

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	27043	1	STRAIGHT OUTPUT ASSY, Q.C.
	7	SEE CHART	1	REACTION BAR, 1000 SERIES
	8	25501	1	BAIL

TOOL MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.	REACTION BAR
AES4A12003BQ	25759.001	24860	24696
AES4A12004BQ	25760.002	24860	24696
AES4A12011BQ	25761.003	24709	24696
AES4A12014BQ	25761.005	24792	24697

INSTALL BAIL INTO MOUNTING HOLES ON HANDLE ASSEMBLY, ITEM 1

APPLY LOCTITE 243 (BLUE) PRIOR TO INSTALLATION OF ITEM 5

SEE NOTE #3

SEE NOTE #1

34.9mm (1 3/8") FLATS
40Nm (30 FT.LBS.)

APPLY LOCTITE 243 (BLUE) PRIOR TO INSTALLATION INTO ITEM 5
TIGHTEN TO 40 Nm (30 FT-LBS)

SEE NOTE 1

◆ 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'

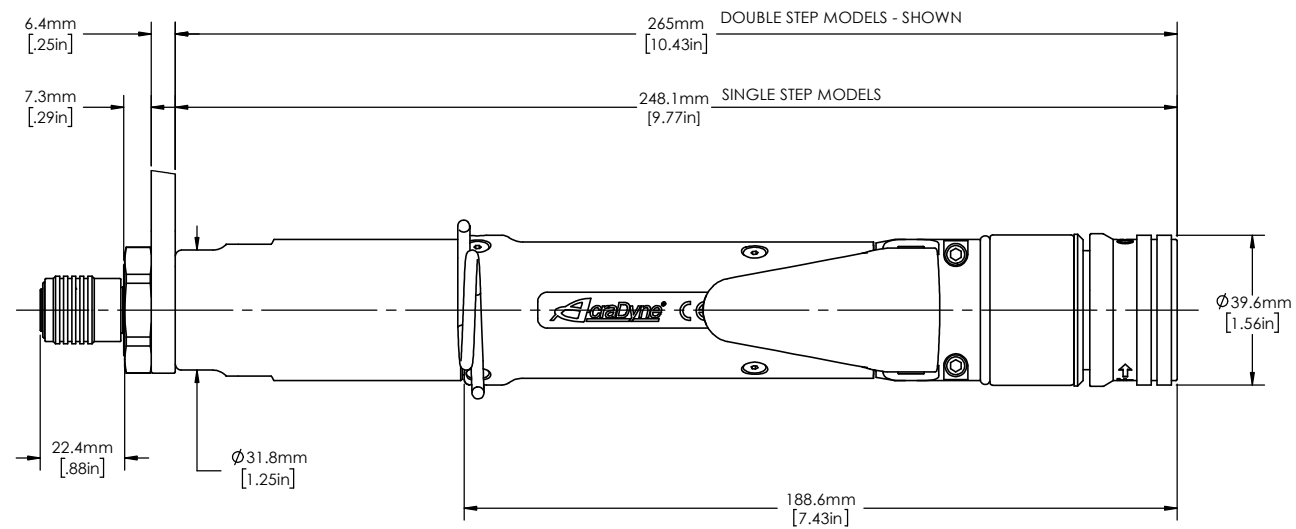
REMOVE BURRS AND SHARP EDGES: R.015 MAX
MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

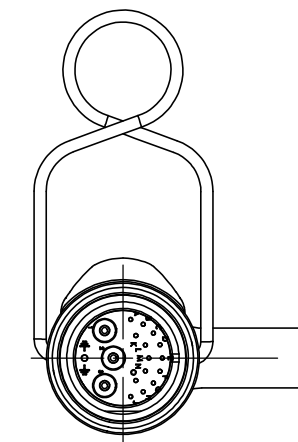
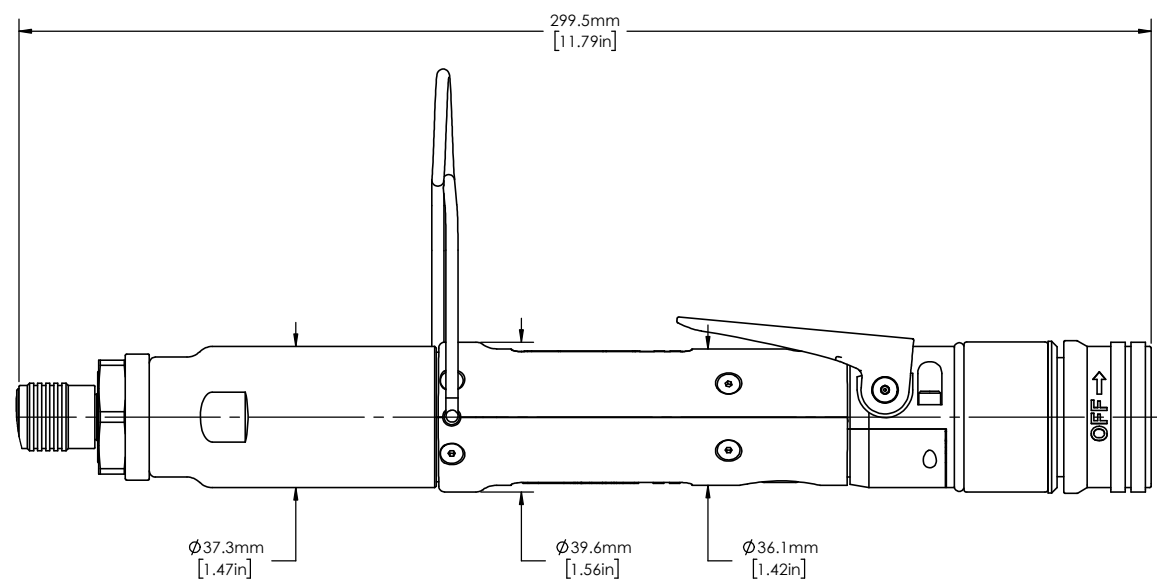
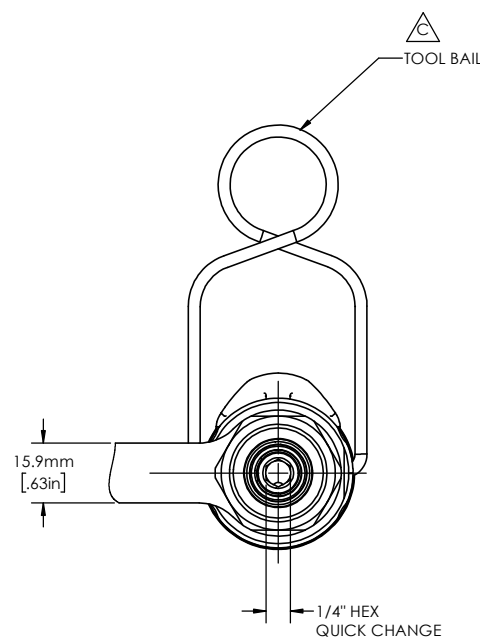
AES4A120_BQ
INLINE NUTRUNNER, Q.C.
GEN IV, 1000 SERIES

SIZE D	PART / DRAWING NUMBER AES4A120_BQ	REVISION C
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SCALE: 1:1 DO NOT SCALE DRAWING SHEET 1 OF 2



	MODEL NO.
SINGLE STEP MODELS	AES4A12003BQ
	AES4A12006BQ
DOUBLE STEP MODELS	AES4A12011BQ
	AES4A12014BQ



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ACRADYNE MECHANICAL ENGINEERING

AES4A120_BQ
INLINE NUTRUNNER, Q.C.
GEN IV, 1000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AES4A120_BQ	C

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