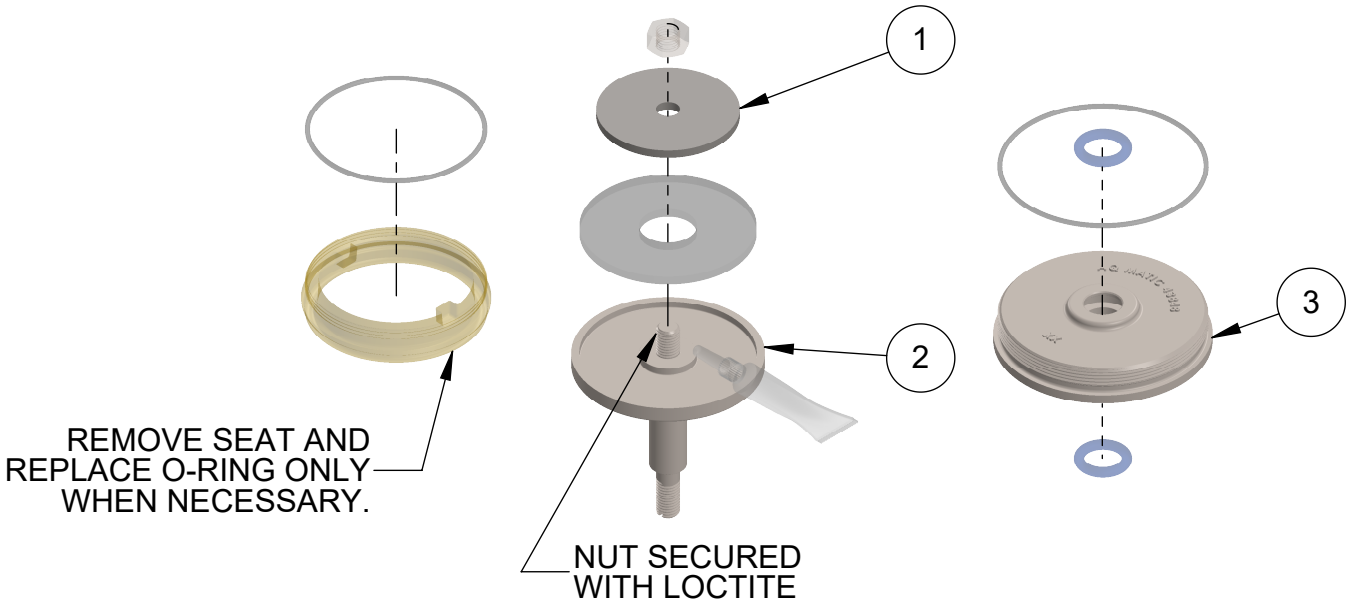


4				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	43943	424-DS	PLATE,424 DIAP/425 DISC PLATE	1
2	44017-01	425-LL	COMBO. SHAFT, NORMALLY CLOSED	1
3	43848	-	GUIDE,SHAFT,AV5,SS	1
4	4510417	-	DIAPHRAGM PLATE,425 DISC,426	2

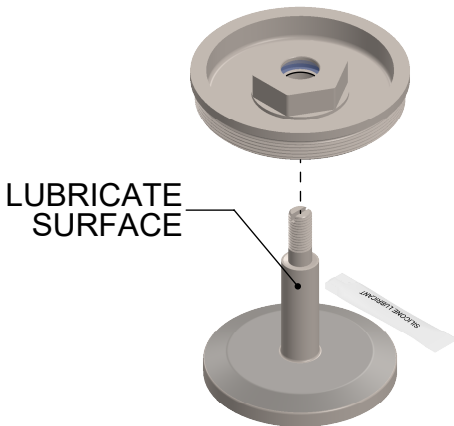
1070131 INTERNAL PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 425-RG

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

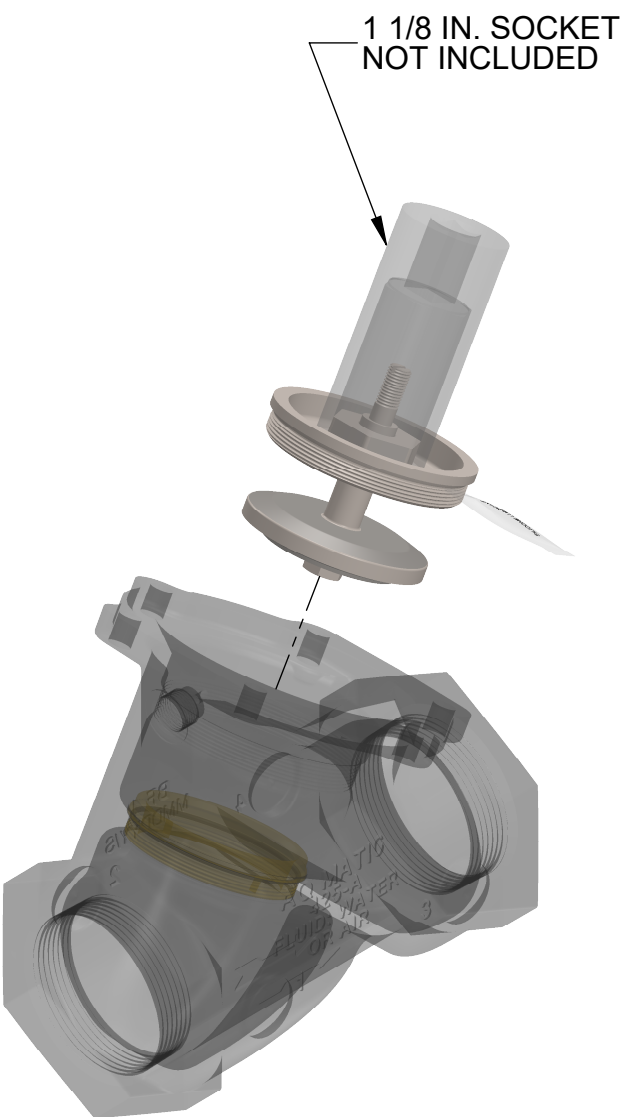
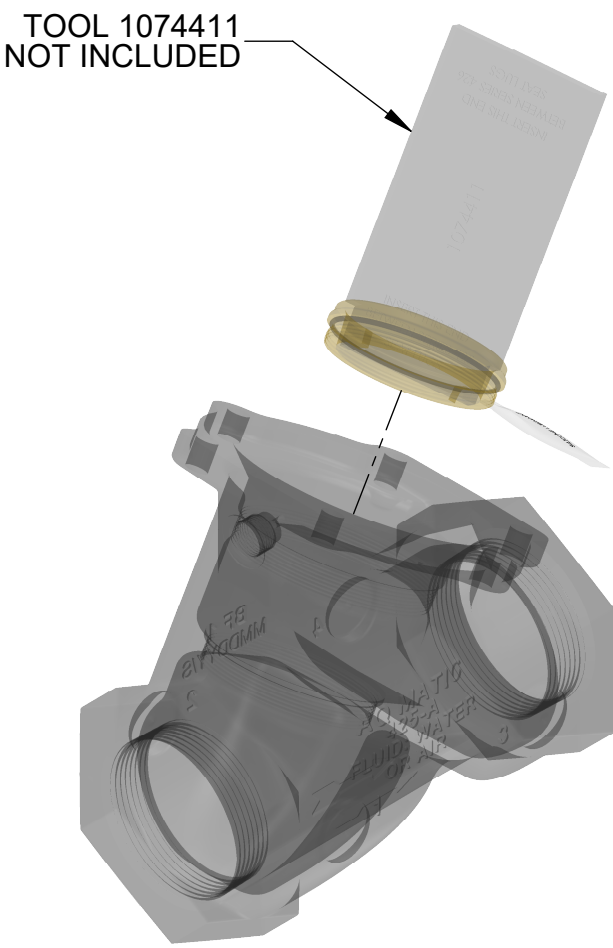
STEP 1
(WITH ONE PIECE SHAFT)



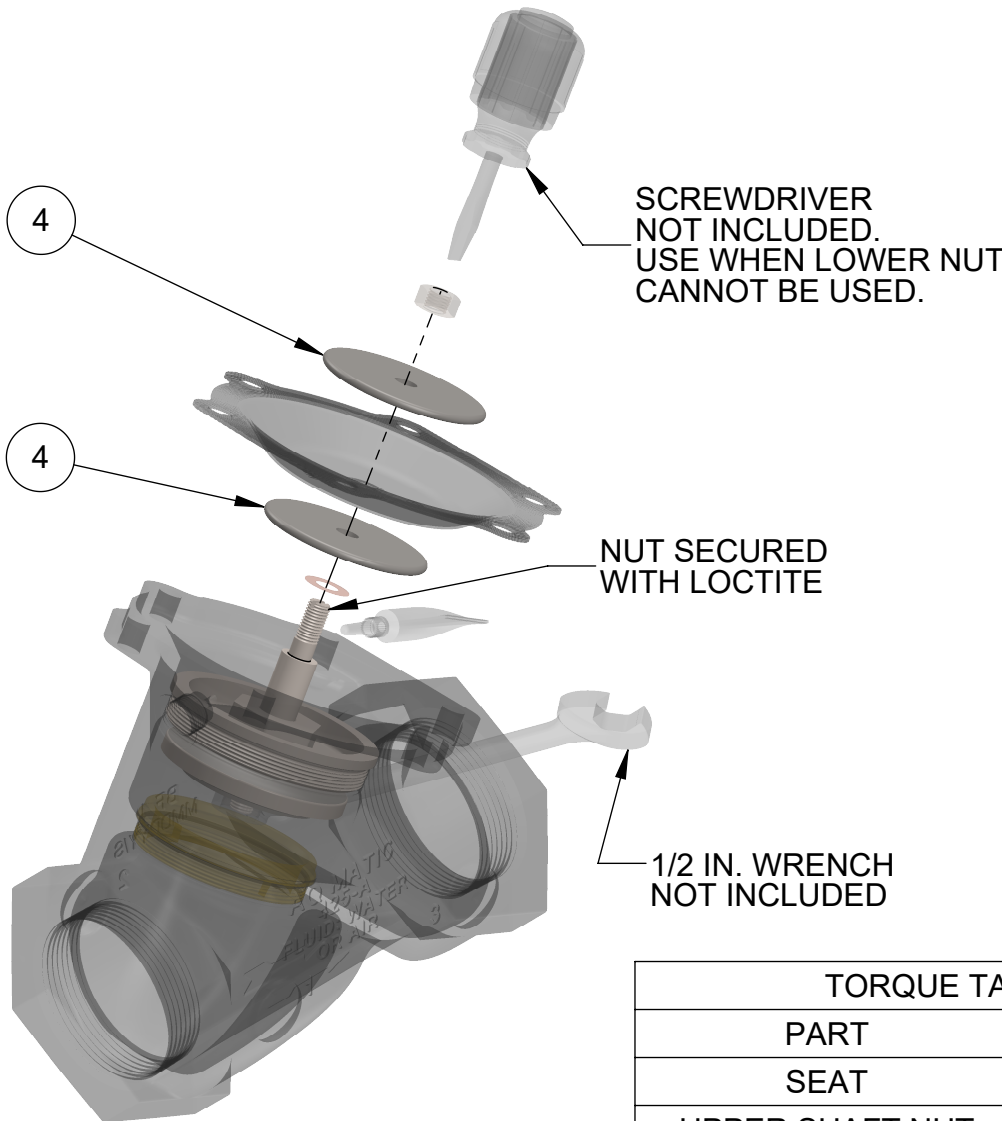
STEP 2



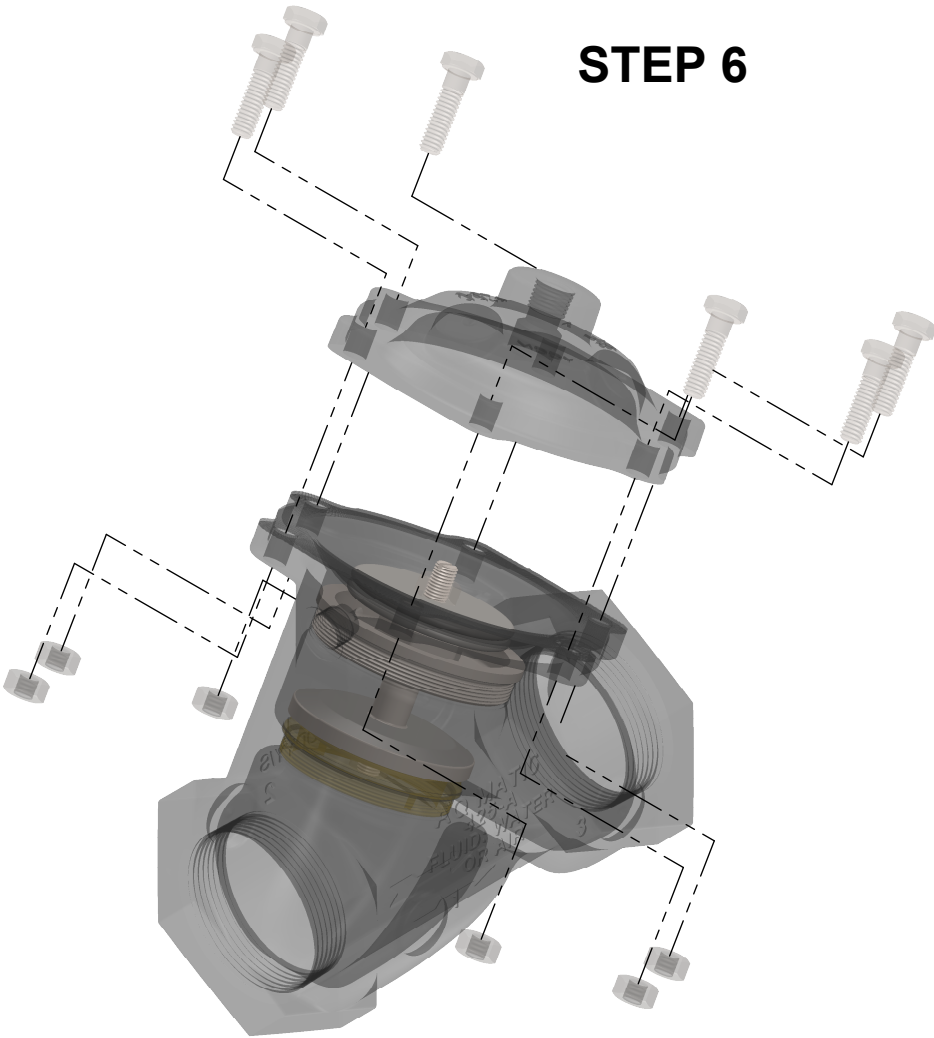
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



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	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.

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

THIS DOCUMENT IS SOLELY THE PROPERTY OF AQ-MATIC. REPRODUCTION, USE DISCLOSURE, OR TRANSMISSION OF THIS DOCUMENT OR DETAILS CONTAINED HEREIN, IN PART OR IN WHOLE, IS PROHIBITED WITHOUT THE WRITTEN CONSENT OF AQ-MATIC ENGINEERING. THIS DOCUMENT AND ANY COPIES SHALL BE RETURNED TO AQ-MATIC UPON WRITTEN REQUEST.

AQMATIC
Valves & Controls

DESCRIPTION
KIT,425,INT,NC

DWG NO. **1070131** REV. **A**

SIZE **C** SCALE **2:5** SHEET 1 OF 1