

# 1074178 REPAIR PARTS KIT ASSEMBLY INSTRUCTION MODEL NO. 421-SO

## REVISIONS

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

## NOTES:

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

## 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. |

## BILL OF MATERIALS

| ITEM NO. | PART NO. | MODEL  | DESCRIPTION               | QTY. |
|----------|----------|--------|---------------------------|------|
| 1        | 1073948  | 200-GG | GASKET,COPPER,1/200X1/4ID | 1    |
| 2        | 1078608  | 421-SB | SPRING,316SS,COMPRESSION  | 1    |
| 3        | 1074149  | 421-KS | DISC PLATE                | 1    |

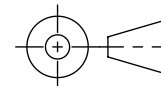
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M -2018.

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



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**AQ-MATIC**  
Valves & Controls

## DESCRIPTION

**KIT,421,INT,SAO**

|         |                |              |            |
|---------|----------------|--------------|------------|
| DWG NO. | <b>1074178</b> | REV.         | <b>A</b>   |
| SIZE    | <b>A</b>       | SCALE        | <b>1:2</b> |
|         |                | SHEET 1 OF 1 |            |