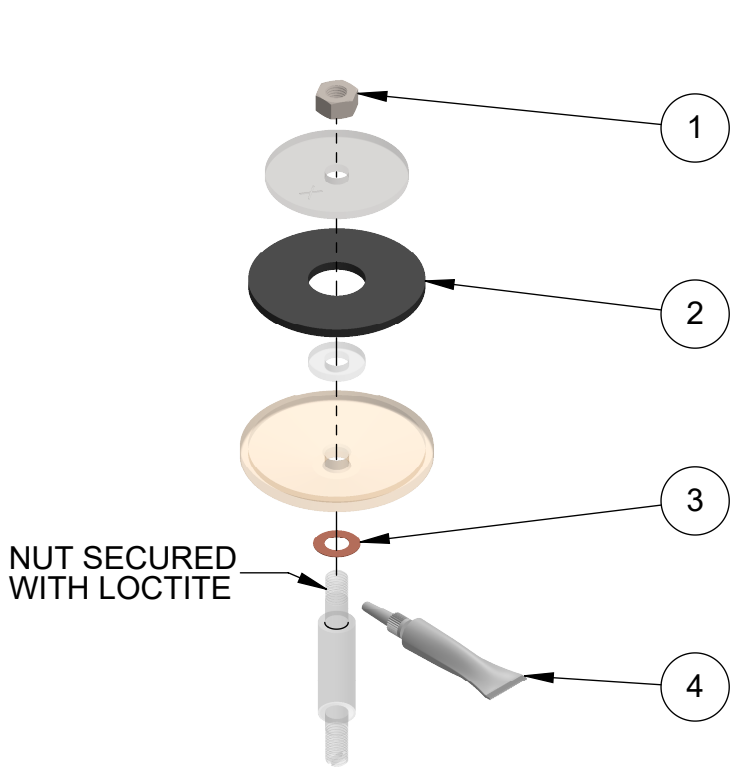


ITEM NO.	PART NO.	MODEL	DESCRIPTION	QTY.
1	1263853	RMET	HEX NUT 5/16" - 24	2
2	1074312	425-JV	DISC, 425, FKM	1
3	1074252	424-R	COPPER GASKET	2
4	1262436	-	LOCTITE 565 POLYTUBE	1
5	1071794	ORV-035	O-RING, -035,FKM	1
6	1071795	ORV-038	O-RING,-038,FKM	1
7	1239008	ORV-206TC-75	O-RING,FKM,ORV-206,TEF COATED	2
8	42561	-	LUBRICANT,SILICONE,PACKET	1
9	1074296	425-FB	DIAPHRAGM,425,BUNA	1

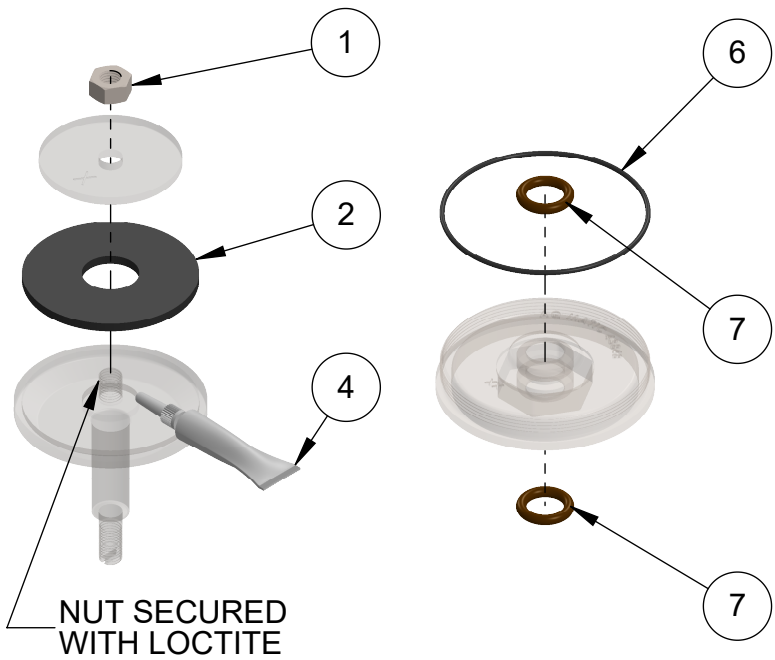
4510892 SEAL AND DIAPHRAGM KIT
ASSEMBLY INSTRUCTION
MODEL NO. 425-RAVFB

REVISIONS				
ECN	REV	DESCRIPTION	DATE	APPROVED
2434	A	INITIAL RELEASE	10/18/2024	PMJ

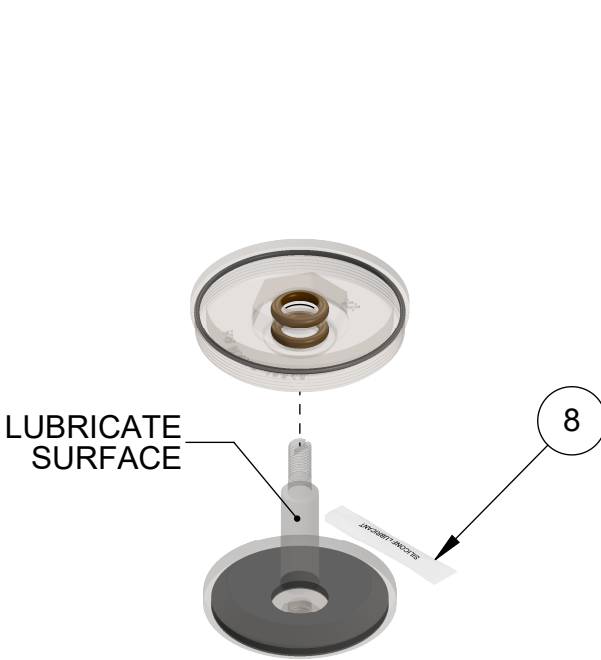
LEGACY TWO PIECE SHAFT



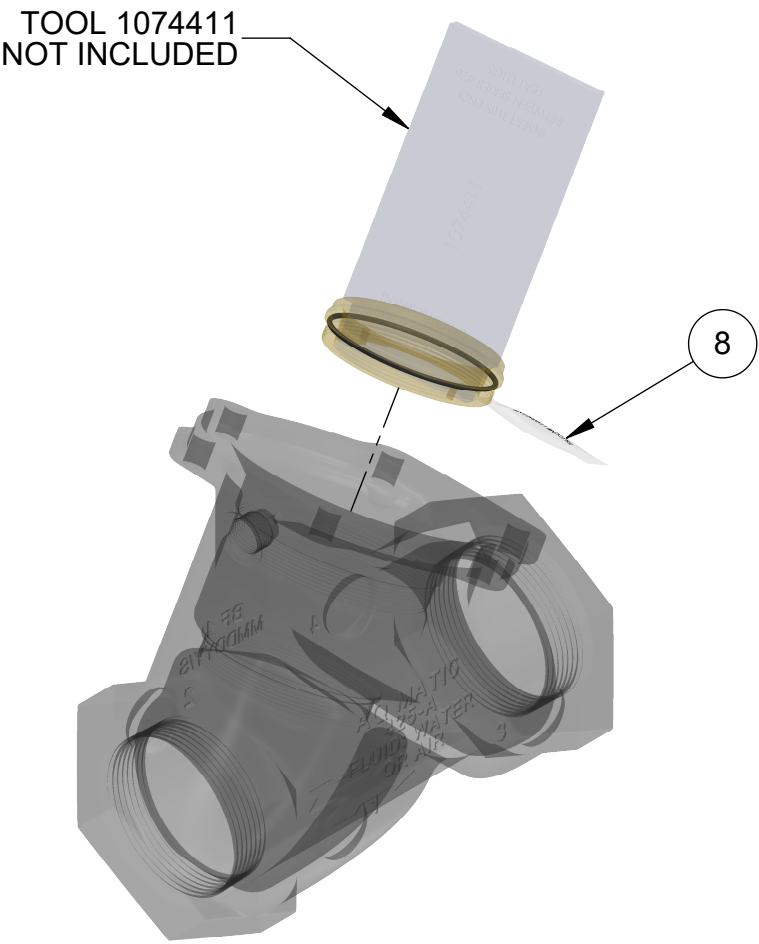
STEP 1
(WITH ONE PIECE SHAFT)



STEP 2

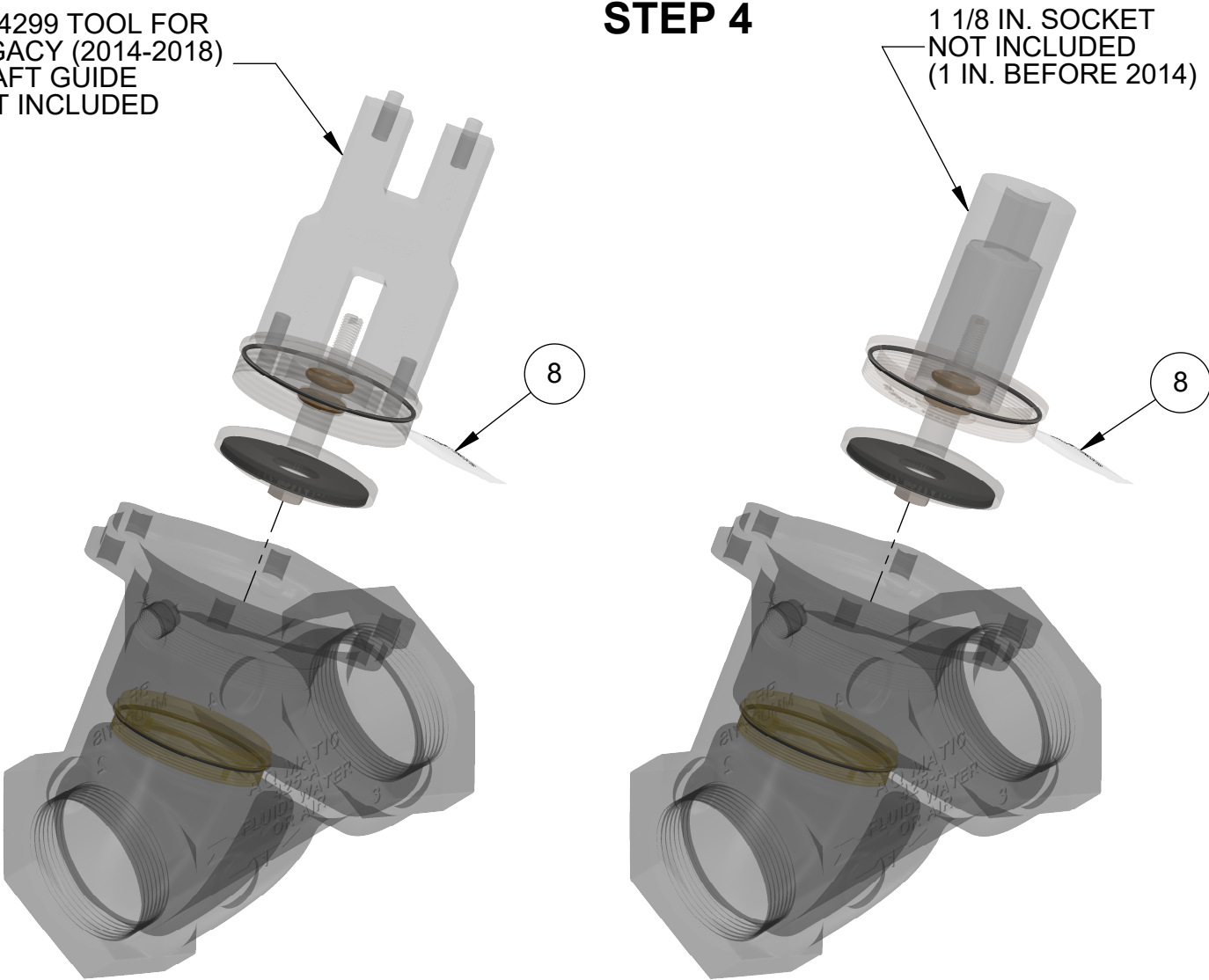


STEP 3
(NOT NEEDED FOR MOST REPAIRS)

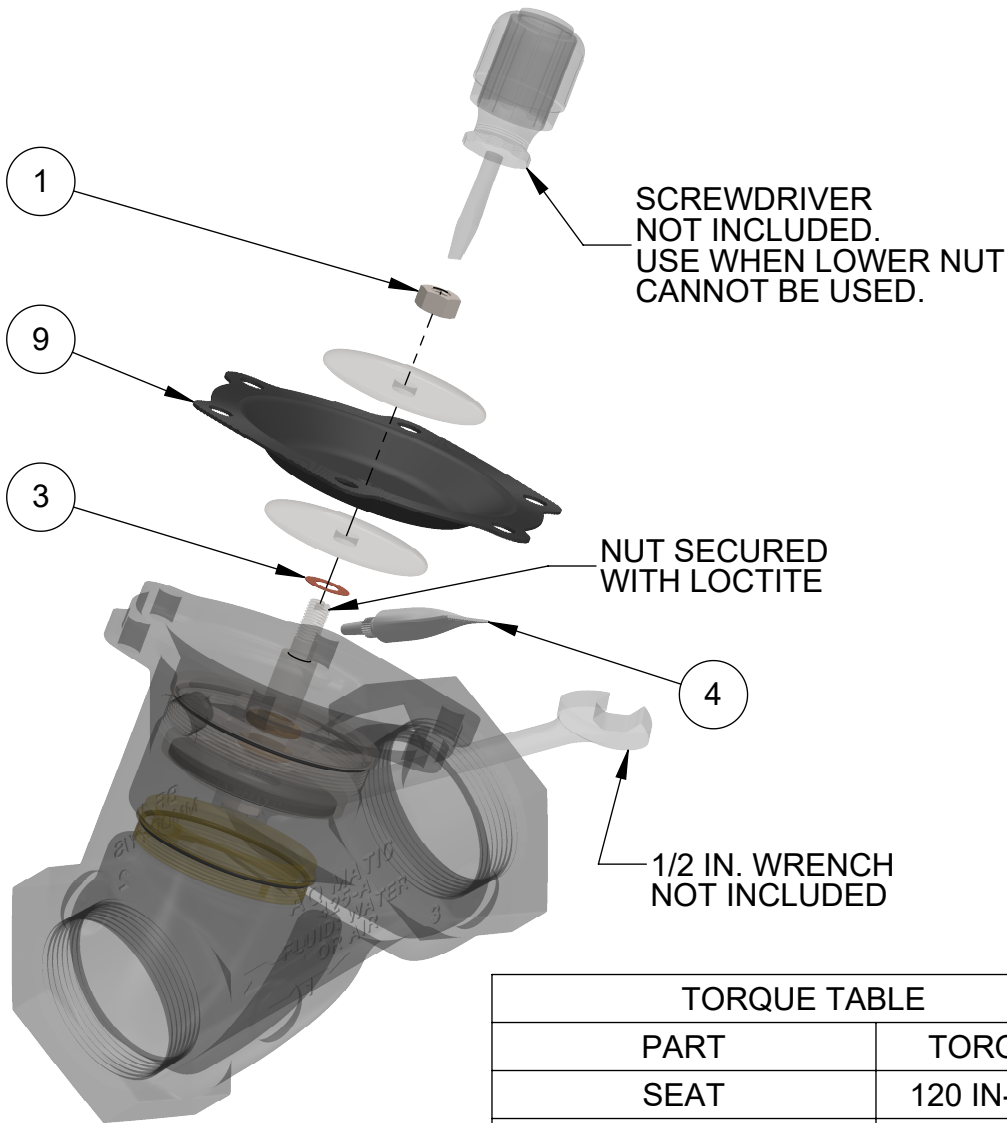


1074299 TOOL FOR
LEGACY (2014-2018)
SHAFT GUIDE
NOT INCLUDED

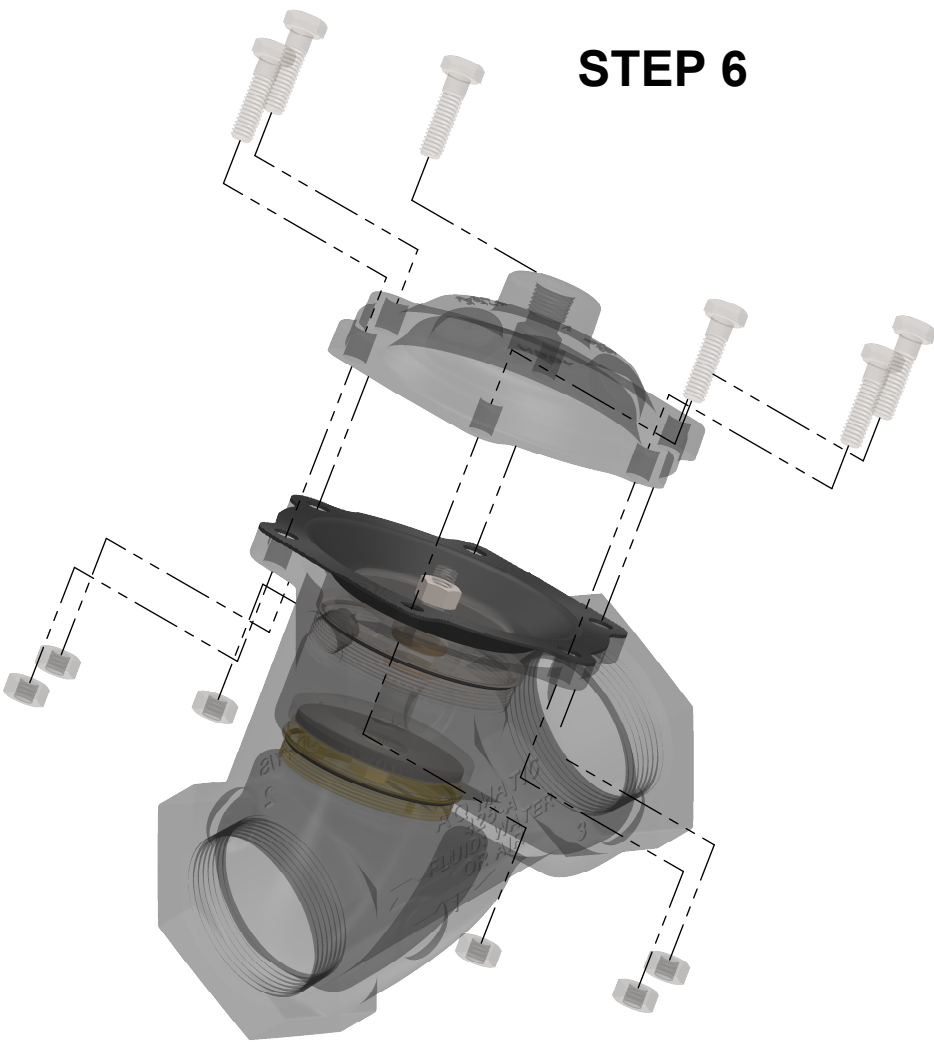
STEP 4



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.

TORQUE TABLE	
PART	TORQUE
SEAT	120 IN-LBS.
UPPER SHAFT NUT	140 IN-LBS.
LOWER SHAFT NUT	140 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]

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2015/863 AND EU REACH REGULATION (EC) 1907/2006.

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THIRD ANGLE
PROJECTION

 **AQMATIC**
Valves & Controls

DESCRIPTION
KIT,425,D&S,BUNA

DWG NO.	4510892	REV.	A
SIZE	C	SCALE	2:5
		SHEET 1 OF 1	