

SUBASSEMBLY 1070097

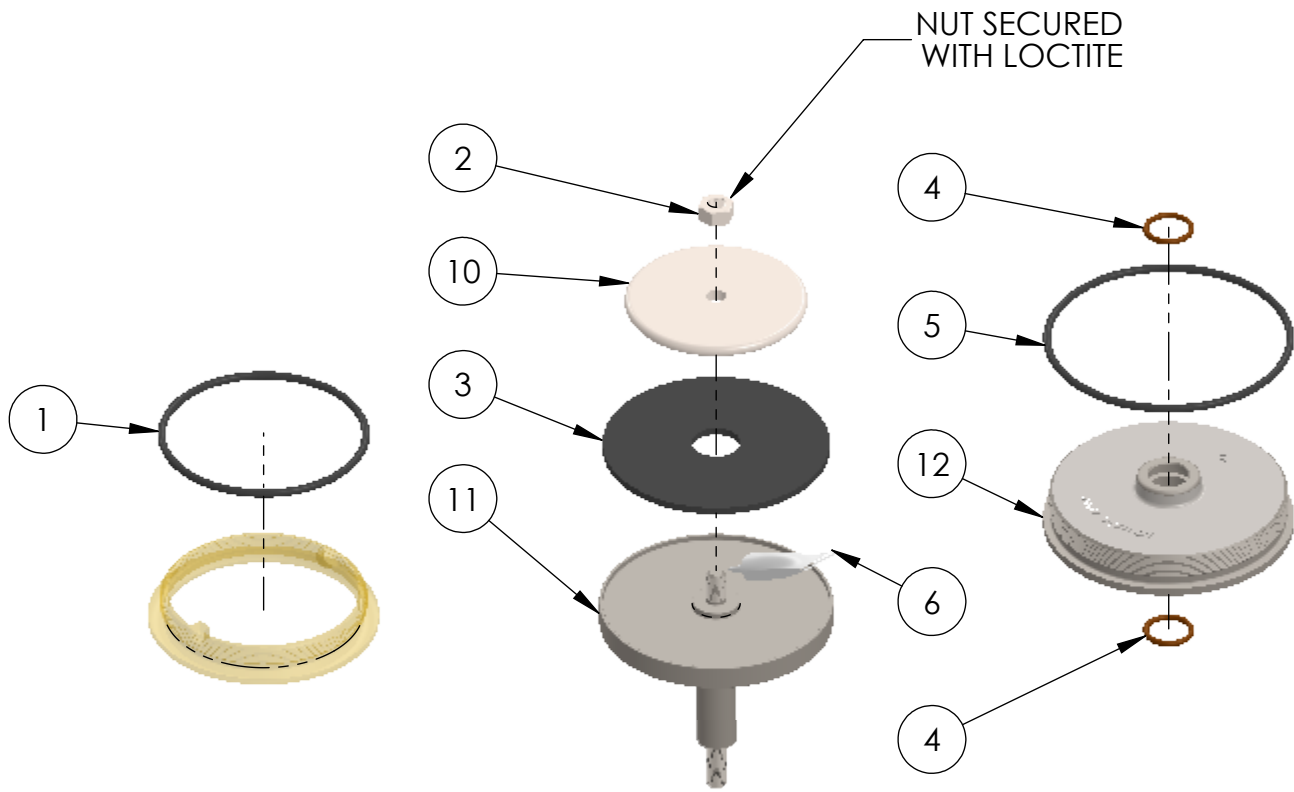
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1071826	ORV-233	O-RING,-233,FKM	1
2	1263853	RMET	HEX NUT 5/16" - 24	2
3	1074492	427-JV	DISC,427,FKM	1
4	1242391	ORV-114	O-RING,-114,FKM,TFL CTD	2
5	1071828	ORV-237	O-RING,-237,FKM	1
6	1262436	-	LOCTITE 565 POLYTUBE	1
7	42561	-	LUBRICANT,SILICONE,PACKET	1
8	1074477	427-FV	DIAPHRAGM,427,FKM	1
9	1074252	424-R	COPPER GASKET	2

SUBASSEMBLY 1070122

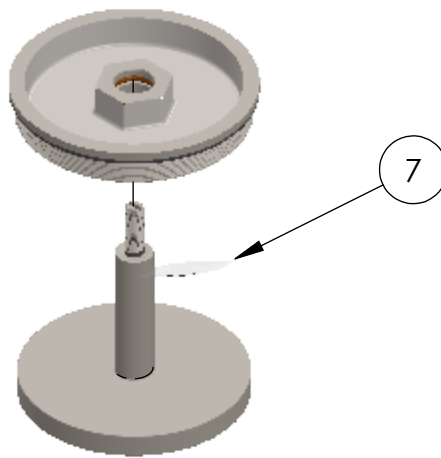
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
10	1074371	426-DA	PLATE,426 DIAPH,427 DIC PLATE	1
11	4510301-01	-	SHAFT NORMALLY OPEN	1
12	43850	427-GASO	SHAFT GUIDE, MACHINED	1
13	1074472	427-DA	DIAPHRAGM PLATE	2

1077862 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. -

STEP 1
(WITH ONE PIECE SHAFT)

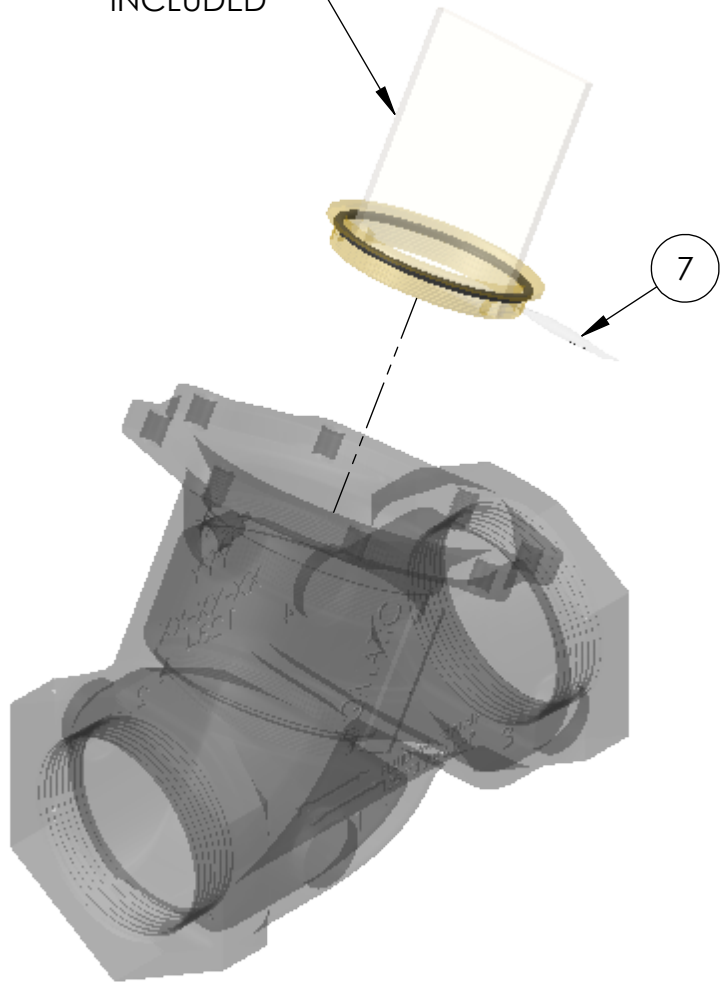


STEP 2

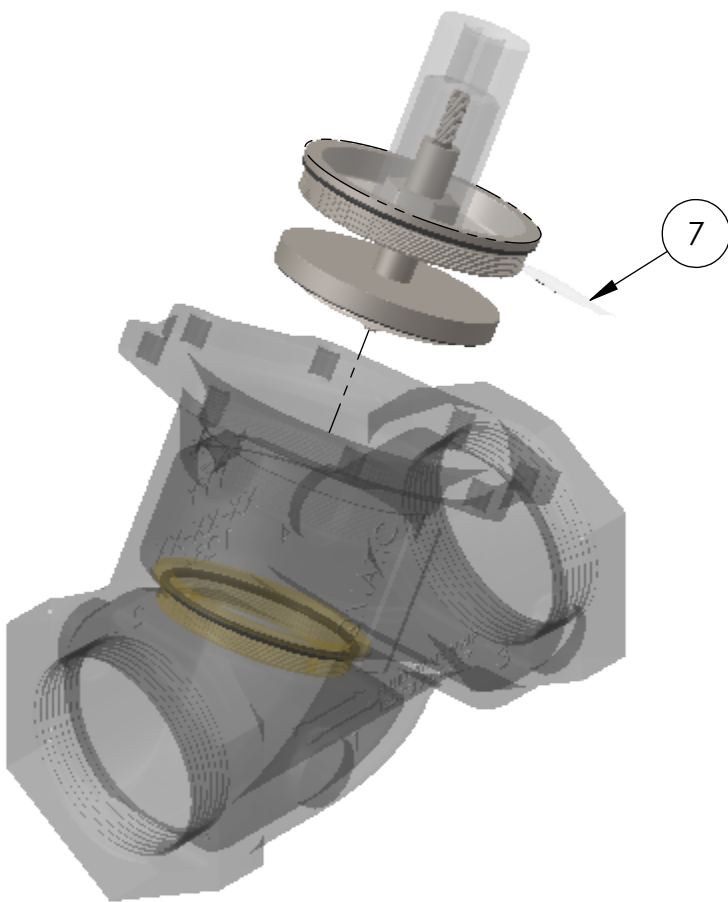


STEP 3

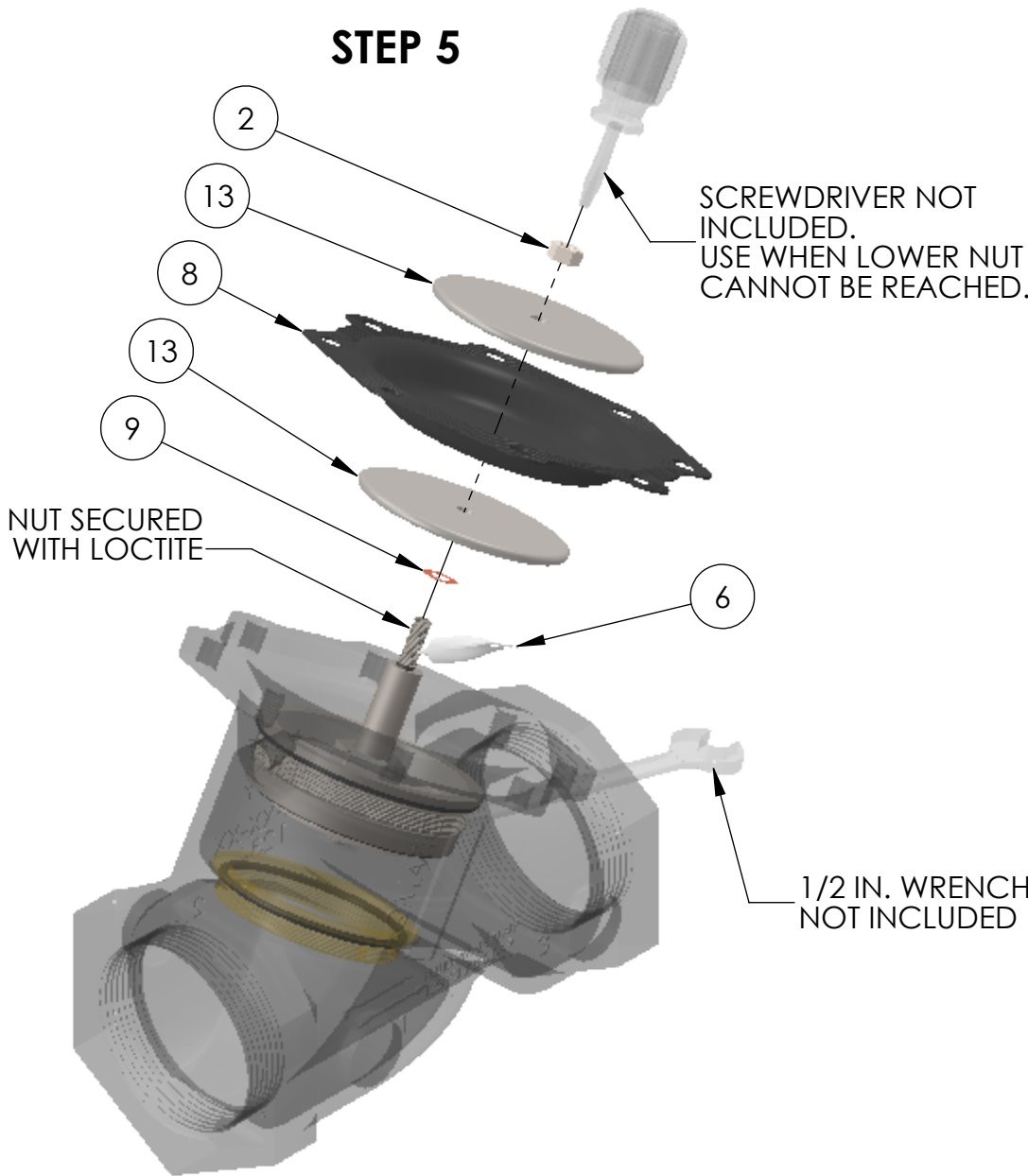
TOOL NOT INCLUDED



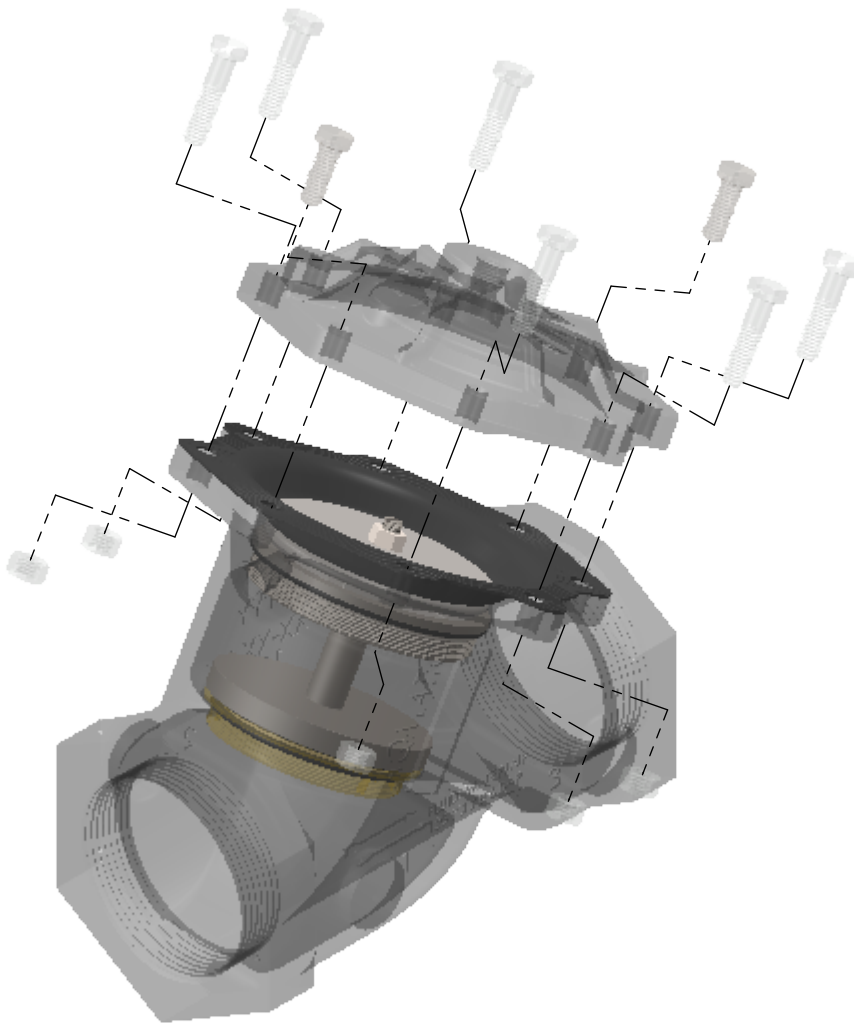
STEP 4



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.
- KIT 1070097 COMES WITH AN EXTRA 1074252 GASKET. DO NOT USE.
- PRIOR TO REV. C, KIT WAS CONTROLLED BY DRAWING NO. 1077863.
- THIS KIT AND ASSEMBLY INSTRUCTIONS WORK FOR ALL THREADED, FLANGED, AND GROOVE ADAPTER BODIES.

TORQUE TABLE	
PART	TORQUE
SEAT	500 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	140 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,427,-RAV & -RF COMBINED			
DWG NO.	1077862	REV.	C
SIZE	C	SCALE	1:3
		SHEET 1 OF 1	