

ASSEMBLY INSTRUCTIONS
SUB-ASSEMBLY

- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- BEARINGS: LUBRICATE WITH CHEVRON SRI GREASE
- O-RINGS: LUBRICATE WITH O-RING LUBE
- APPLY LOCTITE 222 (PURPLE), TIGHTEN TO 1.0 Nm (9 IN-LBS)

MODEL NO.	GEAR CASE SUB-ASM	ANGLEHEAD ASM.	TRANSDUCER SUB-ASM.	SHIMS
AEN4C22014CV	24860	25769	31048.001	24855/24856/24857
AEN4C22024CV	24709	25769	31048.003	24855/24856/24857
AEN4F22029CV	24901	31457	31048.004	21091/21092/21093
AEN4F22036CV	24894	31457	31045.001	21091/21092/21093
AEN4F22043CV	24902	31457	31045.003	21091/21092/21093
AEN4F22055CV	24904	31457	31045.005	21091/21092/21093

COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	28766	1	MOTOR ASSEMBLY
	2	SEE CHART	1	GEAR CASE SUB-ASM.
	3	SEE CHART	1	ANGLE HEAD ASM.
	4	28754	1	LEVER HANDLE
	5	29186	1	COVER, LEVER HANDLE
	6	25763	1	TRANSDUCER ADAPTOR
	7	24780	1	MOTOR COUPLER SUB-ASM.
	8	SEE CHART	1	TRANSDUCER SUB-ASM.
	9	29202	1	TRIGGER CABLE ASM., 6 PIN - 6 PIN
	10	29191	1	TRIGGER/MFG BOARD ASM., 2000-SERIES, GEN 4
	11	28767	1	TOOL CONN. ASM.
	12	30966	1	LED BOARD ASM, I2C
	13	24679	1	RETAINING RNG
	14	24683	1	SPRING, REV BUTTON
	15	25557	1	REV BUTTON SUB-ASSEMBLY
	16	29189	1	TRIGGER SUB-ASM.
	17	31051	1	DOWEL PIN, Ø.094 X .75, GROOVED, STEEL, ZINC PLATED
	18	31061	2	DOWEL PIN, Ø.032 X 1/4, STEEL
	19	28760	1	LED COVER
	20	28753	2	MOTOR COVER, SMALL MOTOR O.D.
	21	22141	1	SAFETY LABEL
	22	20132	1	THROTTLE SPRING
	23	27235	2	O-RING, BUNA-N, #28
	24	23753	8	SCREW, FHSC 6-32x5/16, 18-8 SS
	25	27455	6	SCREW, SHC 4-40 x .188, STEEL, BLACK OXIDE
	26	26078	4	SCREW, SHC 4-40 X 5/16, BLK OXIDE
	27	AEN4C TOOLS ONLY	29	SHIM .1MM, 14MM ID X 20MM OD
	28	AEN4C TOOLS ONLY	28	SHIM .2MM, 14MM ID X 20MM OD
	29	AEN4C TOOLS ONLY	29	SHIM .3MM, 14MM ID X 20MM OD
	30	AEN4C TOOLS ONLY	21091	SHIM, PINION SHAFT, .002 --- 2000 SERIES
	31	AEN4F TOOLS ONLY	21092	SHIM, PINION SHAFT, .005 --- 2000 SERIES
	32	AEN4F TOOLS ONLY	21093	SHIM, PINION SHAFT, .010 --- 2000 SERIES
	33	23741	1	SHIM, OUTPUT, .002 IN, 40 NM
	34	21022	1	SHIM, BLANK OUTPUT SHAFT, 0.005 THK
	35	21021	1	SHIM, BLANK OUTPUT SHAFT, 0.010 THK
	36	20534	1	2000 SERIAL/MODEL LABEL
	37	28257	A/R	CABLE TIE, 1.65mm X 71mm
	38	25471	1	LABEL SN# COVER, .25 X 4"
	39	25130	1	SCREW, BHSC,4-40 X 1/4, STEEL
	40	50061	A/R	RTV 3145, CLEAR



DOCUMENT CONTROL

PRINTED COPY OF THIS DRAWING IS UNCONTROLLED. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL

THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL AND PROPRIETARY TO ACRADYNE/AIMCO. IT IS LOANED TO THE HOLDER FOR THE EXPRESS PURPOSE OF ASSEMBLY. IT IS THE UNDERSTANDING THAT (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN ASSEMBLY, (B) IT WILL NOT BE COPIED OR REPRODUCED, (C) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS, (D) IT WILL NOT BE REPRODUCED, AND (E) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

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

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

BLOCK TOLERANCING PER DECIMAL:
 $X = \pm 0.030$ $XX = \pm 0.10$ $XXX = \pm 0.005$ $XXXX = \pm 0.0005$
ANGLE = $\pm 0^\circ 30'$

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

ANGLE NUTRUNNER, EXT.
OUTPUT, 3/8" SQ. DR.

GEN 4 2000 SERIES

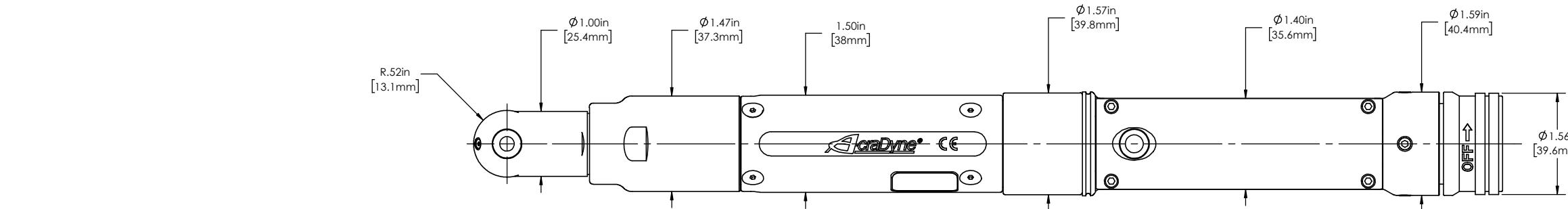
PART / DRAWING NUMBER

REVISION

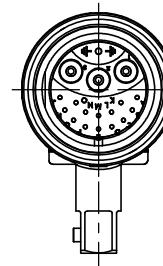
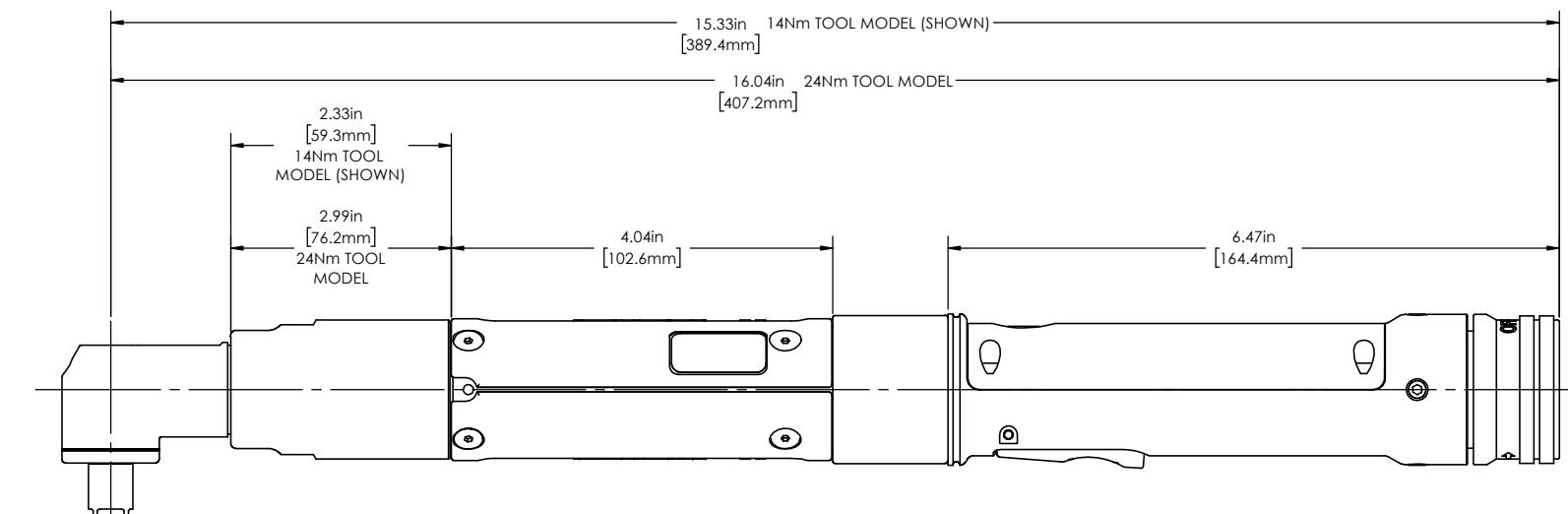
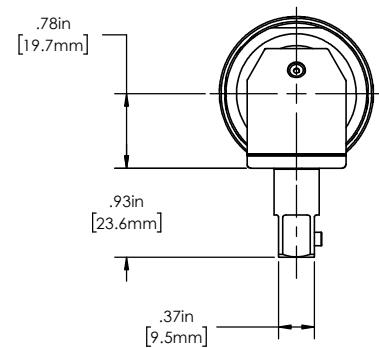
D AEN4_220_CV B

SCALE 1:1 DO NOT SCALE DRAWING

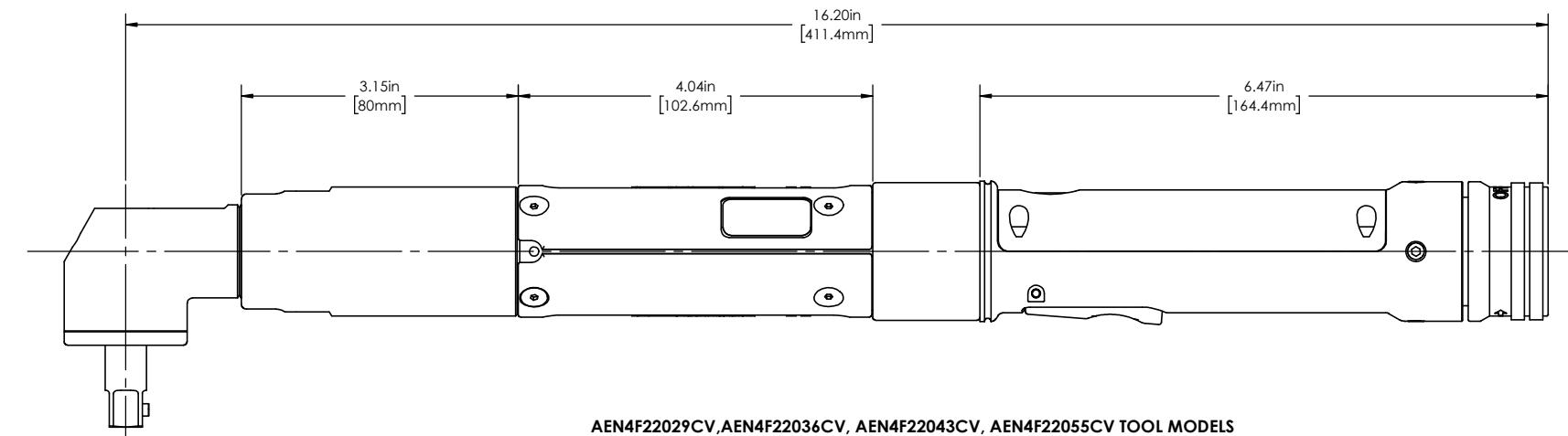
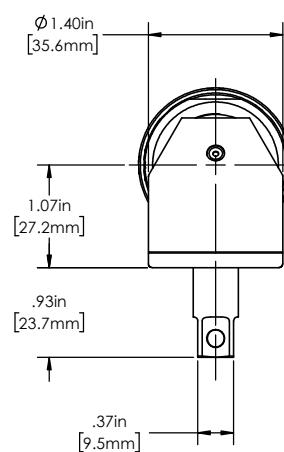
SHEET 1 OF 2



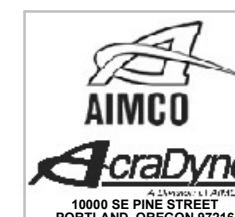
TOOL MODEL NO.
AEN4C22014CV
AEN4C22024CV
AEN4F22029CV
AEN4F22036CV
AEN4F22043CV
AEN4F22055CV



AEN4C22014CV, AEN4C22024CV TOOL MODELS



AEN4F22029CV, AEN4F22036CV, AEN4F22043CV, AEN4F22055CV TOOL MODELS



DOCUMENT CONTROL
PRINTED COPIES OF THIS DRAWING ARE UNCONTROLLED DOCUMENTS. HOLDERS ARE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION LEVEL WITH PURCHASING OR ENGINEERING PRIOR TO USE OR FABRICATION. THE CONTROLLED VERSION OF THIS DOCUMENT IS ELECTRONICALLY MAINTAINED.

PROPRIETARY AND CONFIDENTIAL
THIS DRAWING CONTAINS INFORMATION STRICTLY CONFIDENTIAL TO ACRADYNE/AIMCO. IT IS THE EXCLUSIVE PROPERTY OF ACRADYNE/AIMCO. IT IS LOANED TO THE HOLDER FOR THE EXCLUSIVE USE OF THE HOLDER. (A) IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN THE ONE FOR WHICH IT WAS LOANED. (B) THE DATA CONTAINED HEREIN WILL NOT BE DISCLOSED TO OTHERS. (C) IT WILL NOT BE REPRODUCED, AND (D) IT WILL BE RETURNED TO ACRADYNE/AIMCO IMMEDIATELY UPON DEMAND.

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

BLOCK TOLERANCING PER DECIMAL:
 $X = \pm .030$ $XX = \pm .010$ $XXX = \pm .005$ $XXXX = \pm .0005$
ANGLE = $\pm 0^\circ 30'$

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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

**ANGLE NUTRUNNER, EXT.
OUTPUT, 3/8" SQ. DR.**
GEN 4 2000-SERIES

SIZE	PART / DRAWING NUMBER	REVISION
D	AEN4_220__CV	B

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