SCUBAPRO
Repair Guide
MK 2 Plus
First Stage

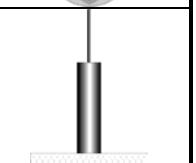
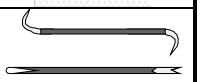
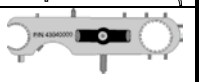
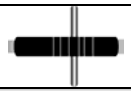
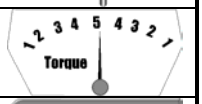
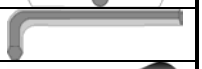
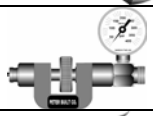


USE THIS GUIDE AS A REFERENCE WHEN SERVICING THE MK 2 Plus FIRST STAGE

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TOOLS NEEDED FOR REPAIR OF MK 2 PLUS FIRST STAGE

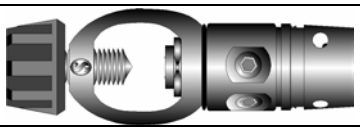
Quantity	Part Number	Description	
1		Ratchet	
1	20-155-500	1” Yoke Nut Socket (Peter Built)	
1	43.300.210 (Scubapro)	Standard piston first stage seat removal tool.	
1 set	10.102.100 (Peter Built)	Brass o’ring picks	
1 tube	41.047.000	Christo-Lube	
1	47.010.000	Counter Mat	
1	41.496.101	Lubricant syringe	
1	43.040.000 (Scubapro)	Universal Tool	
1	20-115-100 (Peter Built)	First Stage Handle	
1		Torque Wrench	
1		Hex Key Set	
1		Crescent wrench	
1	20.500.200 (Peter Built)	Pneumatic Adjusting tool	
1	18.300.500	Blow Gun/Air Nozzle	

ICON LEGEND

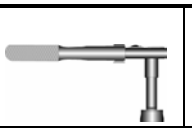
	Inspect carefully, replace if needed
	Lubricate properly
	Replace annually
	Dynamic o’ring, lubricate properly
	No tools needed for this step

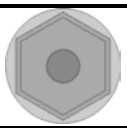
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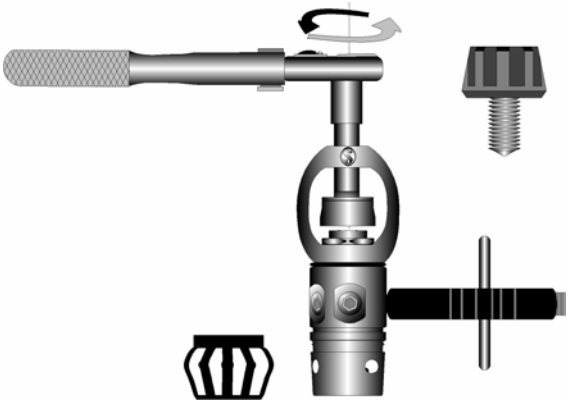


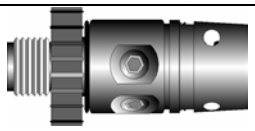
Remove all hoses.

Thread the first stage handle into the high-pressure port as shown.

Use the ratchet and yoke nut socket to remove the yoke nut from the first stage.

Remove the cap cover.









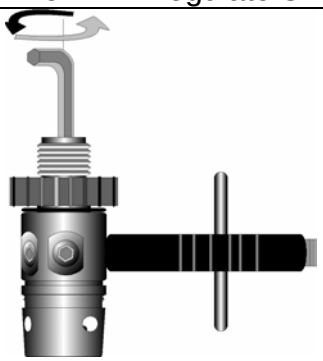
5/32”

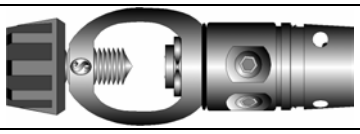
For DIN Regulators

Remove all hoses.

Thread the first stage handle into the high-pressure port as shown.

Loosen the filter retainer using a 5/32” hex wrench.



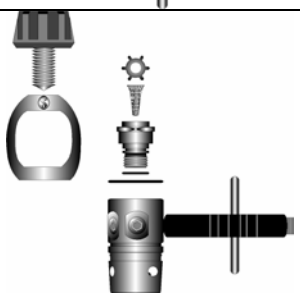




Remove the yoke nut and yoke from the first stage body.

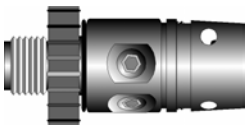
Loosen the star clip and remove the filter.

Remove the yoke nut o’ring.



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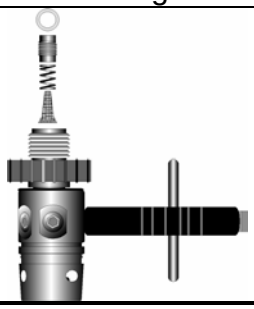
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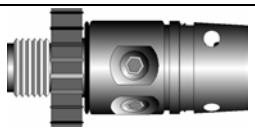


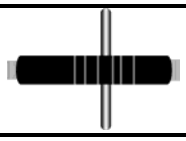


For DIN Regulators

Remove the filter retainer, spring, filter, DIN adapter and o'ring.





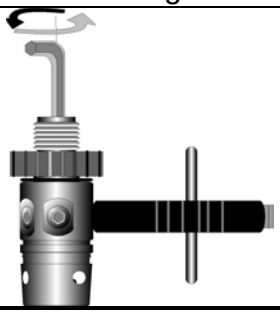


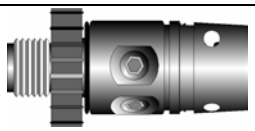


6mm

For DIN Regulators

Loosen the DIN fitting using a 6mm hex wrench.







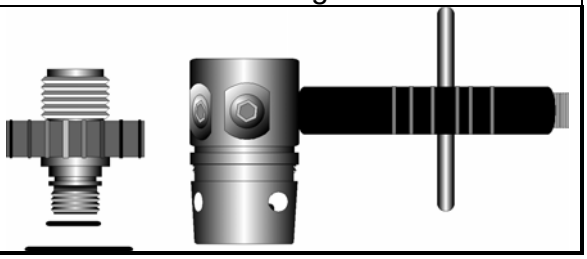


6mm

For DIN Regulators

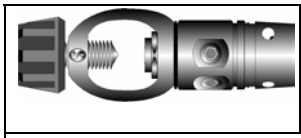
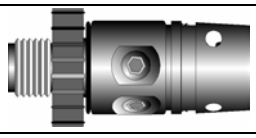
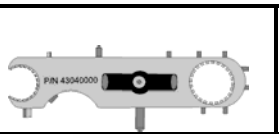
Remove the DIN fitting from the regulator body.

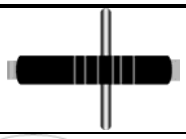
Remove the DIN fitting o'ring.



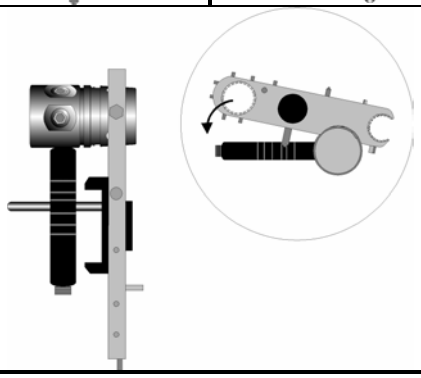
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Loosen the regulator cap from the regulator body using the universal tool and first stage handle.

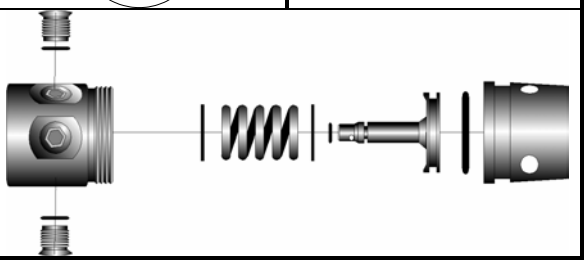






No tools needed this step

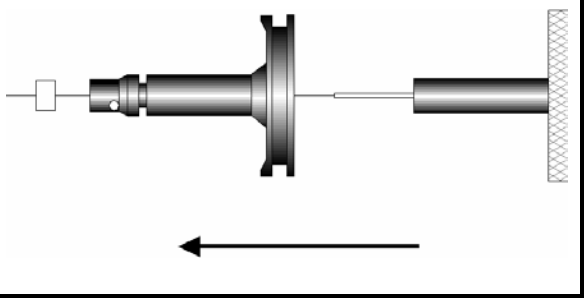
Separate the regulator body and cap. Carefully remove the piston assembly, spring and shims.





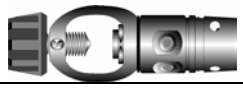
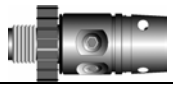
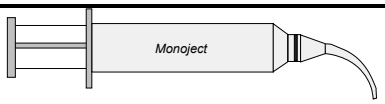


Remove the high-pressure seat from the piston using the seat removal tool.



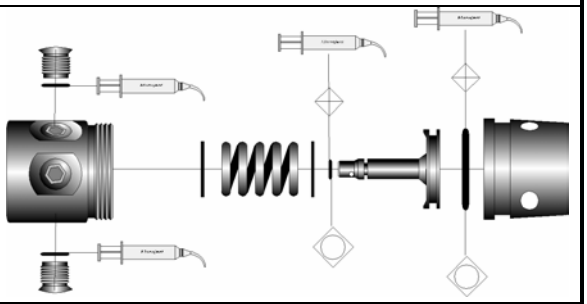
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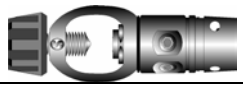
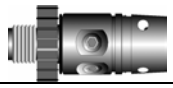
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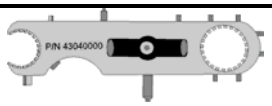




Replace the piston head and piston stem o'rings. Lubricate these o'rings to dynamic specification.

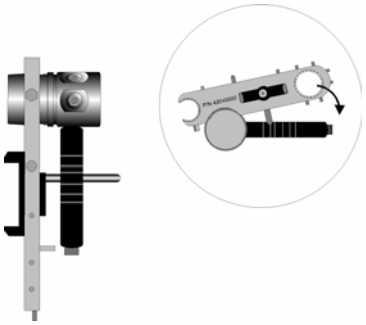
Insert the spring, seat assembly and shims into the regulator cap.

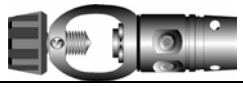




Use the universal tool and first stage handle to tighten the regulator cap to the regulator body.

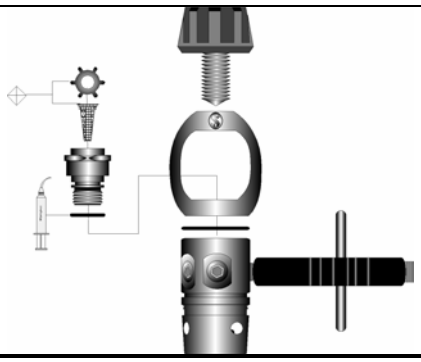






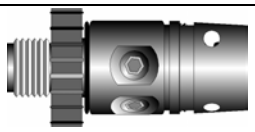
Replace the filter and star retainer. Lubricate the yoke nut o'ring.

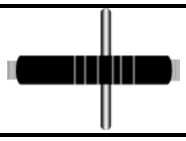
Reassemble the yoke to the regulator body.



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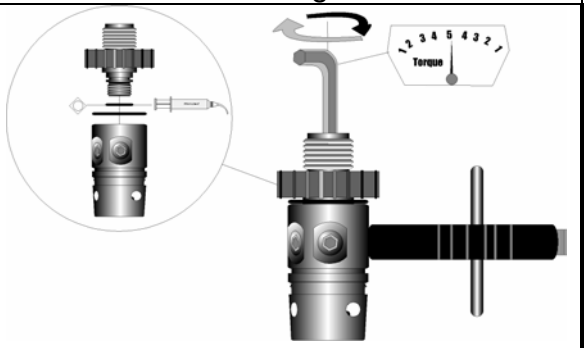


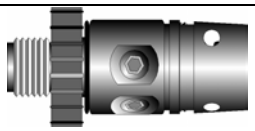
For DIN Regulators

Inspect and lubricate the DIN fitting-to-body o'ring.

Attach the DIN fitting to the regulator body.

Torque the DIN fitting to 266 in-lbs/30 N-m.







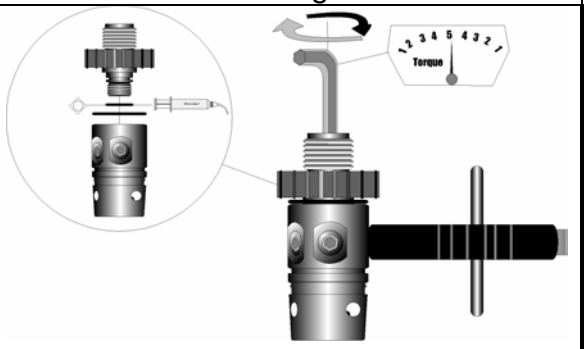


For DIN Regulators

Inspect and lubricate the DIN fitting-to-body o'ring.

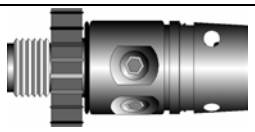
Attach the DIN fitting to the regulator body.

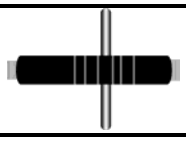
Torque the DIN fitting to 266 in-lbs/30 N-m.



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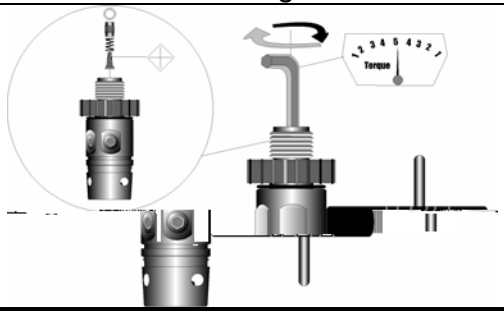




For DIN Regulators

Insert a new filter, the spring, the filter retainer, and o’ring.

Use a 5/32” hex wrench to tighten. Torque to 35 in-lbs/4 N-m.





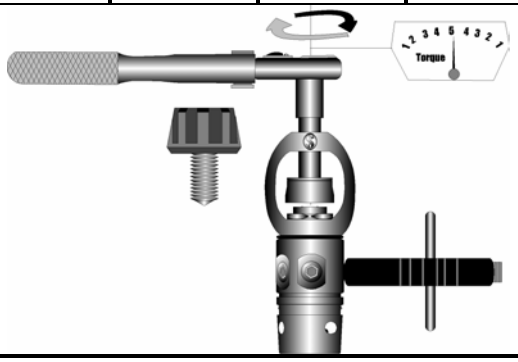






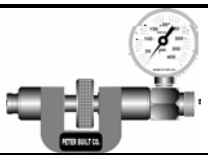
Tighten the yoke nut using the ratchet wrench and yoke nut socket.

Torque the yoke nut to 266 in-lbs/30 N-m.



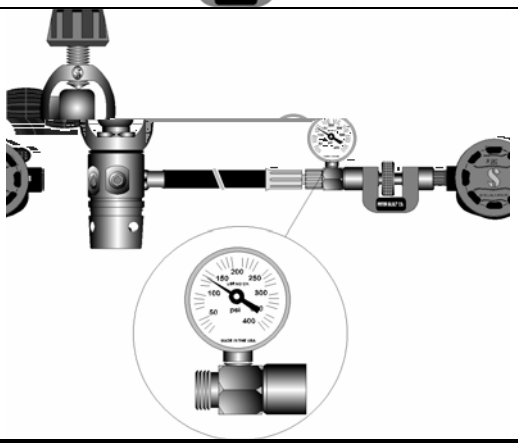






Check the intermediate pressure using the pneumatic adjusting tool.

Intermediate pressure should be 125psi – 145psi at 3000psi and 300psi supply pressure.



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Important note: The following information is not designed to be a complete training guide for servicing the listed SCUBAPRO regulators. All SCUBAPRO technicians are required to attend an annual service training program to insure safe handling and servicing of SCUBAPRO products. All SCUBAPRO technicians must be employed by an authorized SCUBAPRO facility.