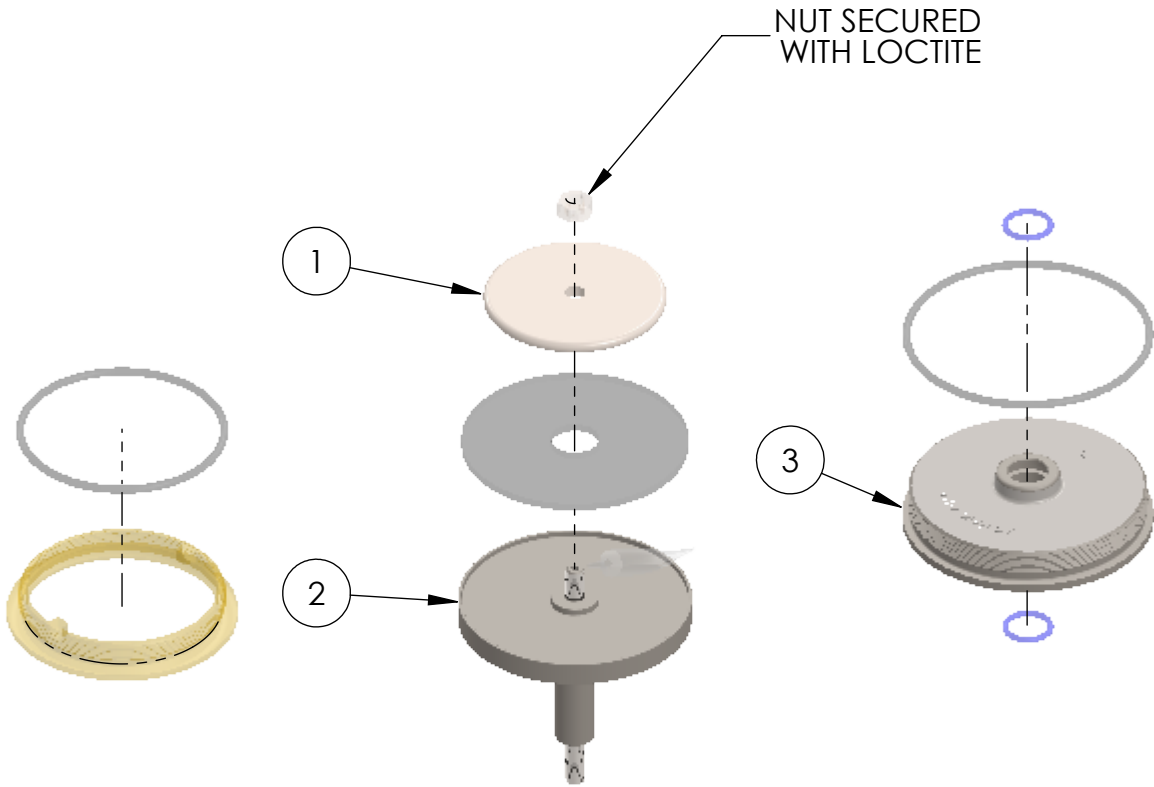


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1074371	426-DA	PLATE,426 DIAPH,427 DIC PLATE	1
2	4510301-02	-	SHAFT NORMALLY CLOSED	1
3	43850	427-GASO	SHAFT GUIDE, MACHINED	1
4	1074472	427-DA	DIAPHRAGM PLATE	2

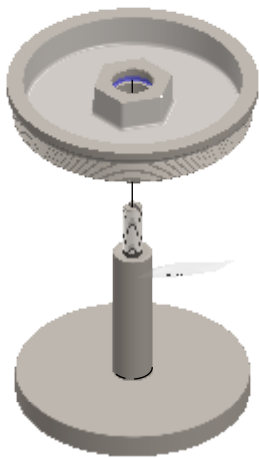
1070133 INTERNAL PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 427-RG

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

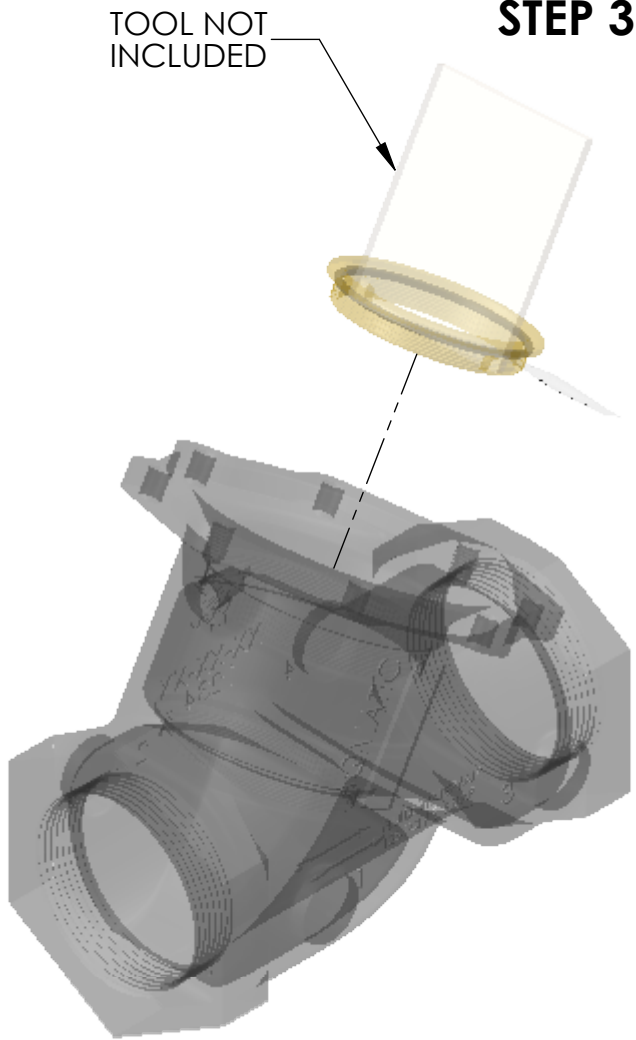
STEP 1
(WITH ONE PIECE SHAFT)



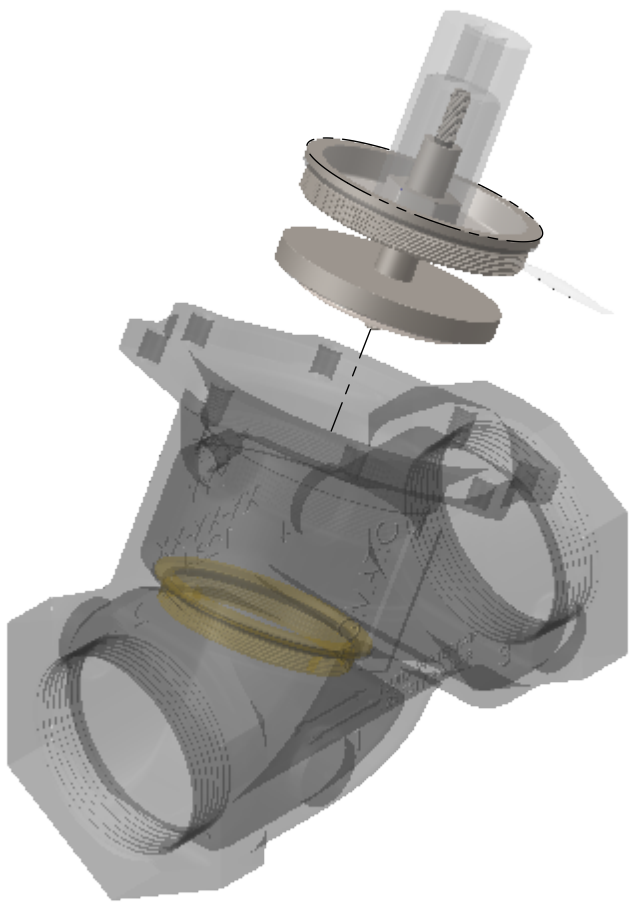
STEP 2



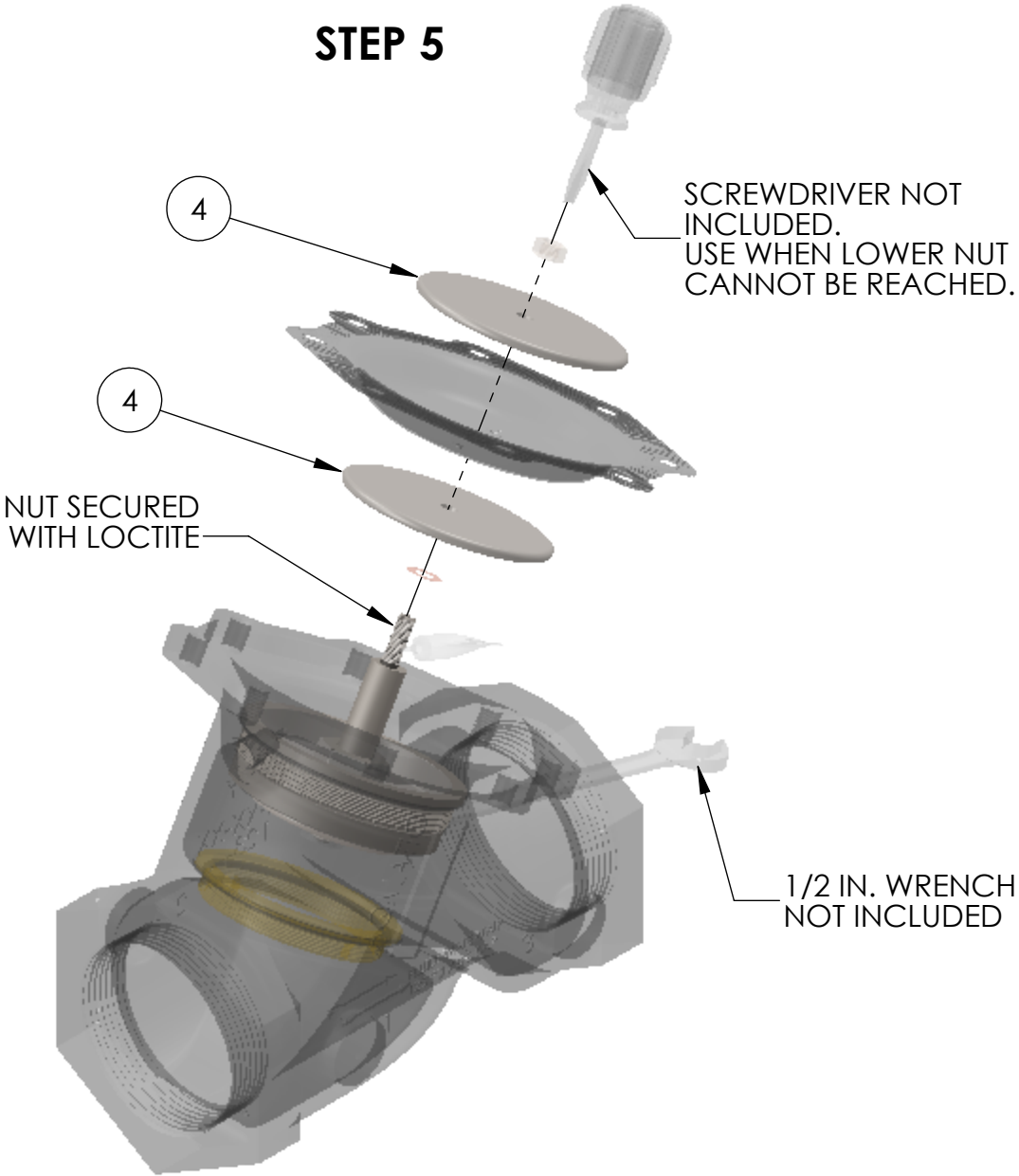
STEP 3



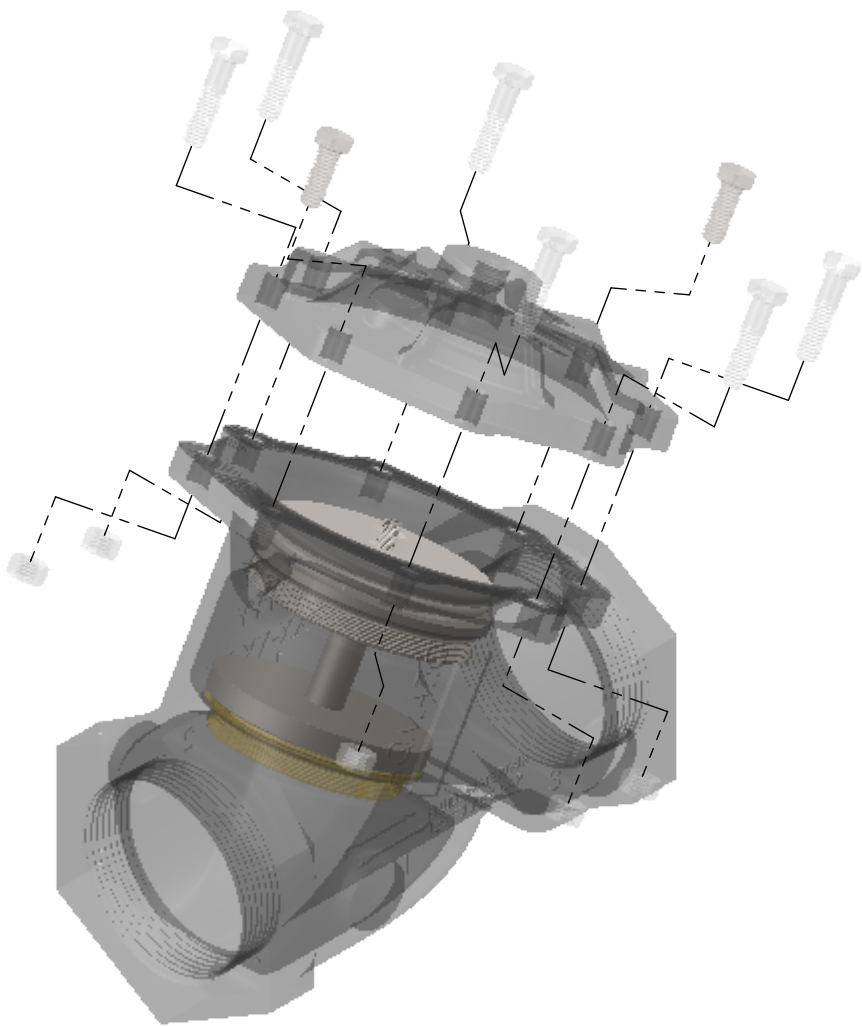
STEP 4



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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AQMATIC
Valves & Controls

DESCRIPTION
KIT,427,INT,NC

DWG NO. **1070133** REV. **A**

SIZE **C** SCALE **1:3** SHEET **1 OF 1**