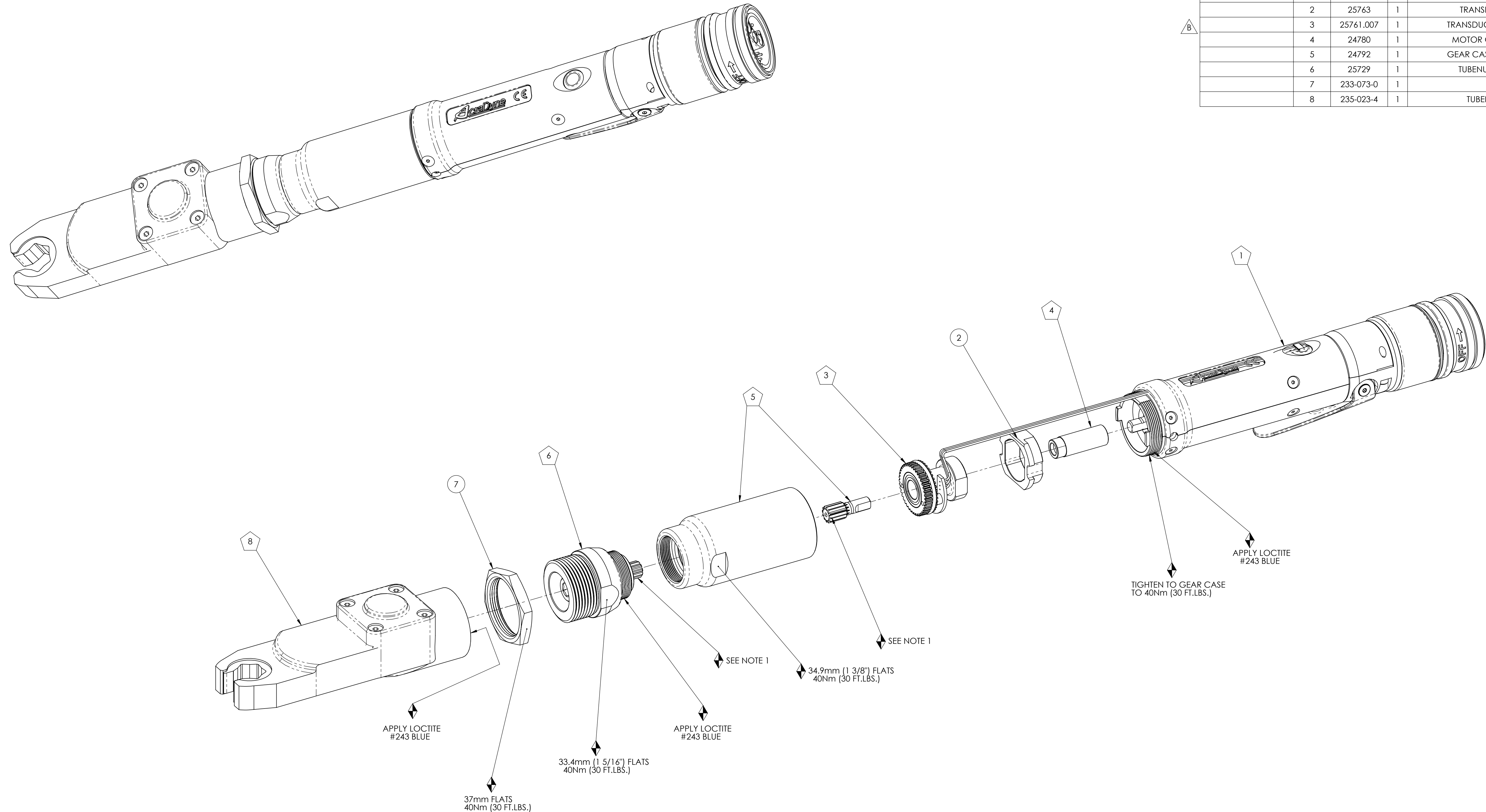


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	25763	1	TRANSDUCER ADAPTOR
	3	25761.007	1	TRANSDUCER SUB-ASM., 20Nm
	4	24780	1	MOTOR COUPLER SUB-ASM.
	5	24792	1	GEAR CASE SUB-ASM., 12T/12T
	6	25729	1	TUBENUT ADAPTOR ASM.
	7	233-073-0	1	LOCK NUT
	8	235-023-4	1	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

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'

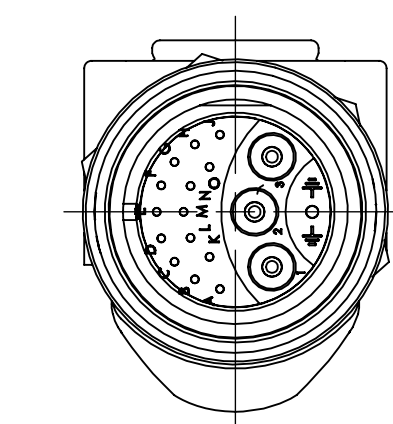
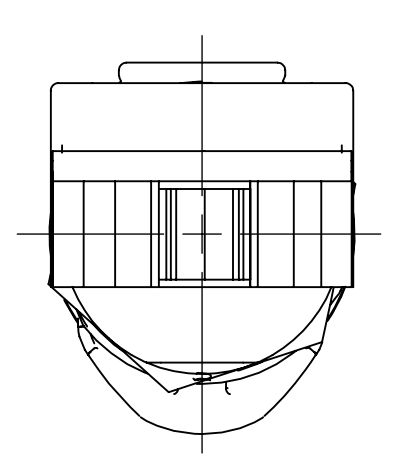
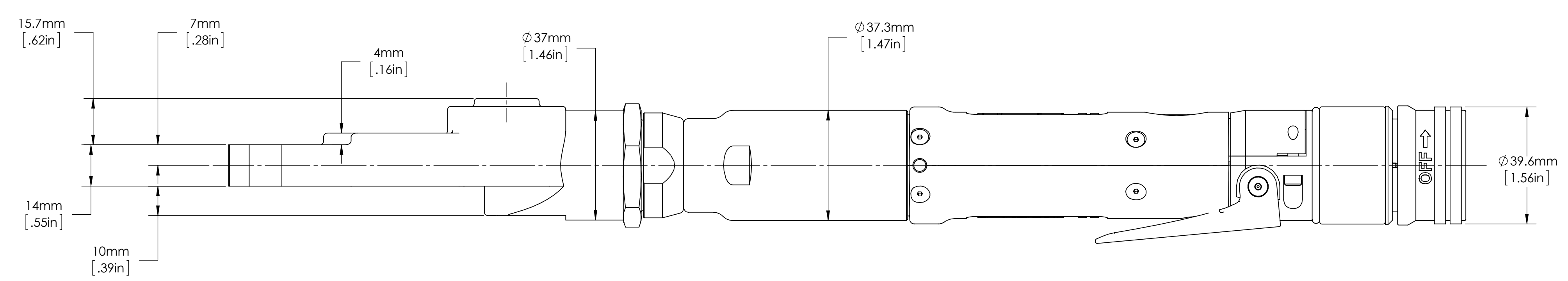
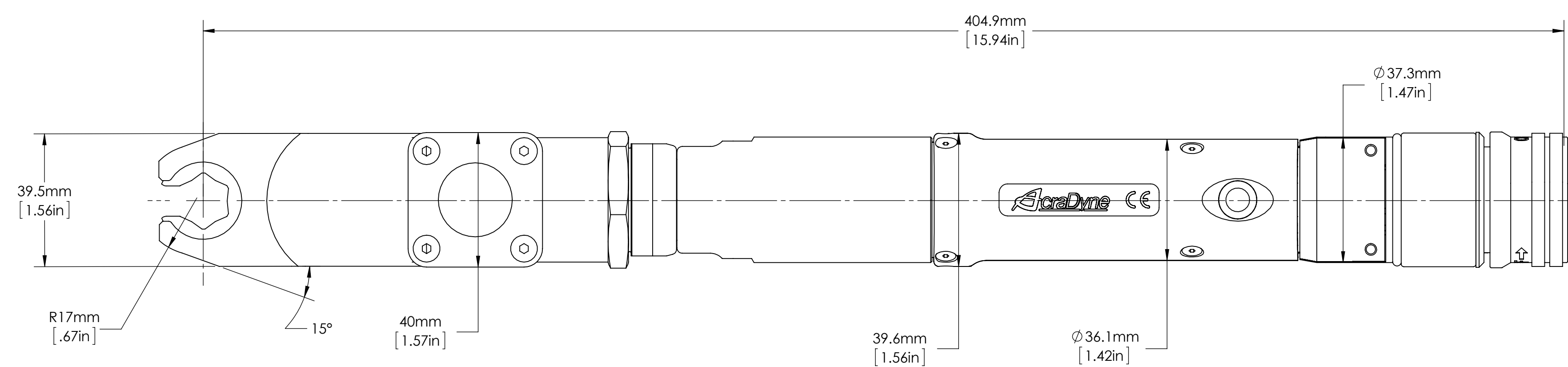
REMOVE BURRS AND SHARP EDGES: R.015 MAX
 MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AET4AB12025B TUBENUT NUTRUNNER GEN IV, 1000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AET4AB12025B	B

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



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AET4AB12025B TUBENUT NUTRUNNER GEN IV, 1000 SERIES		
SIZE D	PART / DRAWING NUMBER AET4AB12025B	REVISION B
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2