

4				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
2	1074234	424-JH	DISC,424,HYCAR	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	1
4	1262436	-	LOCTITE 565 POLYTUBE	1
5	1071678	ORB-028	O-RING,-028,BUNA	1
6	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
7	1071695	ORB-132	O-RING,-132,BUNA	1
8	42561	-	LUBRICANT,SILICONE,PACKET	1
9	1263853	RMET	HEX NUT 5/16" - 24	1
10	1074252	424-R	COPPER GASKET	1
11	1074222	424-FB	DIAPHRAGM,424,BUNA	1

3

2

1

1074258 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 424-RA12888

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	3/11/1998	MM
	B	NUMBER CONVERSION	4/28/2003	GES
2436	C	REDRAWN IN AQ-MATIC FORMAT, DRAWING NO. CHANGE	9/4/2024	PMJ

STEP 1
(WITH ONE PIECE SHAFT)

STEP 2

STEP 3
(NOT NEEDED FOR MOST REPAIRS)

LEGACY TWO PIECE SHAFT

"X" FACES DISC

LUBRICATE
SURFACE

REMOVE SEAT AND
REPLACE O-RING ONLY
WHEN NECESSARY.

NUT SECURED
WITH LOCTITE

STEP 4

STEP 5

STEP 6

1074227 TOOL FOR
LEGACY SHAFT GUIDE
NOT INCLUDED

3/4" SOCKET FOR
CURRENT SHAFT GUIDE
NOT INCLUDED

"X" FACES
DIAPHRAGM

FLATHEAD SCREWDRIVER
NOT INCLUDED.
USE WHEN LOWER NUT
CANNOT BE REACHED.

NUT SECURED
WITH LOCTITE

7/16 IN. WRENCHES
NOT INCLUDED.

- 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 REVISION C, KIT WAS CONTROLLED BY DRAWING NO. 1082521.

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]

THIRD ANGLE
PROJECTION

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DESCRIPTION			
KIT,424,D&S,CUST			
DWG NO.	1074258	REV.	C
SIZE	C	SCALE	1:2
		SHEET 1 OF 1	