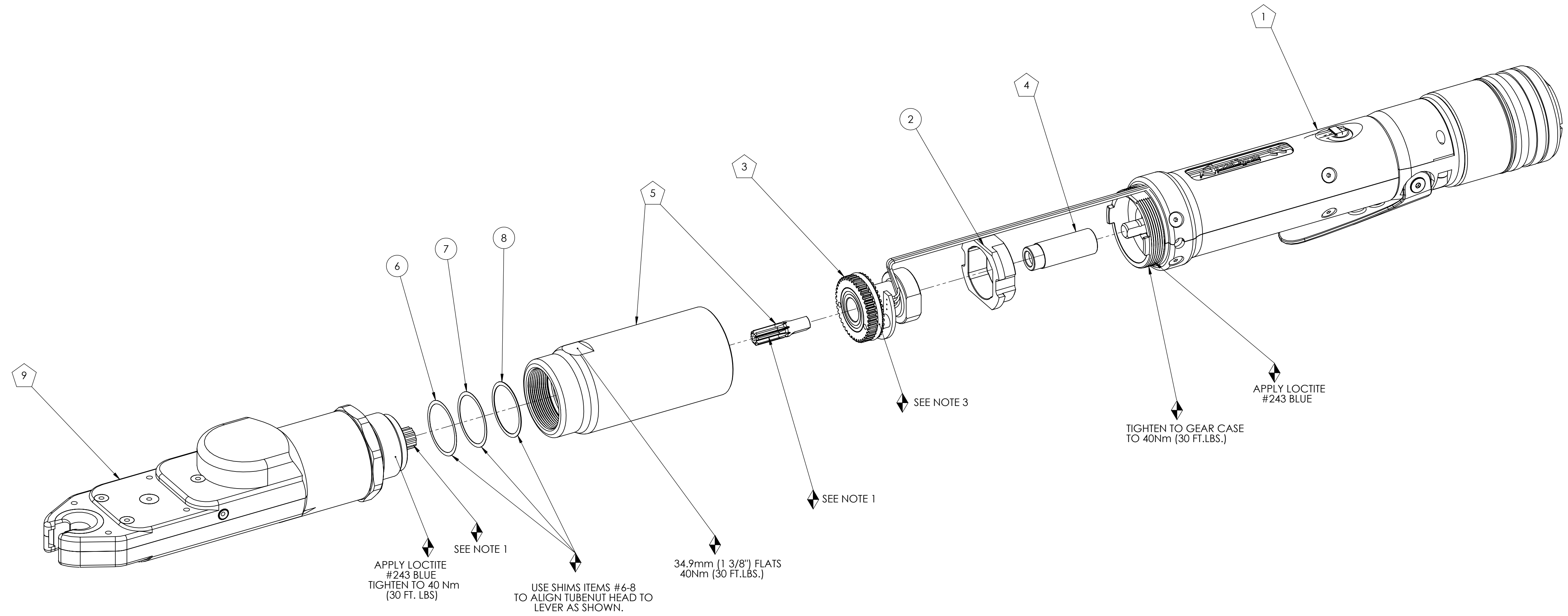
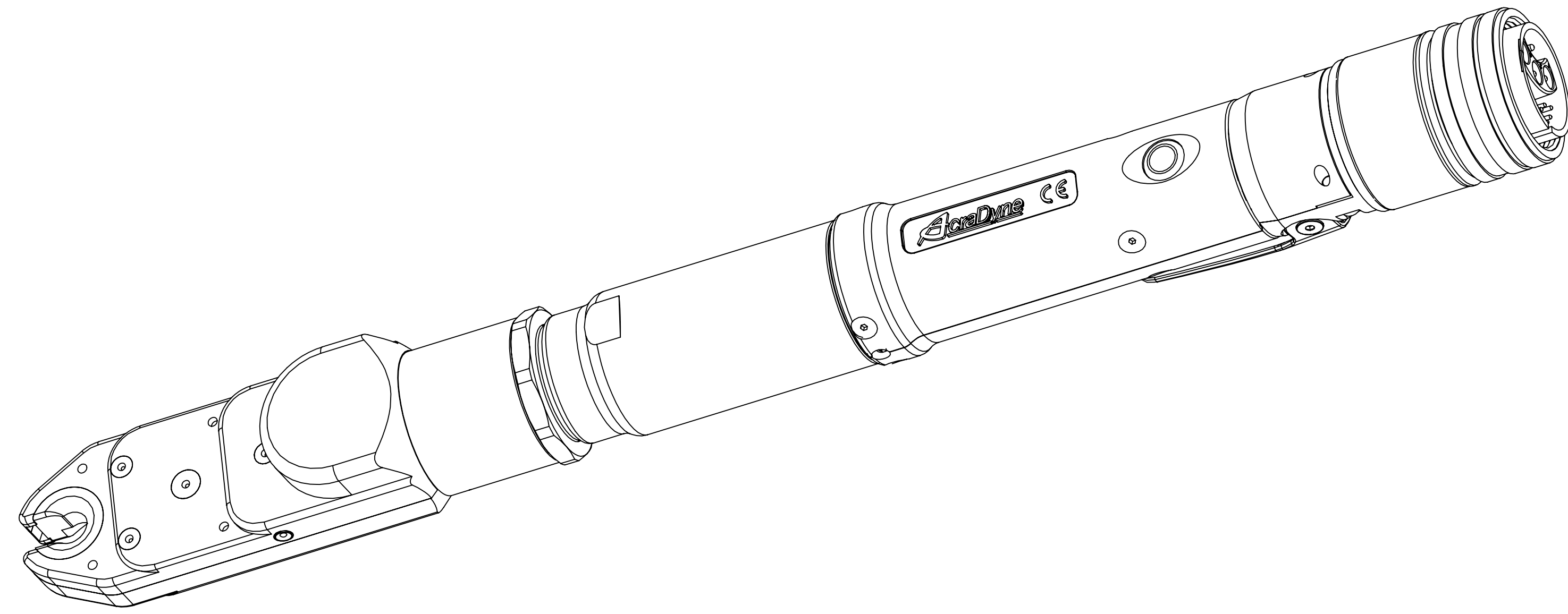


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	25763	1	TRANSDUCER ADAPTOR
	3	25761	1	TRANSDUCER SUB-ASM., 20Nm
	4	24780	1	MOTOR COUPLER SUB-ASM.
	5	24902	1	GEAR CASE SUB-ASM, 8T/14T
	6	21091	1	SHIM, PINION SHAFT, .002 --- 2000 SERIES
	7	21092	1	SHIM, PINION SHAFT, .005 --- 2000 SERIES
	8	21093	1	SHIM, PINION SHAFT, .010 --- 2000 SERIES
	9	S-2112	1	TUBENUT HEAD ASM.



- ◆ 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 1355
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
A	07/08/13	PRODUCTION RELEASE	963	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 = ±0° 30'

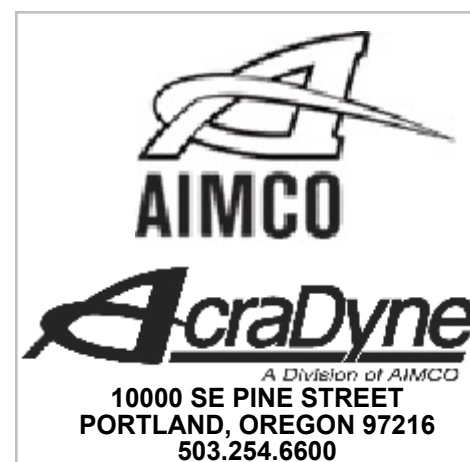
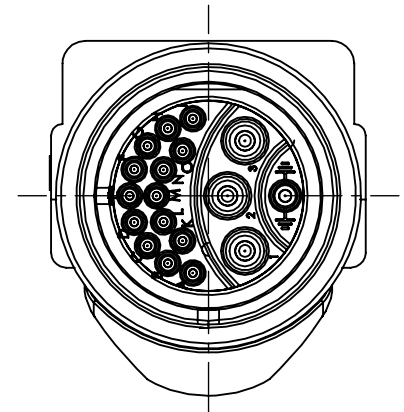
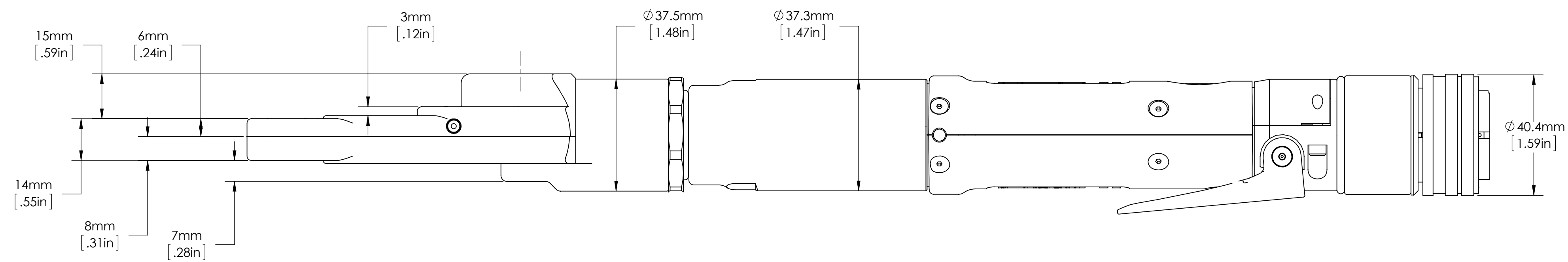
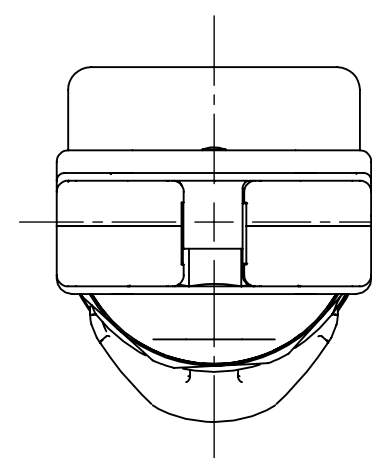
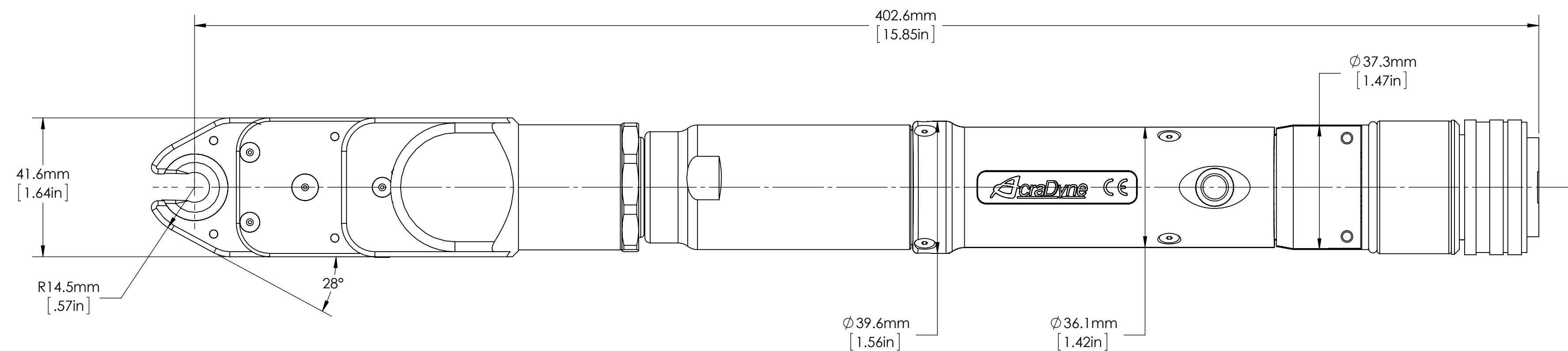
REMOVE BURRS AND SHARP EDGES: R.015 MAX  
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

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

**AET4A12025B-KD TUBENUT NUTRUNNER GEN IV, 1000 SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
D	<b>AET4A12025B-KD</b>	<b>A</b>

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



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