

1074162 REPAIR PARTS KIT ASSEMBLY INSTRUCTION MODEL NO. 421-PI

REVISIONS

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

NOTES:

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

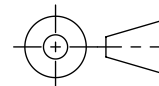
BILL OF MATERIALS

ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1071688	ORB-108TC	O-RING,-108,BUNA,TFLN CTD	1
2	1074121	421-GF	ROD,GUIDE,PI,V42	1
3	1071692	ORB-116	O-RING,-116,BUNA	1
4	1074182	421-TB	NUT,421,TOP,BRASS,PI	1
5	1074164	421-PM	PI ROD,421,SS,MACH	1
6	1073589	WAS-0006	LOCKWASHER,.25,IT	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
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Valves & Controls

DESCRIPTION

KIT,421,INT,PI

DWG NO.	1074162	REV.	A
SIZE	A	SCALE	1:2
		SHEET	1 OF 1

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.