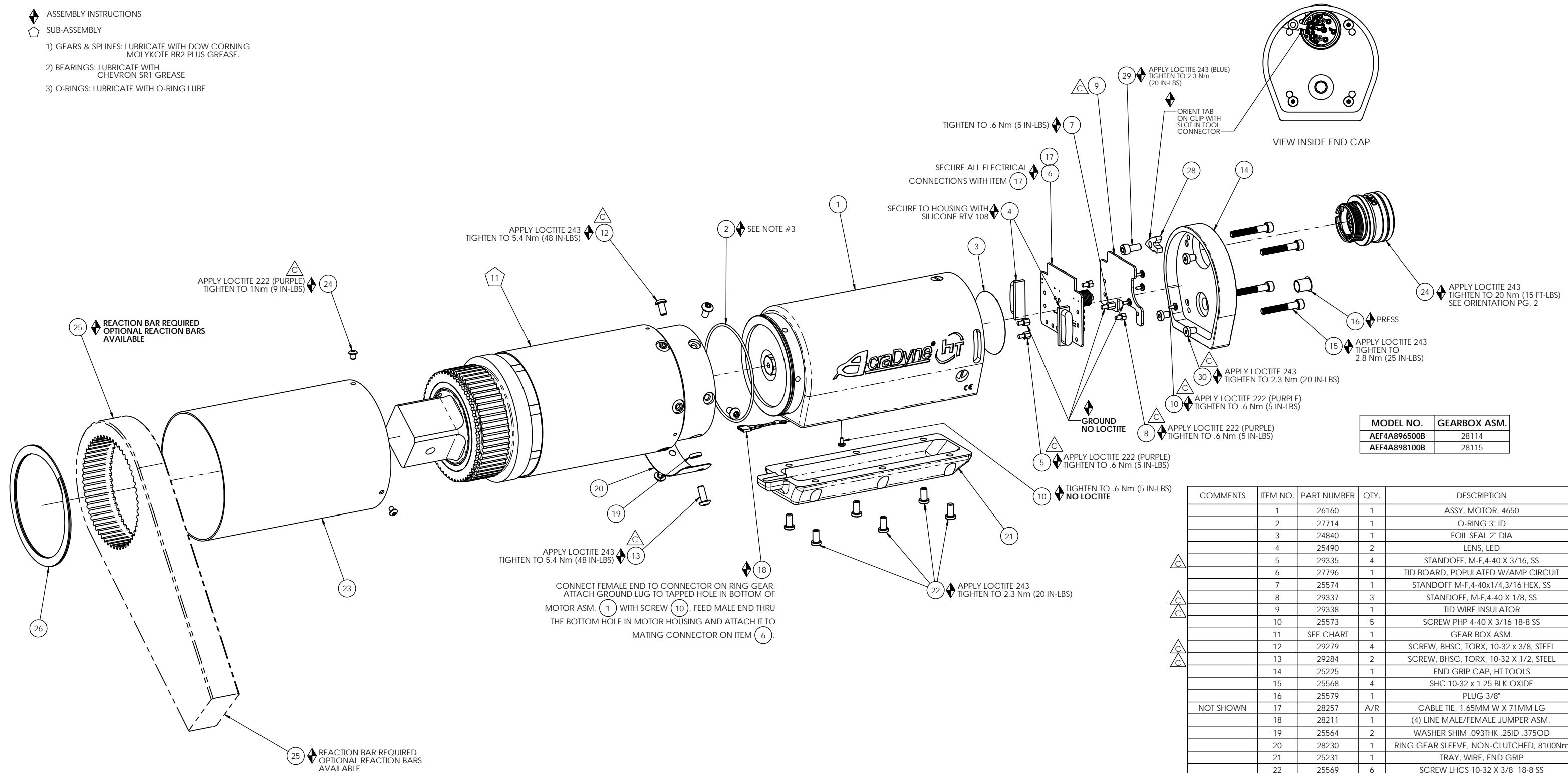


◆ ASSEMBLY INSTRUCTIONS

◇ 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



MODEL NO.	GEARBOX ASM.
AEF4A896500B	28114
AEF4A898100B	28115

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26160	1	ASSY, MOTOR, 4650
	2	27714	1	O-RING 3" ID
	3	24840	1	FOIL SEAL 2" DIA
	4	25490	2	LENS, LED
	5	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	6	27796	1	TID BOARD, POPULATED W/AMP CIRCUIT
	7	25574	1	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
	8	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	9	29338	1	TID WIRE INSULATOR
	10	25573	5	SCREW PHP 4-40 X 3/16 18-8 SS
	11	SEE CHART	1	GEAR BOX ASM.
	12	29279	4	SCREW, BHSC, TORX, 10-32 x 3/8, STEEL
	13	29284	2	SCREW, BHSC, TORX, 10-32 X 1/2, STEEL
	14	25225	1	END GRIP CAP, HT TOOLS
	15	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	16	25579	1	PLUG 3/8"
NOT SHOWN	17	28257	A/R	CABLE TIE, 1.65MM W X 71MM LG
	18	28211	1	(4) LINE MALE/FEMALE JUMPER ASM.
	19	25564	2	WASHER SHIM .093THK .25ID .375OD
	20	28230	1	RING GEAR SLEEVE, NON-CLUTCHED, 8100Nm
	21	25231	1	TRAY, WIRE, END GRIP
	22	25569	6	SCREW LHCS 10-32 X 3/8 18-8 SS
	23	26636	1	GEAR CASE COVER
	24	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	25	26899	1	CHOOSE REACTION BAR
	26	26436	1	RETAINING RING, SPIRAL, Ø3.833 X Ø3.293 X .111
	24	25507	1	TOOL CONNECTOR ASM HERC PISTOL
	28	27063	1	TOOL CONNECTOR CLIP
	29	26458	1	SCREW, SHC 10-32 X .44 LG., STEEL, BLACK OXIDE
	30	24859	3	LHSC 10-32 X 1/4 BLK OXIDE



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 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'

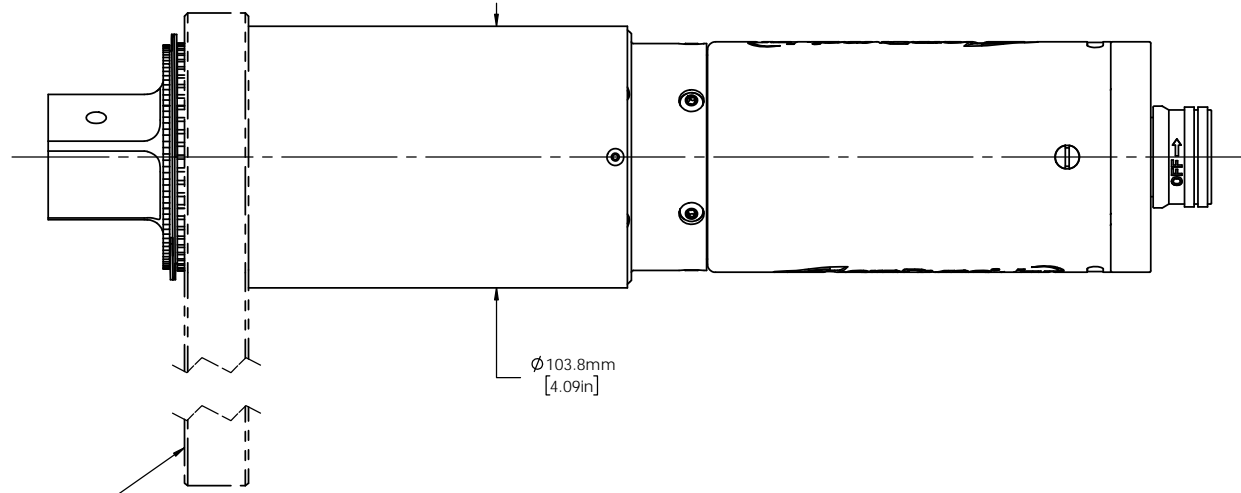
REMOVE BURRS AND SHARP EDGES: R.015 MAX  
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

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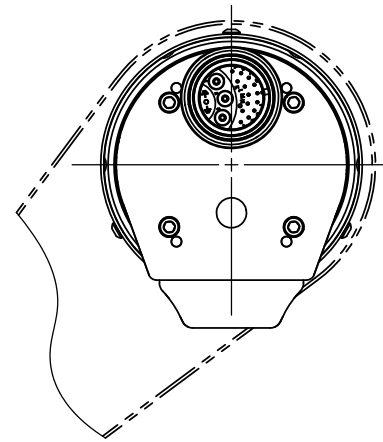
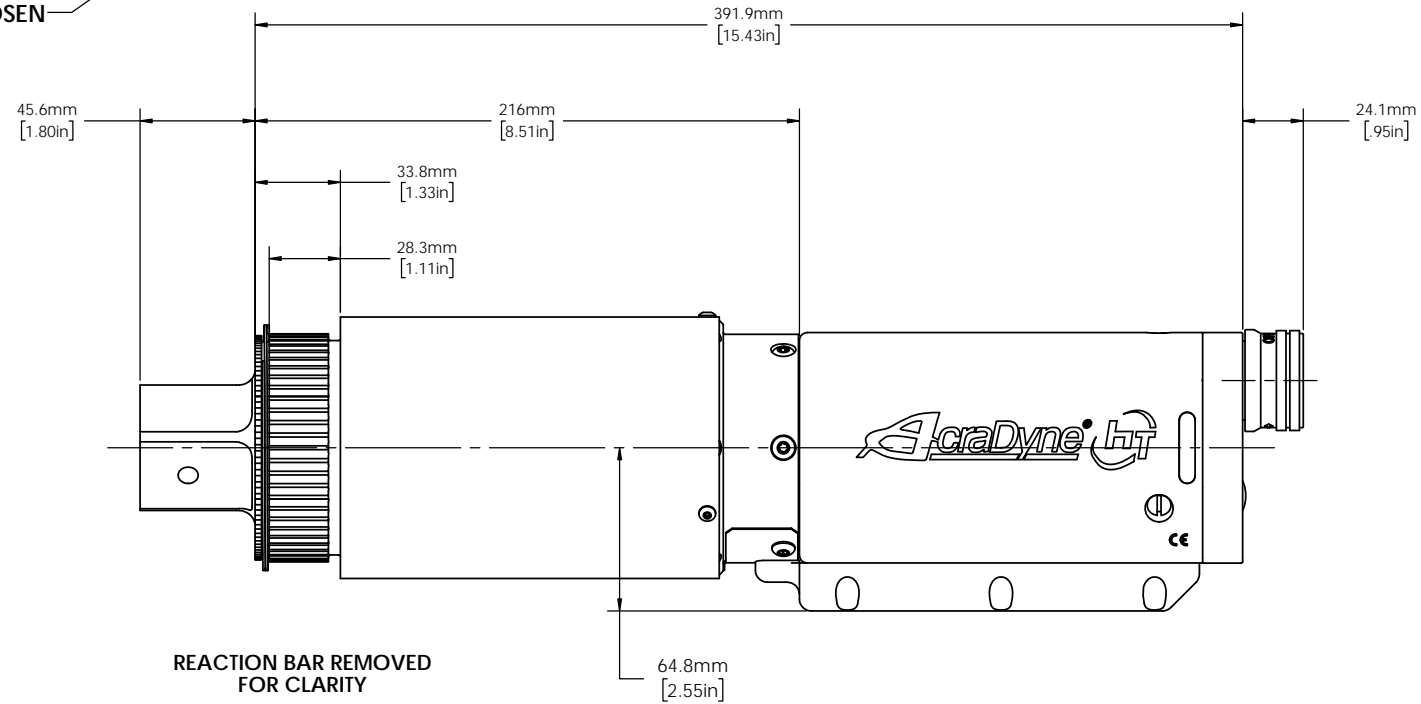
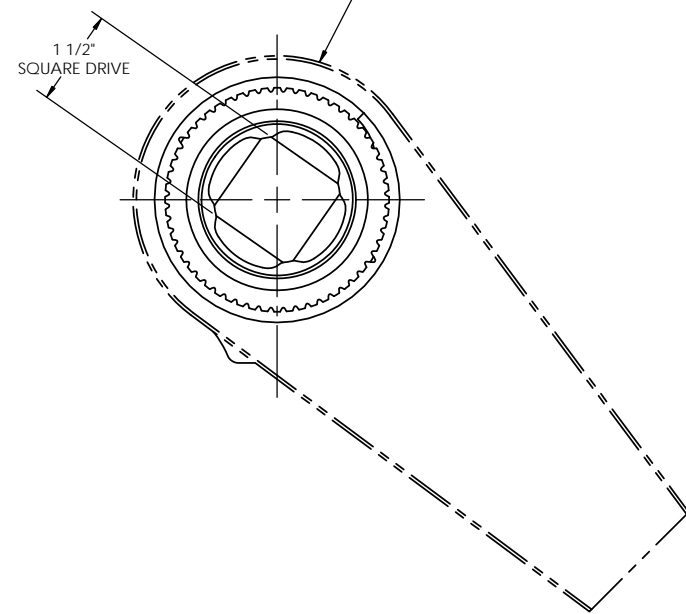
**AED4A89\_\_B**  
**FIXTURED NUTRUNNER**  
**8000 SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
<b>D</b>	<b>AEF4A89__B</b>	<b>C</b>

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



REACTION BAR GEOMETRY  
TO CHANGE DEPENDING  
ON REACTION BAR CHOSEN



MODEL NO.
AEF4A896500B
AEF4A898100B



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REVISION BLOCK

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D	AEF4A89_ _ _ B	C

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