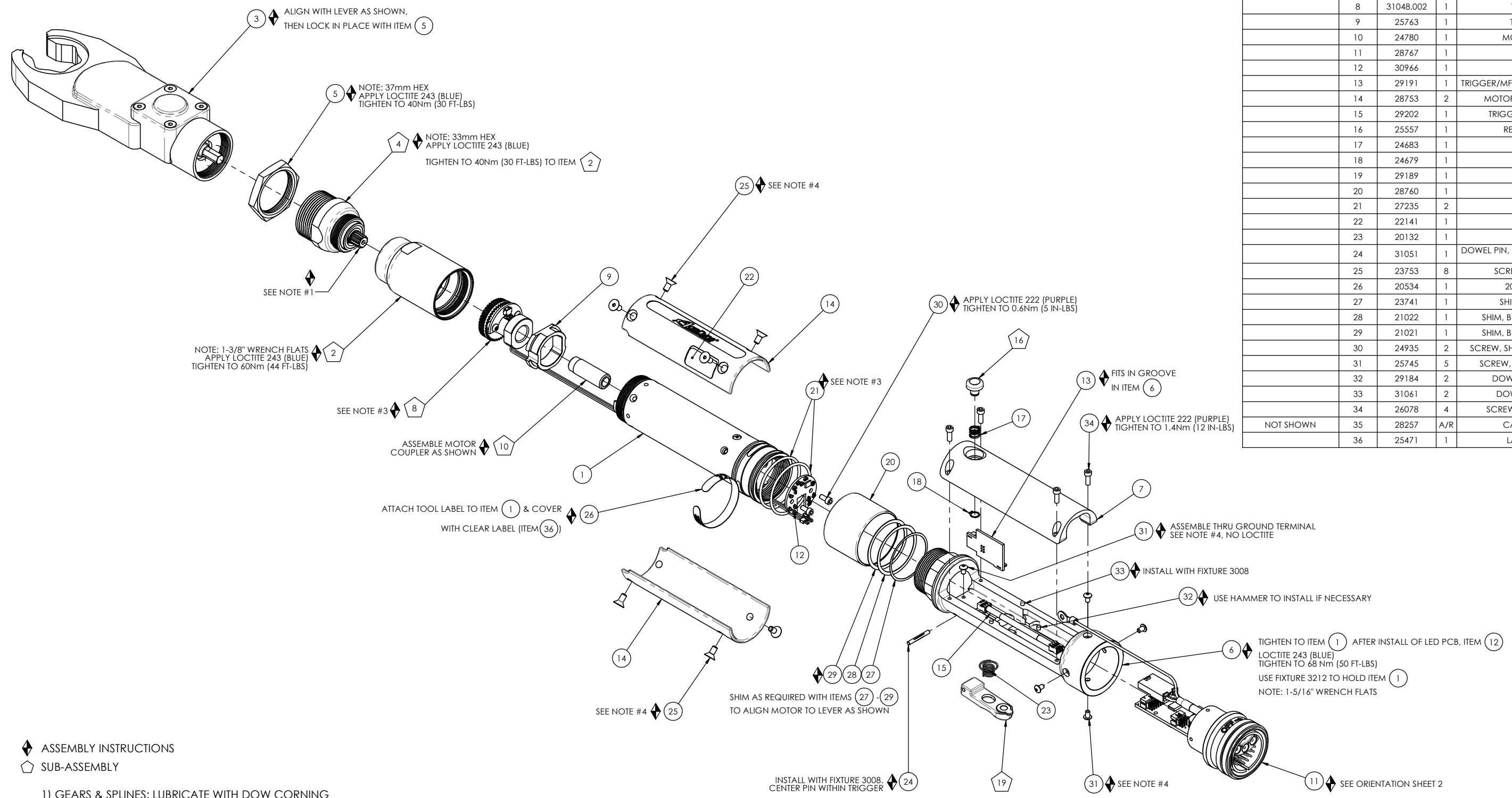


TOOL MODEL NO.	TUBENUT HEAD ASM.
AET4AA22016C	235-023-0
AET4AB22021C	235-023-4
AET4AC22028C	236-023-0
AET4AD22038C	236-023-6

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	28766	1	MOTOR ASSEMBLY
	2	24860	1	GEAR CASE SUB-ASM 6T
	3	SEE CHART	1	TUBENUT HEAD ASM.
	4	25729	1	TUBENUT ADAPTOR ASM.
	5	233-073-0	1	LOCK NUT, GEAR CASE, OHO, S2 INTERFACE
	6	28754	1	LEVER HANDLE
	7	29186	1	COVER, LEVER HANDLE
	8	31048.002	1	TRANSDUCER SUB-ASM.
	9	25763	1	TRANSDUCER ADAPTOR
	10	24780	1	MOTOR COUPLER SUB-ASM.
	11	28767	1	TOOL CONN. ASM.
	12	30966	1	LED BOARD ASM, i2C
	13	29191	1	TRIGGER/MFG BOARD ASM., 2000-SERIES, GEN 4
	14	28753	2	MOTOR COVER, SMALL MOTOR O.D.
	15	29202	1	TRIGGER CABLE ASM., 6 PIN - 6 PIN
	16	25557	1	REV BUTTON SUB-ASSEMBLY
	17	24683	1	SPRING, REV BUTTON
	18	24679	1	RETAINING RNG
	19	29189	1	TRIGGER SUB-ASM.
	20	28760	1	LED COVER
	21	27235	2	O-RING, BUNA-N, #28
	22	22141	1	SAFETY LABEL
	23	20132	1	THROTTLE SPRING
	24	31051	1	DOWEL PIN, Ø.094 X .75, GROOVED, STEEL, ZINC PLATED
	25	23753	8	SCREW, FHSC 6-32x5/16, 18-8 SS
	26	20534	1	2000 SERIAL/MODEL LABEL
	27	23741	1	SHIM, OUTPUT, .002 IN, 40 NM
	28	21022	1	SHIM, BLANK OUTPUT SHAFT, 0.005 THK
	29	21021	1	SHIM, BLANK OUTPUT SHAFT, 0.010 THK
	30	24935	2	SCREW, SHC 4-40 X .25, STEEL, BLACK OXIDE
	31	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	32	29184	2	DOWEL PIN, Ø.094 X .25, PLASTIC
	33	31061	2	DOWEL PIN, Ø3/32 X 1/4, STEEL
	34	26078	4	SCREW, SHC 4-40 X 5/16, BLK OXIDE
NOT SHOWN	35	28257	A/R	CABLE TIE, 1.65mm X 71mm
	36	25471	1	LABEL SN# Cover, .25 X 4"



- ◆ 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	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

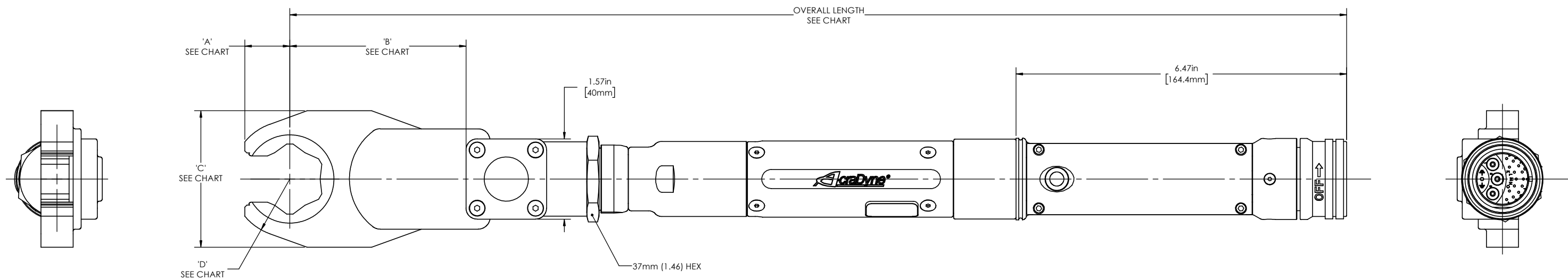
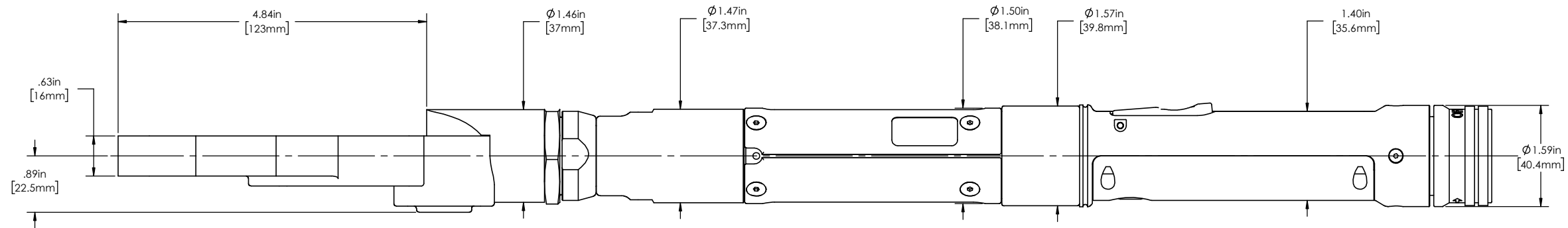
TUBENUT NUTRUNNER

GEN 4 2000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AET4A 220 C	A

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

REVISION BLOCK



TOOL MODEL NO.	OVERALL LENGTH	'A'	'B'	'C'	'D'
AET4AA22016C	484.25mm, [19.07in]	10mm, [.41in]	46mm, [1.83in]	37mm, [1.46in]	14mm, [.55in]
AET4AB22021C	498.73mm, [19.64in]	13mm, [.52in]	61mm, [2.40in]	40mm, [1.56in]	17mm, [.67in]
AET4AC22028C	508.38mm, [20.02in]	17mm, [.68in]	71mm, [2.78in]	56mm, [2.20in]	22mm, [.87in]
AET4AD22038C	525.91mm, [20.71in]	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 #	APPROVAL

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ACRADYNE MECHANICAL ENGINEERING

TUBENUT NUTRUNNER

GEN 4 2000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AET4A 220 C	A

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