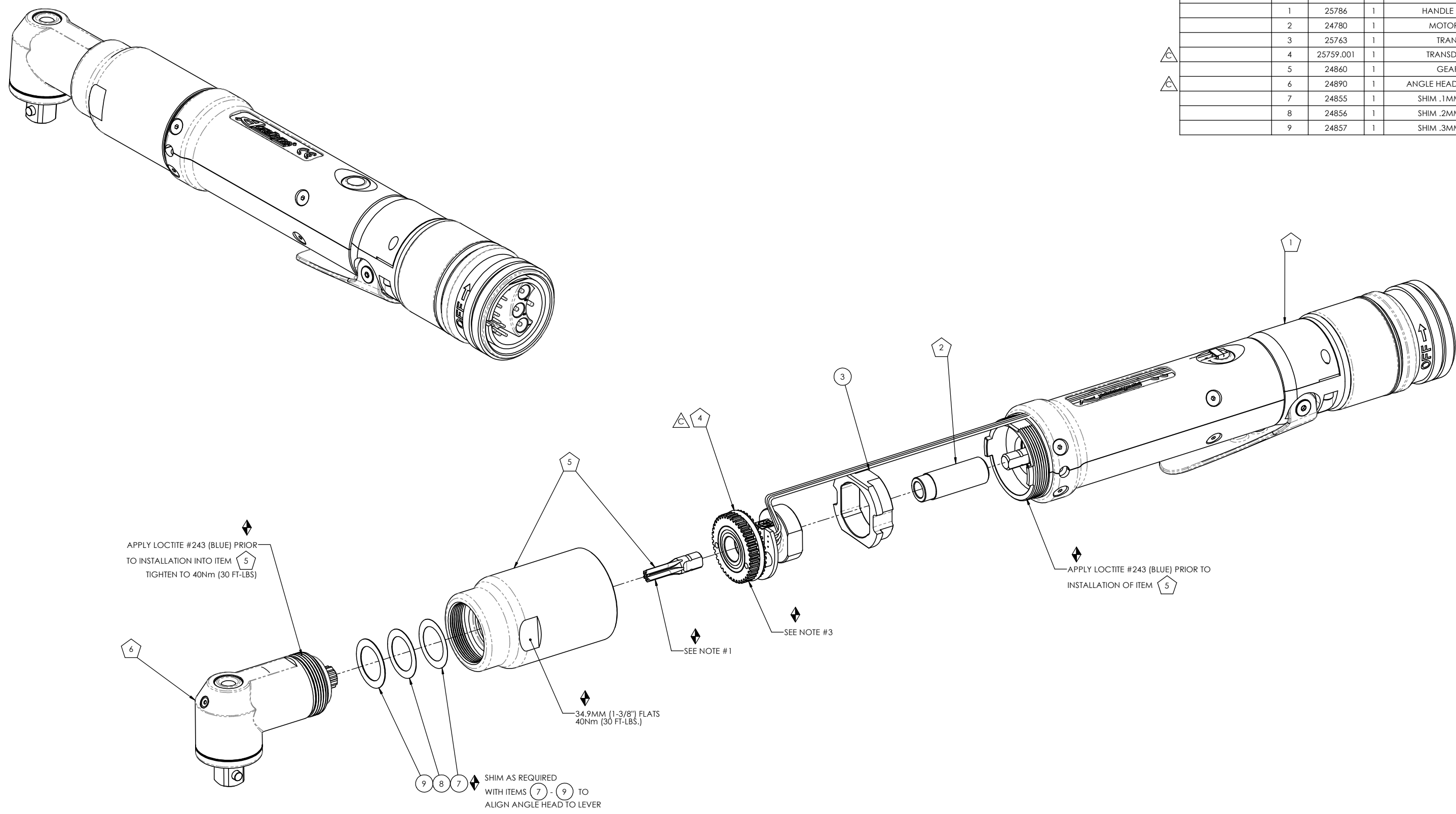


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25786	1	HANDLE ASSEMBLY- 1000 SERIES
	2	24780	1	MOTOR COUPLER SUB-ASM.
	3	25763	1	TRANSDUCER ADAPTOR
△	4	25759.001	1	TRANSDUCER SUB-ASM., 3Nm
	5	24860	1	GEAR CASE SUB-ASM 6T
△	6	24890	1	ANGLE HEAD ASM, STUBBY, 3/8" SQ. DR.
	7	24855	1	SHIM .1MM, 14MM ID X 20MM OD
	8	24856	1	SHIM .2MM, 14MM ID X 20MM OD
	9	24857	1	SHIM .3MM, 14MM ID X 20MM OD



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

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

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

SHIM AS REQUIRED WITH ITEMS 7 - 9 TO ALIGN ANGLE HEAD TO LEVER

SEE NOTE #1

SEE NOTE #3

◆ 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

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
 DIMENSIONS AND TOLERANCING PER ANSI Y14.5 SURFACE ROUGHNESS PER ANSI Y14.36

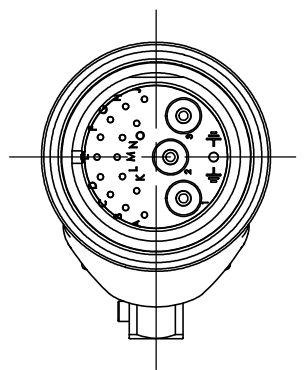
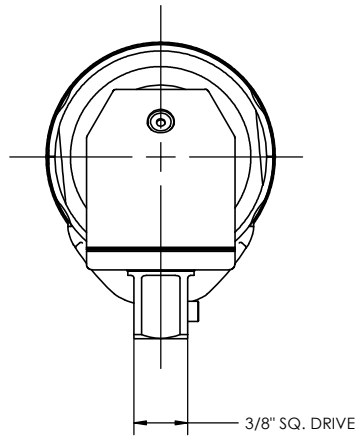
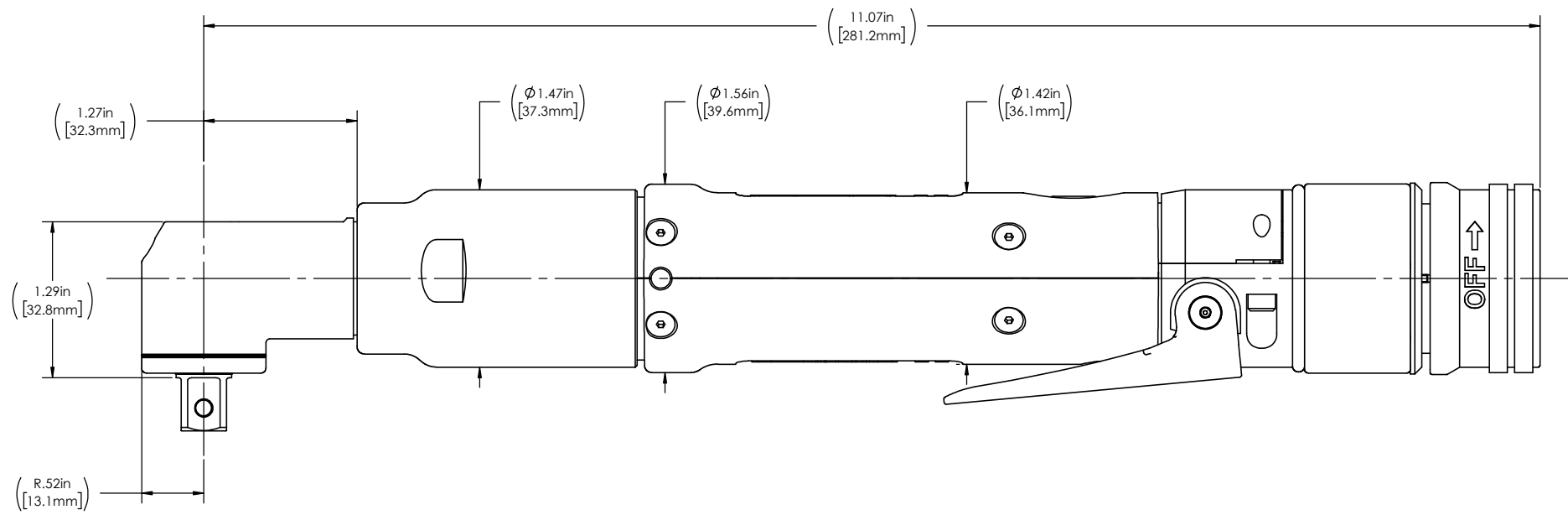
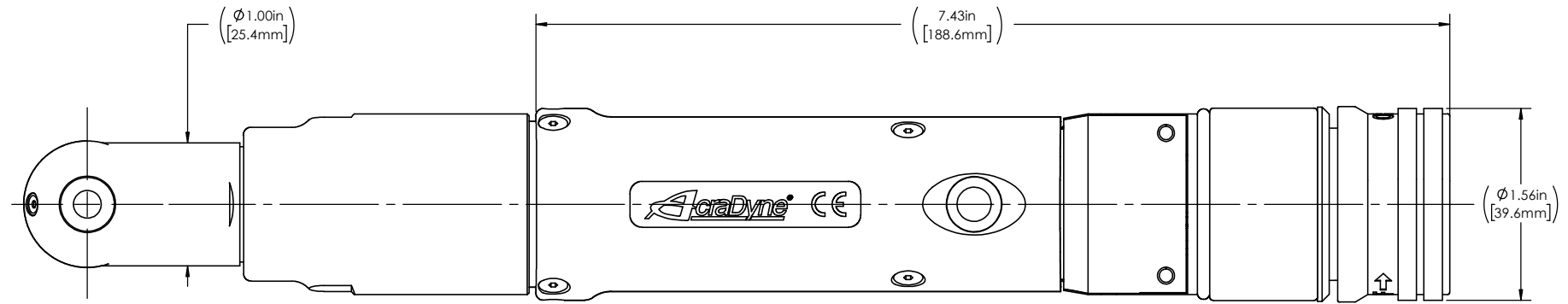
BLOCK TOLERANCING PER DECIMAL:
 .X = ±.030 .XX = ±.010 .XXX = ±.005 .XXXX = ±.0005
 ANGLE = ±0° 30'

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

**AEN4C12004B
 ANGLE NUTRUNNER, 4Nm
 1000-SERIES**

SIZE D	PART / DRAWING NUMBER AEN4C12004B	REVISION C
SCALE: 4:3	DO NOT SCALE DRAWING	SHEET 1 OF 2



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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

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DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

AEN4C12004B
ANGLE NUTRUNNER, 4 Nm
1000 SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEN4C12004B	C

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