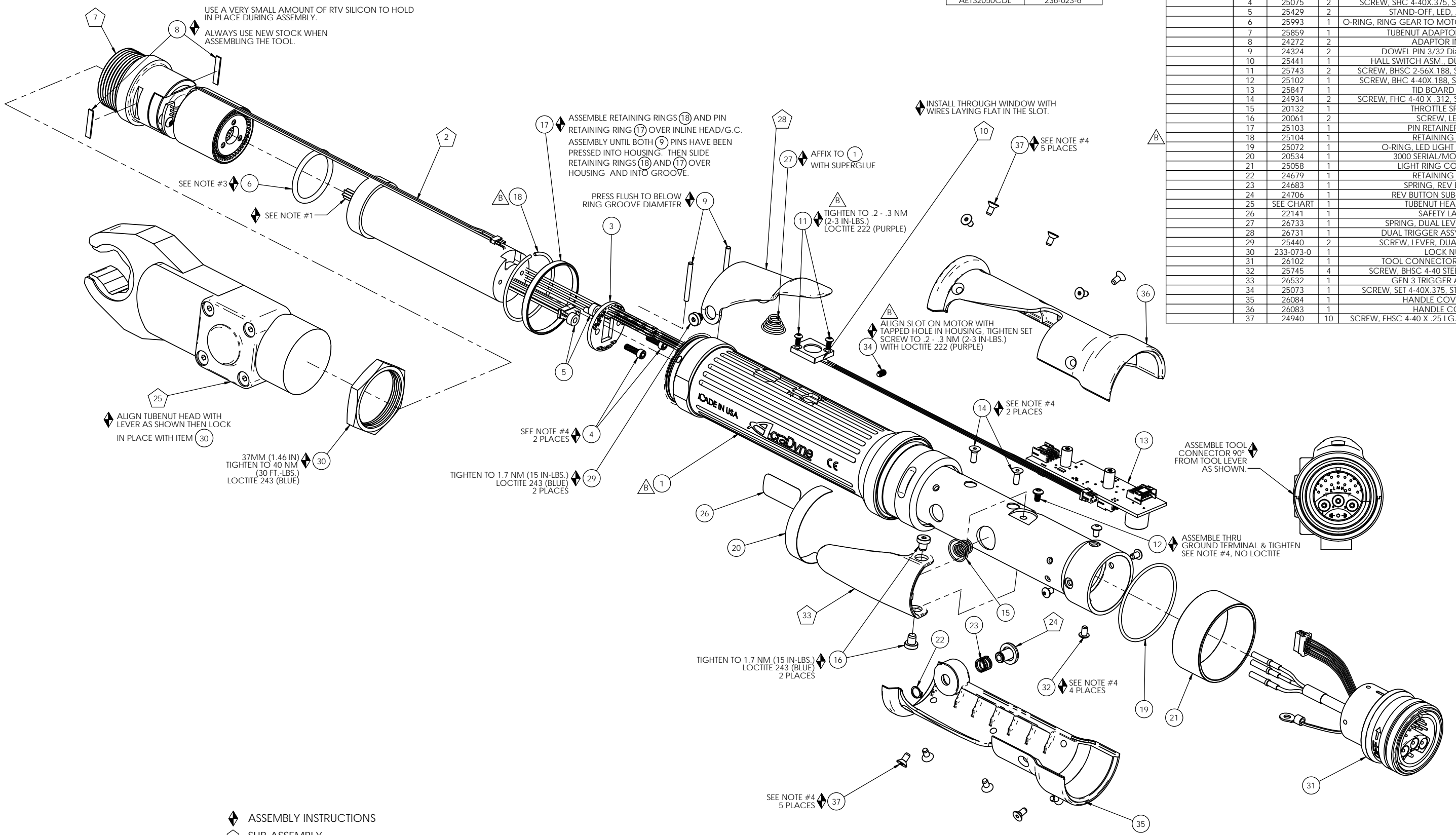


MODEL NUMBER	TUBENUT HEAD ASM
AET32020CDL	235-023-0
AET32025CDL	235-023-4
AET32035CDL	236-023-0
AET32050CDL	236-023-6

ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
1	27624	1	HOUSING MOTOR/HANDLE, DUAL LEVER, 2000-SERIES, GEN 3C
2	25425	1	MOTOR ASM.
3	25063	1	LED BOARD ASM.
4	25075	2	SCREW, SHC 4-40X.375, STEEL, BLACK OXIDE
5	25429	2	STAND-OFF, LED, 2000 SERIES
6	25993	1	O-RING, RING GEAR TO MOTOR, GEN 3B 2000 SERIES
7	25859	1	TUBENUT ADAPTOR ASSEMBLY
8	24272	2	ADAPTOR INSERT
9	24324	2	DOWEL PIN 3/32 Dia x 7/8 LONG
10	25441	1	HALL SWITCH ASM., DUAL LEVER TOOL
11	25743	2	SCREW, BHSC 2-56X.188, STEEL, BLACK OXIDE
12	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
13	25847	1	TID BOARD ASM.
14	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
15	20132	1	THROTTLE SPRING
16	20061	2	SCREW, LEVER
17	25103	1	PIN RETAINER RING
18	25104	1	RETAINING RING
19	25072	1	O-RING, LED LIGHT RING COVER
20	20534	1	3000 SERIAL/MODEL LABEL
21	25058	1	LIGHT RING COVER, LED
22	24679	1	RETAINING RING
23	24683	1	SPRING, REV BUTTON
24	24706	1	REV BUTTON SUB-ASSEMBLY
25	SEE CHART	1	TUBENUT HEAD ASM.
26	22141	1	SAFETY LABEL
27	26733	1	SPRING, DUAL LEVER, TAPERED
28	26731	1	DUAL TRIGGER ASSY, 2000 SERIES
29	25440	2	SCREW, LEVER, DUAL LEVER TOOL
30	233-073-0	1	LOCK NUT
31	26102	1	TOOL CONNECTOR ASM., LEVER
32	25745	4	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
33	26532	1	GEN 3 TRIGGER ASSY, CAST
34	25073	1	SCREW, SET 4-40X.375, STEEL, BLACK OXIDE
35	26084	1	HANDLE COVER, MFB
36	26083	1	HANDLE COVER
37	24940	10	SCREW, FHSC 4-40 X .25 LG., 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) LOCTITE 222 (PURPLE)

REQUIRED TOOLING
LOCTITE 243 (BLUE)
FLAT BLADE SCREW DRIVER
TORQUE SCREW DRIVERS
.050 HEX BIT
1/16 HEX BIT
5/64 HEX BIT
3/32 HEX BIT
SNAP RING PLIERS - EXTERNAL TYPE
37mm OPEN END CROWFOOT



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REVISION LEVEL	REVISION RELEASE DATE	DESCRIPTION OF CHANGES MADE TO PART	ECN #	AUTHOR/ APPROVAL
B	03/31/16	RETAINING RING 25104 QTY: 1 WAS QTY: 2. MOTOR HOUSING 27624 GEOMETRY UPDATED. LOCTITE 222(PURPLE) WAS LOCTITE 243 (BLUE).	1839	T BURNETT
A	12/18/13	PRODUCTION RELEASE	1062	T BURNETT

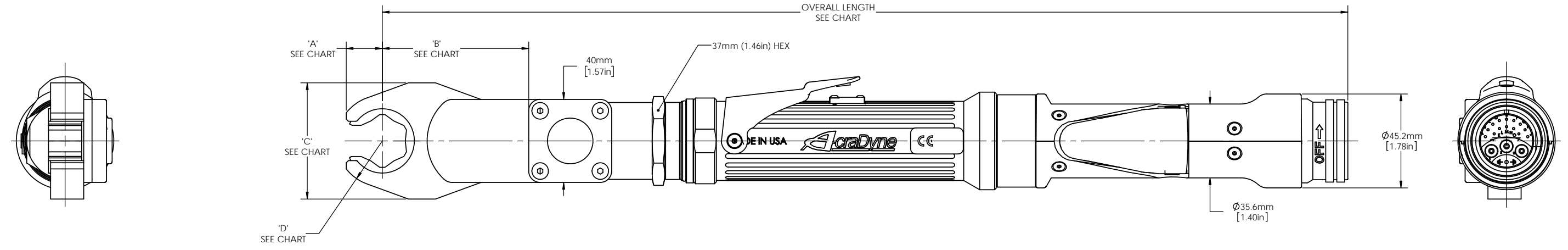
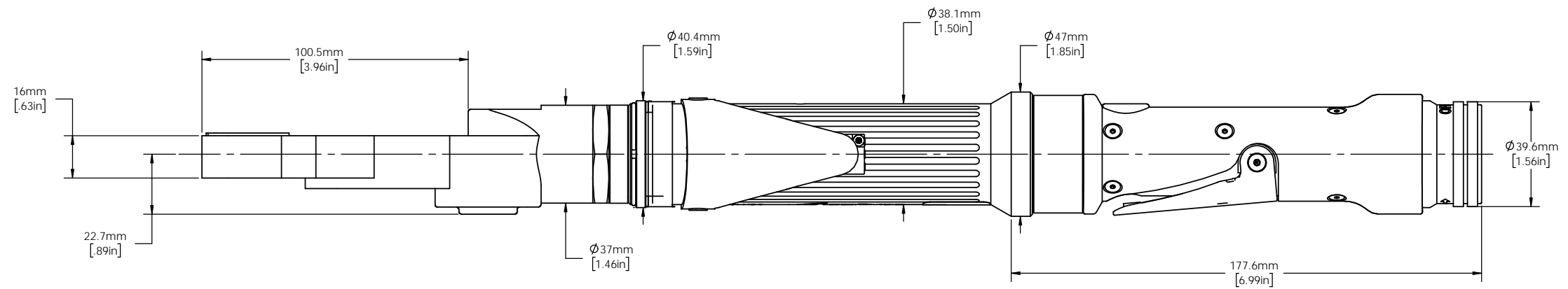
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36

BLOCK TOLERANCING PER DECIMAL:
 .X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005 ANGLE = 90°/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

AET320_CD 2000 SERIES, GEN 3C, DUAL LEVER		
SIZE D	PART / DRAWING NUMBER AET320_CD	REVISION B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2



MODEL NUMBER	OVERALL LENGTH	'A'	'B'	'C'	'D'
AET32020CDL	441mm, [17.38in]	10mm, [.41in]	46mm, [1.83in]	37mm, [1.46in]	14mm, [.55in]
AET32025CDL	456mm, [17.95in]	13mm, [.52in]	61mm, [2.40in]	40mm, [1.56in]	17mm, [.67in]
AET32035CDL	466mm, [18.33in]	17mm, [.68in]	71mm, [2.78in]	56mm, [2.20in]	22mm, [.87in]
AET32050CDL	483mm, [19.02in]	22mm, [.88in]	88mm, [3.45in]	68mm, [2.68in]	29mm, [1.14in]



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 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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AET320_CD 2000 SERIES, GEN 3C, DUAL LEVER		
SIZE	PART / DRAWING NUMBER	REVISION
D	AET320_CD	B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2