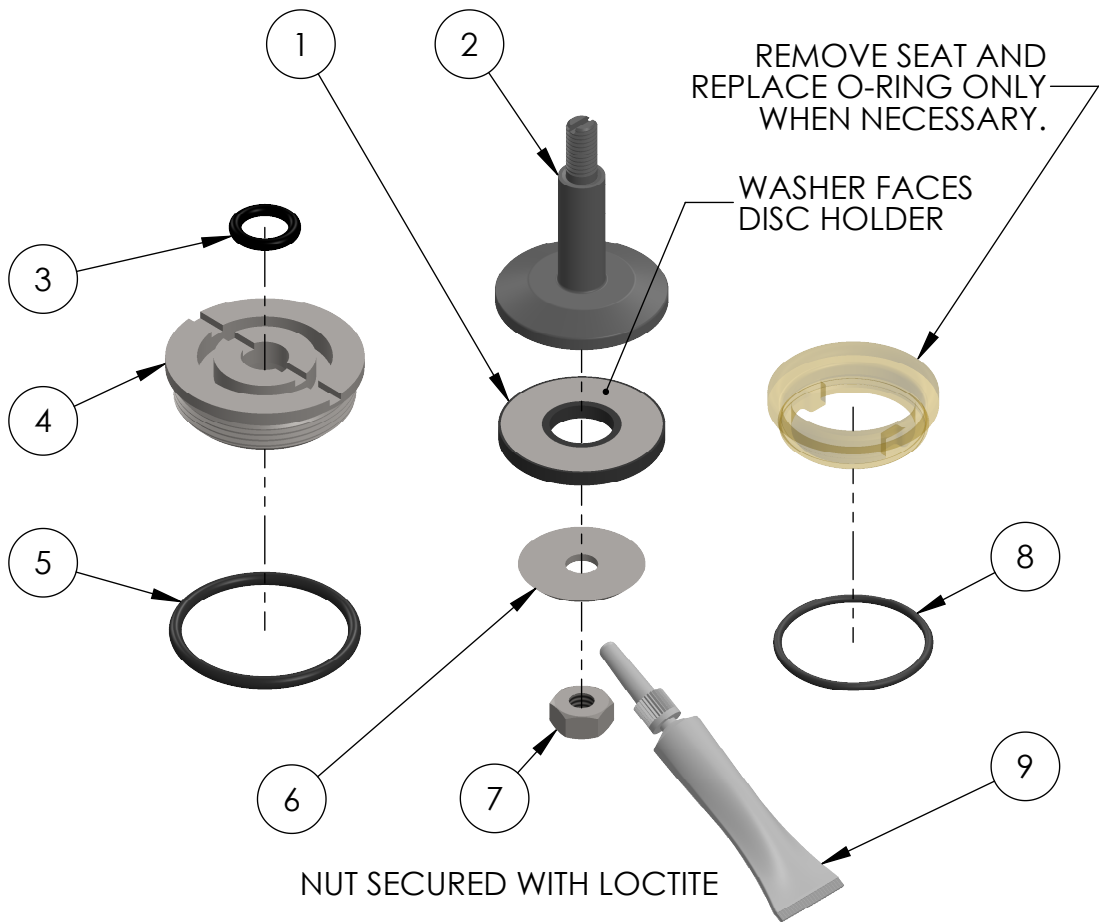


BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1074142	421-JBS	DISC,421,CSTM,EMPIRE	1
2	4510231	421-L2	SHAFT ASMBLY,421,NO	1
3	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
4	1074123	421-GGS	GUIDE,SHAFT,421,SS,MCHD	1
5	1071693	ORB-125	O-RING,-125,BUNA	1
6	1074148	421-KE	PLATE,DISC,421,SS,SPECIAL	1
7	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
8	1071676	ORB-024	O-RING,-024,BUNA	1
9	1262436	-	LOCTITE 565 POLYTUBE	1
10	42561	-	LUBRICANT,SILICONE,PACKET	1
11	43942	424-H	DIAPHRAGM PLATE	2
12	1074119	421-FB	DIAPHRAGM,421,BUNA	1
13	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	1
14	1074185	421-X	CENTERING NUT	1
15	1071674	ORB-020	O-RING,-020,BUNA	1
16	1078602	421-SS	SPRING,316SS	1

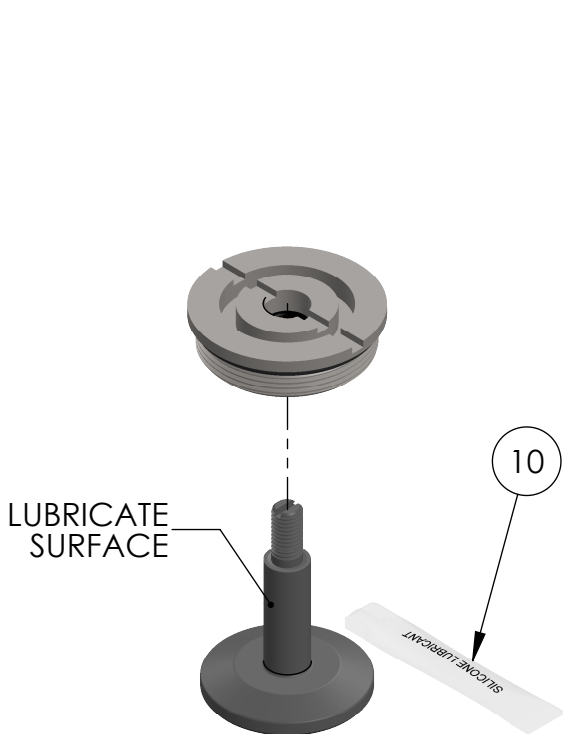
1074166 CUSTOM KIT ASSEMBLY INSTRUCTION
421-RAF12790

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
	C	REDRAWN IN SOLIDWORKS, 1-ADD'D: NOTE-2, 2-PART # NOW DWG #	9/5/2013	ANH
	D	1-WAS 1070616, 2-WAS 1074117, 3-WAS: 1074122, 4-WAS: 1074126, 5-WAS: 1071485, 6-WAS: 1071650, 7-WAS: 1074180, 8-REM'D: NOTE-2 (ROHS) 9-UPDATED TITLEBLOCK	3/19/2015	TJM
	E	REDRAWN IN AQ-MATIC FORMAT	5/28/2024	PMJ

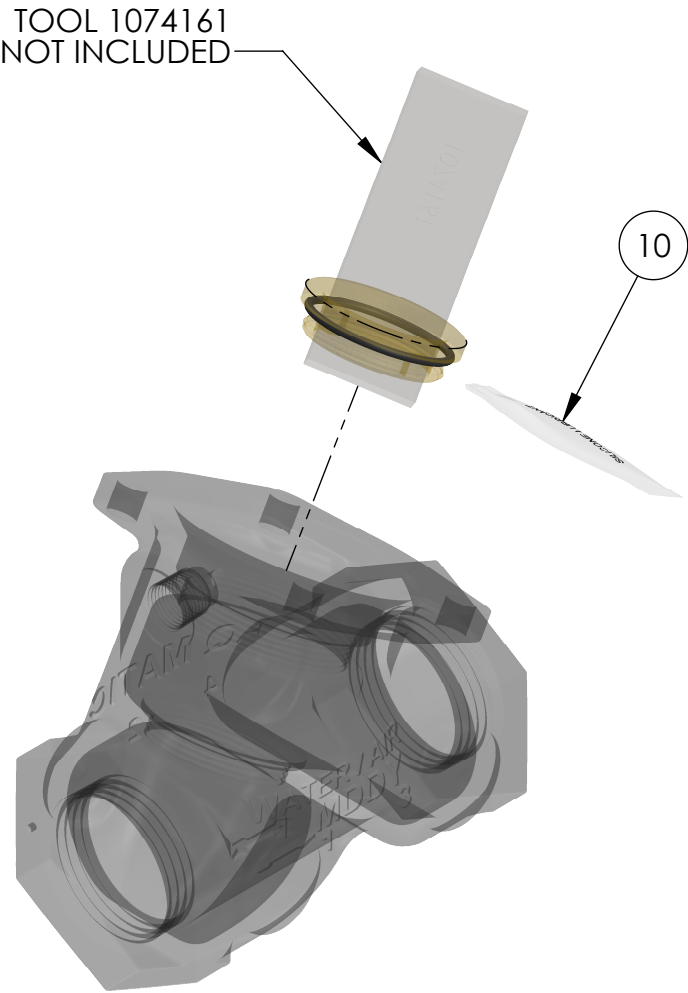
STEP 1
(WITH ONE PIECE SHAFT)



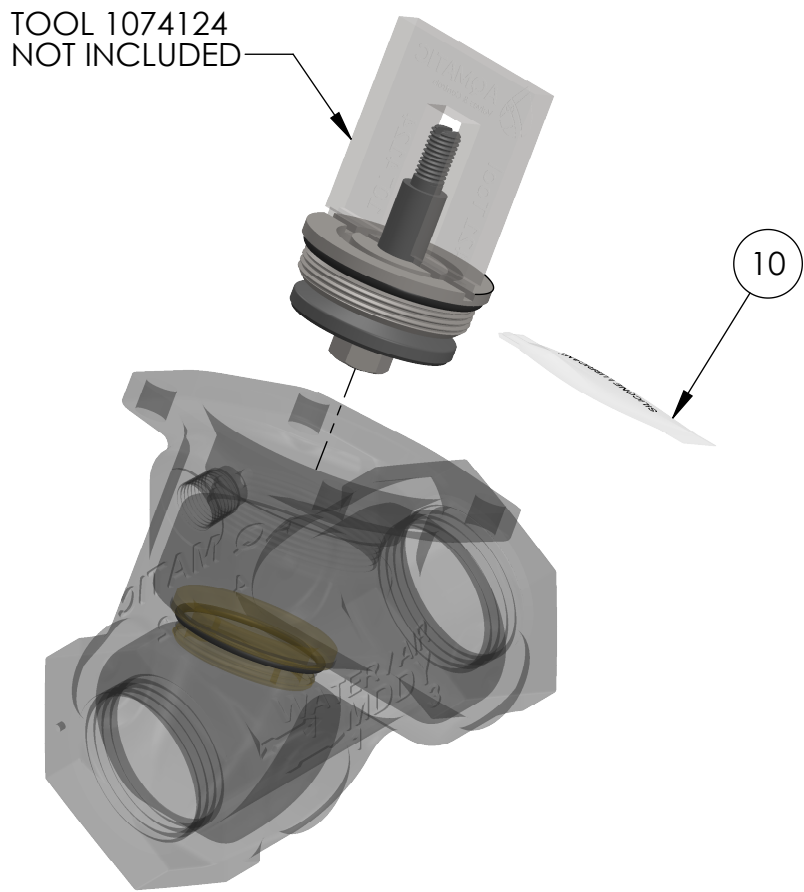
STEP 2



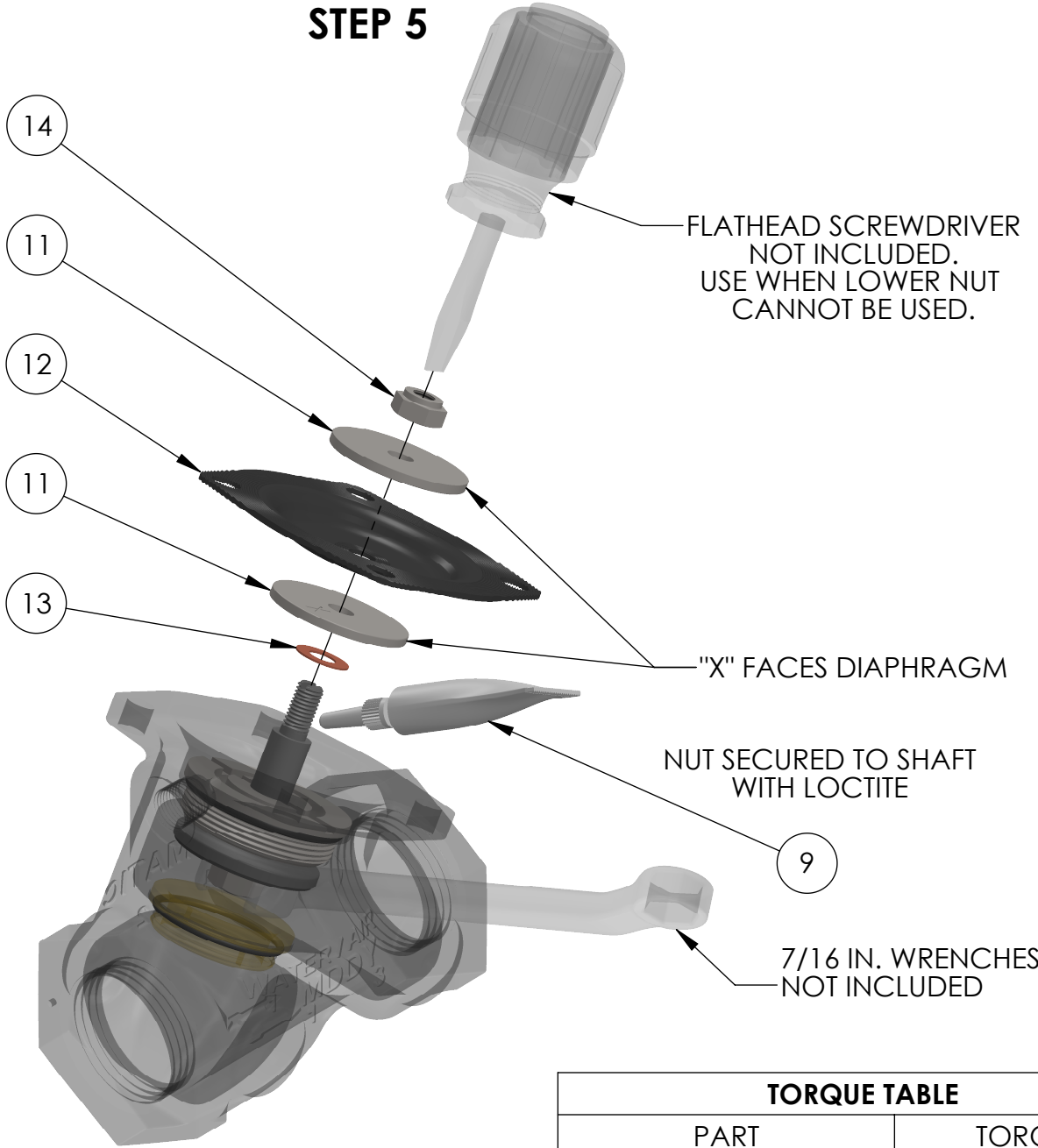
STEP 3
NOT NEEDED FOR MOST REPAIRS



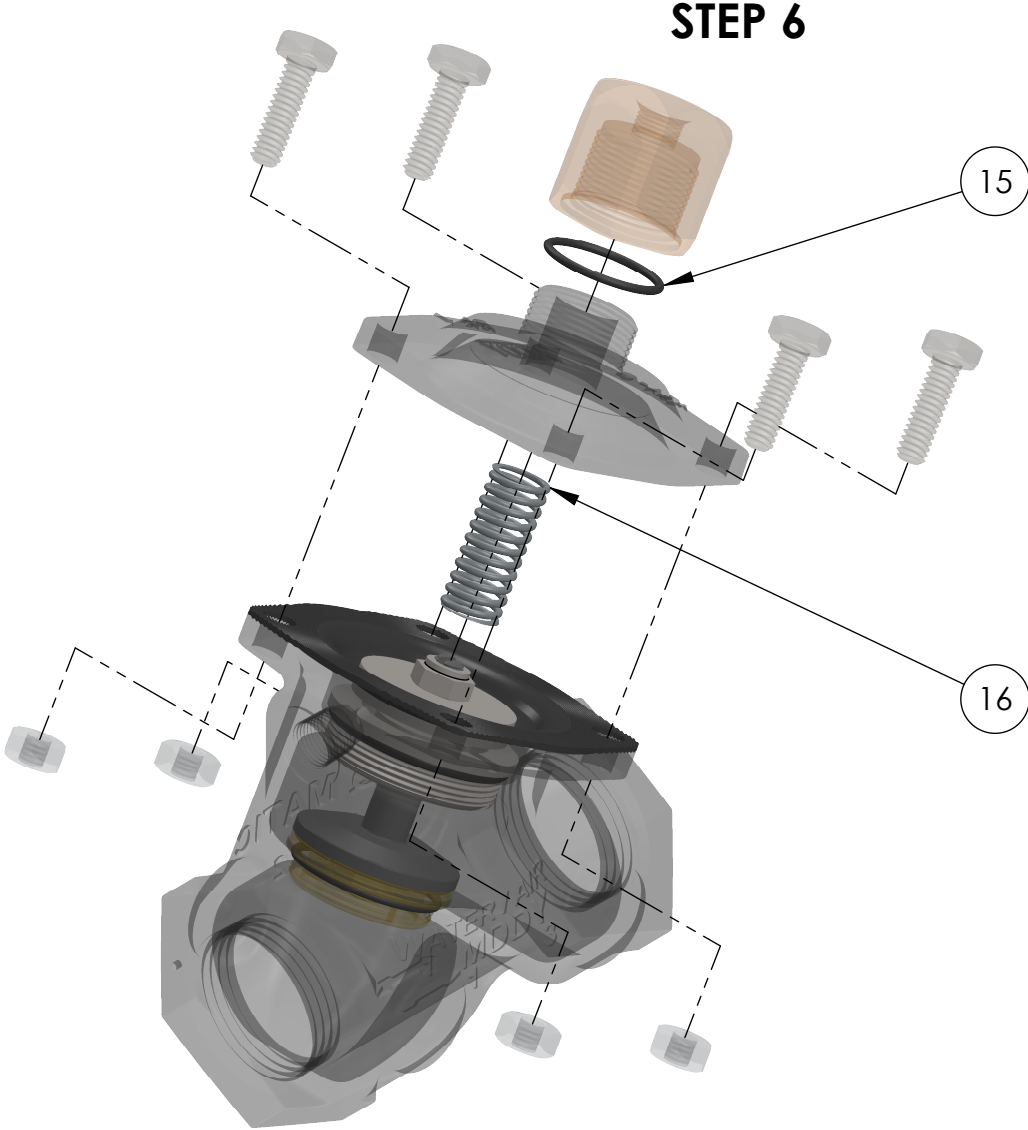
STEP 4



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.
 - LEGACY TWO PIECE SHAFT USES A COPPER GASKET BETWEEN SHAFT AND DISC HOLDER.
 - PRIOR TO REV C, ASSEMBLY WAS CONTROLLED BY DRAWING NO. 1082483.

TORQUE TABLE	
PART	TORQUE
SEAT	120 IN.LBS.
UPPER SHAFT NUT	90 IN.LBS.
LOWER SHAFT NUT	90 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.

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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DESCRIPTION
KIT,421,INT&D&S,CSTM

DWG NO. 1074166
SIZE C

REV. E
SCALE 2:3

SHEET 1 OF 1