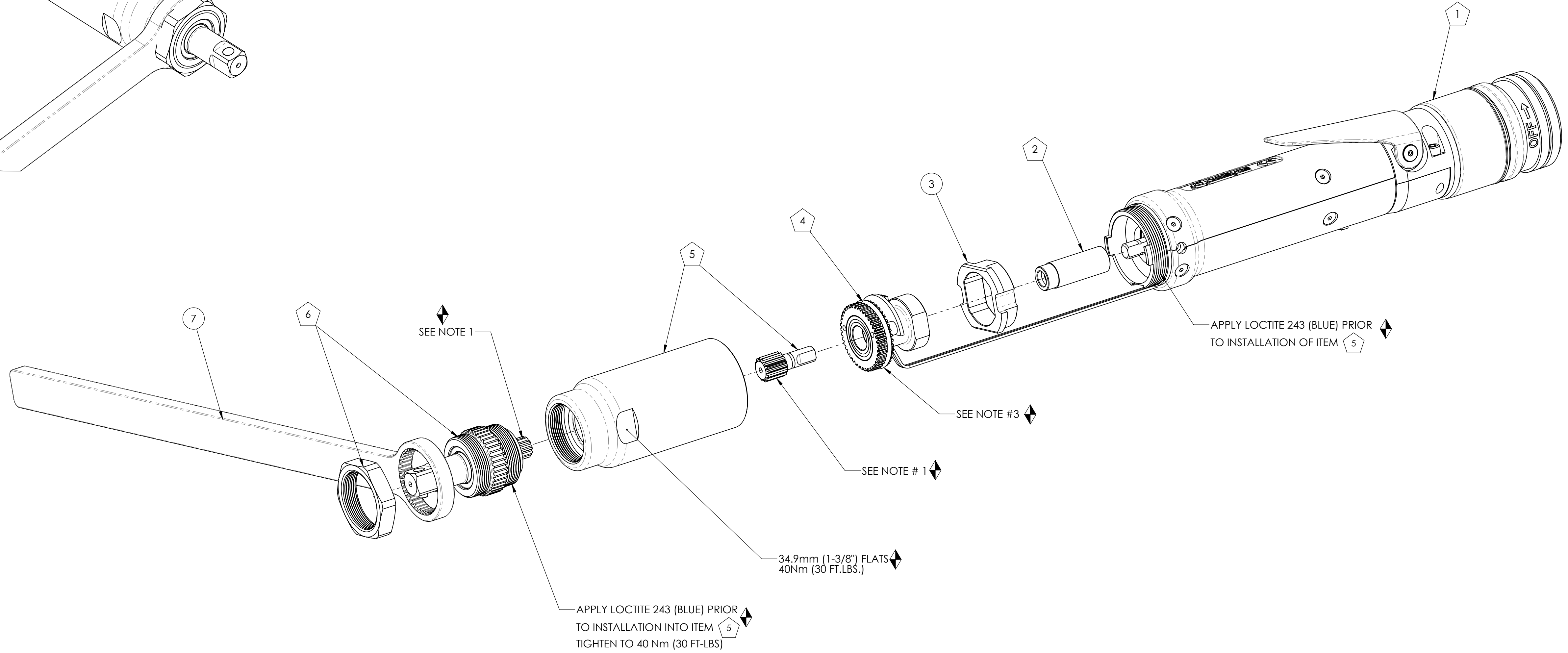


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	24780	1	MOTOR COUPLER SUB-ASM.
	3	25763	1	TRANSDUCER ADAPTOR
	4	SEE CHART	1	TRANSDUCER SUB-ASM.
	5	SEE CHART	1	GEAR CASE SUB-ASM.
	6	25734	1	EXT. STRAIGHT OUTPUT ASM., 3/8" SQ. DR.
	7	24696	1	REACTION BAR, ALUMINUM, 1000 SERIES

TOOL MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AES4A12003BV	25759.001	24860
AES4A12006BV	25760.002	24860
AES4A12011BV	25761.003	24709
AES4A12014BV	25761.005	24792
AES4A12018BV	25761.008	24710
AES4A12022BV	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



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL

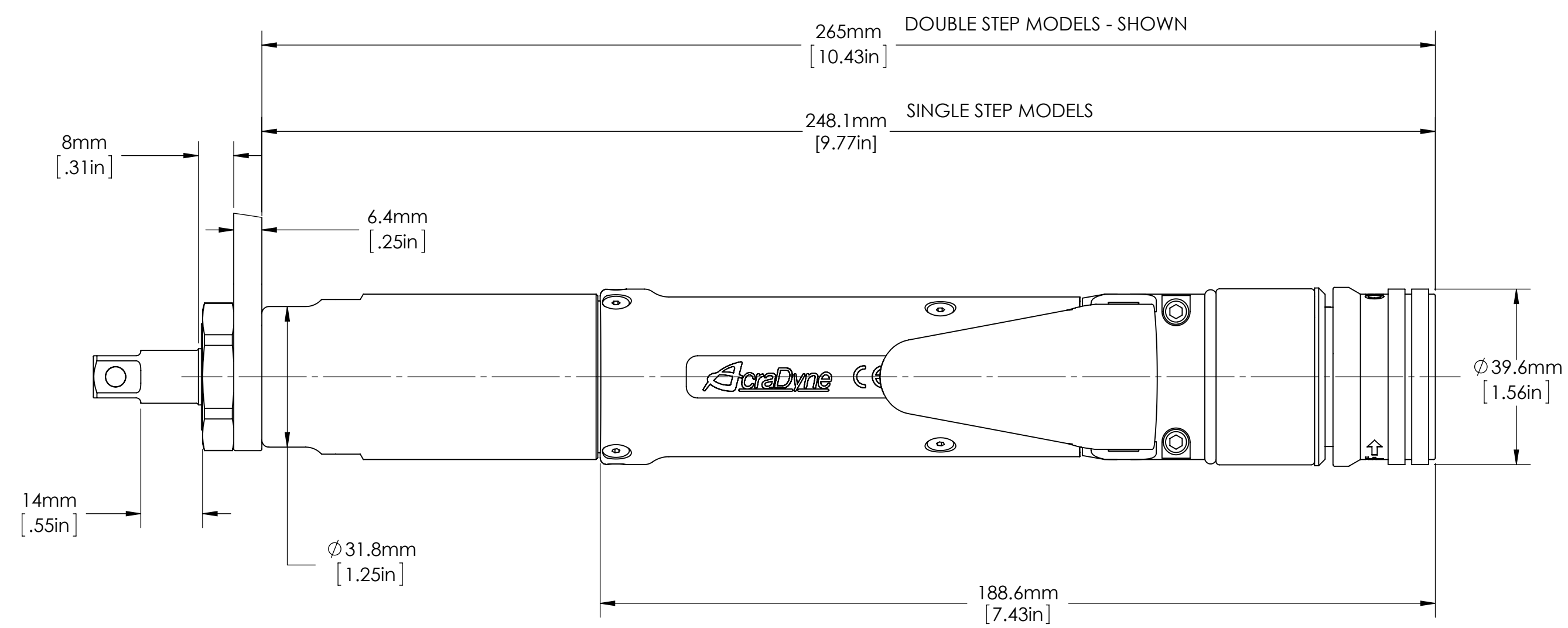
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5
 SURFACE ROUGHNESS PER ANSI Y14.36

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

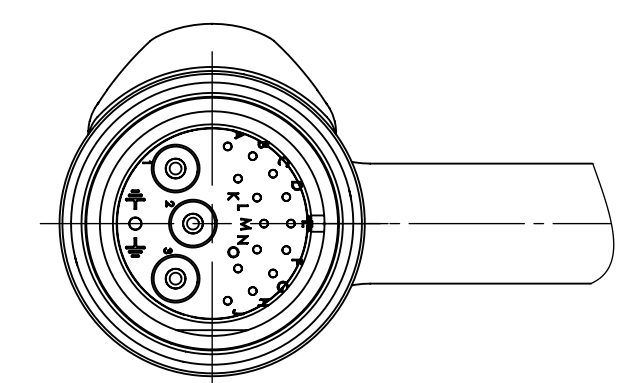
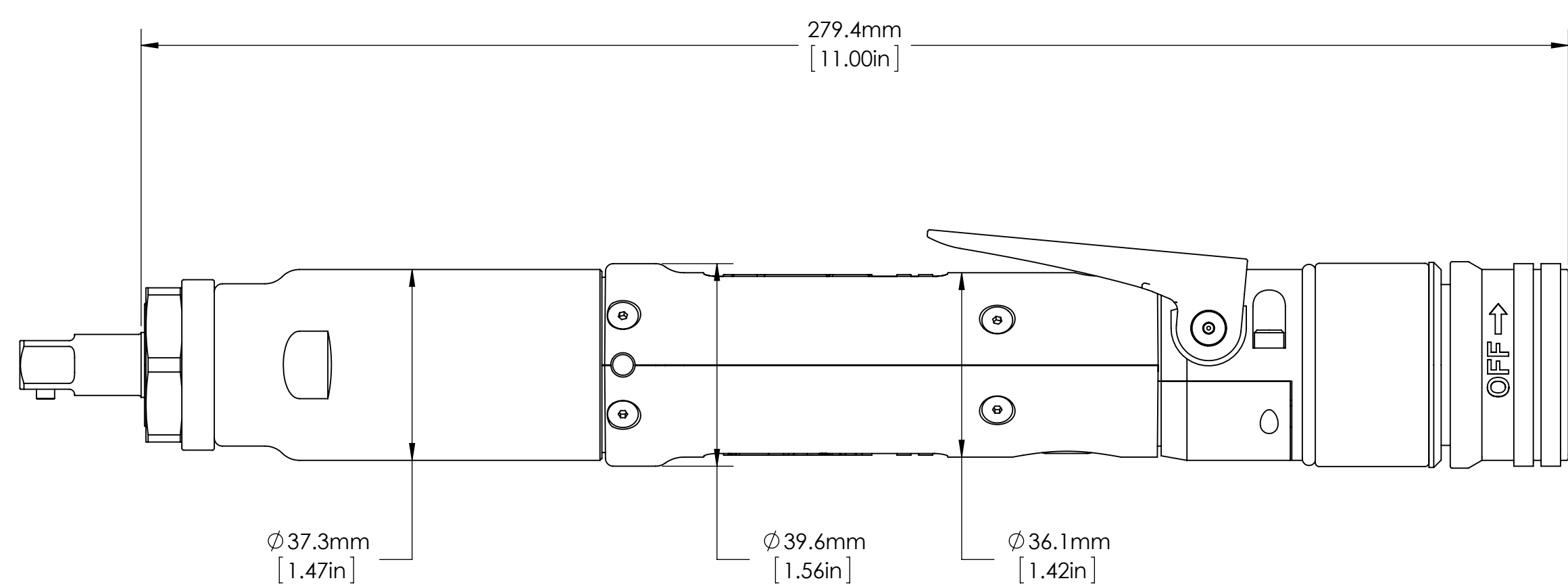
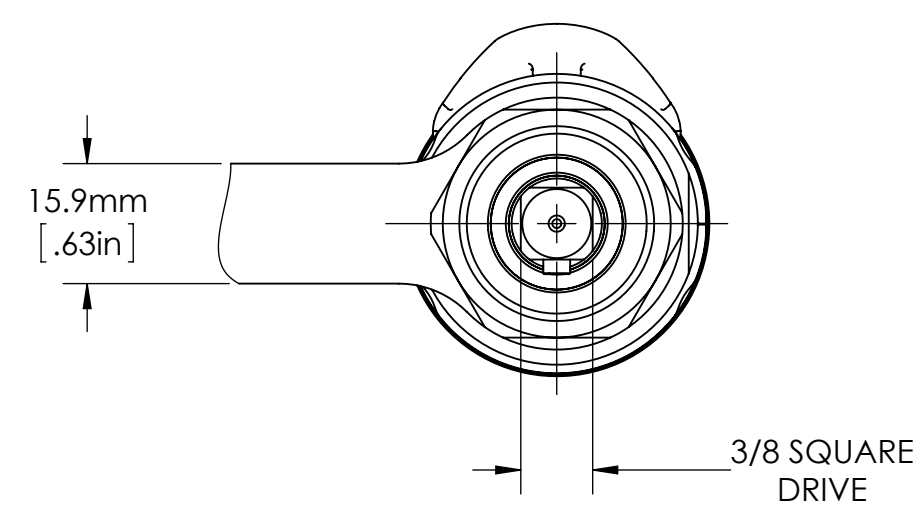
REMOVE BURRS AND SHARP EDGES: R.015 MAX
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AES4A12__BV STRAIGHT NUTRUNNER GEN IV, 1000 SERIES		
SIZE D	PART / DRAWING NUMBER AES4A12__BV	REVISION B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2



	MODEL NO.
SINGLE STEP MODELS	AES4A12003BV
	AES4A12006BV
DOUBLE STEP MODELS	AES4A12011BV
	AES4A12014BV
	AES4A12018BV
	AES4A12022BV



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL

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ACRADYNE MECHANICAL ENGINEERING

AES4A12__BV
STRAIGHT NUTRUNNER
 GEN IV, 1000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AES4A12__BV	B

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