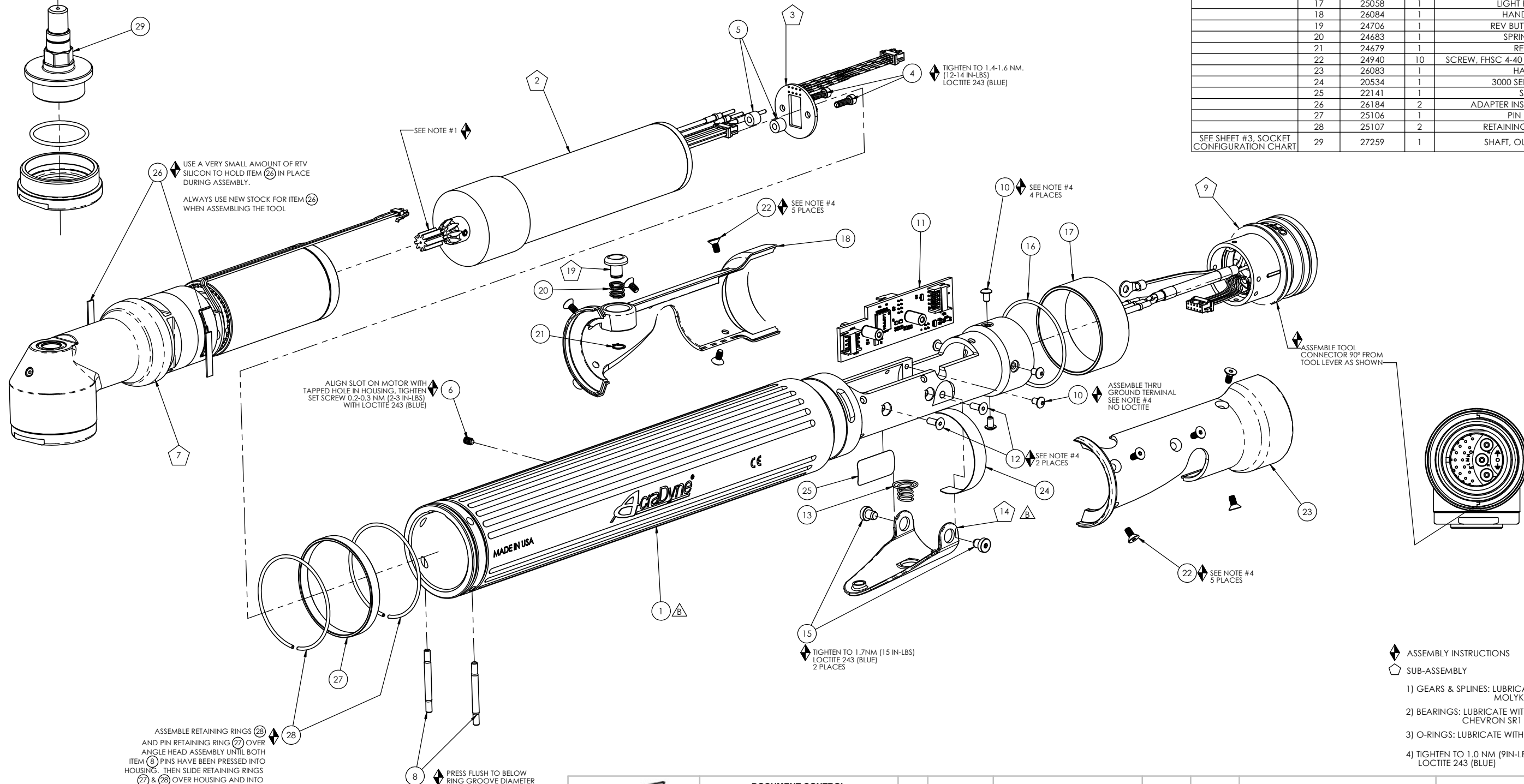


FLUSH SOCKET



MODEL NO.	ANGLEHEAD/GEAR TRAIN ASM.
AEN33060CF	27611
AEN33090CF	27614

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	27031	1	MOTOR HOUSING ASSEMBLY
	2	25525	1	MOTOR ASSY, 9T, 3000 SERIES
	3	25063	1	LED BOARD ASM.
	4	25075	2	SCREW, SHC 4-40X.375, STEEL, BLACK OXIDE
	5	25430	2	STAND-OFF, LED, 3000 SERIES
	6	27027	1	SCREW, SET 5-40X.188, STEEL, BLK OXIDE
	7	SEE CHART	1	ANGLE HEAD, FLUSH SOCKET GEAR TRAIN ASM 90Nm
	8	26793	2	RETAINING PIN, .125 OD X 1-1/4
	9	26102	1	TOOL CONNECTOR ASM., LEVER
	10	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	11	25847	1	TID BOARD ASM., 2000-3000 SERIES
	12	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	13	20132	1	THROTTLE SPRING
	14	26532	1	GEN 3 TRIGGER ASSY, CAST
	15	20061	2	SCREW, LEVER
	16	25072	1	O-RING, LED LIGHT RING COVER
	17	25058	1	LIGHT RING COVER, LED
	18	26084	1	HANDLE COVER, MFB
	19	24706	1	REV BUTTON SUB-ASSEMBLY
	20	24683	1	SPRING, REV BUTTON
	21	24679	1	RETAINING RNG
	22	24940	10	SCREW, FHSC 4-40 X .25 LG., STEEL, BLACK OXIDE
	23	26083	1	HANDLE COVER
	24	20534	1	3000 SERIAL/MODEL LABEL
	25	22141	1	SAFETY LABEL
	26	26184	2	ADAPTER INSERT, GEN 3B 3000 SERIES
	27	25106	1	PIN RETAINER RING
	28	25107	2	RETAINING RING, PIN RETAINER
SEE SHEET #3, SOCKET CONFIGURATION CHART	29	27259	1	SHAFT, OUTPUT, FLUSH SOCKET

26 USE A VERY SMALL AMOUNT OF RTV SILICON TO HOLD ITEM 29 IN PLACE DURING ASSEMBLY.
ALWAYS USE NEW STOCK FOR ITEM 26 WHEN ASSEMBLING THE TOOL

6 ALIGN SLOT ON MOTOR WITH TAPPED HOLE IN HOUSING, TIGHTEN SET SCREW 0.2-0.3 NM (2-3 IN-LBS) WITH LOCTITE 243 (BLUE)

4 TIGHTEN TO 1.4-1.6 NM. (12-14 IN-LBS) LOCTITE 243 (BLUE)

22 SEE NOTE #4 5 PLACES

10 SEE NOTE #4 4 PLACES

10 ASSEMBLE THRU GROUND TERMINAL SEE NOTE #4 NO LOCTITE

12 SEE NOTE #4 2 PLACES

15 TIGHTEN TO 1.7NM (15 IN-LBS) LOCTITE 243 (BLUE) 2 PLACES

22 SEE NOTE #4 5 PLACES

ASSEMBLE RETAINING RINGS 28 AND PIN RETAINING RING 27 OVER ANGLE HEAD ASSEMBLY UNTIL BOTH ITEM 8 PINS HAVE BEEN PRESSED INTO HOUSING. THEN SLIDE RETAINING RINGS 27 & 28 OVER HOUSING AND INTO GROOVES.

8 PRESS FLUSH TO BELOW RING GROOVE DIAMETER

- ◆ ASSEMBLY INSTRUCTIONS
- ◊ SUB-ASSEMBLY
- 1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- 2) BEARINGS: LUBRICATE WITH CHEVRON SRI GREASE
- 3) O-RINGS: LUBRICATE WITH O-RING LUBE
- 4) TIGHTEN TO 1.0 NM (9IN-LBS) LOCTITE 243 (BLUE)

REQUIRED TOOLING
LOCTITE 243 (BLUE)
1/16 HEX WRENCH
5/64 HEX WRENCH
3/32 HEX WRENCH
SNAP RING PLIERS - EXTERNAL TYPE



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

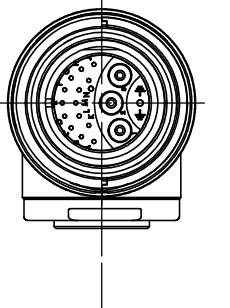
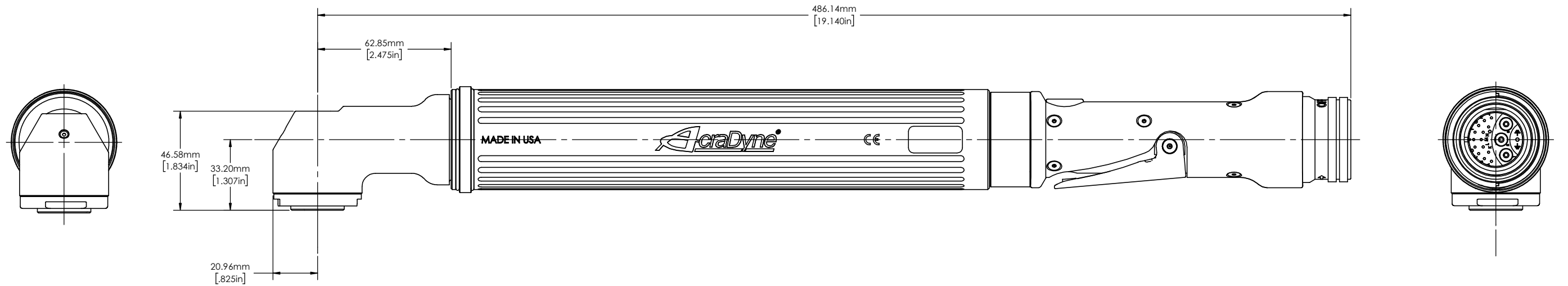
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36

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

AEN330_CF FLUSH HEAD NUTRUNNER 3000 SERIES - GEN 3C		
SIZE D	PART / DRAWING NUMBER AEN330_CF	REVISION B
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 3



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ACRADYNE MECHANICAL ENGINEERING

AEN330_CF FLUSH HEAD NUTRUNNER
 3000 SERIES - GEN 3C

SIZE D	PART / DRAWING NUMBER AEN330_CF	REVISION B
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 2 OF 3

BASE MODEL	DOT	SOCKET BASE	COLUMN 1	SOCKET SIZE	COLUMN 2	EXT.	COLUMN 3	MAGNET	COLUMN 4
AEN33060CF	.	X	DRIVE TYPE	X	HEX SIZE	X	EXTENSION LENGTH	X	MAGNET OPTION
		A	27259 SINGLE HEX	A	10mm	A	0	0	NO MAGNET
		B	27259 DOUBLE HEX	B	11mm	B	3mm	1	WITH MAGNET
		C	27259 SURFACE DRIVE	C	12mm	C	6mm		
				D	13mm	D	9mm		
				E	14mm	E	12mm		
				F	15mm	F	15mm		
				G	16mm	G	18mm		
				H	17mm	H	21mm		
				I	7/16"	I	24mm		
				J	1/2"	J			
				K	9/16"	K			
				L	5/8"	L			
				M	11/16"	M			
				N		N			
				P		P			
				Q		Q			
				R		R			
				S		S			
				T		T			
				U		U			
				V		V			
				W		W			
				X		X			
				Y		Y			
				Z		Z			

****EXAMPLE MODEL NUMBER:** AEN33060CF.CEG0 = SURFACE DRIVE, 14mm HEX, 18mm EXT., NO MAGNET



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DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AEN330__CF FLUSH HEAD NUTRUNNER
 3000-SERIES - GEN 3C

SIZE B	PART / DRAWING NUMBER AEN330__CF	REVISION B
SCALE 1:4	DO NOT SCALE DRAWING	SHEET 3 OF 3