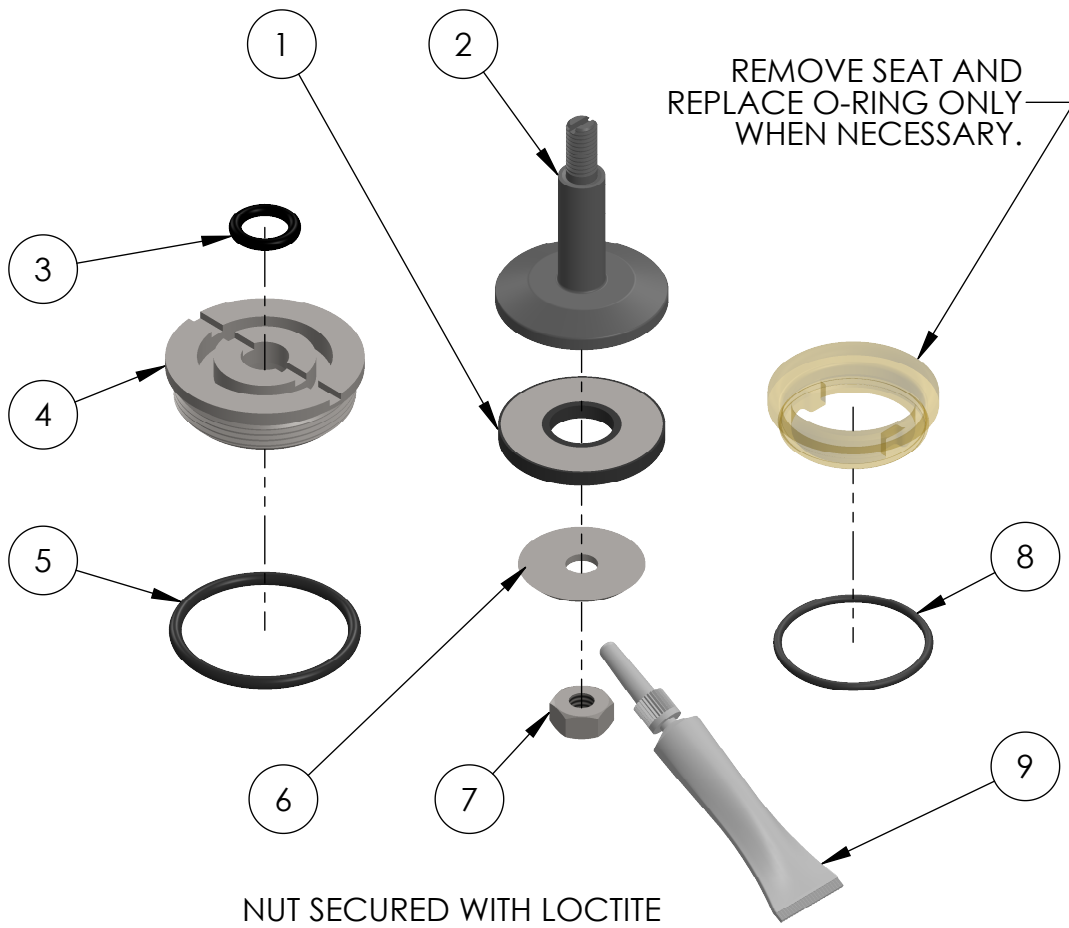


BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1074142	421-JBS	DISC,421,CSTM,EMPIRE	1
2	4510234	421-LE2	SHAFT ASMBLY,421,LE	1
3	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
4	1074123	421-GGS	GUIDE,SHAFT,421,SS,MCHD	1
5	1071693	ORB-125	O-RING,-125,BUNA	1
6	1074148	421-KE	PLATE,DISC,421,SS,SPECIAL	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	1074185	421-X	CENTERING NUT	1
12	43942	424-H	DIAPHRAGM PLATE	2
13	1074119	421-FB	DIAPHRAGM,421,BUNA	1
14	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	1
15	1071674	ORB-020	O-RING,-020,BUNA	1
16	1078602	421-SS	SPRING,316SS	1

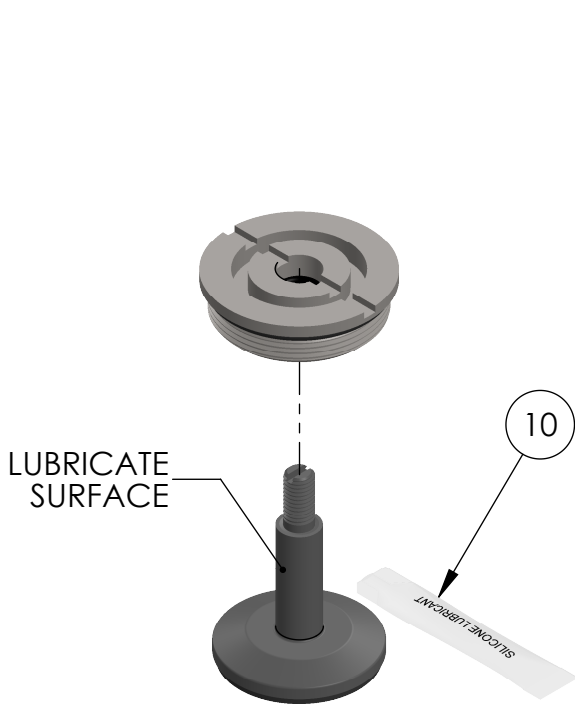
1074167 CUSTOM KIT ASSEMBLY INSTRUCTION

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
	C	REDRAWN IN SOLIDWORKS, 1-ADD'D: NOTE-2, 2-PART # IS NOW DGW #	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
2392	E	REDRAWN IN AQ-MATIC FORMAT.	5/31/2024	PMJ

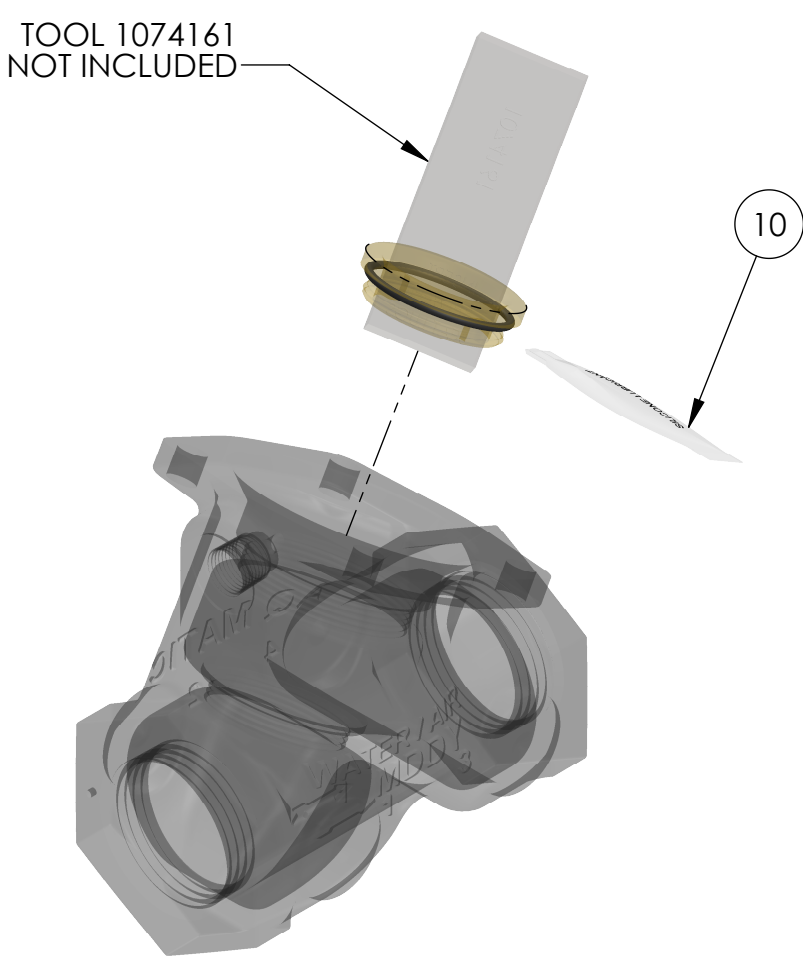
STEP 1
(WITH ONE PIECE SHAFT)



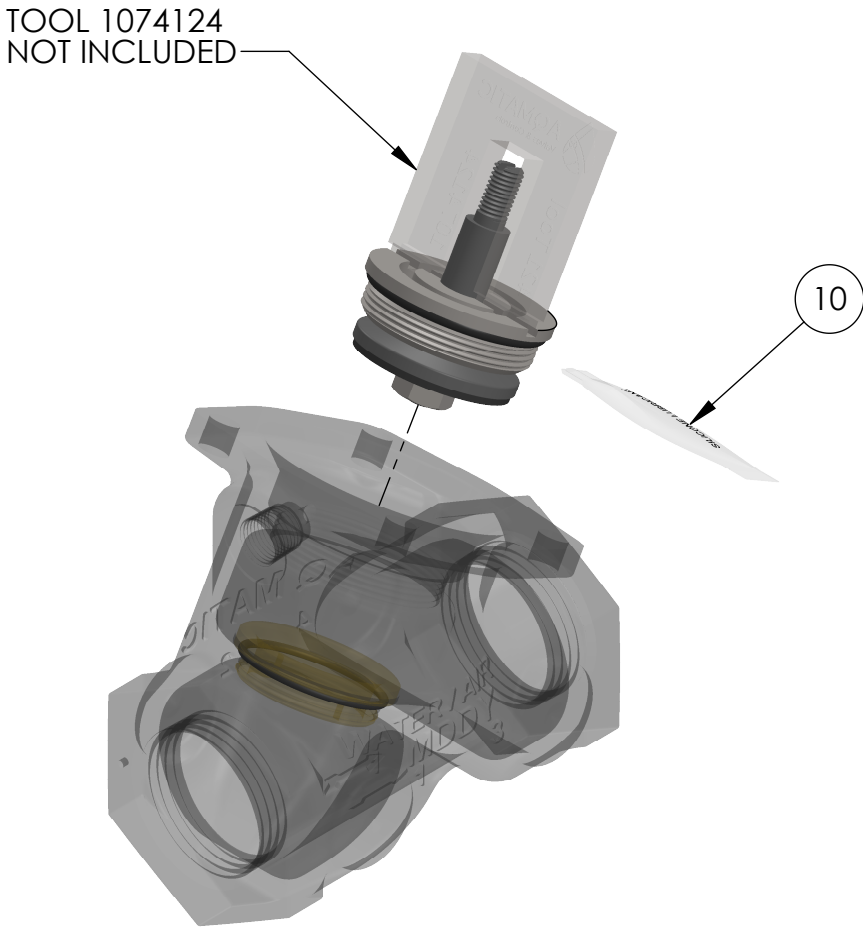
STEP 2



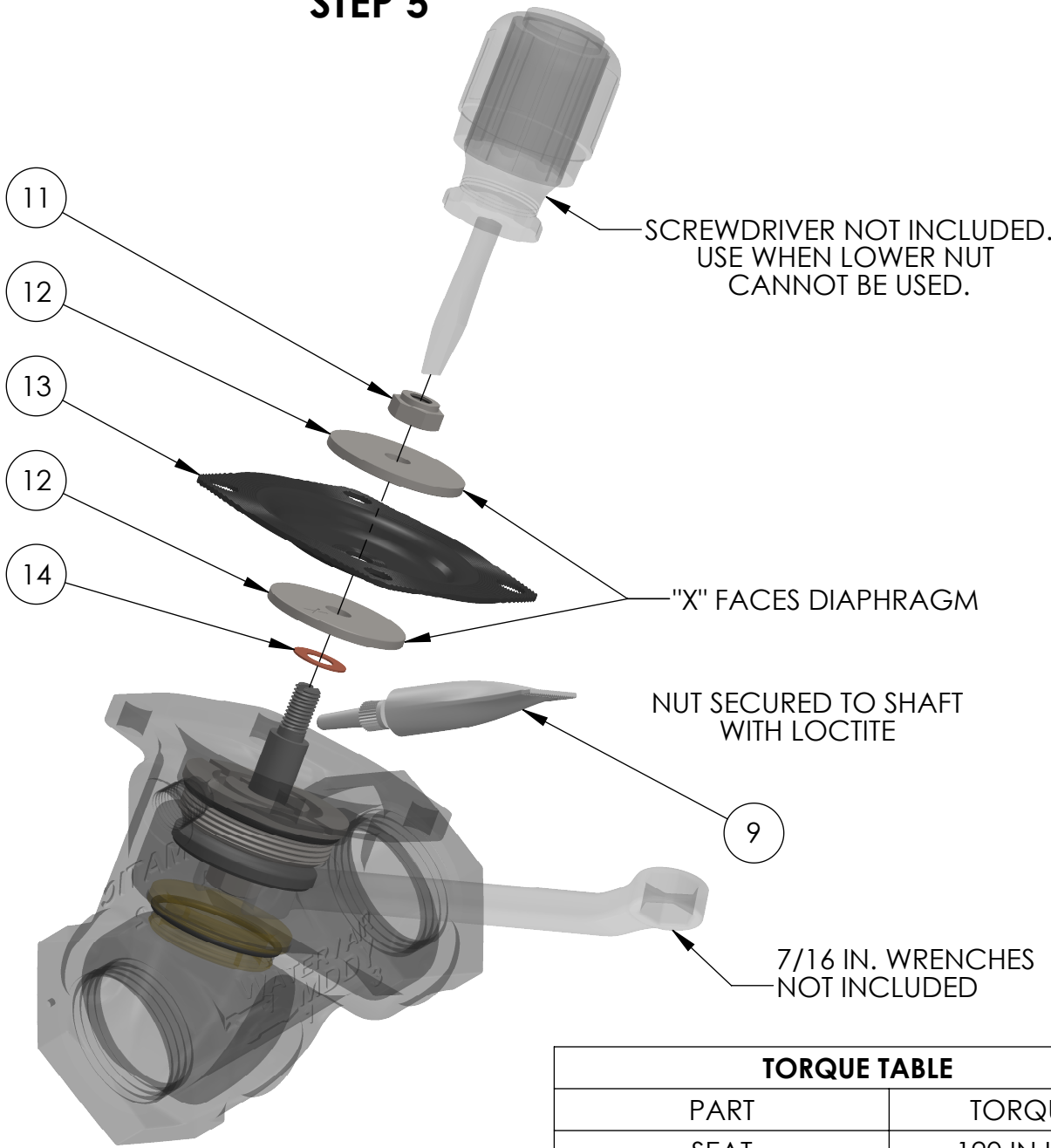
STEP 3
NOT NEEDED FOR MOST REPAIRS



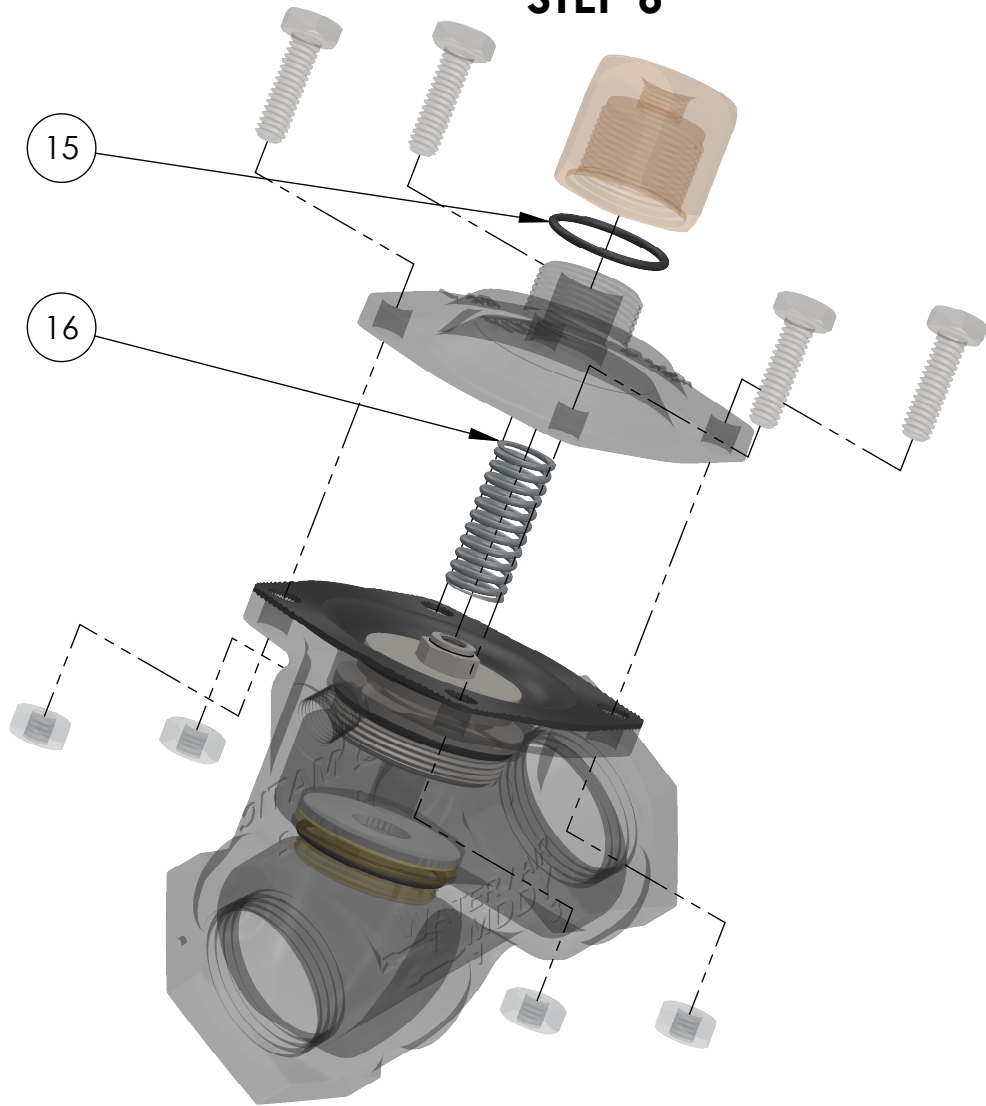
STEP 4



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.
 - PRIOR TO REV. C, KIT 1074167 WAS CONTROLLED BY DRAWING 1082484.

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. 1074167	REV. E
SIZE C	SCALE 2:3
SHEET 1 OF 1	