

**PACER XLB SECOND STAGE****Tools Needed:**

1. 0980-38 Tool Kit
2. 0980-61 O-ring Tool Kit
3. 11/16" Open End Wrench
4. Screwdriver
5. External Retaining Ring Pliers

**Disassembly:**

**Step 1:** Remove hose from second stage.

**Step 2:** Remove exhaust manifold (27) by pulling sharply on one end. No tools are required for removal. Exhaust valves (26) are now accessible and are removed by gently pulling free from bottom box assembly.

**Step 3:** Remove mouthpiece (28) by removing mouthpiece clamp (29) and gently pulling free from mouthpiece sleeve. Have replacement clamps available because this piece has a one time use only and will be destroyed upon removal.

**Step 4:** Remove ring screw (23) and clamp ring (24).

**Step 5:** Remove top cover (3). Low pressure diaphragm (5) is now accessible.

**Step 6:** Remove purge button (1) and purge button spring (2) by releasing purge button retaining ring (4) using external spring clip pliers.

**Step 7:** Remove low pressure diaphragm (5).

**Step 8:** Loosen jam nut (10) with 11/16" wrench. Remove valve seat (9) by turning counter clockwise. "O" ring (11) is now accessible. CAUTION: Do not damage seat during this operation.

**Step 9:** Remove jam nut (10) from valve seat (9).

**Step 10:** Depress L.P. seat assembly (12) by inserting the multi-tool into the bushing and applying pressure until the lever (25) drops. Remove lever (25) from unit. Seat assembly (12) and spring (13) should now drop from housing. "O" ring (15) and washer (14) are available for inspection/replacement.

**Step 11:** Remove screw (21). Leave knob (20) on shaft (16). Turn knob clockwise until shaft falls from unit from hose connection side. "O" ring (17) is now available for

inspection/replacement. Knob is also free.

**Step 12:** Remove plug (19) using small crescent wrench. "O" ring (11) is now available for inspection/replacement.

**Step 13:** Remove spring clip (22).

**Assembly:**

**Step 1:** Install spring clip (22) onto regulator bushing. Exact locations is unimportant at this time, so long as clip does not cover the square holes or the air-flow port.


**Step 2:** Inspect and install exhaust valves (26). If valves are worn or damaged, replace with new valves.

**Step 3:** Insert "O" ring (11) and plug (19) into side port and tighten. Place "O" ring (17) into groove on shaft (16) and insert into regulator bushing and through the opening in plug (19). Pull on the flat end of the protruding shaft (16) and turn counter clockwise approximately three turns. Install the knob (20) and screw (21).

**Step 4:** At this point the spring (13) should be assembled onto the seat assembly (12) followed by the washer (14) and "O" ring (15). This entire sub-assembly should now be inserted into the regulator bushing. Using Dacor's multi-tool or any non-abrasive rod (pencil with eraser) push against the face of the seat and compress approximately 1/4". At the same time insert the lever (25) by opening the two "legs" and inserting the ends into the square holes in the side of the valve bushing. Remove the compression tool and test the lever for proper engagement by compressing it a few times. Looking at the face of the black rubber seat you should see a movement of the whole seat carrier assembly when the lever is pressed on.

**Step 5:** Push spring clip (22) all the way against the lever (25) and press on the end of the lever approximately 1/4". The spring clip (22) will move away from the lever slightly and will now be in the correct position. Reinstall "O" ring (11), jam nut (10), and valve seat (9). Do not tighten the nut at this time.

**Step 6:** Hold regulator at eye level focusing on the very top of the lever (25). With the free hand, turn the valve seat (9) clockwise until the lever starts descending. Stop turning an back off 1/4 turn. Tighten the jam nut (10). Install diaphragm (5), cover assembly (3), clamp (24) and screw (23).

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