

REQUIRED TOOLING	
SNAP-ON CROWFOOT WRENCH, 1/2" SQ. DR. X 1-3/8" OPENING	
SNAP-ON PART NUMBER SC044	
MAGNETIC VISE JAWS - PART NUMBER 1000-100	
LOCTITE #243 BLUE	
TORQUE WRENCH, 1/2" DRIVE	
EXTERNAL SNAP RING PLIERS	
LOCTITE #263 RED	
HEX KEY - 9/64"	
HEX KEY - 3/32"	
HEX KEY - 1/16"	
PHILLIPS HEAD SCREW DRIVER	
TORX - T8	
TORX - T10	

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26787	1	MOTOR ASM., MID-EXIT
	2	24780	1	MOTOR COUPLER SUB-ASM.
	3	25763	1	TRANSDUCER ADAPTOR
	4	25761	1	TRANSDUCER SUB-ASM., 20Nm
	5	24709	1	GEAR CASE SUB-ASM, 14T/14T
	6	26695	1	TOOL CONNECTOR HOUSING
	7	26696	1	TOOL CONNECTOR ASSEMBLY, MID-EXIT
	8	25745	4	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
	9	25814	1	SCREW, PAN HEAD PHILLIPS, 4-40 x 3/16, STAR WASH, SS
	10	24174	A/R	HEAT SHRINK, Ø.125
	11	26166	8	SCREW, BHSC 6-32X.312, STEEL, BLACK OXIDE
	12	25868	2	SCREW, PLASTITE, PH TORX, M2.5 X 1.06 X 5, STEEL
	13	24890	1	ANGLE HEAD ASM, STUBBY, 3/8" SQ. DR.
	14	24855	A/R	SHIM .1MM, 14MM ID X 20MM OD
	15	24856	A/R	SHIM .2MM, 14MM ID X 20MM OD
	16	24857	A/R	SHIM .3MM, 14MM ID X 20MM OD
	17	26691	2	TRIGGER MOUNT
	18	20132	1	THROTTLE SPRING
	19	26697	1	LEVER ASM., MID-EXIT
	20	26719	2	SCREW, LHSC 8-32X .375, STEEL, BLACK OXIDE
	21	26686	1	MOTOR COVER
	22	25557	1	REV BUTTON SUB-ASSEMBLY
	23	24683	1	SPRING, REV BUTTON
	24	24679	1	RETAINING RNG
	25	26698	2	SCREW, PH TORX 4-20 X 1/2" LG. PLASTIC
	26	20534	1	SERIAL/MODEL LABEL
	27	25471	1	CLEAR LABEL COVER
	28	26699	1	LIGHT RING
	29	26720	1	O-RING, LIGHT RING

- ◆ LABEL ATTACHMENT:**
- ATTACH THE TOOL LABEL ITEM (26) INTO THE GROOVE AND COVER IT WITH CLEAR LABEL ITEM (27).
 - SLIDE LED COVER OVER TOOL CONNECTOR INTO PLACE OVER THE LABEL. ROLL THE O-RING OVER THE TOOL CONNECTOR AND INTO THE GROOVE.

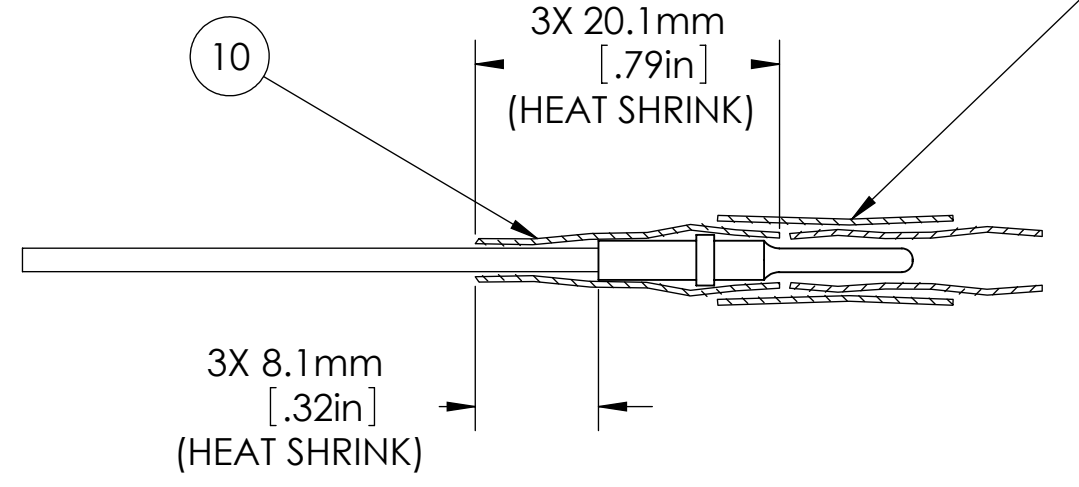
APPLY LOCTITE #243 BLUE TIGHTEN TO 1Nm (9 IN-LBS) TYP 4 SCREWS

◆ USE SHIMS, ITEMS (14) (15) (16) TO ALIGN ANGLE HEAD AS SHOWN

◆ APPLY LOCTITE #243 BLUE ASSEMBLE OUTPUT ASM TO GEAR CASE. TIGHTEN TO 60Nm (44 FT-LBS)

◆ APPLY LOCTITE #243 BLUE 1.7Nm (15 IN-LBS.) TYP 4 PLACES

◆ APPLY THIS LAYER OF HEAT SHRINK (10) AFTER CONNECTING PIN AND SOCKET 3 PLC'S AS SHOWN



MOTOR PHASE WIRE TERMINATION SCALE 2:1

FEED EXCESS WIRE LENGTH INTO REAR CAVITY OF MOTOR

◆ ROUTE HALL SWITCH THRU SLOTS IN REAR OF MOTOR HOUSING THEN FASTEN TO TOOL CONNECTOR HOUSING (6) WITH (12) SCREWS

◆ TIGHTEN TO 1.7Nm (15 IN-LBS)

◆ APPLY LOCTITE #243 BLUE TIGHTEN TO GEAR CASE TO 60Nm (44 FT-LBS.)

◆ APPLY LOCTITE #243 BLUE 1.7Nm (15 IN-LBS.) TYP 4 PLACES

◆ APPLY LOCTITE #243 BLUE TIGHTEN TO 1.7Nm (15 IN-LBS) 9/64 HEX - 2 PLACES

- ◆ ASSEMBLY INSTRUCTIONS
- ◻ SUB-ASSEMBLY
- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
 - BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
 - O-RINGS: LUBRICATE WITH O-RING LUBE



DOCUMENT CONTROL
PRINTED COPIES OF THIS DOCUMENT ARE CONSIDERED TO BE UNCONTROLLED DOCUMENTS. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL
THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL TO ACRADYNE/AIMCO. IN THE ABSENCE OF EXPRESSED WRITTEN PERMISSION, ACRADYNE/AIMCO HAS LOANED THIS COPY WITH THE MUTUAL UNDERSTANDING THAT (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN FOR THAT IN WHICH IT WAS PROVIDED, (B) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS, (C) IT WILL NOT BE REPRODUCED, AND (D) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

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

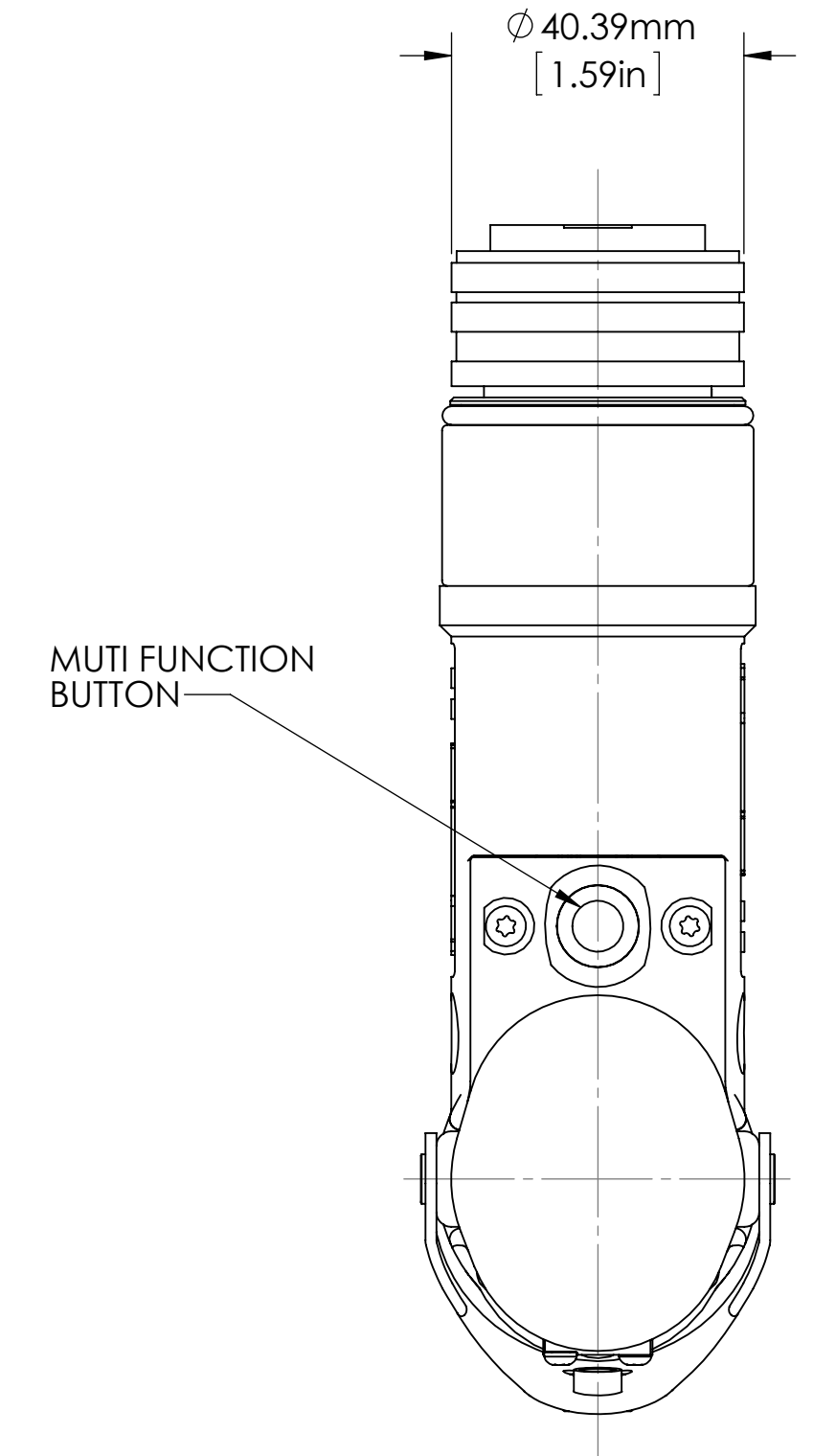
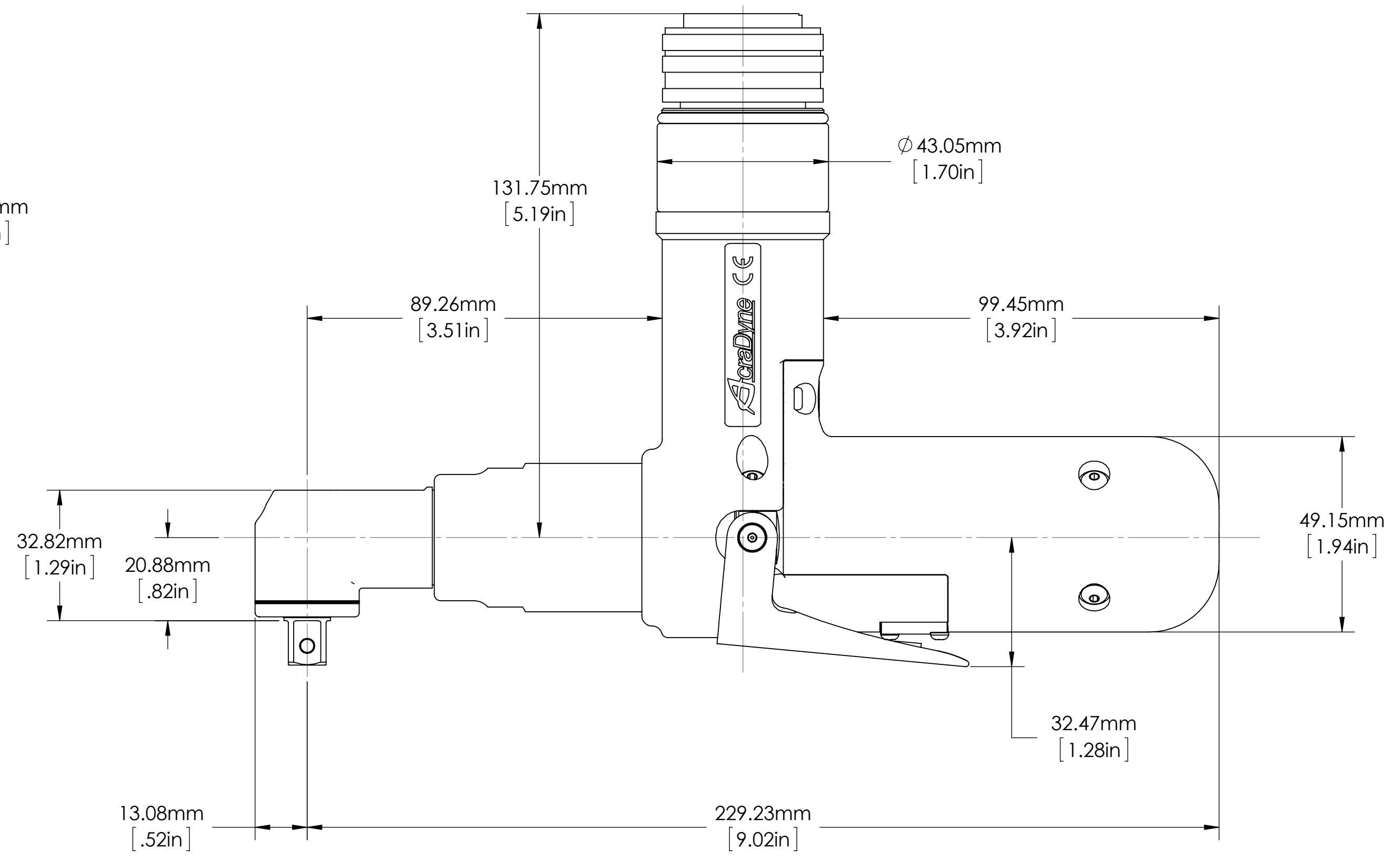
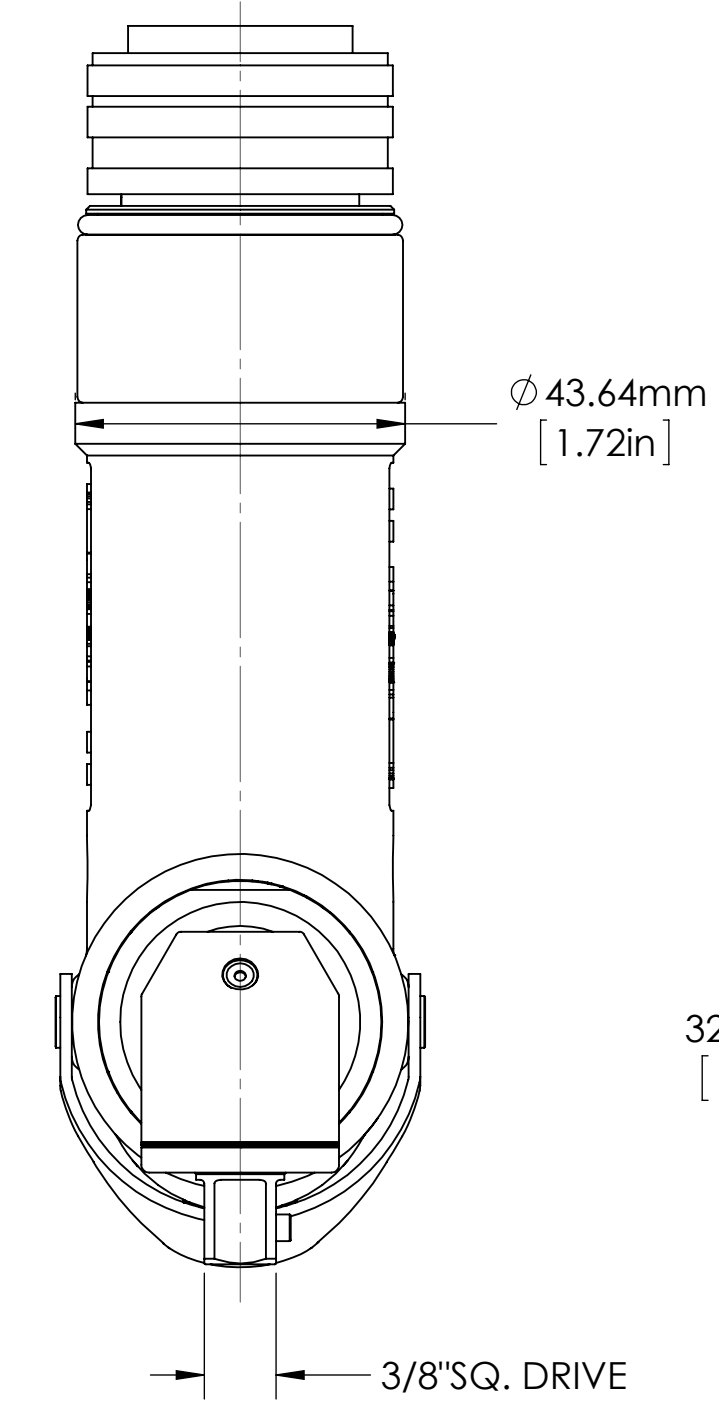
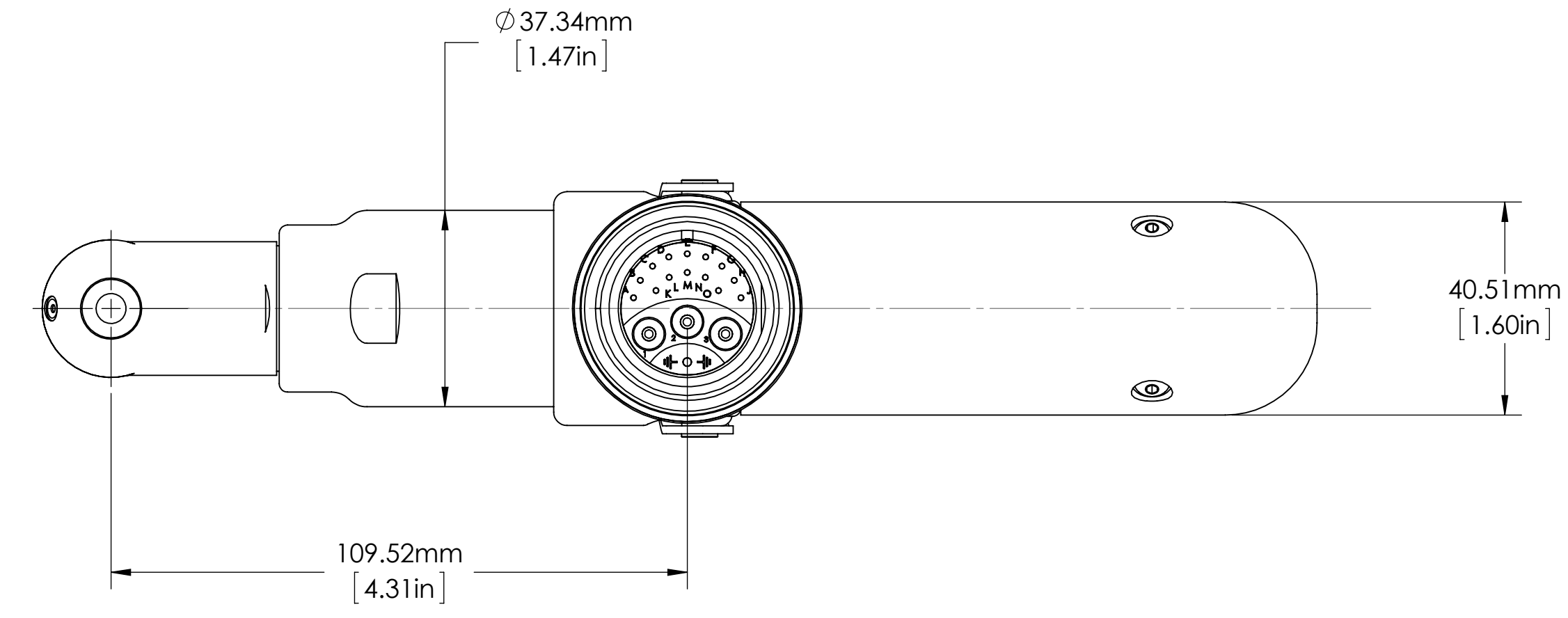
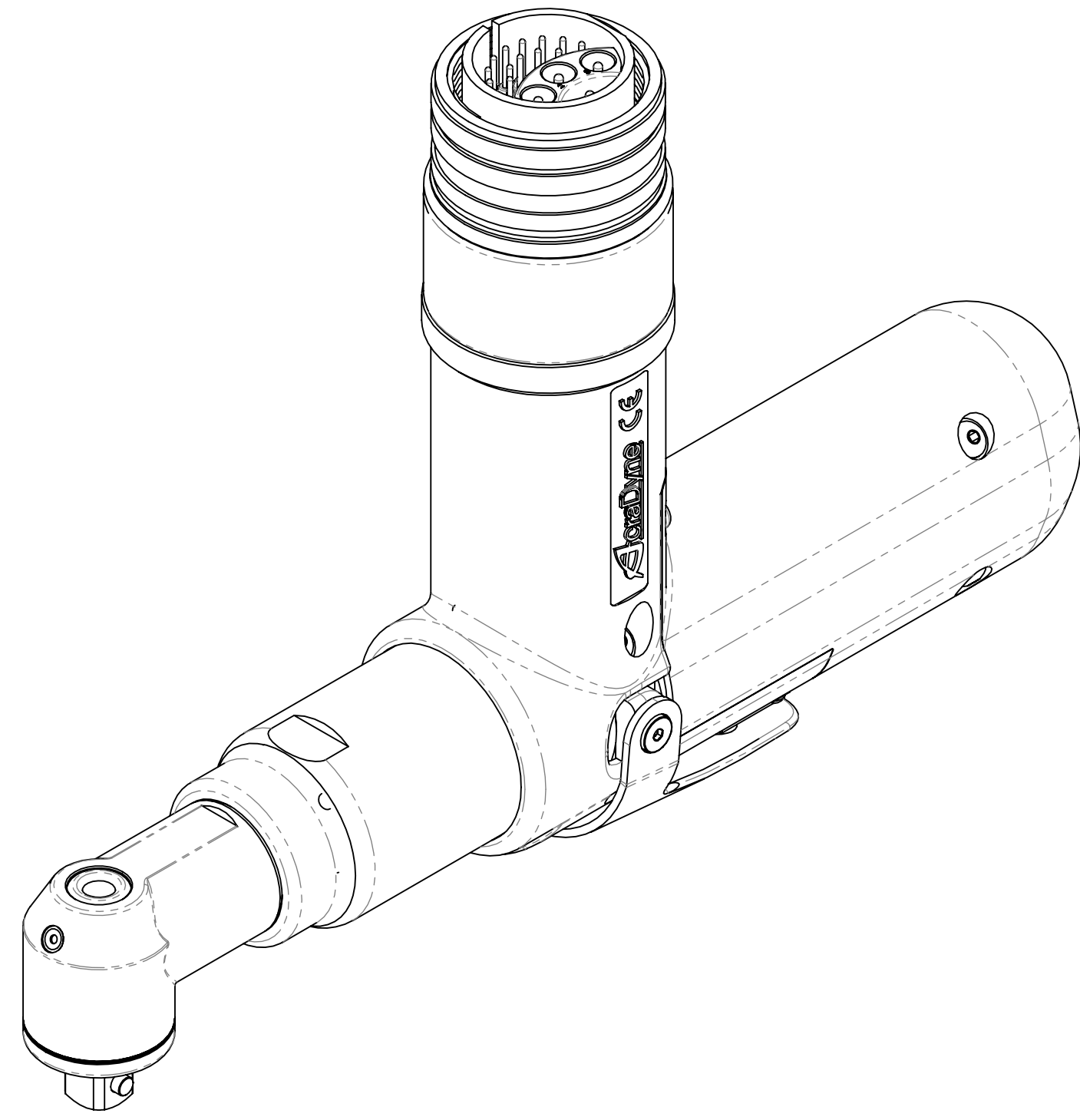
BLOCK TOLERANCING PER DECIMAL:
X = ±.030 XX = ±.010 XXX = ±.005 XXXX = ±.0005
ANGLE = ±0°30'

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AEN4C22015BM ANGLE NUTRUNNER GEN 4, 2000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEN4C22015BM	A
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2



DOCUMENT CONTROL
 PRINTED COPIES OF THIS DOCUMENT ARE CONSIDERED TO BE UNCONTROLLED DOCUMENTS. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL
 THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL TO ACRADYNE/AIMCO. IN THE ABSENCE OF EXPRESSED WRITTEN PERMISSION, ACRADYNE/AIMCO HAS LOANED THIS COPY WITH THE MUTUAL UNDERSTANDING THAT (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN FOR THAT IN WHICH IT WAS PROVIDED, (B) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS, (C) IT WILL NOT BE REPRODUCED, AND (D) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

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

AEN4C22015BM ANGLE NUTRUNNER GEN 4, 2000 SERIES		
SIZE D	PART / DRAWING NUMBER AEN4C22015BM	REVISION A
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2