

TOOL MODEL	GEAR CASE SUB-ASM.	TRANSDUCER SUB-ASM.
AES4A22020CR	24709	31048.005
AES4A22030CR	24710	31045.004
AES4A22040CR	24781	31045.006

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	28766	1	MOTOR ASSEMBLY
	2	SEE CHART	1	GEAR CASE SUB-ASM.
	3	27023	1	SPRING, RIV-NUT SHAFT
	3	27026	1	ADAPTOR ASM., RIV-NUT
	5	28754	1	LEVER HANDLE
	6	29186	1	COVER, LEVER HANDLE
	7	25763	1	TRANSDUCER ADAPTOR
	8	24780	1	MOTOR COUPLER SUB-ASM.
	9	SEE CHART	1	TRANSDUCER SUB-ASM.
	10	29202	1	TRIGGER CABLE ASM., 6 PIN - 6 PIN
	11	29191	1	TRIGGER/MFG BOARD ASM., 2000-SERIES, GEN 4
	12	28767	1	TOOL CONN. ASM.
	13	30966	1	LED BOARD ASM, i2C
	14	24679	1	RETAINING RNG
	15	24683	1	SPRING, REV BUTTON
	16	25557	1	REV BUTTON SUB-ASSEMBLY
	17	29189	1	TRIGGER SUB-ASM.
	18	28760	1	LED COVER
	19	28753	2	MOTOR COVER, SMALL MOTOR O.D.
	20	20534	1	2000 SERIAL/MODEL LABEL
	21	22141	1	SAFETY LABEL
	22	20132	1	THROTTLE SPRING
	23	31051	1	DOWEL PIN, Ø.094 X .75, GROOVED, STEEL, ZINC PLATED
	24	31061	2	DOWEL PIN, Ø3/32 X 1/4, STEEL
	25	23753	8	SCREW, FHSC 6-32x5/16, 18-8 SS
	26	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	27	26078	4	SCREW, SHC 4-40 X 5/16, BLK OXIDE
	28	27235	2	O-RING, BUNA-N, #28
	29	24935	2	SCREW, SHC 4-40 X .25, STEEL, BLACK OXIDE
	30	23741	1	SHIM, OUTPUT, .002 IN, 40 NM
	31	21022	1	SHIM, BLANK OUTPUT SHAFT, 0.005 THK
	32	21021	1	SHIM, BLANK OUTPUT SHAFT, 0.010 THK
	NOT SHOWN	28257	A/R	CABLE TIE, 1.65mm X 71mm
	NOT SHOWN	25471	1	LABEL, SN# COVER, .25 X 4"
	CHOOSE THREAD SIZE	35	SEE SHEET #3	NOSE PIECE ASM., RIV-NUT

- ◆ 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.) LOCTITE 222 (PURPLE)



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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

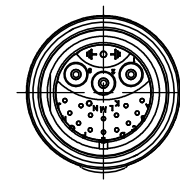
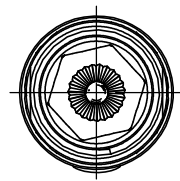
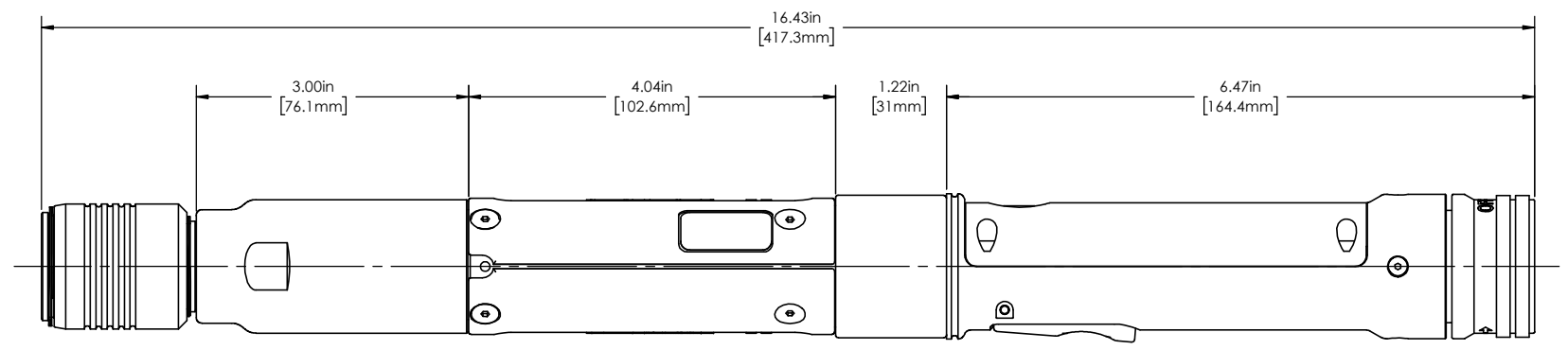
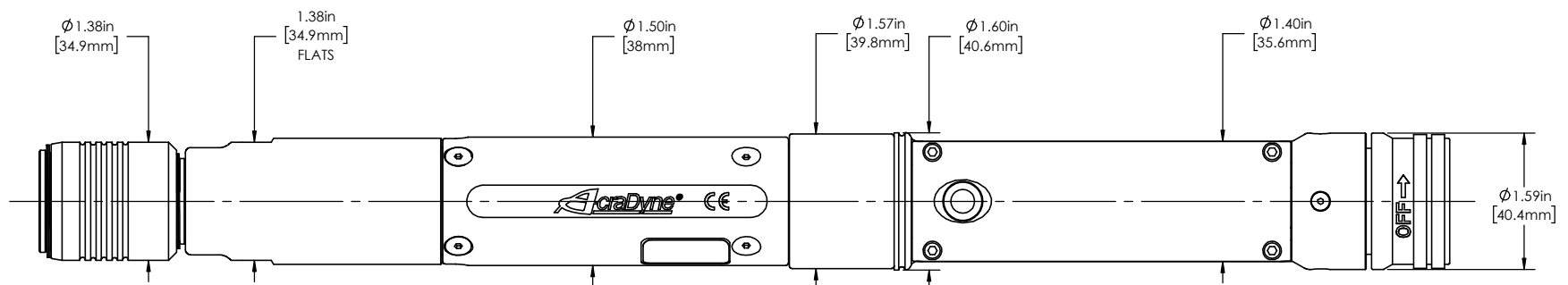
BLOCK TOLERANCING PER DECIMAL:
 X = ±.030 XX = ±.010 XXX = ±.005 .XXXX = ±.0005
 ANGLE = ±.30°

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

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ACRADYNE MECHANICAL ENGINEERING

**INLINE NUTRUNNER
RIV-NUT
GEN 4 2000 SERIES**

SIZE D	PART / DRAWING NUMBER AES4A220 CR	REVISION A
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 3



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INLINE NUTRUNNER RIV-NUT GEN 4 2000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AES4A220 CR	A

SCALE 1:1 DO NOT SCALE DRAWING SHEET 2 OF 3

D

C

B

A

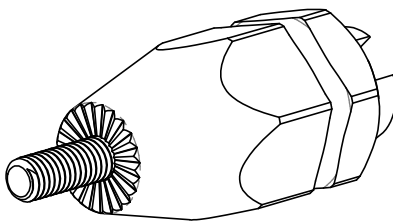
D

C

B

A

SIZE CODE CHART			
METRIC		INCH	
THREAD SIZE	NOSE PIECE ASM.	THREAD SIZE	NOSE PIECE ASM.
M4 x 0.7mm	27051	8-32 UNC	27055
M5 x 0.8mm	27034	10-24 UNC	27056
M6 x 1.0mm	27052	10-32 UNF	27057
M8 x 1.25mm	27053	1/4-20 UNC	27058
M10 x 1.5mm	27054	5/16-18 UNC	27059
		3/8-16 UNC	27060



10000 SE PINE STREET
 PORTLAND, OREGON 97216
 503.254.6600

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REVISION BLOCK

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SIZE	PART / DRAWING NUMBER	REVISION
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SCALE 1:1	DO NOT SCALE DRAWING	SHEET 3 OF 3