

## ◆ 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 (9 IN-LBS.)  
LOCTITE 222 (PURPLE)



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| REVISION<br>LEVEL  | REVISION<br>RELEASE DATE | DESCRIPTION OF CHANGES MADE TO PART |  | ECN # |
|  |                          | <b>REVISION BLOCK</b>               |  |       |

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

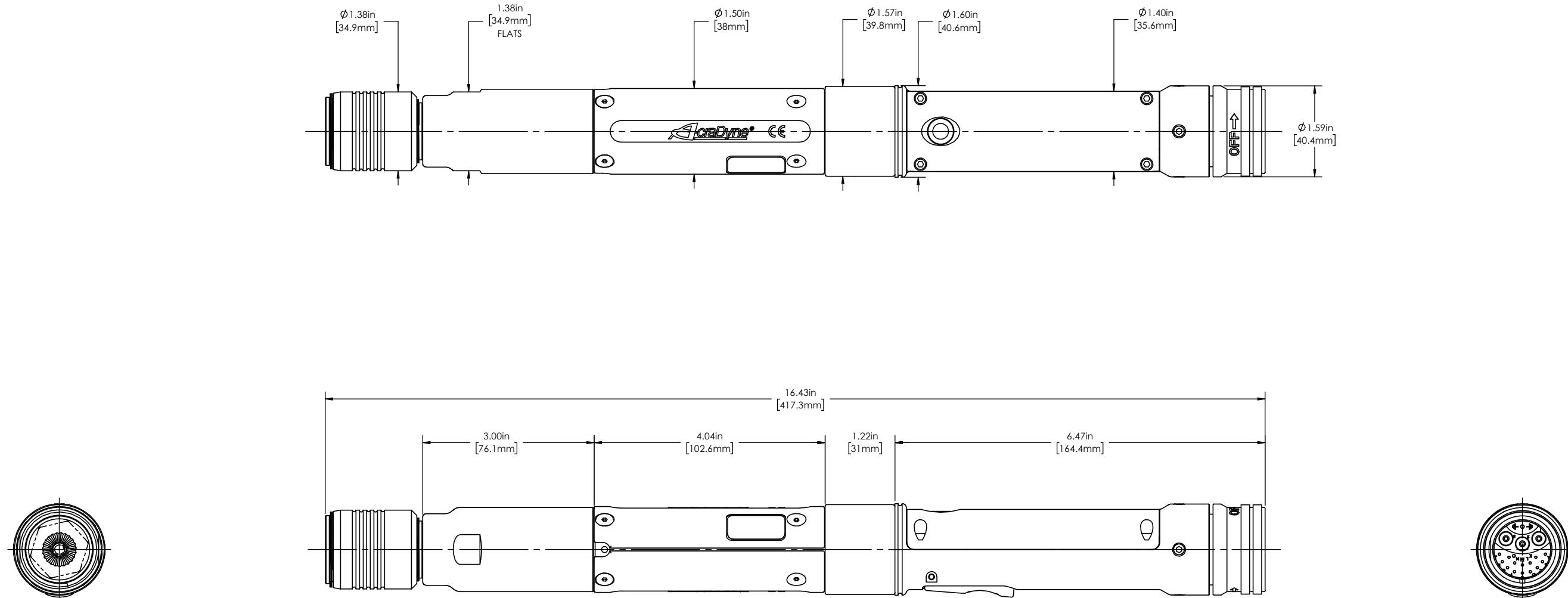
**BLOCK TOLERANCING PER DECIMAL:**  
 $\pm .030$  .XX =  $\pm .010$  .XXX =  $\pm .005$  .XXXX =  $\pm .0005$   
ANGLE =  $\pm 0^\circ 30'$

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

RAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:  
**CRADYNE MECHANICAL ENGINEERING**

# INLINE NUTRUNNER RIV-NUT GEN 4.2000 SERIES

|   |                       |              |
|---|-----------------------|--------------|
|   | PART / DRAWING NUMBER | REVISION     |
|   | <b>AES4A220_ _CR</b>  | <b>B</b>     |
| 1 | DO NOT SCALE DRAWING  | SHEET 1 OF 3 |



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REVISION LEVEL    REVISION RELEASE DATE    DESCRIPTION OF CHANGES MADE TO PART    ECN #    AUTHOR/ APPROVAL  
4    4    REVISION BLOCK

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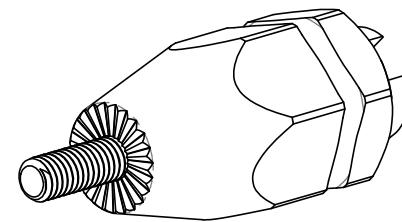
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**RIV-NUT**  
GEN 4 2000 SERIES

|          |                       |          |
|----------|-----------------------|----------|
| SIZE     | PART / DRAWING NUMBER | REVISION |
| <b>D</b> | <b>AES4A220__CR</b>   | <b>B</b> |

SCALE 1:1    DO NOT SCALE DRAWING    SHEET 2 OF 3



| SIZE CODE CHART |                 |             |                 |
|-----------------|-----------------|-------------|-----------------|
| METRIC          |                 | INCH        |                 |
| THREAD SIZE     | NOSE PIECE ASM. | THREAD SIZE | NOSE PIECE ASM. |
| M4 x 0.7mm      | 27051           | 8-32 UNC    | 27055           |
| M5 x 0.8mm      | 27034           | 10-24 UNC   | 27056           |
| M6 x 1.0mm      | 27052           | 10-32 UNF   | 27057           |
| M8 x 1.25mm     | 27053           | 1/4-20 UNC  | 27058           |
| M10 x 1.5mm     | 27054           | 5/16-18 UNC | 27059           |
|                 |                 | 3/8-16 UNC  | 27060           |



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SIZE **B** PART / DRAWING NUMBER **AES4A220\_ \_CR** REVISION **B**  
 SCALE 1:1 DO NOT SCALE DRAWING SHEET 3 OF 3