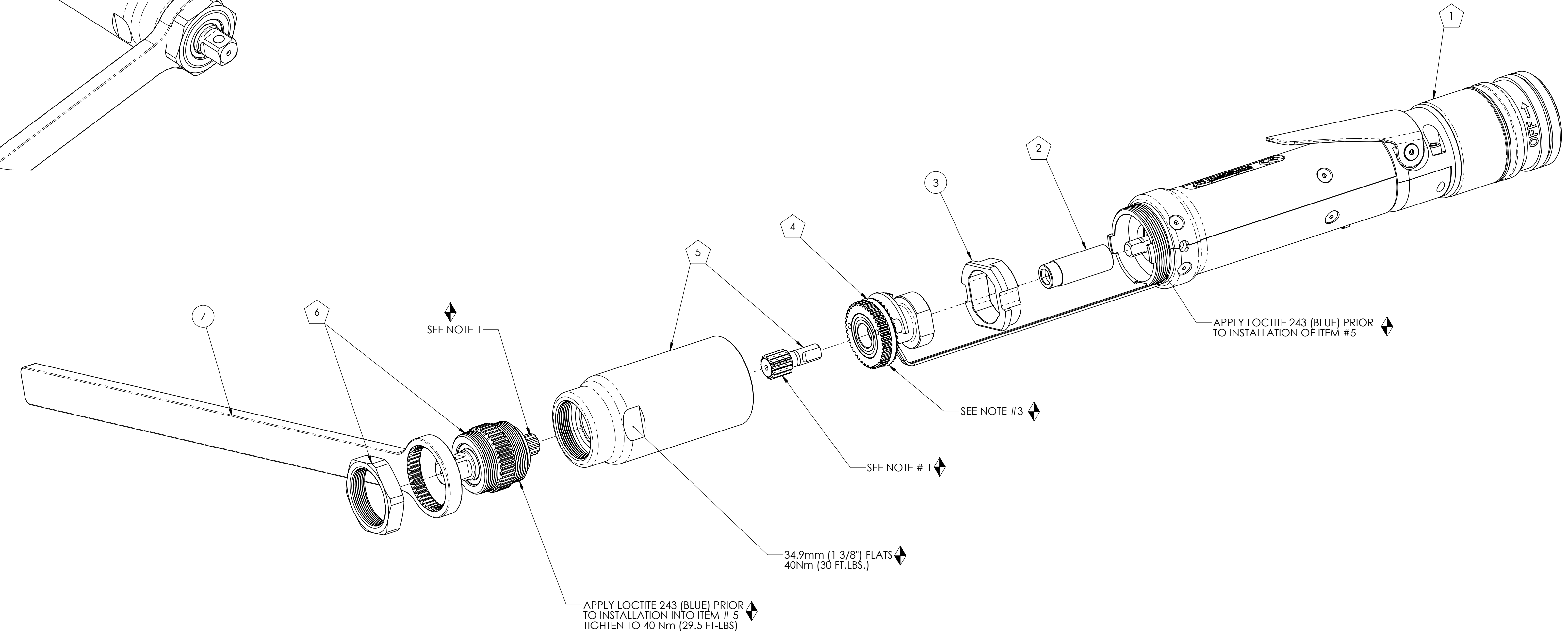


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	24780	1	MOTOR COUPLER SUB-ASM.
	3	25763	1	TRANSDUCER ADAPTOR
	4	SEE CHART	1	TRANSDUCER SUB-ASM.
	5	SEE CHART	1	GEAR CASE SUB-ASM.
	6	24699	1	STRAIGHT OUTPUT ASM., 3/8" SQ. DR.
	7	24696	1	REACTION BAR, ALUMINUM, 1000 SERIES

TOOL MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AES4A12003B	25759.001	24860
AES4A12006B	25760.002	24860
AES4A12011B	25761.003	24709
AES4A12014B	25761.005	24792
AES4A12018B	25761.008	24710
AES4A12022B	25761.010	24781



- ◆ 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

REQUIRED TOOLING
SNAP-ON CROWFOOT WRENCH, 1/2" SQ. DR. X 1-3/8" OPENING SNAP-ON PART NUMBER SC044
MOTOR ASSEMBLY HOLDER - PART NUMBER 25894
LOCTITE #243 BLUE
TORQUE WRENCH, 1/2" DRIVE



**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

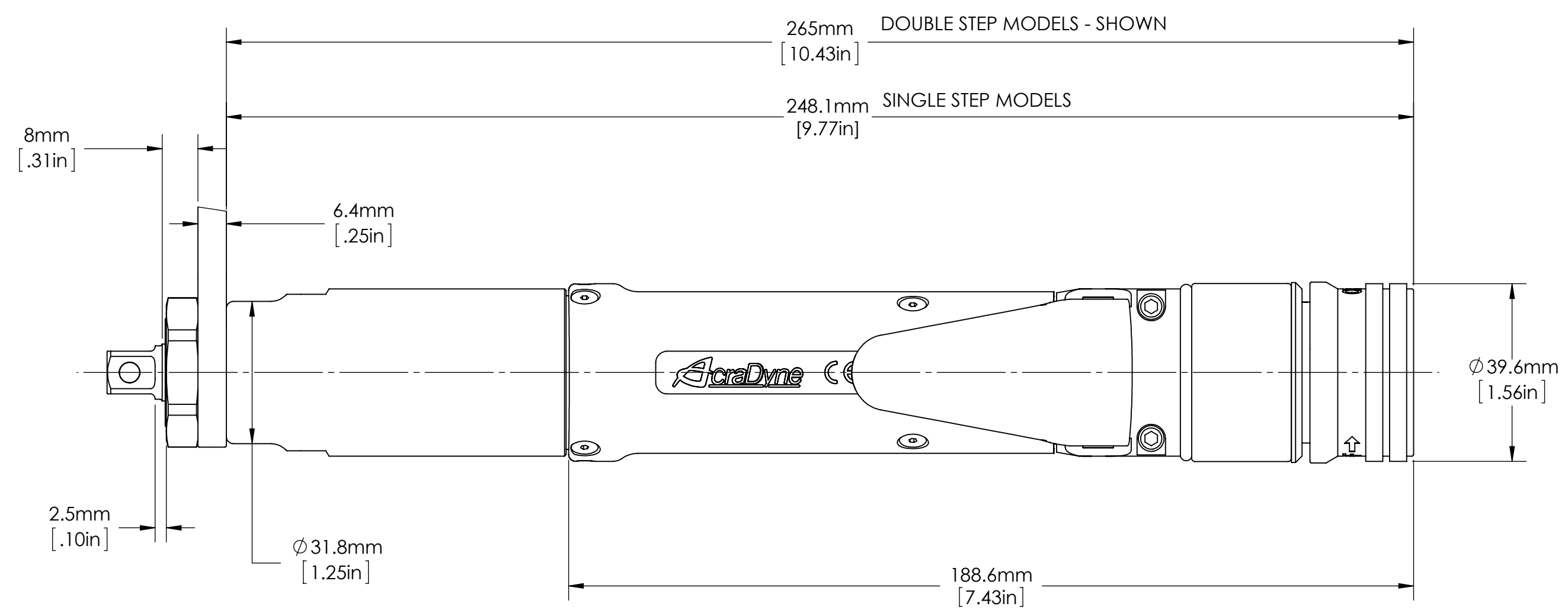
**UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES**  
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5  
 SURFACE ROUGHNESS PER ANSI Y14.36

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

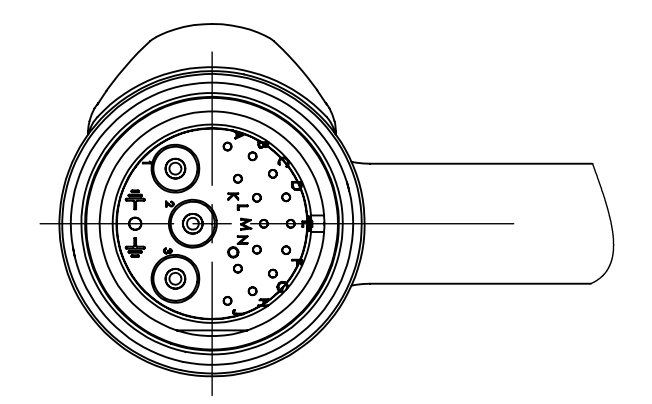
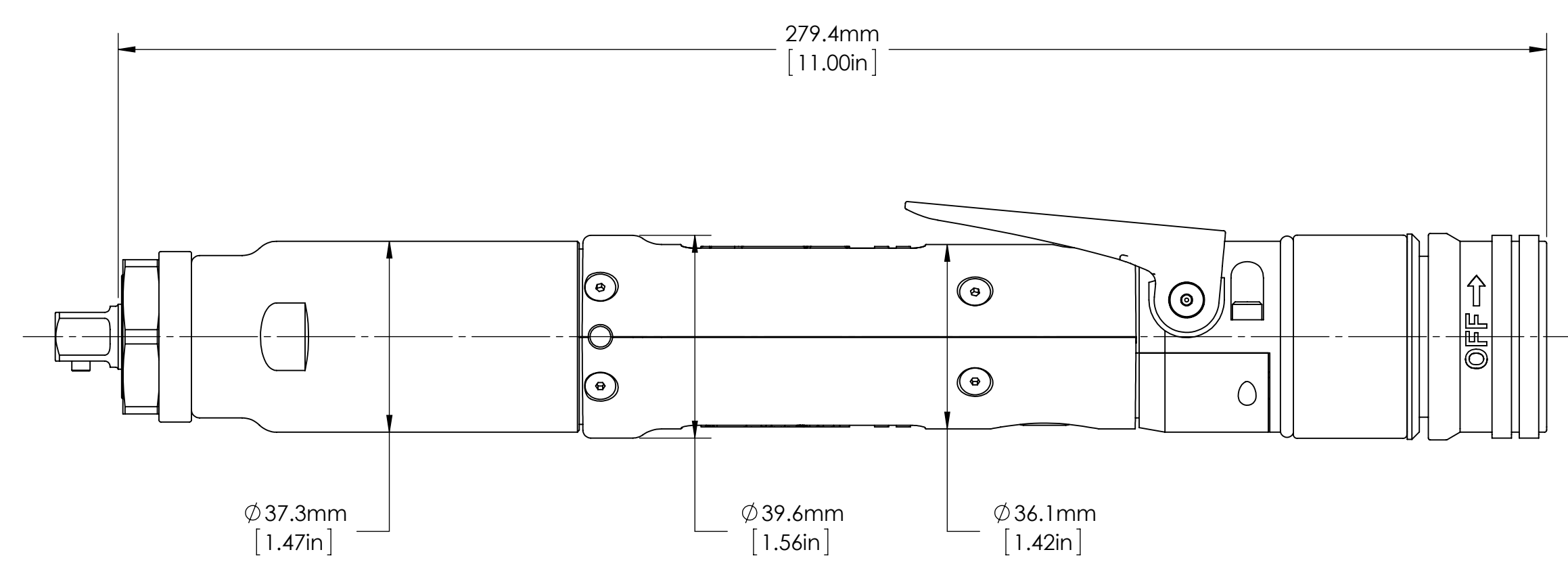
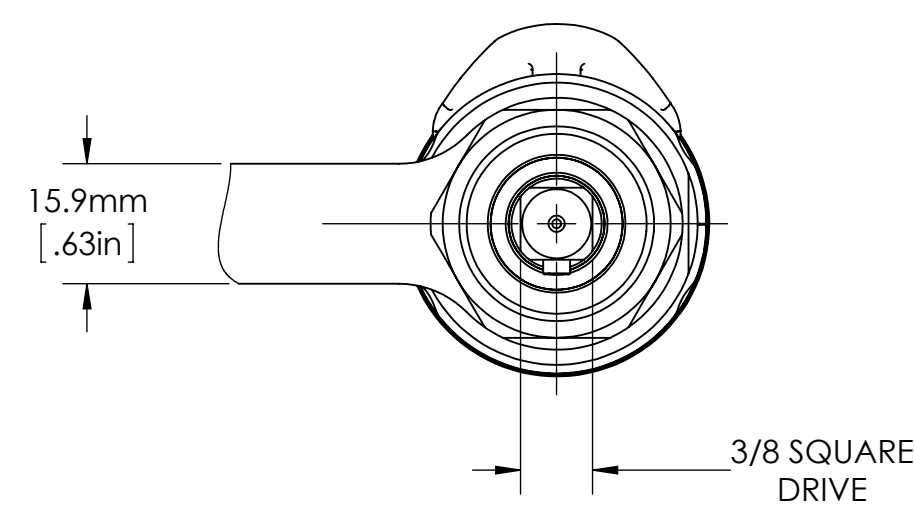
REMOVE BURRS AND SHARP EDGES: R.015 MAX  
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

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

<b>AES4A12__B STRAIGHT NUTRUNNER GEN IV, 1000 SERIES</b>		
SIZE <b>D</b>	PART / DRAWING NUMBER <b>AES4A12__B</b>	REVISION <b>B</b>
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2



	MODEL NO.
SINGLE STEP MODELS	AES4A12003B
	AES4A12006B
	AES4A12011B
DOUBLE STEP MODELS	AES4A12014B
	AES4A12018B
	AES4A12022B



**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**

**AES4A12\_\_B  
STRAIGHT NUTRUNNER  
GEN IV, 1000 SERIES**

SIZE <b>D</b>	PART / DRAWING NUMBER <b>AES4A12__B</b>	REVISION <b>B</b>
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2