

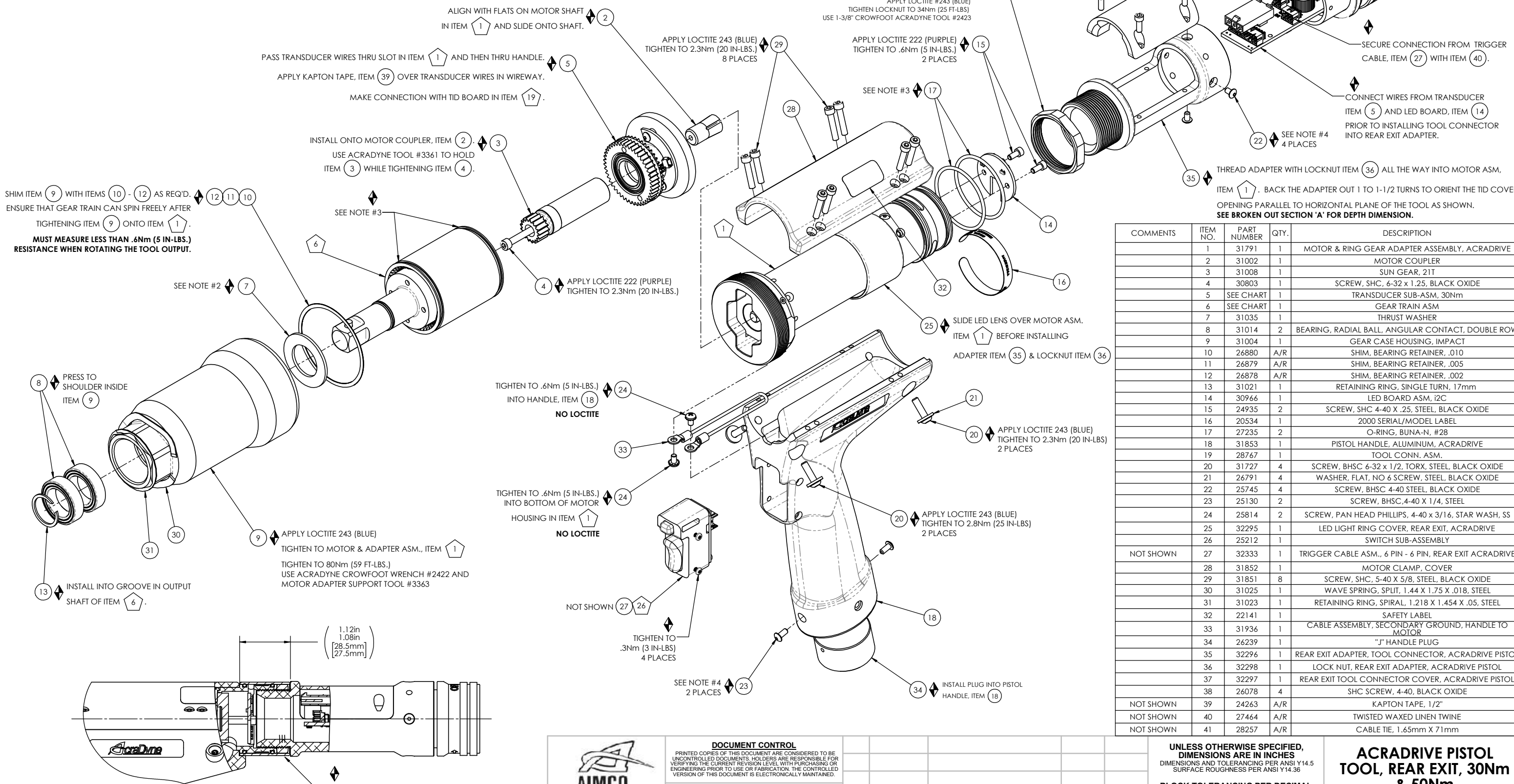
MODEL NO.	GEAR TRAIN ASM.	TRANSDUCER SUB-ASM.
AEP4PR22030AV	31041	31012.002
AEP4PR22050AV	31020	31012.003

REFERENCE WORK INSTRUCTION W2107 FOR DETAILED BUILD INSTRUCTIONS

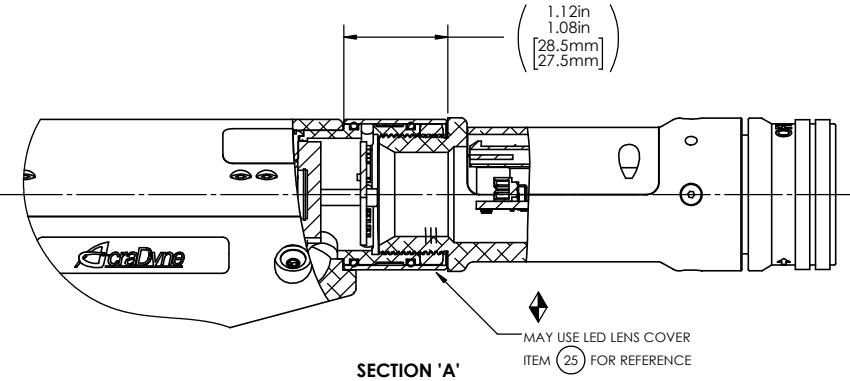
ASSEMBLY INSTRUCTIONS

SUB-ASSEMBLY

- GEARS & SPLINES: LUBRICATE WITH DOW CORNING MOLYKOTE BR2 PLUS GREASE.
- BEARINGS: LUBRICATE WITH CHEVRON SR1 GREASE
- O-RINGS: LUBRICATE WITH O-RING LUBE
- APPLY LOCTITE 222 (PURPLE), TIGHTEN TO 1.0Nm (9 IN-LBS.)



COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	31791	1	MOTOR & RING GEAR ADAPTER ASSEMBLY, ACRADRYNE
	2	31002	1	MOTOR COUPLER
	3	31008	1	SUN GEAR, 21T
	4	30803	1	SCREW, SHC, 6-32 x 1.25, BLACK OXIDE
	5	SEE CHART	1	TRANSDUCER SUB-ASM, 30Nm
	6	SEE CHART	1	GEAR TRAIN ASM
	7	31035	1	THRUST WASHER
	8	31014	2	BEARING, RADIAL BALL, ANGULAR CONTACT, DOUBLE ROW
	9	31004	1	GEAR CASE HOUSING, IMPACT
	10	26880	A/R	SHIM, BEARING RETAINER, .010
	11	26879	A/R	SHIM, BEARING RETAINER, .005
	12	26878	A/R	SHIM, BEARING RETAINER, .002
	13	31021	1	RETAINING RING, SINGLE TURN, 17mm
	14	30966	1	LED BOARD ASM, i2C
	15	24935	2	SCREW, SHC 4-40 X .25, STEEL, BLACK OXIDE
	16	20534	1	2000 SERIAL/MODEL LABEL
	17	27235	2	O-RING, BUNA-N, #28
	18	31853	1	PISTOL HANDLE, ALUMINUM, ACRADRYNE
	19	28767	1	TOOL CONN. ASM.
	20	31727	4	SCREW, BHSC 6-32 x 1/2, TORX, STEEL, BLACK OXIDE
	21	26791	4	WASHER, FLAT, NO 6 SCREW, STEEL, BLACK OXIDE
	22	25745	4	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	23	25130	2	SCREW, BHSC, 4-40 X 1/4, STEEL
	24	25814	2	SCREW, PAN HEAD PHILLIPS, 4-40 x 3/16, STAR WASH, SS
	25	32295	1	LED LIGHT RING COVER, REAR EXIT, ACRADRYNE
	26	25212	1	SWITCH SUB-ASSEMBLY
NOT SHOWN	27	32333	1	TRIGGER CABLE ASM., 6 PIN - 6 PIN, REAR EXIT ACRADRYNE
	28	31852	1	MOTOR CLAMP, COVER
	29	31851	8	SCREW, SHC, 5-40 X 5/8, STEEL, BLACK OXIDE
	30	31025	1	WAVE SPRING, SPLIT, 1.44 X 1.75 X .018, STEEL
	31	31023	1	RETAINING RING, SPIRAL, 1.218 X 1.454 X .05, STEEL
	32	22141	1	SAFETY LABEL
	33	31936	1	CABLE ASSEMBLY, SECONDARY GROUND, HANDLE TO MOTOR
	34	26239	1	"J" HANDLE PLUG
	35	32296	1	REAR EXIT ADAPTER, TOOL CONNECTOR, ACRADRYNE PISTOL
	36	32298	1	LOCK NUT, REAR EXIT ADAPTER, ACRADRYNE PISTOL
	37	32297	1	REAR EXIT TOOL CONNECTOR COVER, ACRADRYNE PISTOL
	38	26078	4	SHC SCREW, 4-40, BLACK OXIDE
NOT SHOWN	39	24263	A/R	KAPTON TAPE, 1/2"
NOT SHOWN	40	27464	A/R	TWISTED WAXED LINEN TWINE
NOT SHOWN	41	28257	A/R	CABLE TIE, 1.65mm X 71mm



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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'

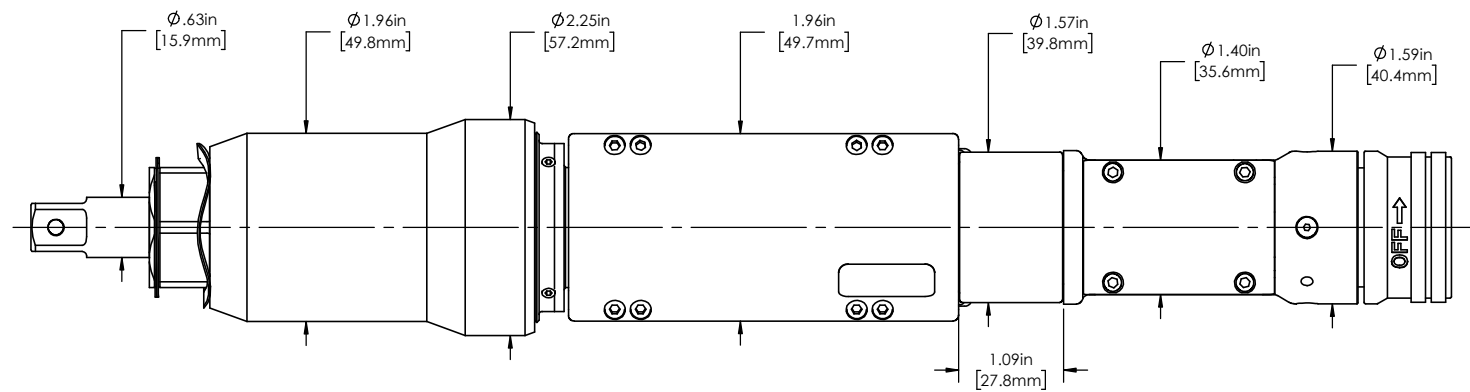
REMOVE BURRS AND SHARP EDGES: R.015 MAX MACHINE SURFACE FINISH: 125 RMS OR BETTER

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
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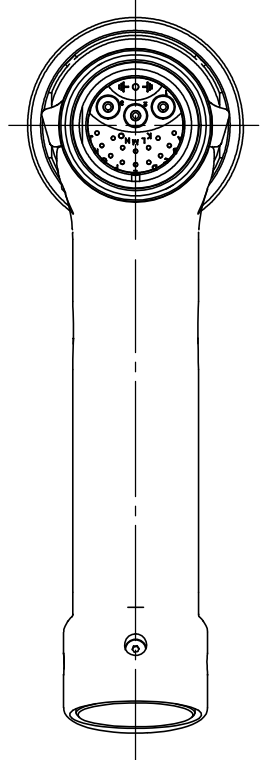
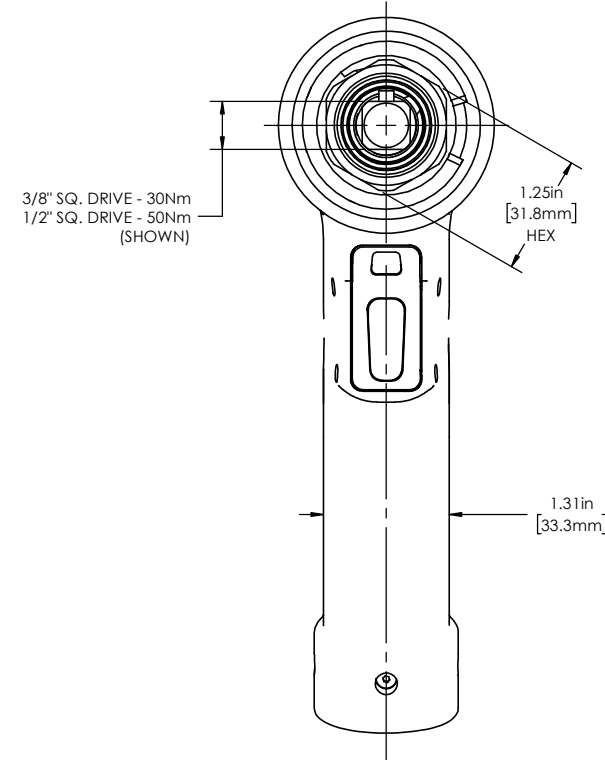
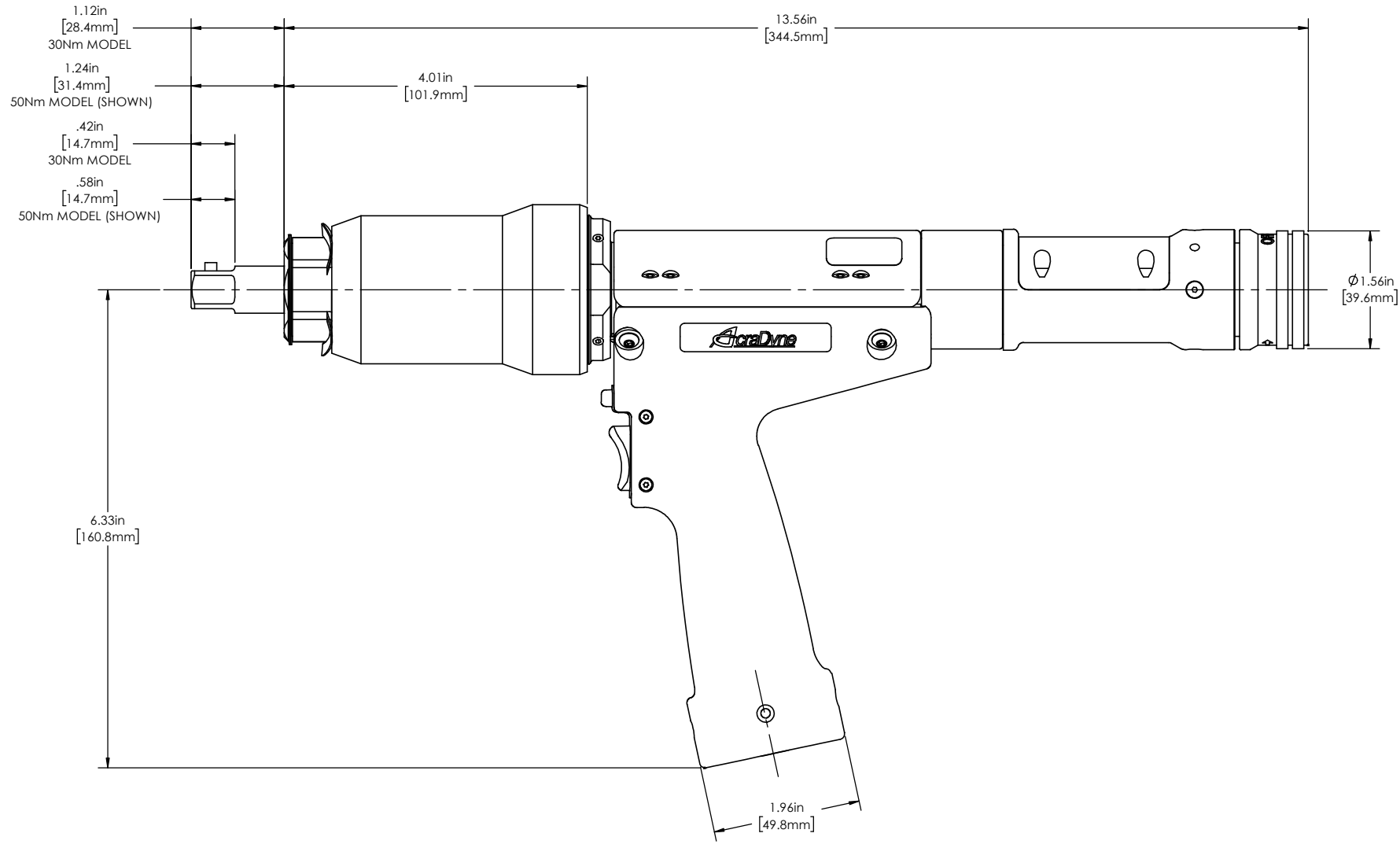
ACRADRYNE PISTOL TOOL, REAR EXIT, 30Nm & 50Nm
 2000 SERIES, GEN 4C

SIZE	PART / DRAWING NUMBER	REVISION
D	AEP4PR220 AV	A

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



MODEL NO.
AEP4PR22030AV
AEP4PR22050AV



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ACRADYNE MECHANICAL ENGINEERING

ACRADYNE PISTOL TOOL, REAR EXIT, 30Nm & 50Nm
 2000 SERIES, GEN 4C

SIZE	PART / DRAWING NUMBER	REVISION
D	AEP4PR220_AV	A
SCALE: 1:1	DO NOT SCALE DRAWING	SHEET 2 OF 3