

RG5400

Deco and Dry Suit First Stage

Service manual

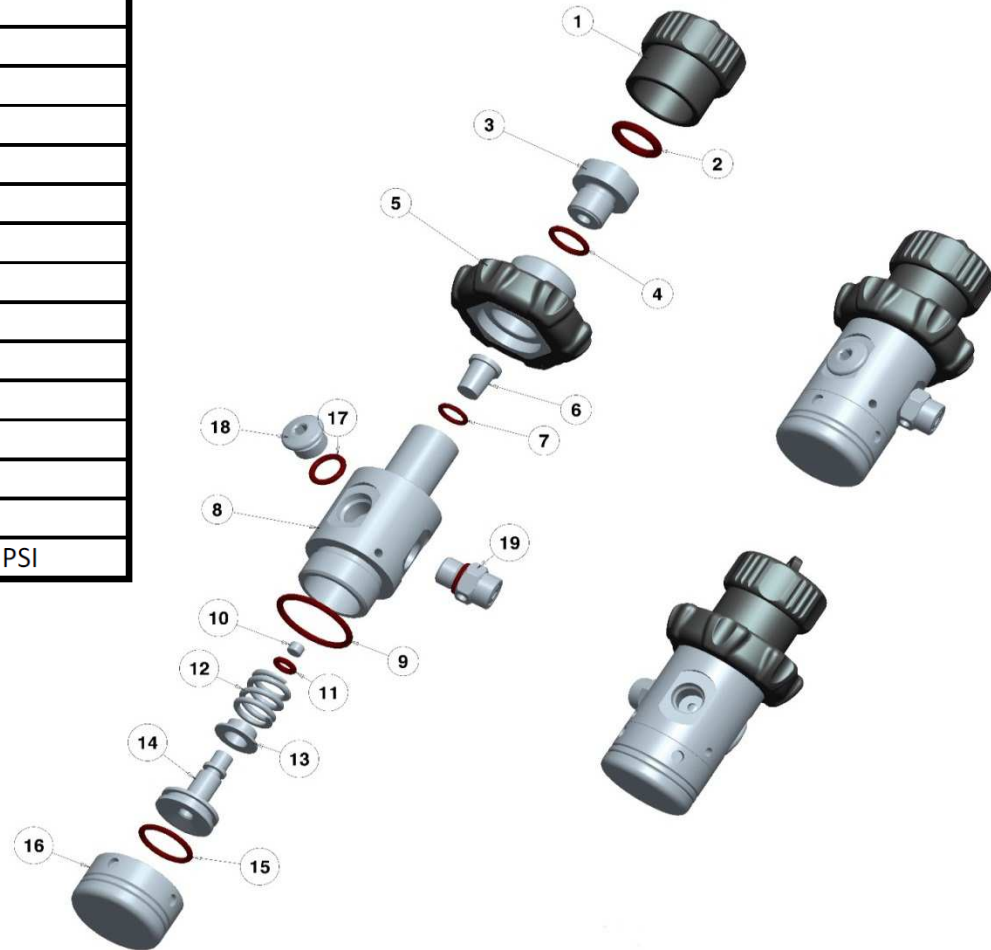


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Warning

- *This manual is only to be used as a guide for trained regulator technicians. Possession of this guide does not qualify any individual in the service of Dive Rite Breathing Systems. Only qualified Dive Rite dealers can service Dive Rite Products. Improper servicing can lead to serious injury or death.*
- **Only Original Parts ordered from Dive Rite are to be used.**

#	P/N	DESCRIPTION
1	RG1222	DUST CAP
2	RG1239	DIN O-RING
3	N/A	DIN LOCKDOWN SCREW
4	RG1236	DIN LOCKDOWN SCREW O-RING
5	N/A	DIN HANDWHEEL
6	RG1240	FILTER
7	RG1243	FILTER O-RING
8	N/A	MAIN BODY
9	1-23-20-03	CAP O-RING
10	0104	HP SEAT
11	2-008-03	PISTON STEM O-RING
12	N/A	SPRING
13	N/A	SPRING HOLDER
14	N/A	PISTON
15	RG1260	PISTON O-RING
16	N/A	END CAP
17	RG1231	HP PORT O-RING
18	RG1246	HP PORT PLUG
19	RG1310-140	OVERPRESSURE VALVE - 140 PSI

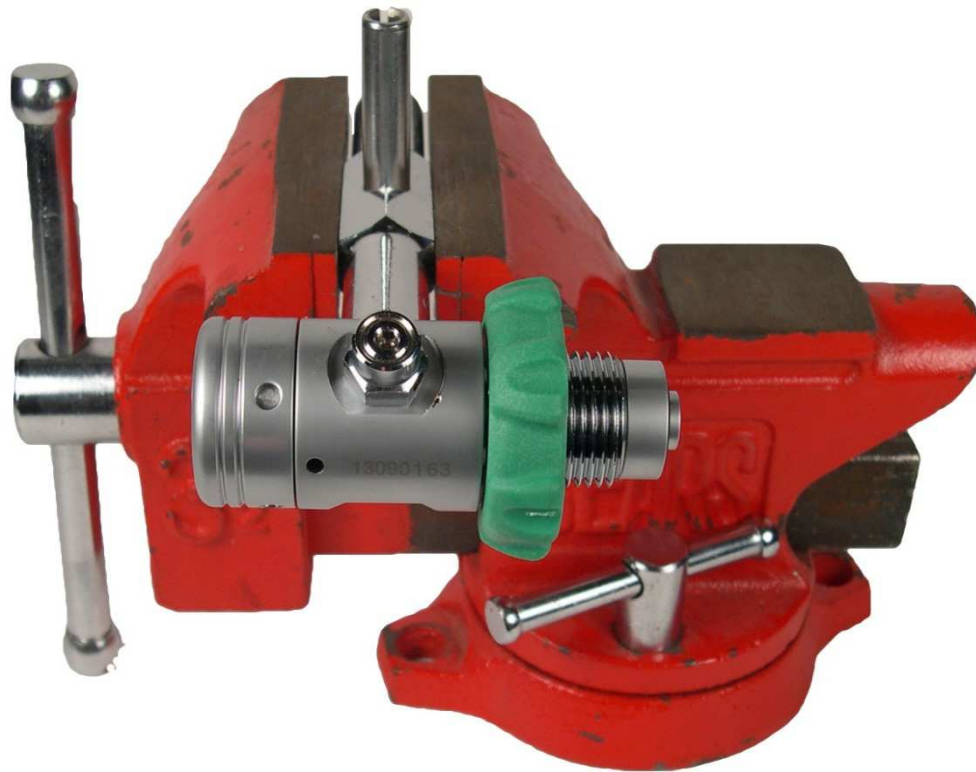


Disassembly

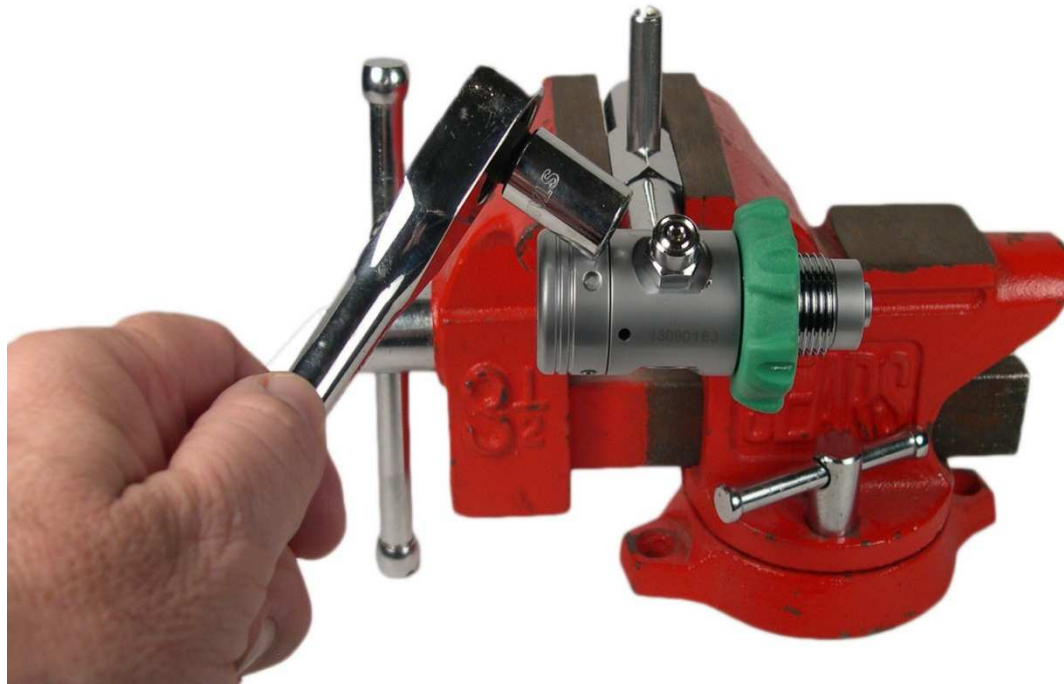
RG5400 first stage



Secure the first stage in a vice.
Use an appropriate tool to keep
from damaging the outer surface.

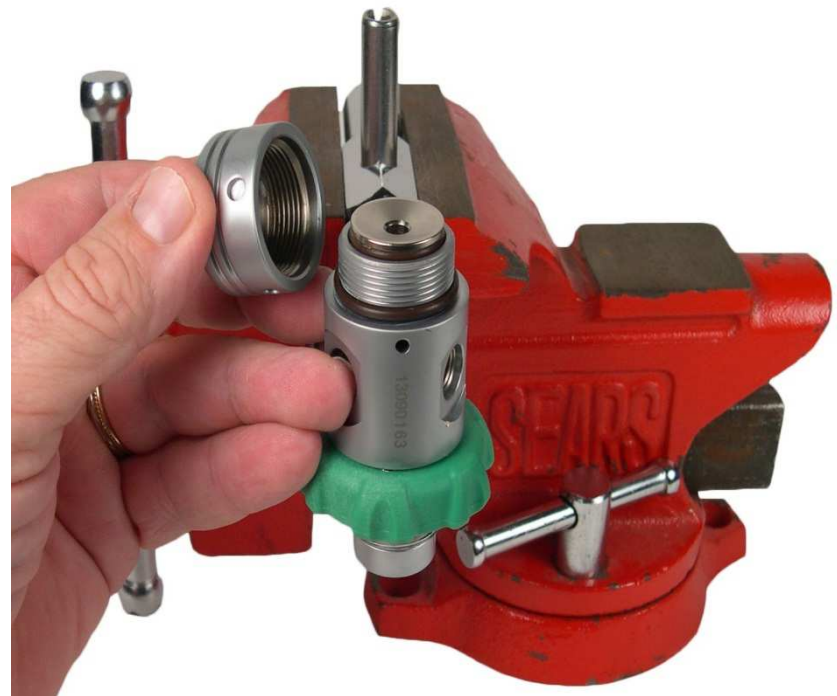


Using a 12mm socket remove the
overpressure valve, if installed.
[RG1310-140]



*The over pressure valve is not a serviceable item.
Any leakage after cleaning and tuning of the first stage
requires replacement.

Using a spanner wrench
loosen and then remove the end cap.

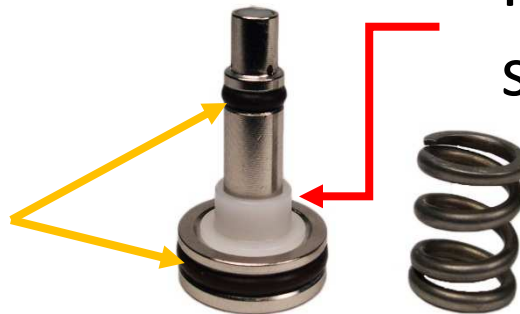


Remove the piston assembly and the spring.



Remove the
spring carrier.

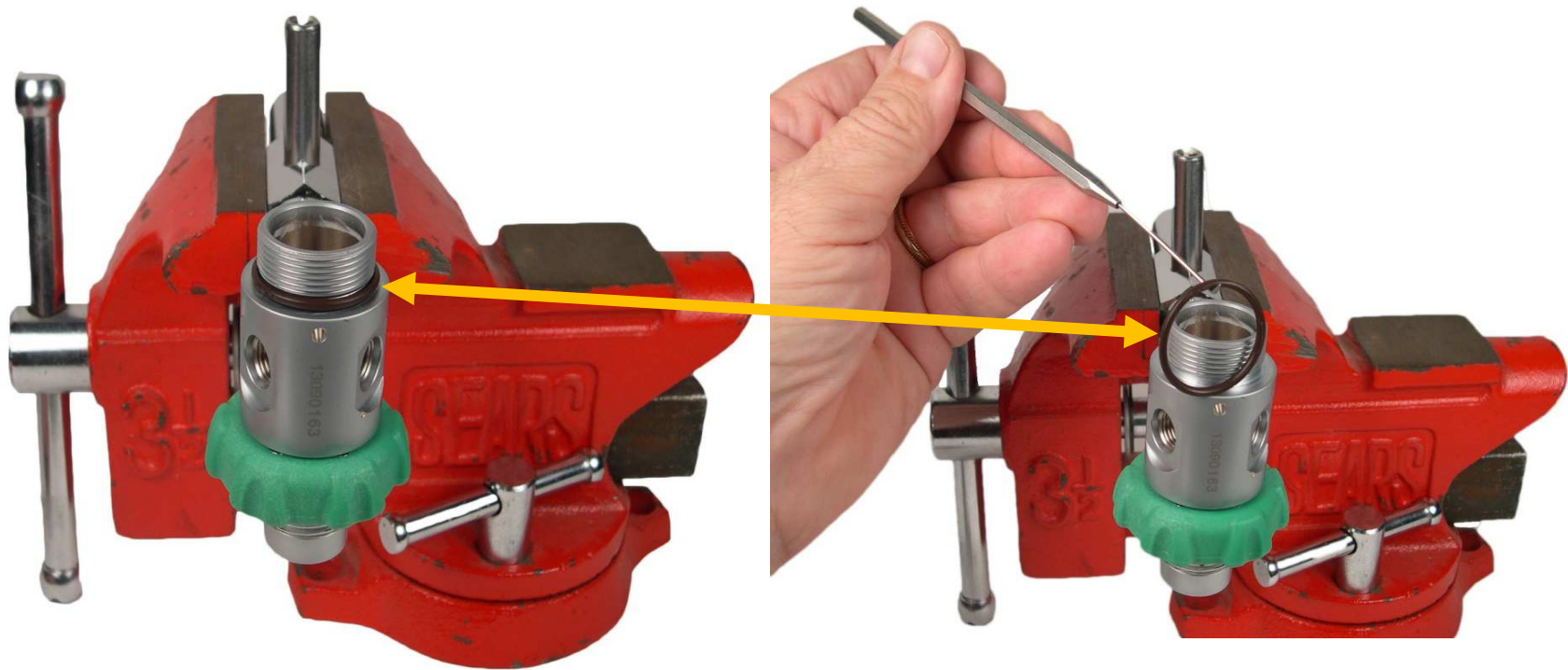
Remove the O-rings.
[2-008-03, RG1260]



Remove the valve seat from the piston using a flat tipped pick or a 1.5 mm hex key.



Remove the O-ring.
[1-23-20-03]



Turn the first stage over.
Using a 6MM Hex wrench loosen and
remove the DIN lockdown screw.



[RG1239]

Remove the O-rings from
the lockdown screw.

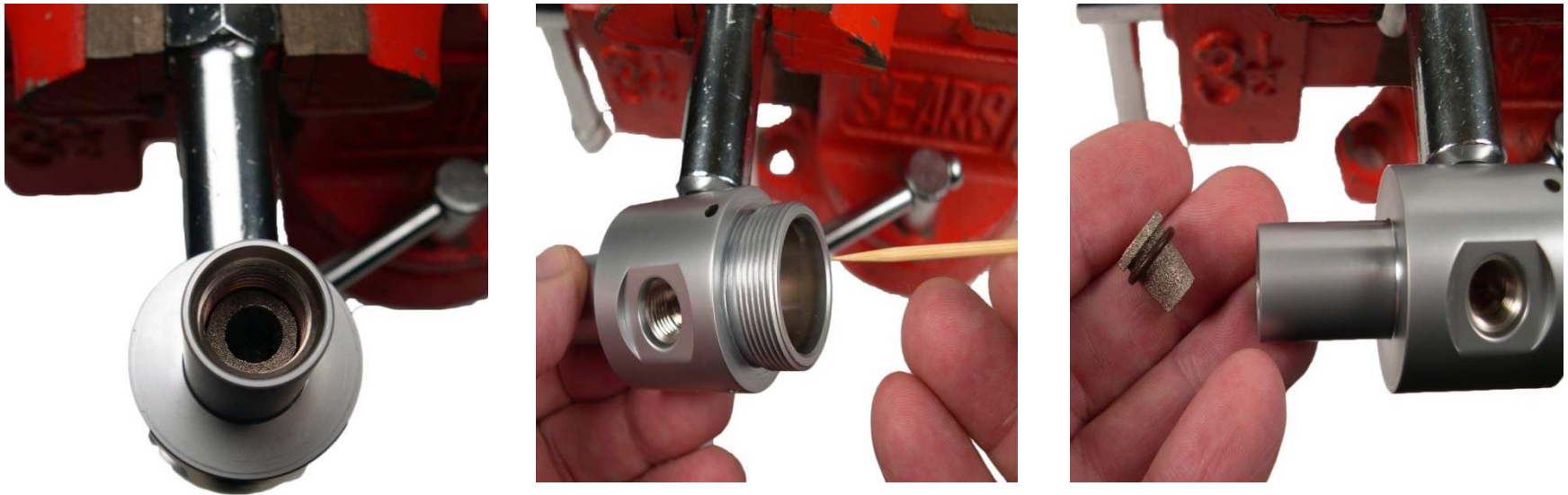


[RG1236]

Remove the DIN handwheel.



Remove the filter [RG1240] and filter O-ring [RG1243] by inserting a toothpick through the HP cone and pushing the filter out.



This completes disassembly of the RG5400 first stage.

Warning!!! Only original Dive Rite parts are to be used.

- All parts that are removed from the serviced regulator are to be replaced with those in the parts kits available from Dive Rite.
- Remaining parts should be cleaned in a solution compatible with **oxygen** use.
- All points of lubrication (O-rings, etc.) require the use an **oxygen** compatible lubricant.
- Dive Rite recommends Tribolube 71 lubricant.

Assembly

RG5400 first stage



Insert a new HP seat into the piston.
Press into place with your thumb.



Lubricate and install the large piston O-ring [RG1260]. Next, install the spring carrier. Then lubricate and install the small piston stem O-ring [2-008-03].



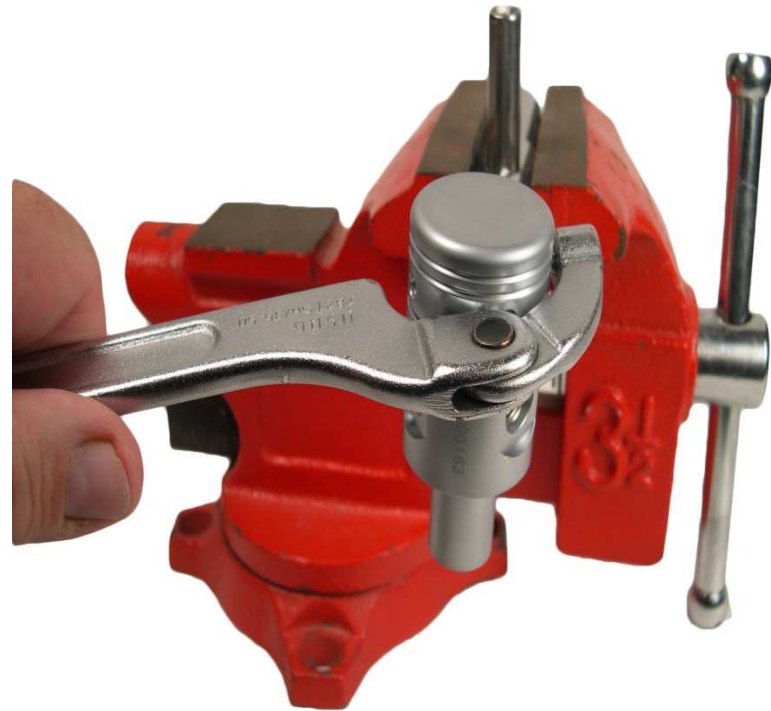
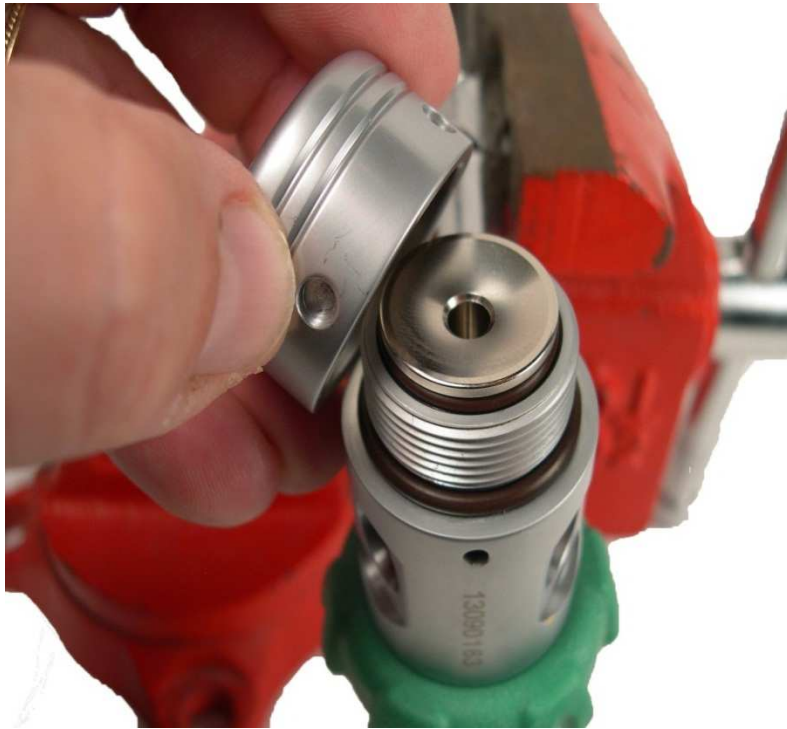
Secure the first stage in a vice using
an appropriate tool to keep from
damaging the outer surface.
Lubricate and install the cap O-ring.
[RG1260]



Install the piston with the spring into the main body.



Replace the cap and tighten with a spanner wrench until just snug. Do not over tighten.



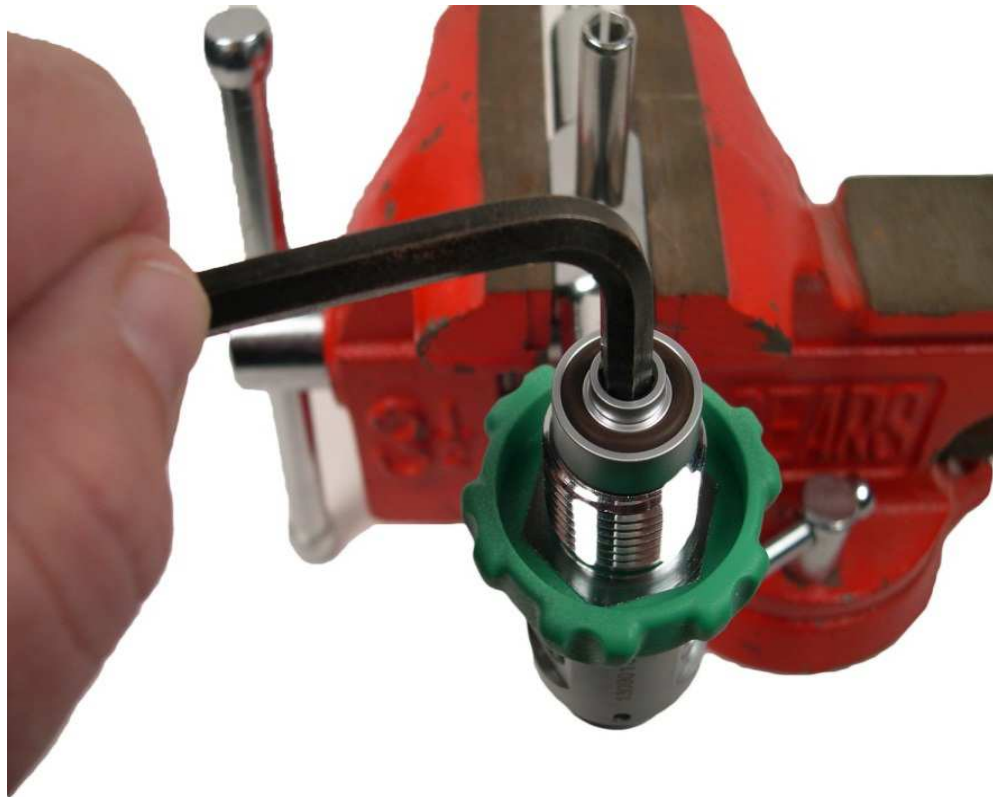
Turn the body over and install the filter [RG1240] and filter O-ring [RG1243].



Install the DIN handwheel. Lubricate and install the two O-rings on the DIN lockdown screw.

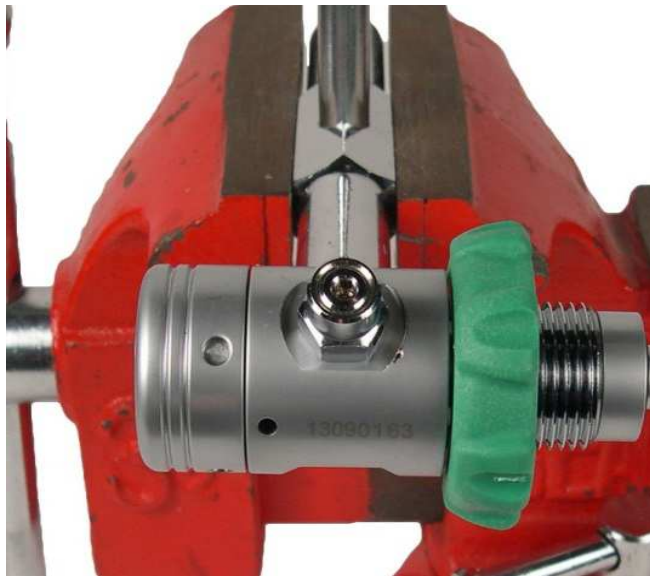


Install and tighten the DIN lockdown
screw with a 6MM Hex wrench.
Torque to 20-25 ft-lbs.



RG5400 first stages used for dry suits
require the use of an OPV.
Install after lubricating O-ring and
tighten with a 12MM socket.

*The over pressure valve is not a serviceable item.
Any leakage after cleaning and tuning of the first stage
requires replacement.



This completes RG5400 first stage assembly.

