

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	27043	1	STRAIGHT OUTPUT ASSY, Q.C.
	7	24696	1	REACTION BAR, ALUMINUM, 1000 SERIES

TOOL MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AES4A12003BQ	25759.001	24860
AES4A12006BQ	25760.002	24860
AES4A12011BQ	25761.003	24709
AES4A12014BQ	25761.005	24792

- ◆ 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

SEE NOTE 1

APPLY LOCTITE 243 (BLUE) PRIOR TO INSTALLATION INTO ITEM # 5
TIGHTEN TO 40 Nm (30 FT-LBS)

SEE NOTE #3

SEE NOTE #1

34.9mm (1 3/8") FLATS
40Nm (30 FT.LBS.)

APPLY LOCTITE 243 (BLUE) PRIOR TO INSTALLATION OF ITEM #5

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



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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'

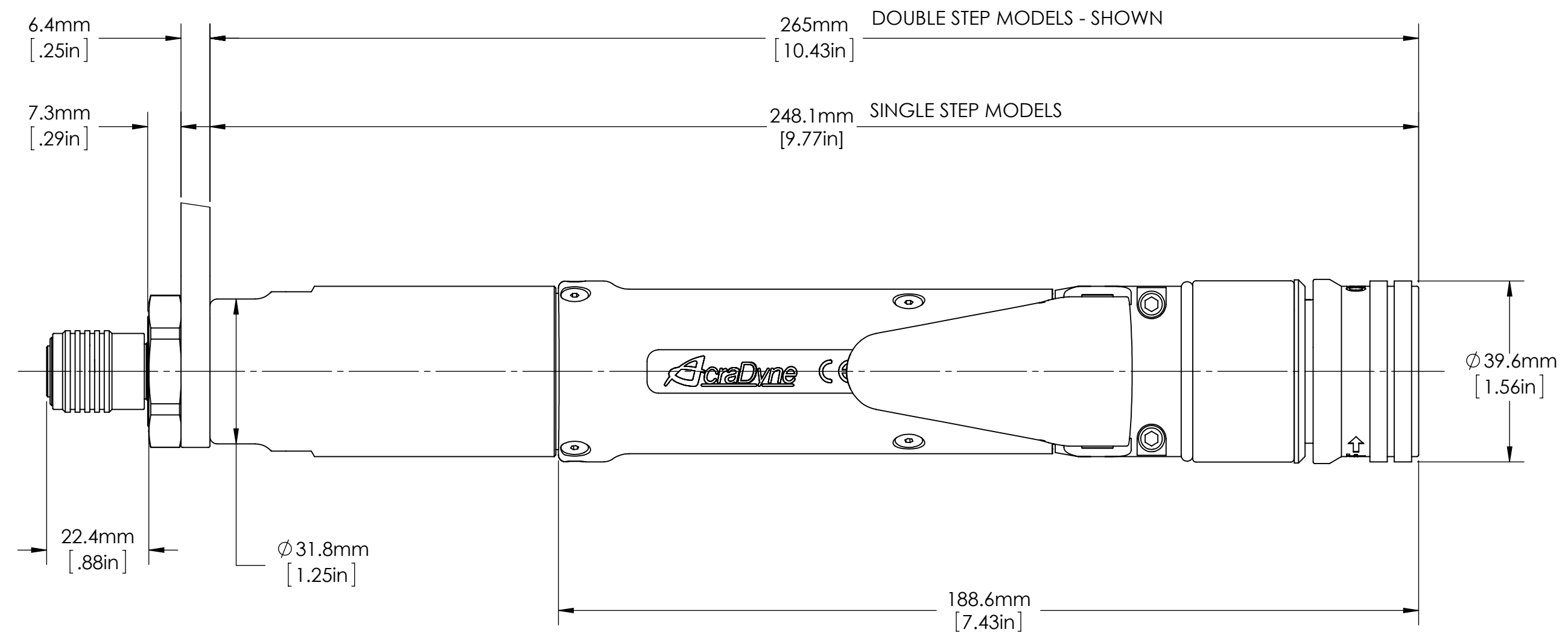
REMOVE BURRS AND SHARP EDGES: R.015 MAX
MACHINE SURFACE FINISH: 125 RMS OR BETTER

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ACRADYNE MECHANICAL ENGINEERING

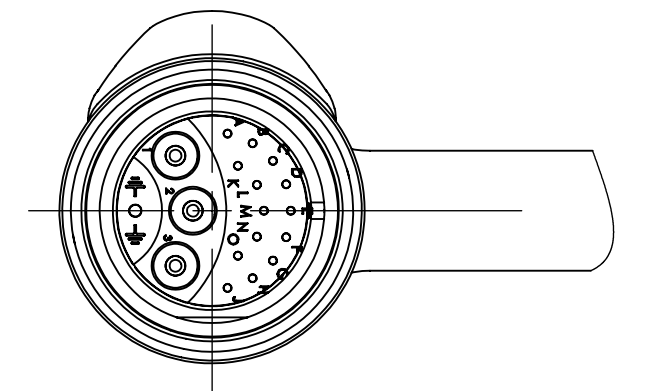
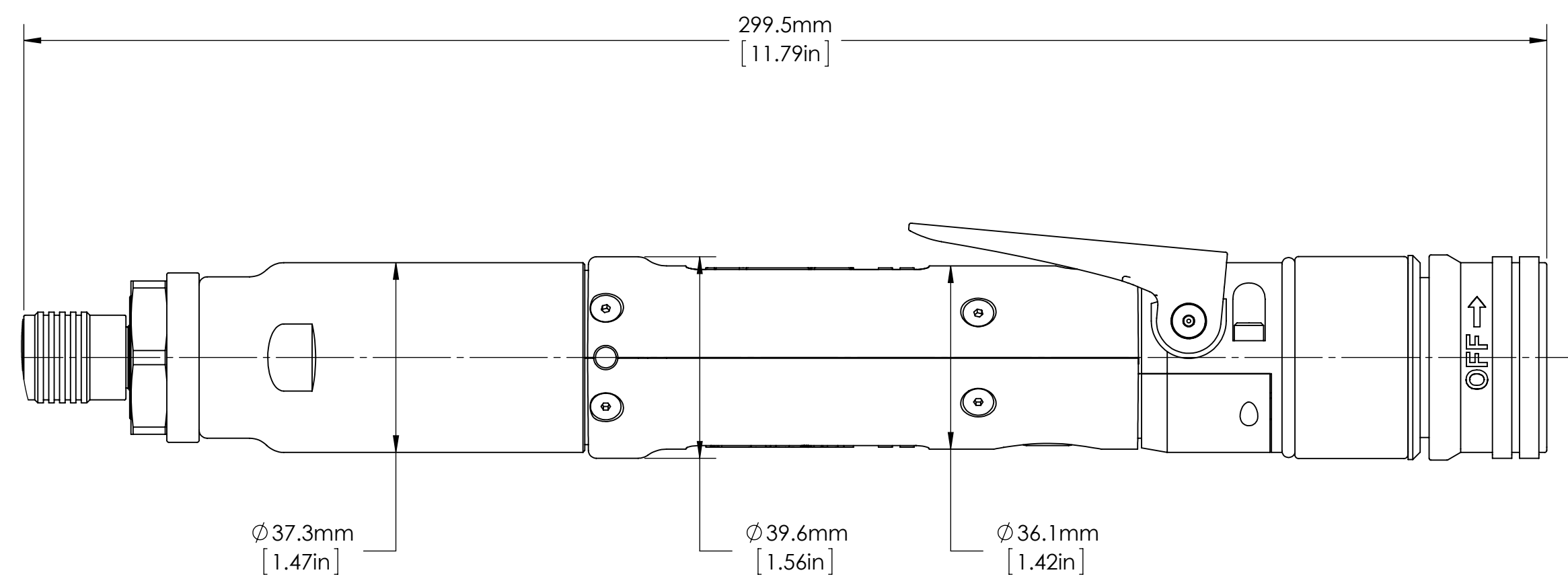
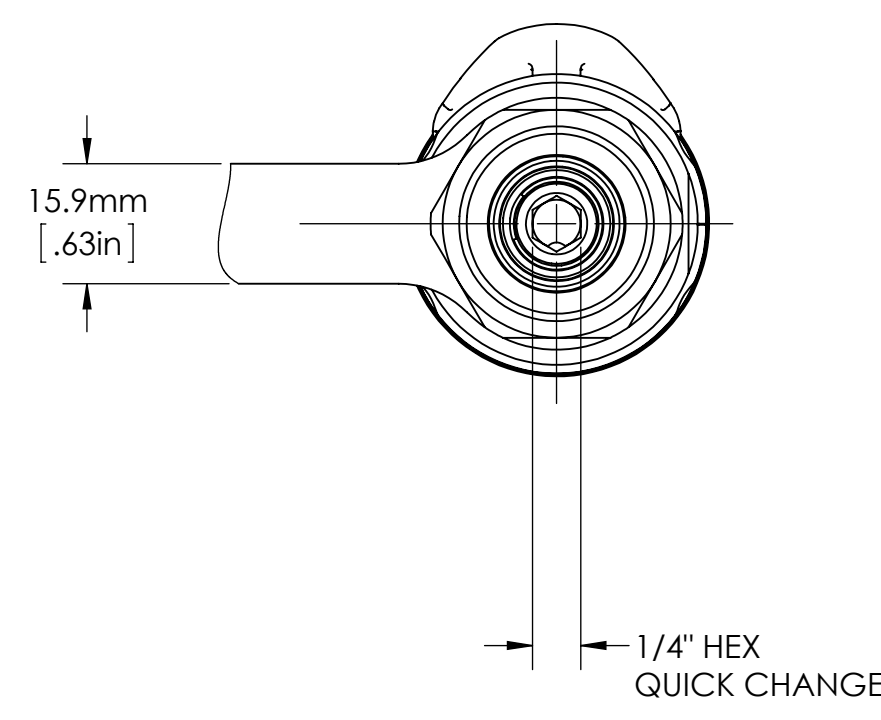
AES4A12__BQ
STRAIGHT NUTRUNNER, Q.C.
GEN IV, 1000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AES4A12__BQ	B

SCALE 1:1 DO NOT SCALE DRAWING SHEET 1 OF 2



	MODEL NO.
SINGLE STEP MODELS	AES4A12003BQ
	AES4A12006BQ
DOUBLE STEP MODELS	AES4A12011BQ
	AES4A12014BQ



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REVISION BLOCK				

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MACHINE SURFACE FINISH: 125 RMS OR BETTER

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ACRADYNE MECHANICAL ENGINEERING

AES4A12011BQ STRAIGHT NUTRUNNER, Q.C. GEN IV, 1000 SERIES		
SIZE D	PART / DRAWING NUMBER AES4A12__BQ	REVISION B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2