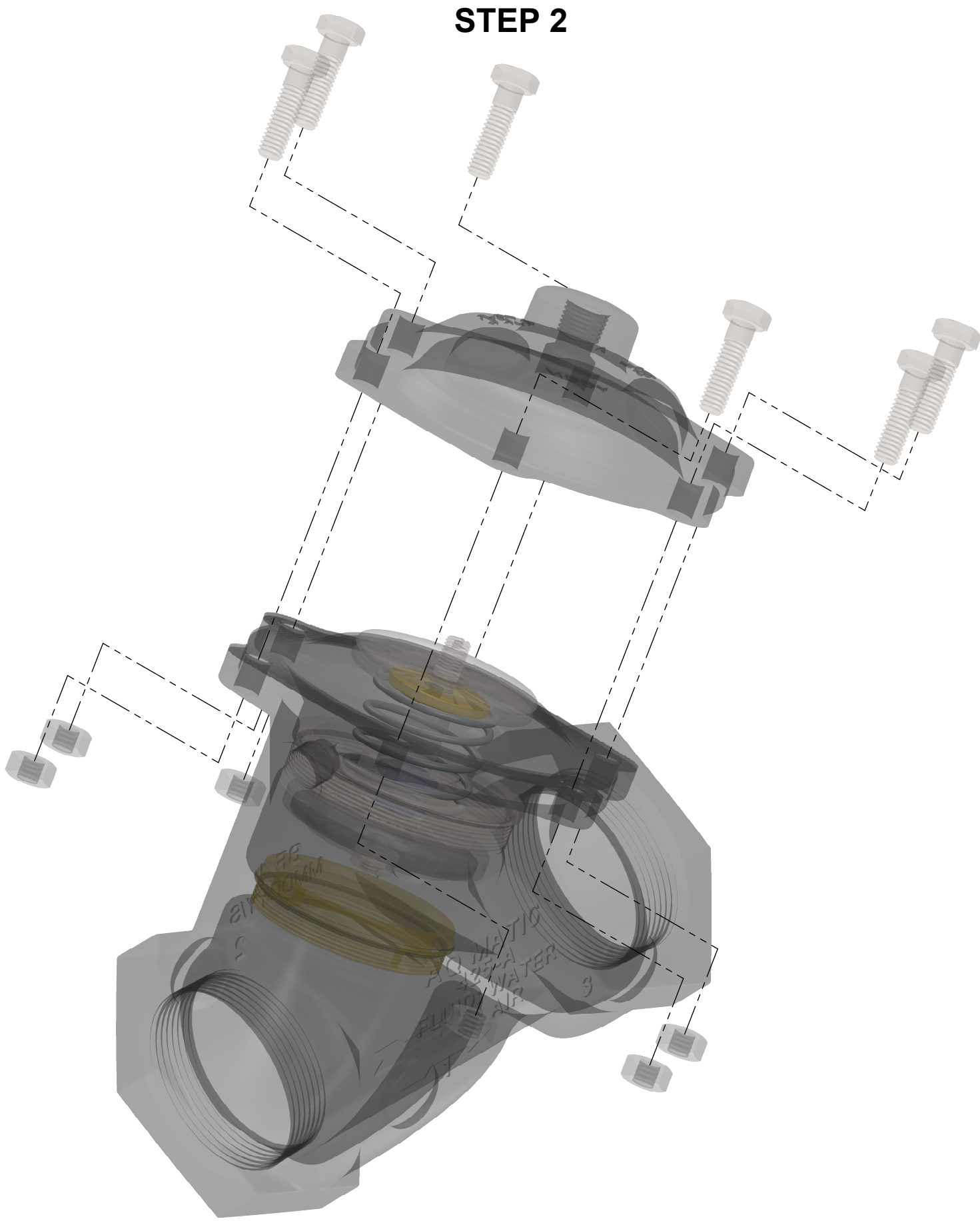
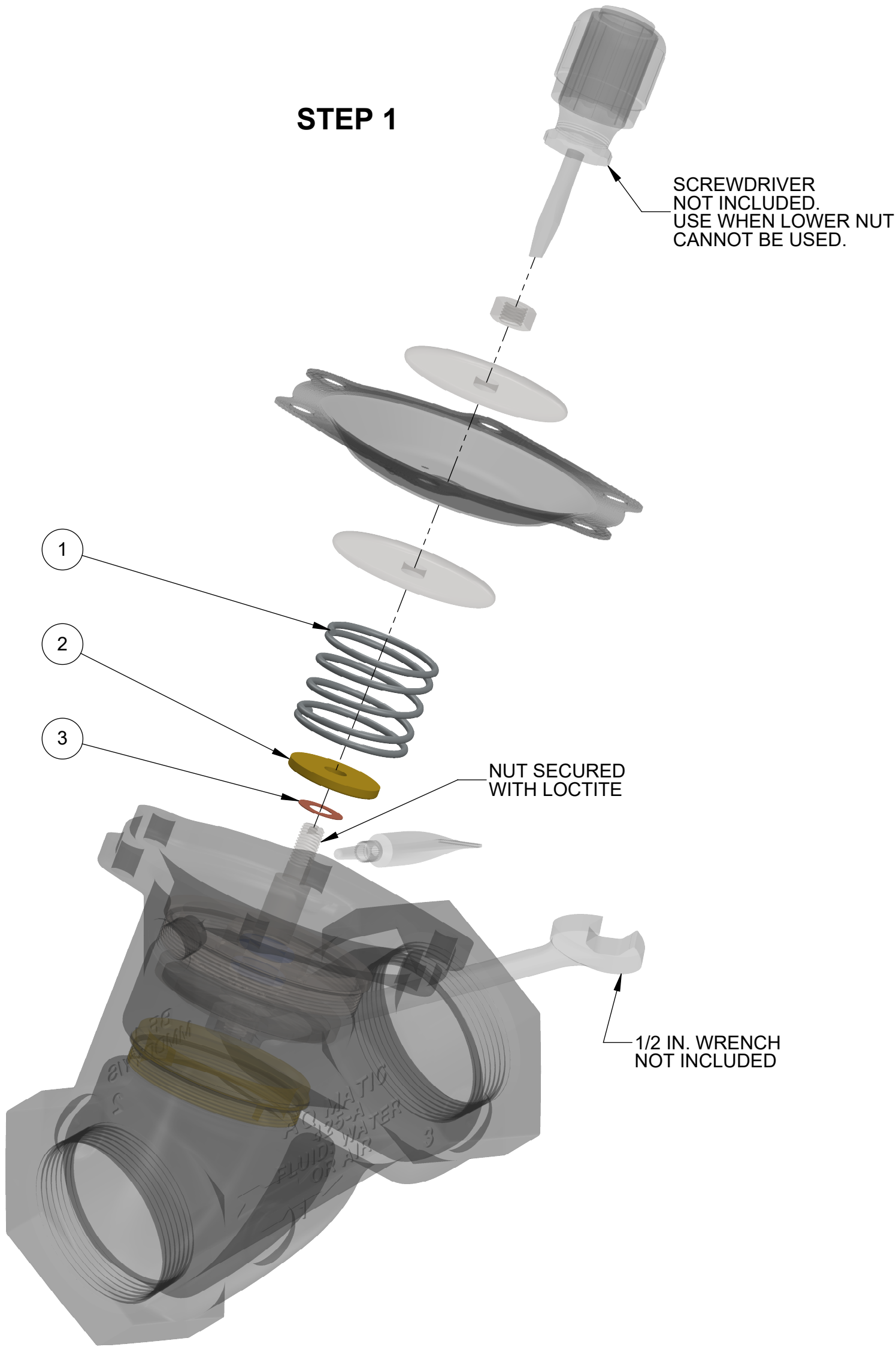


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1078692	424-SS	SPRING,COMPRESSION,302 SS	1
2	1074436	426-V	CENTERING WASHER	1
3	1074252	424-R	COPPER GASKET	1

1074331 SPRING ASSIST OPEN REPAIR KIT
ASSEMBLY INSTRUCTION
MODEL NO. 425-SO

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2464	A	INITIAL RELEASE	10/18/2024	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 : $\pm 1^\circ$
1 PLACE .X: $\pm .100$ [2.54]
2 PLACE .XX: $\pm .010$ [0.3]
3 PLACE .XXX: $\pm .005$ [0.13]

THIRD ANGLE
PROJECTION

THE COMPONENT OR PRODUCT DESCRIBED IN THIS DOCUMENT
MUST COMPLY WITH RoHS 3 EU (EUROPEAN UNION) DIRECTIVE
2015/863 AND EU REACH REGULATION (EC) 1907/2006.

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 **AQMATIC**
Valves & Controls

DESCRIPTION

KIT,425,INT,SAO

DWG NO.	1074331	REV.	A
SIZE	C	SCALE	2:3
		SHEET 1 OF 1	