

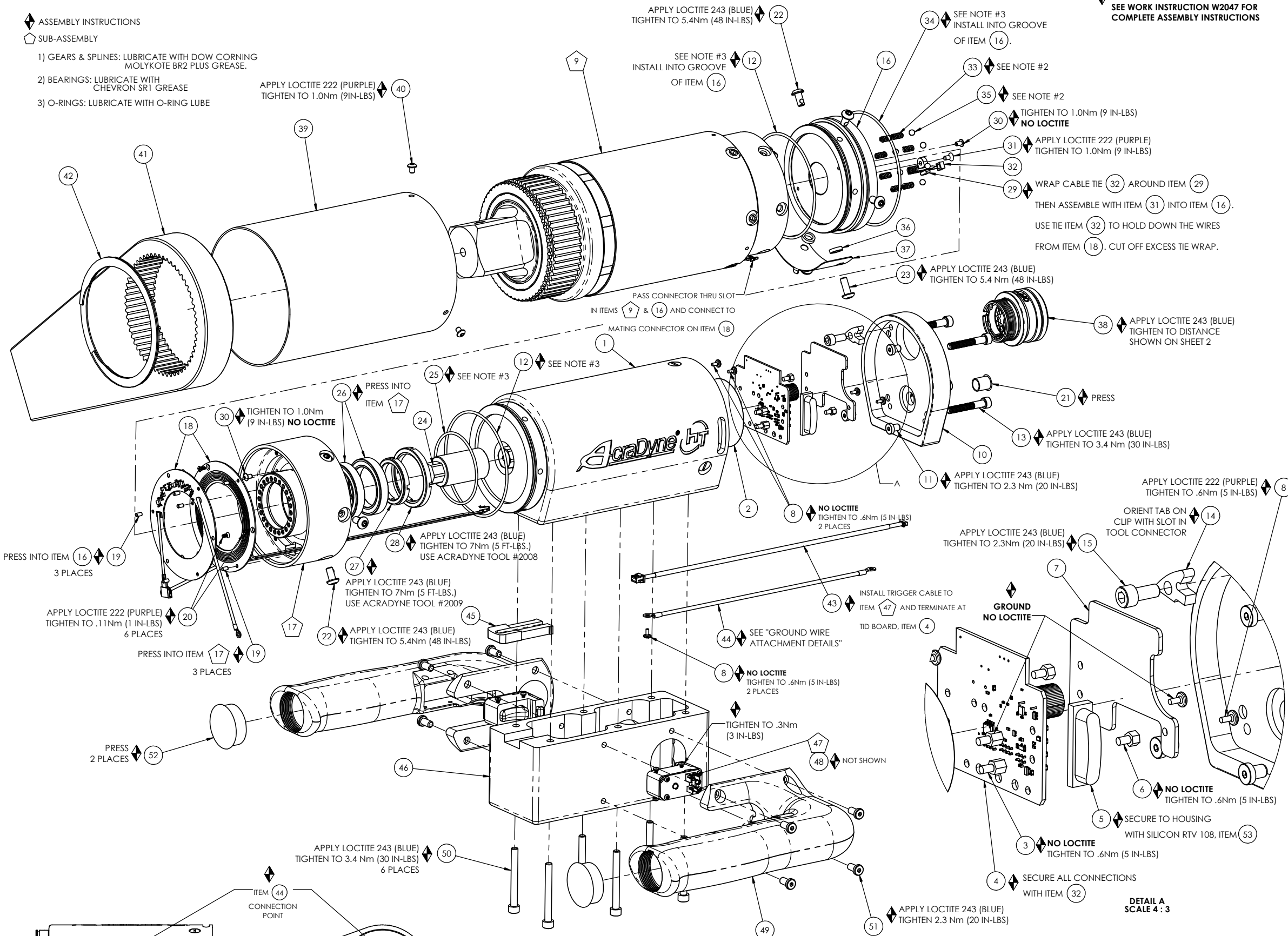
◆ ASSEMBLY INSTRUCTIONS
 ◻ SUB-ASSEMBLY

- 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

APPLY LOCTITE 222 (PURPLE)
 TIGHTEN TO 1.0Nm (9IN-LBS)

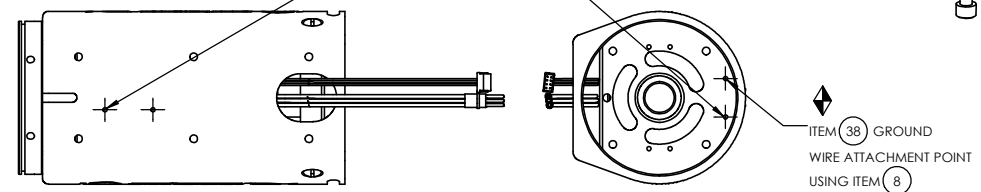
APPLY LOCTITE 243 (BLUE)
 TIGHTEN TO 5.4Nm (48 IN-LBS)

NOTE:
 SEE WORK INSTRUCTION W2047 FOR
 COMPLETE ASSEMBLY INSTRUCTIONS



COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26160	1	ASSY, MOTOR, 4650
	2	24840	1	FOIL SEAL 2" DIA
	3	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	4	27797	1	TID BOARD, POPULATED W/O AMP CIRCUIT
	5	25490	2	LENS, LED, INJECTION MOLDED
	6	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	7	29338	1	TID WIRE INSULATOR
	8	25573	7	SCREW PHP 4-40 X 3/16 18-8 SS
	9	28115	1	GEAR BOX ASSEMBLY
	10	25225	1	END GRIP CAP, HT TOOLS
	11	24859	3	LHSC 10-32 X 1/4 BLK OXIDE
	12	27714	2	O-RING 3" ID
	13	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	14	27063	1	TOOL CONNECTOR CLIP
	15	26458	1	SCREW, SHC 10-32 X .44 LG., STEEL, BLACK OXIDE
	16	27978	1	SLIP RING INNER PLATE
	17	28278	1	SLIP RING OUTER PLATE SUB-ASM.
SEE WORK INSTRUCTIONS W2047	18	27983.006	1	SLIP RING SET
	19	27994	6	DOWEL PIN, Ø.0938 X .1875 LG., STEEL
	20	27993	6	SCREW, FHPM, 2-56, 18-BSS, PLAIN
	21	25579	1	PLUG 3/8"
	22	29279	10	SCREW, BHSC, 10-32 X 3/8, TORX HEAD, NYLON PELL-IT STEEL
	23	29284	2	SCREW, BHSC, 10-32 X 1/2, TORX HEAD, NYLON PELL-IT STEEL
	24	27980	1	SLIP RING PINION ADAPTER
	25	26080	1	O-RING, LED LIGHT RING COVER
	26	25969	2	BEARING, BALL, Ø42mm X Ø30mm X 7mm
	27	25961	1	BEARING RETAINER, INNER
	28	25962	1	BEARING RETAINER, OUTER
	29	28000	1	CABLE TIE-MOUNT
	30	25745	2	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	31	24940	1	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
NOT SHOWN	32	28257	1	CABLE TIE, 1.65MM W X 71MM LG
	33	28174	8	SPRING, COMPRESSION
	34	27953	1	O-RING, 70 DURO BUNA N, -042
	35	20105	8	DETENT BALL
	36	25564	2	WASHER SHIM .093THK .25ID .375OD
	37	28204	1	RING GEAR COVER, 8100Nm
	38	25507	1	TOOL CONNECTOR ASM HERC PISTOL
	39	26636	1	GEAR CASE COVER
	40	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	41	26899	1	CHOOSE REACTION BAR
	42	26436	1	RETAINING RING, SPIRAL, Ø3.833 X Ø3.293 X .111
	43	28107	1	TRIGGER CABLE, 10'LG., 6P TO 3P
	44	31412	1	GROUND WIRE ASSEMBLY, 18 AWG, 8000 & 9000 HT SERIES
	45	27999	1	SLIP RING TRANSDUCER CABLE CHASE
	46	30899	1	MOUNTING BLOCK, J-HANDLE, DUAL LEVER
	47	25212	2	SWITCH SUB-ASSEMBLY
NOT SHOWN	48	25582	1	TRIGGER CABLE
	49	25229	2	AXIAL HANDLE, HT TOOLS
	50	26183	6	SCREW, SHC, 10-32 X 1.75, STEEL
	51	25569	8	SCREW LHCS 10-32 X 3/8 18-8 SS
	52	24858	2	PLUG 1 3/16
NOT SHOWN	53	24177	A/R	RTV 108, TRANSLUCENT

GROUND WIRE ATTACHMENT DETAILS



AIMCO
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 503.254.6600

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BLOCK TOLERANCING PER DECIMAL:
 .X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005
 ANGLE = ±0°30'

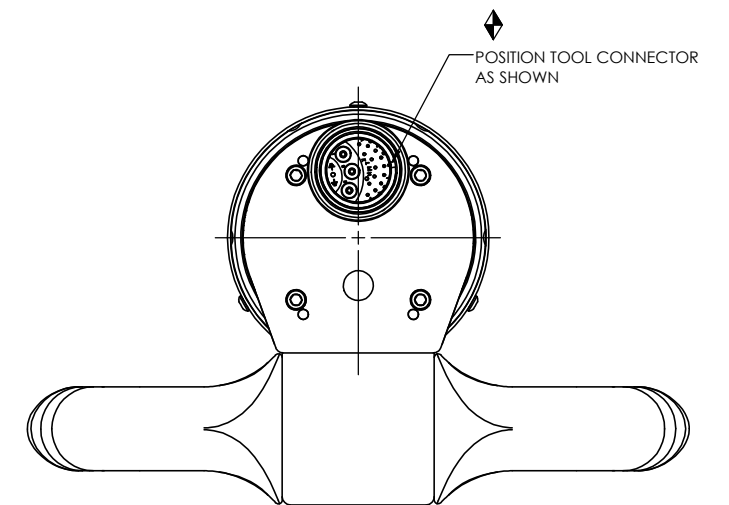
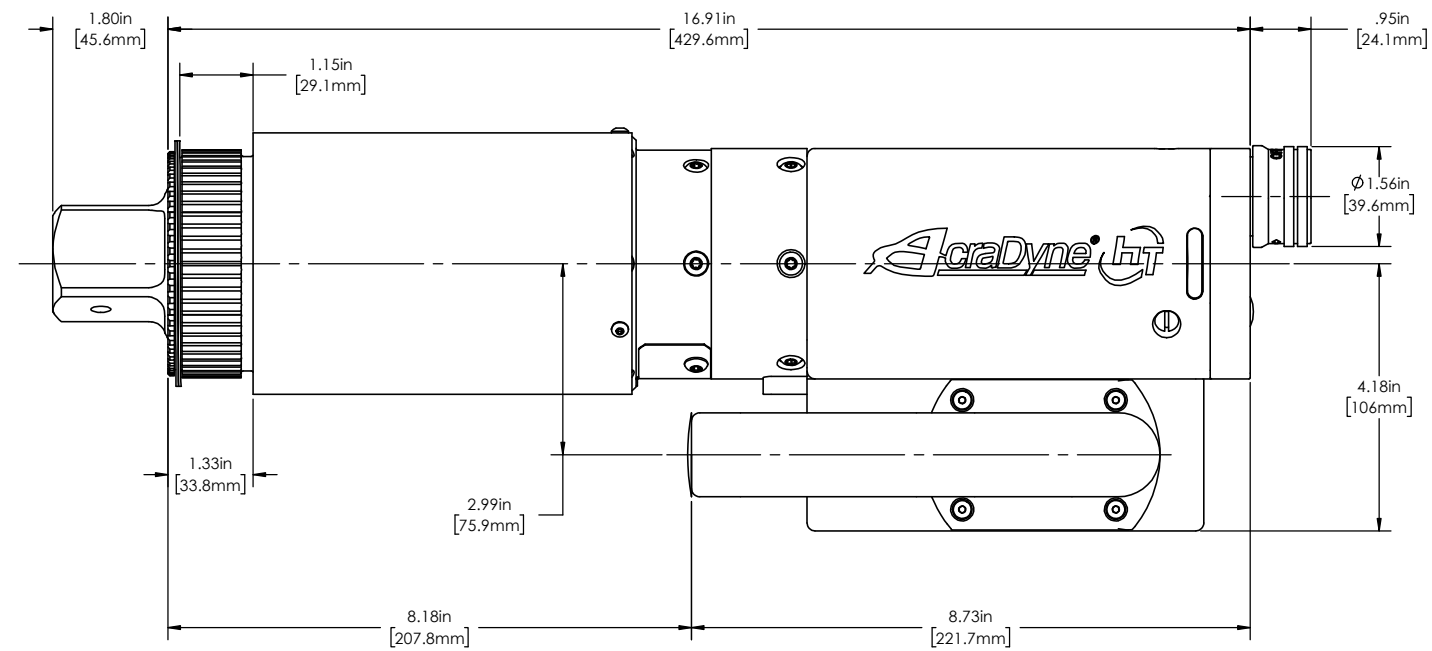
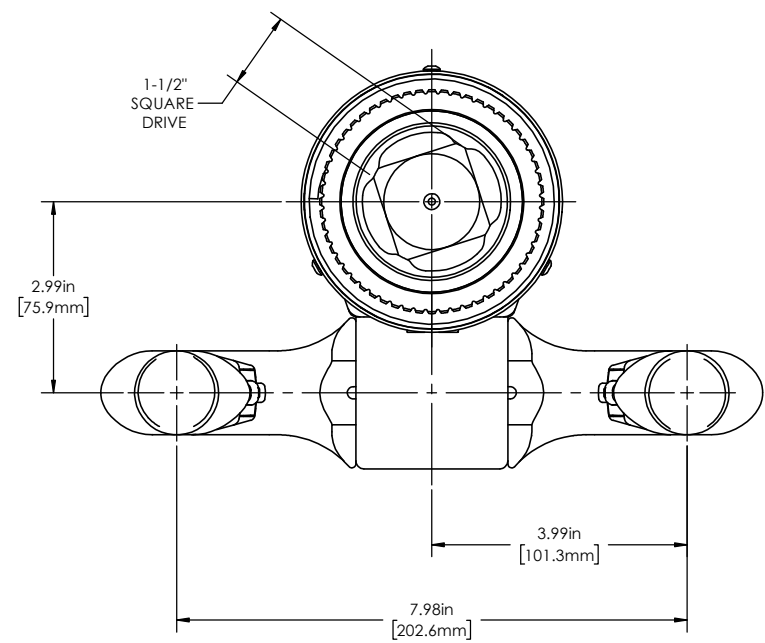
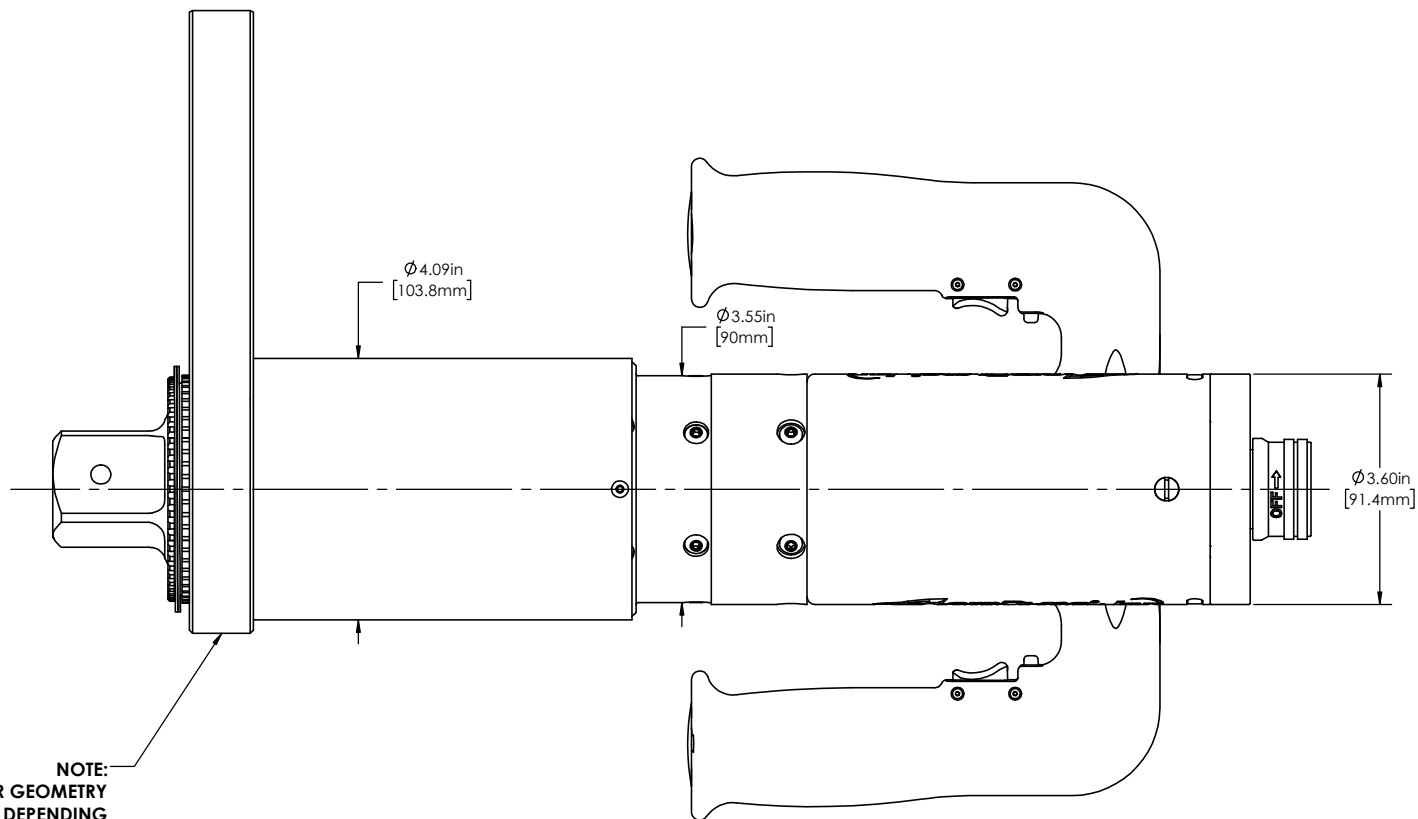
REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINE SURFACE FINISH: 125 RMS OR BETTER

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ACRADYNE MECHANICAL ENGINEERING

DUAL LEVER "J" HANDLE NUTRUNNER W/SLIP RING CLUTCH 8000-SERIES

SIZE: **D** PART / DRAWING NUMBER: **AEJ4B898100BDL** REVISION: **A**

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



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REVISION BLOCK				

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SIZE D	PART / DRAWING NUMBER AEJ4B898100BDL	REVISION A
SCALE: 2:3	DO NOT SCALE DRAWING	SHEET 2 OF 2