

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) Vit. 90
18	1	944	piston hsg
19	1	945	stop ring
20	1or2	952	mount nut - optional
21		979-400	REPAIR KIT - includes items 1,5,14,15,16,17
22	1	1058	warm water manifold
23	1	873H-23	seal (2-134) 70N oring
24	1	873H-24	bolt, pltd steel, 1/4-20 x 1.25" lg hex hd

NOTES

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

- h. 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.
- i. 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.
- j. Screw cap 7 onto cap 3. Hold cap 7 downward so parts stay in place during assembly. Torque to about 20 ft lbs.
- k. Install adjusting screw 9 and knob 10 as shown using Slick 50 or EP grease.

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

