

## **Overhaul Procedure:**

### **PREPARATION AND INITIAL INSPECTION:**

- Always open Service Manual to proper page for easy reference
- Visually inspect the regulator exterior for damage and/or corrosion.
- Remove hose protector(s) if present, to visually inspect the hose and fittings.
- Check the main body carefully for cracks in the plastic
- Closely examine the finish on the hose fittings and the first stage body. Be sure to check for flaking or chipping chrome.

### **DISASSEMBLY**

- Remove the Yoke (01) by removing the Dust Cap (03), Yoke Retainer (07) and O-Ring (08).
- Remove Filter Retainer (04), Filter (05), O-Ring (08).
- Remove Piston Cap (16), and accordingly the HP Spring (11), HP Seat (12), O-Ring (13), Piston (14), O-Ring (15), Spacing Shim (19) and HP Seat (12).
- Remove all remaining parts LP Plug (19), O-Ring (20), HP Plugs (15), O-Ring (16).

### **CLEANING**

- Wash all metal parts using an approved regulator cleaning solution. For the best results use an ultrasonic cleaner to ensure the removal of all debris and corrosion
- Wash all plastic and/or rubber parts with a solution of warm water and mild detergent

- Rinse all cleaning solution in the prescribed manner and then rinse thoroughly with clean fresh water. Allow all parts to dry thoroughly
- Inspect carefully all parts for damage from misuse and/or corrosion. If parts are damaged they must be replaced even if the parts are not included on the Overhaul Kit
- Have the Overhaul Kit ready in order to begin assembly

**ASSEMBLY**

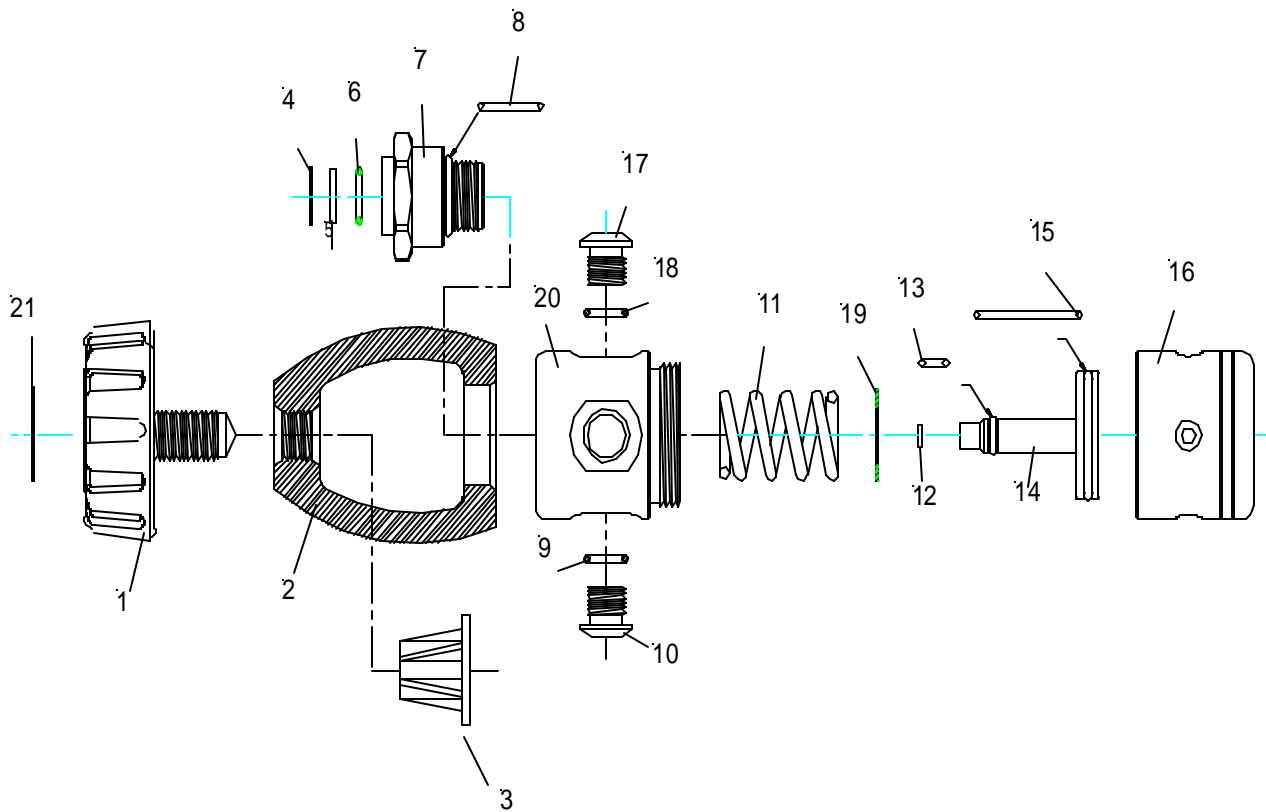
- Begin by checking that all parts are included in the Overhaul Kit

99-204000	Atlas First Stage Overhaul Kit	
Part #	Description	Drawing #
99-023105	Filter	5
99-023106	O-Ring	6
99-023108	O-Ring	8
99-023016	O-Ring HP Plug	9
99-023112	HP Seat	12
99-023113	O-Ring	13
99-023115	O-Ring	15
99-023020	O-Ring LP Plug	18

- Assemble all lightly lubricated O-Rings on to the regulator parts as per the drawing (following)
- Insert the new HP Seat (12) into the Piston (14).
- Insert Piston (14) through Spacing Shim (19), HP Spring (11) and into the Regulator Body (20).
- Install the Piston Cap (16) screwing firmly in a clockwise direction on to the Regulator Body (20).
- Install the Yoke Retainer (07) through the Yoke (01) and tighten firmly.
- Install all remaining port plugs, hoses dust caps etc.

**ADJUSTMENT**

- No adjustment is necessary on this Piston First Stage as long as intermediate pressure is steady and within specification of 130-145 psi
- Any out of specification variance on the intermediate pressure will most likely be caused by an improperly seated HP Seat, the seat surface on the Regulator Body or a bad HP Spring. Replace these parts to gain a steady and within spec intermediate pressure.



<u>Part #</u>	<u>Description</u>	<u>Drawing #</u>	<u>Part #</u>	<u>Description</u>	<u>Drawing #</u>
99-023101	Yoke	1	99-023112	HP Seat	12
99-023001	Yoke Screw	2	99-023113	O-Ring	13
99-023003	Dust Cap	3	99-023114	Piston	14
99-023104	Filter Retainer	4	99-023115	O-Ring	15
99-023105	Filter	5	99-023116	Piston Cap	16
99-023106	O-Ring	6	99-023019	LP Plug	17
99-023107	Yoke Retainer	7	99-023020	O-Ring LP Plug	18
99-023108	O-Ring	8	99-023119	Spacing Shim	19
99-023016	O-Ring HP Plug	9	99-023120	Regulator Body	20
99-023015	HP Plug	10	99-023121	Decal	21
99-023111	HP Spring	11			