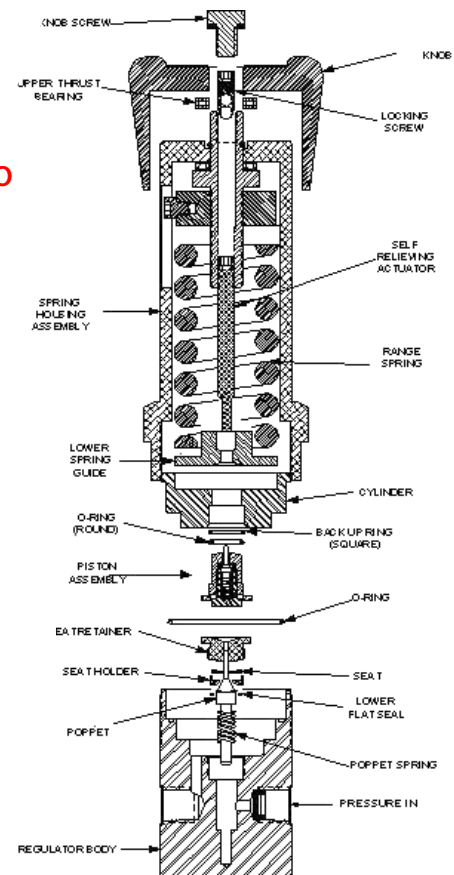


## PR-57 Series High Pressure Regulator Self Relieving Poppet, Seat & Spring Replacement Instructions

**Make sure you thoroughly understand these directions before proceeding  
MAKE SURE THE REGULATOR IS DISCONNECTED FROM AIR SOURCE  
MAKE SURE ANY RESIDUAL PRESSURE IS BLED OFF FROM REGULATOR.**

### Instructions

1. Completely read these instructions before performing any of the operations.
2. Make sure the regulator is disconnected from pressure source; make sure any residual pressure is bled off from the regulator. **FAILURE TO DO THIS WILL RESULT IN SERIOUS PERSONAL INJURY. DO NOT PROCEED UNTIL PRESSURE HAS BEEN REMOVED AND/OR TERMINATED**
3. Securely clamp the regulator body over the flats in a vise.
4. Turn the adjustment knob counterclockwise, as looking from the top of the regulator, until it will turn no further.
5. Using a 1/2" wrench, remove the knob screw.
6. Remove knob.
7. Remove upper thrust bearing. (Top washer may be in knob).
8. Using a 2 1/4" wrench, remove the spring housing assembly from the body.
9. Remove the range spring.
10. Remove the lower spring guide and piston / cylinder assembly.
11. Remove the seat retainer, seat, seat holder, lower flat seal, poppet and poppet spring.
12. Carefully remove cavity O-ring from regulator body and discard.
13. Thoroughly blow out the inside of regulator body using clean, dry compressed air.
14. Clean seal surface with a cotton swab moistened with isopropyl alcohol.
15. Clean seat retainer of any foreign matter.
16. Place new poppet spring into .312 (7.9mm) hole in the body.
17. Place new poppet into poppet spring.
18. Install new lower flat seal into groove of new seat holder.
19. Install new seat into cavity of seat holder.
20. Place the seat holder over the nose of the poppet, with the seat facing up.
21. Place the seat retainer over the nose of the poppet and start the threads by hand. Tighten the seat retainer hand tight.
22. Finish tightening seat retainer to 25 lbf·ft (34 N·m).
23. Attach primary pressure supply to inlet with suitable fittings.
24. Apply a small amount of leak detecting fluid, such as "Leak Detective" or soapy water, around poppet stem and seat retainer.
25. Slowly apply pressure to unit, watching closely for the presence of bubbles. Continue increasing inlet pressure up to one-half the maximum rated pressure for this unit. Let stand for 30 seconds. If there is evidence of leaking, such as bubbles or frothing, immediately relieve the primary pressure. The unit must be disassembled and inspected for foreign debris.
26. If there is no evidence of leaking, clean out the leak detecting fluid and proceed to the next step.
27. Apply O-ring lubricant, such as Krytox grease, into groove in regulator body if new cavity O-ring is dark color. Do not apply lubricant to groove if new O-ring is white color. Install new cavity O-ring into groove.
28. Remove piston assembly from cylinder.



29. Remove O-ring and back-up ring from piston and discard.
30. Install small O-ring over piston assembly.
31. Install back-up ring over piston assembly. Slide it all the way against the O-ring. Make sure that the O-ring and back up ring are oriented correctly.
32. Apply Krytox grease to cylinder bores.
33. Apply O-ring lubrication to small outside diameter of piston. Install piston into cylinder.
34. Place piston / cylinder assembly into regulator cavity. Place lower spring guide onto the end of the piston.
35. Place range spring onto lower spring guide.
36. Remove the locking screw on the self relieving actuator.
37. Engage the socket of the self-relieving actuator with a 1/8" hex key. Turn the screw counterclockwise, as you look down on the spring housing assembly, as far as it will go.
38. Place a small amount of Krytox or other lubricant on the outer threads of the body.
39. Put the spring housing assembly over the regulator and engage threads by hand. Tighten hand tight.
40. Finish tightening spring housing assembly to 80 lbf·ft (108 N·m).
41. Attach a pressure gauge and quarter-turn valve to the outlet port. Leave the valve in the closed position.
42. Squirt a leak detecting fluid around the base of the spring housing assembly where it meets the body. Agitate the leak detecting fluid to form foam. Apply this foam around the slot in the spring housing assembly while watching for signs of escaping gas.
43. Slowly turn the knob while watching and listening for any leaks. It may be necessary to re-apply the liquid. If leaks are noticed, immediately back off adjusting screw and repair unit as needed. Continue turning knob to a value that is 50% of the maximum rating for this regulator.
44. Engage the socket of the self-relieving actuator with a 1/8" hex key. Slowly turn the hex key clockwise until it makes contact with the self-relieving poppet. You will hear escaping gas when this happens, or notice a drop in outlet pressure.
45. Turn the hex key counterclockwise 1/4 to 1/2 of a turn. Remove the hex key.
46. Drop the lock screw assembly down the hole in the adjusting screw. Lightly tighten with the 1/8" hex key, being careful not to change the position of the self-relieving actuator.
47. Turn the adjusting screw counter-clockwise. You should hear the outlet pressure venting through the spring housing and notice the outlet pressure drop to zero. If the outlet pressure does not fall completely to zero, it will be necessary to re-adjust the self-relieving actuator.
48. Make sure the adjusting screw is turned counterclockwise as far as it will go and all the outlet pressure has been relieved.
49. Place one of the thrust plates of the thrust washer over the hexagonal end of the adjusting screw. Apply a liberal amount of grease.
50. Place the bearing race on top of the thrust plate. Apply a liberal amount of grease.
51. Place the other plate over the bearing race (this may have remained in the knob).
52. Place the knob on the end of the adjusting screw. Push down by hand as far as it will go.
53. Place the washer and knob screw on top of adjusting screw.
54. Tighten the hex screw to a value of 20 lbf·in (2 N·m). DO NOT OVER TIGHTEN. Over tightening will cause excessive load on the upper thrust bearing which will make the knob very hard to turn.
55. Slowly turn the knob clockwise until there is evidence of flow at the outlet port.
56. Squirt a leak detecting fluid around the base of the spring housing assembly where it meets the body. Agitate the leak detecting fluid to form a foam. Apply this foam around the slot in the spring housing assembly while watching for signs of escaping gas.
57. If no leaks are noticed, adjust control pressure to a value that is 110% of the maximum rating for this regulator. Reapply the leak detecting fluid as needed.
58. Note the pressure reading on the gauge. Wait for 5 minutes. Increasing pressure indicates a leak across the seat or flat seal. Decreasing pressure indicates a possible O-ring leak. If the pressure does not remain stable, the unit must be disassembled and the cause of leakage repaired.
59. Back off the adjustment knob until it is all the way out and will turn no further. Make sure all of the outlet pressure has vented and there is no trapped residual pressure.
60. The regulator is now ready for service.

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## **GO Regulator**

405 Centura Court • PO Box 4866 • Spartanburg, SC 29303

Phone (864) 574-7966 • Fax (864) 574-5608

[www.goreg.com](http://www.goreg.com) • [sales@goreg.com](mailto:sales@goreg.com)