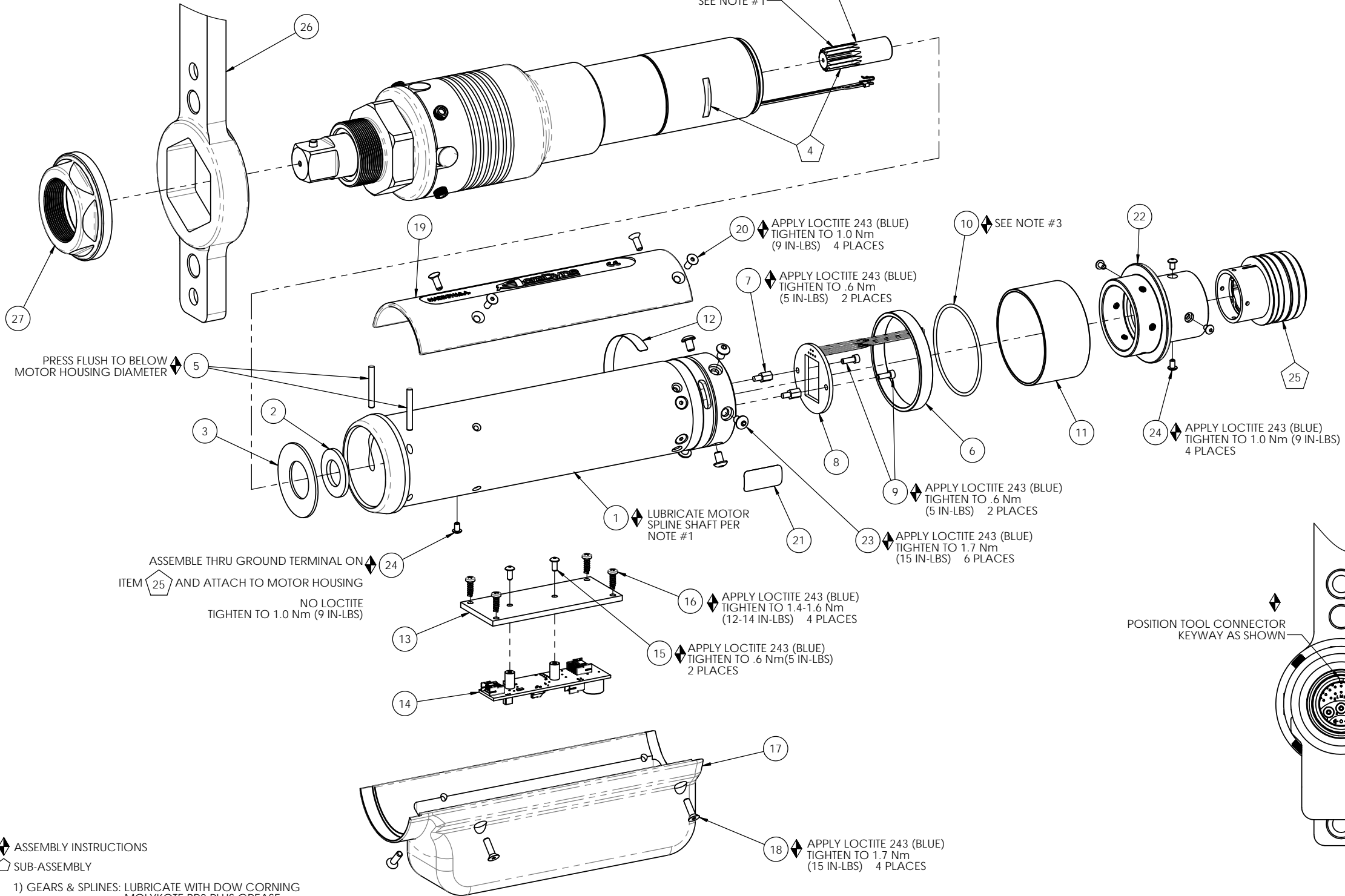


MOTOR PINION IS PART OF GEAR TRAIN ASSEMBLY (SHOWN FOR CLARITY)  
LUBRICATE INTERNAL O-RING PER NOTE #3  
AND SLIDE PINION ONTO MOTOR SHAFT  
UNTIL O-RING SEATS IN GROOVE



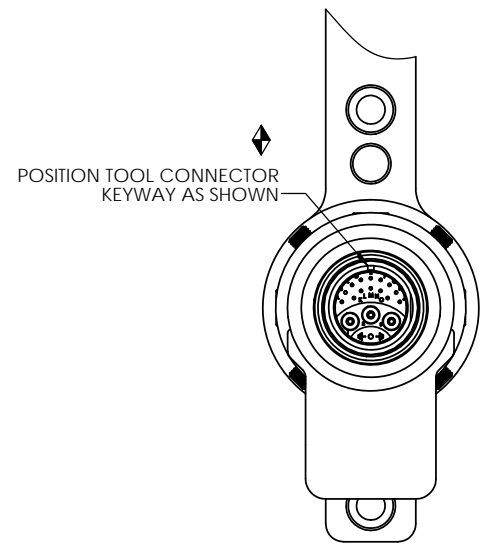
◆ ASSEMBLY INSTRUCTIONS  
◻ SUB-ASSEMBLY

- 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
LOCTITE 243 (BLUE)
1/16 HEX WRENCH
5/64 HEX WRENCH
3/32 HEX WRENCH
7/32 HEX WRENCH
#1 PHILLIPS DRIVER

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26213	1	PISTON MOTOR ASSEMBLY
	2	26198	1	THRUST WASHER
	3	26074	1	BELLEVILLE WASHER
	4	SEE CHART	1	GEARBOX ASM. - TRIPLE STEP
	5	26530	2	DOWEL PIN, Ø1/8 x 1.00, STEEL
	6	27391	1	PIN RETAINER RING
	7	25574	2	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
	8	26359	1	FIXTURE TOOL LED BOARD ASM.
	9	26078	2	SHC SCREW, 4-40, BLACK OXIDE
	10	26080	1	O-RING, LED LIGHT RING COVER
	11	26079	1	LIGHT RING COVER, LED
	12	20534	1	3000 SERIAL/MODEL LABEL
	13	26397	1	SUPPORT, CIRCUIT BOARD
	14	25847	1	TID BOARD ASM.
	15	26404	2	SCREW, BHSC, 4-40 X 1/4, STEEL
	16	24917	4	BHCS, #4 x .38 LG TAP-TITE
	17	26396	1	HOUSING, CIRCUIT BOARD
	18	26439	4	SCREW, FHSC, 6-32 x .500, STEEL, BLACK OXIDE
	19	26081	1	MOTOR HOUSING COVER
	20	25385	4	SCREW, FHSC 6-32 X .375, STEEL
	21	22141	1	SAFETY LABEL
	22	26398	1	STRAIGHT ADAPTER
	23	26088	6	SCREW, BHCS 8-32X.25, STEEL, BLACK OXIDE
	24	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	25	26407	1	TOOL CONNECTOR ASM., FIXTURED
	26	23793	1	REACTION BAR
	27	23792	1	RETAINING NUT, HEX

MODEL NO.	GEARBOX ASM.
AEF35280A	26202
AEF35350A	26203
AEF35420A	26201
AEF35515A	26200
AEF35635A	26129



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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

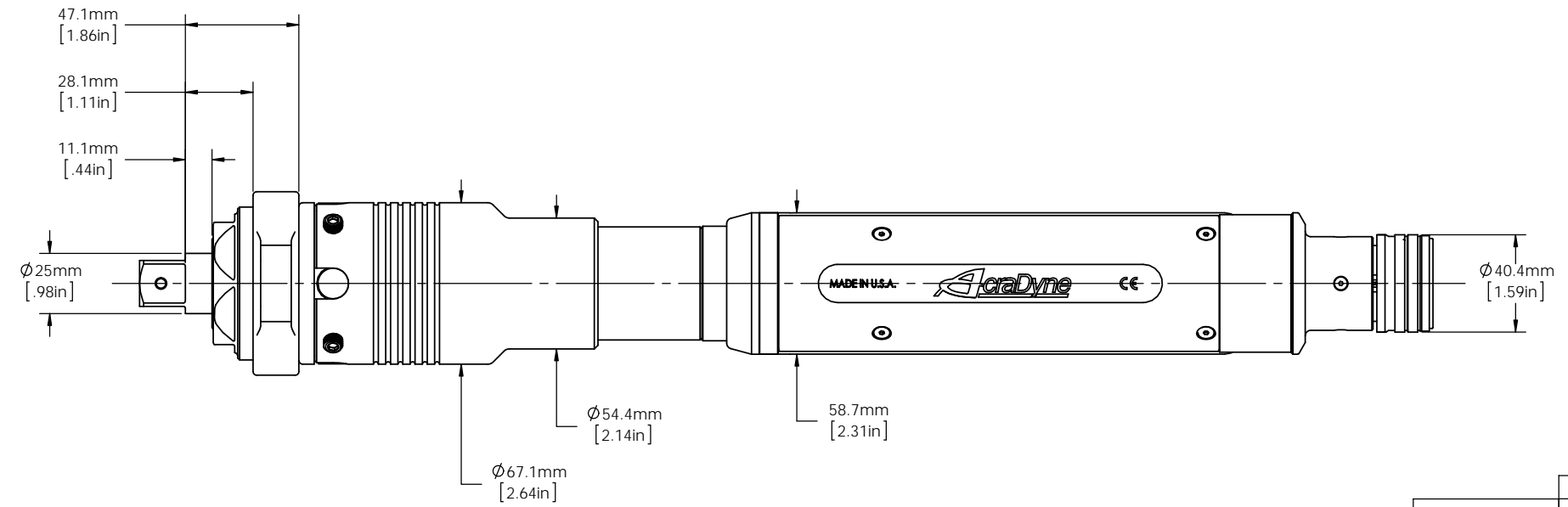
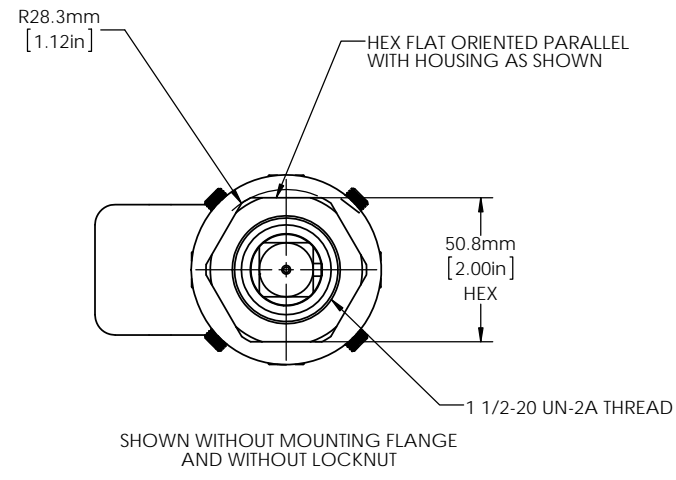
**BLOCK TOLERANCING PER DECIMAL:**  
.X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005  
ANGLE = 80°/30°

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

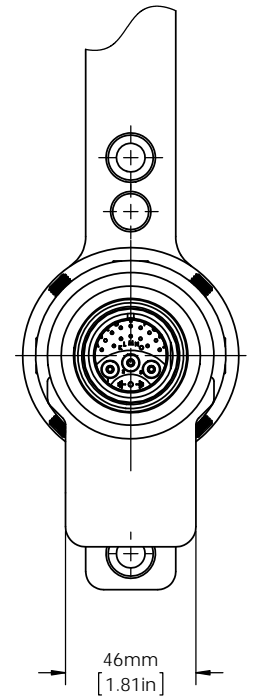
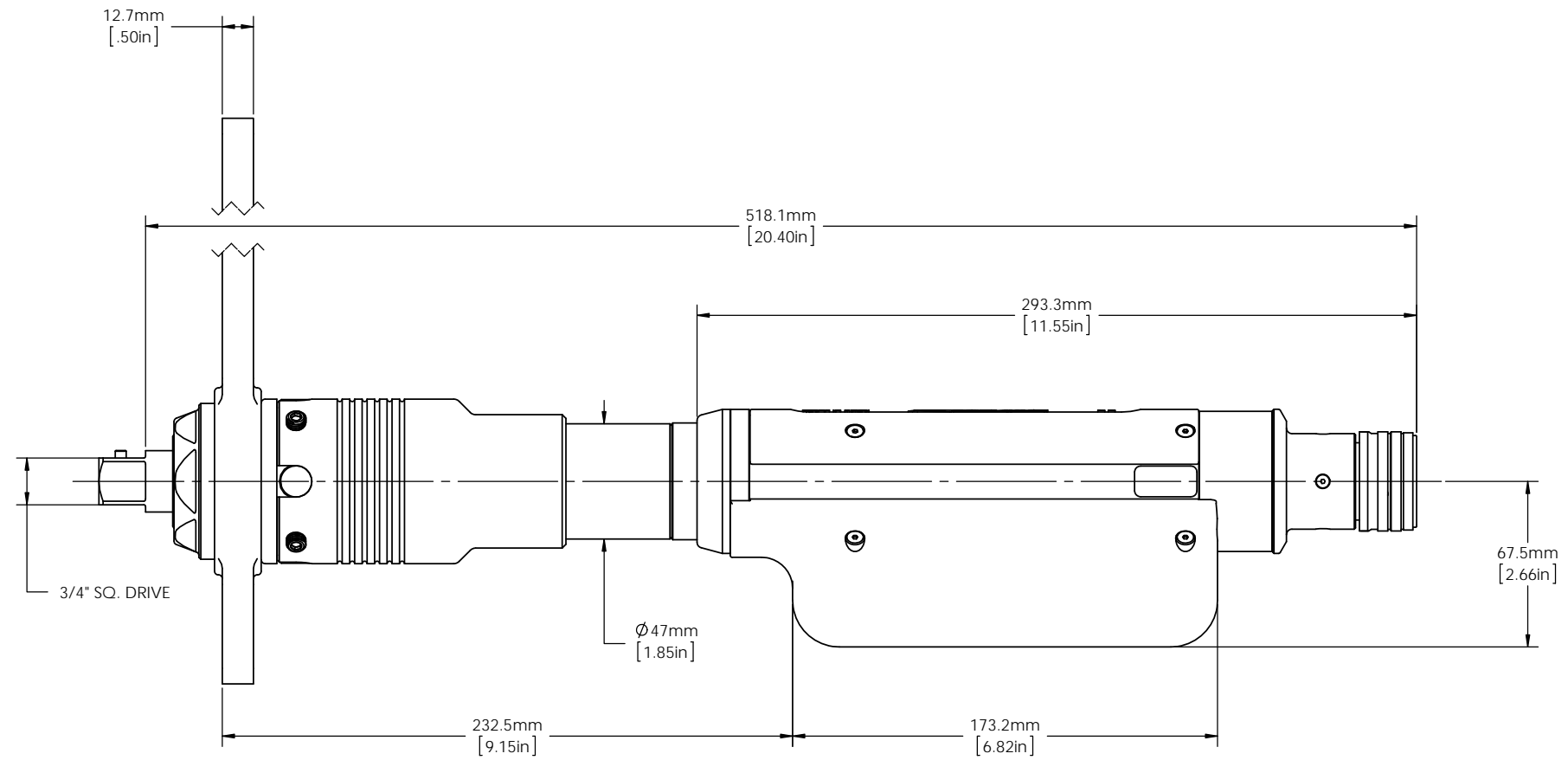
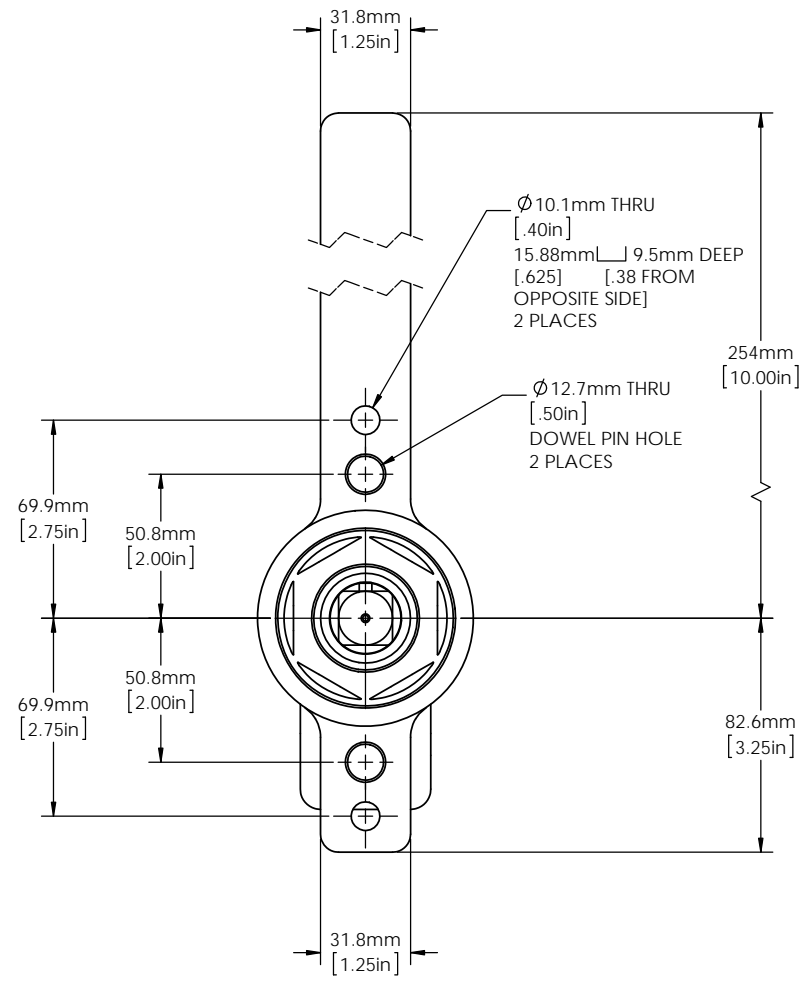
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**ACRADYNE MECHANICAL ENGINEERING**

SIZE	PART / DRAWING NUMBER	REVISION
D	AEF35__ _A	A

SCALE 3:4 DO NOT SCALE DRAWING SHEET 1 OF 2



CATALOG NO.	MODEL NO.
	AEF35280A
	AEF35350A
	AEF35420A
	AEF35515A
	AEF35635A



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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 = 50° 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**

<b>FIXTURED NUTRUNNER 5000 SERIES, GEN 3</b>		
SIZE <b>D</b>	PART / DRAWING NUMBER <b>AEF35__ _A</b>	REVISION <b>A</b>
SCALE 3:4	DO NOT SCALE DRAWING	SHEET 2 OF 2