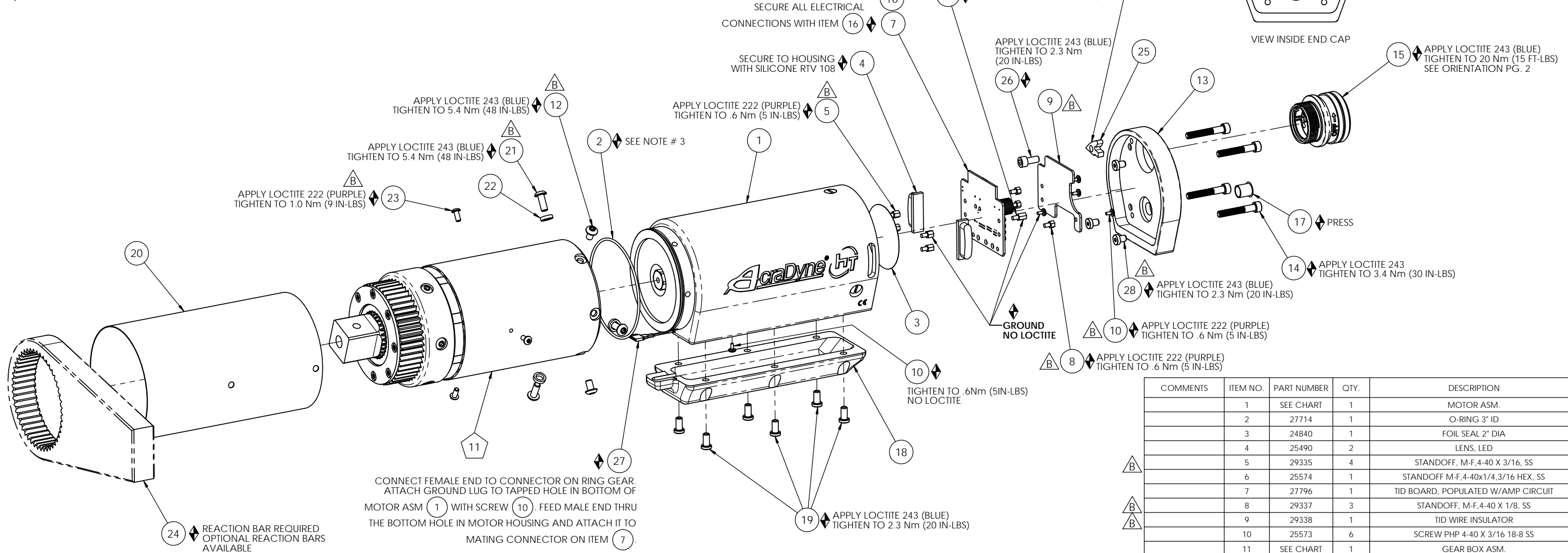


◆ ASSEMBLY INSTRUCTIONS

◇ 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



COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	SEE CHART	1	MOTOR ASM.
	2	27714	1	O-RING 3" ID
	3	24840	1	FOIL SEAL 2" DIA
	4	25490	2	LENS, LED
B	5	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	6	25574	1	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
	7	27796	1	TID BOARD, POPULATED W/AMP CIRCUIT
B	8	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
B	9	29338	1	TID WIRE INSULATOR
	10	25573	6	SCREW PHP 4-40 X 3/16 18-8 SS
	11	SEE CHART	1	GEAR BOX ASM.
B	12	29279	3	SCREW, BHSC, TORX, 10-32 x 3/8, STEEL
	13	25225	1	END GRIP CAP, HT TOOLS
	14	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	15	25507	1	TOOL CONNECTOR ASM HERC PISTOL
NOT SHOWN	16	28257	A/R	CABLE TIE, 1.65MM W X 71MM LG.
	17	25579	1	PLUG 3/8"
	18	25231	1	TRAY, WIRE, END GRIP
	19	25569	6	SCREW LHCS 10-32 X 3/8 18-8 SS
	20	25284	1	HT TOOL TRANSDUCER SLEEVE
B	21	29284	3	SCREW, BHSC, TORX, 10-32 X 1/2, STEEL
	22	25564	3	WASHER SHIM .093THK .25ID .375OD
	23	25218	3	SCREW, BHSC, 6-32 X 5/16, SS
	24	26898	1	CHOOSE REACTION BAR
	25	27063	1	TOOL CONNECTOR CLIP
	26	26458	1	SCREW, SHC 10-32 X .44 LG., STEEL, BLACK OXIDE
	27	28211	1	(4) LINE MALE/FEMALE JUMPER ASM.
B	28	24859	3	LHSC 10-32 X 1/4 BLK OXIDE

MODEL NO.	MOTOR ASM.	GEAR BOX ASM.
AEF4A884200B	25224	28112
AEF4A884200B1	25224	28113
AEF4A885000B	26160	28112
AEF4A885000B1	26160	28113



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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 = ±.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

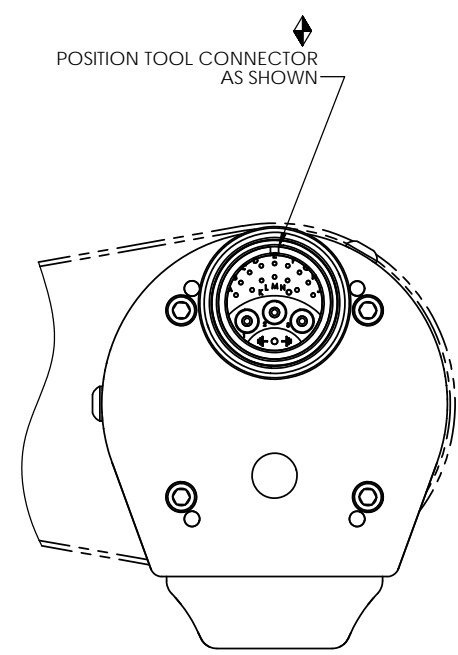
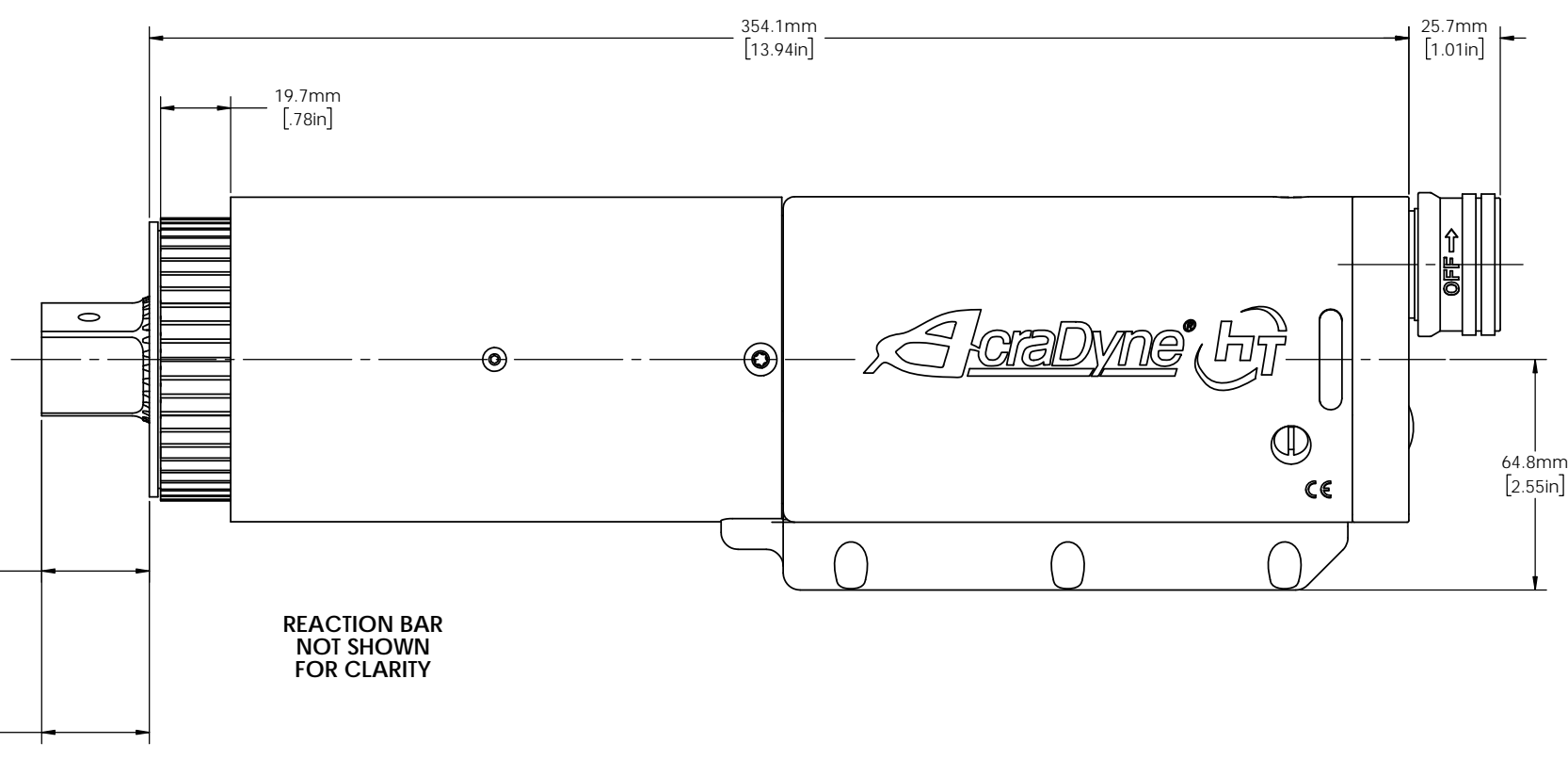
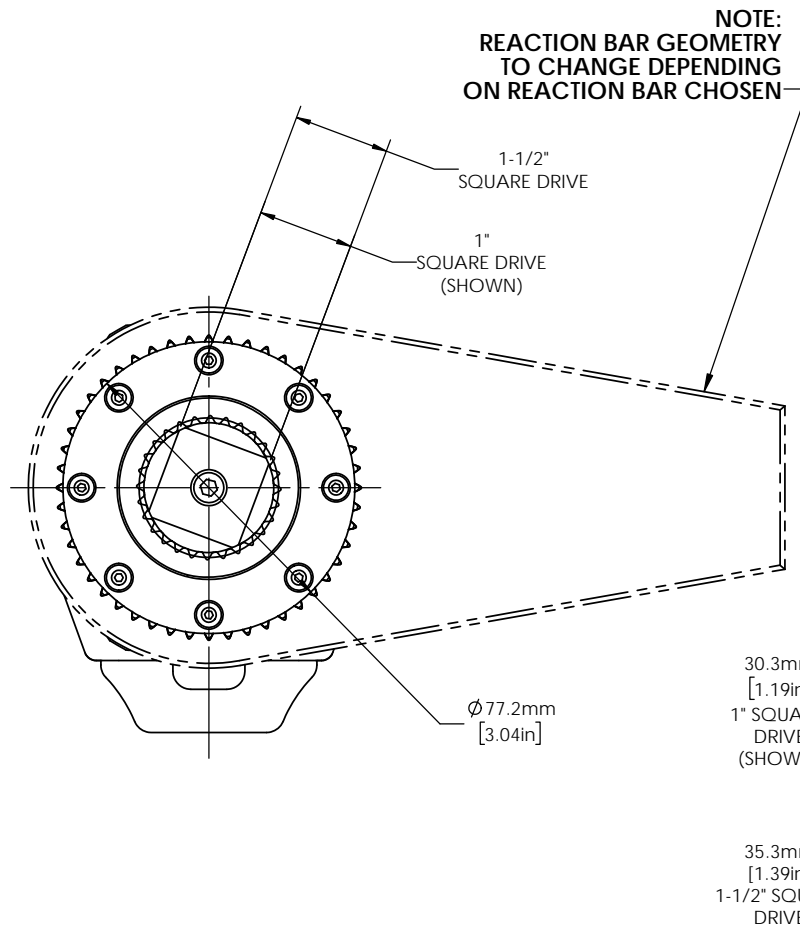
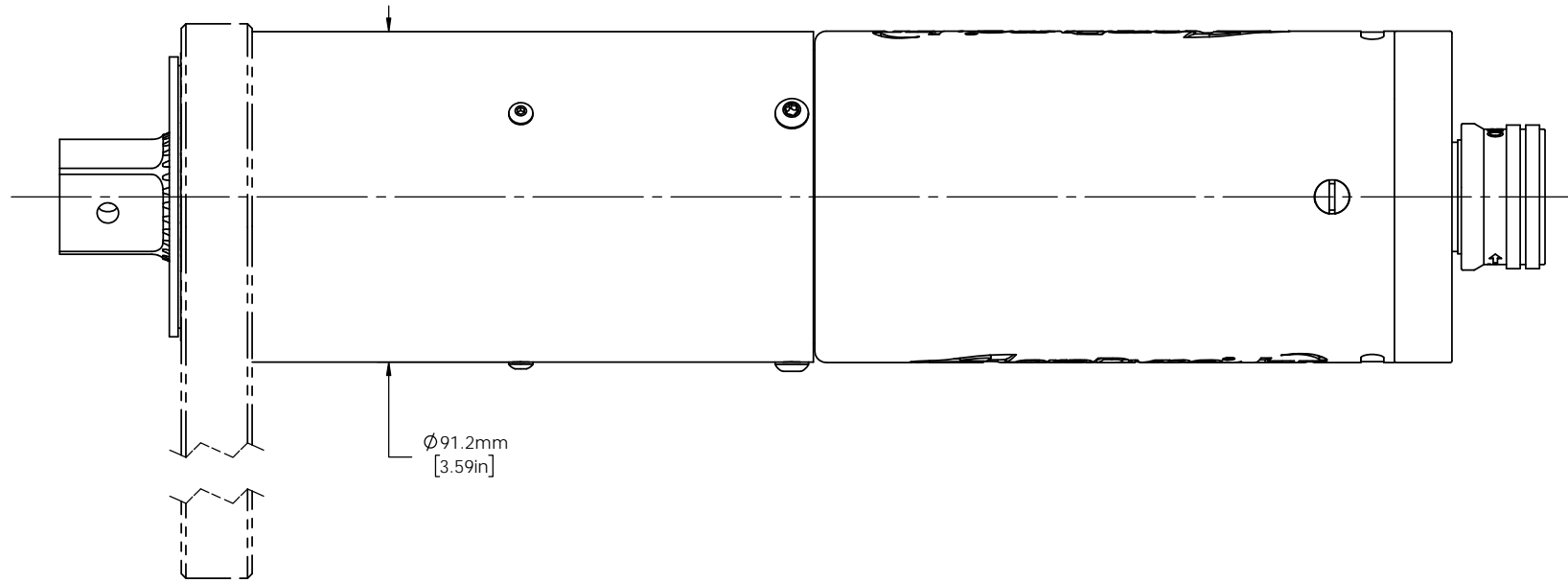
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ACRADYNE MECHANICAL ENGINEERING

AEF4A88__B_
FIXTURED NUTRUNNER
8000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4A88__B_	B

SCALE: 2:3 DO NOT SCALE DRAWING SHEET 1 OF 2

REVISION BLOCK



MODEL NO.	SQUARE DRIVE
AEF4A884200B	1-1/2"
AEF4A884200B1	1"
AEF4A885000B	1-1/2"
AEF4A885000B1	1"



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8000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4A88__B_	B

SCALE: 1:1 DO NOT SCALE DRAWING SHEET 2 OF 2

REVISION BLOCK