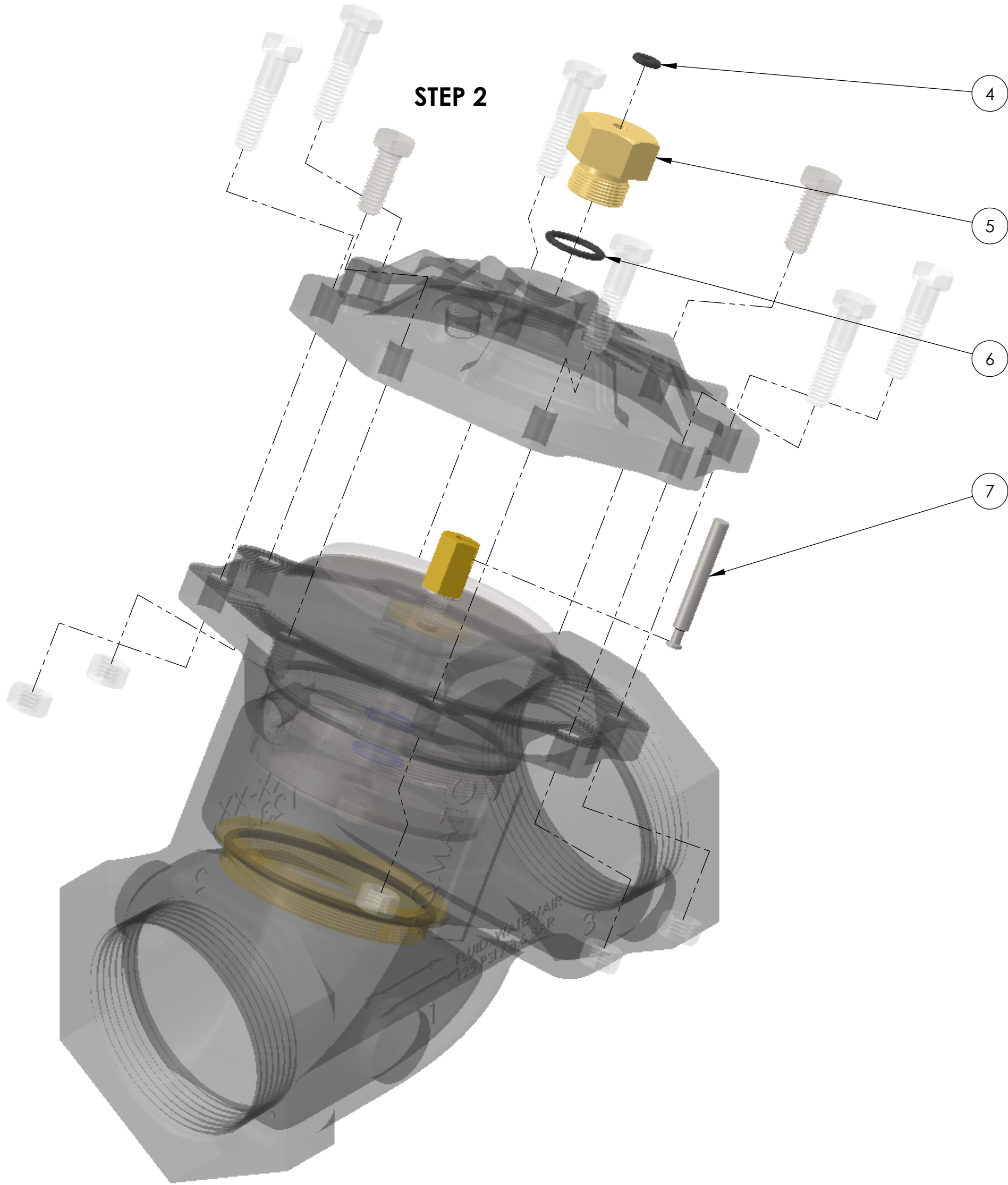
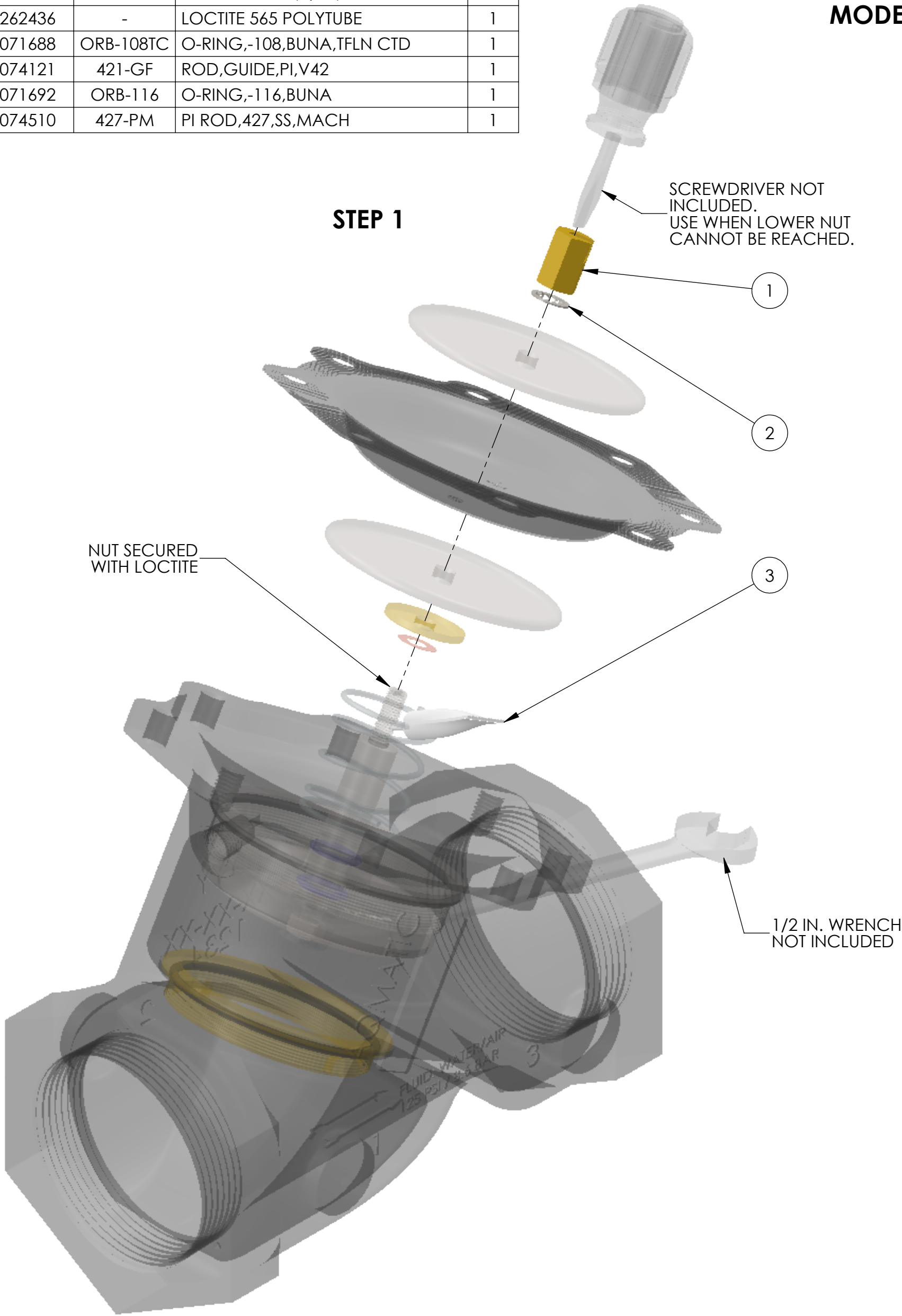


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1074332	425-TB	NUT,TOP,425,PI	1
2	1073590	WAS-0007	LOCKWASHER,5/16,INTRNL TOOTH	1
3	1262436	-	LOCTITE 565 POLYTUBE	1
4	1071688	ORB-108TC	O-RING,-108,BUNA,TFLN CTD	1
5	1074121	421-GF	ROD,GUIDE,PI,V42	1
6	1071692	ORB-116	O-RING,-116,BUNA	1
7	1074510	427-PM	PI ROD,427,SS,MACH	1

1074508 POSITION INDICATOR PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 427-PI

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2562	A	INITIAL RELEASE	7/10/2025	PMJ



- NOTES:
- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
 - ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.
 - THIS KIT AND ASSEMBLY INSTRUCTIONS WORK FOR ALL THREADED, FLANGED, AND GROOVE ADAPTER BODIES.

TORQUE TABLE	
PART	TORQUE
SEAT	500 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	140 IN-LBS.
SHAFT GUIDE	500 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,427,INT,PI

DWG NO.	1074508	REV.	A	
SIZE	C	SCALE	2:3	SHEET 1 OF 1