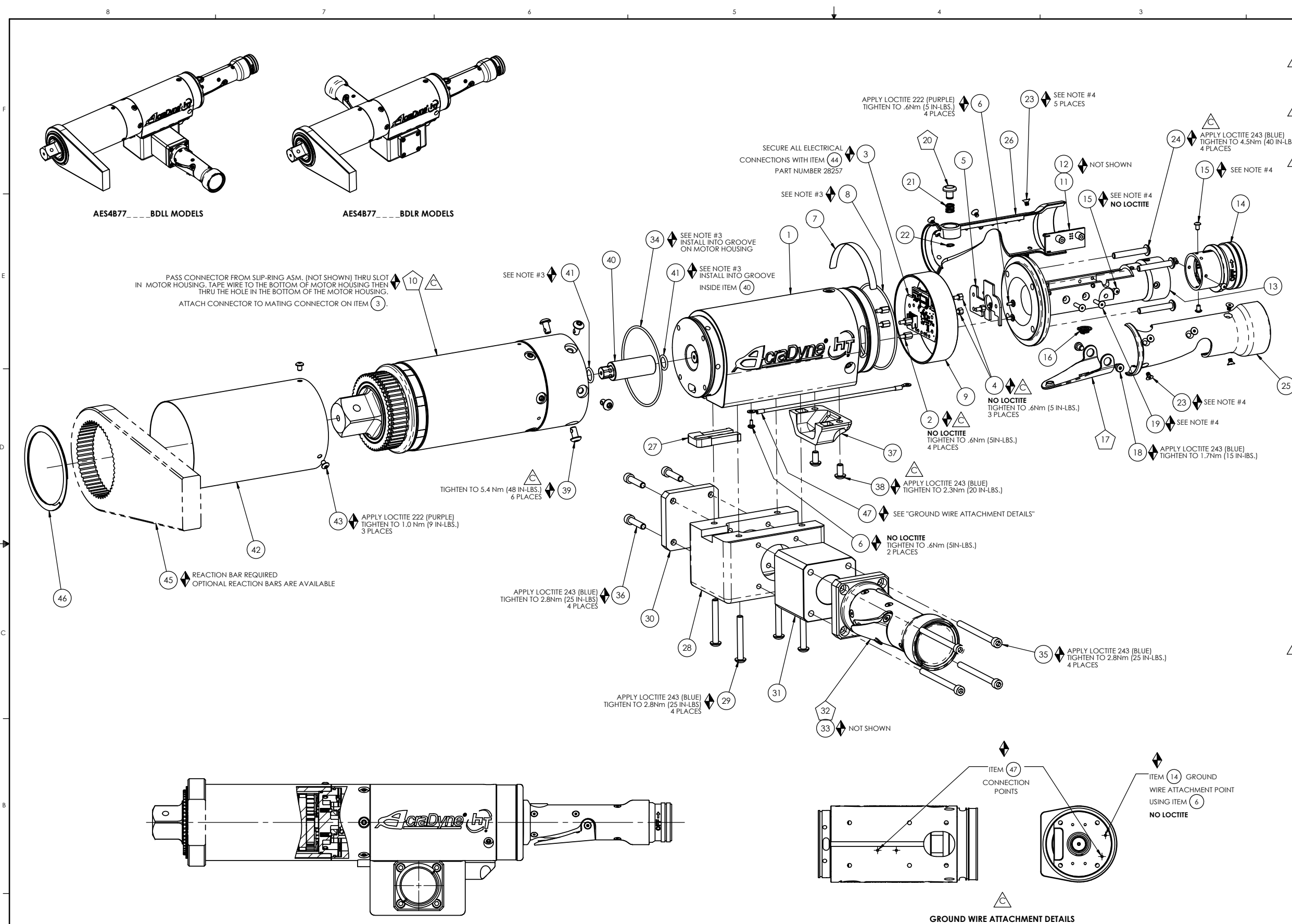




COMMENTS	ITEM NO.	PART NUMBER	QTY.	DESCRIPTION
	1	26212	1	MOTOR ASM., 7000 SERIES
	2	25574	4	STANDOFF M-F, 4-40x1/4, 3/16 HEX, SS
	3	27785	1	TID BOARD, POPULATED W/O AMP CIRCUIT
	4	29337	3	STANDOFF, M-F 4-40 X 1/8, SS
	5	29336	1	TID BOARD WIRE INSULATOR
	6	25573	6	SCREW PHP 4-40 X 3/16 18-8 SS
	7	20534	1	3000 SERIAL/MODEL LABEL
	8	26226	1	O-RING, LED COVER
	9	26223	1	LED COVER
	10	SEE CHART	1	GEARBOX/CLUTCH ASM., 7000-SERIES
	11	26285	1	LEVER TRIGGER PCB ASM.
NOT SHOWN	12	26526	1	TRIGGER CABLE
	13	26279	1	LEVER HANDLE
	14	27660	1	TOOL CONNECTOR ASM., STRAIGHT
	15	25745	5	SCREW, BHSC 4-40 STEEL, BLACK OXIDE
	16	20132	1	THROTTLE SPRING
	17	26532	1	GEN 3 TRIGGER ASSY, CAST
	18	20061	2	SCREW, LEVER
	19	26461	2	SCREW, FHC 4-40 X .50 LG., STEEL, BLACK OXIDE
	20	24706	1	REV BUTTON SUB-ASSEMBLY
	21	24683	1	SPRING, REV BUTTON
	22	24679	1	RETAINING RNG
	23	24938	10	SCREW, FHSC 4-40X.188, STEEL, BLACK OXIDE
	24	27401	4	SCREW, BHSC 10-32 X 1.25, STEEL, BLK OXIDE
	25	26083	1	HANDLE COVER
	26	26084	1	HANDLE COVER, MFB
	27	24838	1	TRANSDUCER CABLE CHASE
	28	28060	1	HANDLE BLOCK, HT DUAL LEVER
	29	26228	4	SCREW, BHSC 10-32X1.50, STEEL, BLACK OXIDE
	30	28061	1	COVER, HT DUAL LEVER
	31	28059	1	HANDLE SPACER, HT DUAL LEVER
	32	28070	1	HANDLE ASM., DUAL LEVER, MFB DISABLED
NOT SHOWN	33	28107	1	TRIGGER CABLE ASM.
	34	26227	1	O-RING, MOTOR HOUSING
	35	28002	4	SCREW, SHC, 10-32 X 2.5, STEEL
	36	26789	4	SCREW, SHC, 10-32 x 7/8, STEEL, BLACK OXIDE
	37	26224	1	TRAY, WIRE, PISTOL, INJECTION MOLDED
	38	26206	2	SCREW, BHSC 10-32 X .375, STEEL
	39	29279	6	SCREW, BHSC, 10-32 x 3/8, TORX HEAD, NYLON PELL-IT, STEEL
	40	29777	1	SLIP RING PINION ADAPTOR, CLUTCH
	41	26299	2	O-RING, PINION
	42	SEE CHART	1	GEAR CASE COVER
	43	26319	3	SCREW, BHSC 6-32 X .188, 18-8 SS
NOT SHOWN	44	28257	A/R	CABLE TIE, 1.65MM W x 71MM LONG
	45	26897	1	CHOOSE REACTION BAR
	46	26243	1	RETAINING RING, SPIRAL, Ø2.864 X Ø2.464 X .078
	47	31410	1	GROUND WIRE ASSEMBLY, 18 AWG, 6000 & 7000 HT SERIES

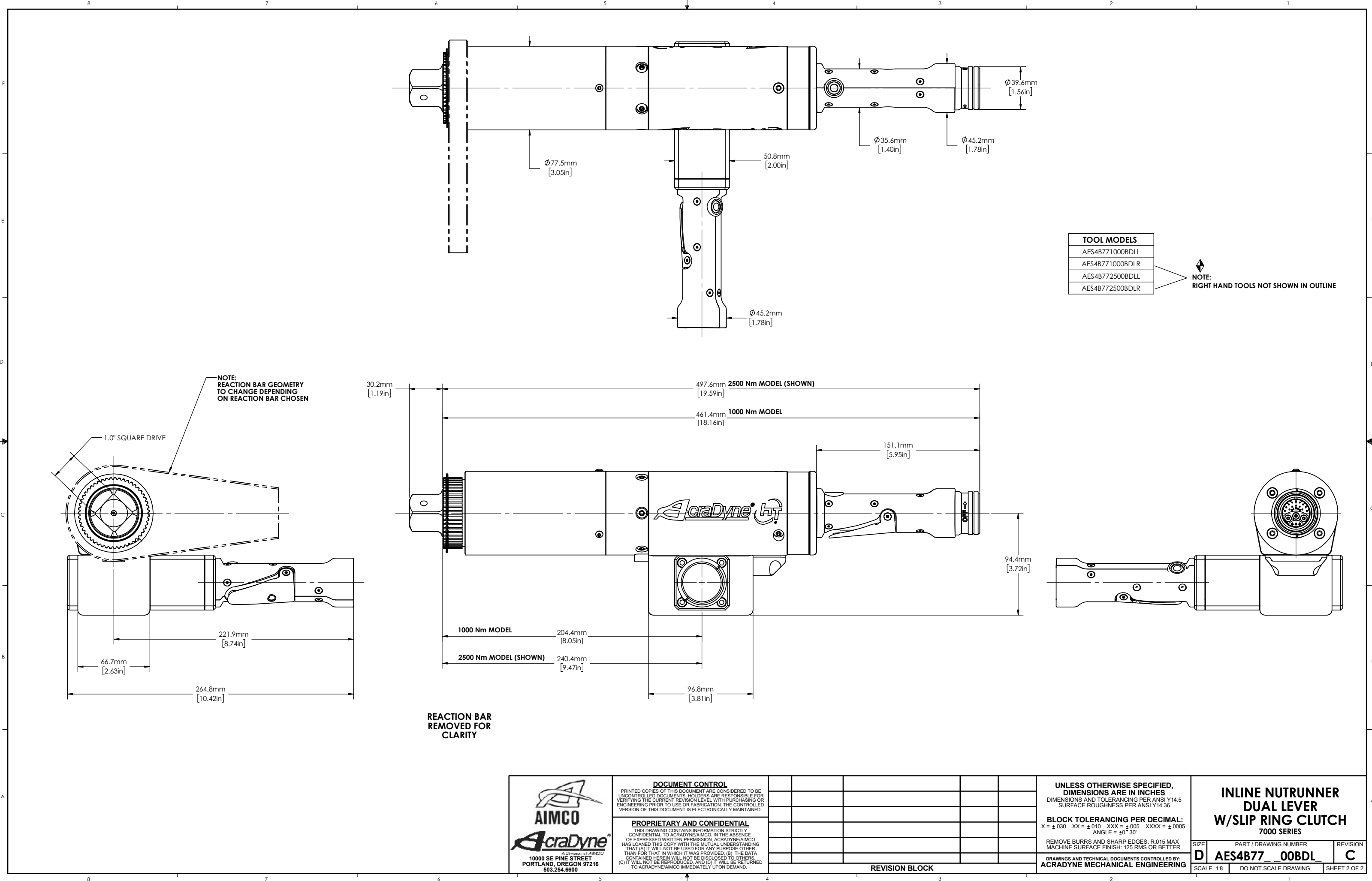
 **NOTE:**  SEE WORK INSTRUCTION DOCUMENT "W2047" FOR COMPLETE SLIP-RING ASSEMBLY INSTRUCTIONS.

		
MODEL NO.	GEARBOX/CLUTCH ASM.	GEAR CASE COVER
AES4B771000BDLL	31777	26298
AES4B771000BDLR		
AES4B772500BDLL	31797	26295
AES4B772500BDLR		

 ASSEMBLY INSTRUCTIONS
 SUB-ASSEMBLY

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

 AIMCO A Division - AcraDYNE® 10000 SE PINE STREET PORTLAND, OREGON 97216 503.254.6600	<u>DOCUMENT CONTROL</u> PRINTED COPIES OF THIS DOCUMENT ARE CONSIDERED TO BE 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.								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 = α° 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	INLINE NUTRUNNER DUAL LEVER W/S LIP RING CLUTCH 7000 SERIES
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	REVISION BLOCK									
		SIZE	PART / DRAWING NUMBER	REVISION						
		D	AES4B77_ _O0BDL_	C						
		SCALE 3:5	DO NOT SCALE DRAWING	SHEET 1 OF 2						



NOTE:
REACTION BAR GEOMETRY
TO CHANGE DEPENDING
ON REACTION BAR CHOSEN

NOTE:
RIGHT HAND TOOLS NOT SHOWN IN OUTLINE

REACTION BAR
REMOVED FOR
CLARITY



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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

DRAWINGS AND TECHNICAL DOCUMENTS CONTROLLED BY:
ACRADYNE MECHANICAL ENGINEERING

INLINE NUTRUNNER DUAL LEVER W/SLIP RING CLUTCH 7000 SERIES		
SIZE D	PART / DRAWING NUMBER AES4B77_00BDL	REVISION C
SCALE 1:8	DO NOT SCALE DRAWING	SHEET 2 OF 2