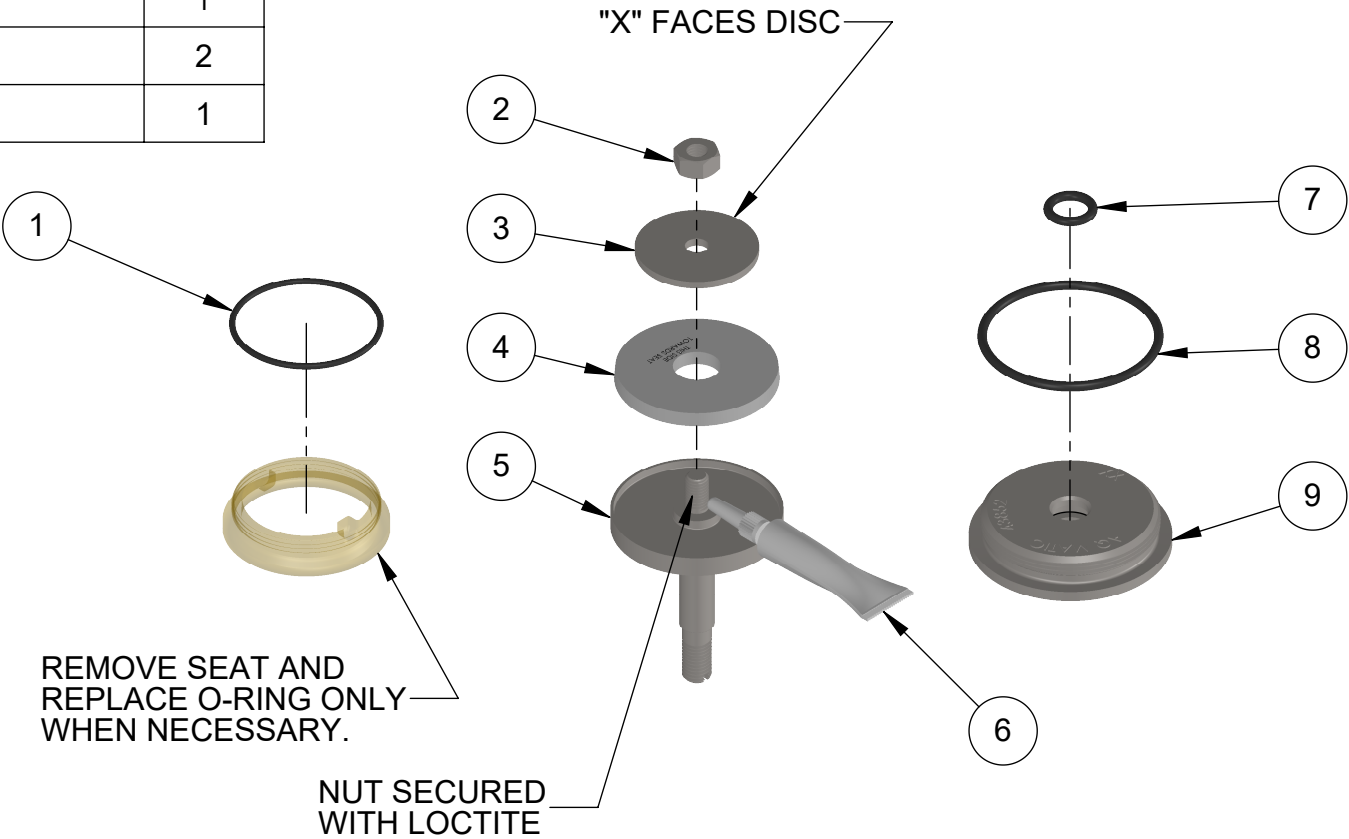


4				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1071793	ORB-028	O-RING,-028,BUNA	1
2	1263852	NUS-0010	NUT,HEX,1/4-28,SS	1
3	43942	424-H	DIAPHRAGM PLATE	1
4	1074234	424-JH	DISC,424,HYCAR	1
5	44013	424-L2	NORMALLY OPEN COMBO SHAFT	1
6	1262436	-	LOCTITE 565 POLYTUBE	1
7	1071661	ORA-110	O-RING,ORA-110,AFLAS	1
8	1071806	ORV-132	O-RING,-132,FKM	1
9	43852	424-GGS	SHAFT GUIDE, 424, HEX	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

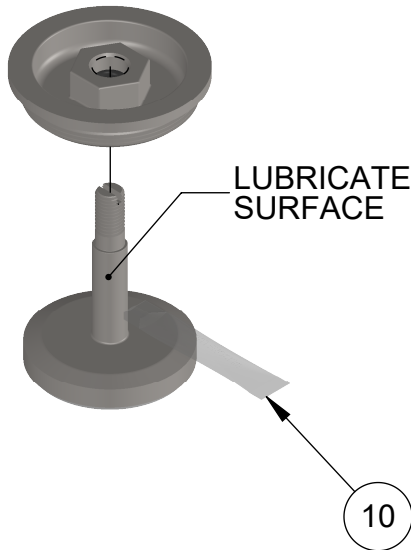
1237440 COMBINED PARTS KIT
ASSEMBLY INSTRUCTION
MODEL NO. -

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2436	A	INITIAL RELEASE	9/6/2024	PMJ

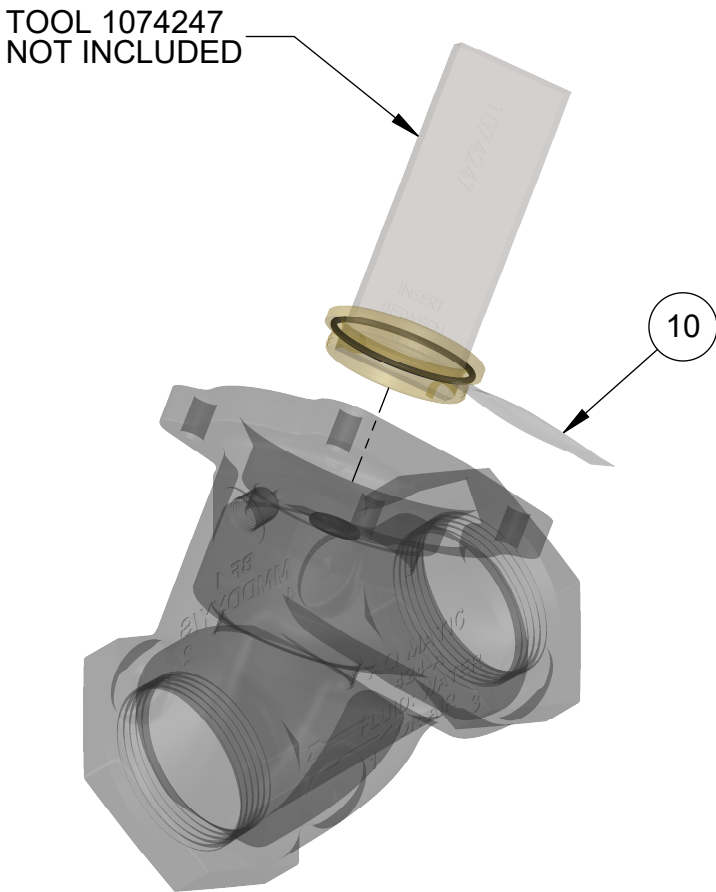
STEP 1
(WITH ONE PIECE SHAFT)



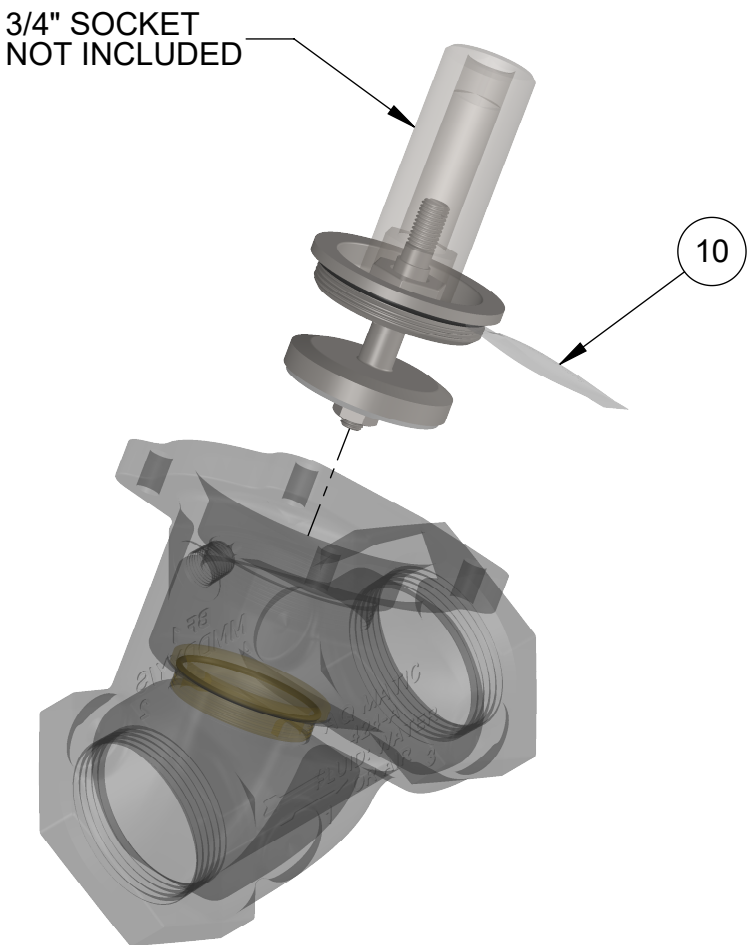
STEP 2



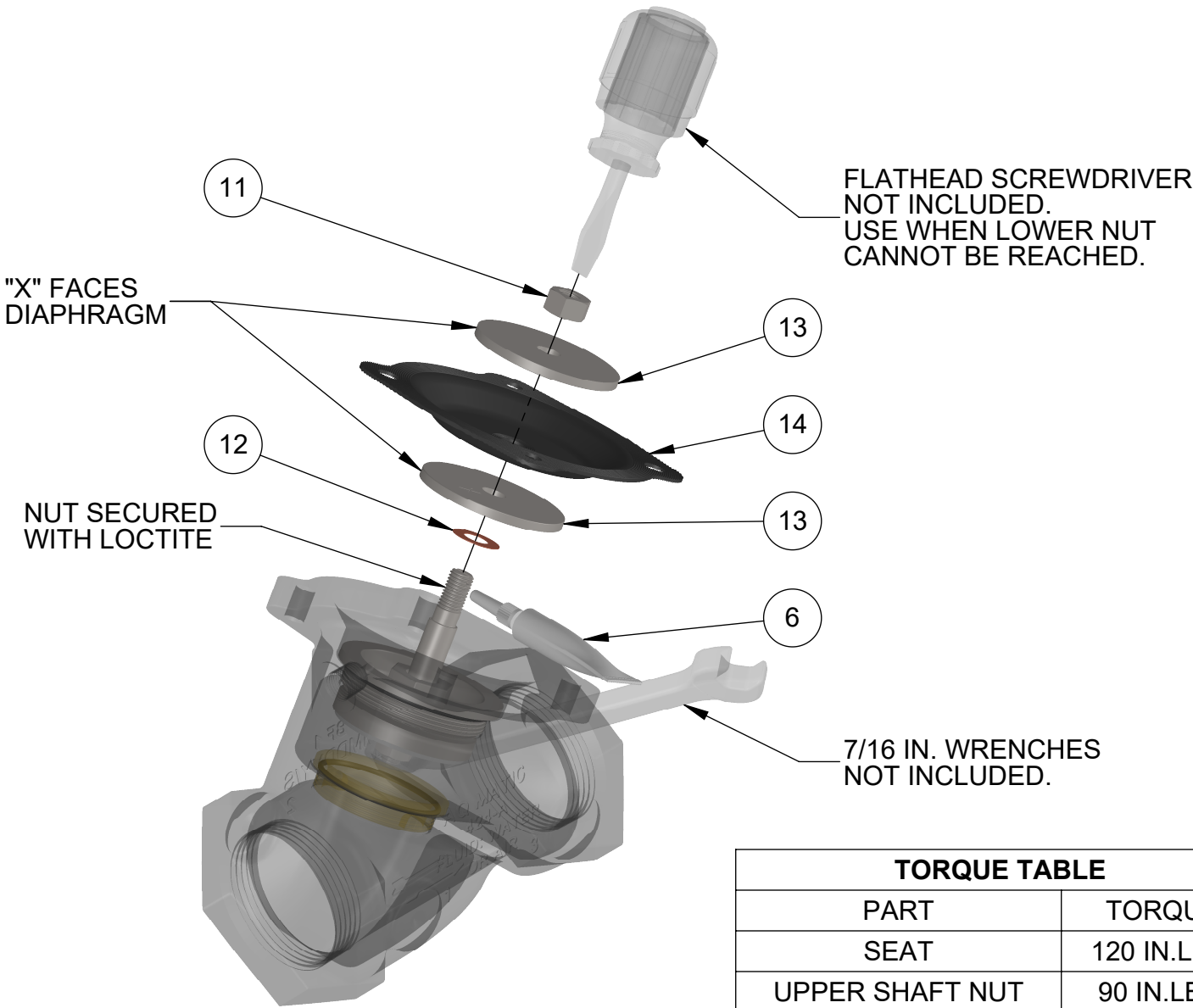
STEP 3
(NOT NEEDED FOR MOST REPAIRS)



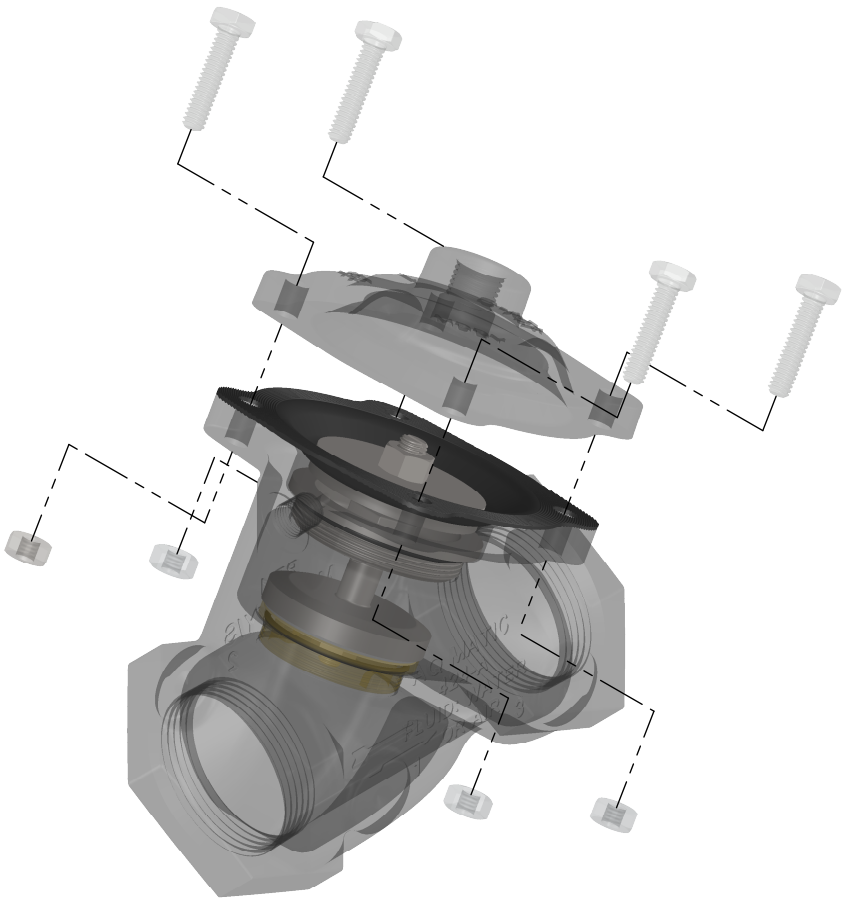
STEP 4



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.

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]

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DESCRIPTION			
KIT,AV4,RP & D&S			
DWG NO.	1237440	REV.	A
SIZE	C	SCALE	1:2
SHEET 1 OF 1			