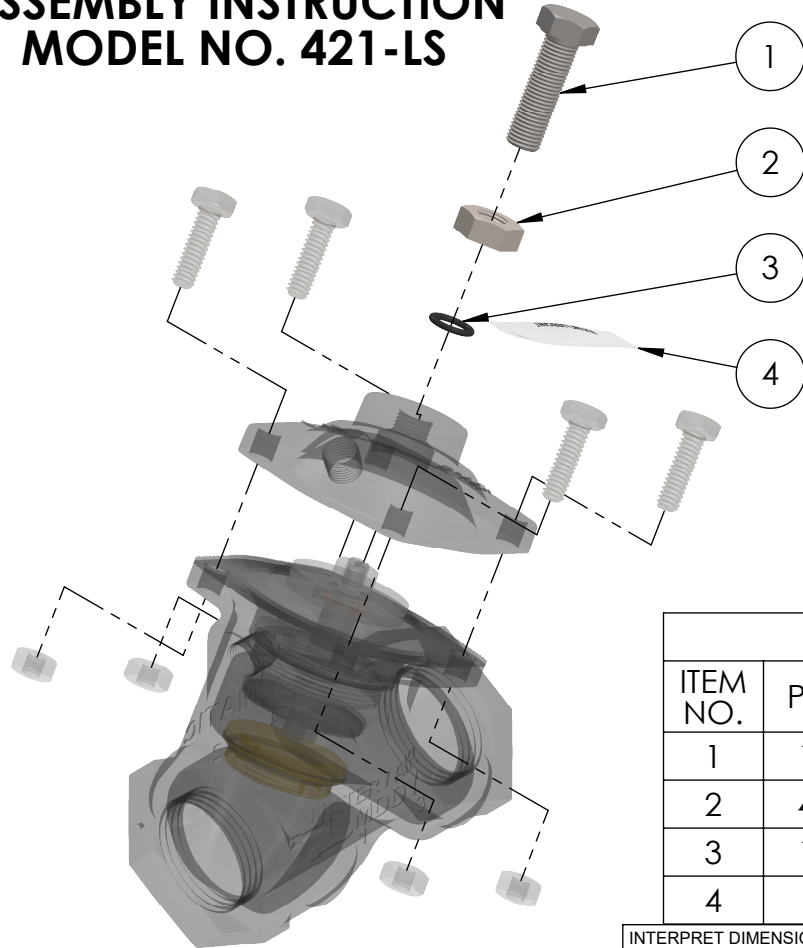


1074154 REPAIR PARTS KIT ASSEMBLY INSTRUCTION MODEL NO. 421-LS



NOTES:

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

BILL OF MATERIALS

ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1072361	SCS-0030	SCREW,HEX HD CAP,3/8-24 X 1.2	1
2	4510459	400-H	NUT,STOP,3/8-24,MACHINED	1
3	1071668	ORB-012	O-RING,-012,BUNA	1
4	42561	-	LUBRICANT,SILICONE,PACKET	1

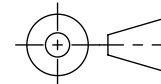
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M -2018.

PRIMARY UNITS SHOWN IN INCHES.
SECONDARY UNITS SHOWN IN MILLIMETERS.

DEFAULT TOLERANCES:

ANGLES : $\pm 1^\circ$
1 PLACE .X: $\pm .100$ [2.54]
2 PLACE .XX: $\pm .010$ [0.3]
3 PLACE .XXX: $\pm .005$ [0.13]

THIRD ANGLE PROJECTION



THE COMPONENT OR PRODUCT DESCRIBED IN THIS DOCUMENT
MUST COMPLY WITH **RoHS 3 EU (EUROPEAN UNION) DIRECTIVE
2015/863 AND EU REACH REGULATION (EC) 1907/2006.**

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.

REVISIONS

ECN	REV	DESCRIPTION	DATE	APPROVED
2392	A	INITIAL RELEASE	5/21/2024	PMJ

TORQUE TABLE

PART	TORQUE
UPPER SHAFT NUT	90 IN.LBS.
LOWER SHAFT NUT	90 IN.LBS.
SHAFT GUIDE	120 IN.LBS.
CAP SCREWS & NUTS	140 IN.LBS.



AQMATIC
Valves & Controls

DESCRIPTION

KIT,421,INT,LS

DWG NO.	1074154	REV.	A
SIZE	A	SCALE	1:2
		SHEET 1 OF 1	