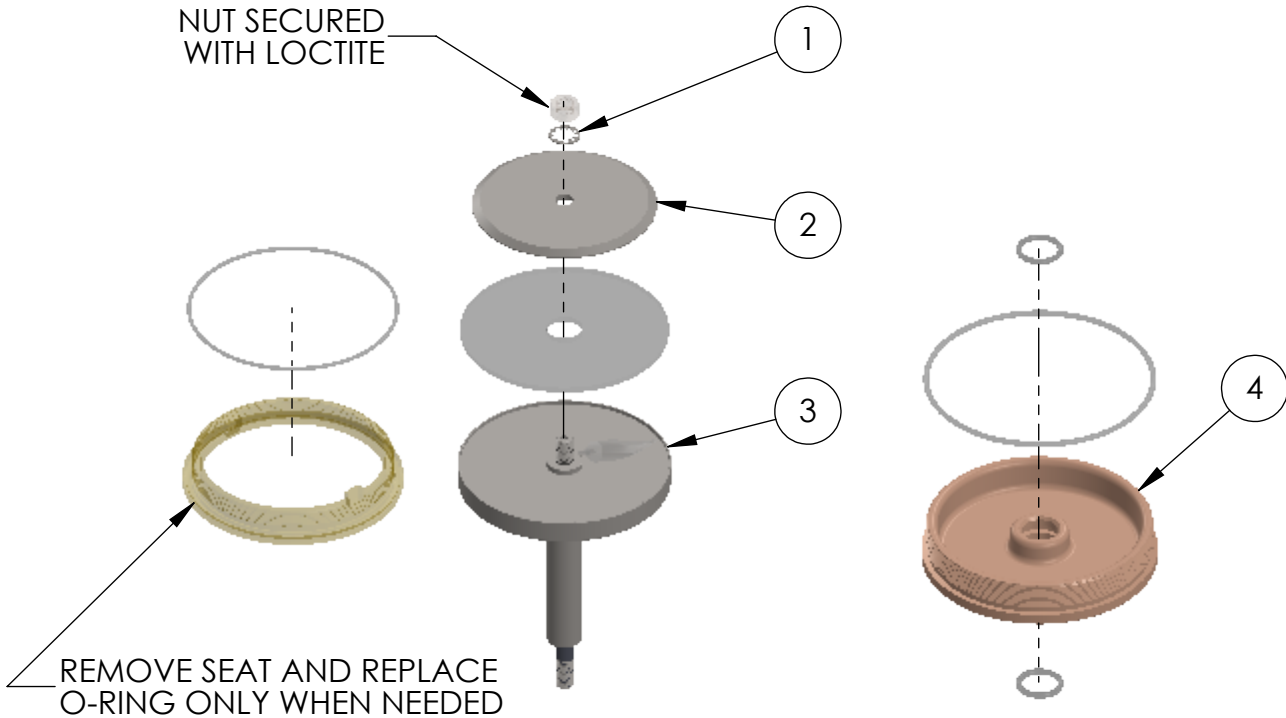


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1073591	WAS-0008	LOCKWASHER, 3/8", INTERNAL	2
2	43734	428-KA	PLATE,DISC,428,SS	1
3	4510302-02	-	SHAFT,428,COMBO,NC	1
4	1074563	428-GO	GUIDE,SHAFT,428,BRASS,MCHD	1
5	43759	428-D	PLATE,DIAPHRAGM,428,SS	2

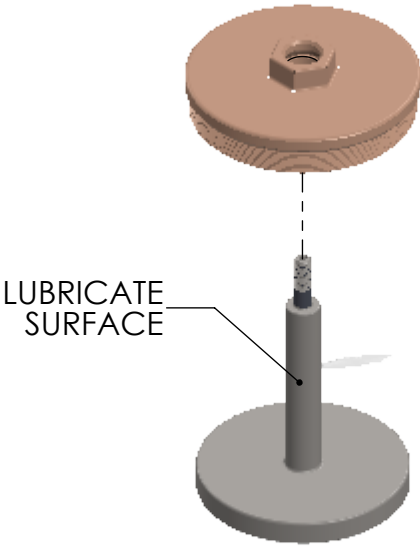
1070134 INTERNAL PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 428-RG

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

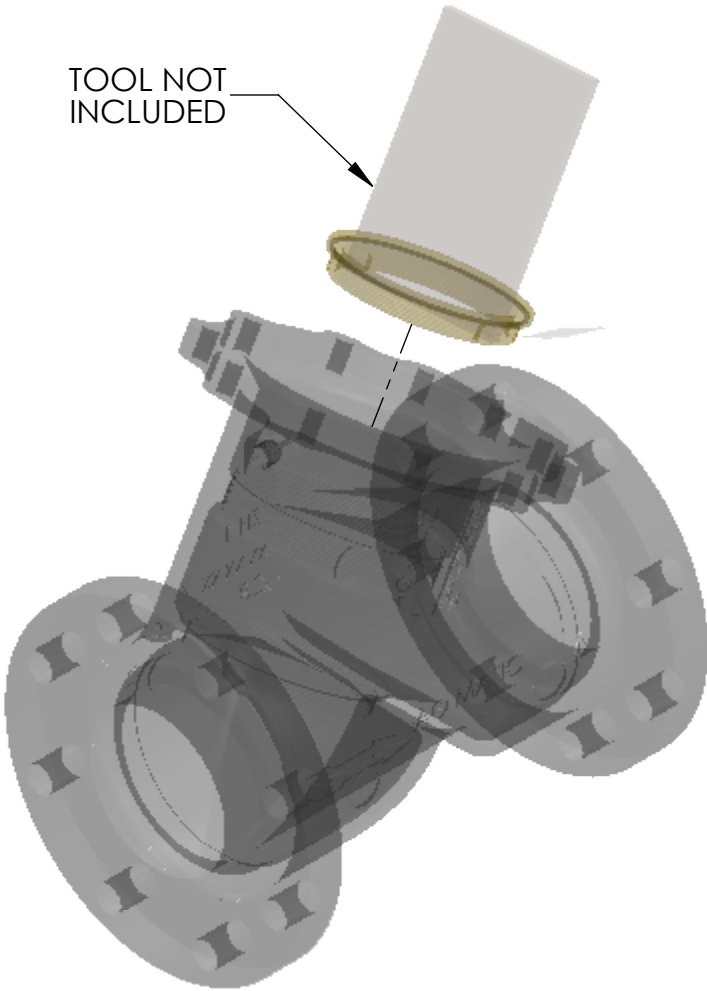
STEP 1
(WITH ONE PIECE SHAFT)



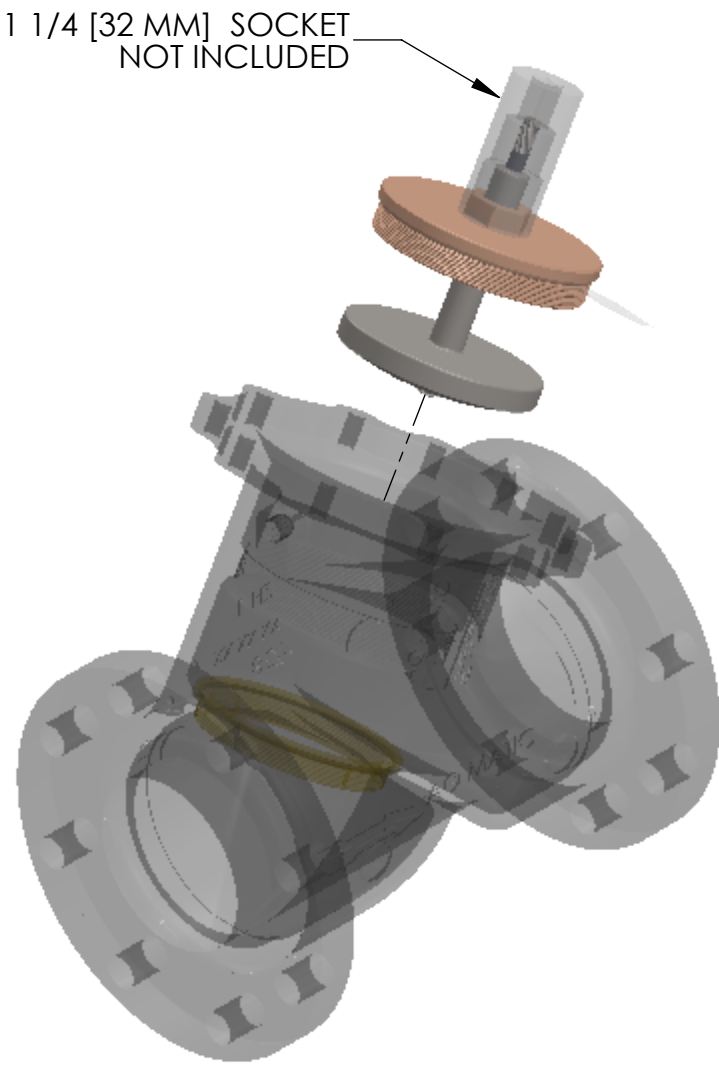
STEP 2



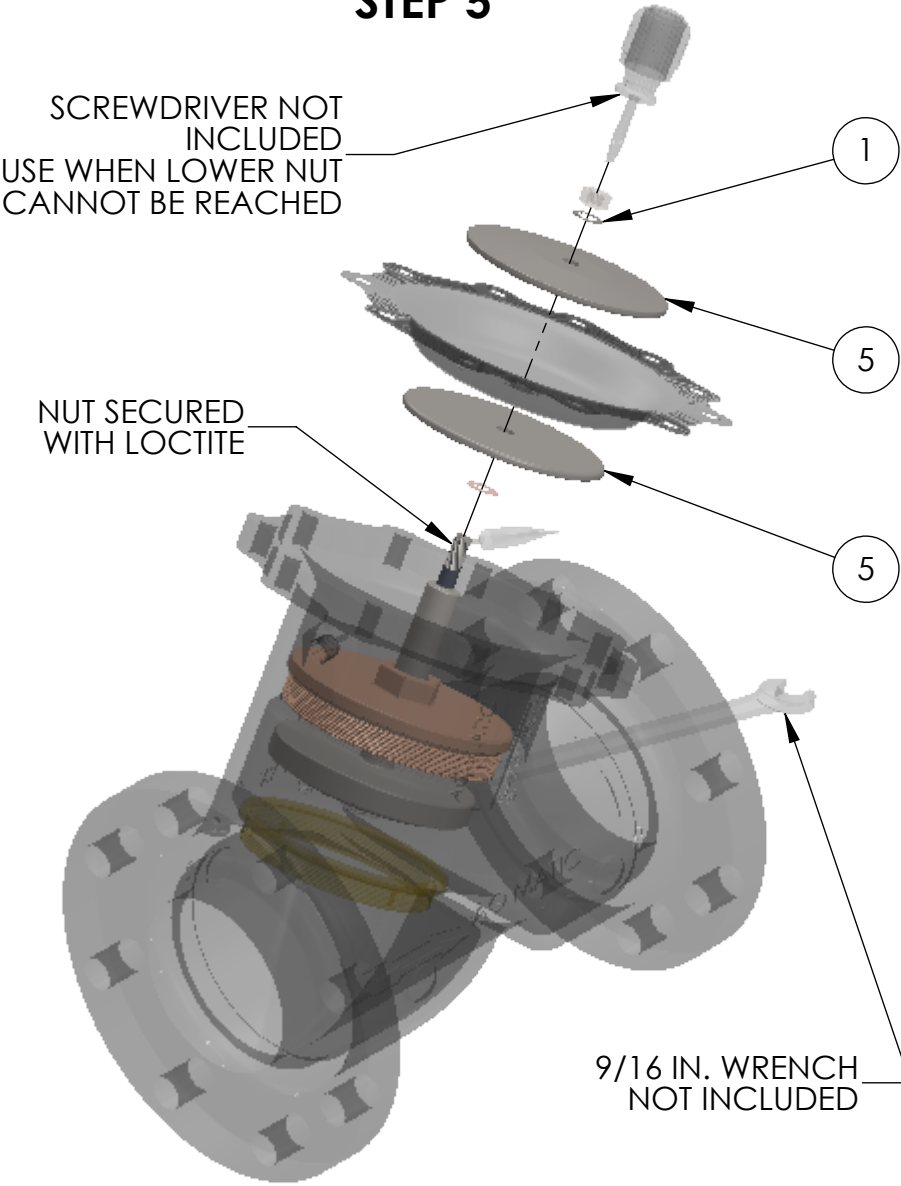
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



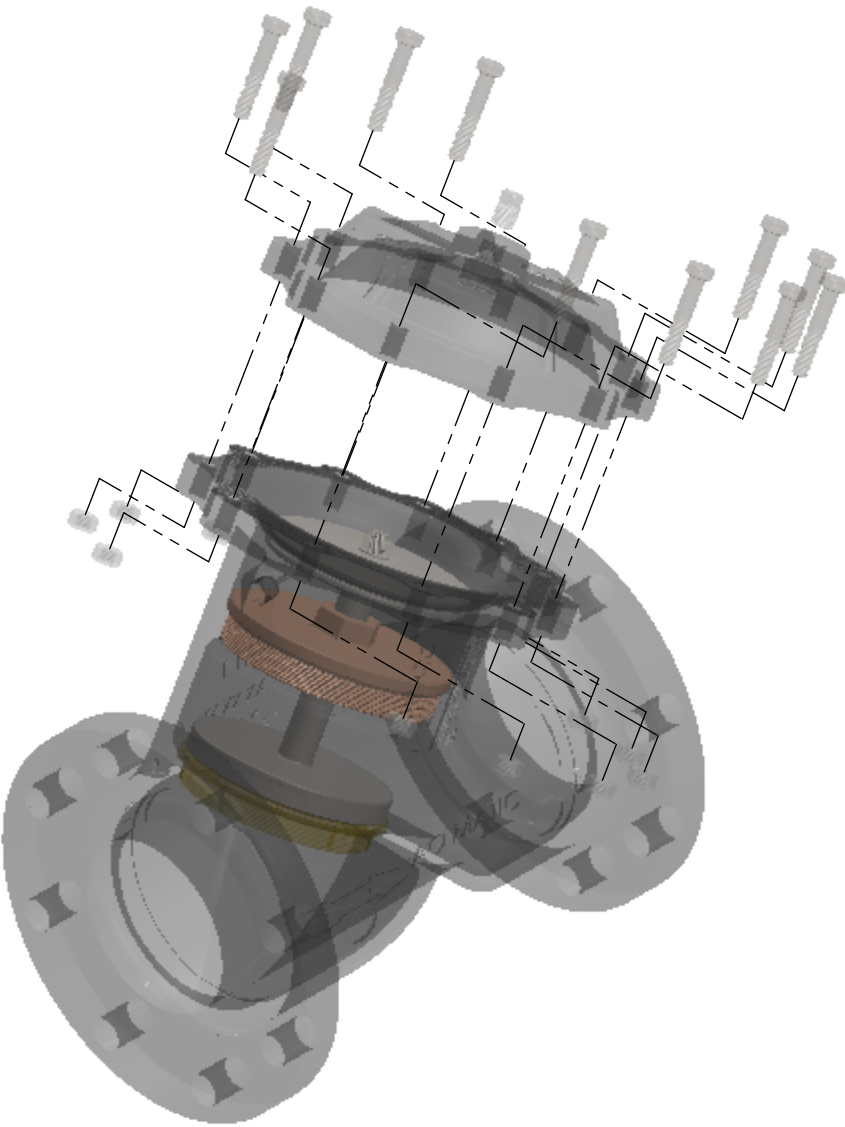
STEP 4



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]
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.

DESCRIPTION	
KIT,428,INT,NC	
DWG NO.	1070134
REV.	A
SIZE	C
SCALE	1:4
SHEET	1 OF 1