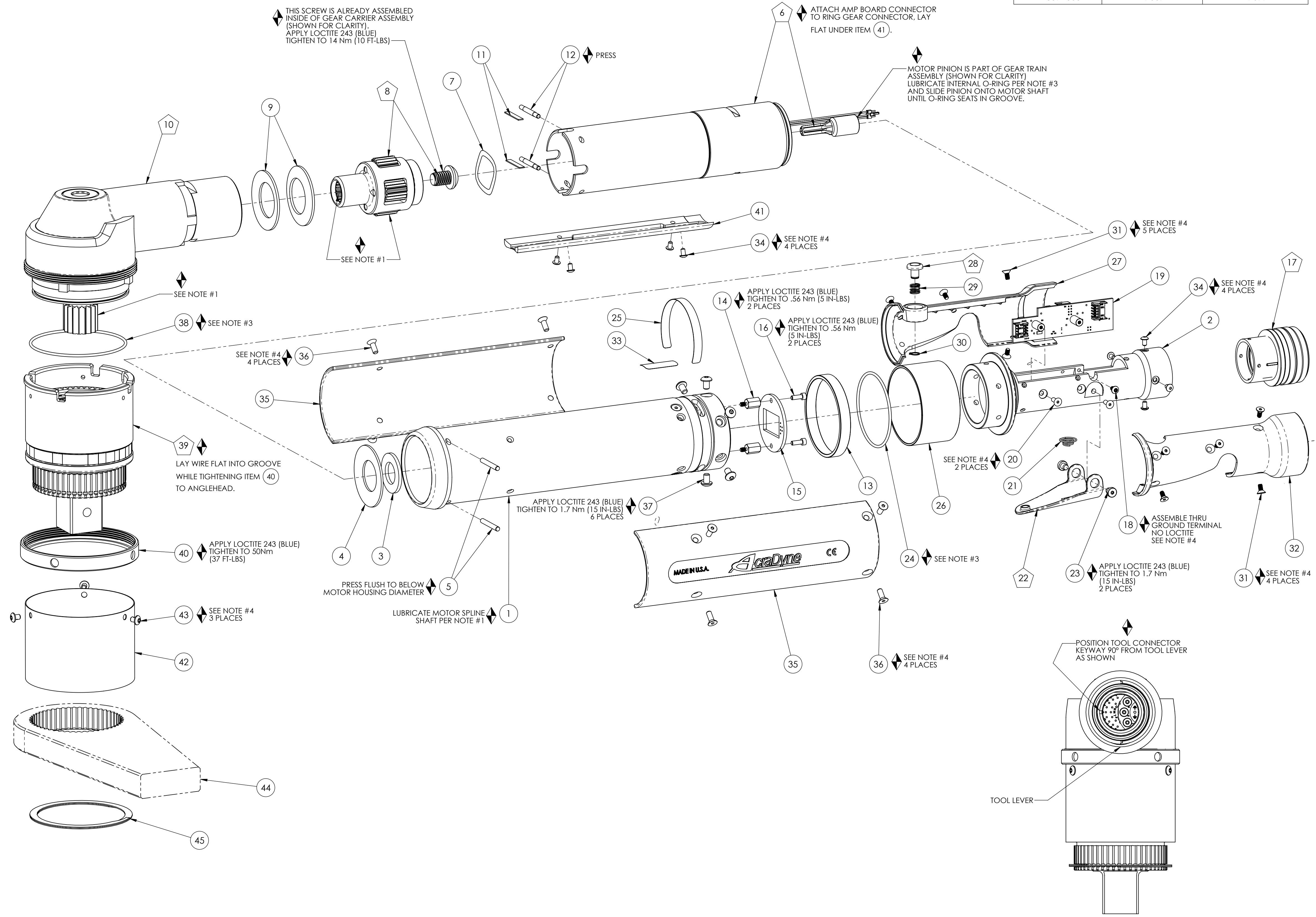


MODEL NO.	HT GEARBOX ASM.	GEAR CASE COVER
AEN3571000A	27648	27675
AEN3572600A	27667	27677

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26058	1	MOTOR ASM., 5000 SERIES
	2	26082	1	LEVER HANDLE
	3	26198	1	THRUST WASHER
	4	26074	1	BELLEVILLE WASHER
	5	26530	2	DOWEL PIN, $\varnothing 1/8 \times 1.00$ , STEEL
	6	28127	1	GEAR TRAIN ASM., HT, 1000Nm, 5000-SERIES
	7	20912	1	WAVE SPRING --- 3000 SERIES
	8	20924	1	ASSEMBLY, GEAR CARRIER, THIRD STAGE
	9	20911	2	BELLEVILLE WASHER
	10	27664	1	ANGLEHEAD ASSY, 2600 Nm, HT ANGLEHEAD
	11	26184	2	ADAPTER INSERT, GEN 3B 3000 SERIES
	12	20913	2	PIN, RETAINING
	13	27391	1	PIN RETAINER RING
	14	26077	2	M-F THREADED HEX STANDOFF
	15	26095	1	LED BOARD ASM.
	16	26078	2	SHC SCREW, 4-40, BLACK OXIDE
	17	26102	1	TOOL CONNECTOR ASM., LEVER
	18	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
	19	25847	1	TID BOARD ASM.
	20	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	21	20132	1	THROTTLE SPRING
	22	26532	1	GEN 3 TRIGGER ASSY, CAST
	23	20061	2	SCREW, LEVER
	24	26080	1	O-RING, LED LIGHT RING COVER
	25	20534	1	3000 SERIAL/MODEL LABEL
	26	26079	1	LIGHT RING COVER, LED
	27	26084	1	HANDLE COVER, MFB
	28	24706	1	REV BUTTON SUB-ASSEMBLY
	29	24683	1	SPRING, REV BUTTON
	30	24679	1	RETAINING RNG
	31	24940	10	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	32	26083	1	HANDLE COVER
	33	22141	1	SAFETY LABEL
	34	25745	8	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	35	26081	2	MOTOR HOUSING COVER
	36	25385	8	SCREW, FHSC 6-32 X .375, STEEL
	37	26088	6	SCREW, BHC 8-32X.25, STEEL, BLACK OXIDE
	38	26227	1	O-RING, MOTOR HOUSING
	39	SEE CHART	1	GEARBOX ASSY, HT ANGLEHEAD, 1000 Nm
	40	27650	1	RETAINER, HT ANGLE TOOLS
	41	27674	1	WIREWAY 1000 NM & 2600 NM
	42	SEE CHART	1	GEAR CASE COVER 1000 NM
	43	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	44	26897	1	CHOOSE REACTION BAR
	45	26243	1	RETAINING RING, SPIRAL, $\varnothing 2.864 \times \varnothing 2.464 \times .078$



- ◆ 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
  - 4) APPLY LOCTITE 243 (BLUE), TIGHTEN TO 1.0 Nm (9 IN-LBS)

REQUIRED TOOLING
LOCTITE 243 (BLUE)
1/16 HEX WRENCH
1/16 HEX WRENCH
1/16 HEX WRENCH
1/16 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
<b>REVISION BLOCK</b>				

**UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES**  
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36

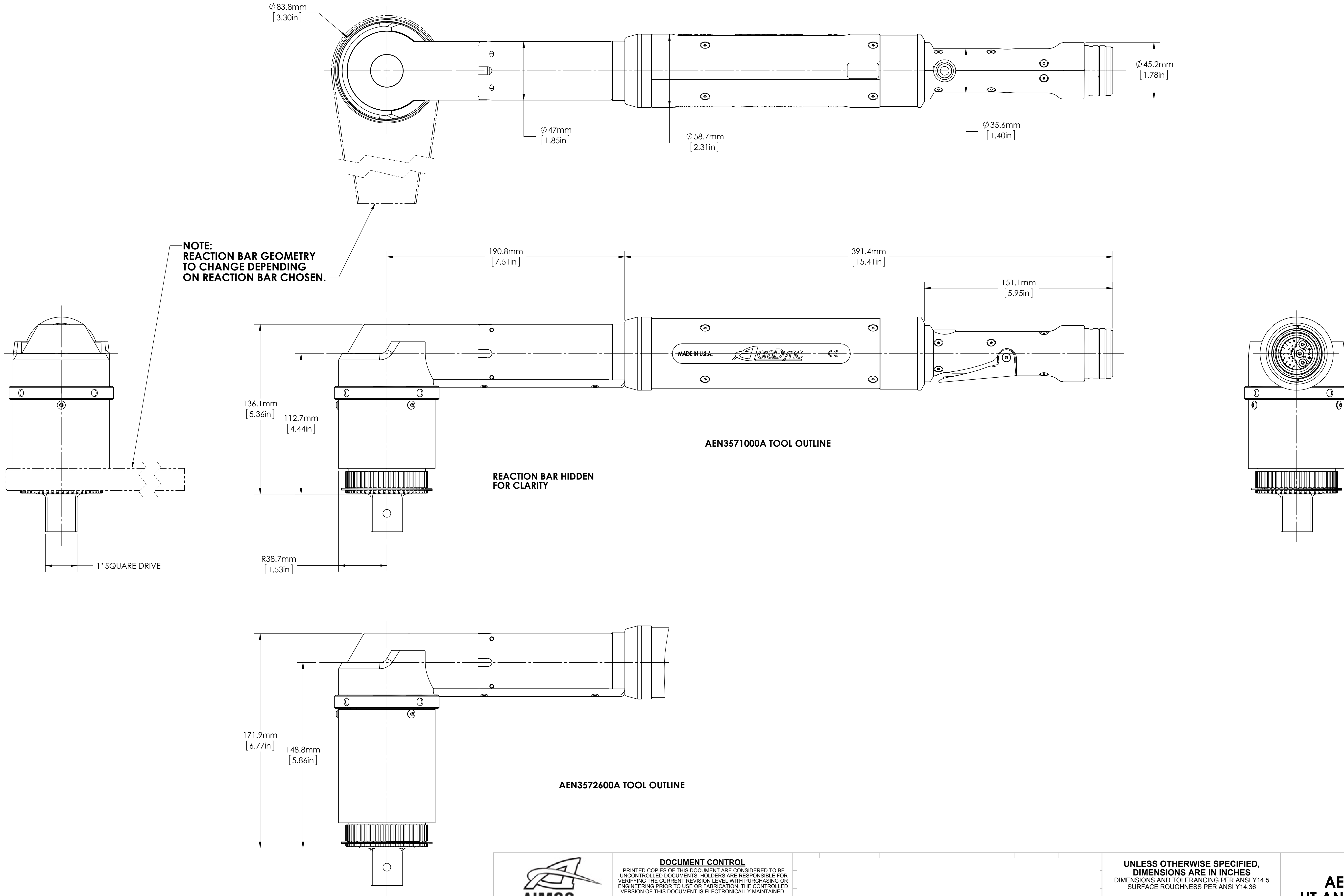
**BLOCK TOLERANCING PER DECIMAL:**  
 X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005  
 ANGLE = ±0° 30'

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:  
**ACRADYNE MECHANICAL ENGINEERING**

**AEN357\_\_A**  
**HT ANGLE NUTRUNNER**  
 5000-SERIES

SIZE <b>D</b>	PART / DRAWING NUMBER <b>AEN357__A</b>	REVISION <b>A</b>
SCALE: 2:3	DO NOT SCALE DRAWING	SHEET 1 OF 2



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<b>AEN357 ___ A HT ANGLE NUTRUNNER 5000-SERIES</b>		
SIZE <b>D</b>	PART / DRAWING NUMBER <b>AEN357 ___ A</b>	REVISION <b>A</b>
SCALE 2:3	DO NOT SCALE DRAWING	SHEET 2 OF 2