

TECHNICAL BULLETIN

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FIRST STAGE CAP SCREW LOCTITE AND TORQUE PROCEDURE

Products Affected: Panther, Cougar and Puma First Stage Regulators with Plain Whistle, Bell, or Warbling Whistle Alarms.

This technical bulletin provides information regarding the proper application procedure for Loctite® 242 and the necessary torque required for the cap screws that affix the alarm cap onto the regulator body.

NOTE

- The **Field Procedure** need only be done on units exhibiting leakage between the regulator body and alarm cap.
- The **Overhaul Procedure** must be done when performing a standard six year overhaul.

Field Procedure:

Should air leakage occur between the regulator body and the alarm cap, use the following procedure to apply Loctite® 242 to the cap screws and then re-torque them.

CAUTION

Prior to working on the SCBA pneumatics, depressurize the SCBA by turning the air off at the cylinder and purging any trapped air by using the second stage regulator bypass or by activating the manual override button.

1. Depressurize the SCBA pneumatics and remove the first stage regulator from the cylinder.
2. Remove the alarm (whistle, bell, or warbling whistle) as needed to access the four cap screws. (Refer to the Panther Repair Manual, Addendum, for specific disassembly procedures. You need not remove the gauge line or intermediate pressure line to accomplish the following procedures.)
3. If the cap has loosened to the point where leakage has occurred between the regulator body and the alarm cap, inspect the regulator to assure that the 957304 o-ring is intact prior to completing the next step. If necessary, remove the alarm cap from the regulator body and replace the 957304 o-ring.

NOTE

During this procedure, do only one cap screw at a time until all four cap screws have been completed. Use a 7/64" allen wrench.

4. Turn (loosen) the cap screw counterclockwise 3 full turns.
5. Turn the regulator upside down (alarm cap down) and apply one drop of Loctite ® 242 into the open threaded cap screw hole. (On the regulator body side.)
6. Turn (tighten) the cap screw clockwise until it stops, loosen and re-tighten, 2 full turns, to assure that the Loctite® 242 has been spread on the internal cap screw threads.
7. Torque the cap screw to 20 - 25 in./lbs.
8. Wipe any excess Loctite® 242 off the regulator body.
9. Re-assemble the alarm (whistle, bell, or warbling whistle) onto the alarm cap. (Refer to the Panther Repair Manual, Addendum, for specific assembly procedures.)
10. Prior to returning the SCBA to service, run a complete flow test on the pneumatics using the Survivair PTC or Posichek³.

Overhaul Procedure:

1. During the overhaul re-assembly procedure, prior to assembling the alarm cap onto the regulator body, turn the regulator body upside down (flange down) and apply one drop of Loctite ® 242 into the open threaded cap screw holes.

NOTE

Do not allow any of the Loctite® 242 to pool on the regulator body flange. (the piston side) Wipe excess Loctite® 242 from flange prior to assembly.

2. Assemble the regulator body to the alarm cap as specified in the Panther Repair Manual, Addendum, and torque the cap screws to 20 - 25 in./lbs.
3. Wipe any excess Loctite® 242 off the regulator body.
4. Continue with the overhaul as specified in the Panther Repair Manual and Addendum.
5. Test the pneumatics as specified in the Panther Repair Manual and Addendum.

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