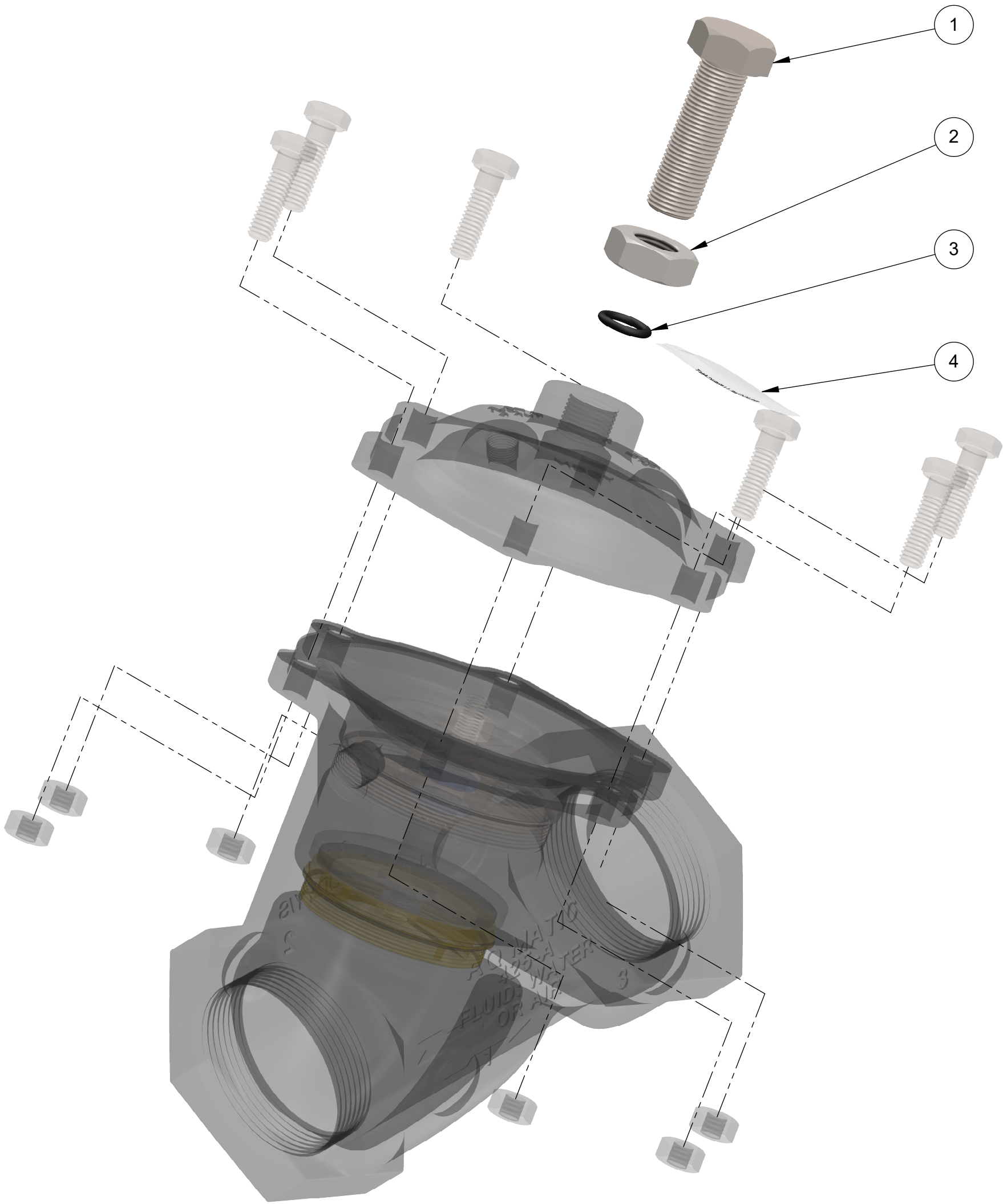


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1078676	SCS-0042	BOLT,HEX HD,FLL THRD,5/8-18X2	1
2	1074434	426-U	NUT,LIMIT STOP,W/O-RING GROOV	1
3	1071690	ORB-112	O-RING, 2-112	1
4	42561	-	LUBRICANT,SILICONE,PACKET	1

1074319 LIMIT STOP REPAIR KIT
ASSEMBLY INSTRUCTION
MODEL NO. 425-LS

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2464	A	INITIAL RELEASE	10/17/2024	PMJ



- NOTES:
- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
 - ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.

TORQUE TABLE	
PART	TORQUE
SEAT	120 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	140 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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THIRD ANGLE PROJECTION

AQMATIC
Valves & Controls

DESCRIPTION		
KIT,425,INT,LS		
DWG NO.	1074319	REV. A
SIZE	C	SCALE 3:4
SHEET 1 OF 1		