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Pneumatic Division
Richland, Michigan 49083
269-629-5000

Installation and Service Instructions
IS-R364R374R384
R364, R374, & R384, 1/8" & 1/4" Miniature Regulators
ISSUED: September, 2005
Doc. #ISR3647484, ECN #050964, Rev. 1

⚠ WARNING

To avoid unpredictable system behavior that can cause personal injury and property damage:

- **Disconnect electrical supply (when necessary) before installation, servicing, or conversion.**
- **Disconnect media source and depressurize all media lines connected to this product before installation, servicing, or conversion.**
- **Operate within the manufacturer's specified pressure, temperature, and other conditions listed in these instructions.**
- **Medium must be moisture-free if ambient temperature is below freezing.**
- **Service according to procedures listed in these instructions.**
- **Installation, service, and conversion of these products must be performed by knowledgeable personnel who understand how pneumatic products are to be applied.**
- **After installation, servicing, or conversion, media and electrical supplies (when necessary) should be connected and the product tested for proper function and leakage. If audible leakage is present, or the product does not operate properly, do not put into use.**
- **Warnings and specifications on the product should not be covered by paint, etc. If masking is not possible, contact your local representative for replacement labels.**

Application Limits

These products are intended for use in general purpose compressed media systems only.

Operating Pressure:

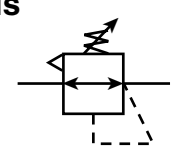
	kPa	PSIG	bar
Maximum Inlet Pressure	2068	300	21.0

Ambient Temperature Range: 4°C to 49°C (40°F to 120°F)

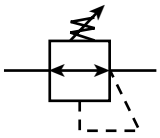
⚠ WARNING

Product rupture can cause serious injury.
Do not connect regulator to bottled gas.
Do not exceed maximum primary pressure rating.

Symbols



Relieving Regulator Adjustable



Non-Relieving Regulator Adjustable

Installation

1. The regulator should be installed with reasonable accessibility for service whenever possible - repair service kits are available. Keep pipe and tubing lengths to a minimum with inside clean and free of dirt and chips. Pipe joint compound should be used sparingly and applied only to the male pipe - never into the female port. Do not use PTFE tape to seal pipe joints - pieces have a tendency to break off and lodge inside unit, possibly causing malfunction.
2. Install regulator so that media flow is in the direction of arrow (on R384's), and into port labelled "IN". Installation must be upstream (high pressure) side and as close to the devices it is to service (valve, cylinder, tool, etc.). Mounting may be in any position.
3. Gauge ports are located on both sides of the regulator body for your convenience. It is necessary to install a gauge or pipe plugs into each port during installation.
4. For protection against rust, pipe scale, and other foreign matter, install a filter on the upstream (high pressure) side as close to the regulator as possible.

Operation

1. Before turning on the media source, disengage the Adjusting Knob by pulling upward. Turn the Adjusting Knob counterclockwise until compression is released from the Control Spring. Then turn on media source and adjust regulator to desired secondary pressure by turning Adjusting Knob clockwise. This permits pressure to build up slowly, preventing any unexpected operation of the valve, cylinders, tools, etc., attached to the line. Adjustment to desired secondary pressure can be made only with primary pressure applied to the regulator.
2. To decrease regulator pressure setting, always reset from a pressure lower than the final setting desired. For example, lowering the secondary pressure from 550 to 410 kPa (80 to 60 PSIG) is best accomplished by dropping the secondary pressure to 350 kPa (50 PSIG), then adjusting upward to 410 kPa (60 PSIG).

   Push the Adjusting Knob down to lock the pressure setting.

Reduced Pressure Spring Ranges

"A" Range = 1 – 25 PSI

"B" Range = 2 – 60 PSI

"C" Range = 2 – 125 PSI

⚠ WARNING

FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS AND/OR SYSTEMS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

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Service

⚠ **CAUTION:**
SHUT OFF MEDIA SOURCE and exhaust the primary and secondary pressure before disassembling regulator unit. (Turning the Knob counterclockwise reduces regulator's setting, but does not vent downstream pressure on non-relieving regulators.)

⚠ **CAUTION:**
Lubricate parts with a mineral based oil / grease or silicone grease. DO NOT use synthetic oils / greases such as esters.

A. Servicing the Bonnet and Diaphragm assembly-

1. Disengage the Adjusting Knob by pulling upward. Turn Adjusting Knob counterclockwise until the compression is released from the Pressure Control Spring.
2. Unscrew the threaded Bonnet Assembly. Next, disassemble, clean, and carefully inspect parts for wear and / or damage. If replacement is necessary, use parts from service kits.
3. Lubricate O-ring and Lip Seals with grease (supplied with kits).
4. Install Diaphragm Assembly into Body. Then install Bonnet Assembly to Body and tighten to 4.5 to 5.6 Nm (40 to 50 in. lb.).

B. Servicing the Poppet Assembly-

1. Exhaust system media pressure as previously described. Then remove Bottom Plug by unscrewing it from Body. Next, remove Bottom Plug O-ring, Poppet Return Spring and Poppet Assembly.
2. Next, disassemble, clean, and carefully inspect parts for wear and / or damage. If replacement is necessary, use parts from service kits.
3. Lubricate O-ring and sliding surfaces using grease supplied with service kit.
4. Install parts as shown.
5. Lubricate Bottom Plug O-ring and install it in o-ring groove on Bottom Plug. Then screw Bottom Plug into Body until the plug bottoms out in body. Tighten to 3.5 to 5.1 Nm (35 to 45 in. lb.).
6. Turn on media source and adjust to desired secondary pressure as described in the **Operation** section.

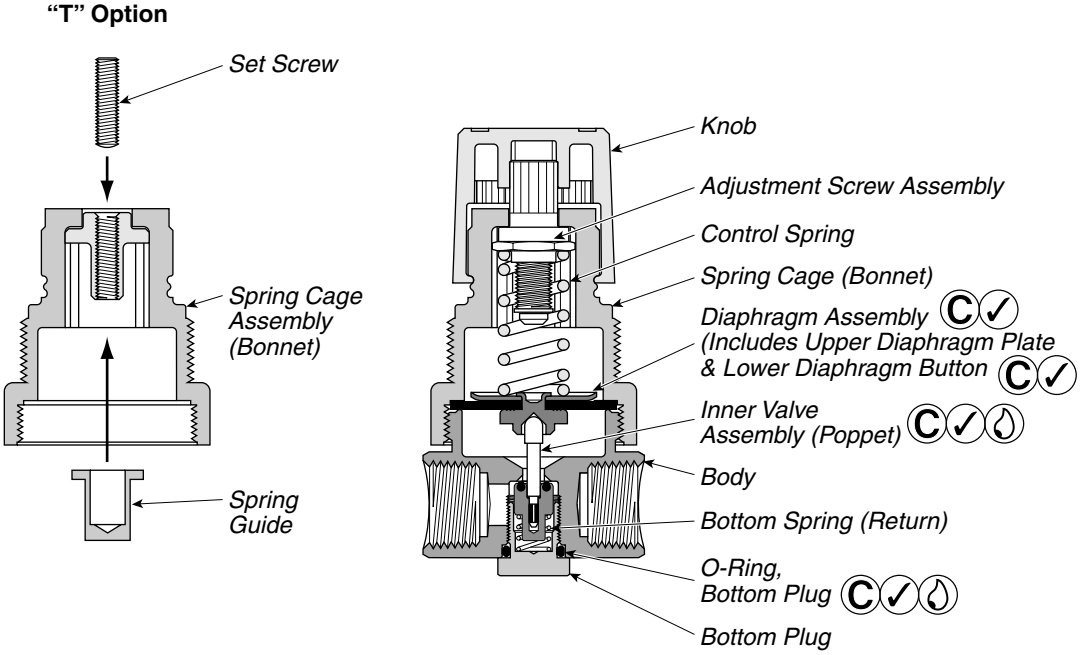
Turn on media pressure and check regulator for leakage. If leakage occurs, DO NOT OPERATE — conduct repairs again.

If you have questions concerning how to service this unit, contact your local authorized dealer or your customer service representative.

Service Kits Available

	R364, R374, & R384, 1/8" & 1/4"
Regulator Repair Kit (Relieving)	RKR164Y
Regulator Repair Kit (Non-Relieving)	RKR163Y
Regulator Repair Kit * (Relieving) X64 Option	RKR164X64
Regulator Repair Kit * (Non-Relieving) X64 Option	RKR164KX64
Spring Cage & Knob Assembly	CKR364Y
"T" Option Cage Kit	CKR364T
Panel Mount Nut	R05X51
Mounting Bracket / Nut	SA161X57
Knob Only	R35-0545P

* For all other "X" options and "Z" models contact factory for kits or replacement parts.



R364, R374, & R384 Miniature Regulator (Non-Relieving Shown)

Ⓛ Lightly grease with provided lubricant.

✓ Inspect for nicks, scratches, and surface imperfections. If present, reduced service life is probable and future replacement should be planned.

Ⓒ Clean with lint-free cloth.

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