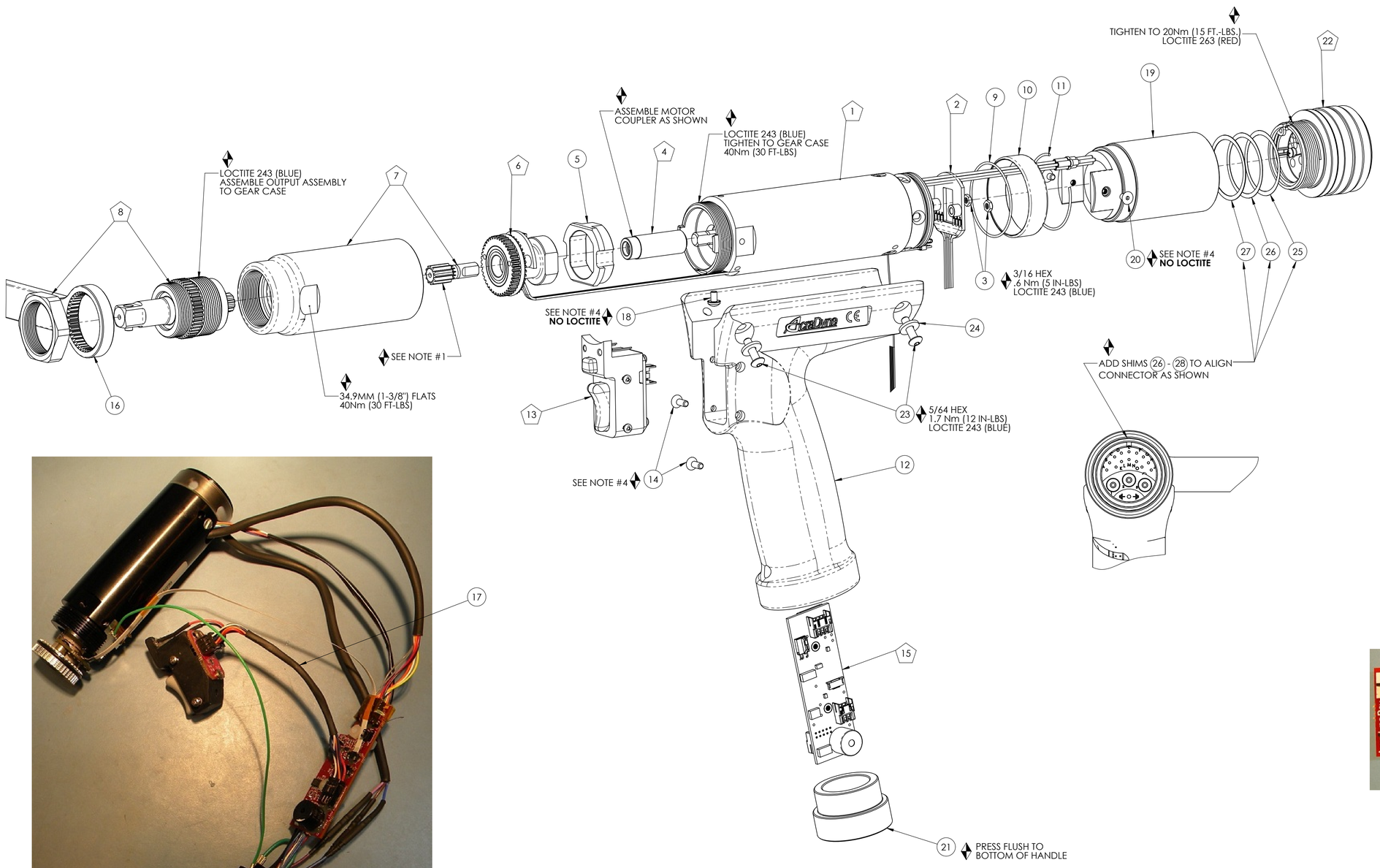
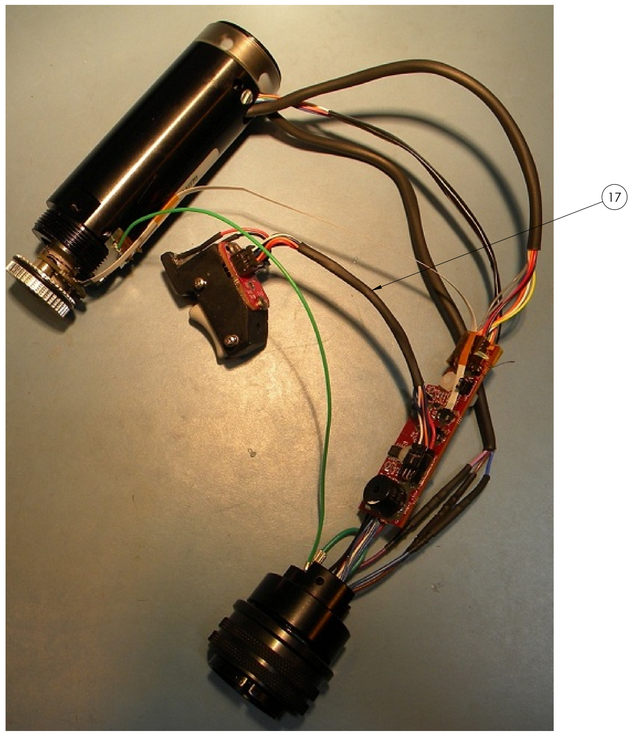
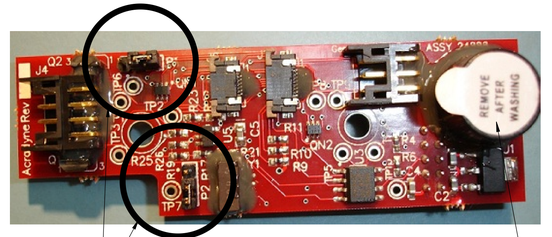


COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	25065	1	PISTOL MOTOR ASSEMBLY, TOP EXIT
	2	26599	1	LED PCB ASSY, PISTOL
	3	27016	2	NUT, HEX, 4-40 UNDERSIZED, STEEL ZINC
	4	24780	1	MOTOR COUPLER SUB-ASM.
	5	25763	1	TRANSDUCER ADAPTOR
	6	SEE CHART	1	TRANSDUCER SUB-ASM.
	7	SEE CHART	1	GEAR CASE SUB-ASM.
	8	25735	1	EXT. STRAIGHT OUTPUT ASM., 3/8" SQ. DR.
	9	24687	1	O-RING, LIGHT RING, LEVER
	10	24873	1	LIGHT RING
	11	24686	1	RETAINING RING, LEVER LIGHT RING
	12	26685	1	PISTOL HANDLE, 2000 SERIES, MODEL B
	13	25871	1	SWITCH SUB-ASSEMBLY
	14	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	15	25849	1	T.I.D. BOARD ASM., PISTOL
	16	24697	1	REACTION BAR, STEEL, 2000 SERIES
SEE WIRING PHOTO	17	25788	1	CABLE, TRIGGER, GEN 4 PISTOL
	18	25814	1	SCREW, PAN HEAD PHILLIPS, 4-40 x 3/16, STAR WASH, SS
	19	24909	1	STRAIGHT ADAPTOR, PISTOL TOOL CONNECTOR
	20	25138	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
	21	25798	1	PLUG, PISTOL HANDLE
	22	26141	1	TOOL CONNECTOR ASM., FIXTURED TOOLS
	23	26792	4	SCREW, BHSC 6-32X.50, STEEL, BLACK OXIDE
	24	26791	4	WASHER, FLAT, NO 6 SCREW, STEEL, BLACK OXIDE
	25	25271	A/R	SHIM. - .002
	26	25272	A/R	SHIM. - .005
	27	25273	A/R	SHIM. - .010

MODEL NO.	TRANSDUCER SUB-ASM.	GEAR CASE SUB-ASM.
AEP4R22020BV	25761.009 (20Nm)	24901 (14T/14T)
AEP4R22025BV	25762.001 (40Nm)	24894 (12T/12T)
AEP4R22030BV	25762.002 (40Nm)	24902 (8T/14T)
AEP4R22035BV	25762.003 (40Nm)	24903 (8T/12T)
AEP4R22040BV	25762.004 (40Nm)	24904 (6T/14T)



PRE-WIRE PISTOL AND PROGRAM TID TO TEST MOTOR, CABLING AND TID BOARD BEFORE ASSEMBLING INTO HANDLE



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

4) TIGHTEN TO 1.0 Nm (9IN-LBS) LOCTITE 243 (BLUE)

REQUIRED TOOLING
SNAP-ON CROWFOOT WRENCH, 1/2" SQ. DR. X 1-3/8" OPENING SNAP-ON PART NUMBER SC044
MAGNETIC VISE JAWS - PART NUMBER 1000-100
LOCTITE #243 BLUE
TORQUE WRENCH, 1/2" DRIVE
LOCTITE #263 RED

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AcraDyne®
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10000 SE PINE STREET
PORTLAND, OREGON 97216
503.254.6600

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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

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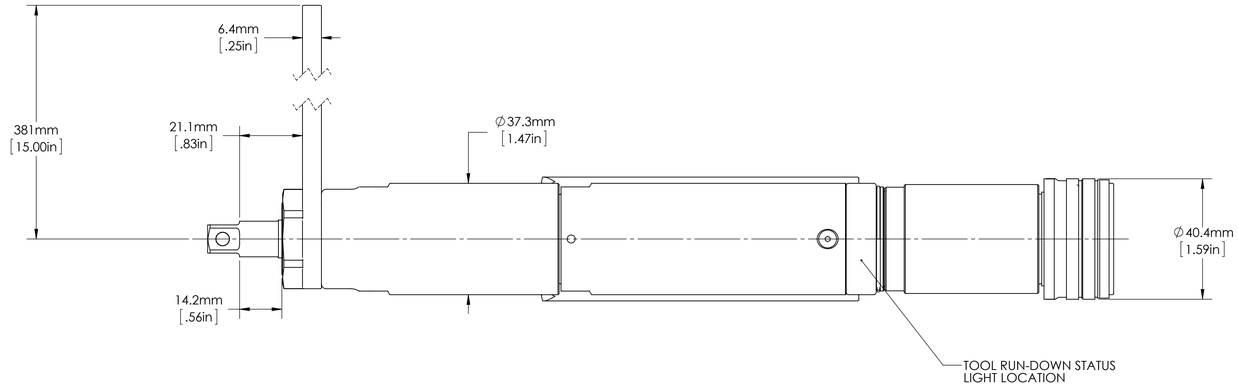
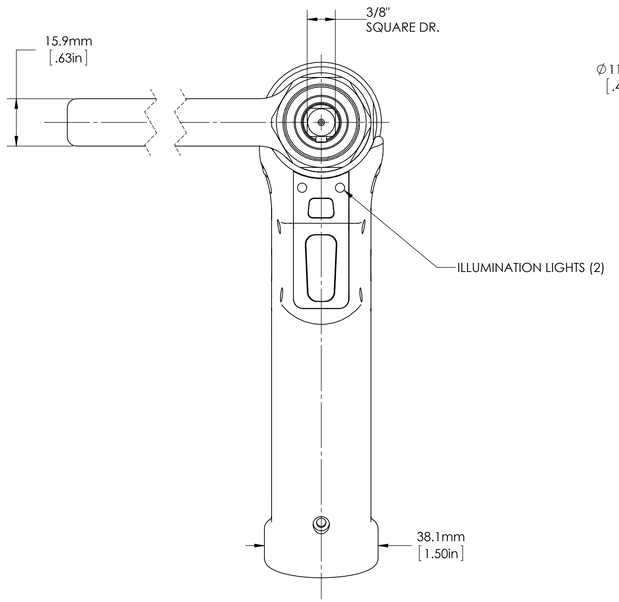
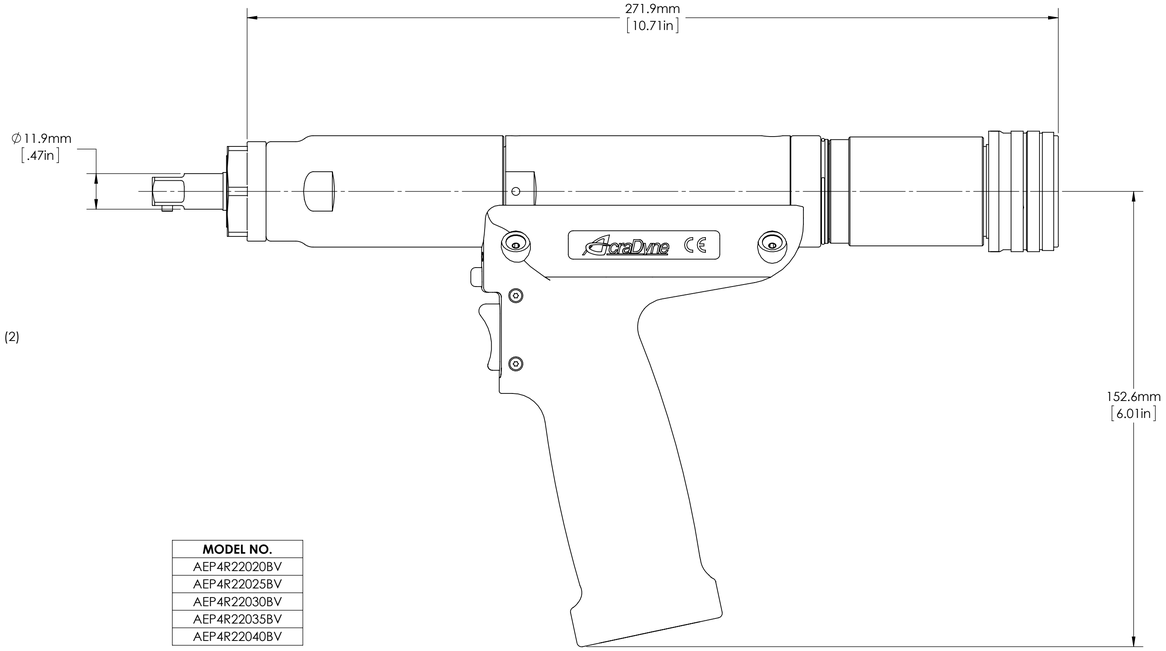
GEN IV, 2000 SERIES

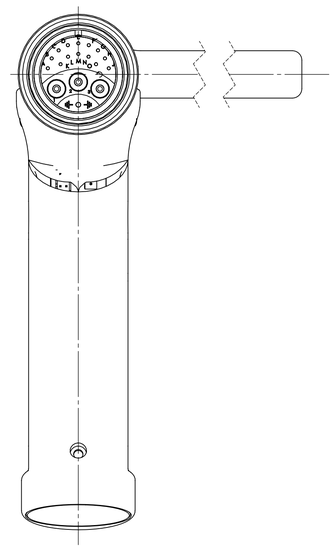
SIZE	PART / DRAWING NUMBER	REVISION
D	AEP4R22 _ _ _ BV	F

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









MODEL NO.
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AEP4R22030BV
AEP4R22035BV
AEP4R22040BV

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