

4				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
2	1074232	424-J	DISC,424,BUNA	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	1
4	1262436	-	LOCTITE 565 POLYTUBE	1
5	1071678	ORB-028	O-RING,-028,BUNA	1
6	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
7	1071695	ORB-132	O-RING,-132,BUNA	1
8	42561	-	LUBRICANT,SILICONE,PACKET	1
9	1263853	RMET	HEX NUT 5/16" - 24	1
10	1074252	424-R	COPPER GASKET	1
11	1074222	424-FB	DIAPHRAGM,424,BUNA	1

3

2

1

1070069 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 424-RA

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2436	A	INITIAL RELEASE	9/4/2024	PMJ

STEP 1
(WITH ONE PIECE SHAFT)

STEP 2

STEP 3
(NOT NEEDED FOR MOST REPAIRS)

LEGACY TWO PIECE SHAFT

"X" FACES DISC

LUBRICATE
SURFACE

REMOVE SEAT AND
REPLACE O-RING ONLY
WHEN NECESSARY.

NUT SECURED
WITH LOCTITE

STEP 4

STEP 5

STEP 6

1074227 TOOL FOR
LEGACY SHAFT GUIDE
NOT INCLUDED

3/4" SOCKET FOR
CURRENT SHAFT GUIDE
NOT INCLUDED

"X" FACES
DIAPHRAGM

FLATHEAD SCREWDRIVER
NOT INCLUDED.
USE WHEN LOWER NUT
CANNOT BE REACHED.

NUT SECURED
WITH LOCTITE

7/16 IN. WRENCHES
NOT INCLUDED.

NOTES:

- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
- ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.
- LEGACY TWO PIECE SHAFT USES A COPPER GASKET BETWEEN SHAFT AND DISC HOLDER.

TORQUE TABLE

PART	TORQUE
SEAT	120 IN.LBS.
UPPER SHAFT NUT	90 IN.LBS.
LOWER SHAFT NUT	90 IN.LBS.
SHAFT GUIDE	120 IN.LBS.
CAP SCREWS & NUTS	140 IN.LBS.

INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M -2018.
PRIMARY UNITS SHOWN IN INCHES.
SECONDARY UNITS SHOWN IN MILLIMETERS.
DEFAULT TOLERANCES:
ANGLES : ± 1°
1 PLACE .X: ± .100 [2.54]
2 PLACE .XX: ± .010 [0.3]
3 PLACE .XXX: ± .005 [0.13]
THIRD ANGLE
PROJECTION
THE COMPONENT OR PRODUCT DESCRIBED IN THIS DOCUMENT
MUST COMPLY WITH RoHS 3 EU (EUROPEAN UNION) DIRECTIVE
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DESCRIPTION
KIT,424,D&S,BUNA

DWG NO. 1070069 REV. A
SIZE C SCALE 1:2 SHEET 1 OF 1