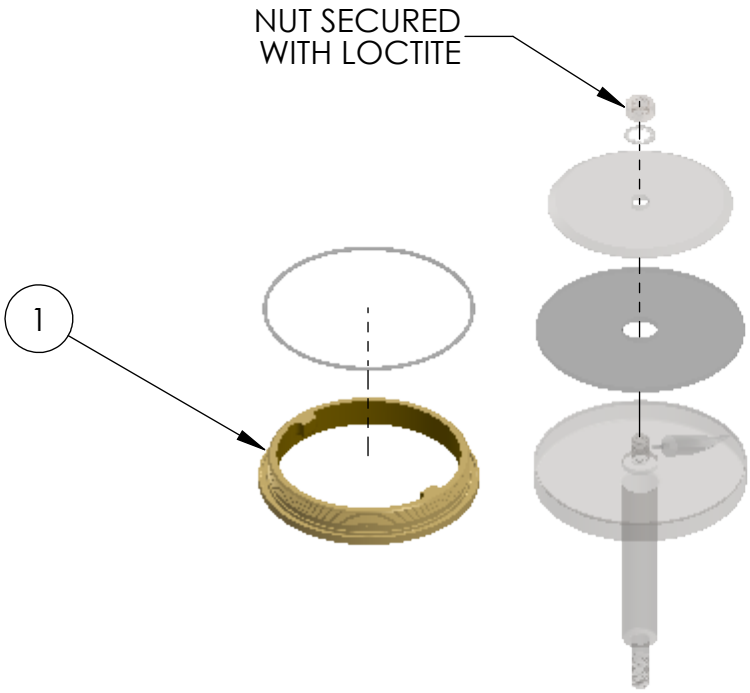


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1074585	428-MAO	SEAT,428,BRASS,MCHD	1

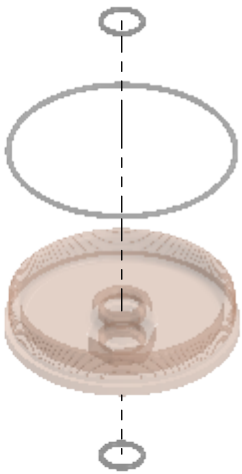
1074585 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 428-MAO

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2588	A	INITIAL RELEASE	8/25/2025	PMJ

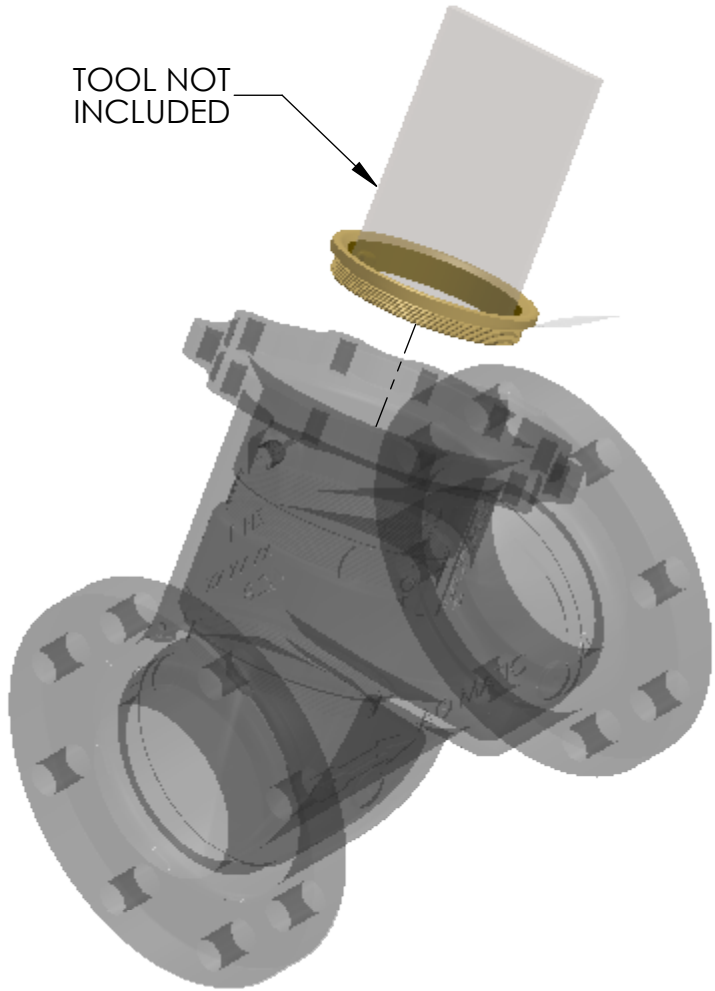
STEP 1
(WITH ONE PIECE SHAFT)



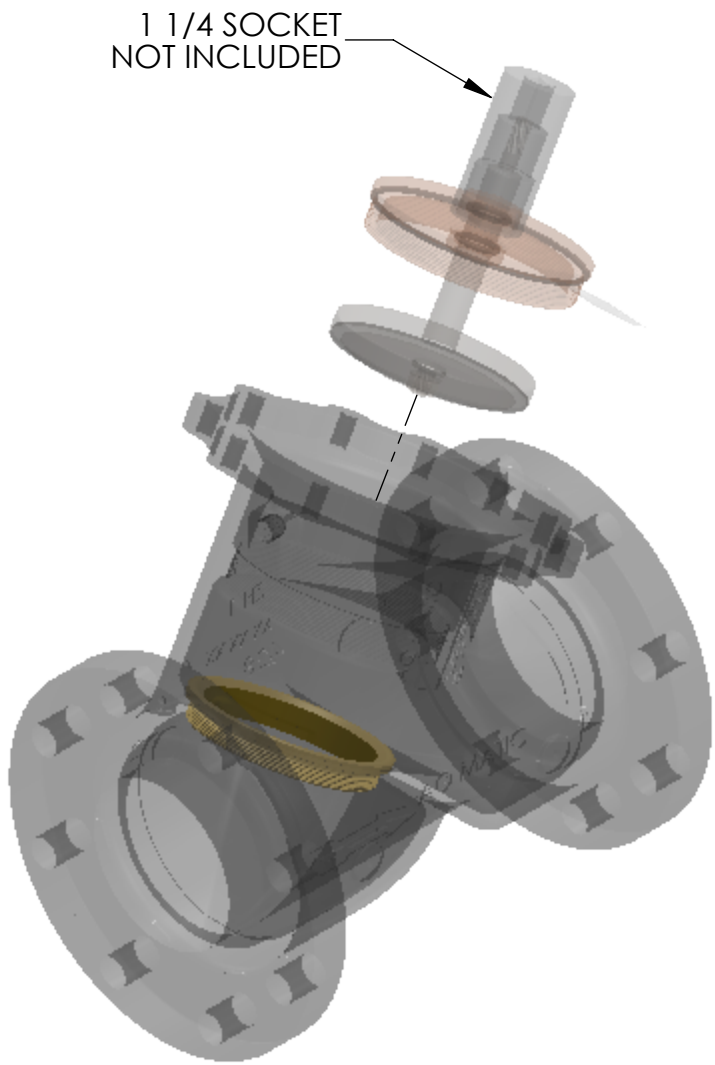
STEP 2



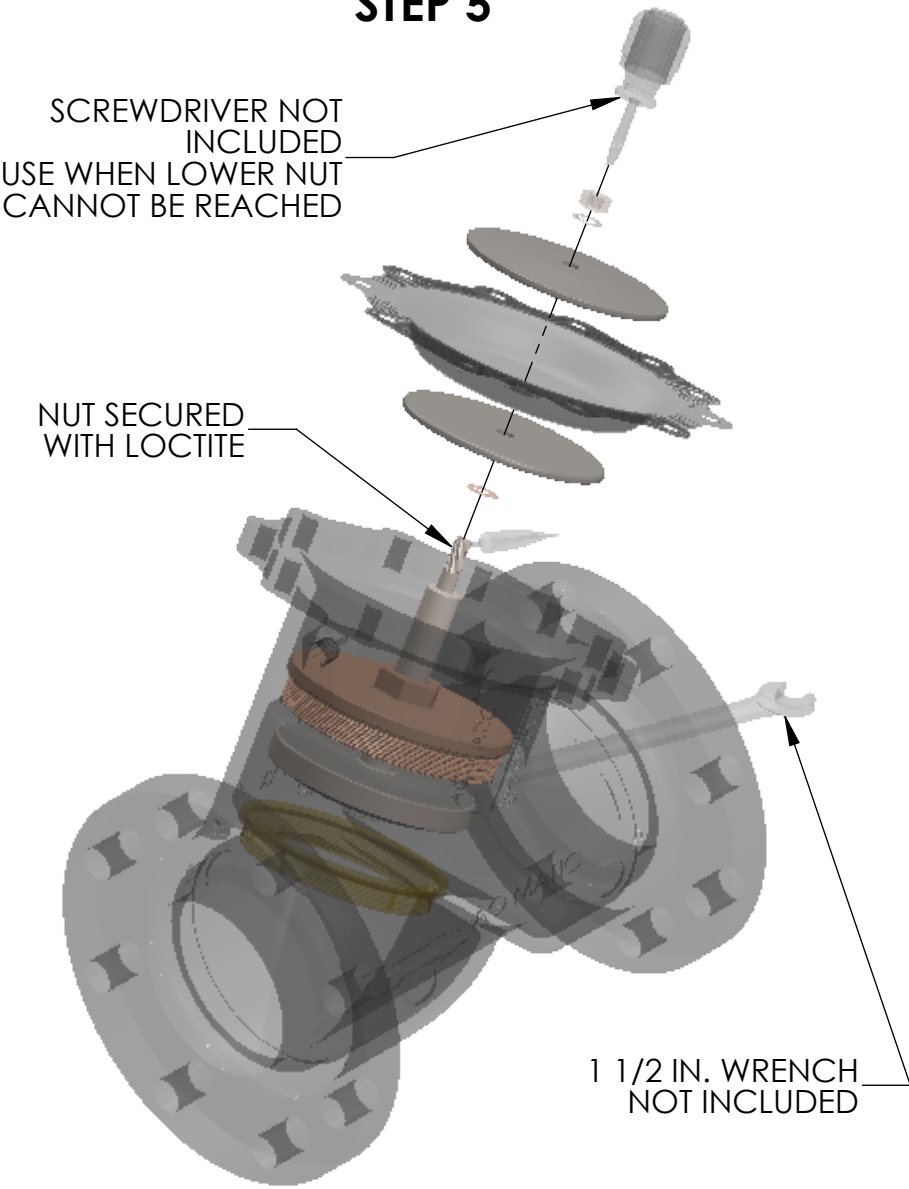
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



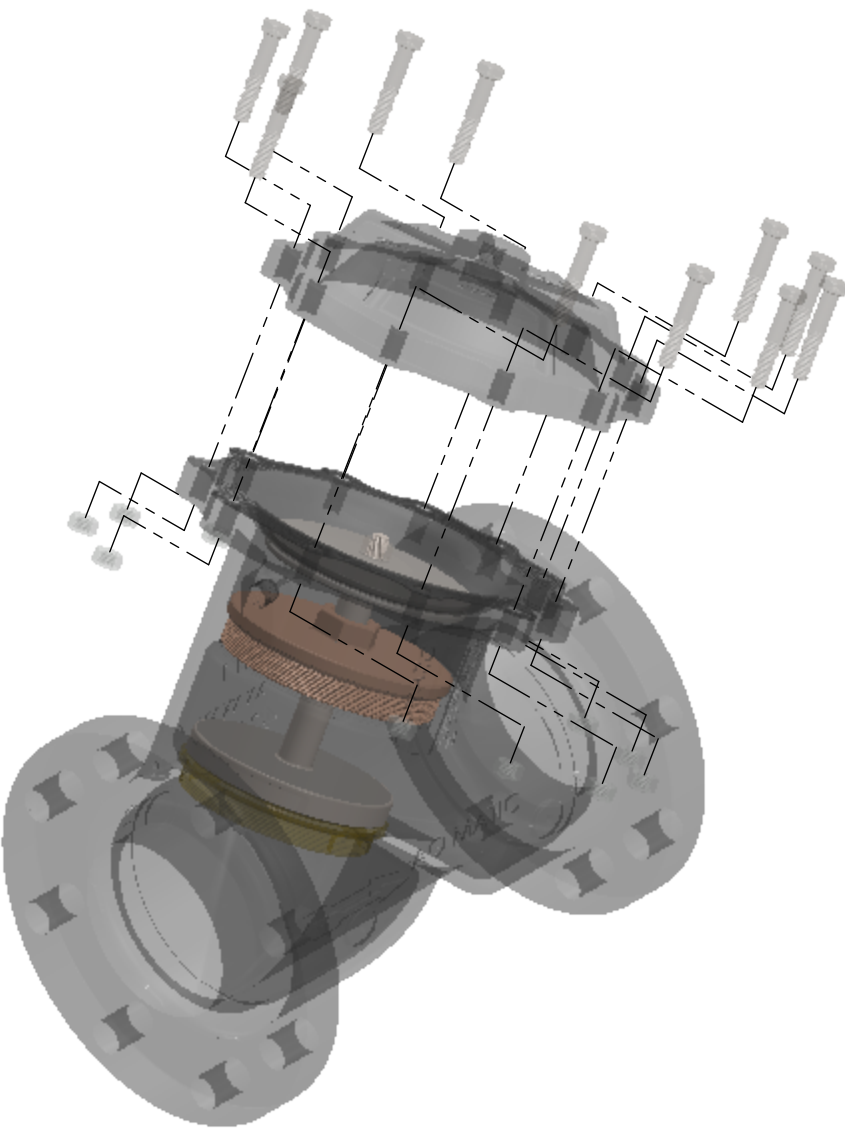
STEP 4



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.

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 : ± 1°
1 PLACE .X: ± .100 [2.54]
2 PLACE .XX: ± .010 [0.3]
3 PLACE .XXX: ± .005 [0.13]
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DESCRIPTION			
SEAT,428,BRASS,MCHD			
DWG NO.	1074585WI	REV.	A
SIZE	C	SCALE	1:4
SHEET 1 OF 1			