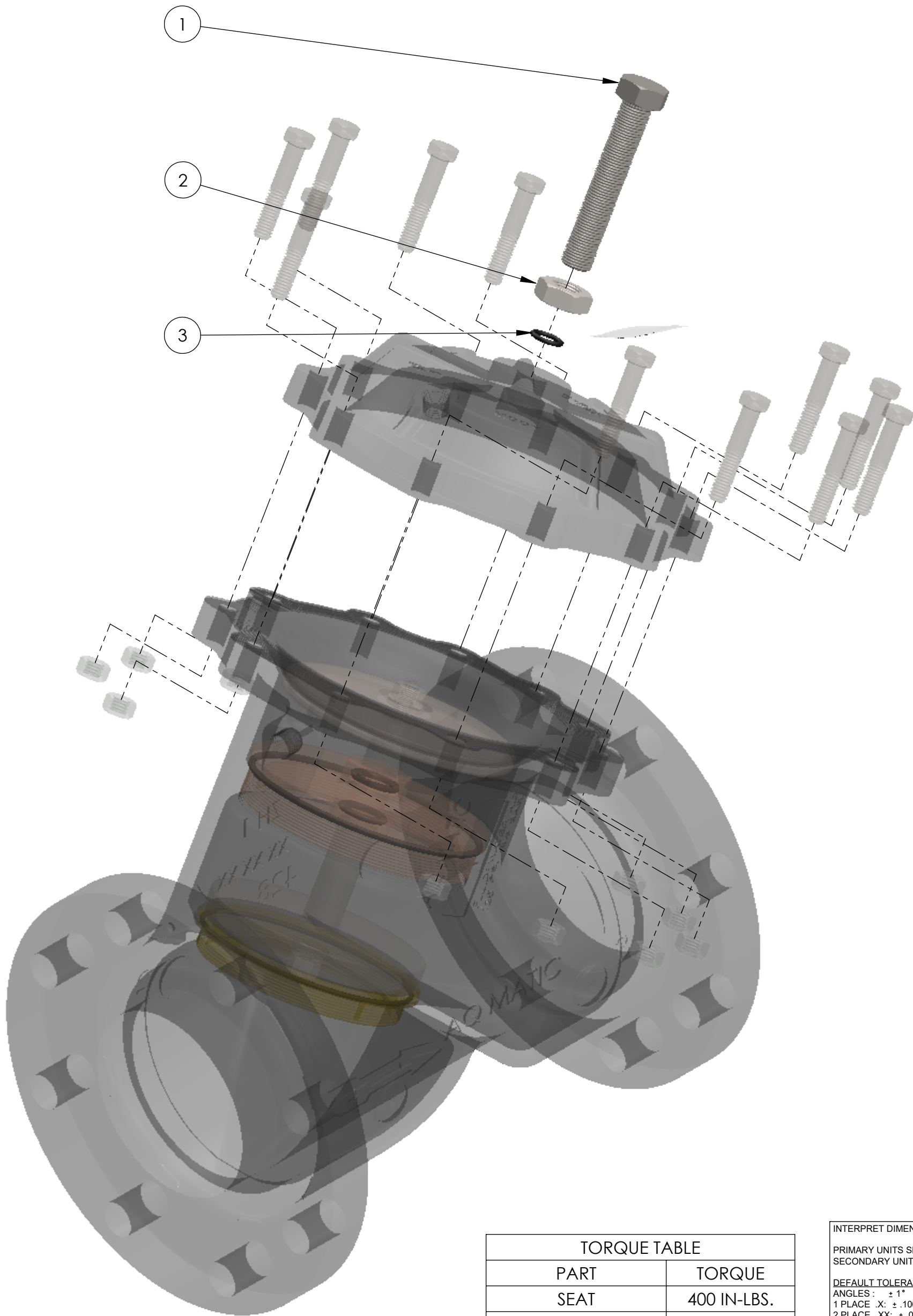


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1072365	SCS-0043	SCREW,5/8-18 X 3.50 HEX HD	1
2	1074434	426-U	NUT,LIMIT STOP,W/O-RING GROOV	1
3	1071690	ORB-112	O-RING,-112,BUNA	1

1074583 SPRING LIMIT STOP PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 428-LS

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2588	A	INITIAL RELEASE	8/25/2025	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	400 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	215 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 : $\pm 1^\circ$
1 PLACE .X: $\pm .100$ [2.54]
2 PLACE .XX: $\pm .010$ [0.3]
3 PLACE .XXX: $\pm .005$ [0.13]

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DESCRIPTION

KIT,428,INT,LS

DWG NO. 1074583

REV. A

SIZE C

SCALE 1:2

SHEET 1 OF 1