

1070069 PARTS

ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
2	1074232	424-J	DISC,424,BUNA	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	1
4	1262436	-	LOCTITE 565 POLYTUBE	1
5	1071678	ORB-028	O-RING,-028,BUNA	1
6	1071689	ORB-110TC	O-RING,-110,BUNA,TFL CTD	1
7	1071695	ORB-132	O-RING,-132,BUNA	1
8	42561	-	LUBRICANT,SILICONE,PACKET	1
9	1263853	RMET	HEX NUT 5/16" - 24	1
10	1074252	424-R	COPPER GASKET	1
11	1074222	424-FB	DIAPHRAGM,424,BUNA	1

1070119 PARTS

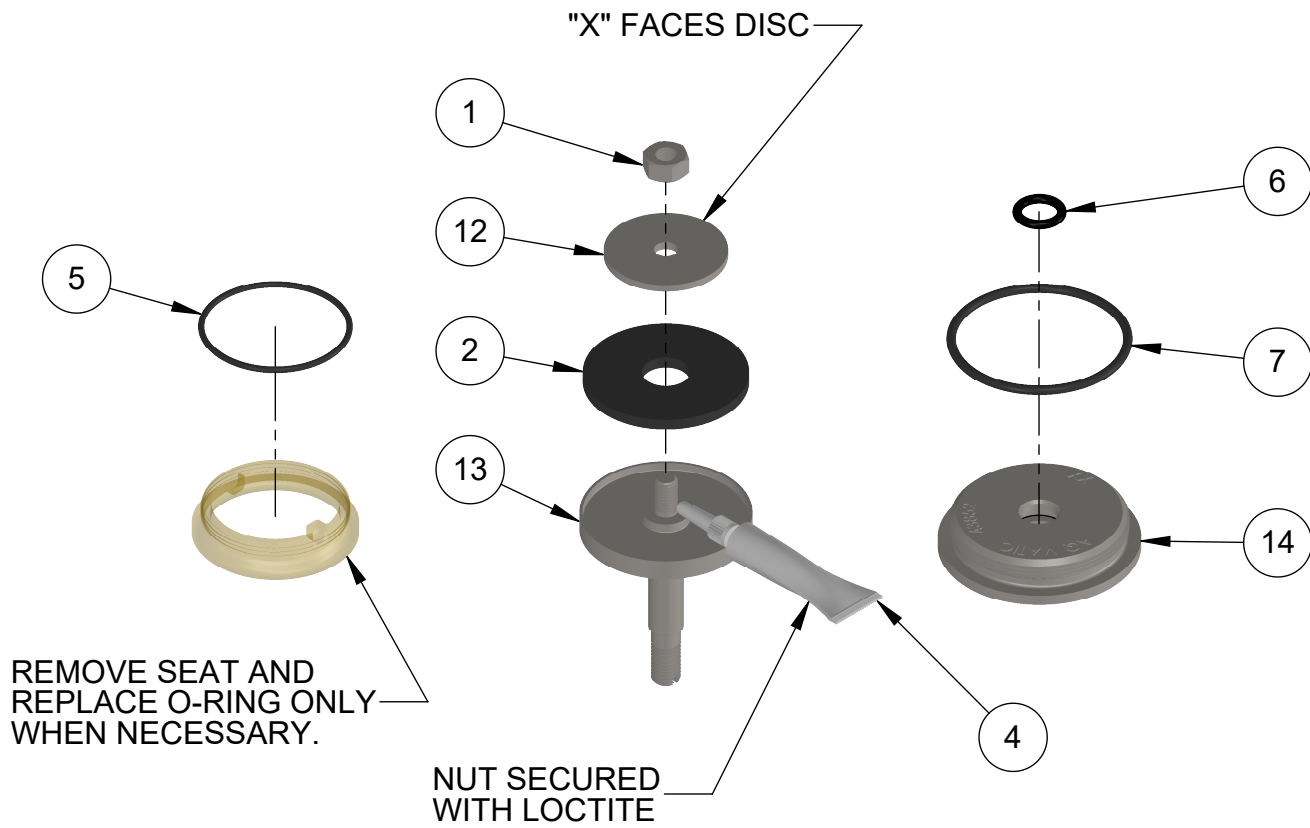
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
12	43942	424-H	DIAPHRAGM PLATE	1
13	44013	424-L2	NORMALLY OPEN COMBO SHAFT	1
14	43852	424-GGS	SHAFT GUIDE, 424, HEX	1
15	43943	424-DS	DIAPHRAGM PLATE	2

REVISIONS

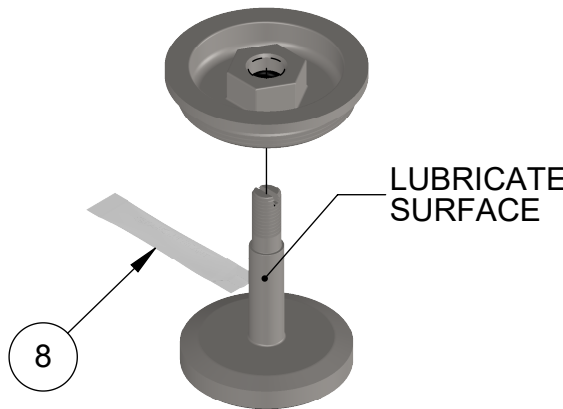
ECN	REV	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE	2/22/2001	ACE
	B	NUMBER CONVERSION	10/31/2002	ACE
2436	C	REDRAWN IN AQ-MATIC FORMAT, DRAWING NO. CHANGE, UPDATED BOM	9/5/2024	PMJ

1077809 COMBINATION KIT
ASSEMBLY INSTRUCTION
MODEL NO. -

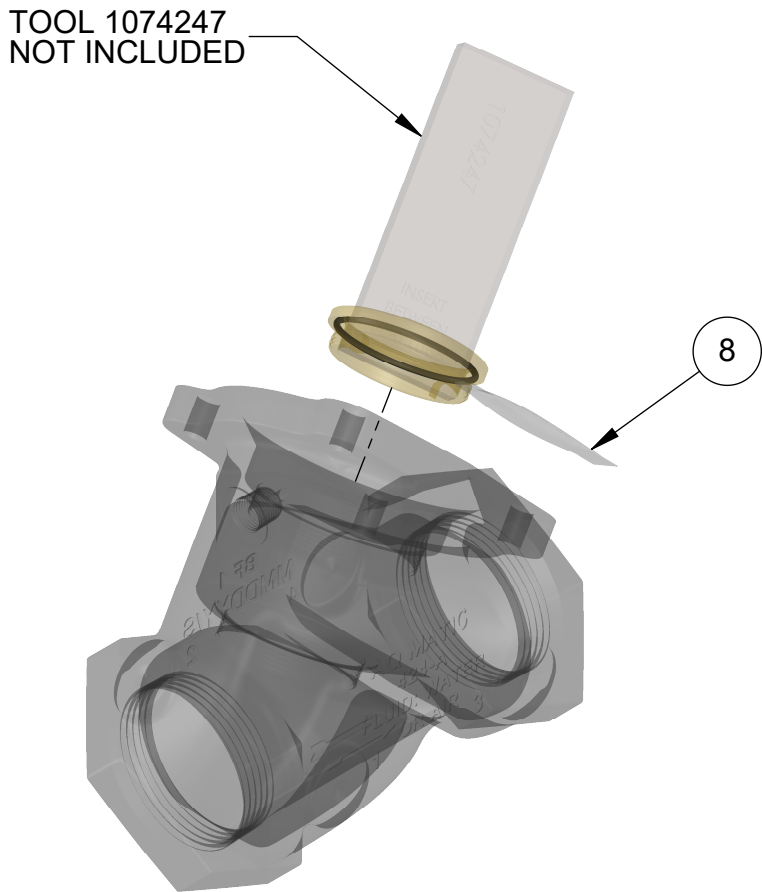
STEP 1
(WITH ONE PIECE SHAFT)



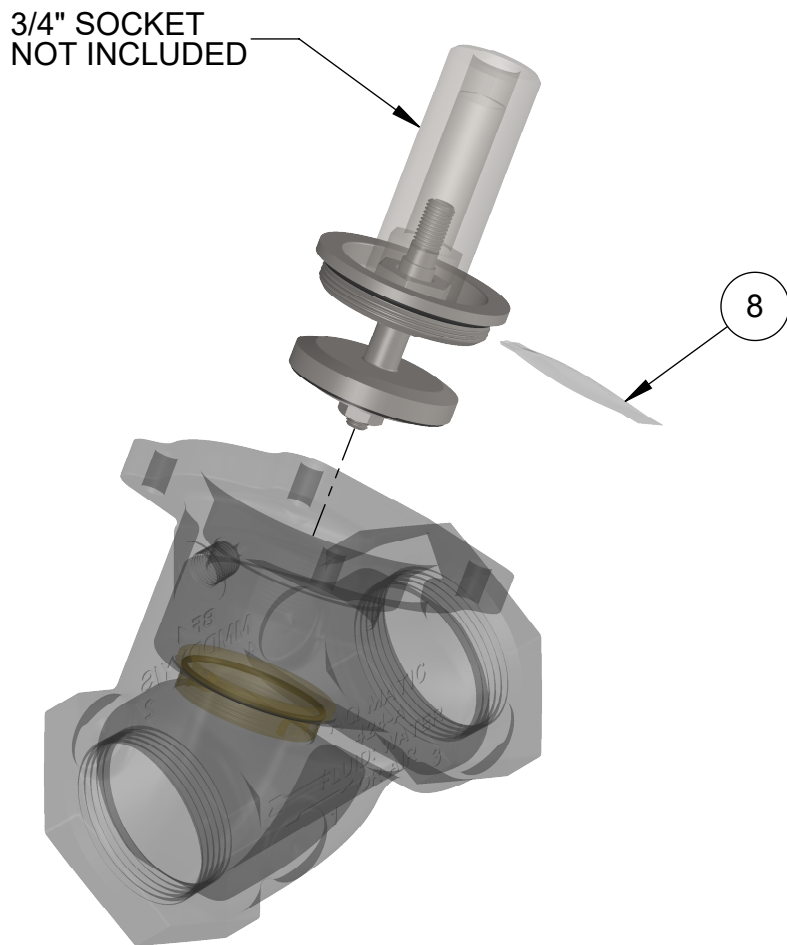
STEP 2



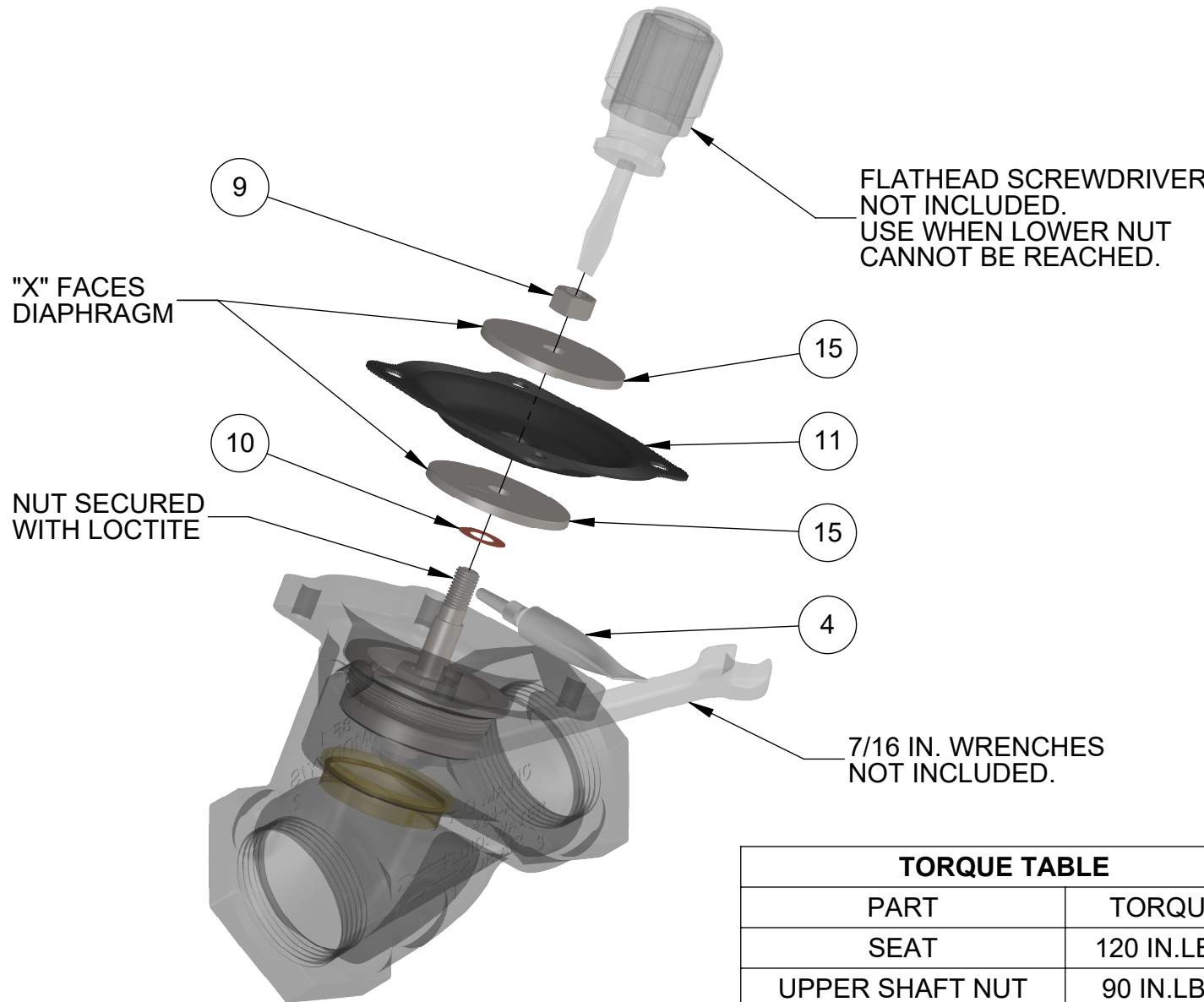
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



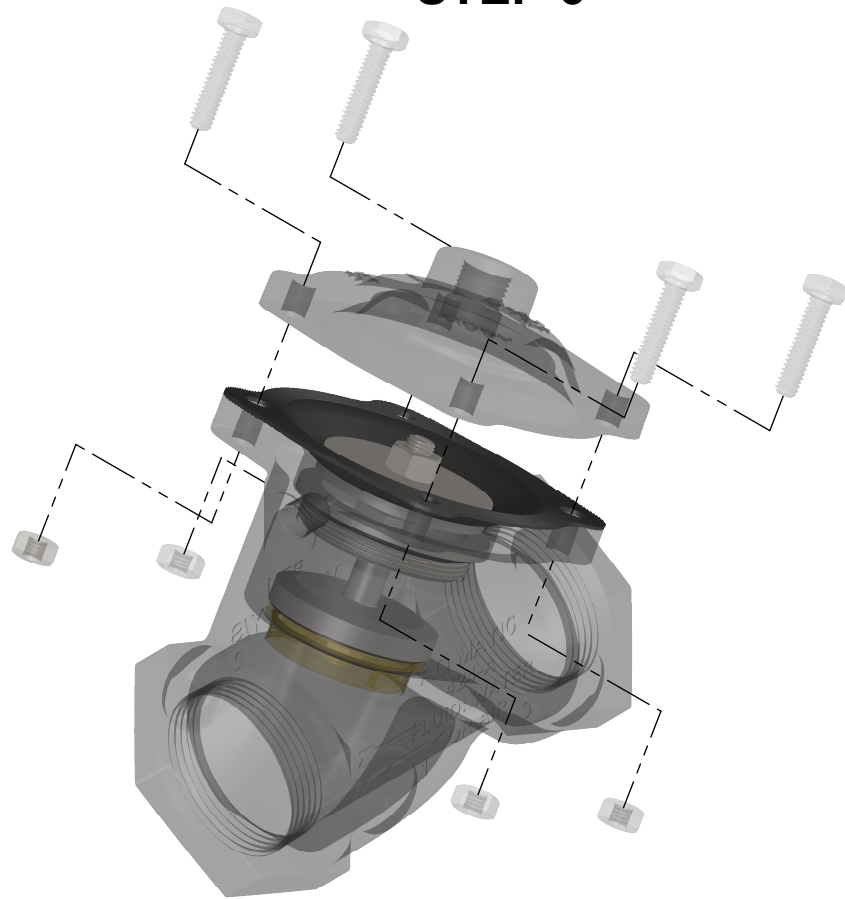
STEP 4



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.
- ITEM 3 (P/N 1073948) NOT TO BE USED IN COMBINED KIT.
- PRIOR TO REV. C, KIT WAS CONTROLLED BY DRAWING NO. 1077811.

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.

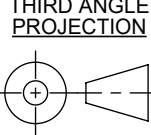
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M -2018.

PRIMARY UNITS SHOWN IN INCHES.
SECONDARY UNITS SHOWN IN MILLIMETERS.

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,424,-RA&-RF COMBINED

DWG NO. 1077809 REV. C
SIZE C SCALE 1:2 SHEET 1 OF 1