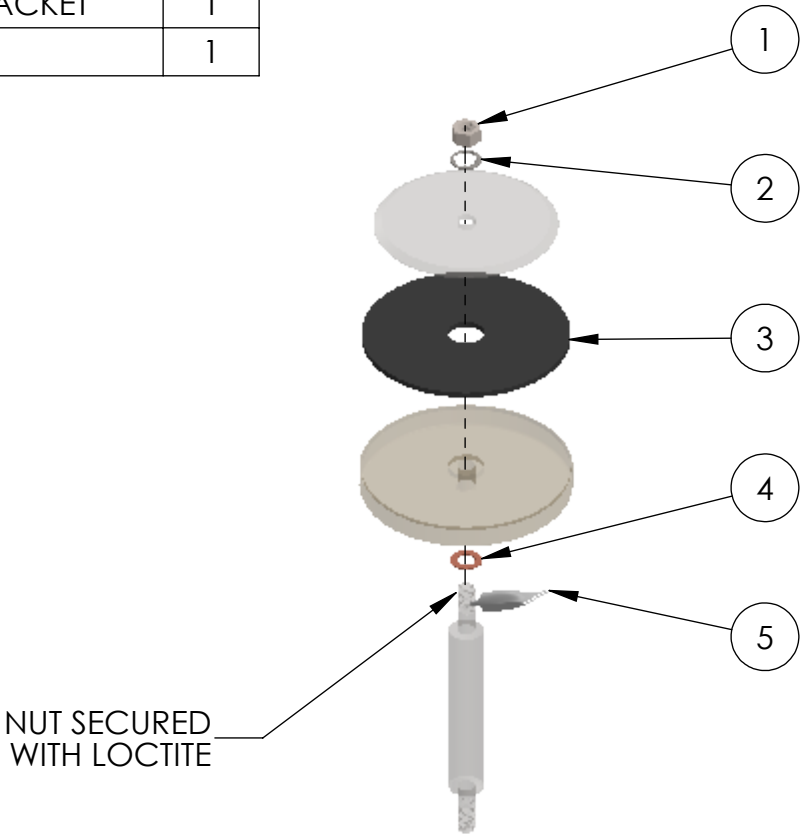


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	3001990	NUS-0017	NUT,HEX,3/8-24,SS	2
2	1073591	WAS-0008	LOCKWASHER, 3/8", INTERNAL	2
3	1074568	428-J	DISC,428,BUNA	1
4	1073950	200-LL	GASKET, COPPER	2
5	1262436	-	LOCTITE 565 POLYTUBE	1
6	1071697	ORB-156	O-RING,-156,BUNA	1
7	1071702	ORB-210TC	O-RING,-210,BUNA,TFL CTD	2
8	1071711	ORB-245	O-RING,-245,BUNA	1
9	42561	-	LUBRICANT,SILICONE,PACKET	1
10	1074557	428-FB	DIAPHRAGM,428,BUNA	1

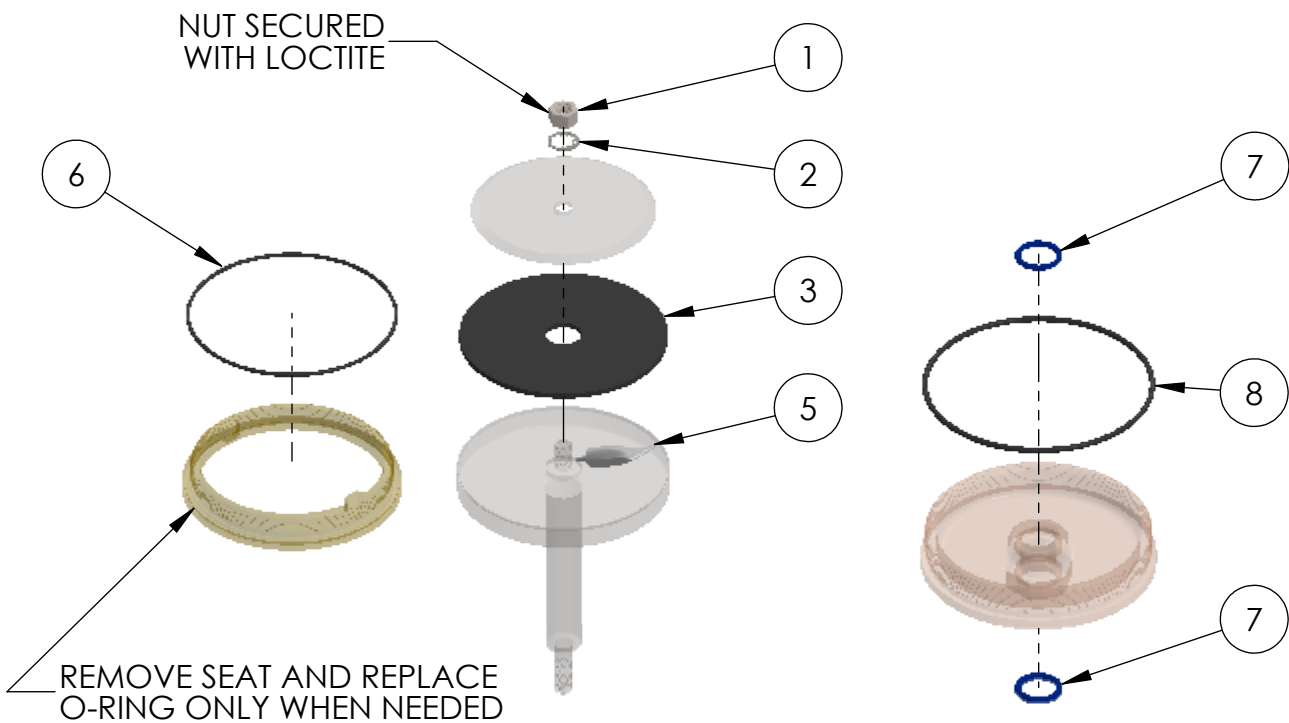
1070073 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 428-RA

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2588	A	INITIAL RELEASE	8/25/2025	PMJ

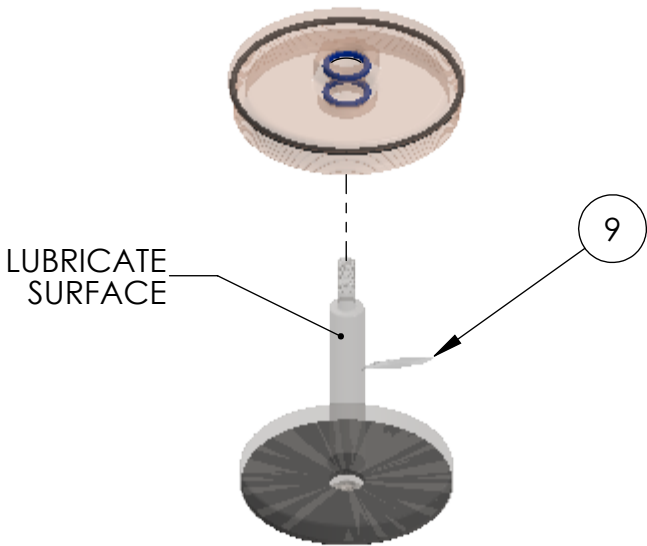
LEGACY TWO
PIECE SHAFT



STEP 1
(WITH ONE PIECE SHAFT)

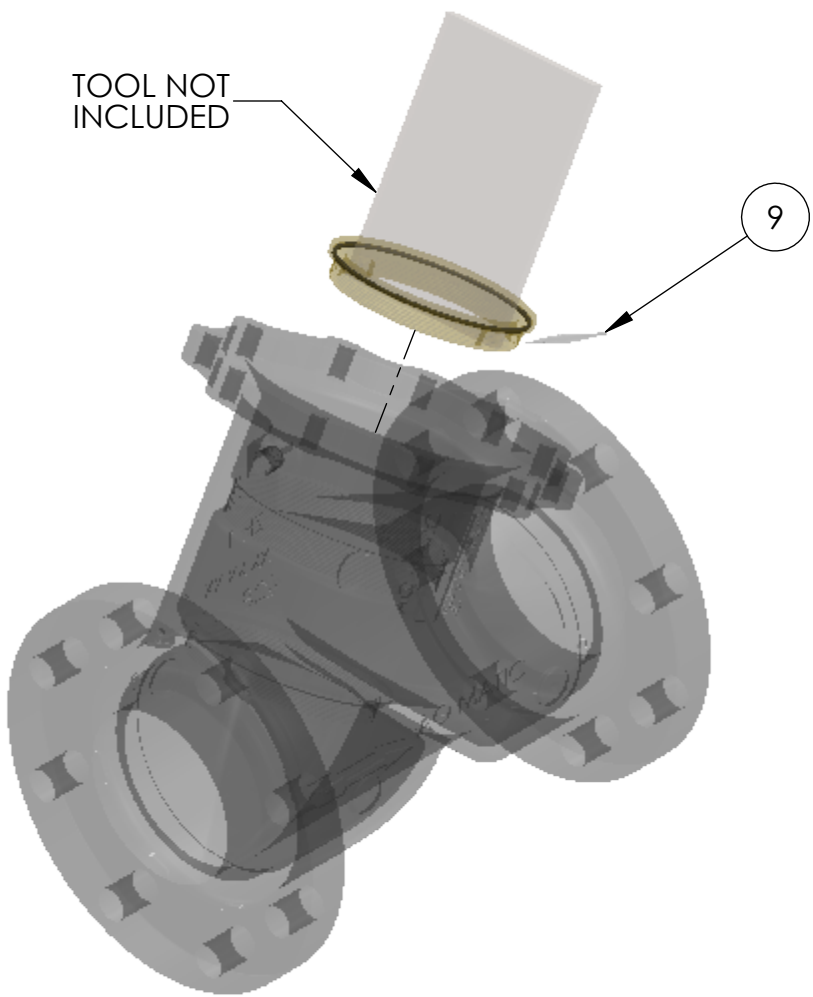


STEP 2

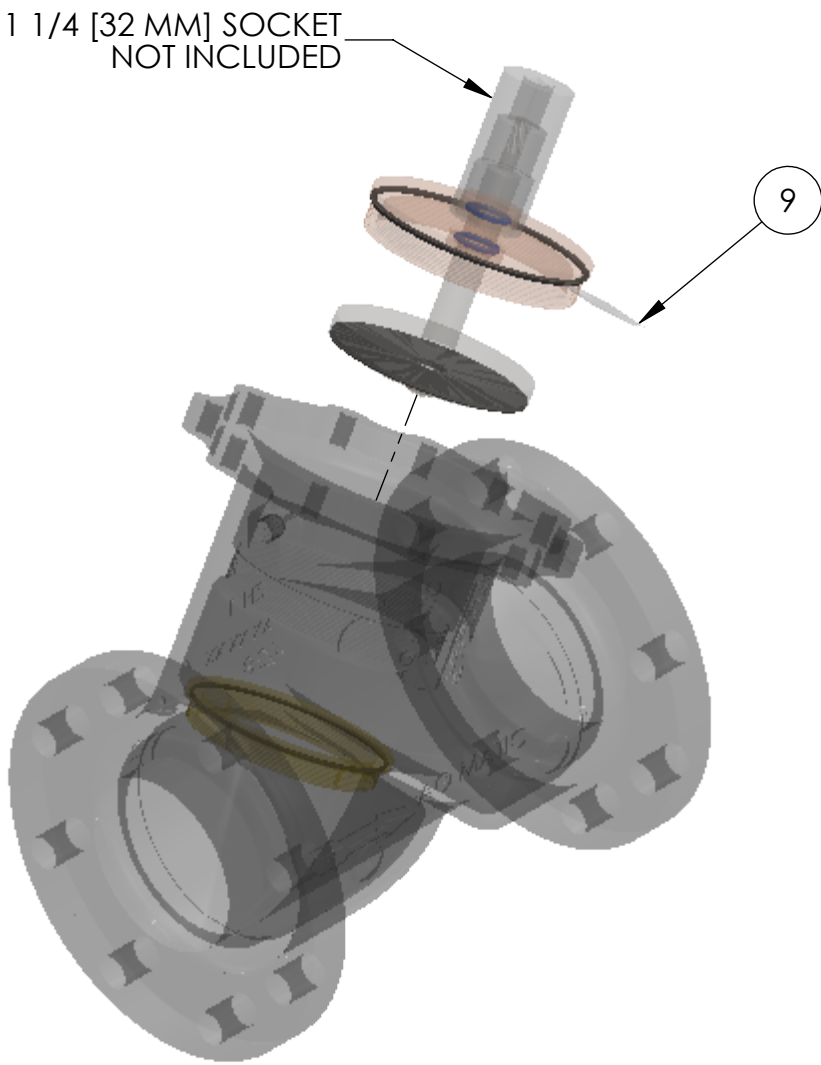


STEP 3

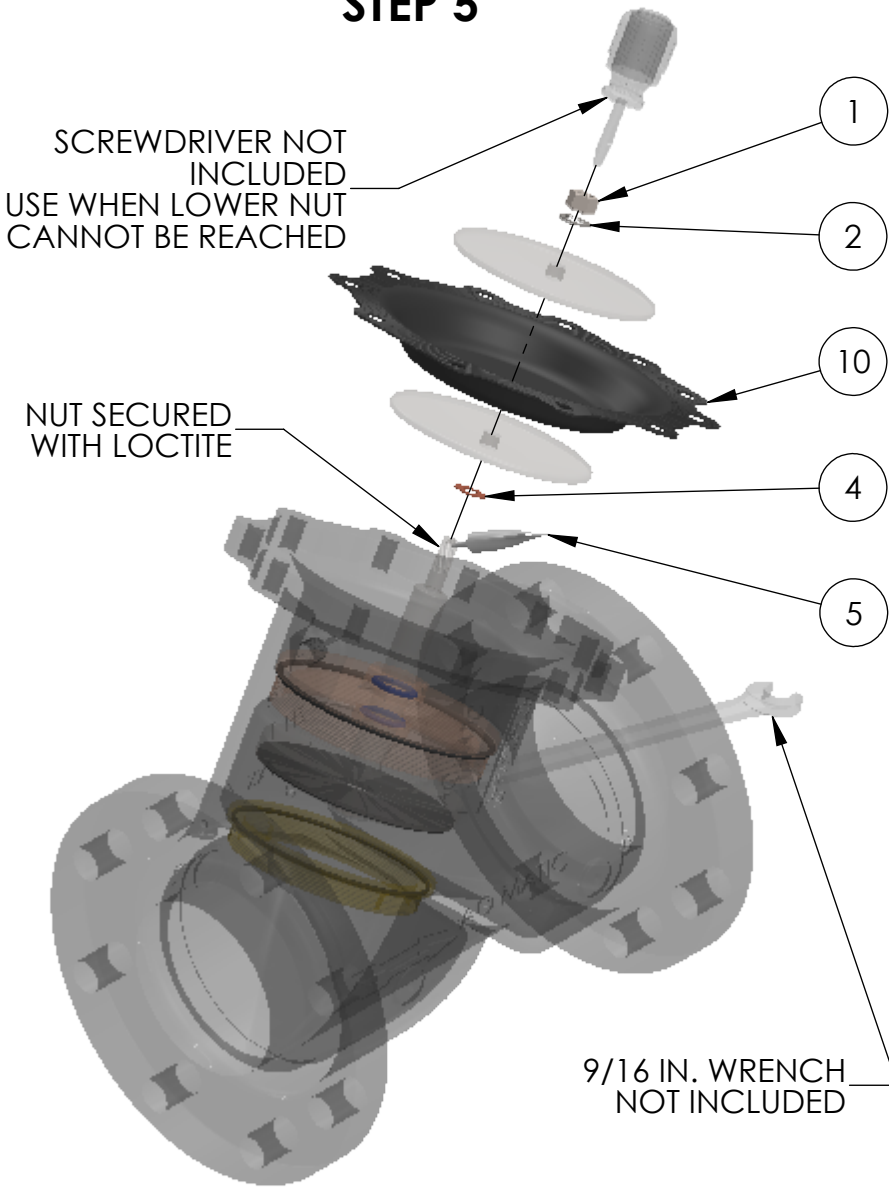
(NOT NEEDED FOR MOST REPAIRS)



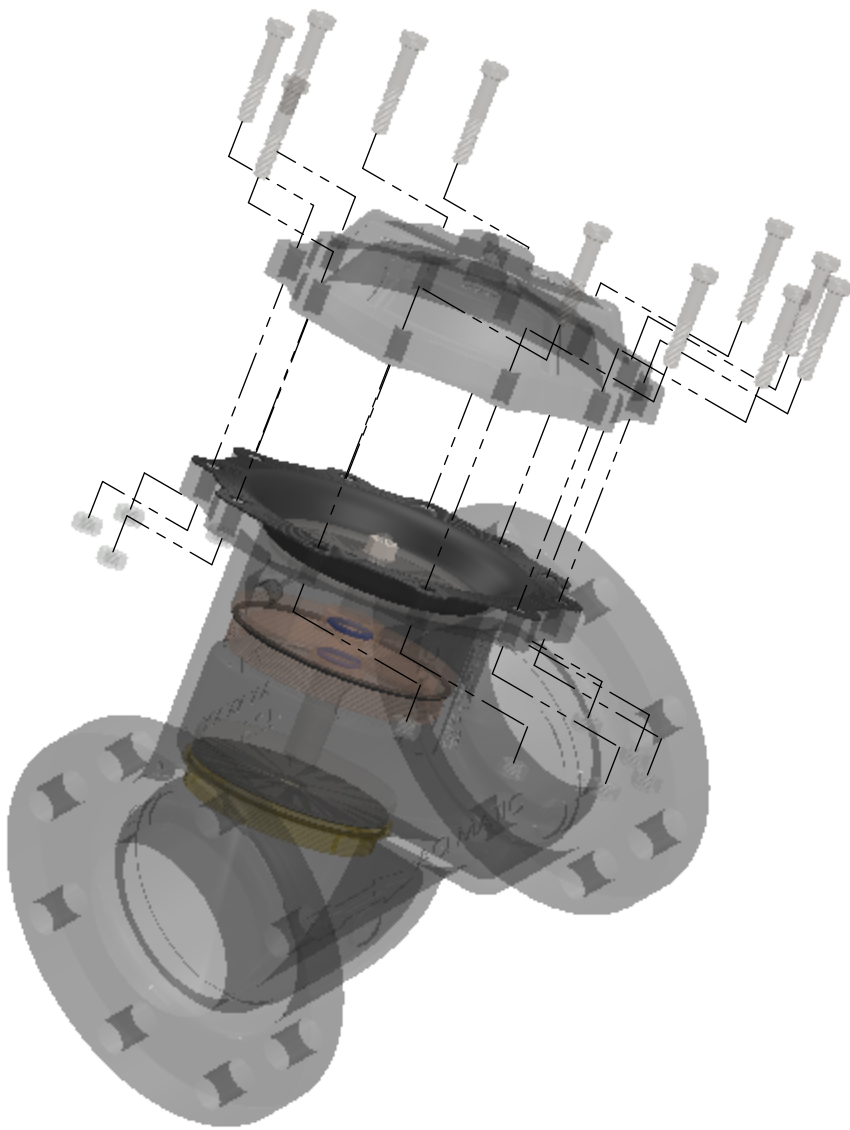
STEP 4



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.

TORQUE TABLE	
PART	TORQUE
SEAT	400 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	215 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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MUST COMPLY WITH RoHS 3 EU (EUROPEAN UNION) DIRECTIVE
2015/863 AND EU REACH REGULATION (EC) 1907/2006.

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DESCRIPTION	
KIT,428,D&S,BUNA	
DWG NO.	1070073
REV.	A
SIZE	C
SCALE	1:4
SHEET	1 OF 1