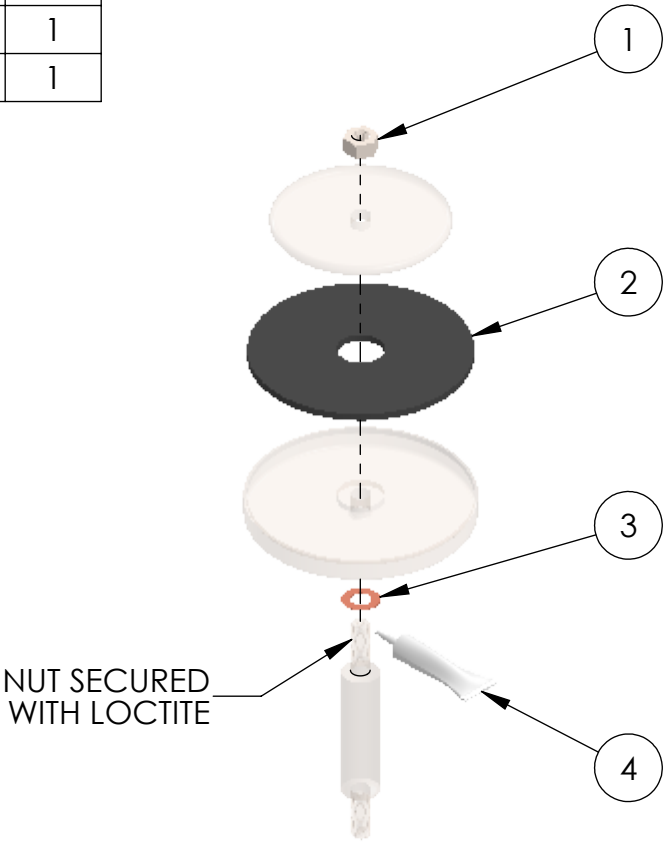


| ITEM NO. | PART NO. | MODEL     | DESCRIPTION               | QTY. |
|----------|----------|-----------|---------------------------|------|
| 1        | 1263853  | RMET      | HEX NUT 5/16" - 24        | 2    |
| 2        | 1074489  | 427-JE    | DISC,427,EPDM             | 1    |
| 3        | 1074252  | 424-R     | COPPER GASKET             | 2    |
| 4        | 1262436  | -         | LOCTITE 565 POLYTUBE      | 1    |
| 5        | 1071754  | ORE-233   | O-RING,-233,EPDM          | 1    |
| 6        | 1071729  | ORE-114TC | O-RING,-114,EP,TEF COATED | 2    |
| 7        | 1071755  | ORE-237   | O-RING,-237,EPDM          | 1    |
| 8        | 42561    | -         | LUBRICANT,SILICONE,PACKET | 1    |
| 9        | 1074475  | 427-FB    | DIAPHRAGM,427,BUNA        | 1    |

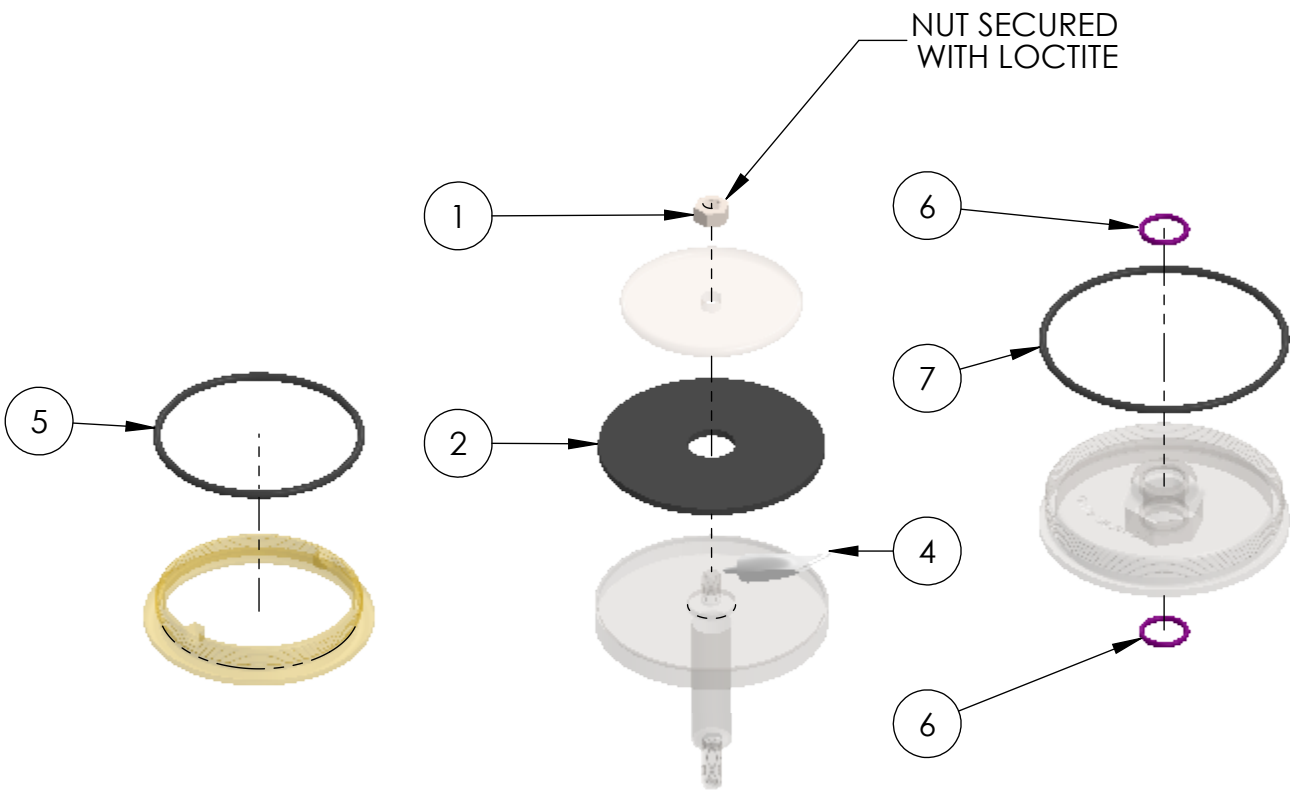
1070085 SEAL AND DIAPHRAGM KIT  
ASSEMBLY INSTRUCTION  
MODEL NO. 427-RAE

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

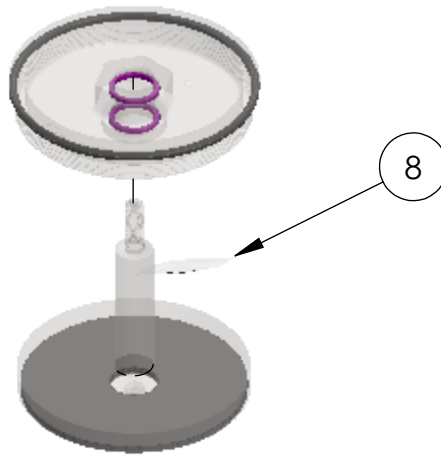
LEGACY TWO  
PIECE SHAFT



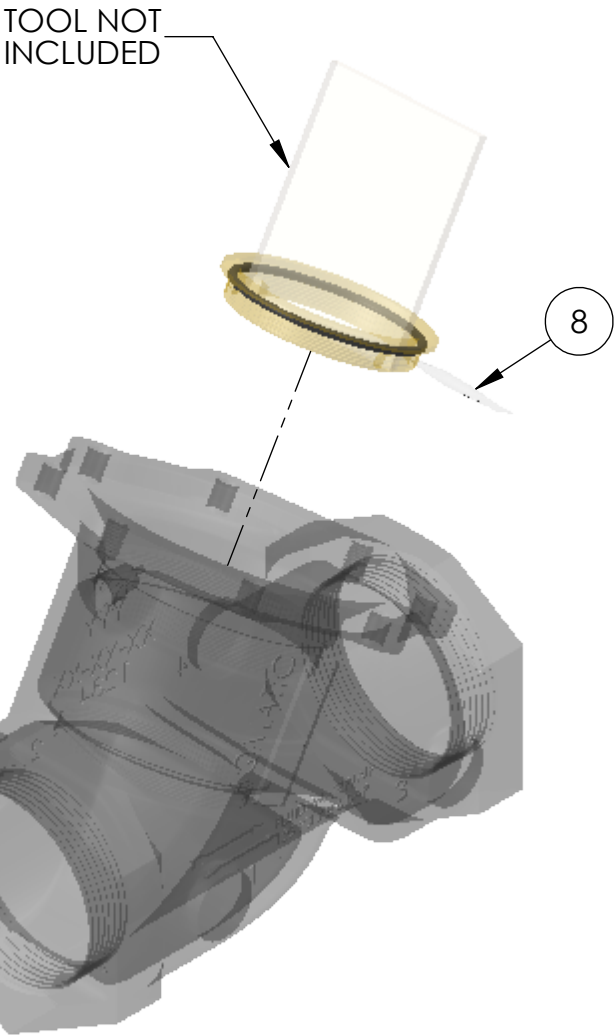
STEP 1  
(WITH ONE PIECE SHAFT)



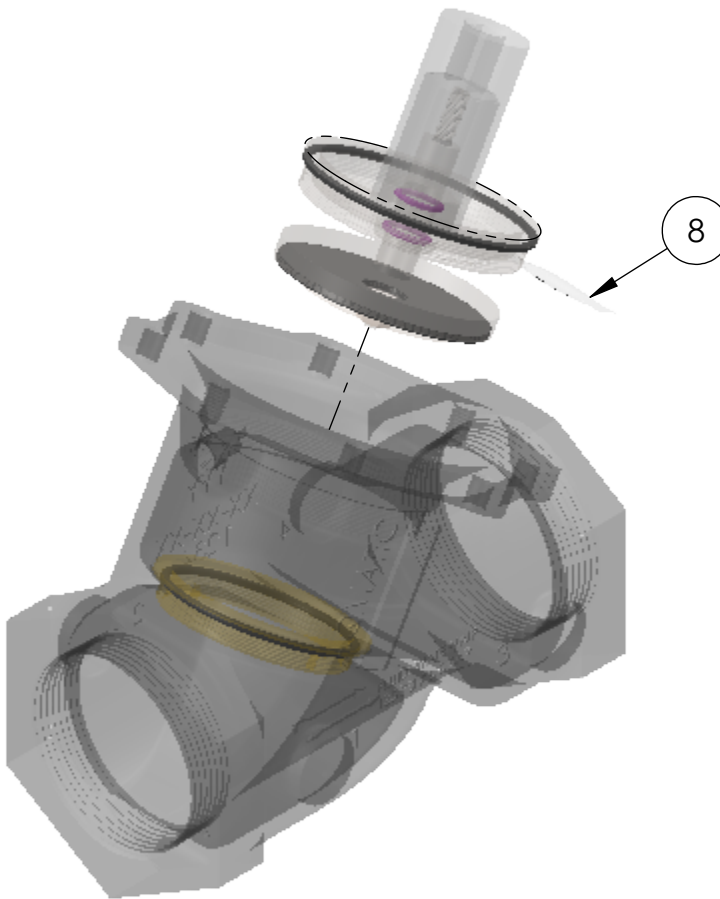
STEP 2



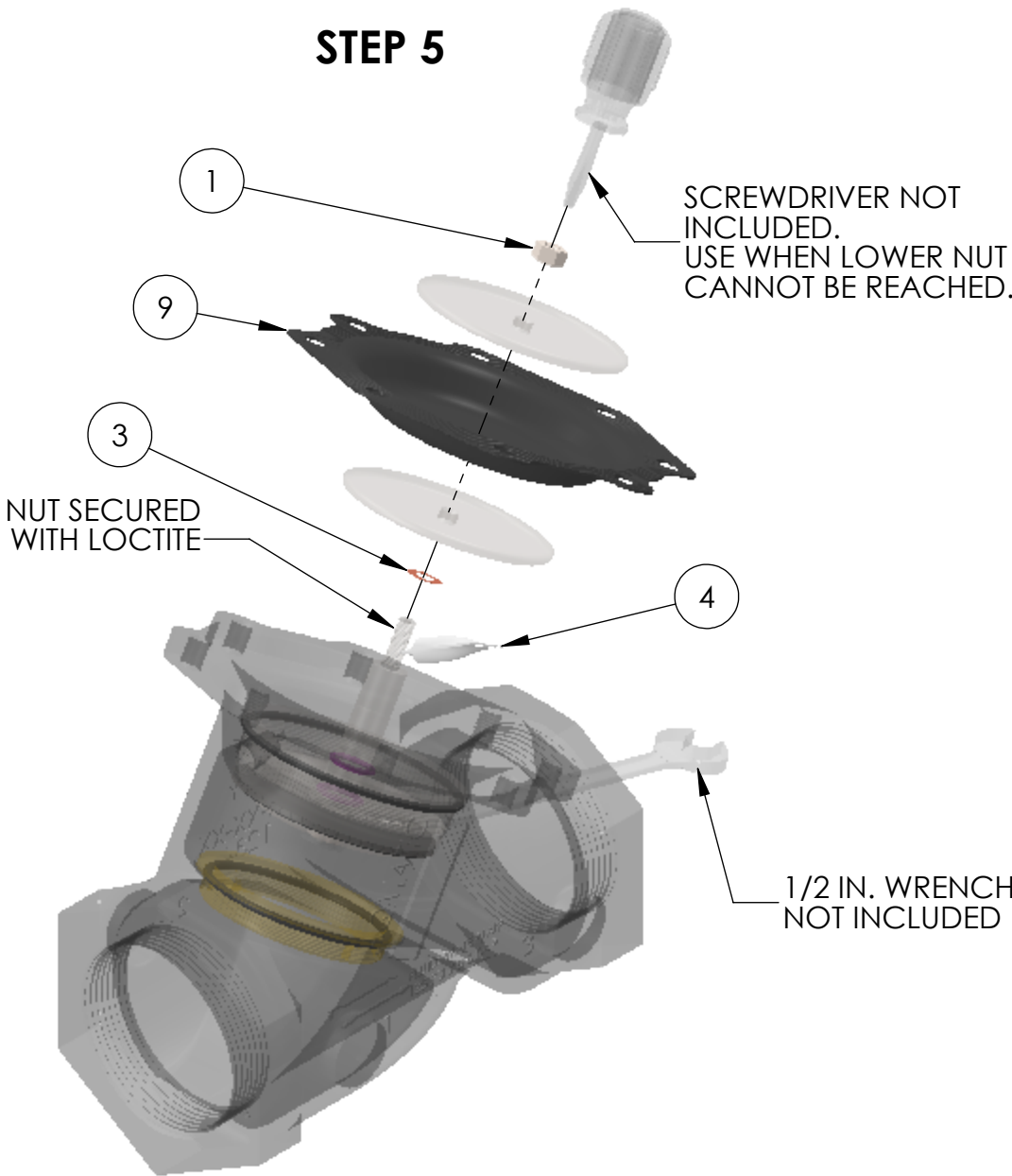
STEP 3



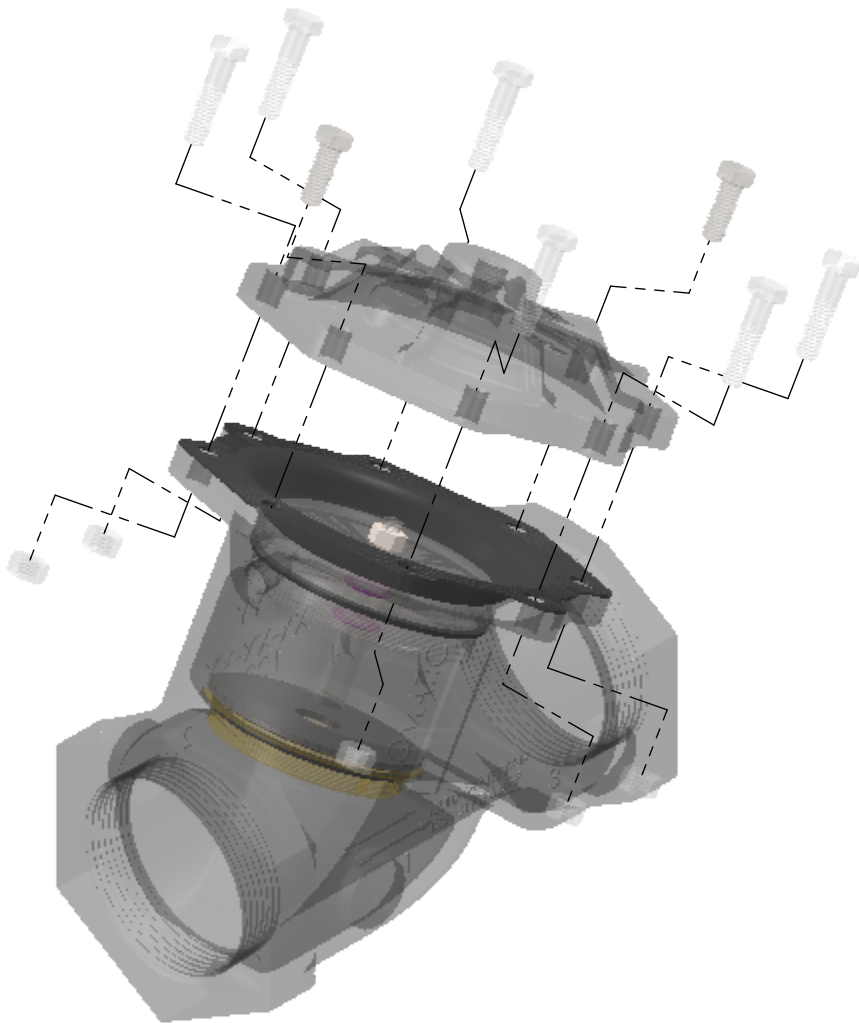
STEP 4



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,EP |         |              |     |
| DWG NO.        | 1070085 | REV.         | A   |
| SIZE           | C       | SCALE        | 1:3 |
|                |         | SHEET 1 OF 1 |     |