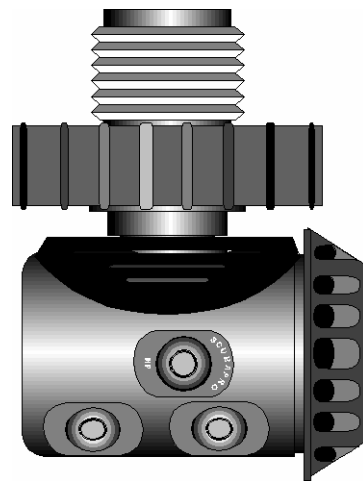
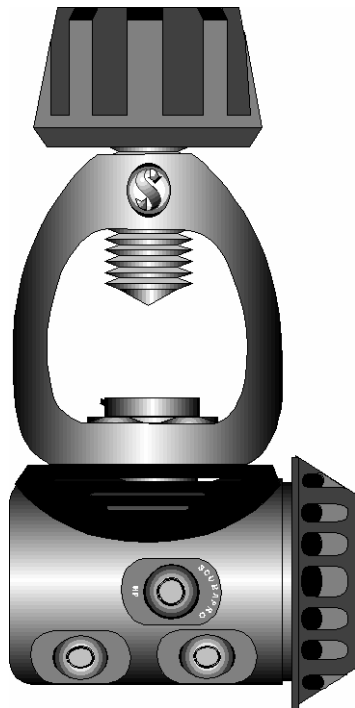


SCUBAPRO

Repair Guide

MK 16 First Stage



**USE THIS GUIDE AS A REFERENCE WHEN SERVICING
THE MK 16 FIRST STAGE**

TOOLS NEEDED FOR REPAIR OF MK 16












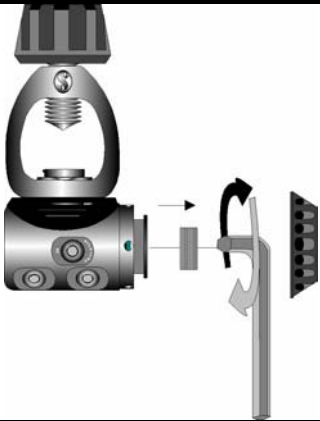
Quantity	Part Number	Description	
1		Socket Wrench with 3/8" drive and 3" extension	
1	20-155-500 (Peter Built)	1" Yoke Nut Socket	
	20.270-100 (Peter Built)	MK 16 Tool	
1 set	10.102.100 (Peter Built)	Brass o'ring picks	
1 tube	41.047.000	Christo-Lube	
1	47.010.000	Counter Mat	
1	41.496.101	Lubricant syringe	
1	43.040.000	Universal Tool	
1	20-115-100 (Peter Built)	First Stage Handle	
2		Torque Wrench with 3/8" drive - 100 in-lb range and 600 in-lb range	
1		Hex Key Set: 7/32" and 6mm	
1		Crescent wrench	
1	20.500.200 (Peter Built)	Pneumatic Adjusting tool	
1	18.300.500 (Peter Built)	Blow Gun/Air Nozzle	

ICON LEGEND



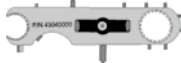

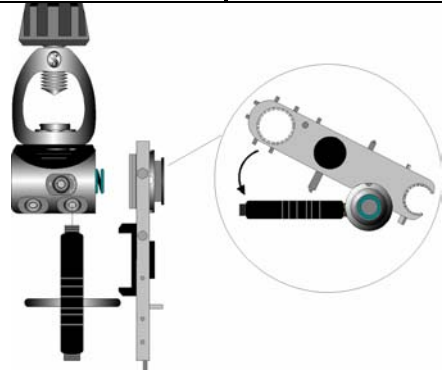
	Inspect carefully, replace if needed
	Lubricate properly
	Replace annually
	Dynamic o'ring, lubricate properly
	No tools needed for this step
	Indicates the regulators affected by this step





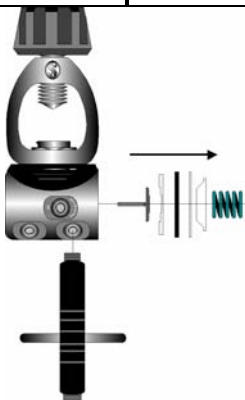
SCUBAPRO MK 16 First Stage





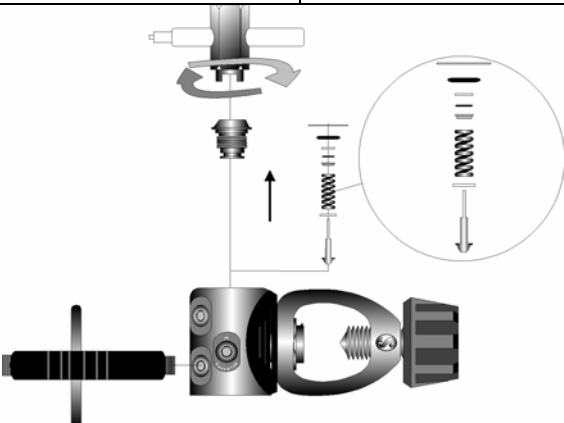
			
<p>Remove hoses from the first stage by using an adjustable wrench or 5/8" open-end wrench.</p> <p>Remove plugs using a 5/32" hex wrench.</p>			

			 <p>6 mm</p>
<p>Remove the plastic boot. Using a 6 mm hex wrench, thread out the intermediate pressure adjustment screw.</p>			




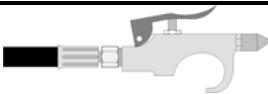
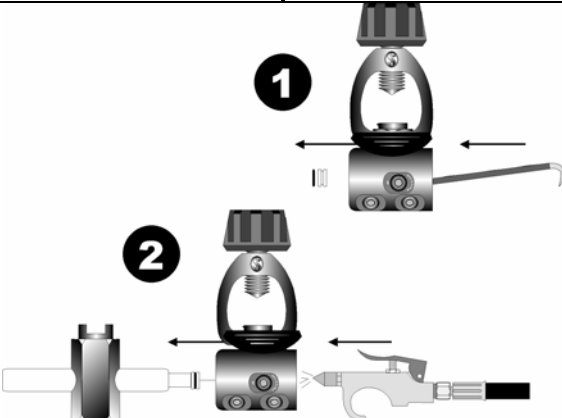
SCUBAPRO MK 16 First Stage





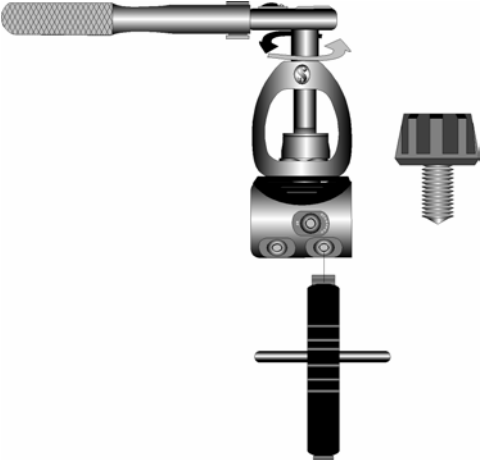
			
<p>Use the Universal Tool to remove the end cap from the main regulator body. The spring and spring pad can now be removed.</p>			

			
<p>Remove the friction washer and diaphragm carefully.</p> <p>Remove the HP module button and pin. Remove the pin carefully to ensure it is not lost.</p>			


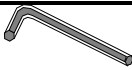

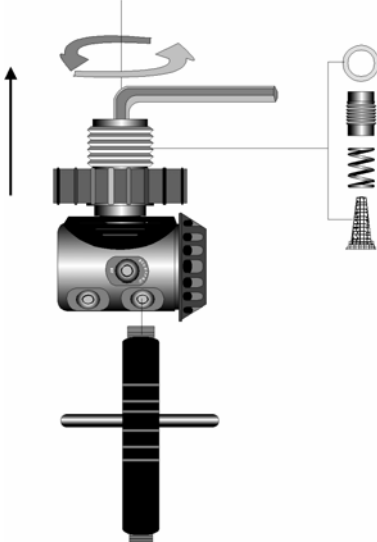
			
<p>Using the Balance Chamber Tool, remove the balance chamber by threading out the unit in a counter clockwise direction. Turn the unit as shown to prevent loss of the HP seat and spring assembly.</p> <p>Remove the spring assembly.</p>			


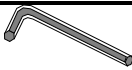

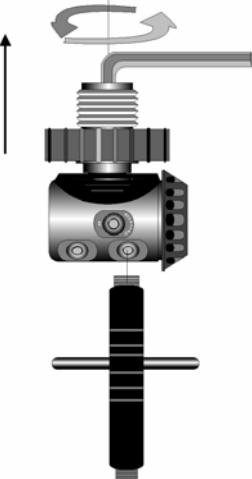
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<p>Remove the HP seat using the brass picks. The HP seat will be replaced. Use caution to prevent damaging the regulator body.</p> <p>Alternatively, use the air gun and MK16 tool to remove the HP seat.</p>			





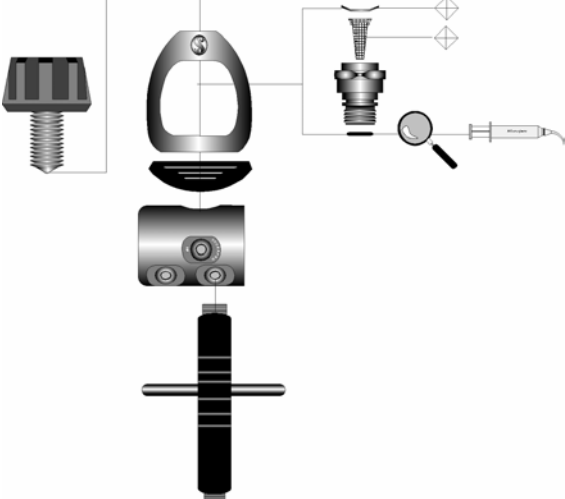
				
<p>Remove the Yoke Nut, Yoke and Saddle from the regulator body.</p>				



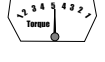


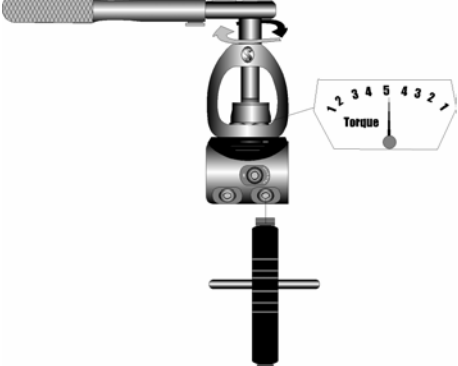
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		 5/32"	
For DIN Regulators			
<p>Remove the Filter retainer, filter, spring, and o’ring from the DIN Fitting using a 5/32” hex wrench.</p>			


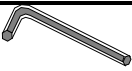

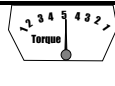

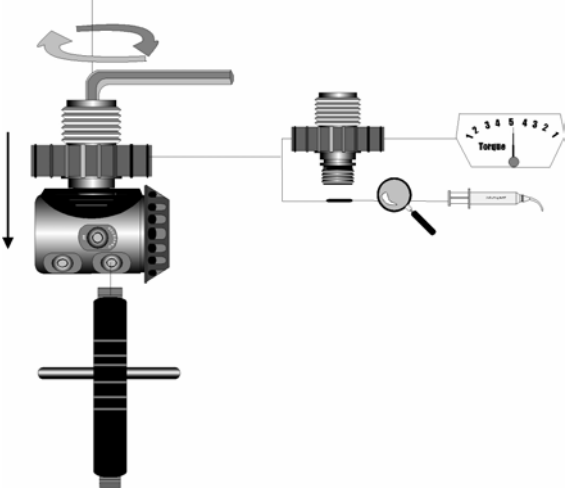
		 6 mm	
For DIN Regulators			
<p>Remove the DIN Fitting from the regulator body.</p>			



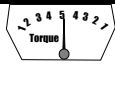

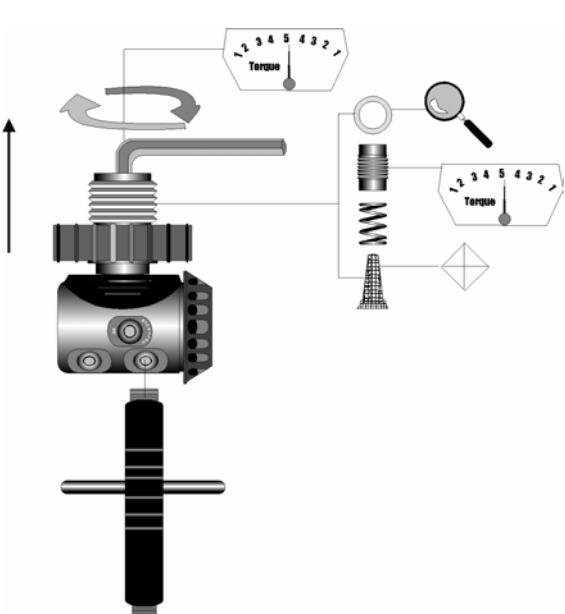
SCUBAPRO MK 16 First Stage

				
<p>Using a brass o’ring pick, remove the star retainer and filter.</p> <p>Clean and inspect all regulator parts.</p> <p>Replace the conical filter. Inspect and lubricate the static yoke nut o’ring. Replace the o’ring if needed.</p>				




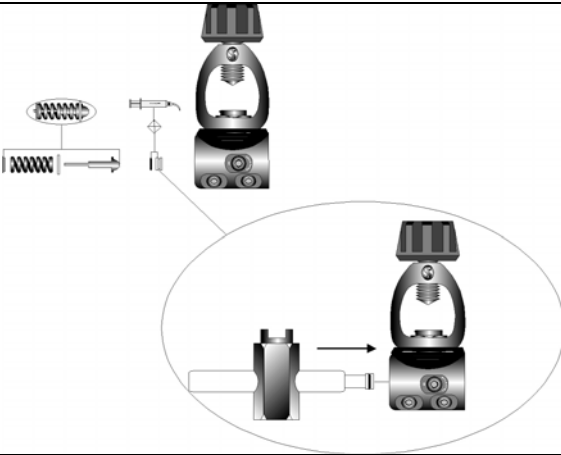
					
<p>Torque the yoke nut to 266 in-lbs or 30 Newton-meters.</p>					




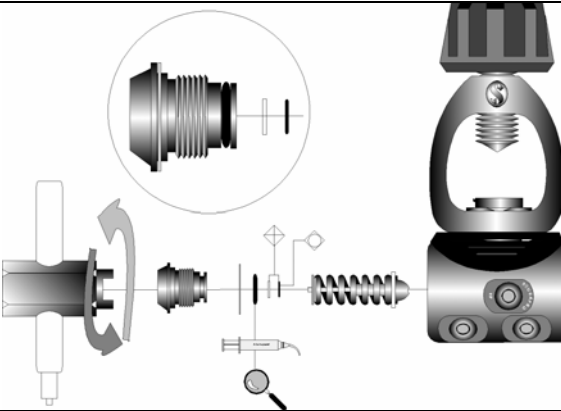
SCUBAPRO MK 16 First Stage

		 6 mm			
For DIN Regulators					
<p>Replace the DIN Fitting into the regulator body after inspection and lubrication of the fitting-to-body o’ring.</p> <p>Torque to 266 in-lbs or 30 Newton-meters.</p>					




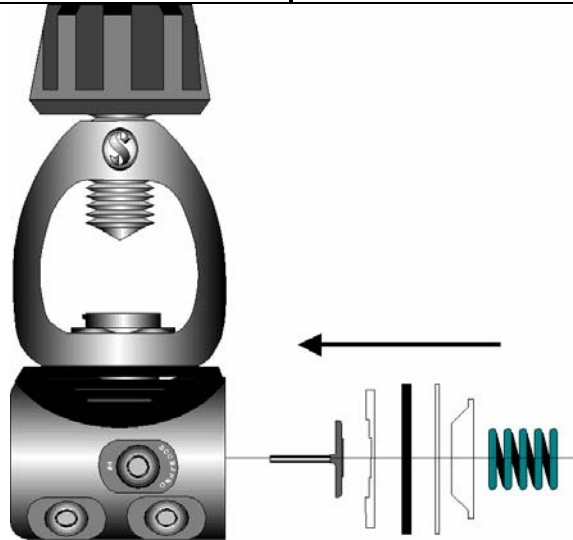




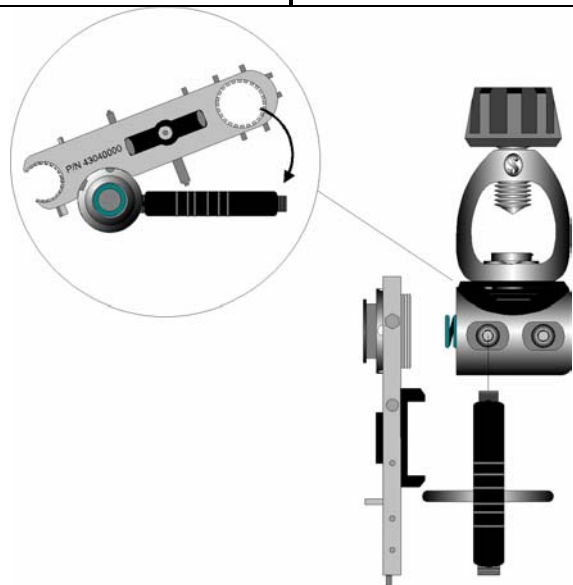
		 5/32"			
For DIN Regulators					
<p>Replace the spring, filter, o’ring, and filter retainer. Torque to 35 in-lbs or 4 Newton-meters.</p>					

SCUBAPRO MK 16 First Stage




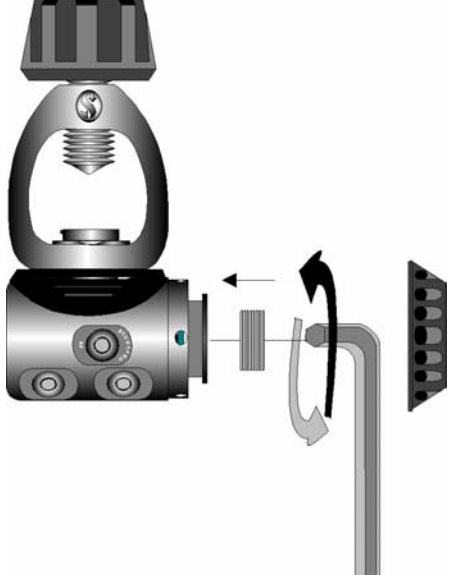
		
<p>Insert a new HP seat assembly into the regulator body after lubricating the HP seat o’ring properly.</p> <p>Assemble the HP poppet, spring and washers.</p>		





		
<p>Assemble the o’ring, (2) washers in the HP seat retainer.</p> <p>Insert the poppet assembly. Insert the HP seat retainer and tighten using the MK 16 tool.</p>		

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			<p>No tools needed for this step</p>
<p>Insert the pin, disc, diaphragm, diaphragm ring, diaphragm disc and spring. Be certain that the diaphragm is pressed evenly into place.</p>			
			
<p>Thread and tighten the diaphragm holder using the universal tool and first stage handle.</p>			

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		 <p>6mm</p>
<p>Thread in the spring screw (adjustment cap) and tighten flush with the 6 mm hex wrench.</p> <p>The cap will be adjusted to set the intermediate pressure in a subsequent step.</p> <p>Replace the plastic cap. It is possible to make intermediate pressure adjustments with the plastic cap in place.</p>		

			 <p>6mm</p>
<p>Attach the second stage regulator through the pneumatic adjusting tool. Do an air-on test to determine the intermediate pressure.</p> <p>Adjust the intermediate pressure using the 6mm hex wrench. Increase intermediate pressure by turning clockwise.</p> <p>Intermediate pressure should be between 125 and 145 psi at 3000 psi and 300 psi.</p>		