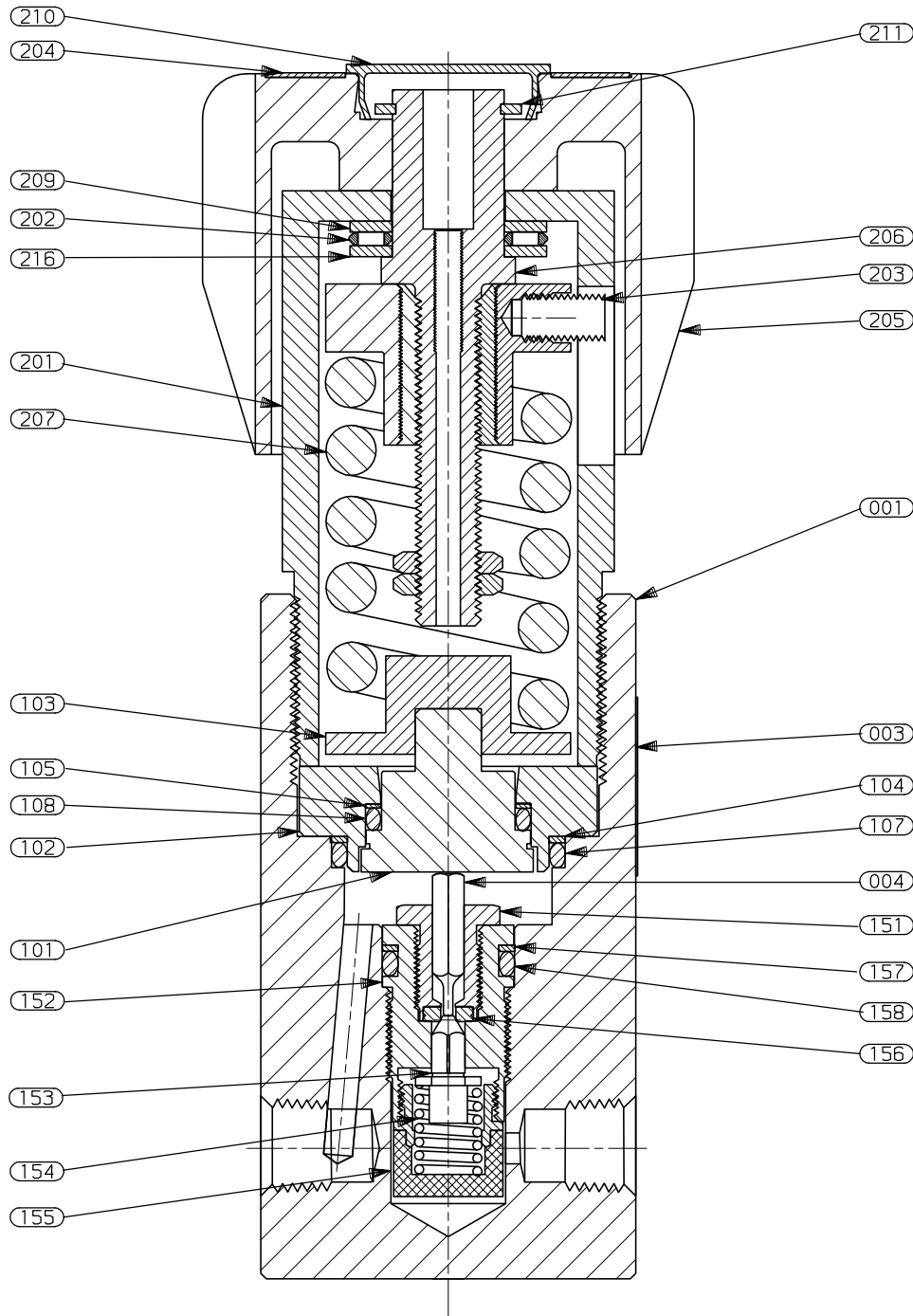




1. APPLY LUBRICANT (P/N 9575) TO THE FOLLOWING.
 ALL O-RING SURFACES
 FIND NO'S: 201, 152, 151, 155 - - - THREADED PORTIONS
 FIND NO'S: 202 - - - - - MOVING PORTION OF BEARING
2. VALVE SEAT (FIND NO. 156) SHALL BE INSTALLED WITH CHAMFER TOWARDS VALVE (FIND NO. 153).
3. TORQUE VALVES:
 FIND NO. 203 - - - 20-25 IN-LBS.
 FIND NO. 151 - - - 110-125 IN-LBS.
 FIND NO. 201 - - - 50 FT-LBS.
4. LABEL (FIND NO. 003) SHALL BE READ WHEN HANDKNOB IS IN UP POSITION.
5. (FIND NO. 105 AND 104) ARE NOT USED ON 44-11X1 THRU 44-11X3.

6. USE KRYTOX OIL (P/N 9308) FOR 44-11XX-XX-047 IN PLACE OF P/N 9575.

A4509-02: HAND OPERATED NON-VENTING

				TESCOM CORPORATION INDUSTRIAL CONTROLS DIVISION ELK RIVER, MN USA		MATERIAL:	
M 3-1-05 1114-05 DKD MKS L 5-5-04 1376-04 JK MKS K 2-2-00 732-00 SKO SJW J 2-15-99 568-99 JLS MKS H 11-11-98 995-98 JLS MKS G 8-17-94 772-94 JLS MKS F 4-16-94 416-94 KBK MKS				INFORMATION CONTAINED ON THIS DOCUMENT IS THE PROPERTY OF TESCOM CORPORATION. NO RIGHTS ARE CONVEYED NOR IS PERMISSION TO DISCLOSE TO OTHERS GIVEN. UNLESS OTHERWISE SPECIFIED: .0 ± .020 ANGLES: ±1° .00 ± .010 .000 ± .005 SURFACE ROUGHNESS: 100/ CORNER & FILLET RADI: .005-.020 THREADS: CLASS 2 REMOVE ALL BURRS MFG. SPEC. 00301		FINISH:	
REV. DATE ECO NO. BY: APPR.				DRAWN BY: KBK 4-18-94 CHECKED BY: MKS 4-27-94 APPROVED BY: MKS 4-27-94		NAME	
REVISIONS REFERENCE DRAWING(S)				DRAWING MADE IN THIRD ANGLE PROJECTION (DO NOT SCALE DRAWING)		ASSEMBLY, INFO SCALE: 2:1 SIZE C CODE NO. 13669	
						NUMBER A4509-02 SHT. 1 OF 1	