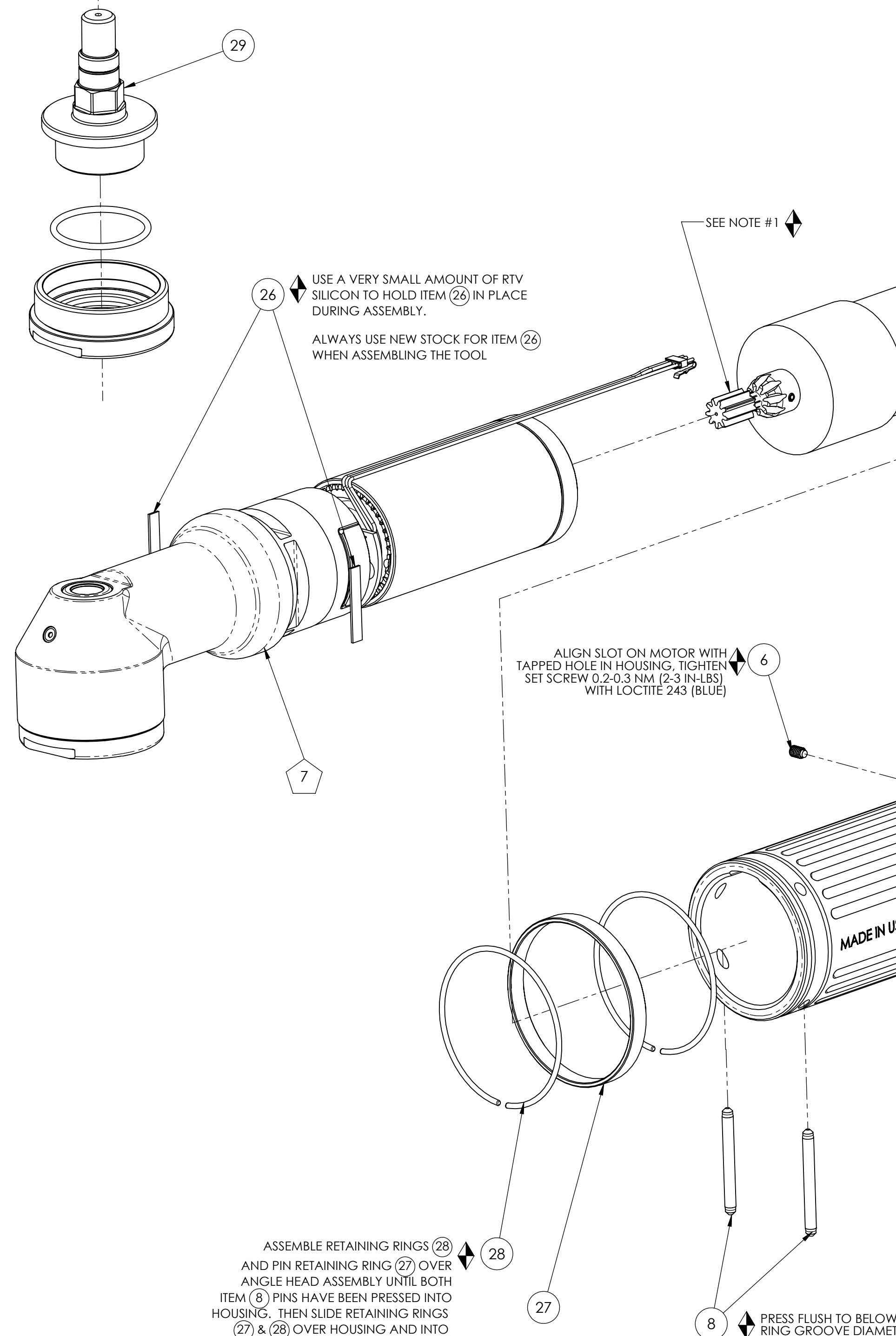
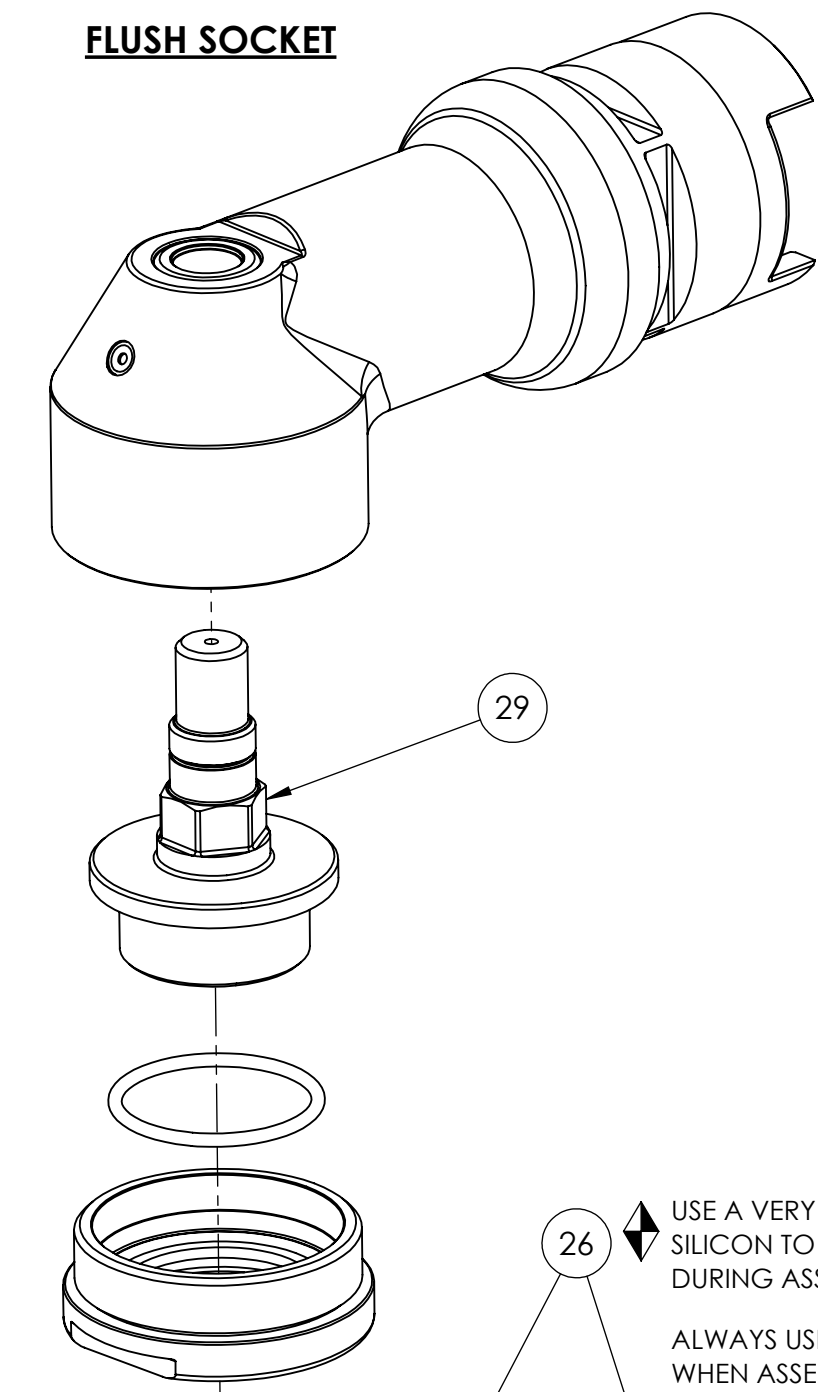


FLUSH SOCKET



26 USE A VERY SMALL AMOUNT OF RTV SILICON TO HOLD ITEM (26) IN PLACE DURING ASSEMBLY.
ALWAYS USE NEW STOCK FOR ITEM (26) WHEN ASSEMBLING THE TOOL

6 ALIGN SLOT ON MOTOR WITH TAPPED HOLE IN HOUSING. TIGHTEN SET SCREW 0.2-0.3 NM (2-3 IN-LBS) WITH LOCTITE 243 (BLUE)

ASSEMBLE RETAINING RINGS (28) AND PIN RETAINING RING (27) OVER ANGLE HEAD ASSEMBLY UNTIL BOTH ITEM (8) PINS HAVE BEEN PRESSED INTO HOUSING. THEN SLIDE RETAINING RINGS (27) & (28) OVER HOUSING AND INTO GROOVES.

8 PRESS FLUSH TO BELOW RING GROOVE DIAMETER

MODEL NO.	ANGLEHEAD/GEAR TRAIN ASM.
AEN33060CF	27611
AEN33090CF	27614

COMMENTS	ITEM NO.	PART NUMBER	Motor_exploded/QTY.	DESCRIPTION
	1	27031	1	NUTRUNNER HOUSING, GEN III
	2	25525	1	MOTOR ASSY, 9T, 3000 SERIES
	3	25063	1	LED BOARD ASM.
	4	25075	2	SCREW, SHC 4-40X.375, STEEL, BLACK OXIDE
	5	25430	2	STAND-OFF, LED, 3000 SERIES
	6	27027	1	SCREW, SET 5-40X.188,STEEL,BLK OXIDE
	7	SEE CHART	1	ANGLE HEAD, FLUSH SOCKET GEAR TRAIN ASM.
	8	26793	2	RETAINING PIN, .125 OD X 1-1/4
	9	26102	1	TOOL CONNECTOR ASM., LEVER
	10	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	11	25847	1	TID BOARD ASM.
	12	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	13	20132	1	THROTTLE SPRING
	14	26532	1	GEN 3 TRIGGER ASSY, CAST
	15	20061	2	SCREW, LEVER
	16	25072	1	O-RING, LED LIGHT RING COVER
	17	25058	1	LIGHT RING COVER, LED
	18	26084	1	HANDLE COVER, MFB
	19	24706	1	REV BUTTON SUB-ASSEMBLY
	20	24683	1	SPRING, REV BUTTON
	21	24679	1	RETAINING RING
	22	24940	10	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	23	26083	1	HANDLE COVER
	24	20534	1	3000 SERIAL/MODEL LABEL
	25	22141	1	SAFETY LABEL
	26	26184	2	ADAPTER INSERT, GEN 3B 3000 SERIES
	27	25106	1	PIN RETAINER RING
	28	25107	2	RETAINING RING, PIN RETAINER
	29	27259	1	SHAFT, OUTPUT, FLUSH SOCKET

4 TIGHTEN TO 1.4-1.6 NM. (12-14 IN-LBS) LOCTITE 243 (BLUE)

22 SEE NOTE #4 5 PLACES

10 ASSEMBLE THRU GROUND TERMINAL SEE NOTE #4 NO LOCTITE

12 SEE NOTE #4 2 PLACES

10 SEE NOTE #4 4 PLACES

ASSEMBLE TOOL CONNECTOR 90° FROM TOOL LEVER AS SHOWN

15 TIGHTEN TO 1.7NM (15 IN-LBS) LOCTITE 243 (BLUE) 2 PLACES

22 SEE NOTE #4 5 PLACES

- ◆ ASSEMBLY INSTRUCTIONS
- ◡ SUB-ASSEMBLY
- 1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- 2) BEARINGS: LUBRICATE WITH CHEVRON SRI GREASE
- 3) O-RINGS: LUBRICATE WITH O-RING LUBE
- 4) TIGHTEN TO 1.0 NM (9IN-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



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
REVISION BLOCK				

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

AEN330__CF FLUSH HEAD NUTRUNNER 3000 SERIES - GEN 3C		
SIZE D	PART / DRAWING NUMBER AEN330__CF	REVISION A
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 3

BASE MODEL	DOT	SOCKET BASE	COLUMN 1	SOCKET SIZE	COLUMN 2	EXT.	COLUMN 3	MAGNET	COLUMN 4
AEN33060CF	.	X	DRIVE TYPE	X	HEX SIZE	X	EXTENSION LENGTH	X	MAGNET OPTION
		A	27259 SINGLE HEX	A	10mm	A	0	0	NO MAGNET
		B	27259 DOUBLE HEX	B	11mm	B	3mm	1	WITH MAGNET
		C	27259 SURFACE DRIVE	C	12mm	C	6mm		
				D	13mm	D	9mm		
				E	14mm	E	12mm		
				F	15mm	F	15mm		
				G	16mm	G	18mm		
				H	17mm	H	21mm		
				I	7/16"	I	24mm		
				J	1/2"	J			
				K	9/16"	K			
				L	5/8"	L			
				M	11/16"	M			
				N		N			
				P		P			
				Q		Q			
				R		R			
				S		S			
				T		T			
				U		U			
				V		V			
				W		W			
				X		X			
				Y		Y			
				Z		Z			

****EXAMPLE MODEL NUMBER:** AEN33060CF.CEG0 = SURFACE DRIVE, 14mm HEX, 18mm EXT., NO MAGNET



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
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 DIMENSIONS AND TOLERANCING PER ANSI Y14.5
 SURFACE ROUGHNESS PER ANSI Y14.36

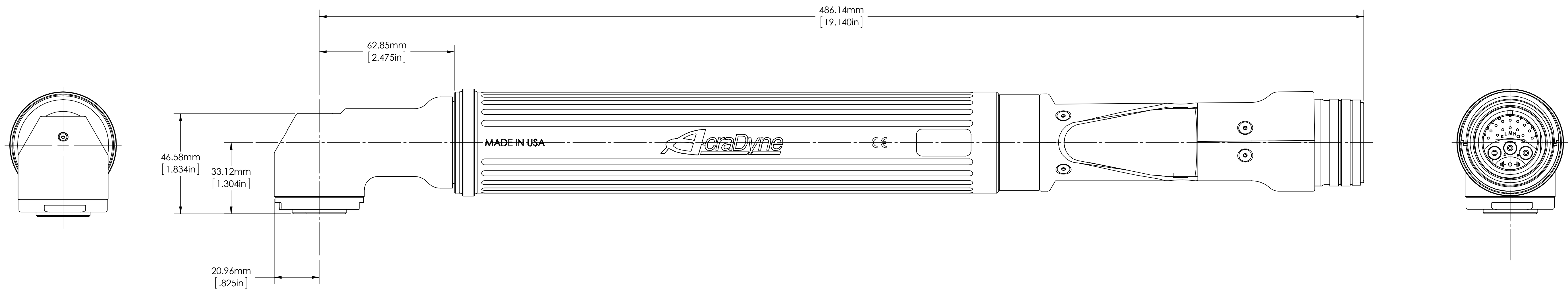
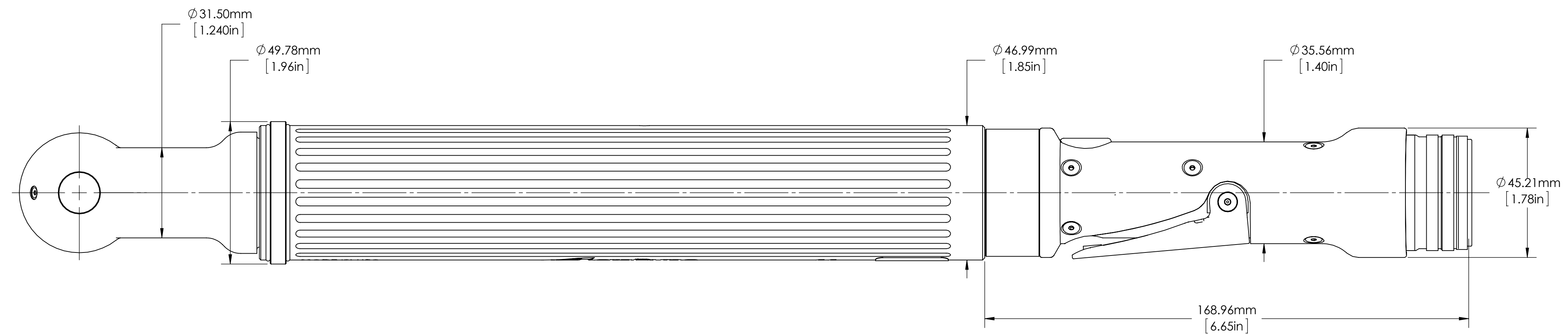
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 ANGLE = ±0° 30'

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 MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AEN330__CF FLUSH HEAD NUTRUNNER
 3000-SERIES - GEN 3C

SIZE B	PART / DRAWING NUMBER AEN330__CF	REVISION A
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 3 OF 3



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AEN330_CF FLUSH HEAD NUTRUNNER
 3000 SERIES - GEN 3C

SIZE D	PART / DRAWING NUMBER AEN330_CF	REVISION A
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 2 OF 3