

4

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1

BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263852	NUS-0010	NUT,HEX,1/4-28,SS	2
2	1074146	421-JV	DISC,421,FKM	1
3	1073948	200-GG	GASKET,COPPER,1/200X1/4ID	2
4	1239021	ORV-110TC	O-RING,FKM,ORV-110,TEF COATED	1
5	1071803	ORV-125	O-RING,-125,FKM	1
6	1071791	ORV-024	O-RING,-024,FKM	1
7	1074119	421-FB	DIAPHRAGM,421,BUNA	1
8	1262436	-	LOCTITE 565 POLYTUBE	1
9	42561	-	LUBRICANT,SILICONE,PACKET	1

4510894 SEAL AND DIAPHRAGM KIT ASSEMBLY INSTRUCTION

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2392	A	INITIAL RELEASE	5/16/2024	PMJ

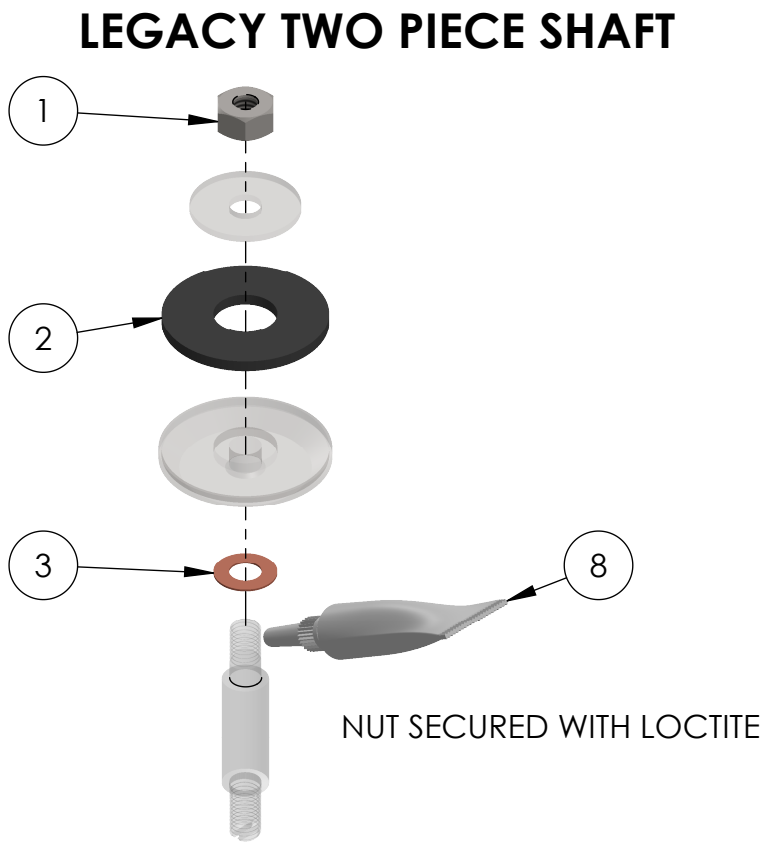
D

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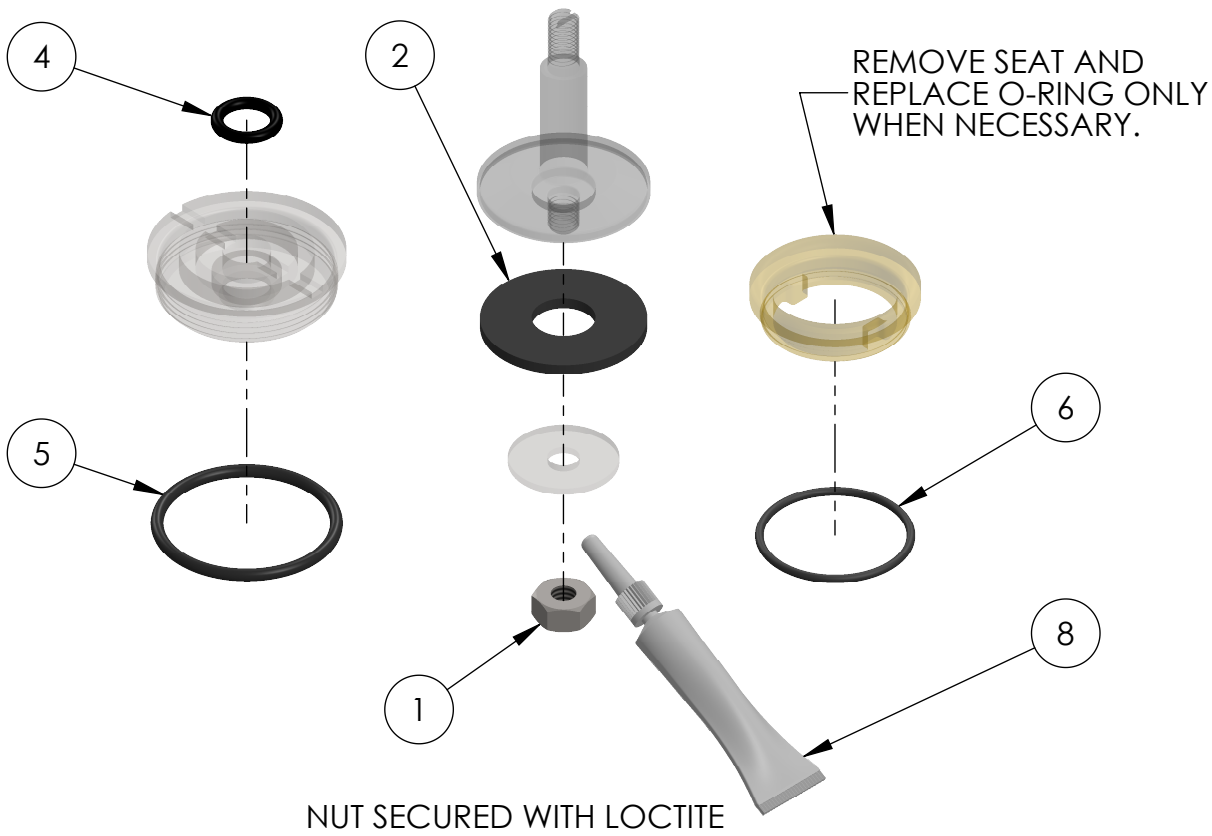
C

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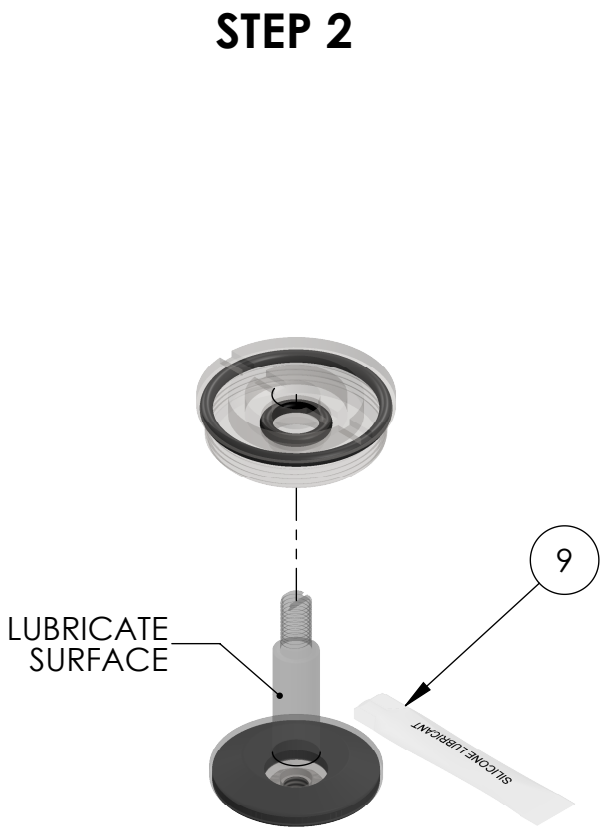
LEGACY TWO PIECE SHAFT



STEP 1
(WITH ONE PIECE SHAFT)

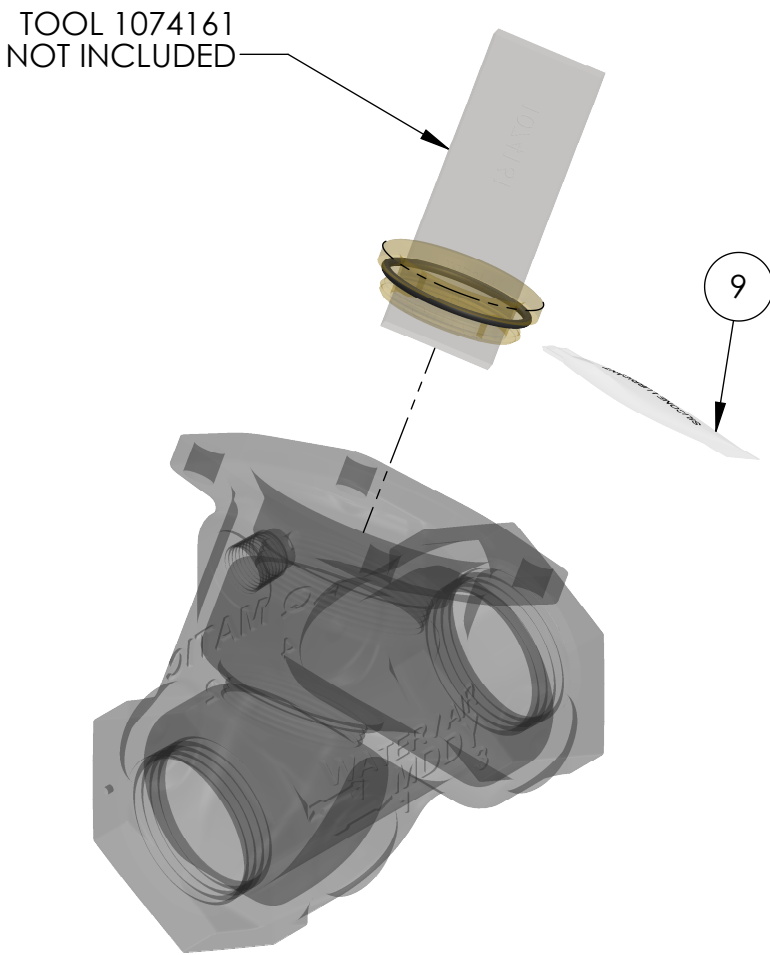


STEP 2

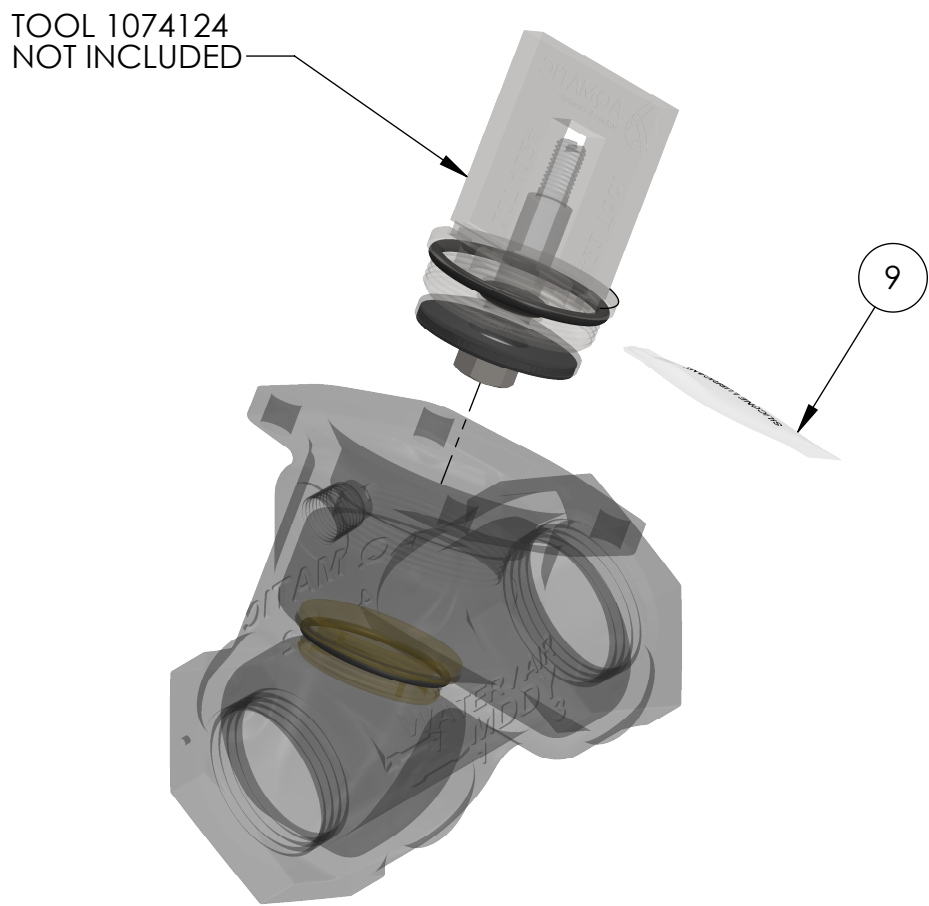


STEP 3

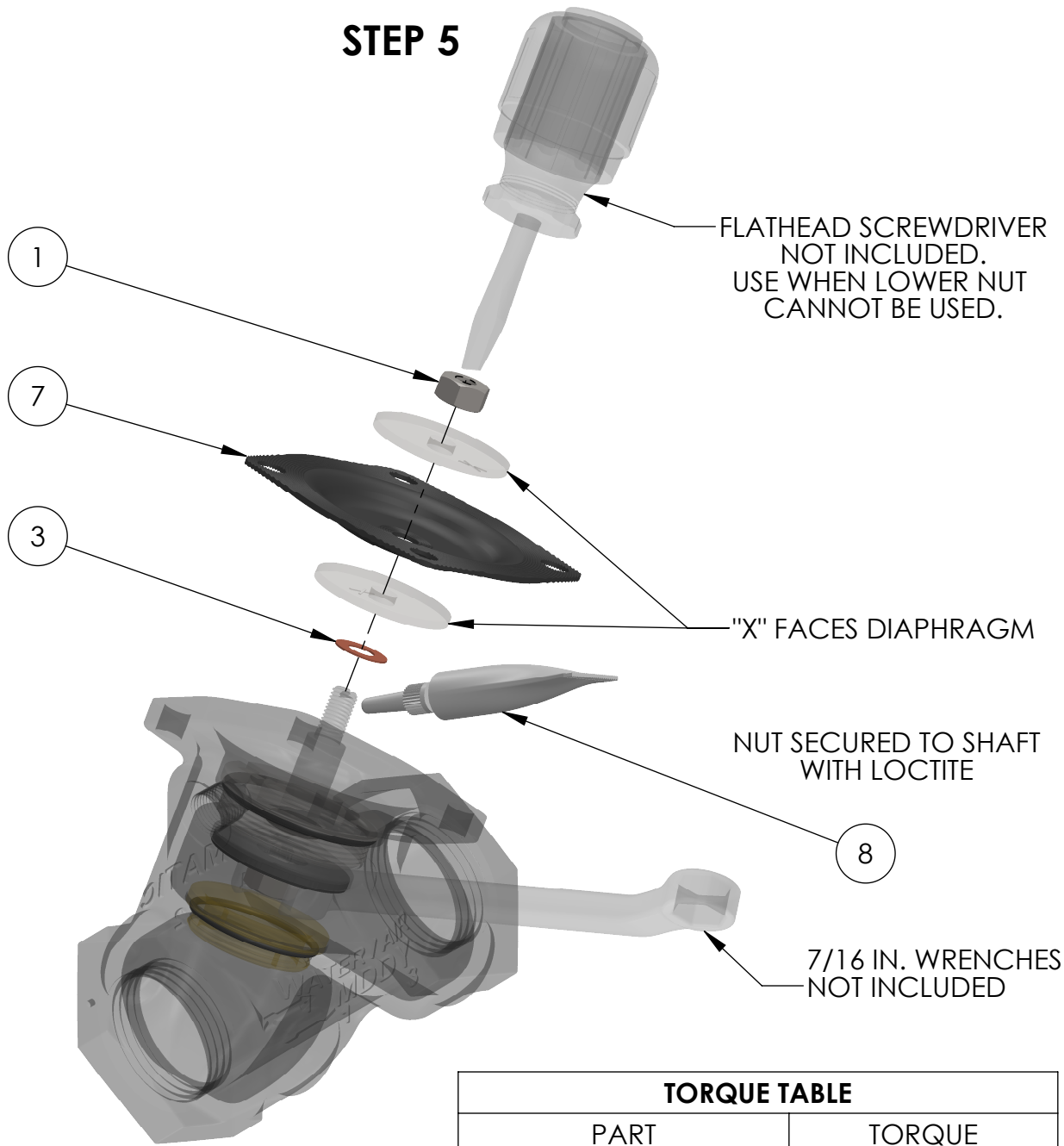
NOT NEEDED FOR MOST REPAIRS



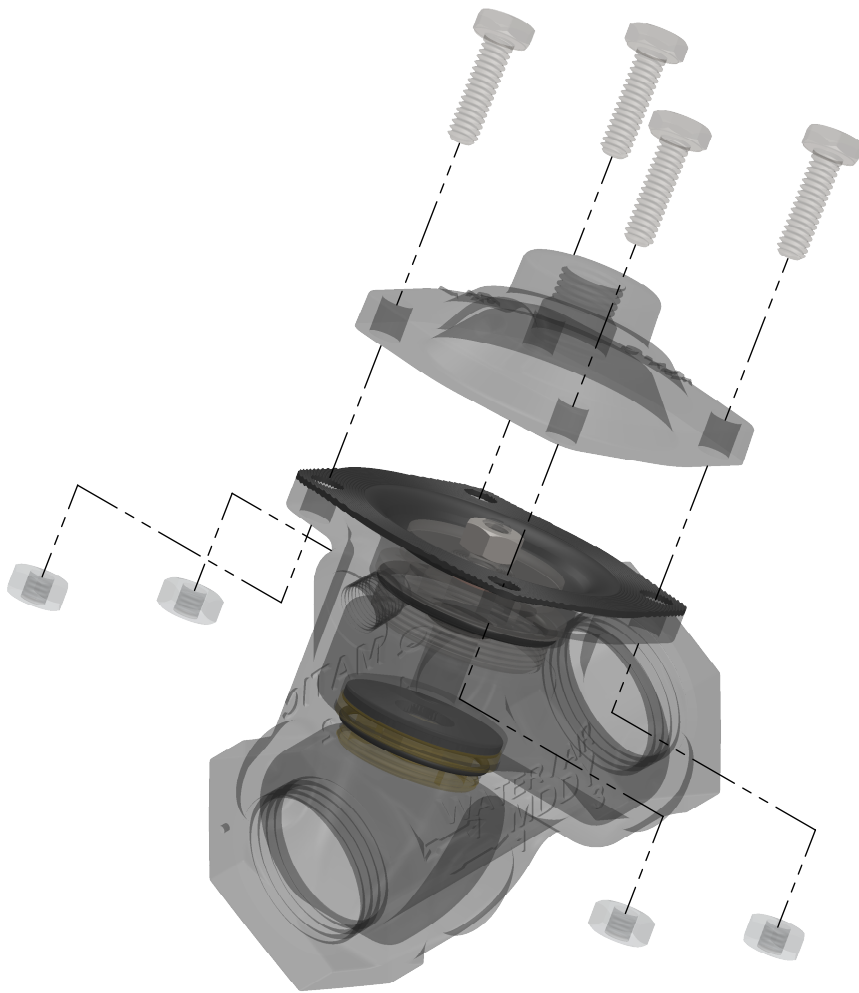
STEP 4



STEP 5



STEP 6



NOTES:

- ALL O-RINGS MUST BE INSTALLED WITH 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,421,D&S,BUNA		
DWG NO.	4510894	REV. A
SIZE	C	SCALE 2:3 SHEET 1 OF 1

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