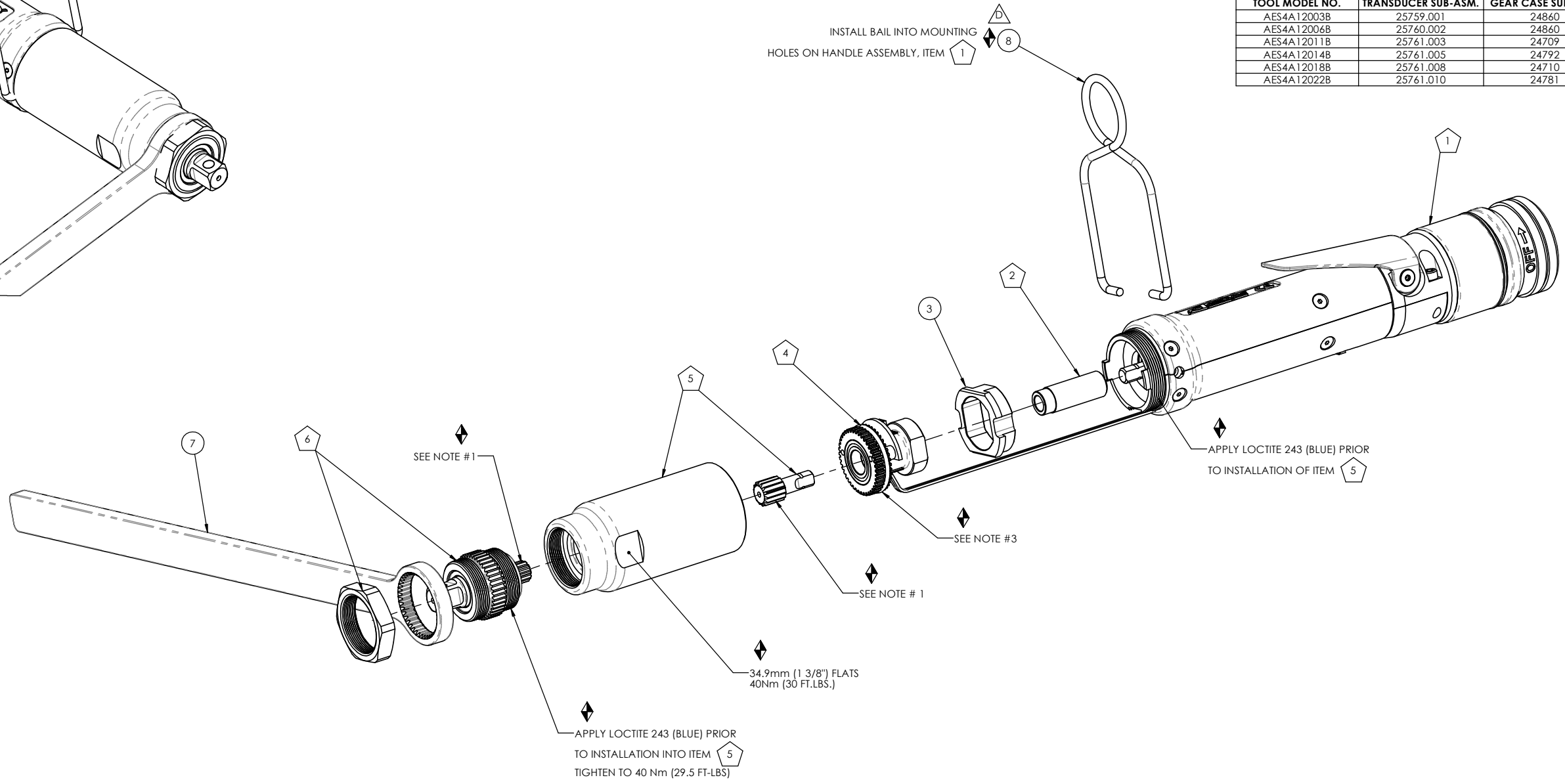


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	24780	1	MOTOR COUPLER SUB-ASM.
	3	25763	1	TRANSDUCER ADAPTOR
	4	SEE CHART	1	TRANSDUCER SUB-ASM.
	5	SEE CHART	1	GEAR CASE SUB-ASM.
	6	24699	1	STRAIGHT OUTPUT ASM., 3/8" SQ. DR.
	7	SEE CHART	1	REACTION BAR, 1000 SERIES
	8	25501	1	BAIL

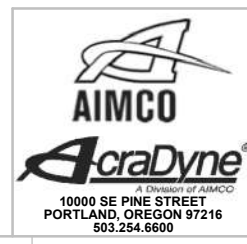
TOOL MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.	REACTION BAR
AES4A12003B	25759.001	24860	24696
AES4A12006B	25760.002	24860	24696
AES4A12011B	25761.003	24709	24696
AES4A12014B	25761.005	24792	24696
AES4A12018B	25761.008	24710	24696
AES4A12022B	25761.010	24781	24697



◆ 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 25894
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

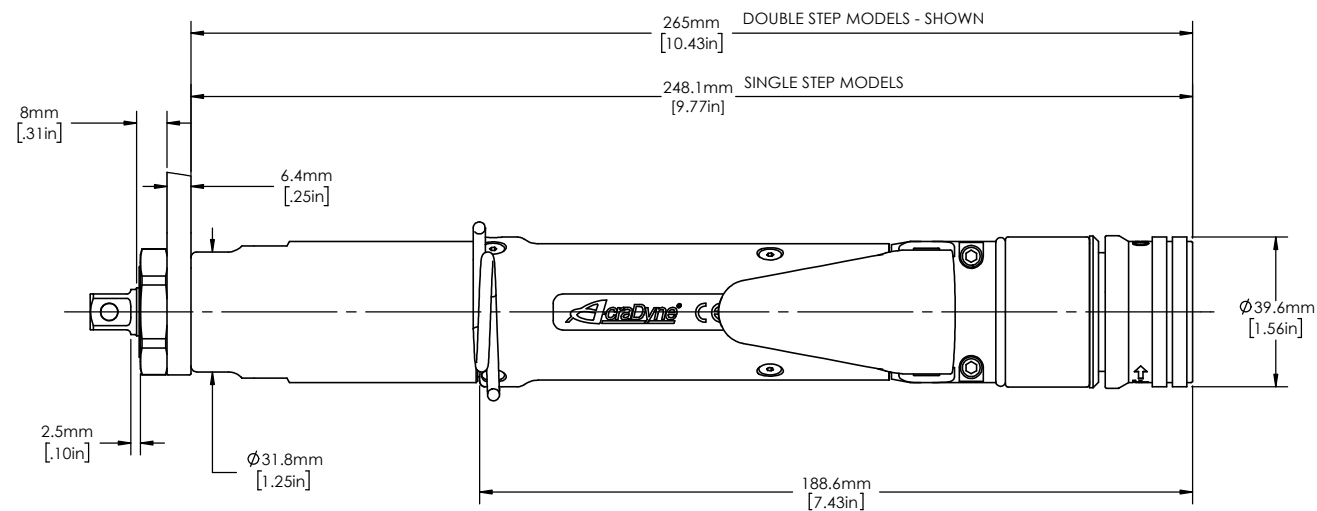
**BLOCK TOLERANCING PER DECIMAL:**  
 .X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005  
 ANGLE = ±0° 30'

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

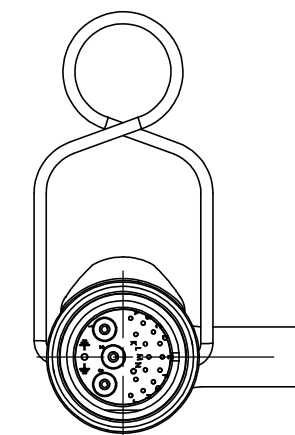
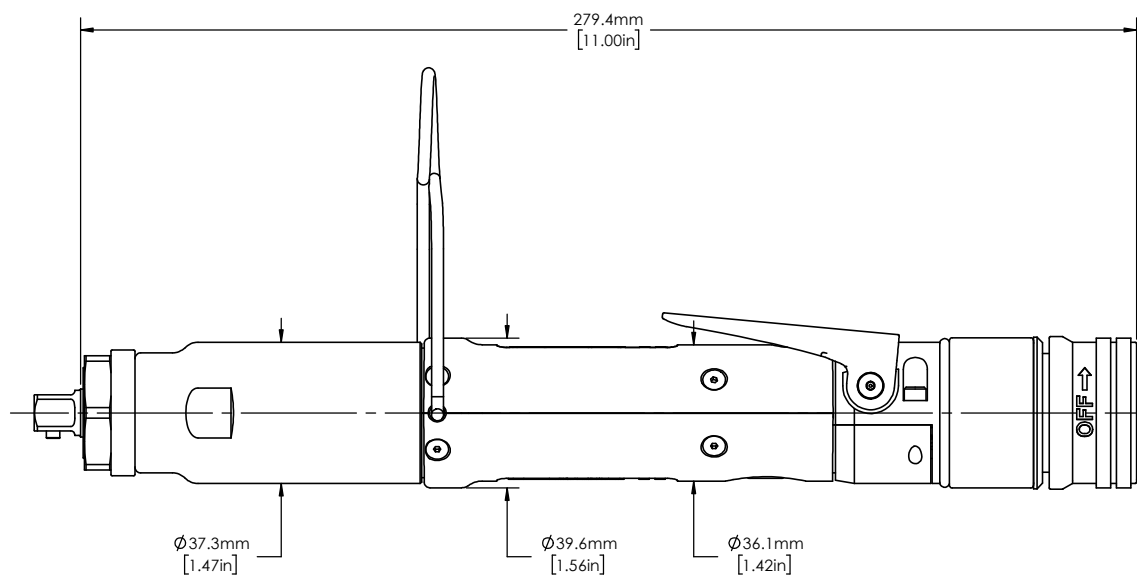
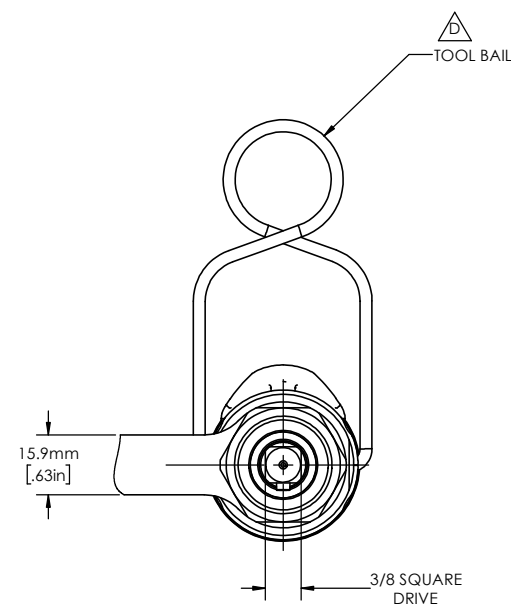
DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:  
**ACRADYNE MECHANICAL ENGINEERING**

**AES4A120\_B**  
**INLINE NUTRUNNER**  
 GEN IV, 1000 SERIES

SIZE <b>D</b>	PART / DRAWING NUMBER <b>AES4A120_B</b>	REVISION <b>D</b>
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 1 OF 2



MODEL NO.	
SINGLE STEP MODELS	AES4A12003B
	AES4A12006B
	AES4A12011B
DOUBLE STEP MODELS	AES4A12014B
	AES4A12018B
	AES4A12022B



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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

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

**DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:**  
**ACRADYNE MECHANICAL ENGINEERING**

<b>AES4A120_B INLINE NUTRUNNER GEN IV, 1000 SERIES</b>		
SIZE <b>D</b>	PART / DRAWING NUMBER <b>AES4A120_B</b>	REVISION <b>D</b>
SCALE 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2