



Kirby Morgan Dive Systems, Inc.[®]

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Part #525-395 Conversion Kit, REX Regulator for 37SS

Part #	Description	Qty
320-040	Regulator Mount Washer	1
505-278	Regulator Assembly, REX	1
510-403	Gasket, Pod	1
510-741	Valve, Waterdump	1
510-743	Oral Nasal Mask	1
530-145	Lock Nut	8
550-372	Regulator Mount Nut, Black Chrome	1
555-173	KM 77 Bent Tube, Chromed w/O-rings	1
560-516	Regulator Mount pod REX	1

*See back page for *O-ring Identification*

O-rings should be lightly lubricated with food grade silicone Molykote[®] 111 or equivalent in accordance with the operations and maintenance manual. Christo-Lube[®] may also be used. At a minimum, all helmet or BandMask O-rings should be replaced at least once a year in accordance with the A2.1 checklist for the helmet or mask being inspected. During daily and monthly maintenance, disturbed O-rings and valves may be reused providing no damage or deformation is found. O-rings and valves may require replacement more often than yearly if the helmet or mask use is extreme, or if the helmet or mask is used in waters containing oil or chemical contamination. Daily cleaning and inspections as well as performing the monthly inspection (A2.2 checklist) will identify the need more accurately than simply placing a number of hours between overhaul. Store spare O-rings, valves and soft goods in a cool, dark, dry place. Avoid prolonged exposure to temperatures above 90 degrees Fahrenheit and/or exposure to ultra violet rays. Do not lubricate exhaust valves. Lubricating valves can cause dirt to stick, allowing leakage.

CAUTION

Use only KMDSI original replacement parts. The use of other manufacturers' parts will interfere with the performance characteristics of your life support equipment and may jeopardize your safety. Additionally, any substitutions will void any warranties offered by KMDSI. When ordering spares, always insist on Kirby Morgan Genuine Parts.

Required Tools:

3/8" socket with driver

Torque screwdriver with flat blade attachment

5/32 inch hex key

3/8 inch open end wrench

Medium Strength Loctite[®]

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- 1) See the *Stainless Steel Helmets with SuperFlow[®] 350 or 455 Balanced Regulators* module in your manual for pod removal, remove the pod/regulator assembly from the helmet shell. Remove the oral nasal mask, then remove and save the oral nasal valve body and valve to be used with the new oral nasal mask.



Remove the pod/regulator assembly from the helmet shell

- 2) Install the washer and regulator assembly into the helmet, threading the regulator mount nut as you feed the regulator assembly in, hand tight only.

- 3) Work around the edge of the whisker where it meets the helmet shell to align the rubber grooves at the back of the whisker, to the grooves on the pod.

- 4) Install the gasket on the pod. Make sure that the ridge on the gasket is properly seated in the groove in the pod.

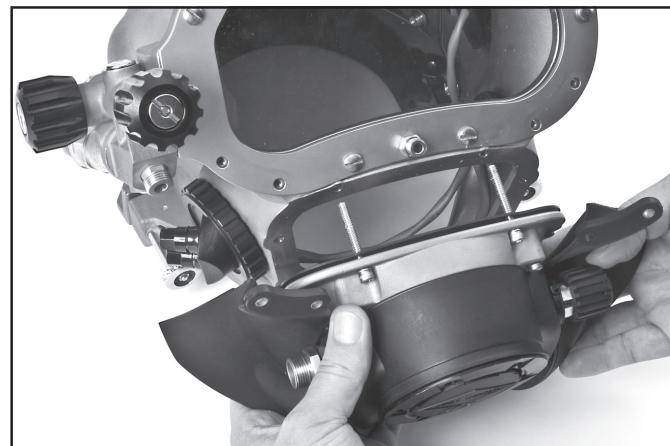
- 5) Install all of the allen screws and washers through the pod and gasket, with the exception of the bottom two. The screws will help to align the pod and gasket to the helmet.

Remember that the two long screws are installed in the top two holes of the pod, between the top of the regulator cover and the port retainer.



Note that there are eight screws that secure the pod to the helmet. Six screws are "short" while two are "long." The two longer screws are installed in the top two holes in the pod.

- 6) Install the new pod/regulator assembly onto the helmet shell.



Install the new pod/regulator assembly onto the helmet shell.

- 7) Install the remaining two bottom screws, washers and nuts. Run the nuts up until they are finger tight. The nuts are positioned on the outside of the pod on the two screws on the bottom, below the regulator

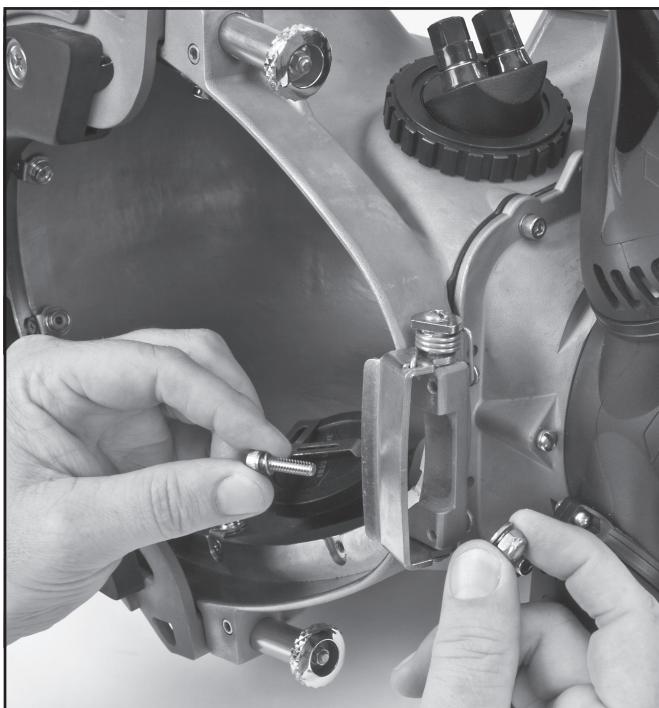


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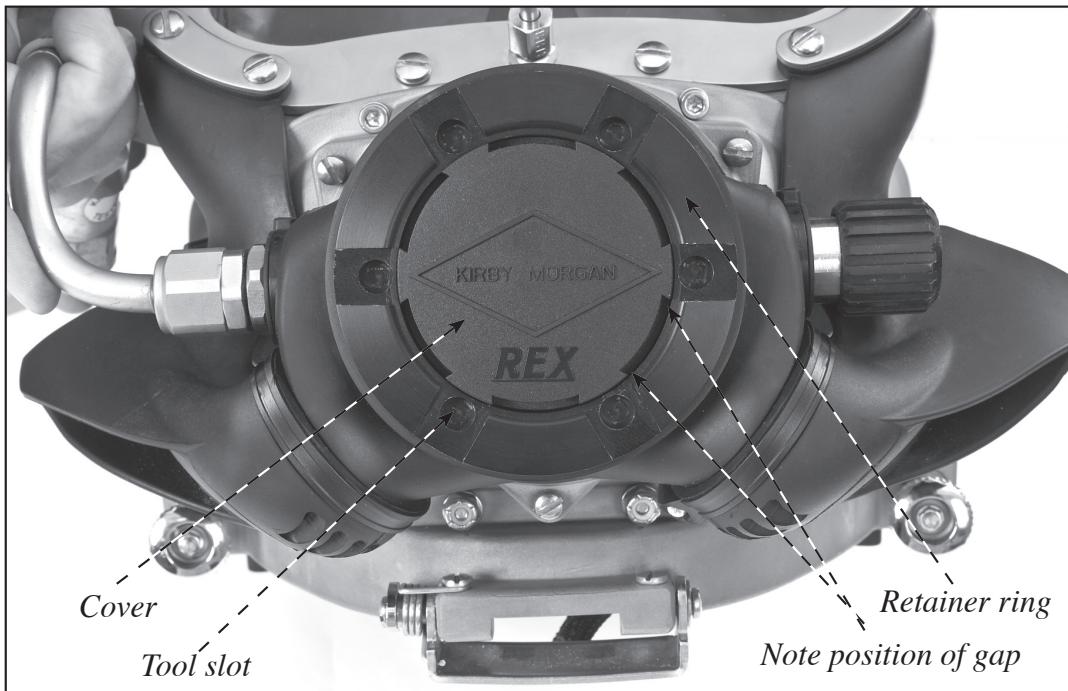
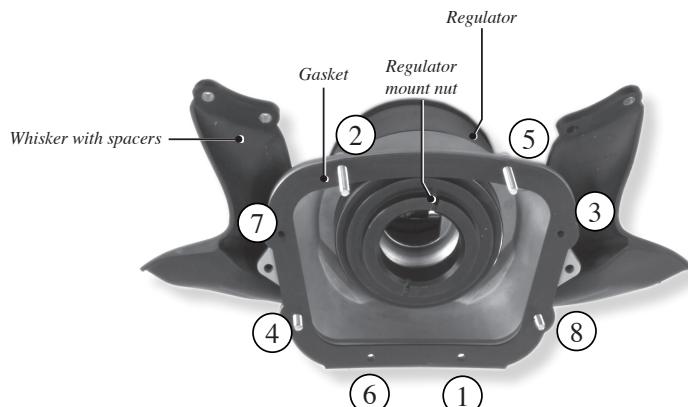
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The two nuts below the regulator are installed on the outside of the pod.

8) Tighten the screws onto the helmet. The numbers indicate the order in which the screws and nuts that retain the pod are tightened to connect the pod to the helmet. See figure 4. Tighten the screws gradually, moving from one to another. Do not overtighten. Carefully watch the gasket as you tighten the screws—tightening until the gasket barely begins to extrude from between the pod and helmet shell.



The REX[®] regulator must be properly assembled and installed to function correctly. Note the position of the regulator cover relative to the outer retaining ring. The gaps on the edge of regulator cover must be centered between the holes on the regulator retainer ring.

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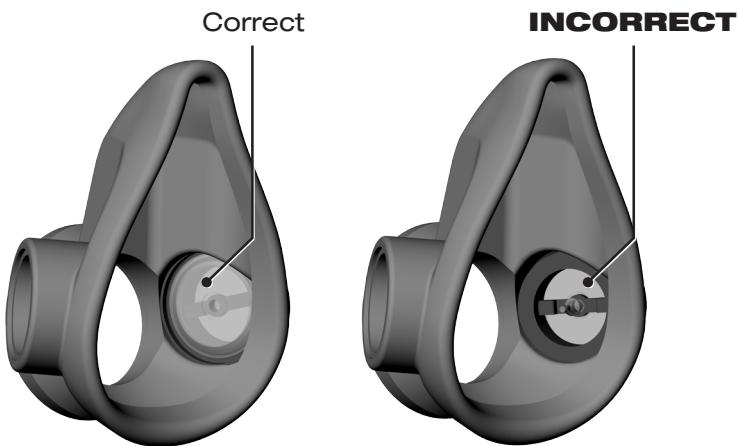
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Tighten the nuts in a staggered pattern.

9) The whisker should have a straight angled surface from the helmet shell towards the outer edge of the regulator. Realign if needed.

10) Install the oral nasal valve body and valve into the new oral nasal mask. Make certain the valve direction is correct.



11) Install the bent tube into the inlet nipple, 3 or 4 turns. If needed, turn the regulator assembly on the helmet to allow alignment of the bent tube to the side block.

12) Lightly lubricate the male threads on the side block and swing the bent tube up into place and torque the bent tube to the side block.

13) Apply medium strength Loctite[®] to whisker screws before installing. Install the whisker spacers, zinc anodes or kidney plates if present, and screws that secure the whiskers. Torque whisker screws to 15 in/lbs.



The whiskers are fastened to the face port using two screws on each side.



Only use a torque screwdriver to tighten the screws that secure the whiskers to the face port.