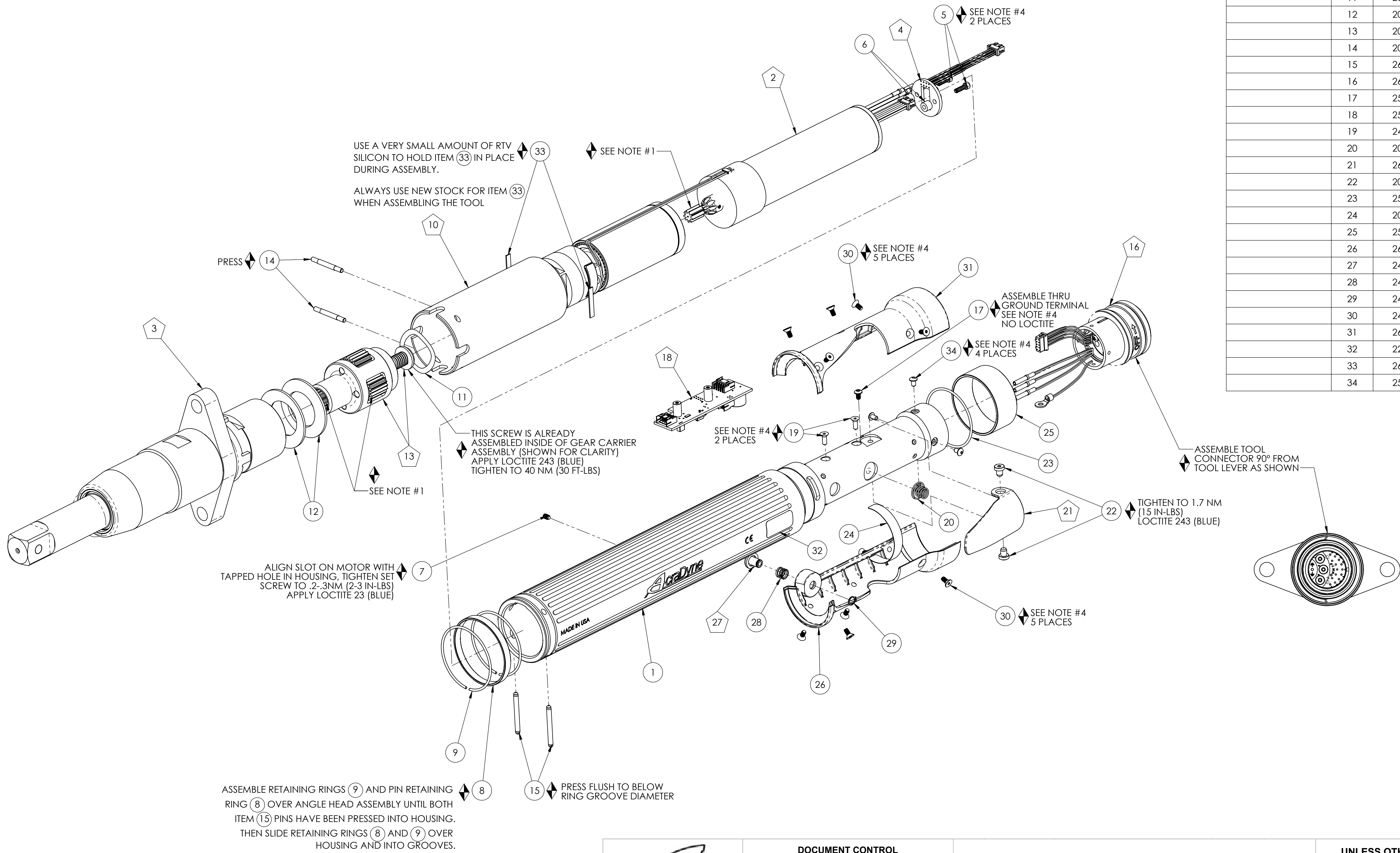


MODEL NO.	MOTOR ASM.	OUTPUT ASM.	GEAR TRAIN ASM.
AES33100C-2	25530	26405	25834
AES33150C-2	25525	27689	25835
AES33230C-2	25525	27689	25836

COMMENTS	ITEM NO.	PART NUMBER	Motor_exploded/QTY.	DESCRIPTION
	1	27031	1	MOTOR HOUSING ASSEMBLY
	2	SEE CHART	1	MOTOR ASSY, 9T, 3000 SERIES
	3	SEE CHART	1	SLIDING OUTPUT SPINDLE ASM
	4	25063	1	LED BOARD ASM.
	5	25075	2	SCREW, SHC 4-40X.375, STEEL, BLACK OXIDE
	6	25430	2	STAND-OFF, LED, 3000 SERIES
	7	27027	1	SCREW, SET 5-40X.188,STEEL,BLK OXIDE
	8	25106	1	PIN RETAINER RING
	9	25107	2	RETAINING RING, PIN RETAINER
	10	SEE CHART	1	GEAR TRAIN ASM.
	11	20912	1	WAVE SPRING --- 3000 SERIES
	12	20911	2	BELLEVILLE WASHER
	13	20924	1	GEAR CARRIER ASSY, THIRD STAGE, 4:1
	14	20913	2	PIN, RETAINING
	15	26793	2	RETAINING PIN, .125 OD X 1-1/4
	16	26102	1	TOOL CONNECTOR ASM., LEVER
	17	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
	18	25847	1	TID BOARD ASM.
	19	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	20	20132	1	THROTTLE SPRING
	21	26532	1	GEN 3 TRIGGER ASSY, CAST
	22	20061	2	SCREW, LEVER
	23	25072	1	O-RING, LED LIGHT RING COVER
	24	20534	1	3000 SERIAL/MODEL LABEL
	25	25058	1	LIGHT RING COVER, LED
	26	26084	1	HANDLE COVER, MFB
	27	24706	1	REV BUTTON SUB-ASSEMBLY
	28	24683	1	SPRING, REV BUTTON
	29	24679	1	RETAINING RNG
	30	24940	10	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	31	26083	1	HANDLE COVER
	32	22141	1	SAFETY LABEL
	33	26184	2	ADAPTER INSERT, GEN 3B 3000 SERIES
	34	25745	4	SCREW, BHSC 4-40 STEEL, BLACK OXIDE



- ◆ 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) TIGHTEN TO 1.0 NM (9 IN-LBS.) USE 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				

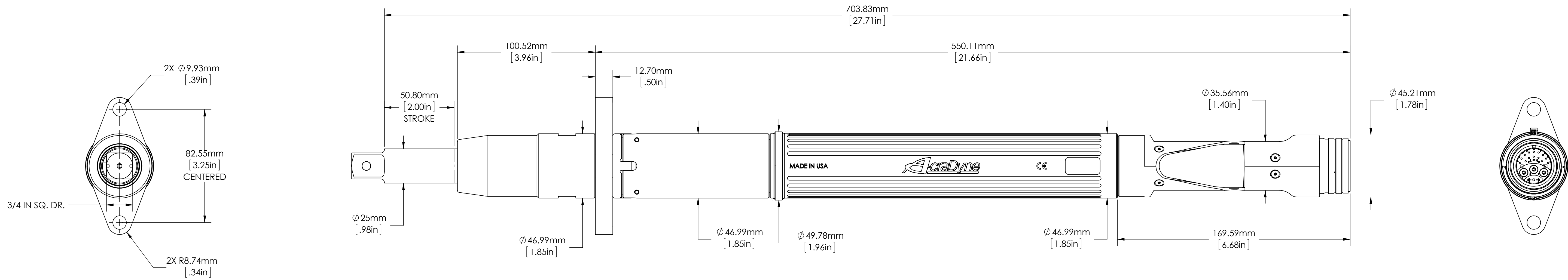
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5
 SURFACE ROUGHNESS PER ANSI Y14.36

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

INLINE TOOL, SLIDING SPINDLE 3000 SERIES, GEN 3C		
SIZE	PART / DRAWING NUMBER	REVISION
D	AES33__C-2	A
SCALE 2:3	DO NOT SCALE DRAWING	SHEET 1 OF 2



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