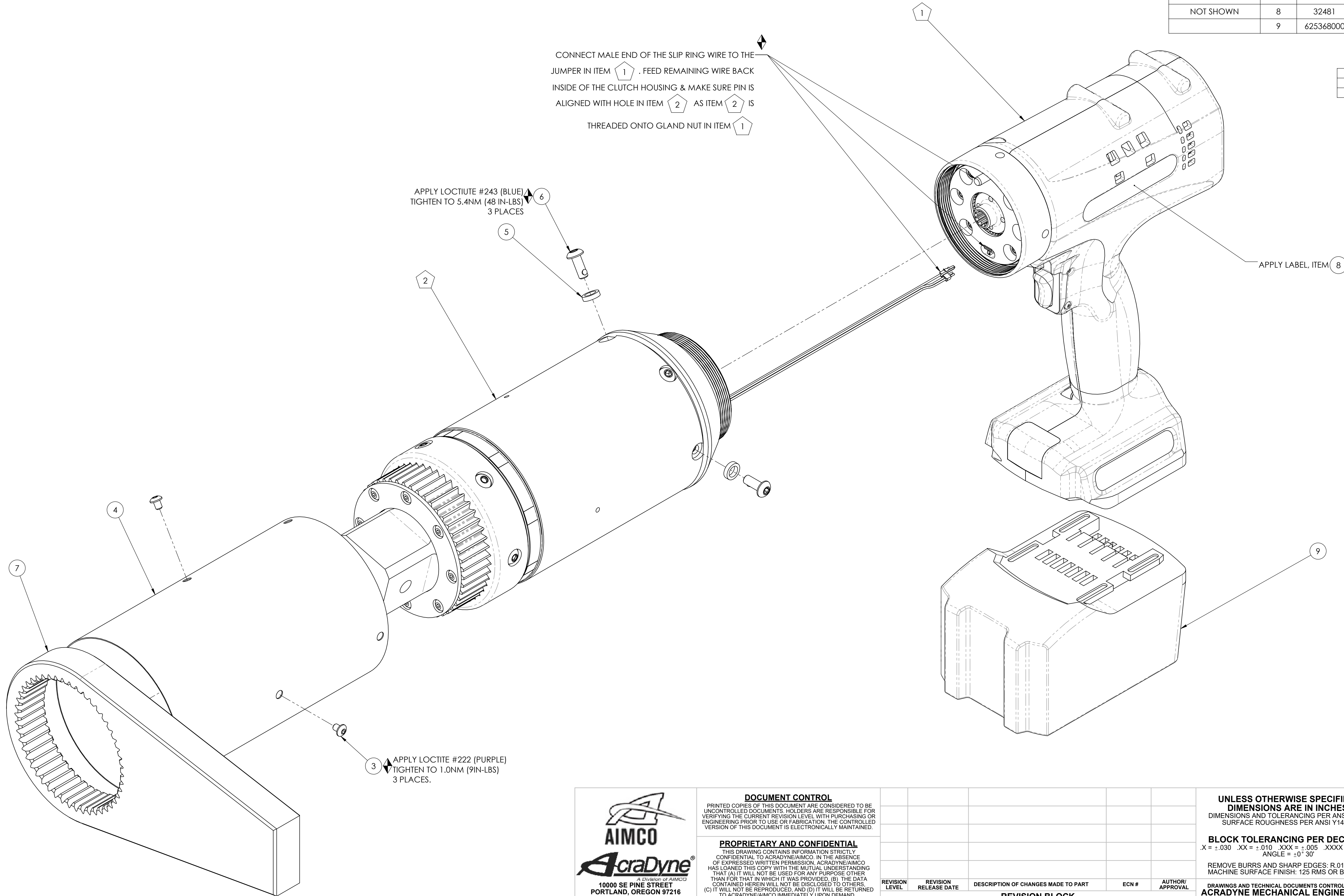


- ◆ ASSEMBLY INSTRUCTIONS
 ◊ SUB-ASSEMBLY
- 1) GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
 - 2) BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
 - 3) O-RINGS: LUBRICATE WITH O-RING LUBE

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	32360.001	1	HT PISTOL HANDLE ASSEMBLY
	2	SEE CHART	1	GEARBOX/SLIP RING ASM., HT 8000-SERIES
	3	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	4	28203	1	HT TOOL TRANSDUCER SLEEVE
	5	25564	3	WASHER SHIM .093THK .25ID .375OD
	6	29284	3	SCREW, BHSC, T0-32 X 1/2, TORX HEAD, NYLON PELL-IT, STEEL
	7	26898	1	CHOOSE REACTION BAR
NOT SHOWN	8	32481	2	LABEL, CORDLESS SERIES HT TOOLS
	9	625368000	1	BATTERY, 5.5Ah, 18V, LION

TOOL MODEL	GEARBOX ASM.
ACP4B185000A	31923



CONNECT MALE END OF THE SLIP RING WIRE TO THE JUMPER IN ITEM 1. FEED REMAINING WIRE BACK INSIDE OF THE CLUTCH HOUSING & MAKE SURE PIN IS ALIGNED WITH HOLE IN ITEM 2 AS ITEM 2 IS THREADED ONTO GLAND NUT IN ITEM 1

APPLY LOCTIUTE #243 (BLUE) TIGHTEN TO 5.4NM (48 IN-LBS) 3 PLACES

APPLY LOCTIUTE #222 (PURPLE) TIGHTEN TO 1.0NM (9IN-LBS) 3 PLACES.

APPLY LABEL, ITEM 8



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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

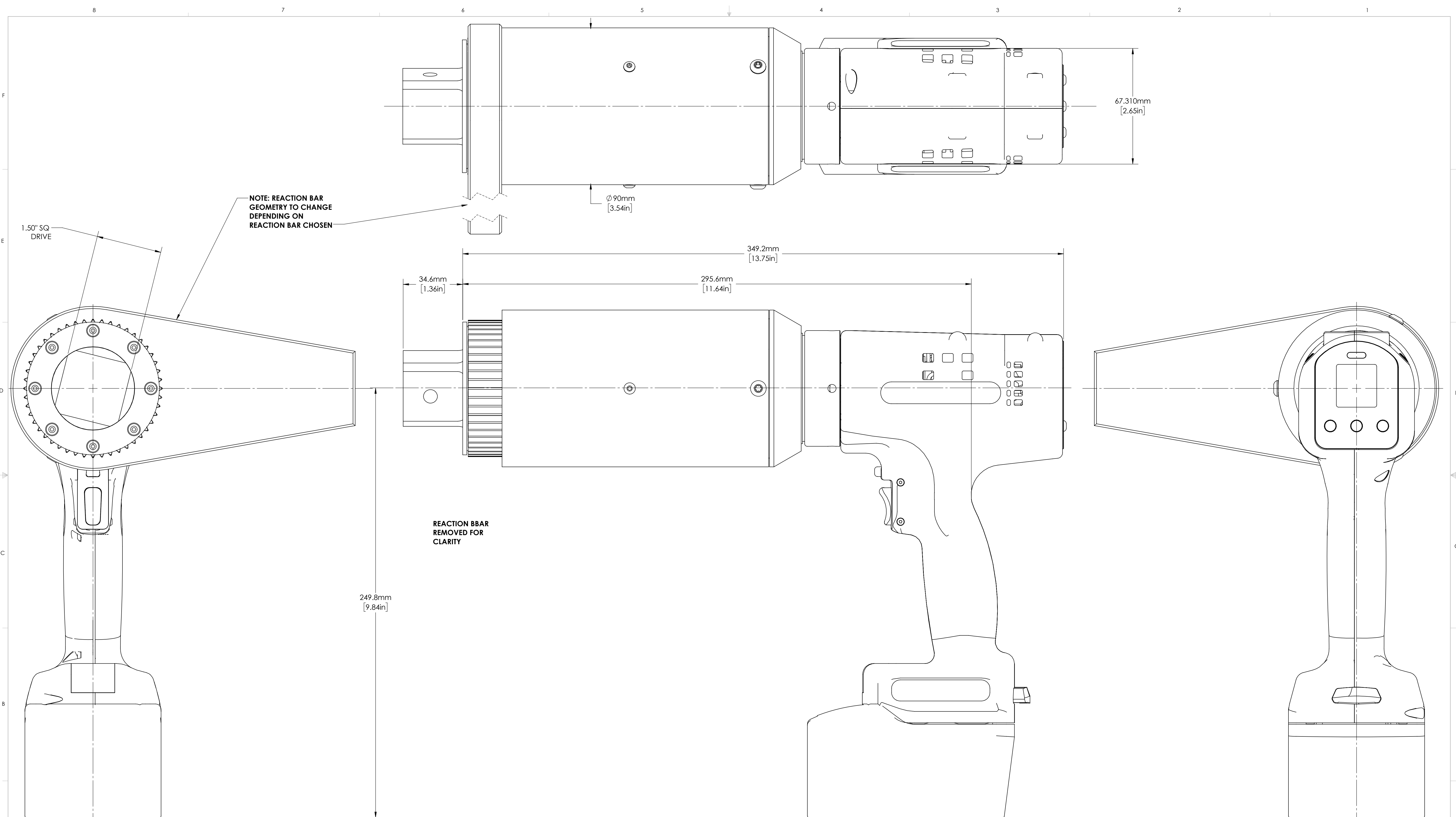
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SIZE	PART / DRAWING NUMBER	REVISION
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SCALE: 1:1 DO NOT SCALE DRAWING SHEET 1 OF 2



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D	ACP4B18_ _ _ A	A

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