





◆ 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

21 ◆ APPLY LOCTITE #243 (BLUE)  
TIGHTEN TO 2.8Nm (25 IN-LBS.)  
4 PLACES



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
A	10/27/21	PRODUCTION RELEASE	6079	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**

<b>DUAL "J" HANDLE NUTRUNNER, W/SLIPRING CLUTCH &amp; FAN KIT, 8100Nm</b>		REVISION
SIZE	PART / DRAWING NUMBER	REVISION
<b>D</b>	<b>AEJ4U998100BDL</b>	<b>A</b>
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 2 OF 3

