

4

3

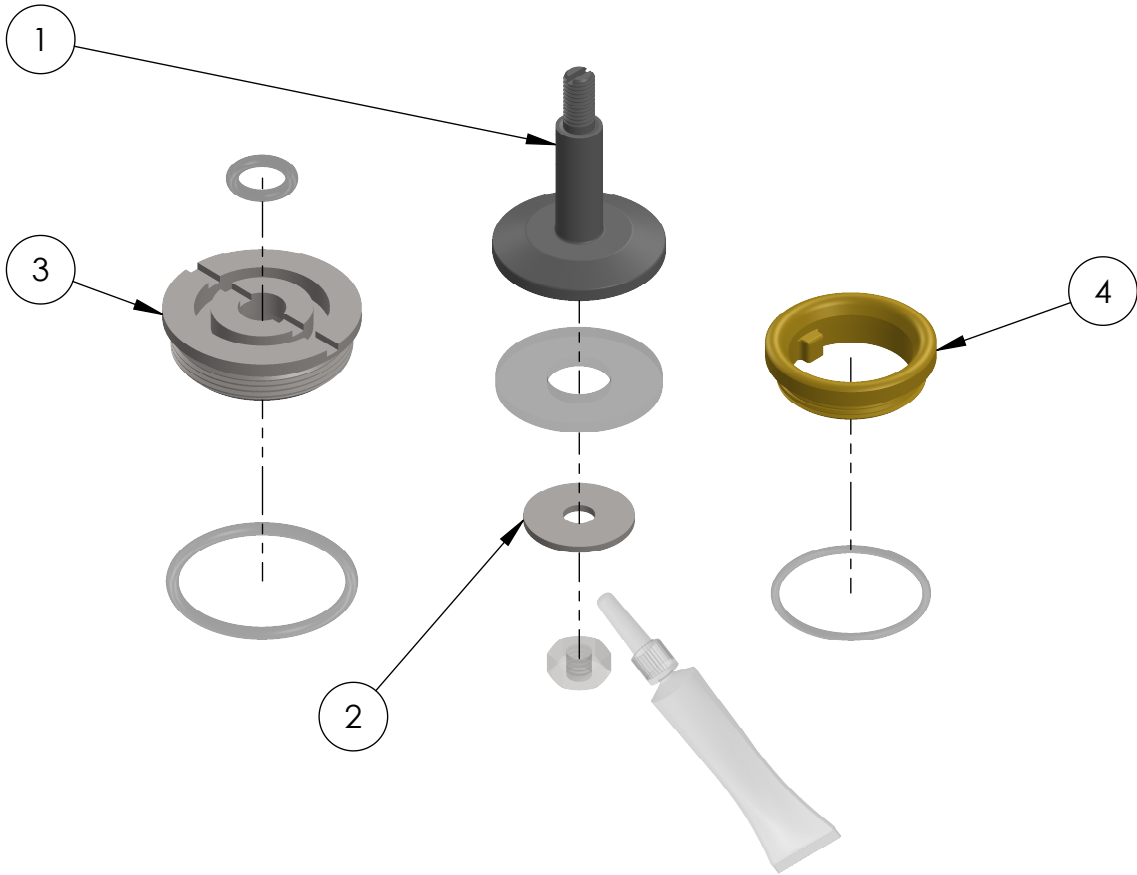
2

1

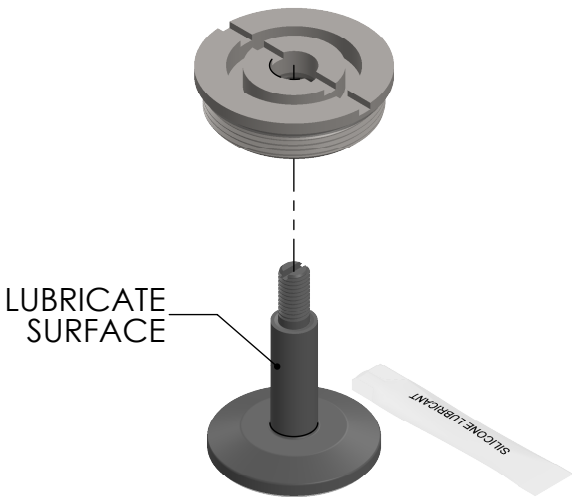
BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	4510231	421-L2	SHAFT ASMBLY,421,NO	1
2	1074149	421-KS	DISC PLATE	1
3	1074123	421-GGS	GUIDE,SHAFT,421,SS,MCHD	1
4	1074158	421-MO	SEAT,421,BRASS,MCHD	1
5	43942	424-H	DIAPHRAGM PLATE	2

1263388 INTERNAL PARTS KIT ASSEMBLY INSTRUCTION

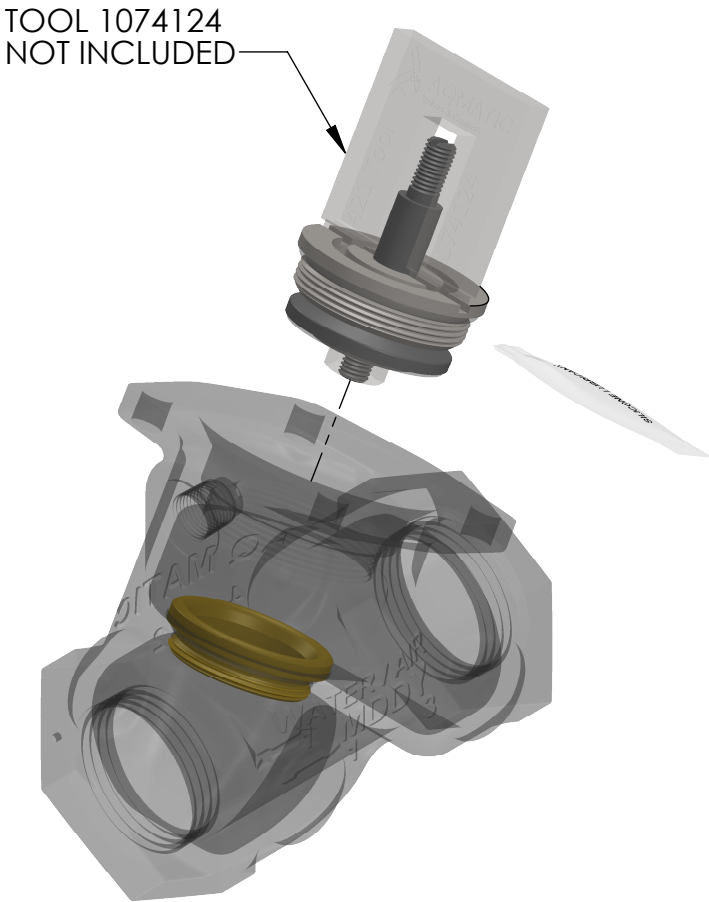
REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2392	A	INITIAL RELEASE	5/16/2024	PMJ



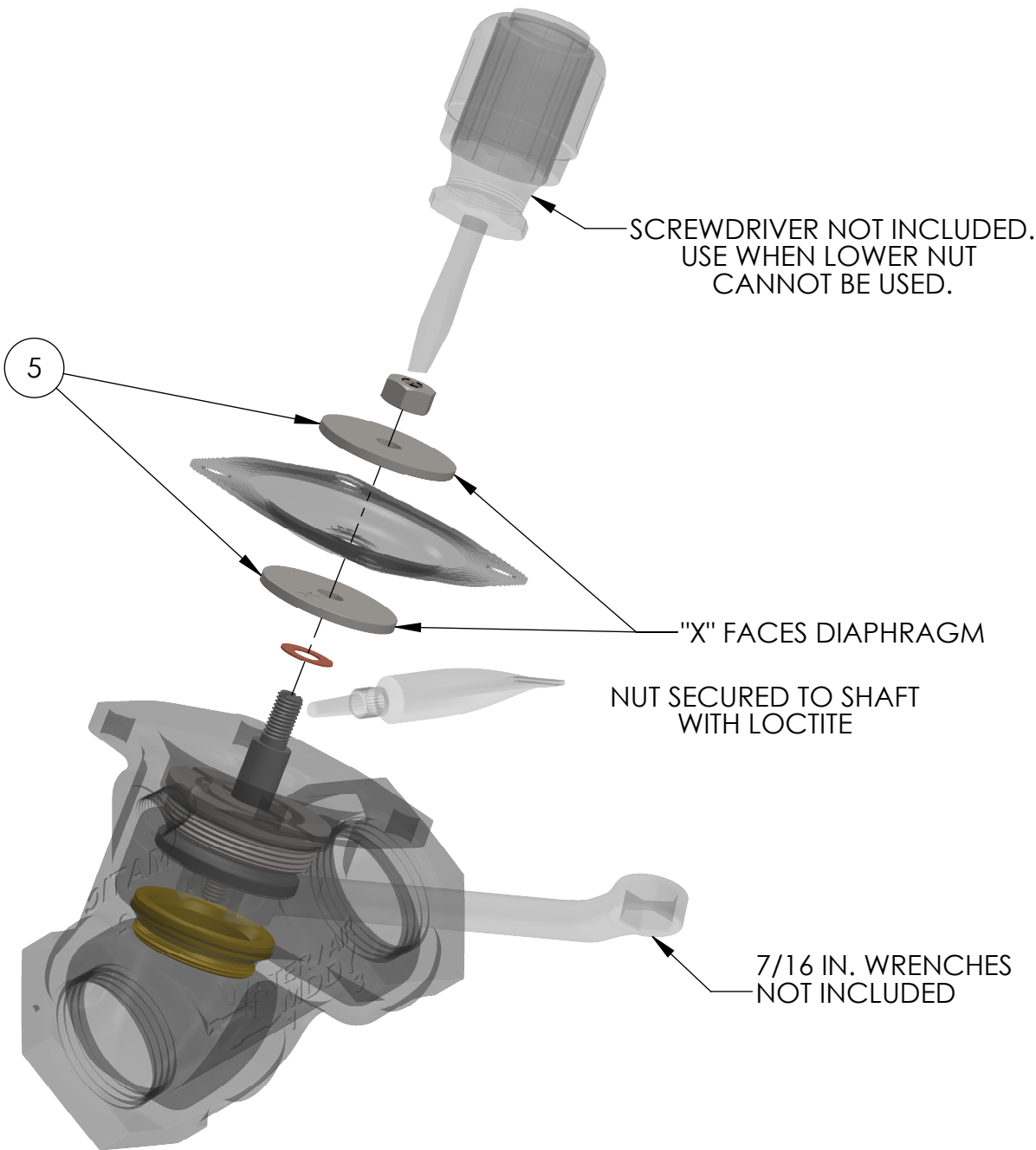
STEP 2



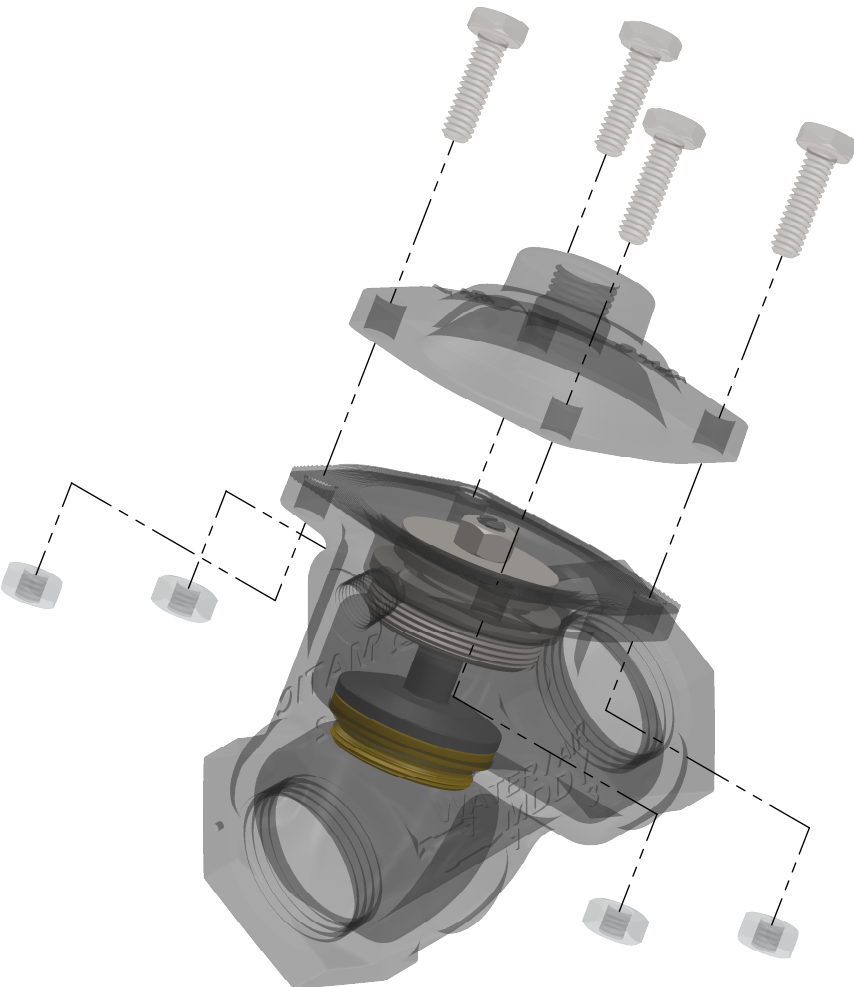
STEP 3



STEP 4



STEP 5



- NOTES:
- ALL O-RINGS MUST BE INSTALLED WITH 42561 SILICONE LUBRICANT.
 - ACTUAL TORQUE MAY BE WITHIN 10% OF NOMINAL VALUE IN TABLE.

TORQUE TABLE	
PART	TORQUE
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,421,INT,NO PLUS SEAT, CSTM

DWG NO.	1263388	REV.	A	
SIZE	C	SCALE	2:3	SHEET 1 OF 1