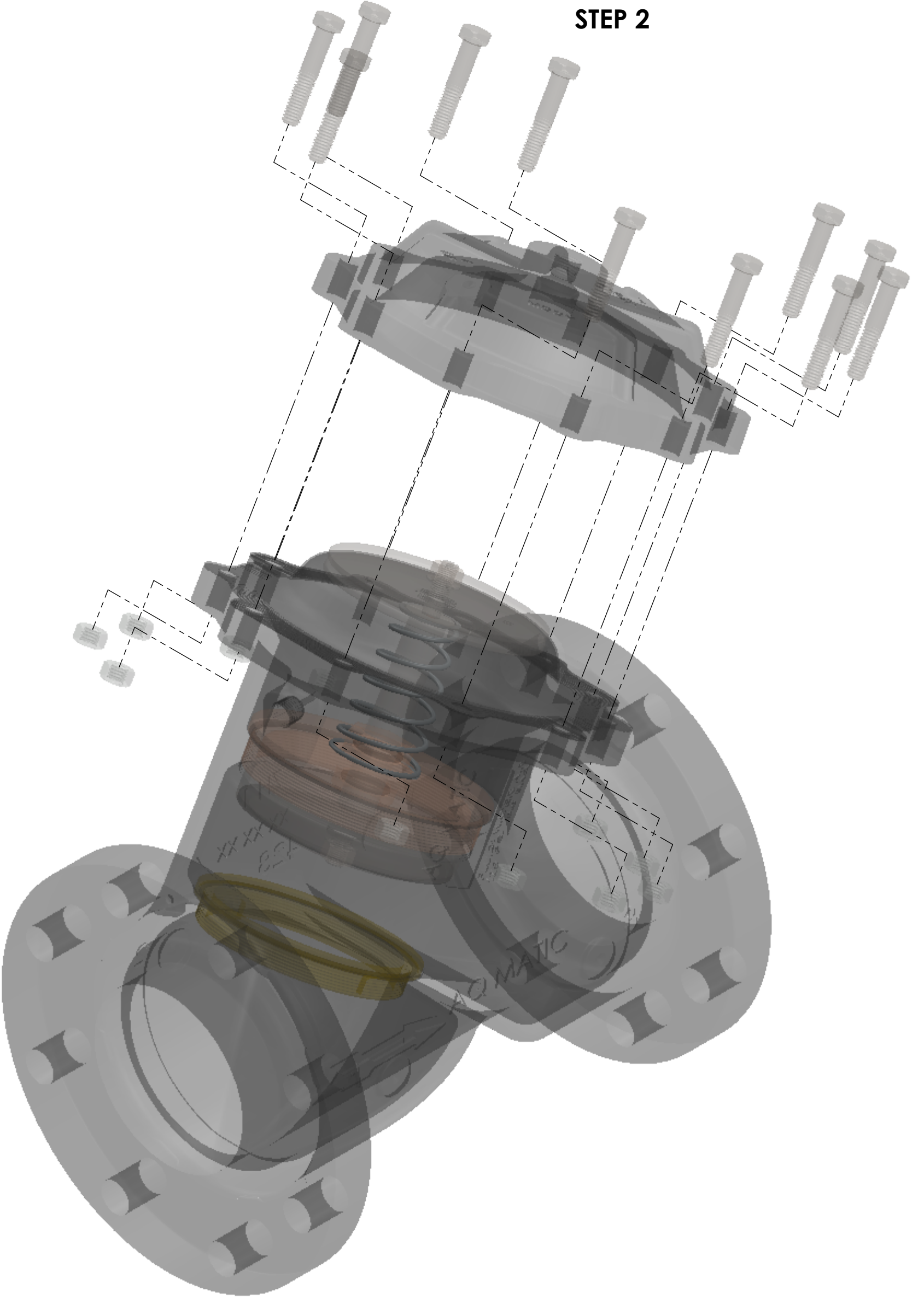
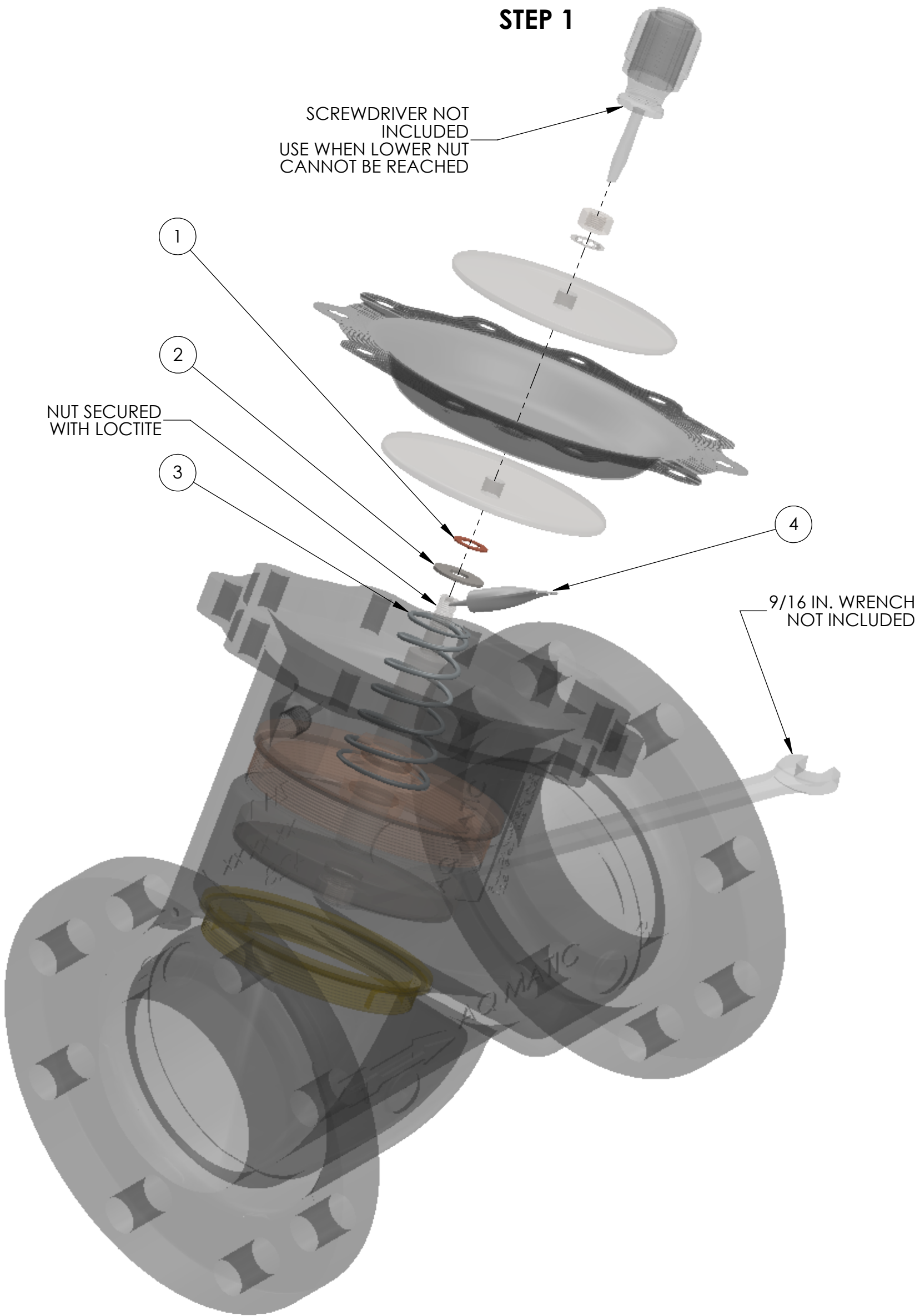


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1073950	200-LL	GASKET, COPPER	1
2	1074610	428-V	WASHER,428,316SS	1
3	1074600	428-S	SPRING,COMPRESSION,428,SAO	1
4	1262436	-	LOCTITE 565 POLYTUBE	1

1074606 SPRING ASSIST OPEN CONVERSION KIT
ASSEMBLY INSTRUCTION
MODEL NO. 428-SOC

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 : ± 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,428,CONV,SAO

DWG NO.	1074606	REV.	A	
SIZE	C	SCALE	1:2	SHEET 1 OF 1