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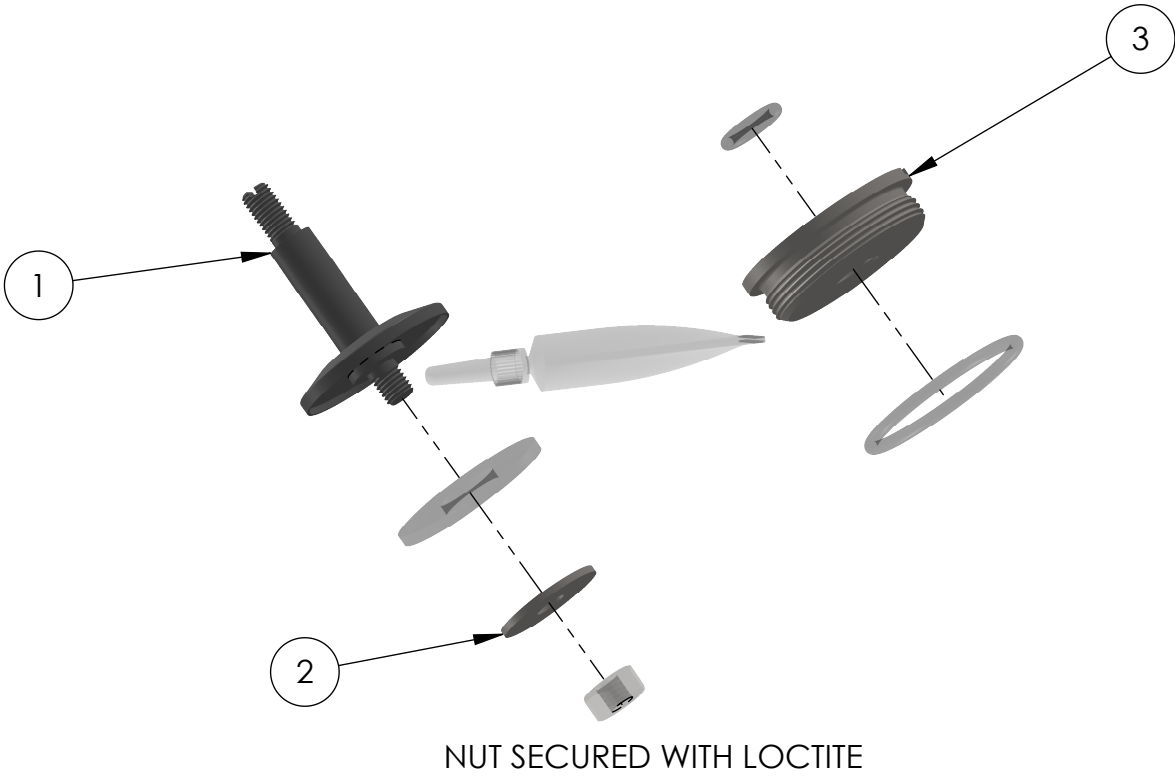
1

BILL OF MATERIALS				
ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	4510232	421-LL2	SHAFT ASMBLY,421,NC	1
2	1074149	421-KS	DISC PLATE	1
3	1074123	421-GGS	GUIDE,SHAFT,421,SS,MCHD	1
4	43942	424-H	DIAPHRAGM PLATE	2
5	1074185	421-X	CENTERING NUT	1
6	1071674	ORB-020	O-RING,-020,BUNA	1
7	1078602	421-SS	SPRING,316SS	1

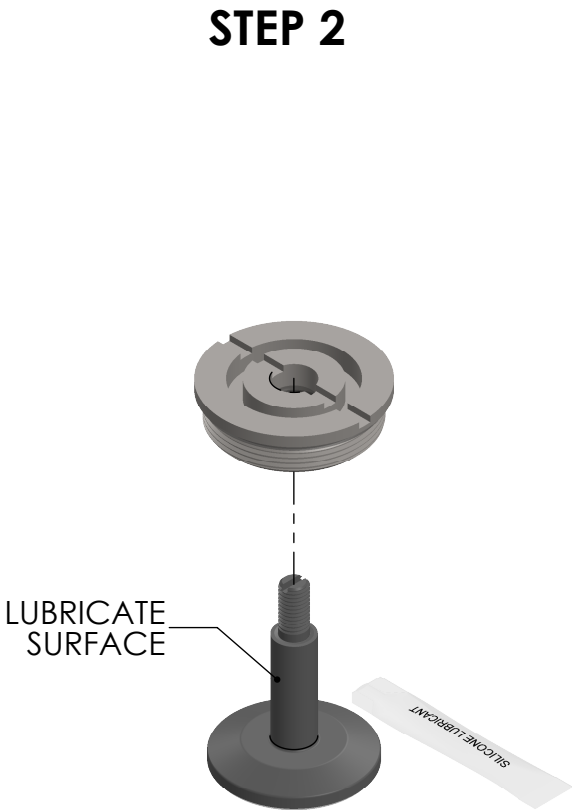
4500676 INTERNAL PARTS KIT ASSEMBLY INSTRUCTION
MODEL NO. 421-SC/421-RG (CSTM)

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

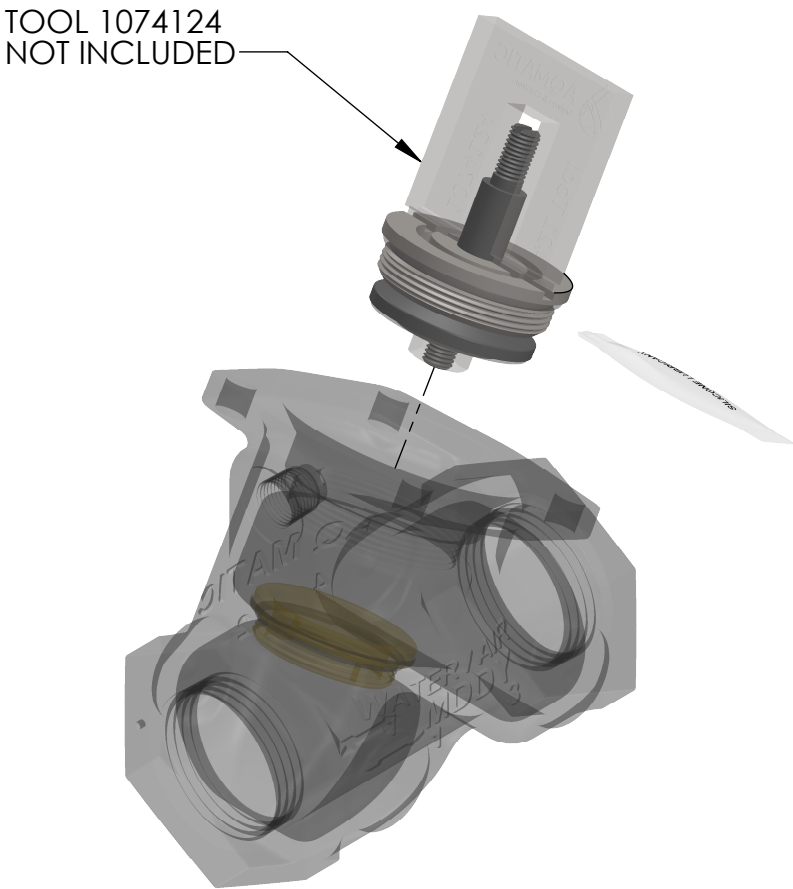
STEP 1



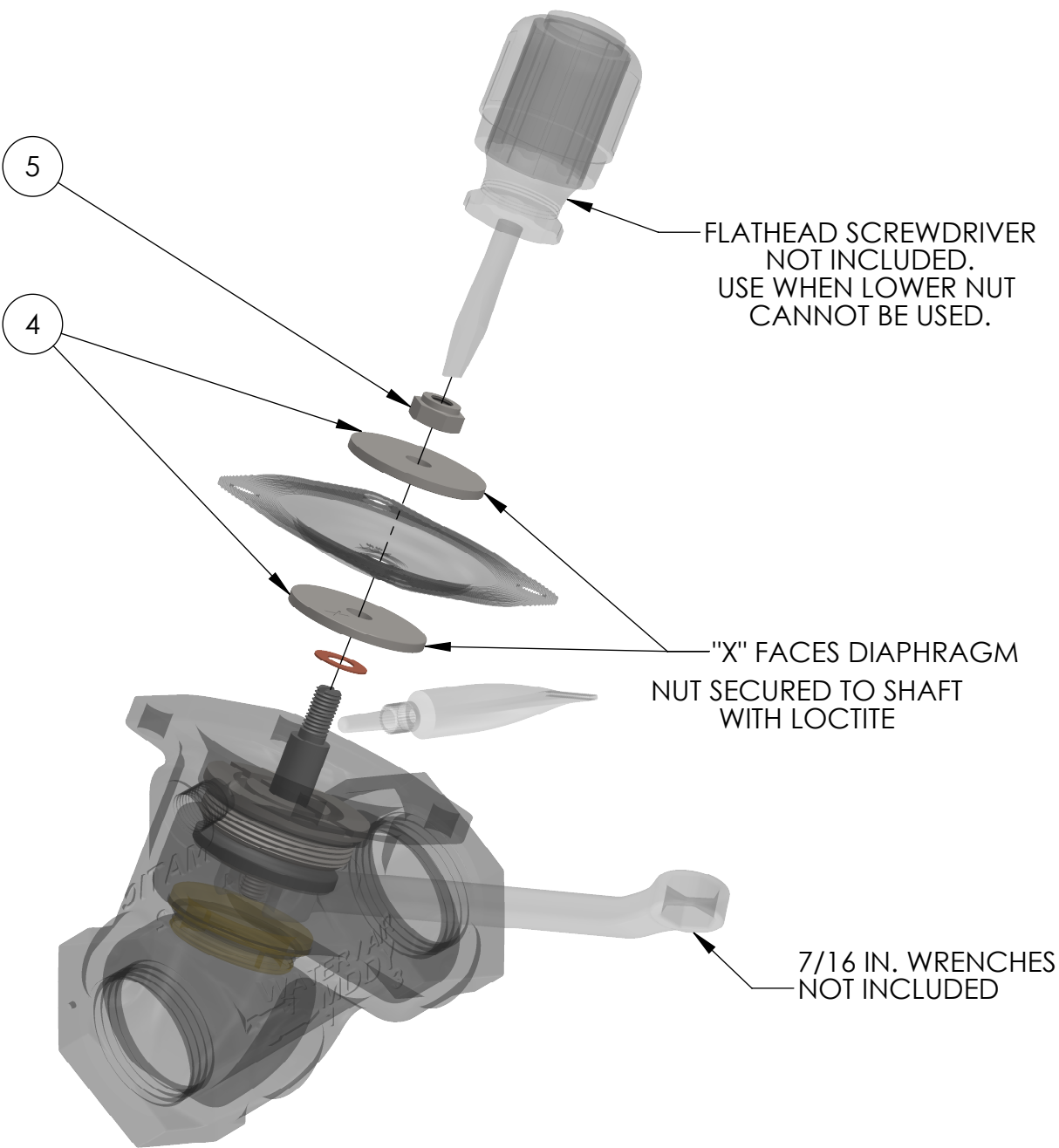
STEP 2



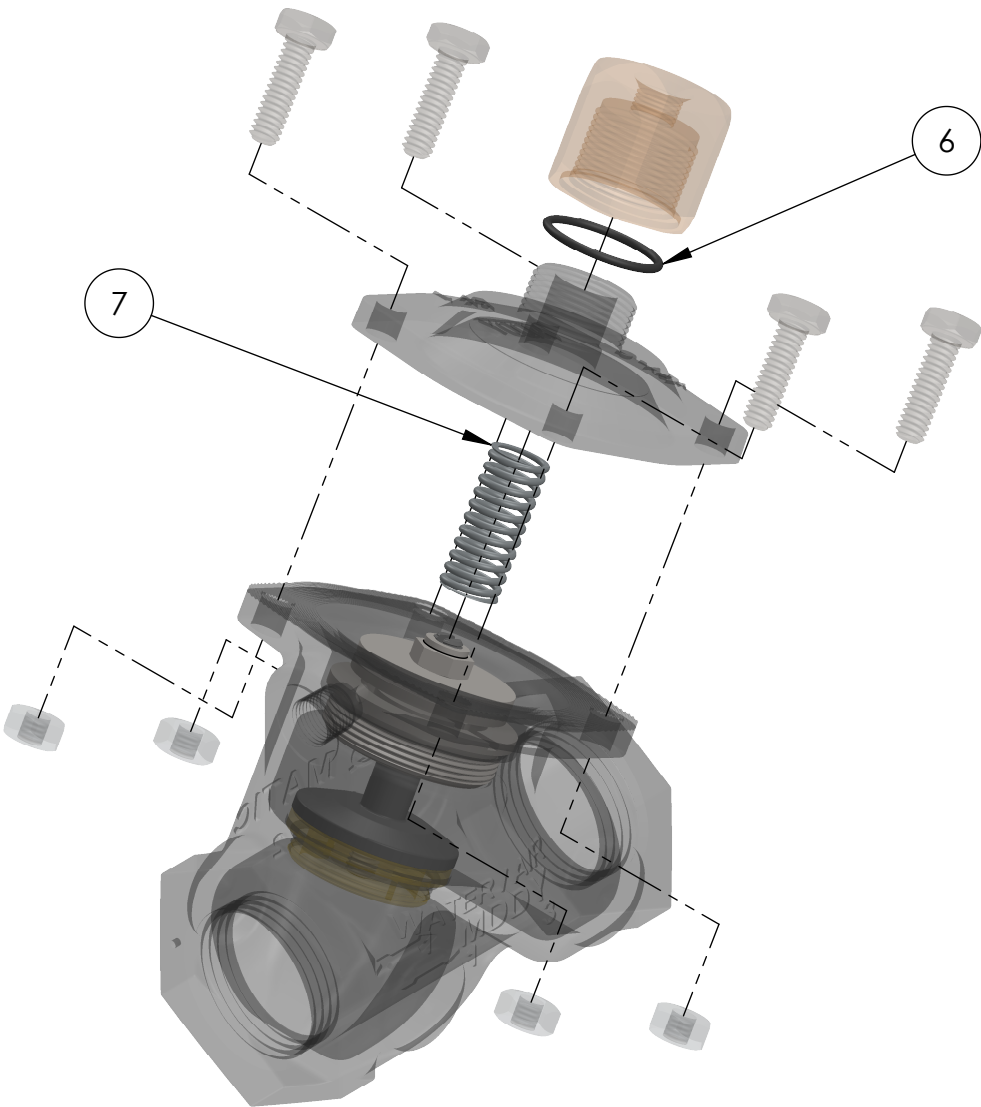
STEP 3



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.
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,INT,NC/SC	
DWG NO. 4500676	REV. A
SIZE C	SCALE 2:3 SHEET 1 OF 1

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