

| 4        |          |           |                              |      |
|----------|----------|-----------|------------------------------|------|
| ITEM NO. | PART NO. | MODEL     | DESCRIPTION                  | QTY. |
| 1        | 1263853  | RMET      | HEX NUT 5/16" - 24           | 2    |
| 2        | 1074309  | 425-JE    | DISC, 425, EP                | 1    |
| 3        | 1074252  | 424-R     | COPPER GASKET                | 2    |
| 4        | 1262436  | -         | LOCTITE 565 POLYTUBE         | 1    |
| 5        | 1071724  | ORE-035   | O-RING,EP,ORE-035            | 1    |
| 6        | 1071725  | ORE-038   | O-RING,EP,ORE-038            | 1    |
| 7        | 1239009  | ORE-206TC | O-RING,EP,ORE-206,TEF COATED | 2    |
| 8        | 42561    | -         | LUBRICANT,SILICONE,PACKET    | 1    |
| 9        | 1074296  | 425-FB    | DIAPHRAGM,425,BUNA           | 1    |

1070083 SEAL AND DIAPHRAGM KIT  
ASSEMBLY INSTRUCTION  
MODEL NO. 425-RAE

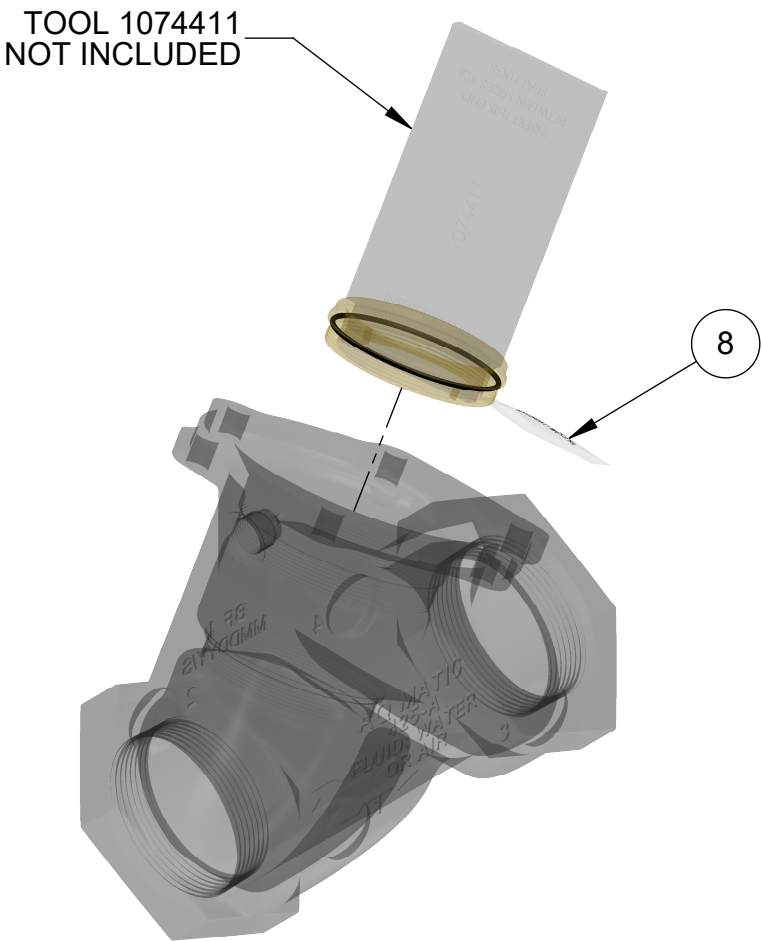
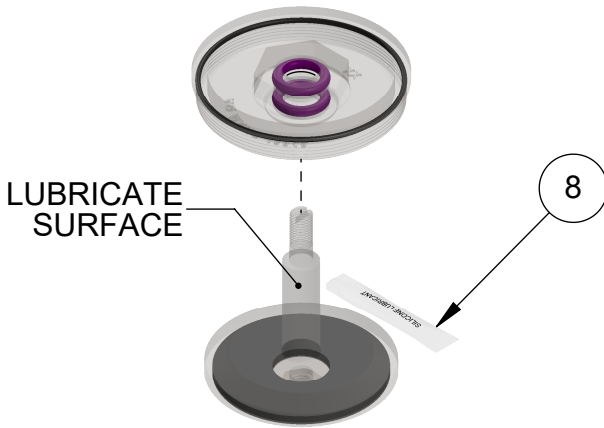
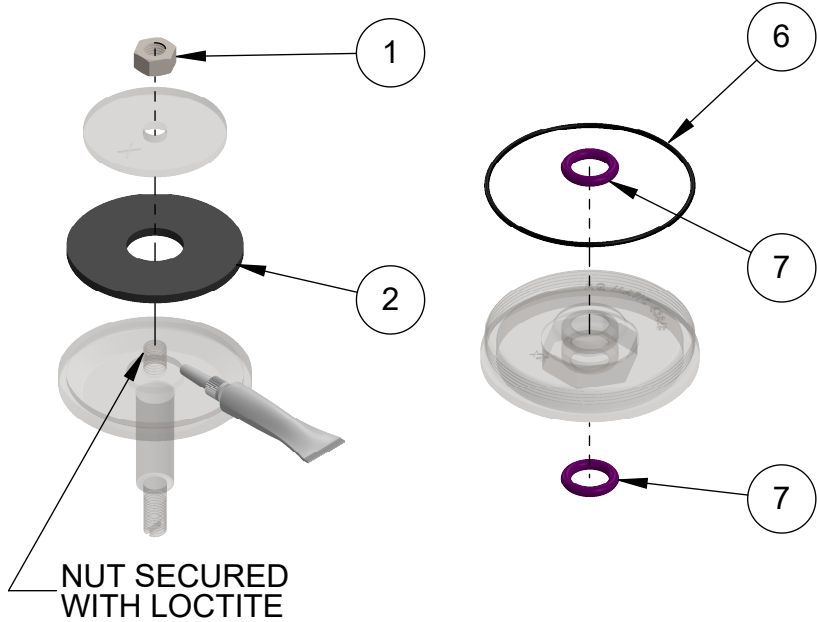
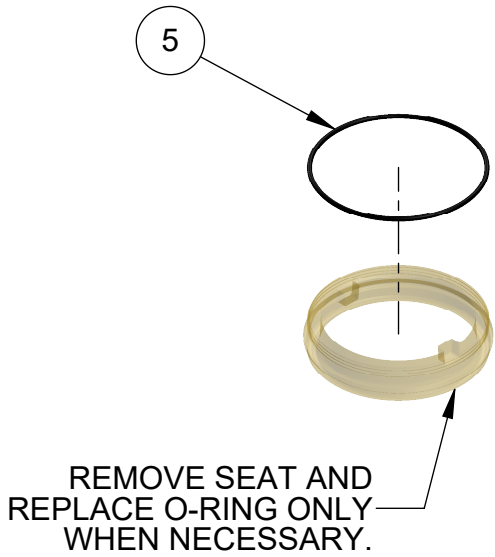
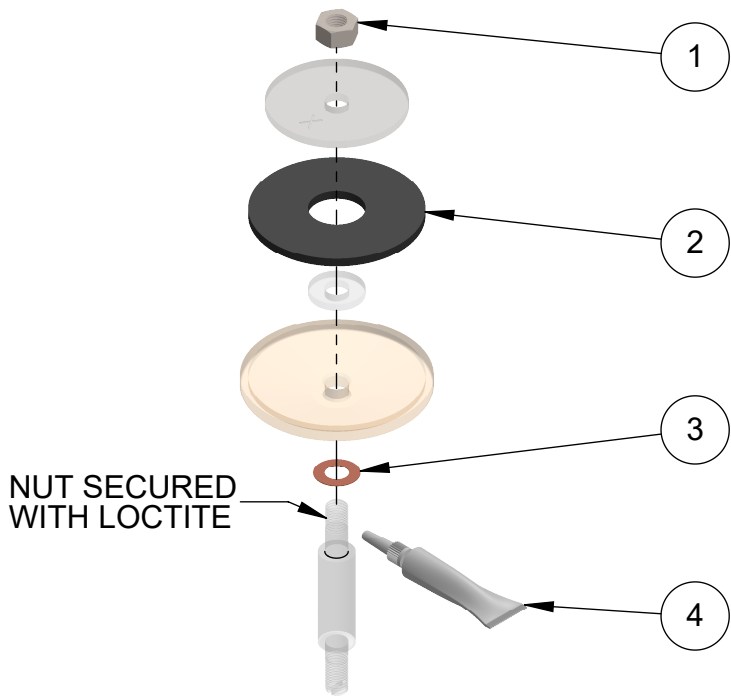
| REVISIONS |     |                 |            |          |
|-----------|-----|-----------------|------------|----------|
| ECN       | REV | DESCRIPTION     | DATE       | APPROVED |
| 2464      | A   | INITIAL RELEASE | 10/17/2024 | PMJ      |

STEP 1  
(WITH ONE PIECE SHAFT)

STEP 2

STEP 3  
(NOT NEEDED FOR MOST REPAIRS)

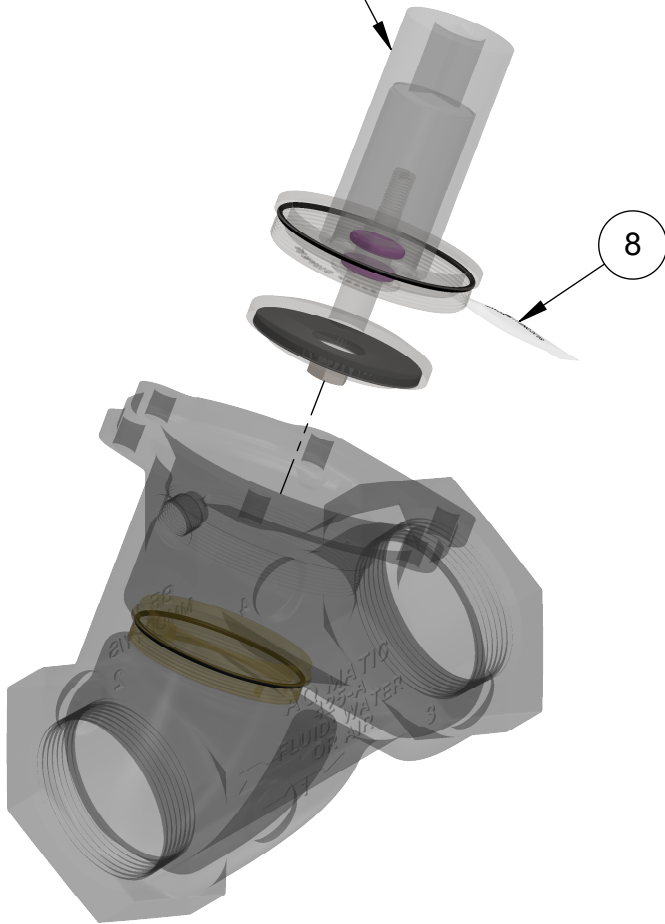
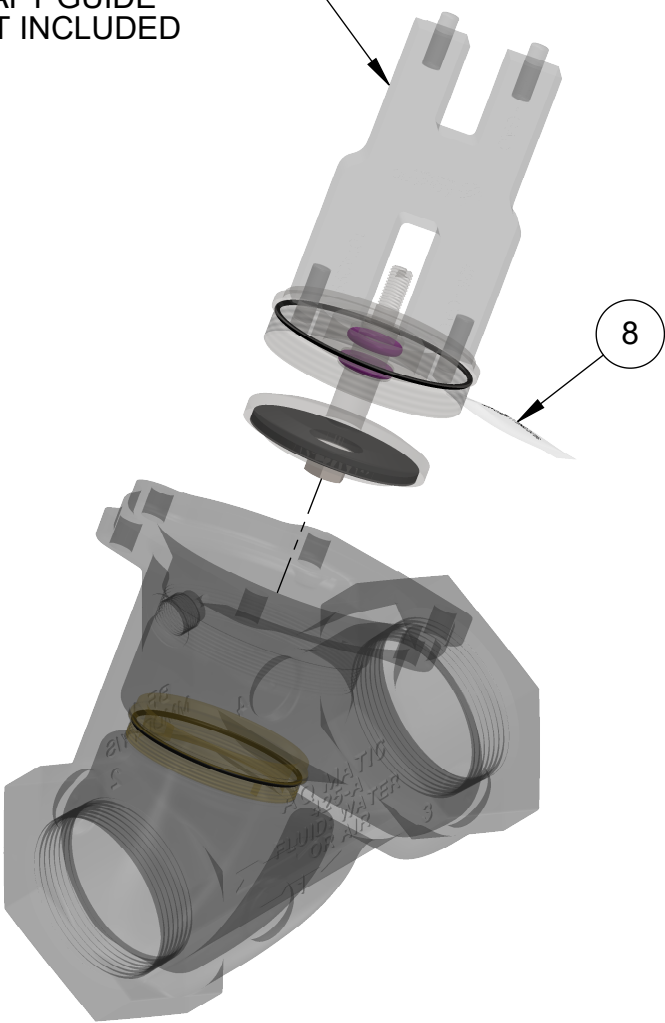
LEGACY TWO PIECE SHAFT



1074299 TOOL FOR  
LEGACY (2014-2018)  
SHAFT GUIDE  
NOT INCLUDED

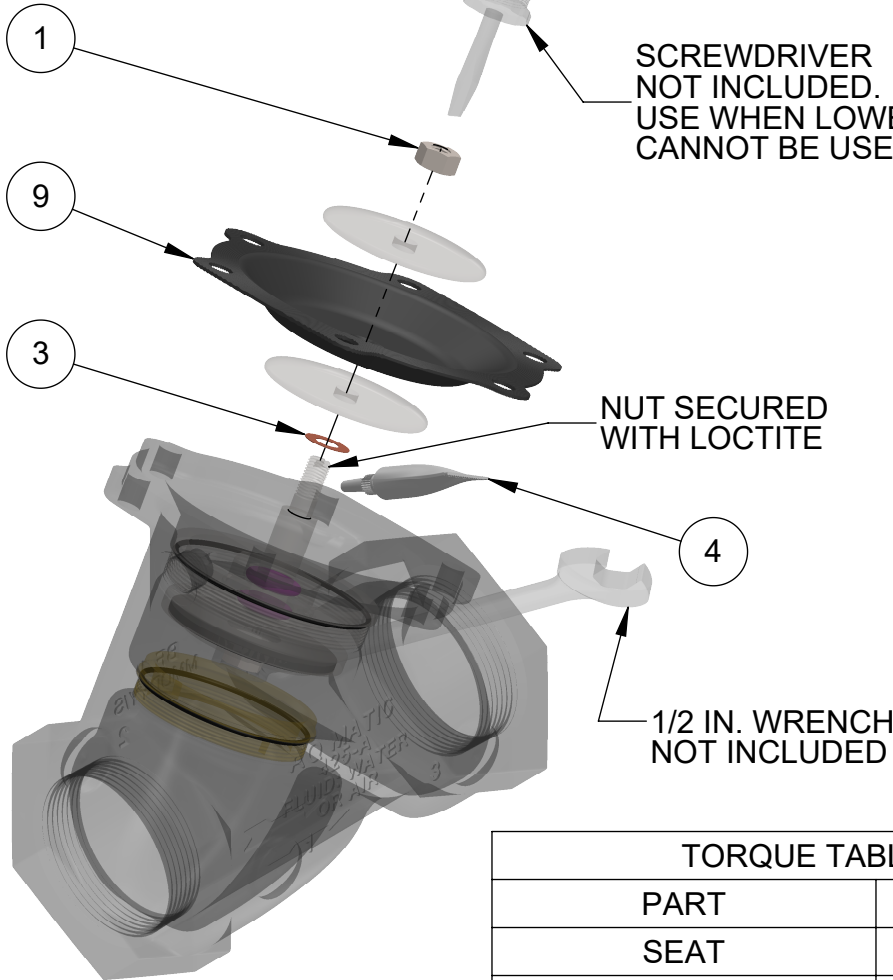
STEP 4

1 1/8 IN. SOCKET  
NOT INCLUDED  
(1 IN. BEFORE 2014)



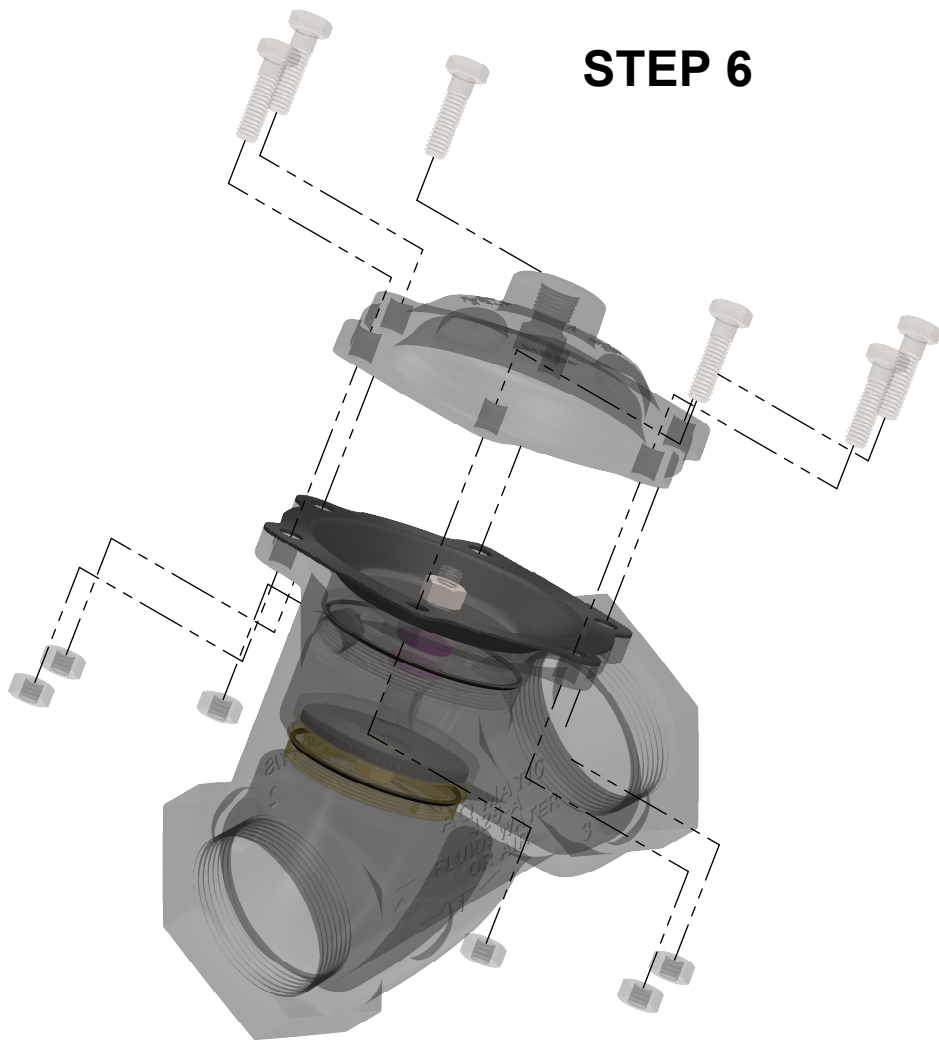
STEP 5

SCREWDRIVER  
NOT INCLUDED.  
USE WHEN LOWER NUT  
CANNOT BE USED.



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

STEP 6



- NOTES:
- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
  - ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.

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,425,D&S,NO,EP |         |              |     |
| DWG NO.           | 1070083 | REV.         | A   |
| SIZE              | C       | SCALE        | 2:5 |
|                   |         | SHEET 1 OF 1 |     |