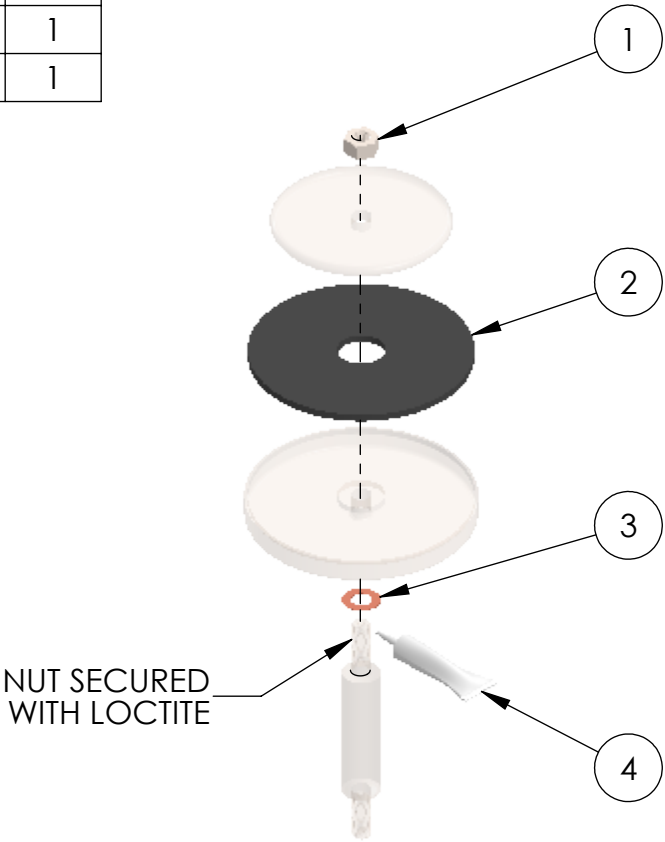


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263853	RMET	HEX NUT 5/16" - 24	2
2	1074487	427-J	DISC,427,BUNA	1
3	1074252	424-R	COPPER GASKET	2
4	1262436	-	LOCTITE 565 POLYTUBE	1
5	1071706	ORB-233	O-RING,-233,BUNA	1
6	1071691	ORB-114TC	O-RING,-114,BUNA,TFL CTD	2
7	1071708	ORB-237	O-RING,-237,BUNA	1
8	42561	-	LUBRICANT,SILICONE,PACKET	1
9	1074475	427-FB	DIAPHRAGM,427,BUNA	1

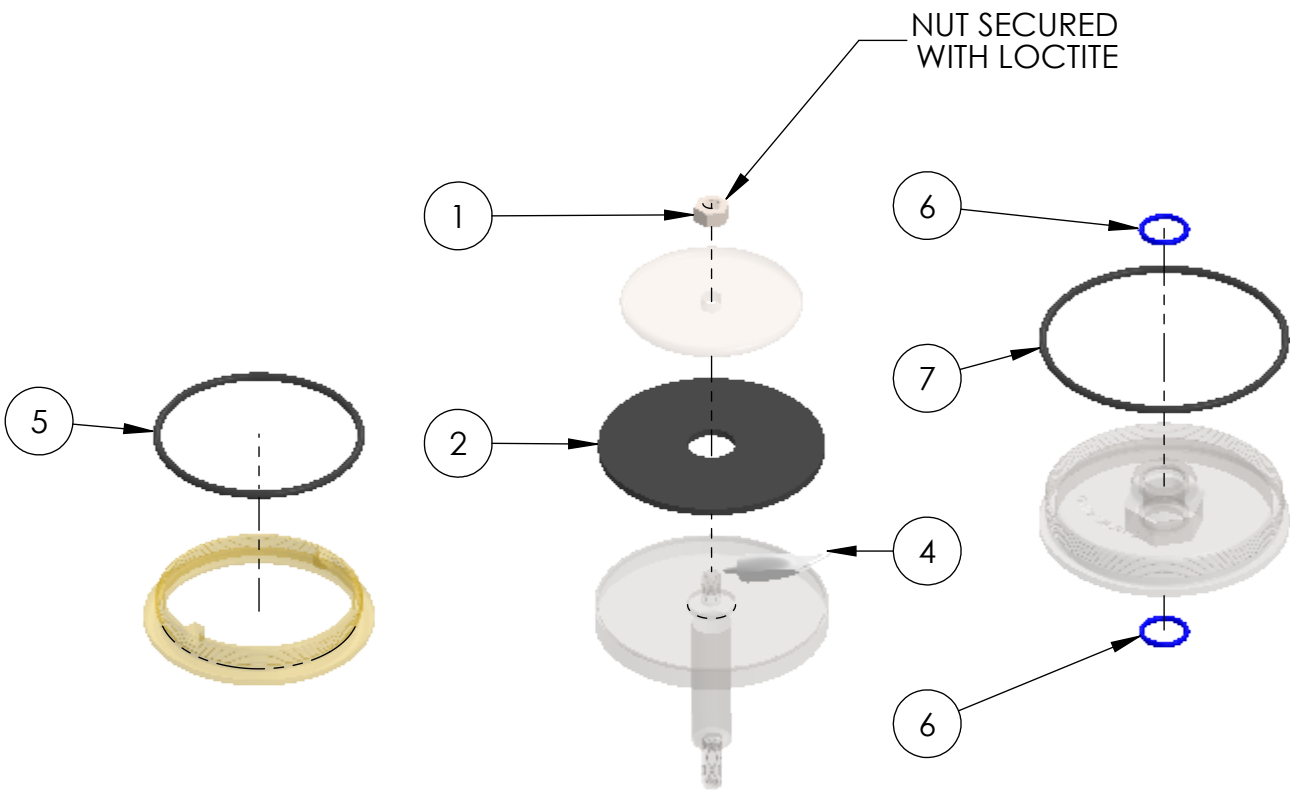
1070072 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 427-RA

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2562	A	INITIAL RELEASE	7/9/2025	PMJ

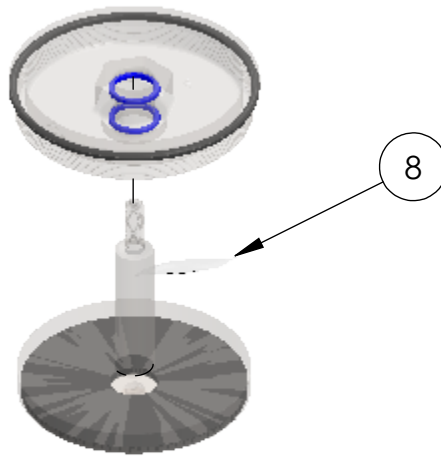
LEGACY TWO
PIECE SHAFT



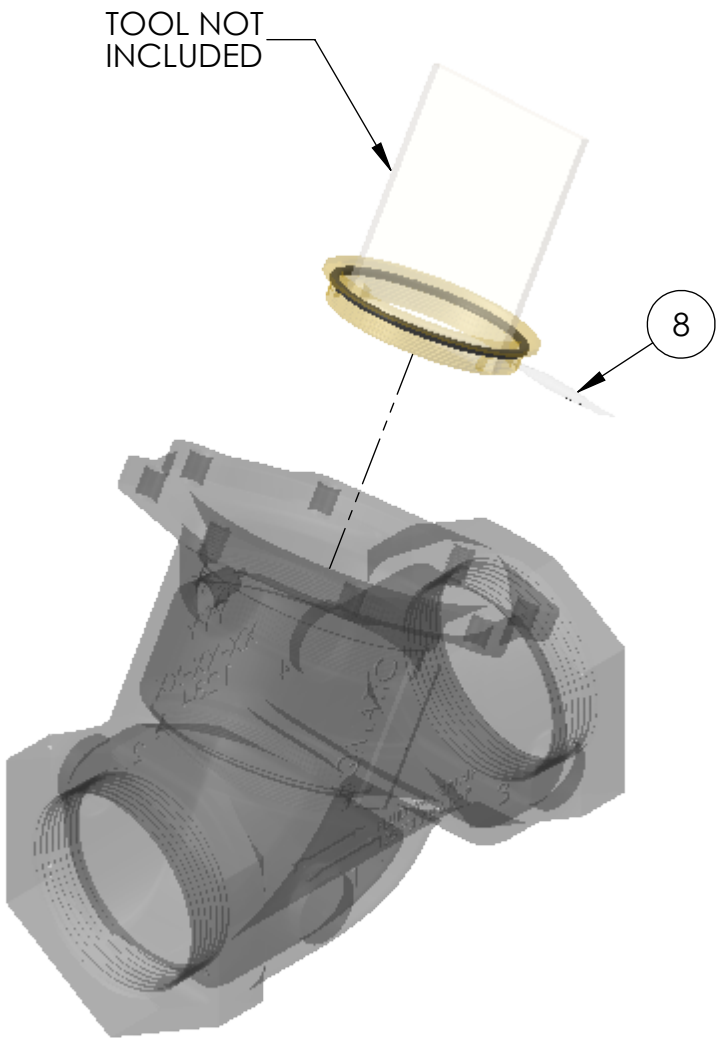
STEP 1
(WITH ONE PIECE SHAFT)



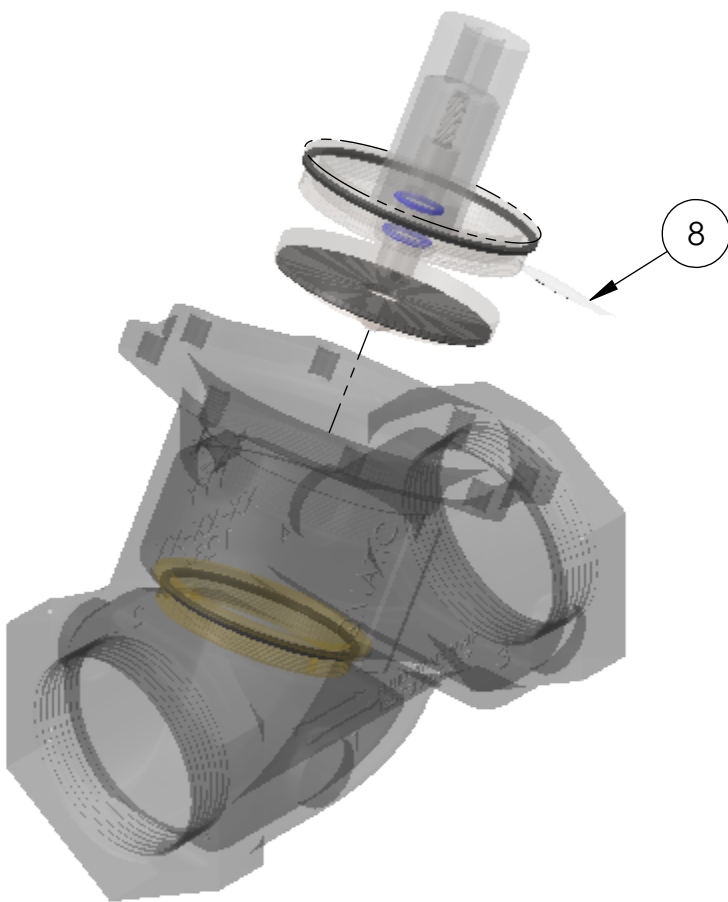
STEP 2



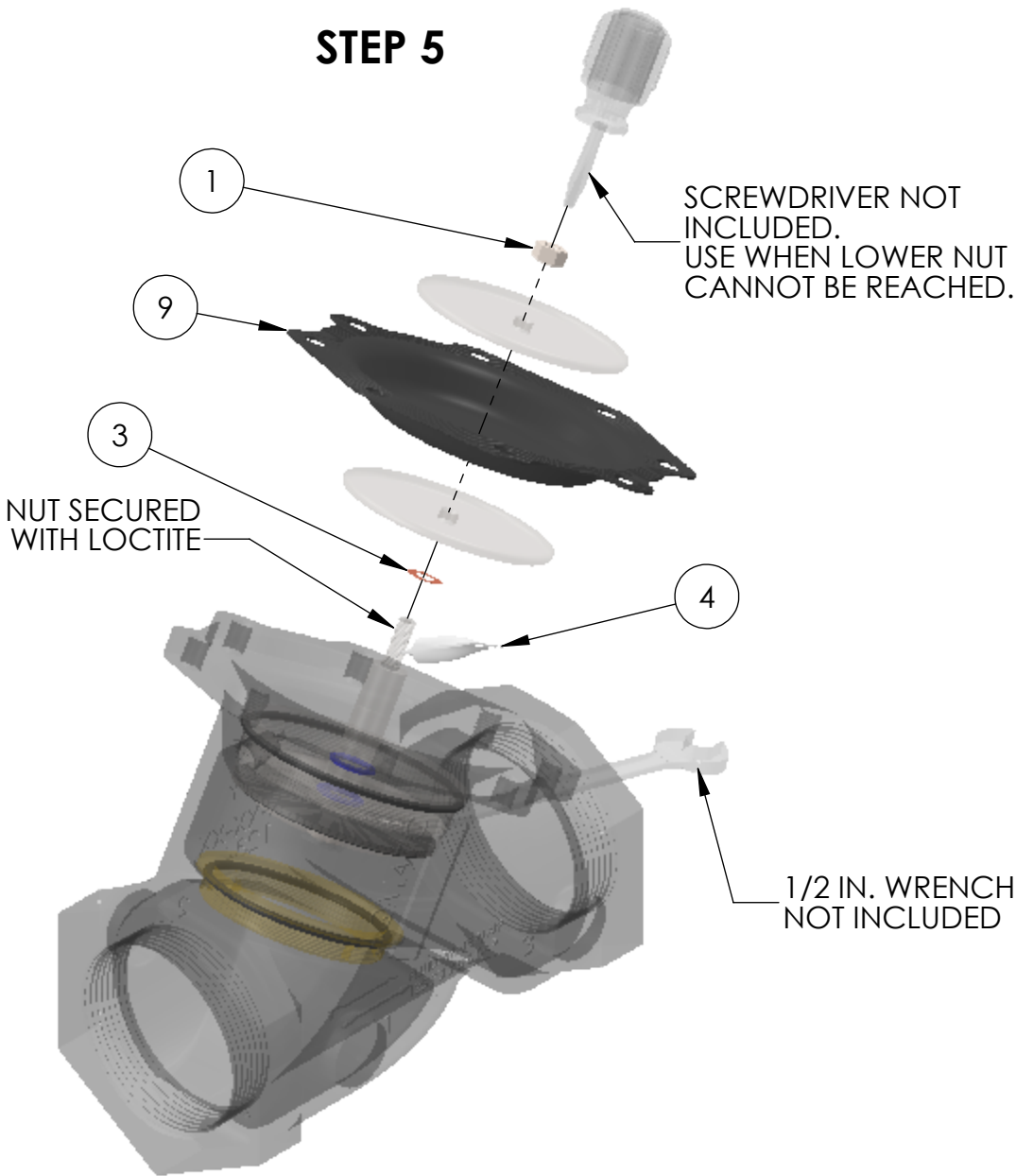
STEP 3



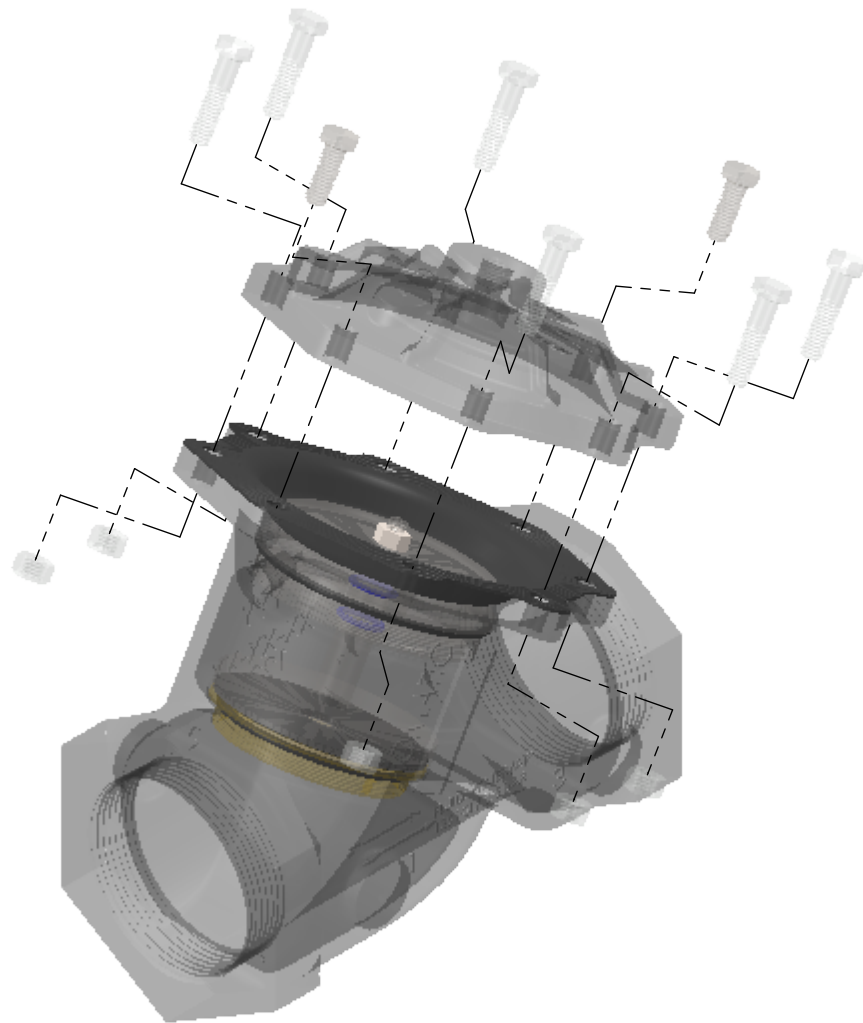
STEP 4



STEP 5



STEP 6



NOTES:

- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
- ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.
- THIS KIT AND ASSEMBLY INSTRUCTIONS WORK FOR ALL THREADED, FLANGED, AND GROOVE ADAPTER BODIES.

TORQUE TABLE	
PART	TORQUE
SEAT	500 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	140 IN-LBS.
SHAFT GUIDE	500 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.

THIRD ANGLE
PROJECTION

DEFAULT TOLERANCES:
ANGLES : ± 1°
1 PLACE .X: ± .100 [2.54]
2 PLACE .XX: ± .010 [0.3]
3 PLACE .XXX: ± .005 [0.13]

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DESCRIPTION	
KIT,427,D&S,BUNA	
DWG NO.	1070072
REV.	A
SIZE	C
SCALE	1:3
SHEET	1 OF 1