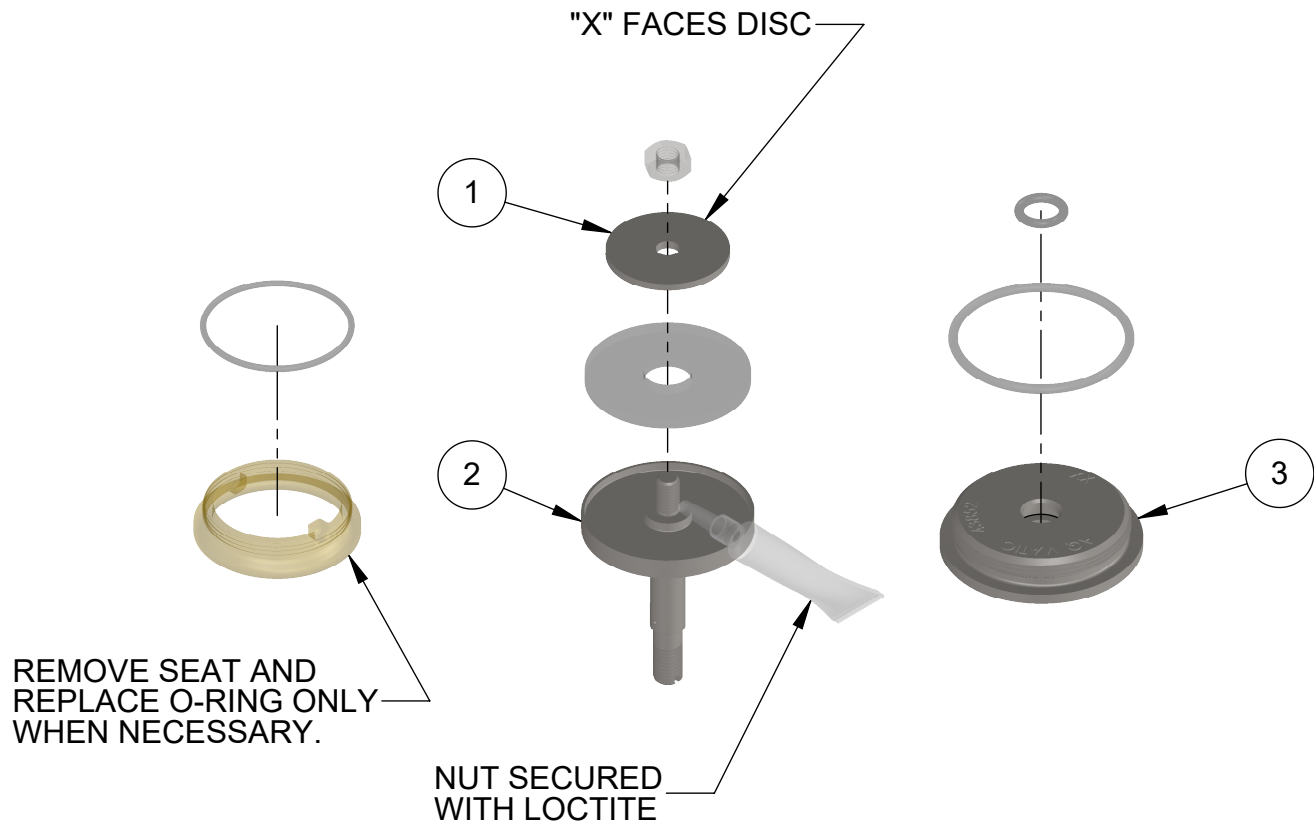


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	43942	424-H	DIAPHRAGM PLATE	1
2	44013-03	424-LE2	SHAFT ASMBLY,424,CUSTOM,LE	1
3	43852	424-GGS	SHAFT GUIDE, 424, HEX	1
4	43943	424-DS	DIAPHRAGM PLATE	2

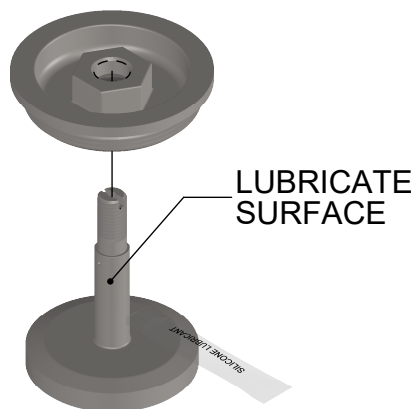
1074260 CUSTOM INTERNAL PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 424-RF12792

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2436	A	INITIAL RELEASE	9/5/2024	PMJ

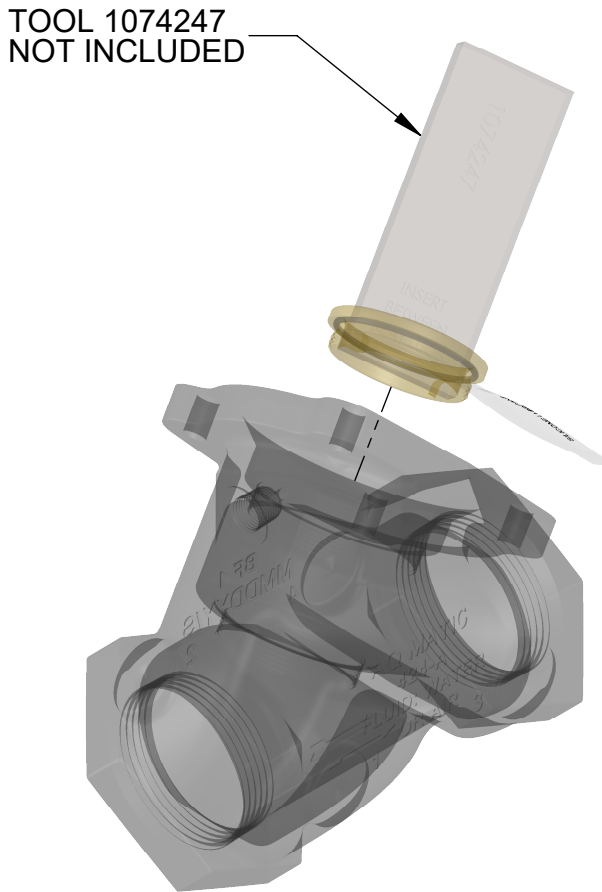
STEP 1
(WITH ONE PIECE SHAFT)



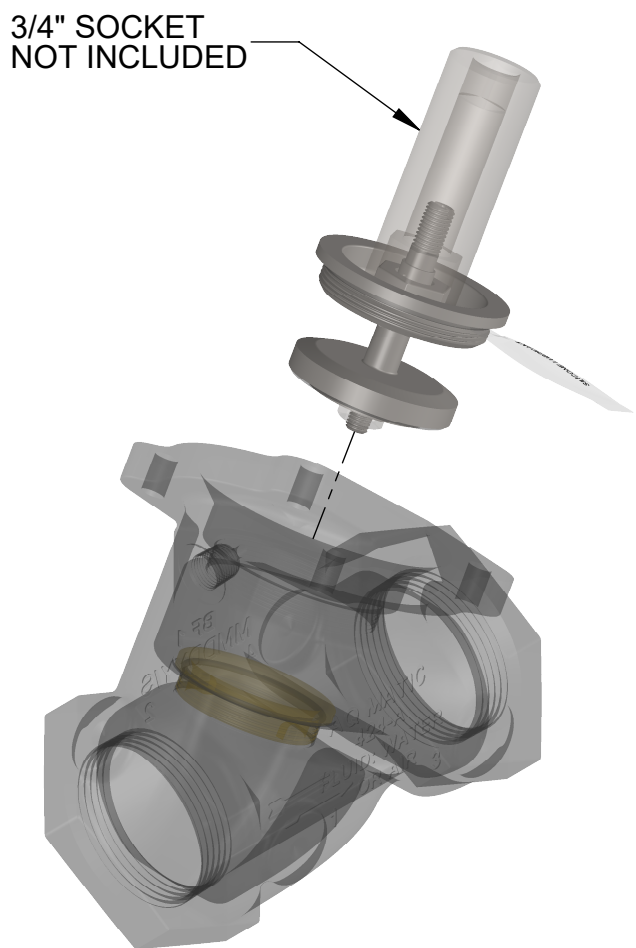
STEP 2



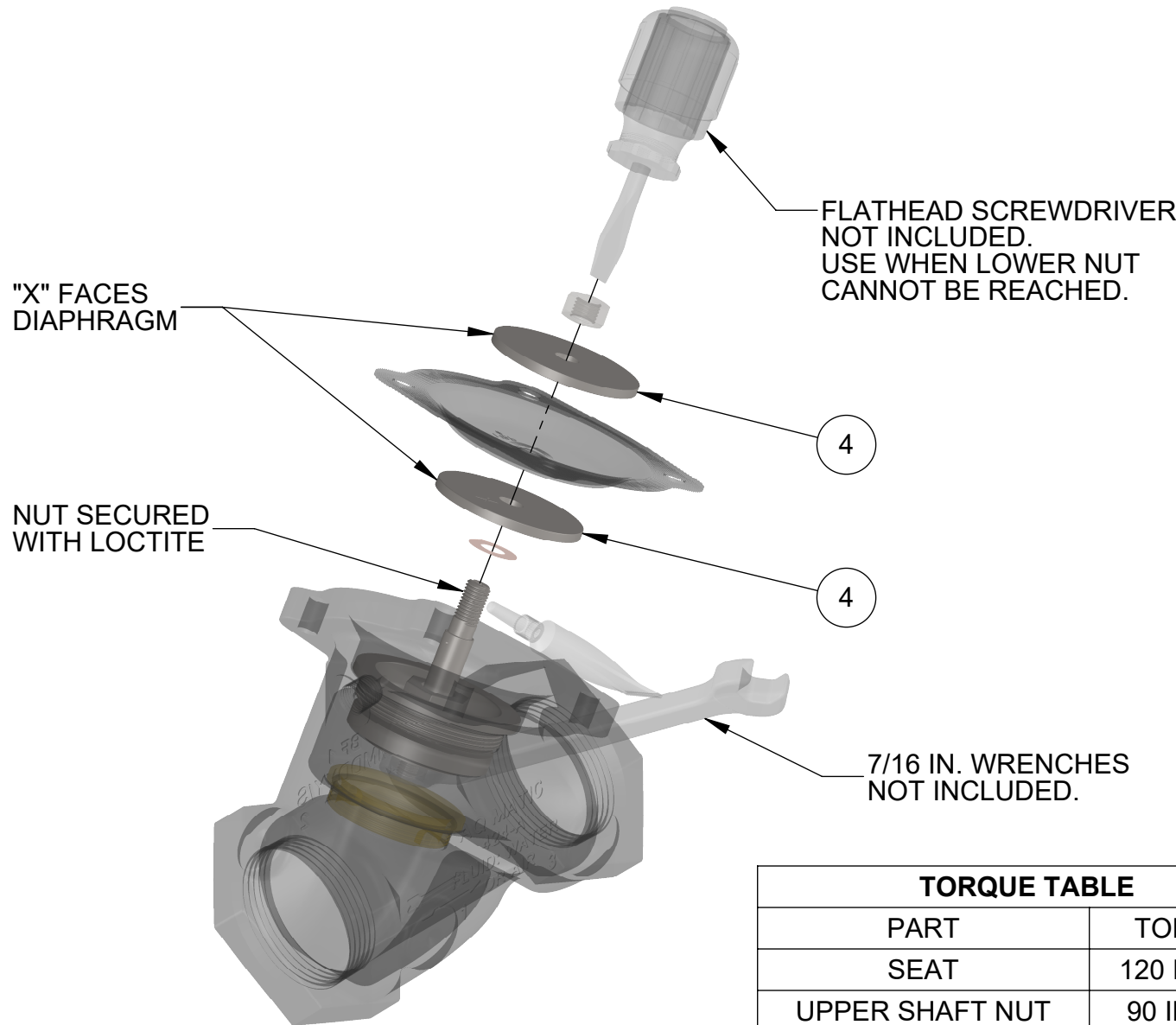
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



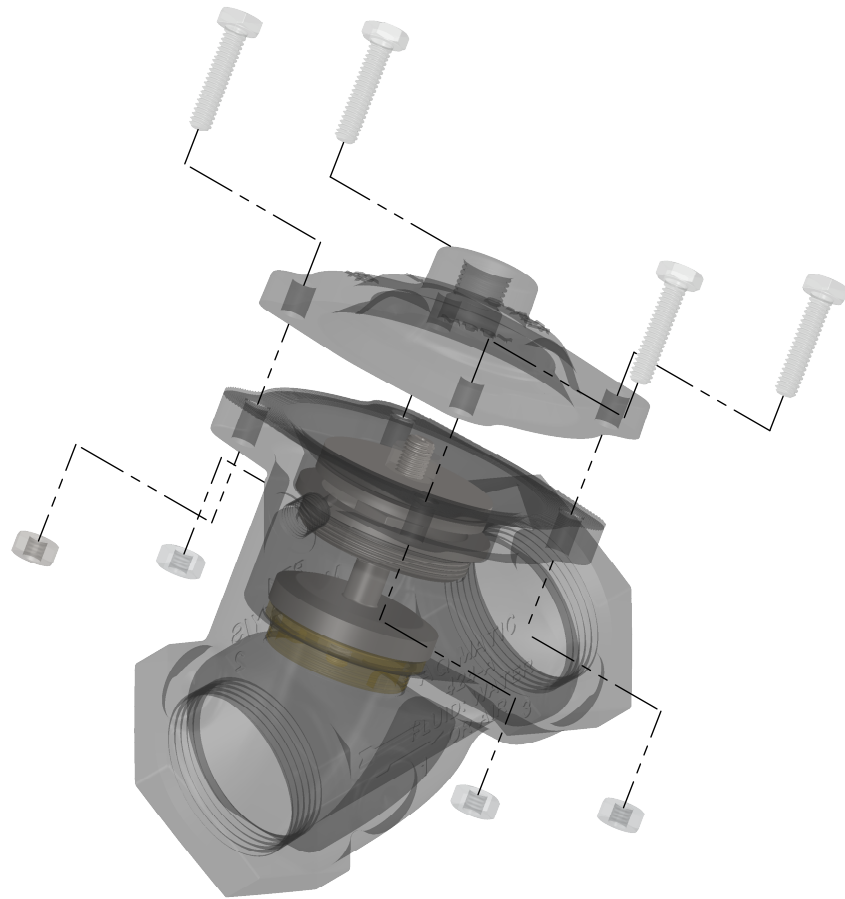
STEP 4



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.

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,424,INT,CUST	
DWG NO.	1074260
REV.	A
SIZE	C
SCALE	1:2
SHEET	1 OF 1