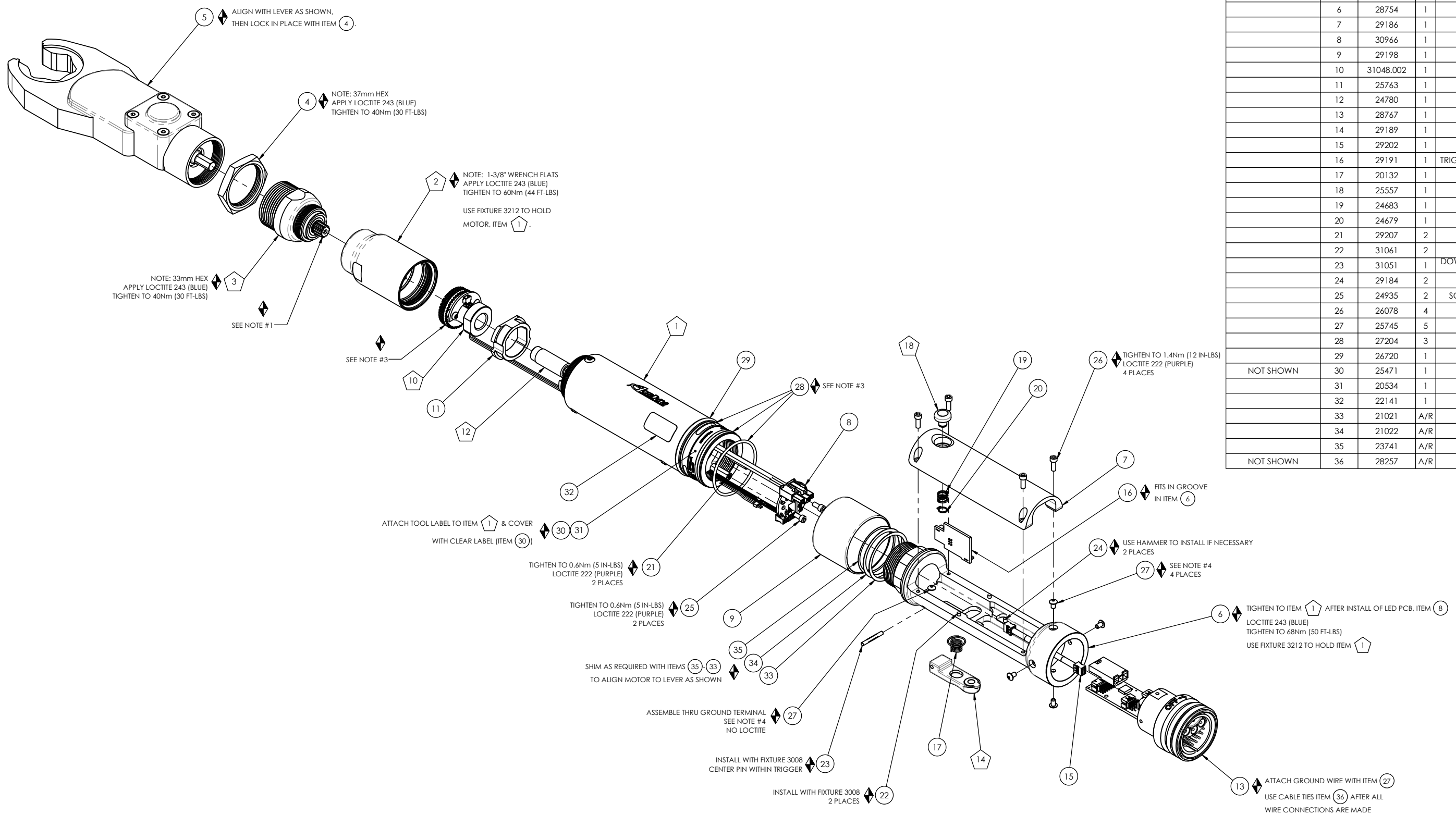


TOOL MODEL NO.	TUBENUT HEAD ASM.
AET4AA22016B	235-023-0
AET4AB22021B	235-023-4
AET4AC22028B	236-023-0
AET4AD22038B	236-023-6

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	31056	1	MOTOR ASM., 2000 B SERIES
	2	24860	1	GEAR CASE SUB-ASM.
	3	25729	1	TUBENUT ADAPTOR ASM.
	4	233-073-0	1	LOCK NUT, GEAR CASE, OHO, S2 INTERFACE
	5	SEE CHART	1	TUBENUT HEAD ASM.
	6	28754	1	LEVER HANDLE
	7	29186	1	COVER, LEVER HANDLE
	8	30966	1	LED BOARD ASM, i2C
	9	29198	1	LED COVER, LARGE DIA.
	10	31048.002	1	TRANSDUCER SUB-ASM.
	11	25763	1	TRANSDUCER ADAPTOR
	12	24780	1	MOTOR COUPLER SUB-ASM.
	13	28767	1	TOOL CONN. ASM.
	14	29189	1	TRIGGER SUB-ASM.
	15	29202	1	TRIGGER CABLE ASM., 6 PIN - 6 PIN
	16	29191	1	TRIGGER/MFG BOARD ASM., 2000-SERIES, GEN 4
	17	20132	1	THROTTLE SPRING
	18	25557	1	REV BUTTON SUB-ASSEMBLY
	19	24683	1	SPRING, REV BUTTON
	20	24679	1	RETAINING RNG
	21	29207	2	STANDOFF, F-F, 4-40 X 5/8, 3/16 HEX, AL
	22	31061	2	DOWEL PIN, Ø3/32 X 1/4, STEEL
	23	31051	1	DOWEL PIN, Ø.094 X .75, GROOVED, STEEL, ZINC PLATED
	24	29184	2	DOWEL PIN, Ø.094 X .25, PLASTIC
	25	24935	2	SCREW, SHC 4-40 X .25, STEEL, BLACK OXIDE
	26	26078	4	SCREW, SHC 4-40 X 5/16, BLK OXIDE
	27	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	28	27204	3	O-RING, OUTER CLUTCH PLATE
	29	26720	1	O-RING, LIGHT RING
NOT SHOWN	30	25471	1	LABEL SN# COVER, .25 X 4"
	31	20534	1	2000 SERIAL/MODEL LABEL
	32	22141	1	SAFETY LABEL
	33	21021	A/R	SHIM, BLANK OUTPUT SHAFT, 0.010 THK
	34	21022	A/R	SHIM, BLANK OUTPUT SHAFT, 0.005 THK
	35	23741	A/R	SHIM, OUTPUT, .002 IN, 40 NM
NOT SHOWN	36	28257	A/R	CABLE TIE, 1.65mm X 71mm



- ◆ 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

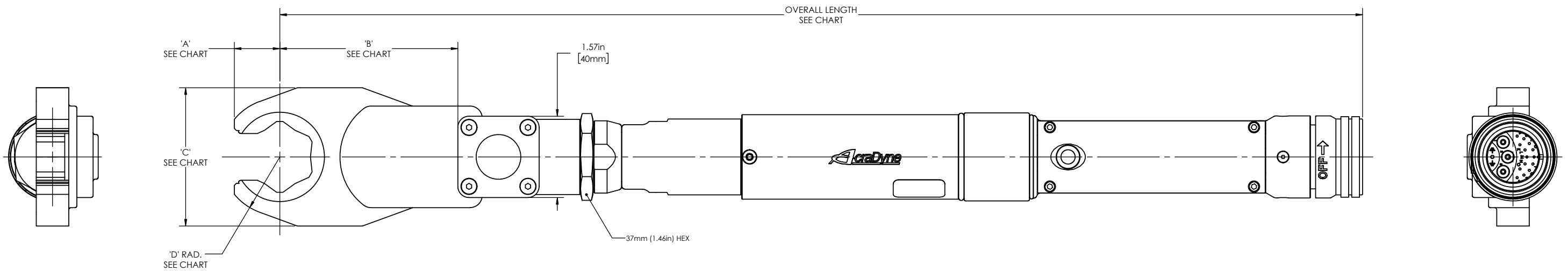
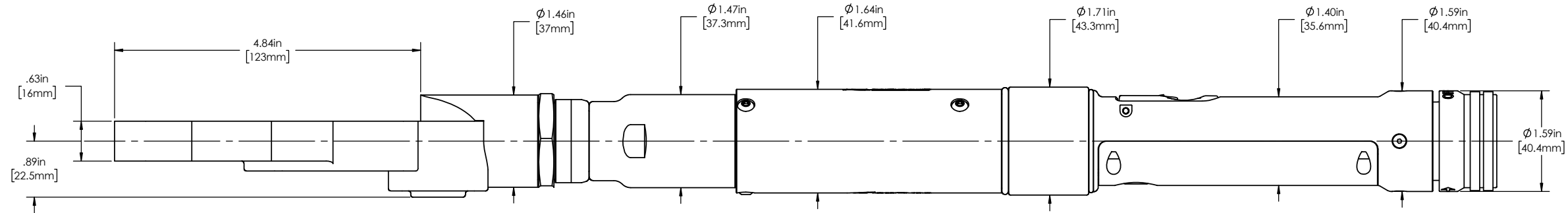
BLOCK TOLERANCING PER DECIMAL:
 X = ±.030 XX = ±.010 XXX = ±.005 XXXX = ±.0005
 ANGLE = ±30°

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

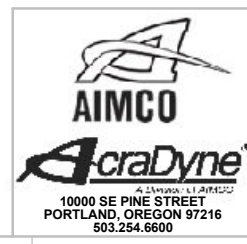
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ACRADYNE MECHANICAL ENGINEERING

TUBENUT NUTRUNNER
 GEN 4 2000 B SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AET4A 220 B	A
SCALE 3:4	DO NOT SCALE DRAWING	SHEET 1 OF 2



TOOL MODEL NO.	OVERALL LENGTH	'A'	'B'	'C'	'D'
AET4AA22016B	490.8mm [19.32in]	10mm [.41in]	46mm [1.83in]	37mm [1.46in]	14mm [.55in]
AET4AB22021B	505.4mm [19.90in]	13mm [.52in]	61mm [2.40in]	40mm [1.56in]	17mm [.67in]
AET4AC22028B	515.0mm [20.27in]	17mm [.68in]	71mm [2.78in]	56mm [2.20in]	22mm [.87in]
AET4AD22038B	532.9mm [20.98in]	22mm [.88in]	88mm [3.45in]	68mm [2.68in]	29mm [1.14in]



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

REVISION BLOCK

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DIMENSIONS AND TOLERANCING PER ANSI Y14.5
SURFACE ROUGHNESS PER ANSI Y14.36

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TUBENUT NUTRUNNER

GEN 4 2000 B SERIES

SIZE D	PART / DRAWING NUMBER AET4A 220 B	REVISION A
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SCALE 1:1 DO NOT SCALE DRAWING SHEET 2 OF 2