



## ASSEMBLY & DISASSEMBLY - MODEL 873-400 REGULATOR

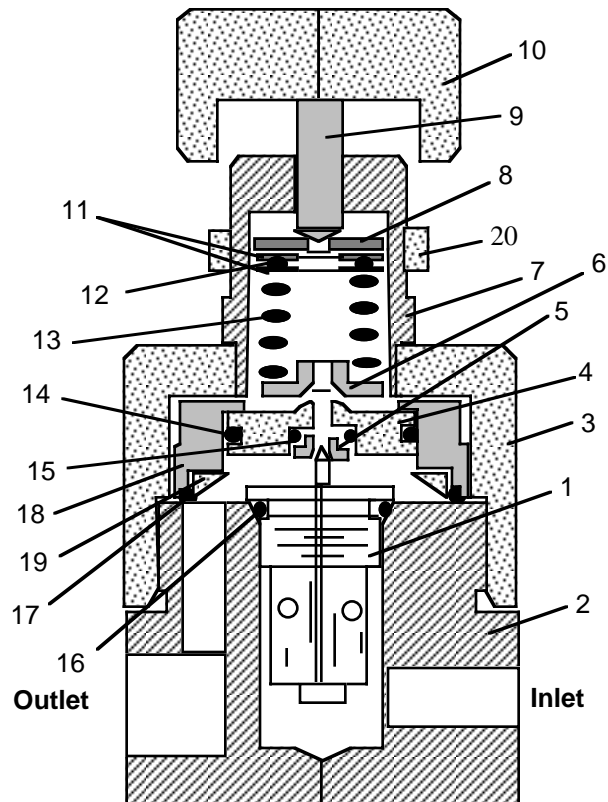
ITEM	QTY	PART NO.	DESCRIPTION
1	1	895	poppet assy
2	1	893	body
3	1	879	cap
4	1	744	piston
5	1	946	vent seat (vented)
	1	1035	seat - not vented
6	1	849	spring guide
7	1	903	cap
8	2	410	spring guide (note 4)
9	1	378-2	adjusting screw
10	1	379-30	knob
11	2	379-37	bearing plate
12	1	379-38	bearing
13	1	379-5	spring
14	1	876-24	seal (2-122) Vit. 75
15	1	876-15	seal (2-010) Vit. 90
16	1	876-16	seal (2-020) Vit. 90
17	1	876-27	seal (2-135) Buna 90
18	1	944	piston hsg
19	1	945	stop ring
20	1 or 2	952	mount nut - optional
21		979-400	REPAIR KIT - includes items 1,5,14,15,16,17

### NOTES

- Technical bulletin - 874  
895 poppet cartridge assy - drw 896
- Use Dow silicone grease 111 or equivalent on seals and threads except seal 14. Pack this area with Cristo-Lube MCG 121. Use Slick 50 EP grease or equivalent on bearings 11 and 12 and on threads between items 7 and 9.
- ASSEMBLY**
  - Clean all parts and insure there are no visible chips or particulates.
  - Inspect vent seat 5 under 10X magnification at sealing edge. Wipe clean as required.
  - Install cartridge 1 with seal 16 in housing 2. Torque to 10 to 20 ft-lbs.
  - Install seal 14 on piston 4. Pack heavily with Cristo-Lube MCG 121.
  - Carefully slide piston 4 into hsg 18 as shown.
  - Install seal 15 and vent seat 5 into piston as shown.
  - Install seal 17 as shown.

- Screw cap 3 and body 2 together. Hold cap 3 downward so seat 5 does not fall out during assembly. Torque to 10 to 20 ft-lbs using a strap wrench or by hand.
- Install spring guide 8, then bearing plate 11, then bearing 12, then second bearing plate 11, then spring 13, then spring guide 6 into cap as shown. Use ample Slick 50 EP grease or equivalent on the bearings. Silicone spray can be used to coat these parts and act as a preservative.
- Screw cap 7 onto cap 3. Hold cap 7 downward so parts stay in place during assembly. Torque to about 20 ft lbs.
- Install adjusting screw 9 and knob 10 as shown using Slick 50 or EP grease.

- Two item 8 are required for full spring travel
- Model 873-400NA denotes fixed adjustment and uses a bolt and locking nut instead of items 9 and 10.
- Model 873-400NV denotes non-vented regulator.



**Model 873-400**