAINING RING 25104 QTY: 1 WAS QTY: 2. MOTOR HOUSING 27030 GEOMETRY UPDATED.	1634	T. BURNETT
A	10/19/12	PRODUCTION RELEASE	751	M. JULIANO

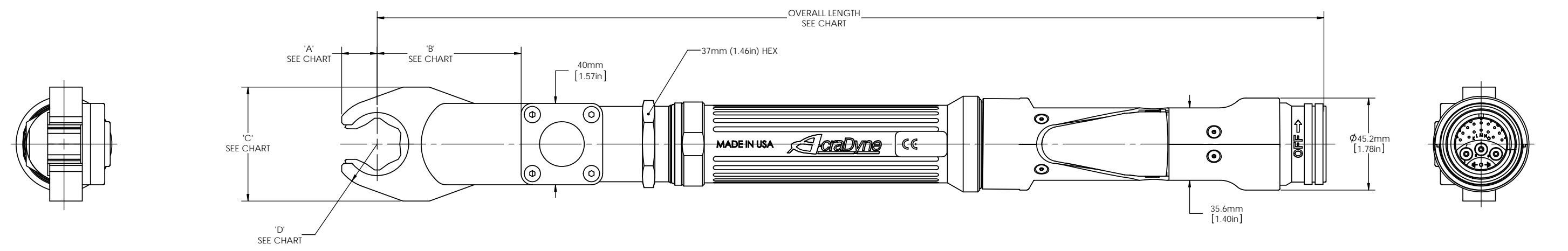
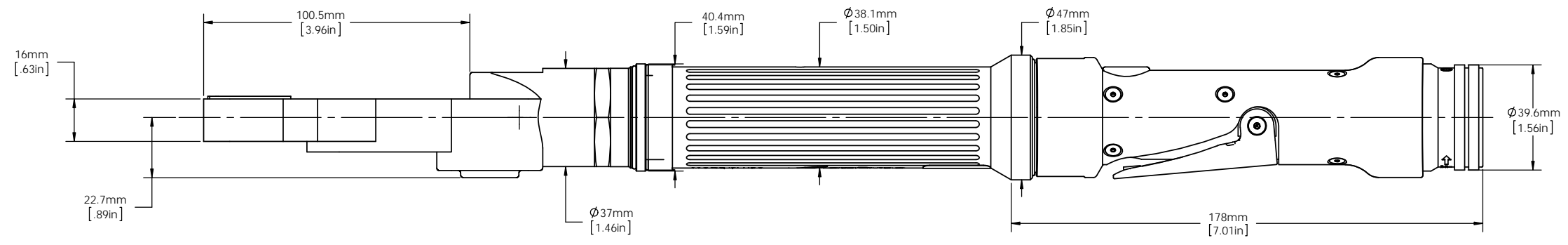
**UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES**  
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5  
 SURFACE ROUGHNESS PER ANSI Y14.36

**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**

AET3203_C TUBENUT NUTRUNNER 2000 SERIES, GEN 3C	
SIZE	REVISION
D	B
PART / DRAWING NUMBER	SCALE 1:1
AET320_C	DO NOT SCALE DRAWING
SHEET 1 OF 2	



MODEL NUMBER	OVERALL LENGTH	'A'	'B'	'C'	'D'
AET32020C	17.18	.41	1.83	1.46	.55
AET32025C	17.75	.52	2.40	1.56	.67
AET32035C	18.13	.68	2.78	2.20	.87
AET32050C	18.82	.88	3.45	2.68	1.14



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B	10/8/15	RETAINING RING 25104 QTY: 1 WAS QTY: 2 MOTOR HOUSING 27030 GEOMETRY UPDATED.	1634	T. BURNETT
A	10/19/12	PRODUCTION RELEASE	751	M. JULIANO

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

<b>AET3203_ _C TUBENUT NUTRUNNER TOOL OUTLINE</b> 2000 SERIES, GEN 3C		
SIZE	PART / DRAWING NUMBER	REVISION
D	AET320_ _C	B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2