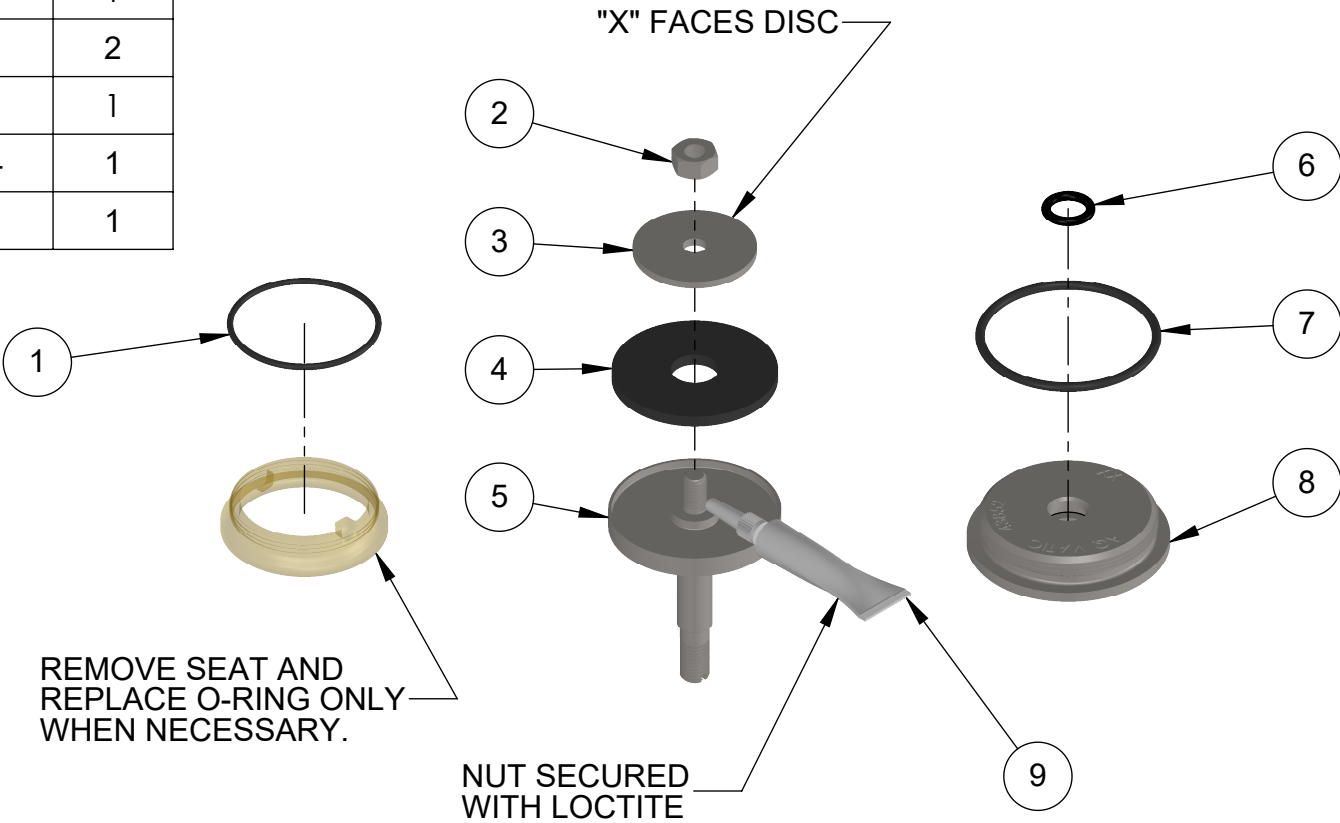


4				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1071678	ORB-028	O-RING,-028,BUNA	1
2	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
3	43942	424-H	DIAPHRAGM PLATE	1
4	1074232	424-J	DISC,424,BUNA	1
5	44013	424-L2	NORMALLY OPEN COMBO SHAFT	1
6	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
7	1071695	ORB-132	O-RING,-132,BUNA	1
8	43852	424-GGS	SHAFT GUIDE, 424, HEX	1
9	1262436	-	LOCTITE 565 POLYTUBE	1
10	42561	-	LUBRICANT,SILICONE,PACKET	1
11	1263853	RMET	HEX NUT 5/16" - 24	1
12	1074252	424-R	COPPER GASKET	1
13	43943	424-DS	DIAPHRAGM PLATE	2
14	1074222	424-FB	DIAPHRAGM,424,BUNA	1
15	1267398	524-S	SPRING, COMPRESSION,524/5524	1
16	1071677	ORB-025	O-RING,-025,BUNA	1

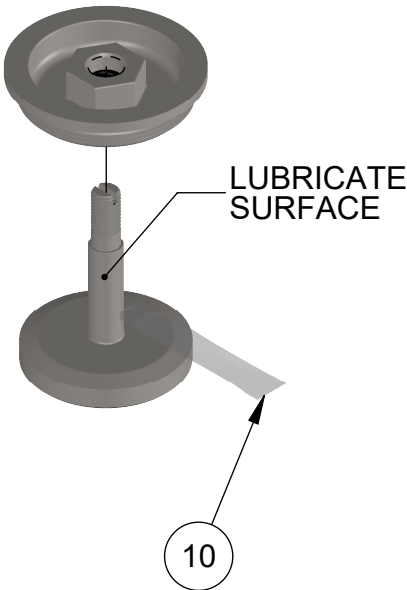
1077570 CUSTOM PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. 424-RAF12897

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
	A	ORB-028 WAS ORB-029	7/26/1999	MM
	B	NUMBER CONVERSION	4/28/2003	GES
	C	REDRAWN IN SOLIDWORKS, UPDATED BOM	10/28/2013	ANH
2436	D	REDRAWN IN AQ-MATIC FORMAT	9/5/2024	PMJ

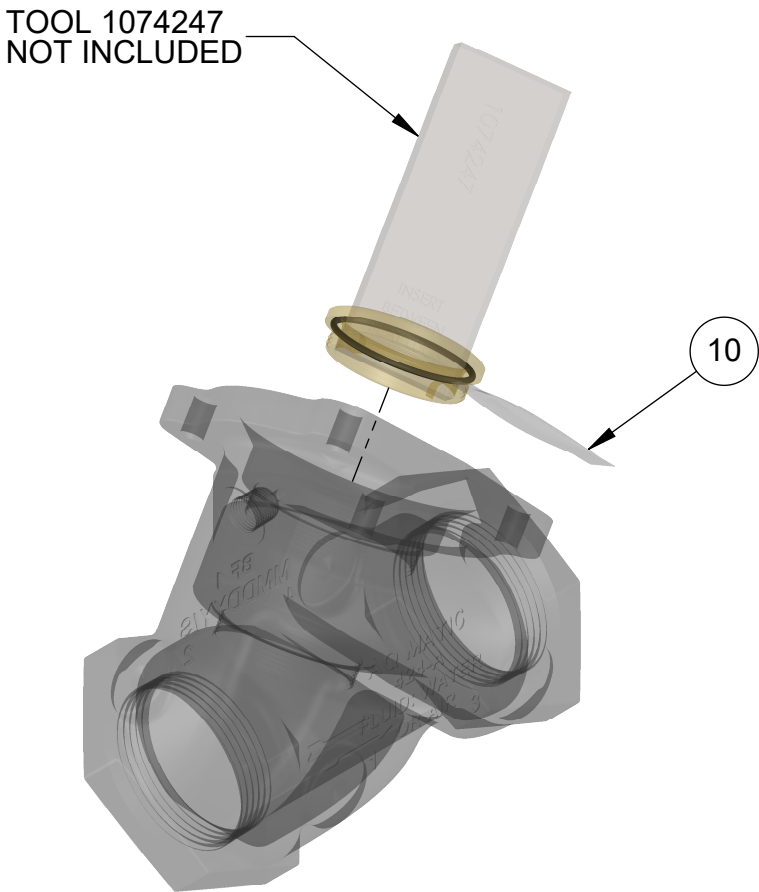
STEP 1
(WITH ONE PIECE SHAFT)



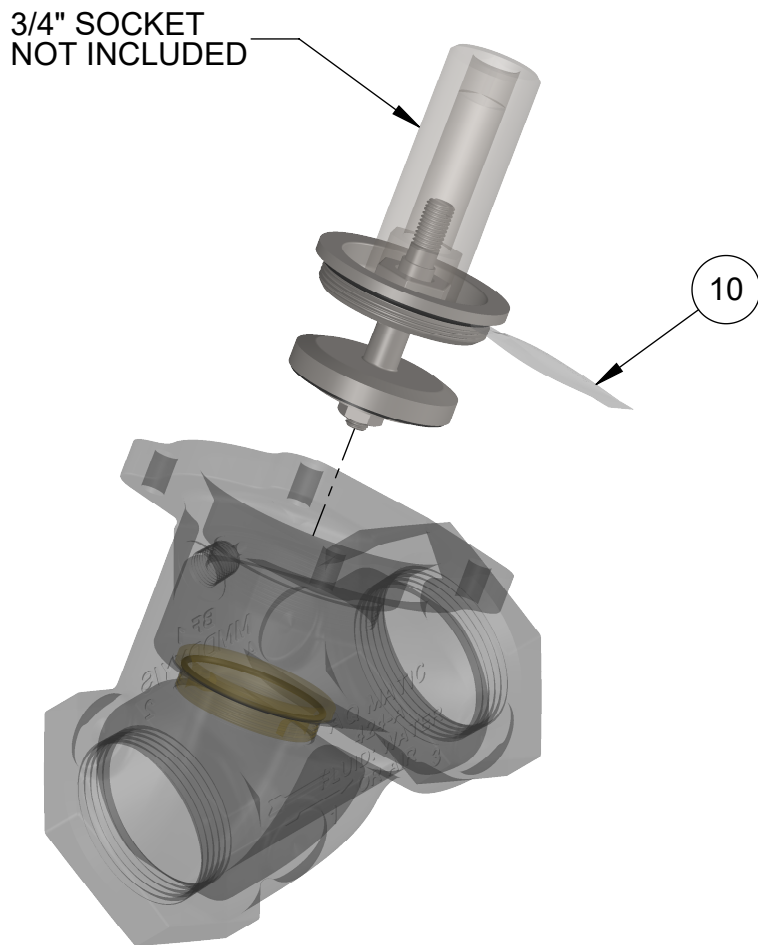
STEP 2



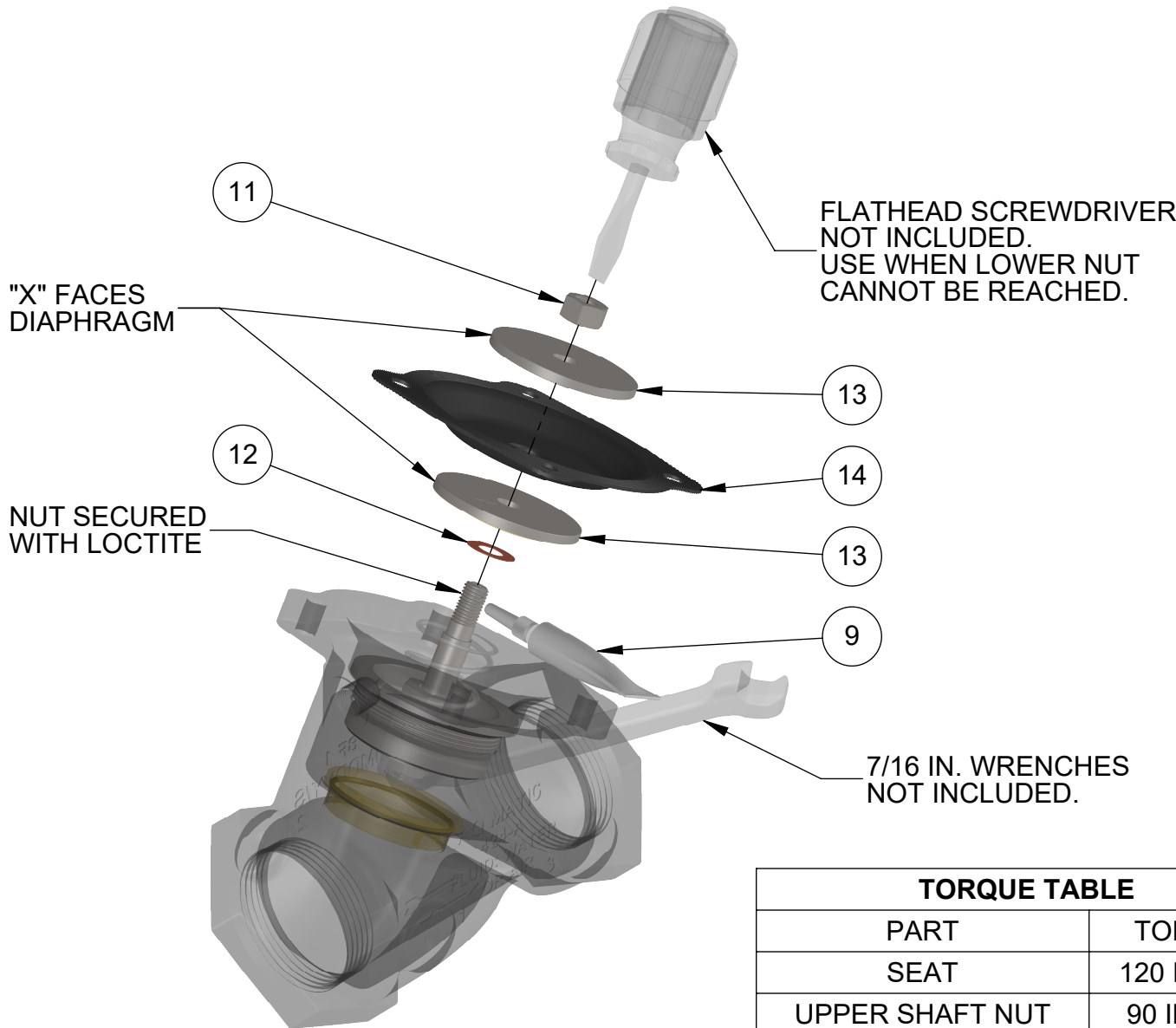
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



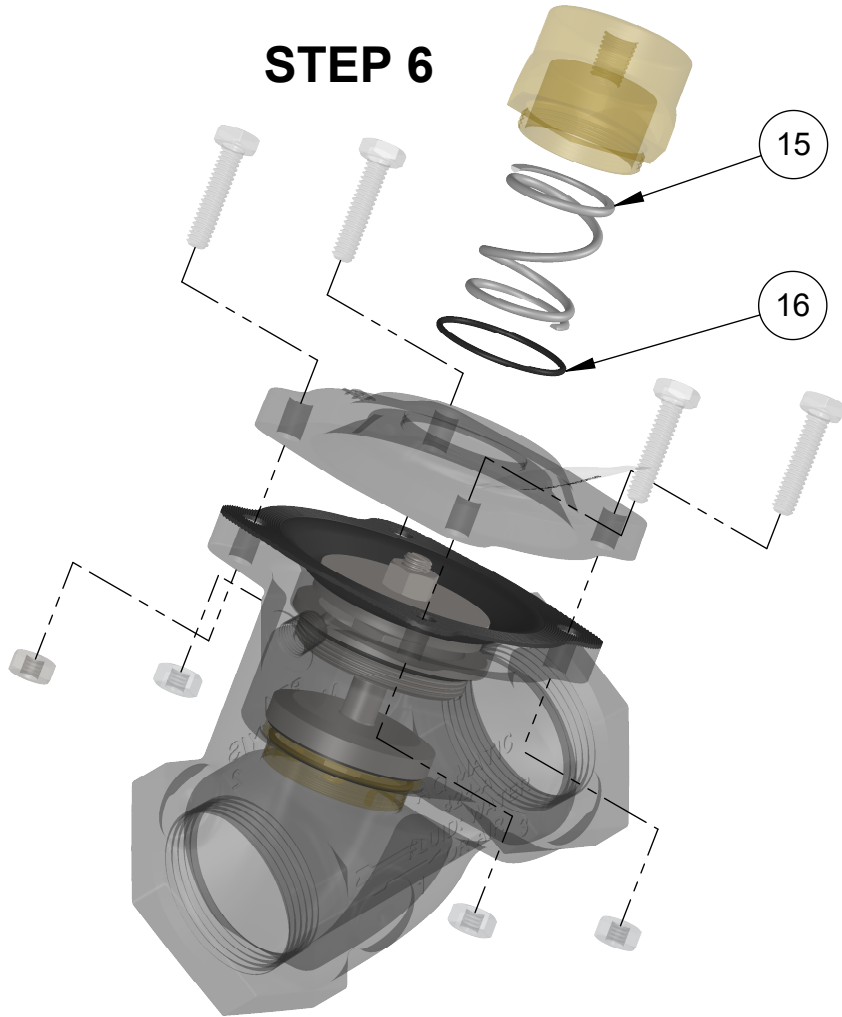
STEP 4



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.
- LEGACY TWO PIECE SHAFT USES A COPPER GASKET BETWEEN SHAFT AND DISC HOLDER.
- PRIOR TO REV. C, KIT WAS CONTROLLED BY DRAWING NO. 1082527.

TORQUE TABLE	
PART	TORQUE
SEAT	120 IN.LBS.
UPPER SHAFT NUT	90 IN.LBS.
LOWER SHAFT NUT	90 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.
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]
THIS DOCUMENT IS SOLELY THE PROPERTY OF AQ-MATIC.
REPRODUCTION, USE DISCLOSURE, OR TRANSMISSION OF THIS
DOCUMENT OR DETAILS CONTAINED HEREIN, IN PART OR IN WHOLE,
IS PROHIBITED WITHOUT THE WRITTEN CONSENT OF AQ-MATIC
ENGINEERING. THIS DOCUMENT AND ANY COPIES SHALL BE
RETURNED TO AQ-MATIC UPON WRITTEN REQUEST.

DESCRIPTION			
KIT,424,INT,CSTM			
DWG NO.	1077570	REV.	D
SIZE	C	SCALE	1:2
		SHEET 1 OF 1	