Introduction

Thank you for purchasing this AcraDyne DC electric assembly tool, one of the lightest and fastest DC electric assembly tools on the market. When used with the AcraDyne iEC tool controller, this tool will provide excellent productivity, ergonomics, reliability and quality on a wide range of industrial assembly applications.

Safety Information

SAVE THESE INSTRUCTIONS

1) WORK AREA
   a) Keep work area clean and well lit. Cluttered and dark areas invite accidents.
   b) Do not operate power tools in explosive atmospheres, such as the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
   c) Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.

2) ELECTRICAL SAFETY
   a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
   b) Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
   c) Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
   d) Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
   e) This tool is intended for indoor use only.

3) PERSONAL SAFETY
   a) Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
   b) Use safety equipment. Always wear eye protection. Safety equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries. If the maximum duty cycle of the attached tool is exceeded or the tool temperature exceeds 50° C., then the operator should wear protective hand wear (gloves).
   c) Avoid accidental starting. Ensure the switch is in the off-position before plugging in. Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.
   d) Remove any adjusting key or wrench before turning the power tool on. A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
   e) Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
   f) Dress properly. Do no wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts.
   g) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used. Use of these devices can reduce dust-related hazards.

4) POWER TOOL USE AND CARE
   a) Do not force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.
   b) Do not use the power tool if the switch does not turn it on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
   c) This product is designed to be used in combination with the AcraDyne iEC DC tool controller for intermittent hand-held or fixtured assembly processes.
1. Connect tool cable to the iEC controller and the tool: The tool cable has curved alignment tabs and slots built into the connectors at each end to ensure proper alignment and connection with the tool and controller. **Make sure that power is not turned on at the controller before making any connections.** Align the female connector on the cable with the male connector on the tool and insert the cable onto the tool, then slide the connector nut onto the threads on the cable and turn clockwise until hand-tight. Align the male connector tab on the other end of the tool cable with the female slot on the controller and insert the cable into the connector, then slide the metal outer cover onto the connection threads on the controller and turn clockwise until hand-tight.

2. Multifunction Button Operation: The tool will flash all LED lights three times when power is first turned on at the controller. After the controller finishes initializing and displays a target torque value, the multifunction button (MFB) is used to toggle the tool from clockwise mode (FWD) to counter-clockwise operation mode (REV). The MFB is the small button opposite the trigger. The tool will initially start in clockwise mode and will have no LED lights turned on. If the trigger is pressed, the tool will turn on the blue LED meaning the tightening operation is underway. Pressing the MFB will cause the tool to flash yellow and red LED lights. Pressing the MFB again will switch the tool back FWD mode and will indicate this with no LED lights turned on.

3. Start Lever Operation: To start the tool, depress the start lever. Blue LED lights will be displayed while tightening a bolt. The tool will stop automatically when it senses its target torque value or if no torque is sensed in a specified time period. After a cycle is complete, the tool will display green LED lights for a success, or red LED lights for failure to reach torque/angle.

<table>
<thead>
<tr>
<th>Light Color</th>
<th>Meaning</th>
</tr>
</thead>
<tbody>
<tr>
<td>Green Solid</td>
<td>OK</td>
</tr>
<tr>
<td>Red Flashing</td>
<td>Torque Low</td>
</tr>
<tr>
<td>Red Solid</td>
<td>Torque High</td>
</tr>
<tr>
<td>Yellow Flashing</td>
<td>Angle Low</td>
</tr>
<tr>
<td>Yellow Solid</td>
<td>Angle High</td>
</tr>
<tr>
<td>Blue Solid</td>
<td>Tool In-Cycle/Tool Armed</td>
</tr>
<tr>
<td>Blue Flashing</td>
<td>P-Set Change thru MFB</td>
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<tr>
<td>All On Flashing</td>
<td>Tool in Disassembly</td>
</tr>
<tr>
<td>Buzzer</td>
<td>Bad Assembly/Tool in Disassembly/Pwr Up</td>
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</table>

A complete tool system consists of the following items:

- Controller
- Power cord
- Tool
- Tool Cable
THIS SCREW IS ALREADY ASSEMBLED INSIDE OF GEAR CARRIER ASSEMBLY (SHOWN FOR CLARITY)
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 40 Nm (30 FT-LBS)

SEE NOTE #1

PRESSTHROUGH GROUND TERMINAL
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)

APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 2 PLACES

APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 8.3-8.5 Nm (73-75 IN-LBS) 2 PLACES

PRESS FLUSH TO BELOW MOTOR HOUSING DIAMETER 34
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 5 PLACES

MOTOR PINION IS PART OF GEAR TRAIN ASSEMBLY (SHOWN FOR CLARITY)
LUBRICATE INTERNAL O-RING PER NOTE #3 AND SLIDE PINION ONTO MOTOR SHAFT UNTIL O-RING SEATS IN GROOVE.
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.9-2.5 Nm (17-22 IN-LBS) 4 PLACES
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.9-2.5 Nm (17-22 IN-LBS) 4 PLACES
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 2 PLACES

APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 2.5-2.9 Nm (22-26 IN-LBS) 6 PLACES

APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 2 PLACES
SEE NOTE #3

LUBRICATE MOTOR SPLINE SHAFT PER NOTE #1
APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 2.5-2.9 Nm (22-26 IN-LBS) 6 PLACES

APPLY LOCTITE 243 (BLUE)
TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 2 PLACES
SEE NOTE #3

TOOL LEVER
POSITION TOOL CONNECTOR KEYWAY 90° FROM TOOL LEVER, AS SHOWN

ITEM #  PART NUMBER QTY. DESCRIPTION
1  26058  1  MOTOR ASM., 5000 SERIES
2  26198  1  THRUST WASHER
3  26074  1  BELLEVILLE WASHER
4  26117  2  M-F THREADED HEX STANDOFF
5  20911  2  BELLEVILLE WASHER
6  20913  4  PIN, RETAINING
7  26077  2  M-F THREAD HEX STANDOFF
8  26095  1  LED BOARD ASM.
9  26078  2  SCREW, SHC 4-40X.312, STEEL, BLACK OXIDE
10 26080  1  O-RING, LED LIGHT RING COVER
11 26079  1  LIGHT RING COVER, LED
12 26082  1  LEVER HANDLE
13 26088  6  SCREW, BHC 6-32X.25, STEEL, BLACK OXIDE
14 26102  1  TOOL CONNECTOR ASM., LEVER
15 25417  1  TID BOARD ASM.
16 24934  2  SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
17 25071  1  SPRING, LEVER
18 25074  1  LEVER ASSEMBLY
19 20061  2  SCREW, LEVER
20 26054  1  HANDLE COVER, MFH
21 24706  1  REV BUTTON SUB-ASSEMBLY
22 24879  1  retaining RING
23 24938  10  SCREW, FHSC 4-40X.188, STEEL, BLACK OXIDE
24 26083  1  HANDLE COVER
25 20534  1  3000 SERIAL/MODEL LABEL
26 26111  2  MOTOR HOUSING COVER
27 25385  8  SCREW, FHSC 6-32 X .375, STEEL
28 22141  1  SAFETY LABEL

MODEL NO.  GEAR TRAIN ASM. GEAR CARRIER ASM. ANGLE HEAD ASM. SPLINED SPINDLE SHAFT
AEN35090A  26116  20924  26119  26122
AEN35140A  26116  20924  23461  N/A
AEN35175A  26115  26117  23461  N/A
AEN35225A  26114  20924  23468  N/A
AEN35285A  26112  20924  23468  N/A
AEN35350A  26111  26117  23468  N/A

ASSEMBLY INSTRUCTIONS
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
ASSEMBLY INSTRUCTIONS
1) ASSEMBLED LUBRICATION MOLYKOTE BR2 PLUS GEAR TRAIN
2) ASSEMBLED LUBRICATION CHEVRON SR1 BEARING
3) ASSEMBLED LUBRICATION DOW CORNING MOLYKOTE BR2 PLUS GEAR TRAIN

Assembly for: AES35075AV, AES35090AV, AES35110AV, AES35135AV, AES35170AV

<table>
<thead>
<tr>
<th>ITEM #</th>
<th>PART NUMBER</th>
<th>QTY.</th>
<th>DESCRIPTION</th>
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<td>MOTOR ASM., 5000 SERIES</td>
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<td>26074</td>
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<td>25385</td>
<td>8</td>
<td>SCREW, FHS 6-32 X .375, STEEL</td>
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<td>34</td>
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<td>SAFETY LABEL</td>
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<td>20455</td>
<td>1</td>
<td>FIXTURE NUT, INLINE — 3000 SERIES</td>
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</table>

MODEL NO.  | GEAR TRAIN ASM.  | GEAR CARRIER ASM.  |
AES35075AV | 26116            | 20924             |
AES35090AV | 26115            | 26117             |
AES35110AV | 26114            | 20924             |
AES35135AV | 26113            | 26117             |
AES35170AV | 26111            | 26117             |

THIS SCREW IS ALREADY ASSEMBLED INSIDE OF GEAR CARRIER ASSEMBLY (SHOWN FOR CLARITY)
APPLY LOCTITE 243 (BLUE) TIGHTEN TO 40 Nm (30 FT-LBS)

SEE NOTE #1

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 2 PLACES

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 8.3-8.5 Nm (73-75 IN-LBS) 2 PLACES

PRESS FLUSH TO BELOW MOTOR HOUSING DIAMETER

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 5 PLACES

MOTOR PINION IS PART OF GEAR TRAIN ASSEMBLY (SHOWN FOR CLARITY)
LUBRICATE INTERNAL O-RING PER NOTE #3 AND SLIDE PINION ONTO MOTOR SHAFT UNTIL O-RING SEATS IN GROOVE.

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS) 5 PLACES

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.9-2.5 Nm (17-22 IN-LBS) 4 PLACES

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.9-2.5 Nm (17-22 IN-LBS) 4 PLACES

LUBRICATE MOTOR SPLINE SHAFT PER NOTE #1

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 2.5-2.9 Nm (22-26 IN-LBS) 6 PLACES

ASSEMBLE THRU GROUND TERMINAL

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)
APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)
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APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)

TOOL LEVER
POSITION TOOL CONNECTOR KEYWAY 90° FROM TOOL LEVER, AS SHOWN

LUBRICATE MOTOR SPLINE SHAFT PER NOTE #1

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 2.5-2.9 Nm (22-26 IN-LBS) 6 PLACES

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)
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APPLY LOCTITE 243 (BLUE) TIGHTEN TO 1.4-1.6 Nm (12-14 IN-LBS)
5000 SERIES IN-LINE NUTRUNNERS

Assembly for: AES35280AV, AES35350AV, AES35420AV, AES35515AV, AES35635AV

Assemble through ground terminal...

Assembly Instructions

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.

ITEM # | PART NUMBER | QTY. | DESCRIPTION
--- | --- | --- | ---
1 | 26058 | 1 | MOTOR ASM., 5000 SERIES
2 | 26198 | 1 | THRUST WASHER
3 | 26074 | 1 | BELLEVILLE WASHER
4 | SEE CHART | 1 | GEARBOX ASM., TRIPLE STEP
5 | 20913 | 2 | PR. RETAINING
6 | 26077 | 2 | M/F THREADED HEX STANDOFF
7 | 26095 | 1 | LED BOARD ASM.
8 | 26078 | 2 | SCREW, SBC 4-40 X .312, STEEL, BLACK OXIDE
9 | 26080 | 1 | O-RING, LED LIGHT RING COVER
10 | 26079 | 1 | LIGHT RING COVER, LED
11 | 26082 | 1 | LEVER HANDLE
12 | 26088 | 6 | SCREW, BHC 8-32 X .25, STEEL, BLACK OXIDE
13 | 26102 | 1 | TOOL CONNECTOR ASM., LEVER
14 | 25745 | 4 | SCREW, BHC 4-40 X 188, STEEL, BLACK OXIDE
15 | 25102 | 1 | SCREW, BHC 4-40 X 188, STEEL, BLACK OXIDE
16 | 25847 | 1 | TID BOARD ASM.
17 | 24934 | 2 | SCREW, FHSC 4-40 X .312, STEEL, BLACK OXIDE
18 | 25071 | 1 | SPRING, LEVER
19 | 25074 | 1 | LEVER ASSEMBLY
20 | 20061 | 2 | SCREW, LEVER
21 | 26084 | 1 | HANDLE COVER, MFB
22 | 24706 | 1 | REV BUTTON SUB-ASSEMBLY
23 | 24683 | 1 | SPRING, REV BUTTON
24 | 24679 | 1 | RETAINING RING
25 | 24940 | 10 | SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
26 | 25083 | 1 | HANDLE COVER
27 | 20534 | 1 | 3000 SERIAL/MODEL LABEL
28 | 26081 | 2 | MOTOR HOUSING COVER
29 | 25385 | 8 | SCREW, FHSC 6-32 X .375, STEEL
30 | 22141 | 1 | SAFETY LABEL
31 | 23793 | 1 | REACTION BAR
32 | 23792 | 1 | RETAINING NUT, HEX

MODEL # | GEARBOX ASM.
--- | ---
AES35280AV | 26202
AES35350AV | 26203
AES35420AV | 26201
AES35515AV | 26200
AES35635AV | 26129
Specifications

Environmental
- Operating Temperature: 0°C to 32°C
- Storage Temperature: 0°C to 65°C
- Humidity:
  - 5% to 90% RH, Non-Condensing, for temperatures 0°C to 40°C
  - 5% to 60% RH, Non-Condensing, for temperatures 0°C to 65°C
- Maximum Altitude of Operation: 3000m
- Maximum decibel level: 77 dB(A)

Electrical
- Motor Type: BLDC
  - Motor Phase Voltage: 160 Volts Pulse DC @ Controller Supply Voltage of 120 RMS, or 320 Volts Pulse DC @ Controller Supply Voltage of 230 RMS
- Duty Cycle: The Nutrunner tools are intended for intermittent operation with recommended maximum duty cycles not to exceed 25%. Note: actual maximum duty cycles are dependant upon several factors including: Ambient Temperature, Tool selection, Joint conditions, Fastening-parameter programming, and different applications and strategies. For optimum duty cycle determination, please contact your AcraDyne sales representative.

Physical
- 6.9 lbs/3.1 kg - 16.1 lbs/7.3 kg

Performance (Series)
- Torque Range: 19 - 635 NM
- Speed Range: 14 - 468.6 RPM

Notes: Full speed 50% of rated for 5000 series tools @ 120VAC.
5000 series tools must be connected to iEC controllers equipped with 40A servo drive.