

4

3

2

1

BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	2
2	1074140	421-J	DISC,421,BUNA	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	2
4	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
5	1071693	ORB-125	O-RING,-125,BUNA	1
6	1071676	ORB-024	O-RING,-024,BUNA	1
7	1074120	421-FV	DIAPHRAGM,421,FLOR	1
8	1262436	-	LOCTITE 565 POLYTUBE	1
9	42561	-	LUBRICANT,SILICONE,PACKET	1

1074170 SEAL AND DIAPHRAGM KIT ASSEMBLY INSTRUCTION
MODEL NO. 421-RA12805

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
	A	NUMBER CONVERSION	4/25/2003	ACE
2392	B	REDRAWN IN AQ-MATIC FORMAT	5/28/2024	PMJ

D

C

B

A

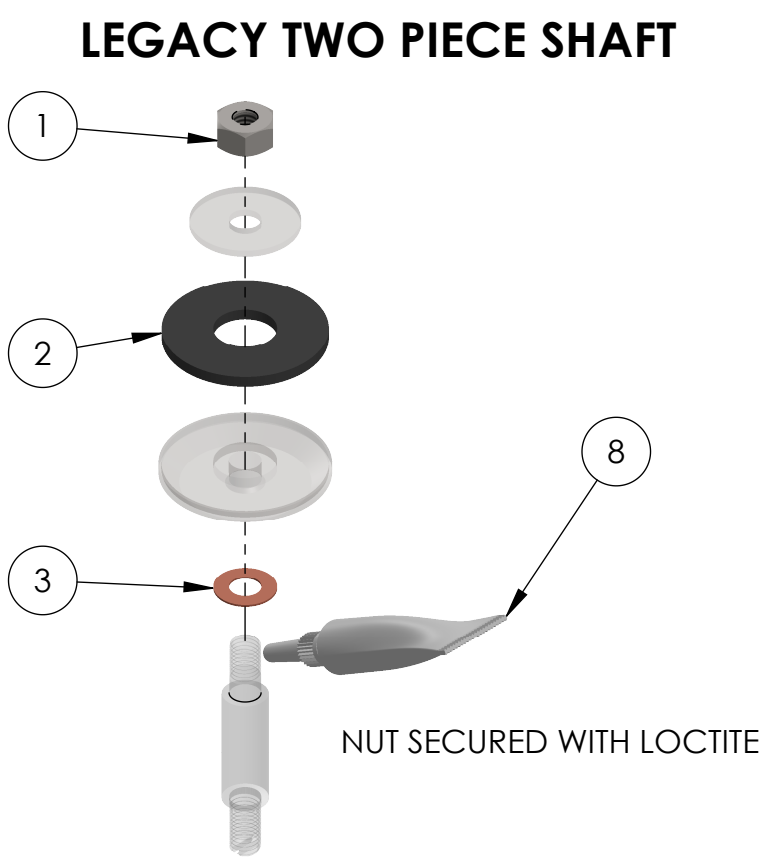
D

C

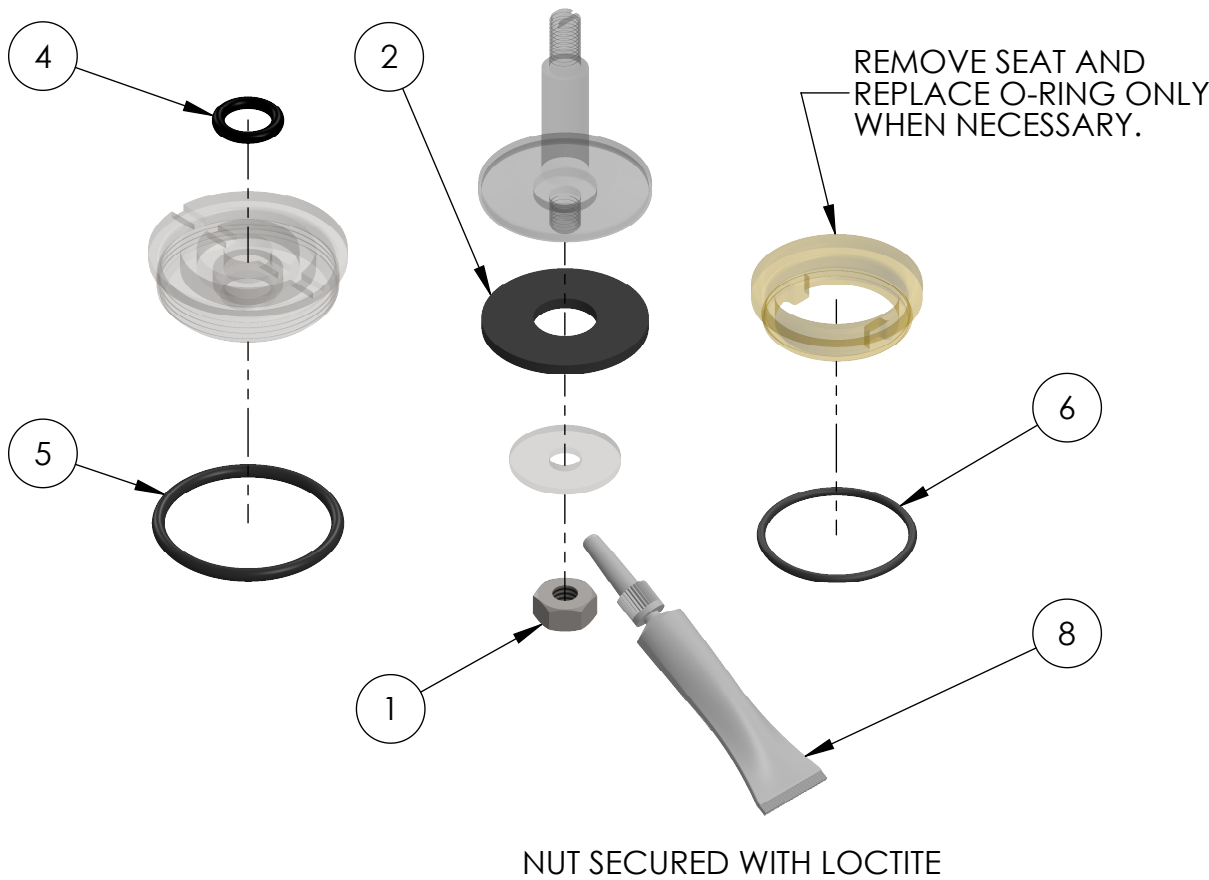
B

A

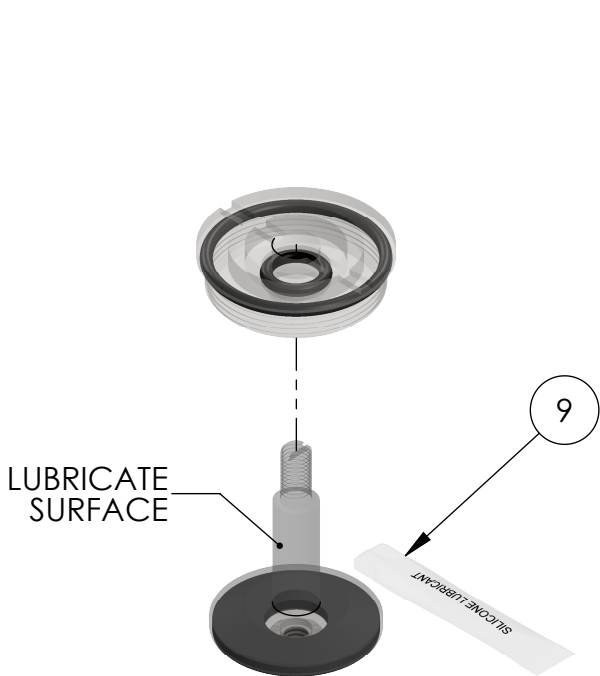
LEGACY TWO PIECE SHAFT



STEP 1
(WITH ONE PIECE SHAFT)

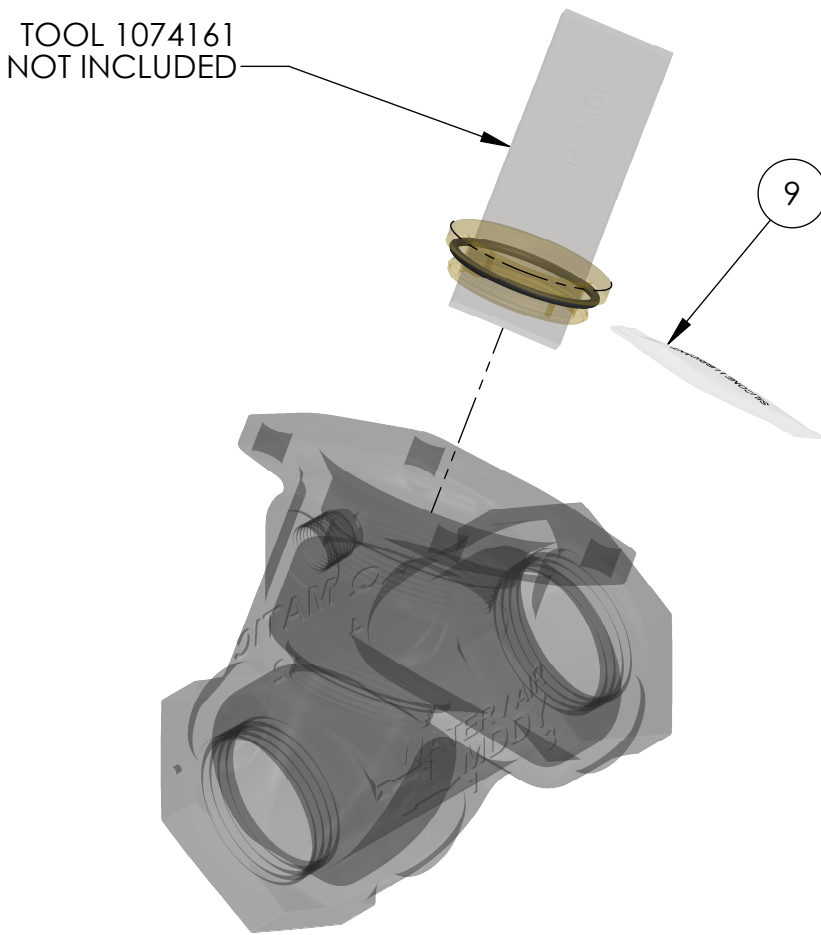


STEP 2

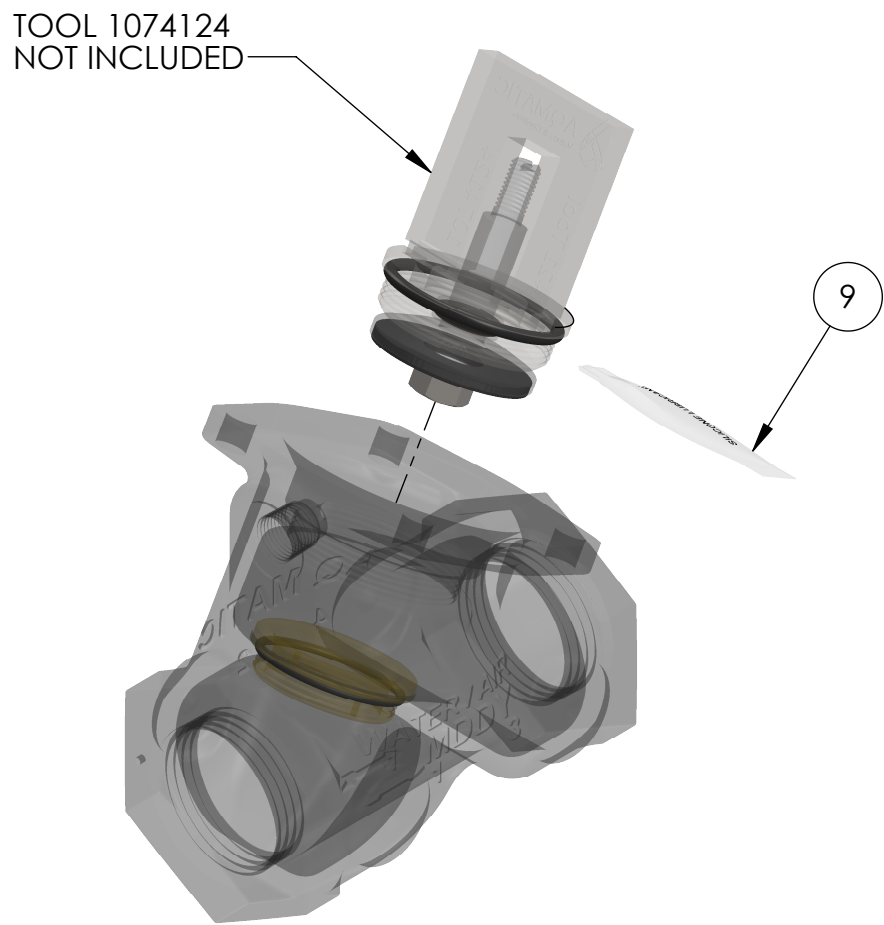


STEP 3

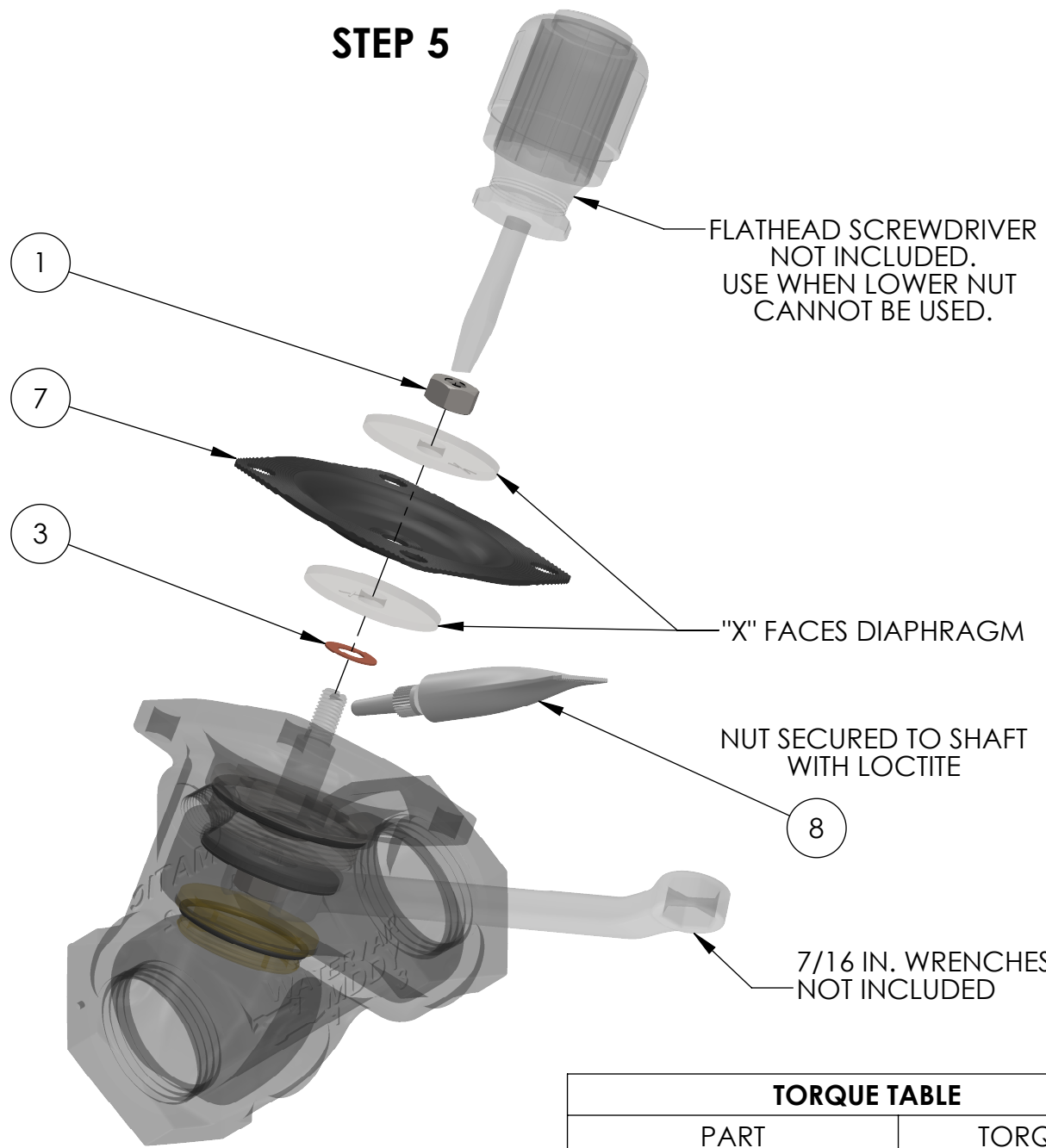
NOT NEEDED FOR MOST REPAIRS



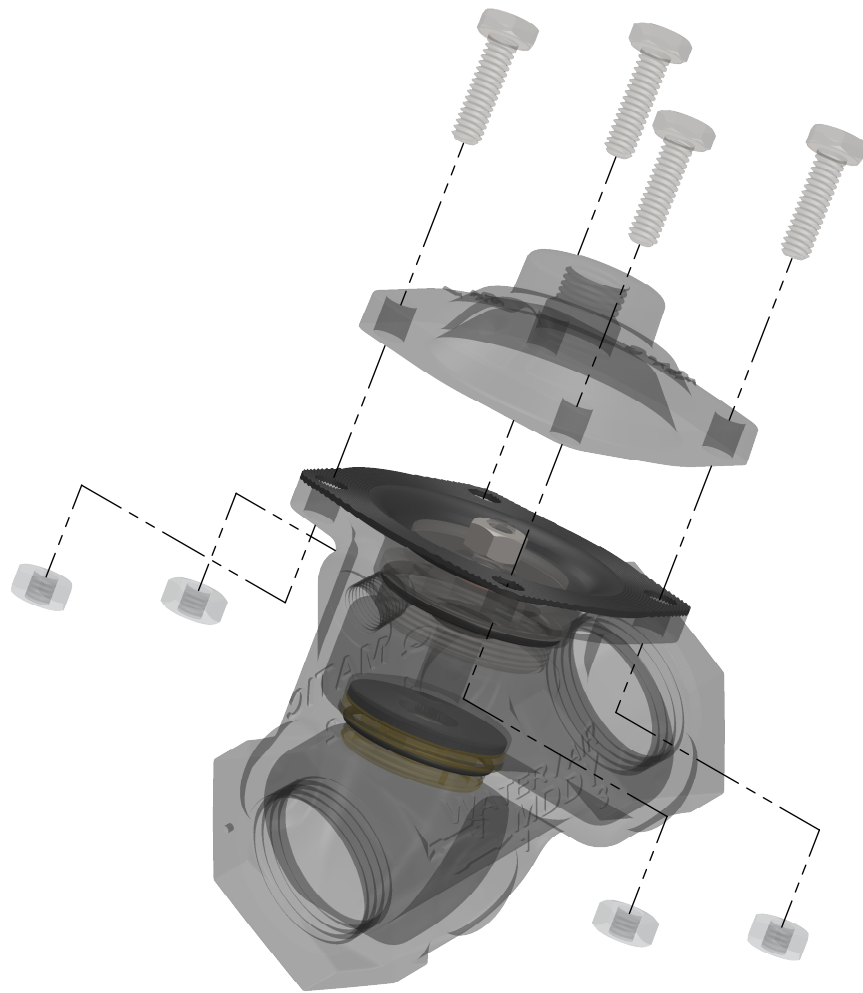
STEP 4



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. B, ASSEMBLY WAS CONTROLLED BY DRAWING NO. 1082490.

TORQUE TABLE

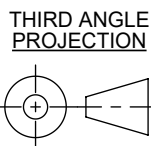
PART	TORQUE
SEAT	120 IN.LBS.
UPPER SHAFT NUT	90 IN.LBS.
LOWER SHAFT NUT	90 IN.LBS.
SHAFT GUIDE	120 IN.LBS.
CAP SCREWS & NUTS	140 IN.LBS.

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

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

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,D&S,CSTM

DWG NO.	1074170	REV.	B
SIZE	C	SCALE	2:3
SHEET 1 OF 1			

4

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