

GROUND WIRE ATTACHMENT DETAILS

ITEM (25) CONNECTION POINTS

ITEM (19) GROUND WIRE ATTACHMENT POINT USING ITEM (8).
NO LOCTITE

SEE NOTE #3 (10)

TIGHTEN TO 5.4 Nm (48 IN-LBS) 6 PLACES (12)

SEE NOTE #1 (11)

TIGHTEN TO 5.4 Nm (48 IN-LBS) 6 PLACES (12)

SECURE ALL ELECTRICAL CONNECTIONS WITH ITEM (20) (5)

SECURE TO HOUSING WITH SILICONE ITEM (30) (RTV 108) 2 PLACES (3)

NO LOCTITE TIGHTEN TO .6 Nm (5 IN-LBS) 4 PLACES (4)

ORIENT TAB ON CLIP WITH SLOT IN TOOL CONNECTOR

VIEW INSIDE END CAP

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 20 Nm (15 FT-LBS) SEE "GROUND WIRE ATTACHMENT DETAILS" (19)

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 2.8 Nm (25 IN-LBS) 4 PLACES (18)

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 2.3 Nm (20 IN-LBS) 3 PLACES (15)

APPLY LOCTITE 222 (PURPLE) TIGHTEN TO .6 Nm (5 IN-LBS) 4 PLACES (8)

TIGHTEN TO .6 Nm (5 IN-LBS) **NO LOCTITE** 3 PLACES (6)

APPLY LOCTITE 222 (PURPLE) TIGHTEN TO 1.0 Nm (9 IN-LBS) 3 PLACES (27)

REACTION BAR REQUIRED OPTIONAL REACTION BARS AVAILABLE (28)

APPLY LOCTITE 243 (BLUE) TIGHTEN TO 2.3 Nm (20 IN-LBS) 6 PLACES (23)

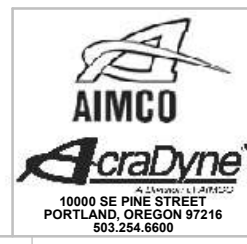
TIGHTEN TO .6Nm (5IN-LBS) **NO LOCTITE** 3 PLACES (8)

CONNECT FEMALE END TO CONNECTOR ON RING GEAR. ATTACH GROUND LUG TO TAPPED HOLE IN BOTTOM OF MOTOR ASM (1) WITH SCREW (8). FEED MALE END THRU THE BOTTOM HOLE IN MOTOR HOUSING AND ATTACH IT TO MATING CONNECTOR ON ITEM (5).

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26160	1	MOTOR ASM.
	2	24840	1	FOIL SEAL 2" DIA
	3	25490	2	LENS, LED, INJECTION MOLDED
	4	29335	4	STANDOFF, M-F, 4-40 X 3/16, SS
	5	27796	1	TID BOARD, POPULATED W/AMP CIRCUIT
	6	29337	3	STANDOFF, M-F, 4-40 X 1/8, SS
	7	29338	1	TID WIRE INSULATOR
	8	25573	8	SCREW PHP 4-40 X 3/16 18-8 SS
	9	31793	1	PINION EXTENSION, 8000-SERIES MOTOR TO 7000-SERIES GEARBOX
	10	26299	1	O-RING, PINION
	11	31792	1	MOTOR ADAPTER, 8000-SERIES MOTOR TO 7000-SERIES GEARBOX
	12	29279	12	SCREW, BHSC, 10-32 x 3/8, TORX HEAD, NYLON PELL-II, STEEL
	13	28111	1	GEAR BOX ASM.
	14	25225	1	END GRIP CAP, HT TOOLS
	15	24859	3	LHSC 10-32 X 1/4 BLK OXIDE
	16	27063	1	TOOL CONNECTOR CLIP
	17	26458	1	SCREW, SHC 10-32 X .44 LG., STEEL, BLACK OXIDE
	18	25568	4	SHC 10-32 x 1.25 BLK OXIDE
	19	25507	1	TOOL CONNECTOR ASM HERC PISTOL
NOT SHOWN	20	28257	A/R	CABLE TIE, 1.65MM W X 71MM LG.
	21	25579	1	PLUG 3/8"
	22	25231	1	TRAY, WIRE, END GRIP
	23	25569	6	SCREW LHCS 10-32 X 3/8 18-8 SS
	24	28211	1	(4) LINE MALE/FEMALE JUMPER ASM.
	25	31412	1	GROUND WIRE ASSEMBLY, 18 AWG, 8000 & 9000 HT SERIES
	26	26295	1	GEAR CASE COVER, 2500 Nm
	27	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
	28	26897	1	CHOOSE REACTION BAR
	29	26243	1	RETAINING RING, SPIRAL, Ø2.864 X Ø2.464 X .078
NOT SHOWN	30	24177	A/R	RTV 108, TRANSLUCENT

- ◆ 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



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

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DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36

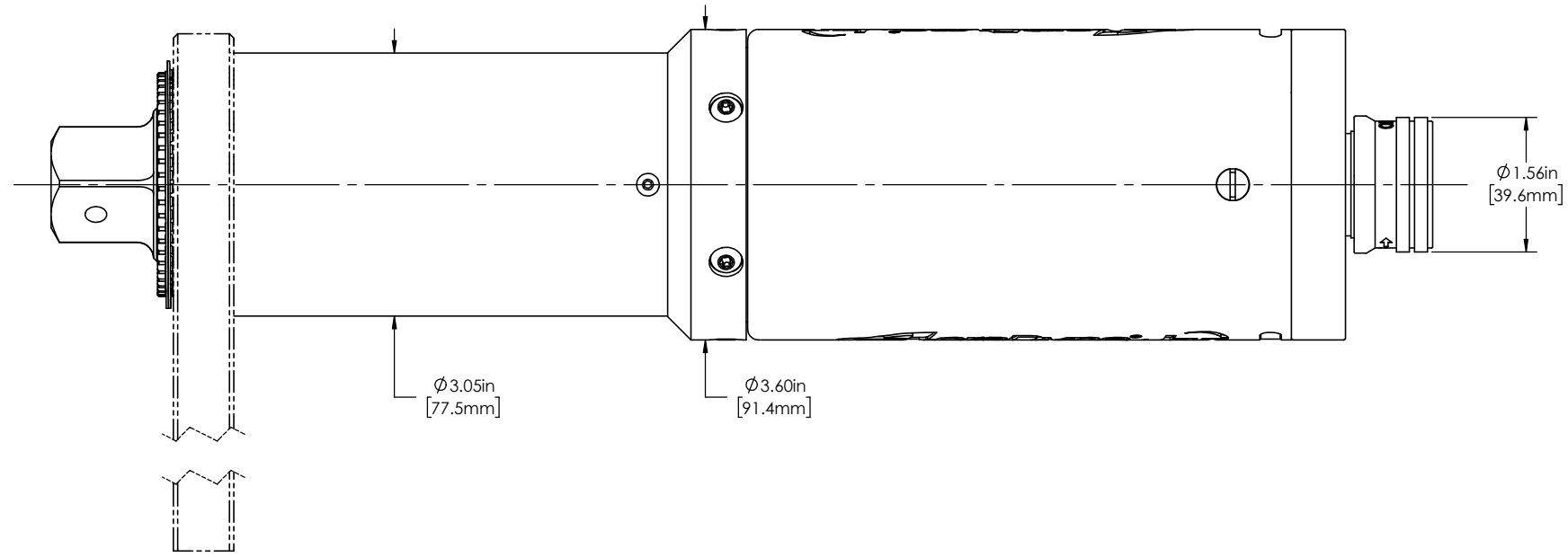
BLOCK TOLERANCING PER DECIMAL:
X = ±.030 XX = ±.010 XXX = ±.005 .XXXX = ±.0005
ANGLE = ±0° 30'

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

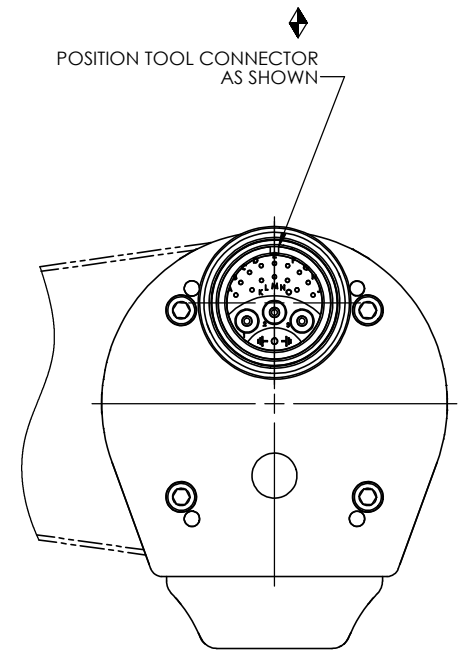
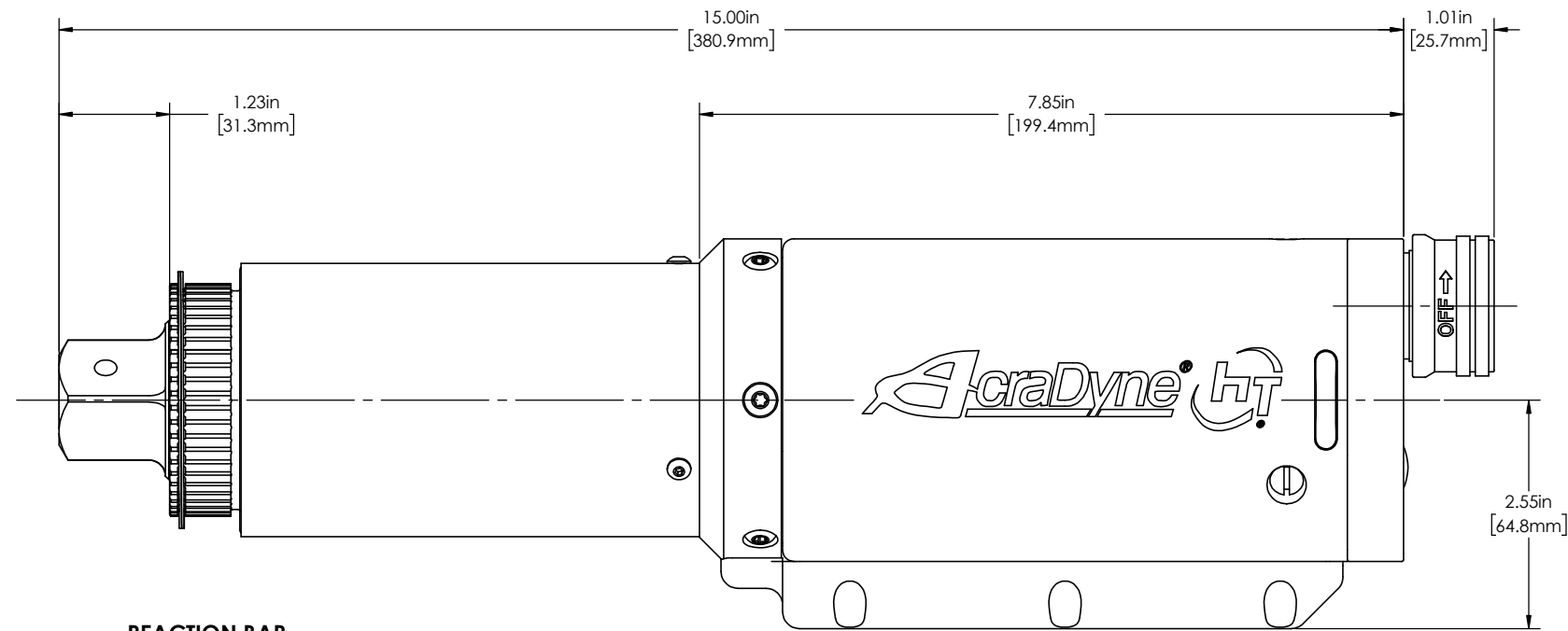
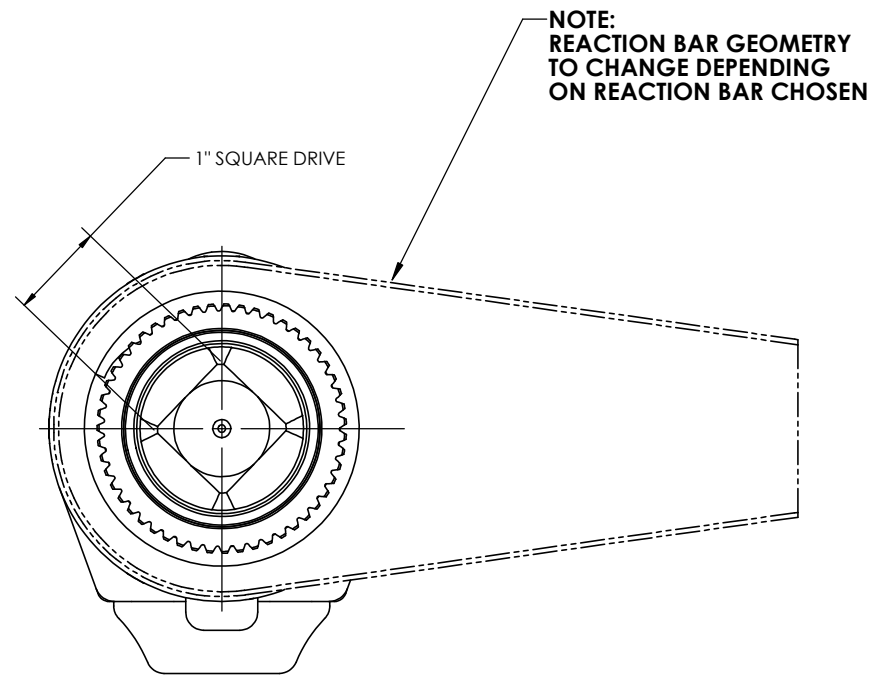
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ACRADYNE MECHANICAL ENGINEERING

FIXTURED NUTRUNNER, 2800Nm 8000-SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4A872800B	A
SCALE: 2:3	DO NOT SCALE DRAWING	SHEET 1 OF 2



MODEL NO.	SQUARE DRIVE
AEF4A872800B	1"



REACTION BAR NOT SHOWN FOR CLARITY



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 MACHINE SURFACE FINISH: 125 RMS OR BETTER

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**FIXTURED NUTRUNNER
 2800Nm
 8000-SERIES**

SIZE	PART / DRAWING NUMBER	REVISION
D	AEF4A872800B	A
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 2