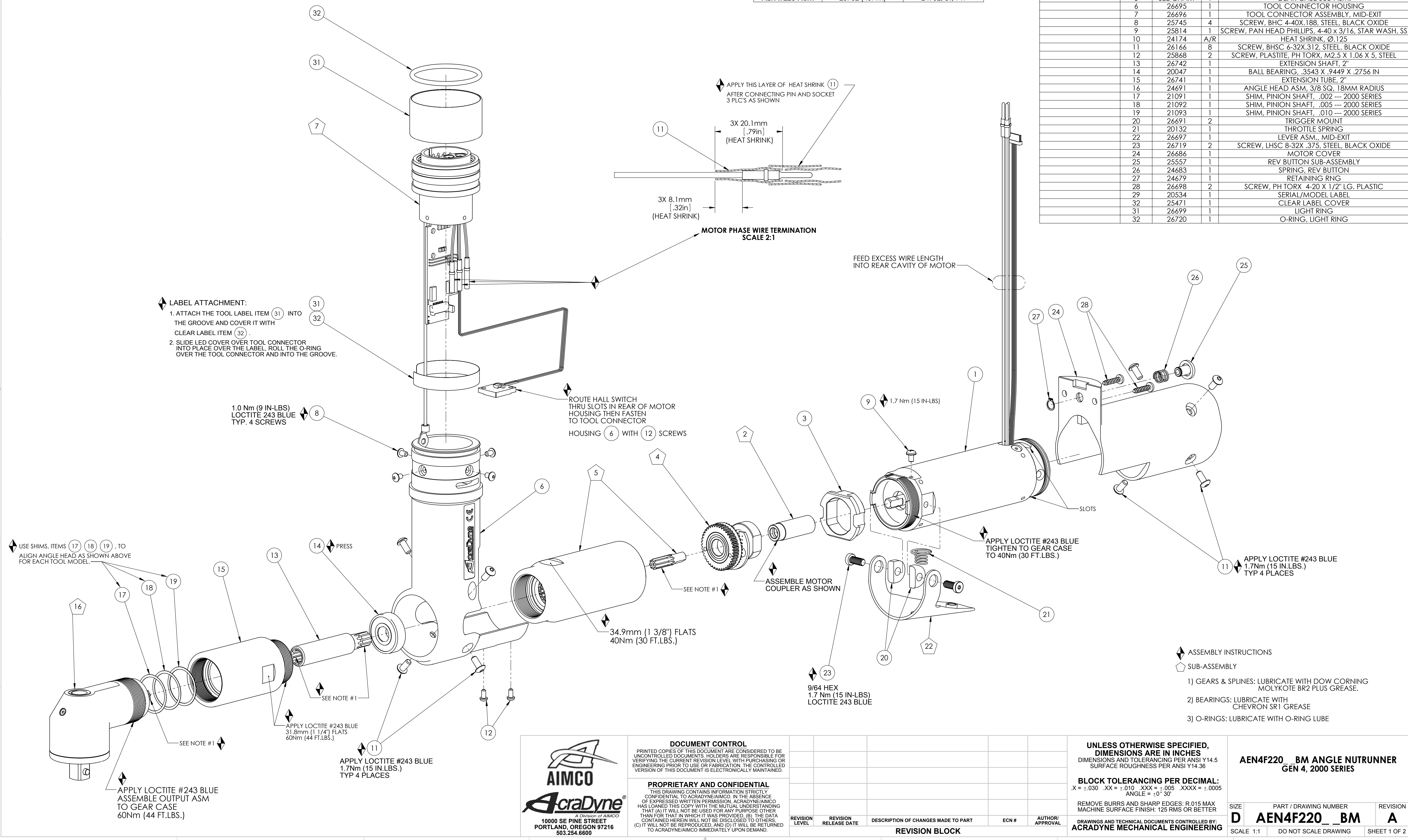


TOOL MODEL	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AEN4F22030BM	25761 (20Nm)	24901, 14T/14T
AEN4F22037BM	25762 (40Nm)	24894, 12T/12T
AEN4F22044BM	25762 (40Nm)	24902, 8T/14T

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	SEE CHART	1	TRANSDUCER SUB-ASM.
	5	SEE CHART	1	GEAR CASE SUB-ASM.
	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, PLASTIC, PH TORX, M2.5 X 1.06 X 5, STEEL
	13	26742	1	EXTENSION SHAFT, 2"
	14	20047	1	BALL BEARING, .3543 X .9449 X .2756 IN
	15	26741	1	EXTENSION TUBE, 2"
	16	24691	1	ANGLE HEAD ASM, 3/8 SQ, 18MM RADIUS
	17	21091	1	SHIM, PINION SHAFT, .002 --- 2000 SERIES
	18	21092	1	SHIM, PINION SHAFT, .005 --- 2000 SERIES
	19	21093	1	SHIM, PINION SHAFT, .010 --- 2000 SERIES
	20	26691	2	TRIGGER MOUNT
	21	20132	1	THRITTLE SPRING
	22	26697	1	LEVER ASM., MID-EXIT
	23	26719	2	SCREW, LHSC 8-32X .375, STEEL, BLACK OXIDE
	24	26686	1	MOTOR COVER
	25	25557	1	REV BUTTON SUB-ASSEMBLY
	26	24683	1	SPRING, REV BUTTON
	27	24679	1	RETAINING RING
	28	26698	2	SCREW, PH TORX 4-20 X 1/2" LG. PLASTIC
	29	20534	1	SERIAL/MODEL LABEL
	30	25471	1	CLEAR LABEL COVER
	31	26699	1	LIGHT RING
	32	26720	1	O-RING, LIGHT RING



LABEL ATTACHMENT:
 1. ATTACH THE TOOL LABEL ITEM (31) INTO THE GROOVE AND COVER IT WITH CLEAR LABEL ITEM (32).
 2. SLIDE LED COVER OVER TOOL CONNECTOR INTO PLACE OVER THE LABEL. ROLL THE O-RING OVER THE TOOL CONNECTOR AND INTO THE GROOVE.

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

FEED EXCESS WIRE LENGTH INTO REAR CAVITY OF MOTOR

APPLY LOCTITE #243 BLUE TIGHTEN TO GEAR CASE TO 40Nm (30 FT.LBS.)

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

- ◆ 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



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

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

AEN4F220__BM ANGLE NUTRUNNER GEN 4, 2000 SERIES		
SIZE	PART / DRAWING NUMBER	REVISION
D	AEN4F220__BM	A
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2