

BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	2
2	1074144	421-JH	DISC,421,HYCAR	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	2
4	1071661	ORA-110	O-RING,ORA-110,AFLAS	1
5	1071803	ORV-125	O-RING,-125,FKM	1
6	1071791	ORV-024	O-RING,-024,FKM	1
7	1074120	421-FV	DIAPHRAGM,421,FLOR	1
8	1262436	-	LOCTITE 565 POLYTUBE	1

1079155 SEAL AND DIAPHRAGM KIT ASSEMBLY INSTRUCTION

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2392	A	INITIAL RELEASE	5/15/2024	PMJ

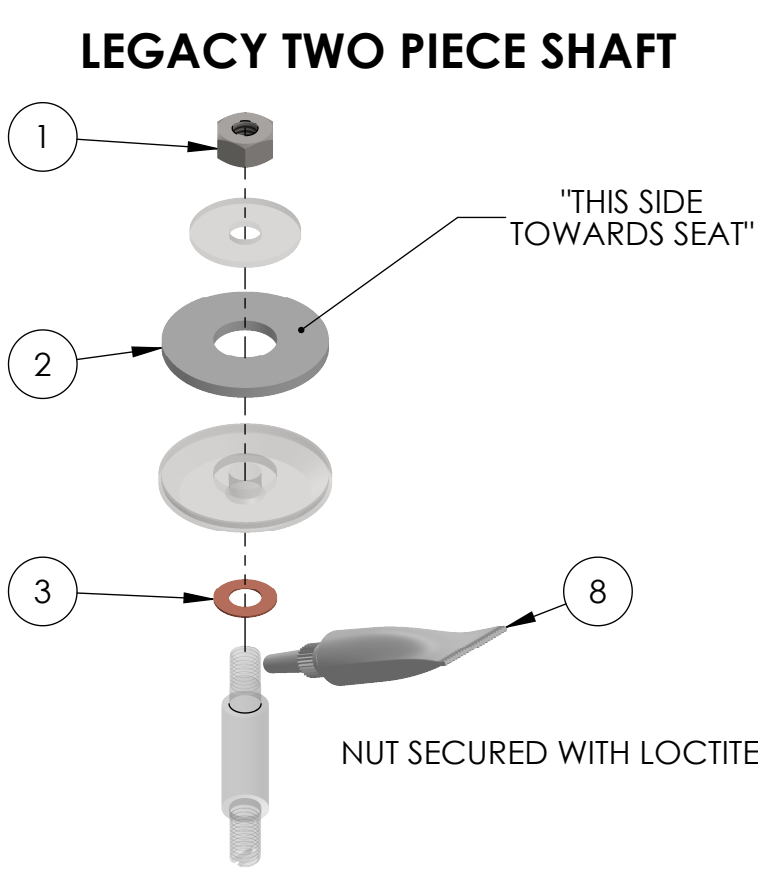
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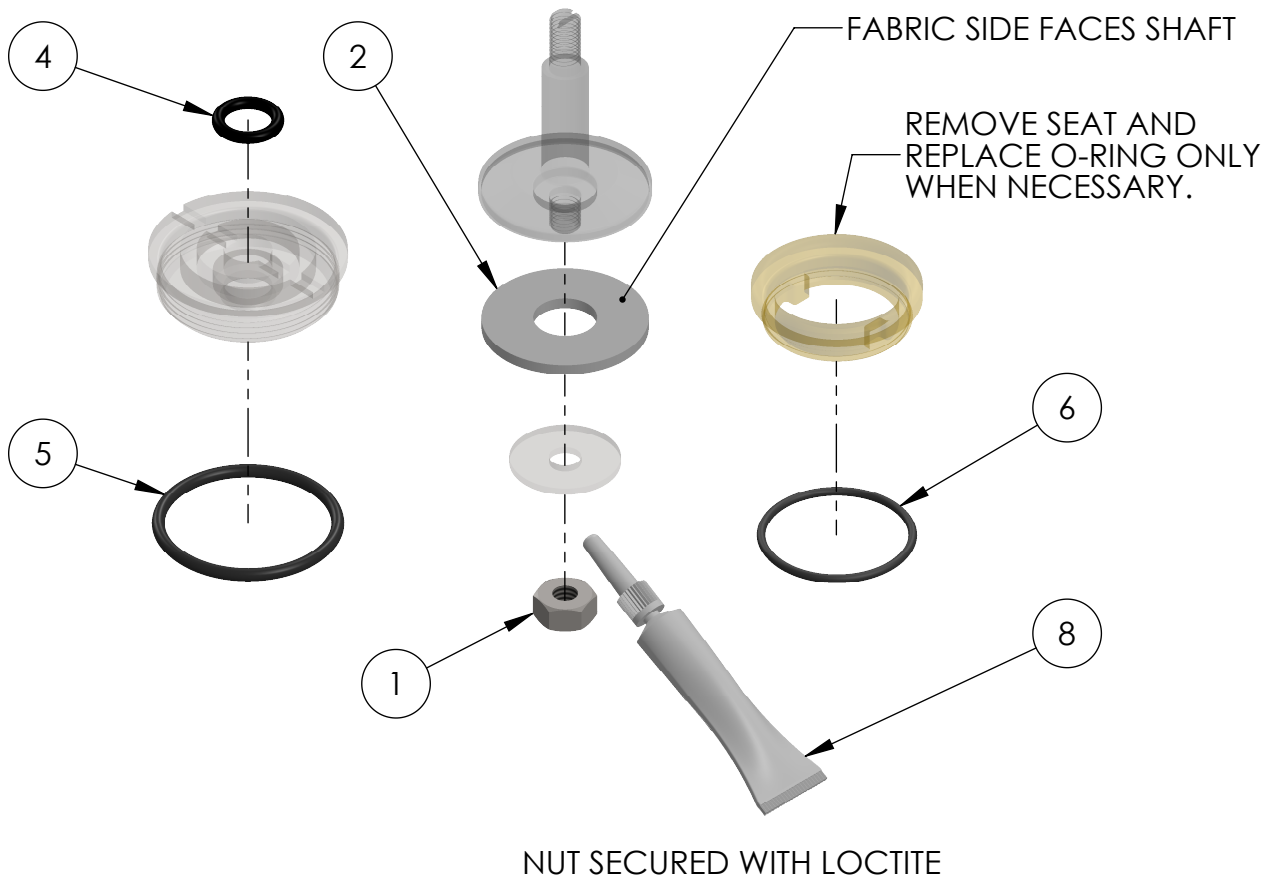
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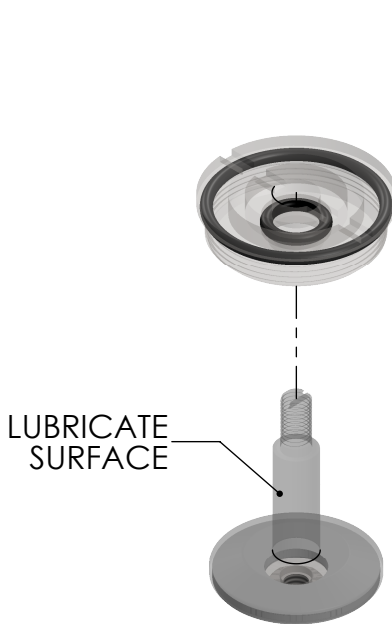
LEGACY TWO PIECE SHAFT



STEP 1
(WITH ONE PIECE SHAFT)

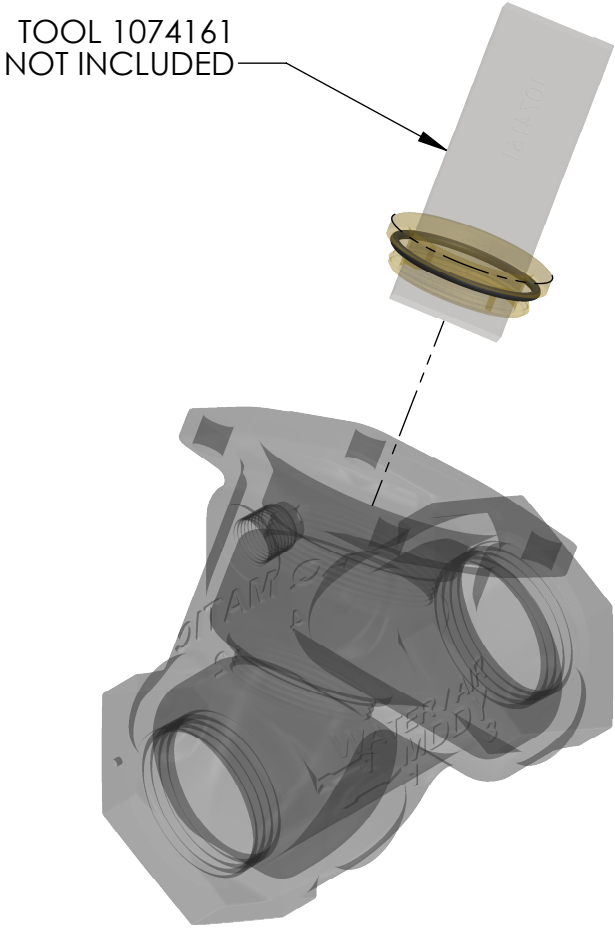


STEP 2

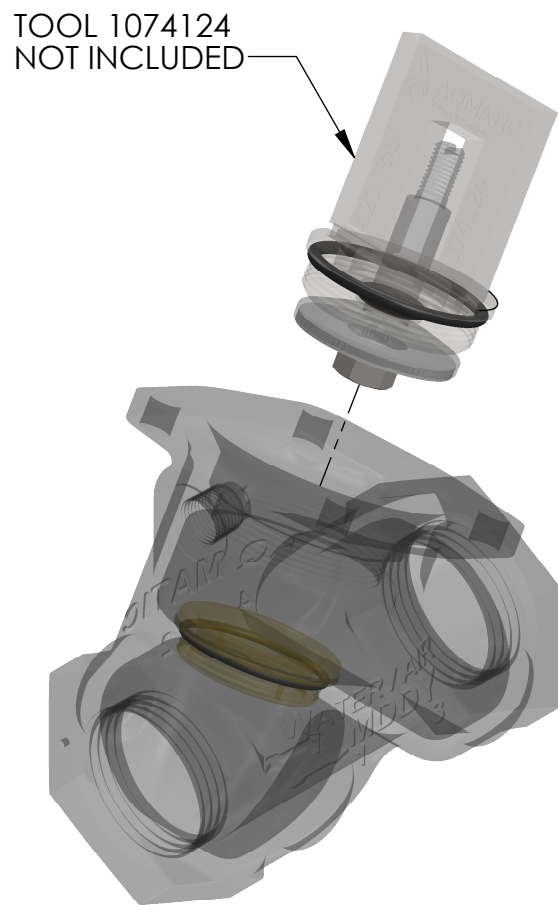


STEP 3

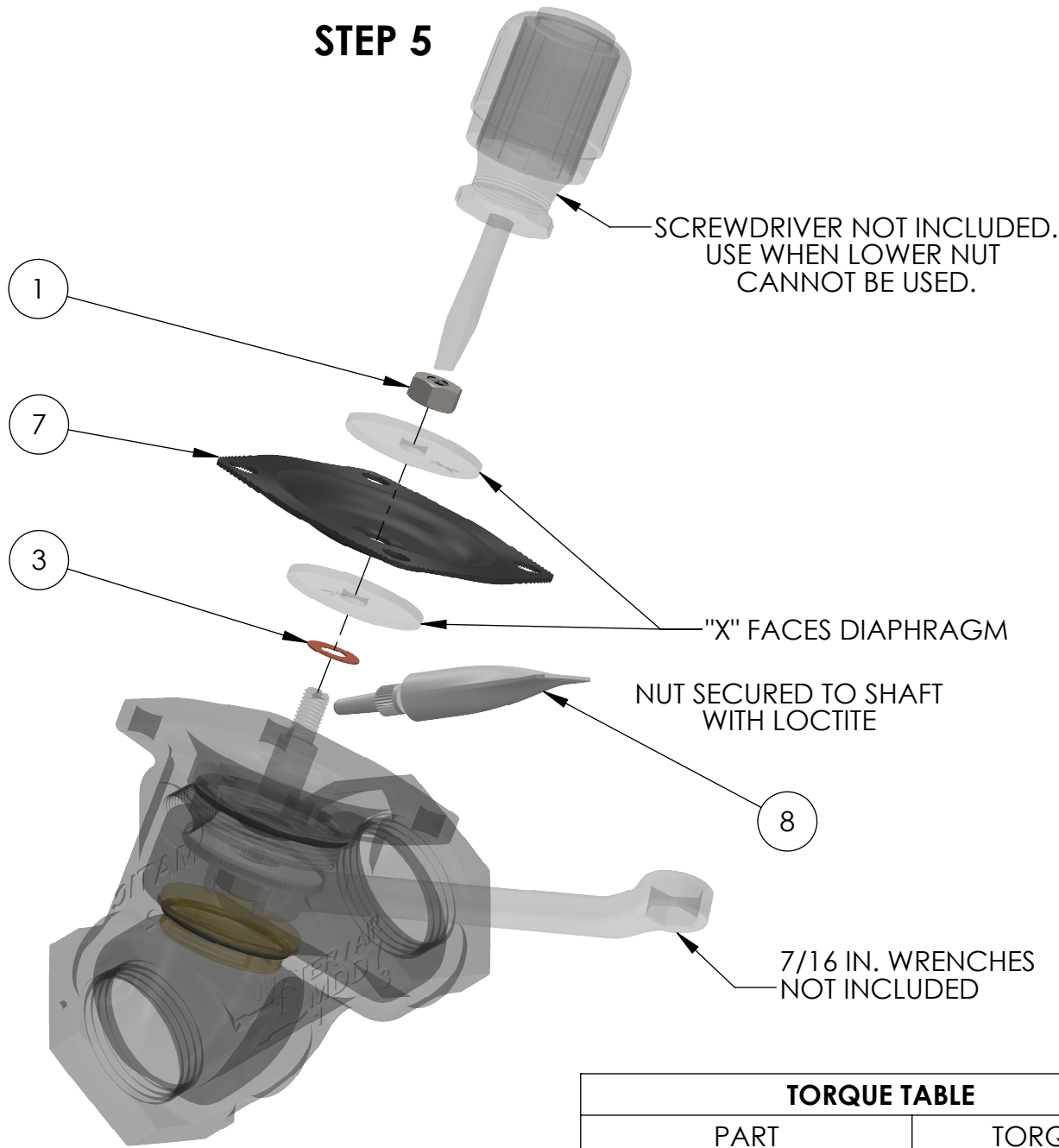
NOT NEEDED FOR MOST REPAIRS



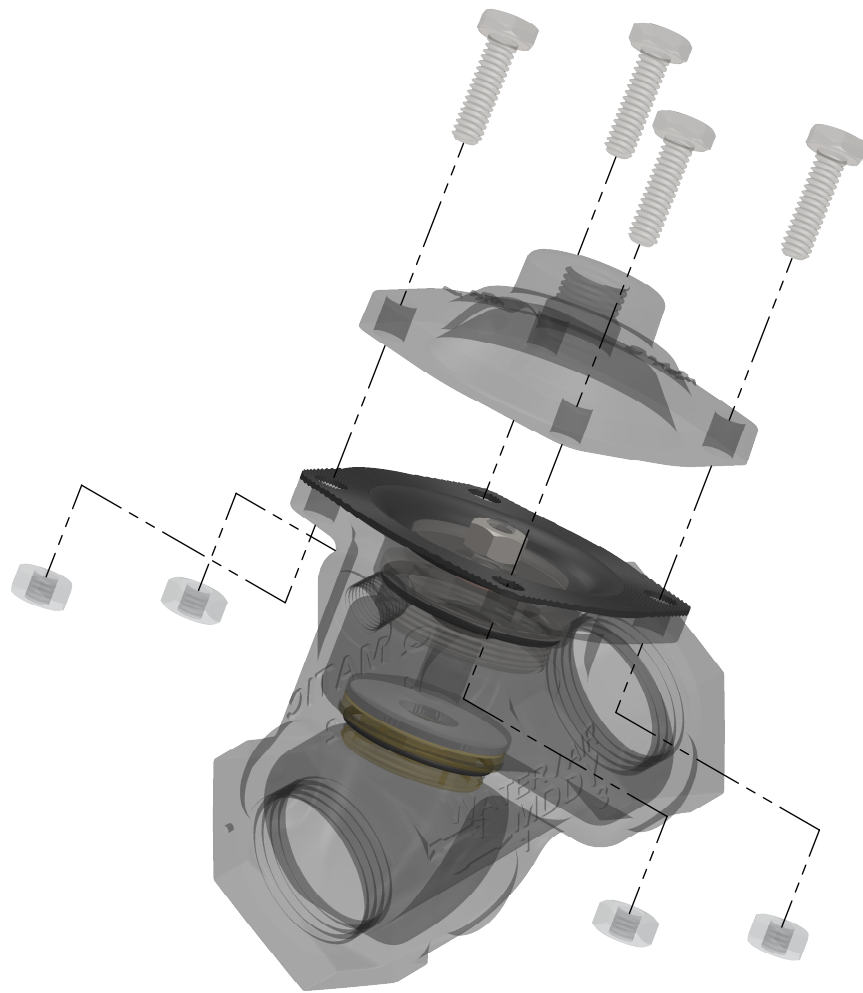
STEP 4



STEP 5



STEP 6



- NOTES:
- ALL O-RINGS MUST BE INSTALLED WITH SILICONE-FREE 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.

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]
THIRD ANGLE PROJECTION
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DESCRIPTION			
KIT,AV1,D&S,-FV,-JT,SIL FREE			
DWG NO.	1079155	REV.	A
SIZE	C	SCALE	2:3
		SHEET 1 OF 1	

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