



Kirby Morgan Dive Systems, Inc.®

1430 Jason Way Santa Maria, California 93455

Phone: 805/928-7772 Fax: 805/928-0342

www.KirbyMorgan.com email: kmdsi@KirbyMorgan.com

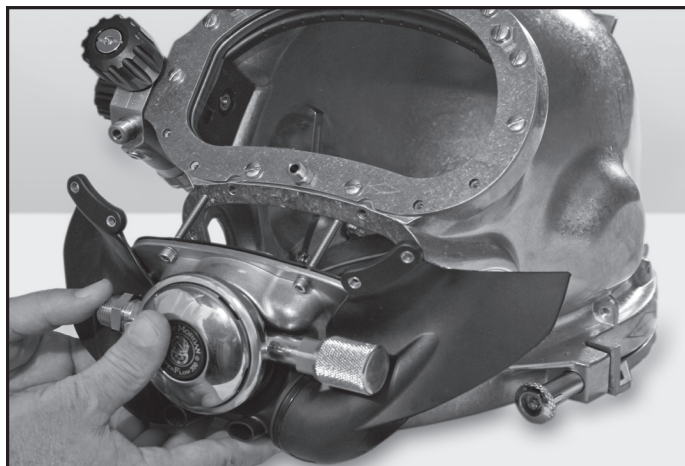
Part #525-395 Conversion Kit, REX Regulator for 37SS & KM 97

PART #	DESCRIPTION	QTY
320-040	Regulator Mount Washer	1
505-278	Regulator Assembly, REX®	1
510-403	Gasket, Pod	1
510-741	Valve, Waterdump	1
510-743	Oral Nasal Mask	1
530-145	Lock Nut	8
550-372	Regulator Mount Nut, Black Chrome	1
555-168	Bent Tube w/O-ring	1
560-516	Regulator Mount Pod REX®	1

Tools Required:

- $\frac{3}{8}$ inch Socket with Driver
- Torque Screwdriver with Flat Blade Attachment
- $\frac{5}{32}$ inch Hex Key
- $\frac{3}{8}$ inch Open End Wrench
- Medium Strength Loctite®

1) See the *Stainless Steel Helmets with SuperFlow® 350 or 455 Balanced Regulators* module in your manual for pod removal, remove the pod/regulator assembly from the helmet shell. Remove the oral nasal mask, then remove and save the oral nasal valve body and valve to be used with the new oral nasal mask.



*Remove the pod/regulator assembly
from the helmet shell*



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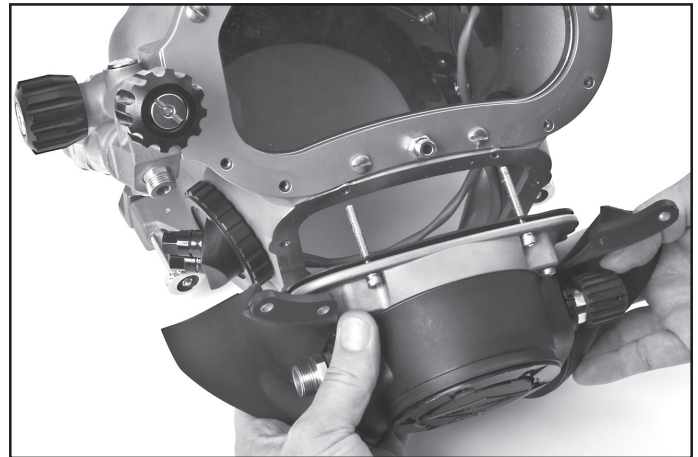
2) Install the washer and regulator assembly into the helmet, threading the regulator mount nut as you feed the regulator assembly in, hand tight only.

3) Work around the edge of the whisker where it meets the helmet shell to align the rubber grooves at the back of the whisker, to the grooves on the pod.

4) Install the gasket on the pod. Make sure that the ridge on the gasket is properly seated in the groove in the pod.

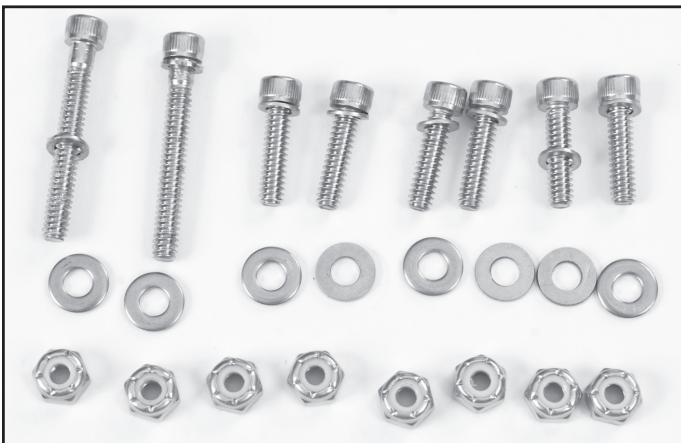
5) Install all of the allen screws and washers through the pod and gasket, with the exception of the bottom two. The screws will help to align the pod and gasket to the helmet.

Remember that the two long screws are installed in the top two holes of the pod, between the top of the regulator cover and the port retainer.



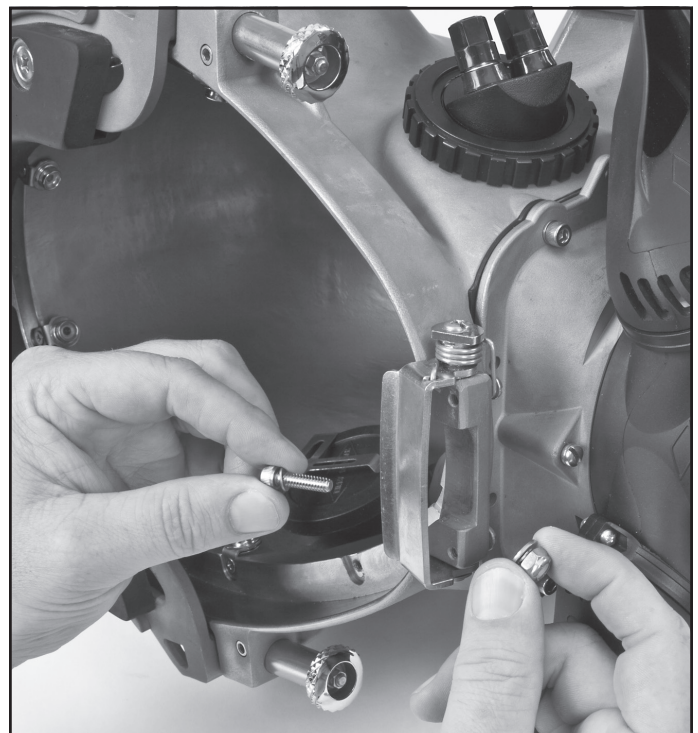
Install the new pod/regulator assembly onto the helmet shell.

7) Install the remaining two bottom screws, washers and nuts. Run the nuts up until they are finger tight. The nuts are positioned on the outside of the pod on the two screws on the bottom, below the regulator



Note that there are eight screws that secure the pod to the helmet. Six screws are "short" while two are "long." The two longer screws are installed in the top two holes in the pod.

6) Install the new pod/regulator assembly onto the helmet shell.



The two nuts below the regulator are installed on the outside of the pod.

8) Tighten the screws onto the helmet. The numbers



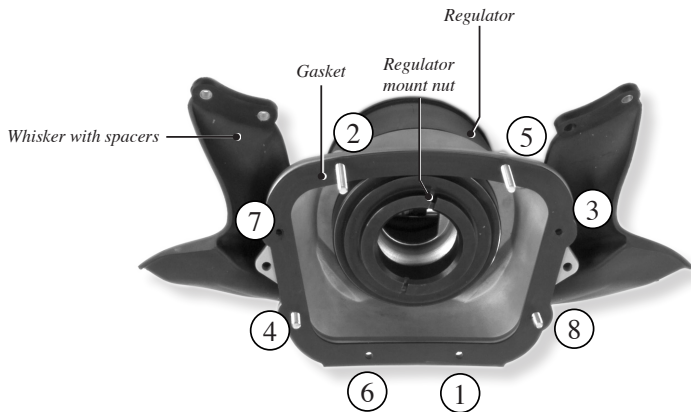
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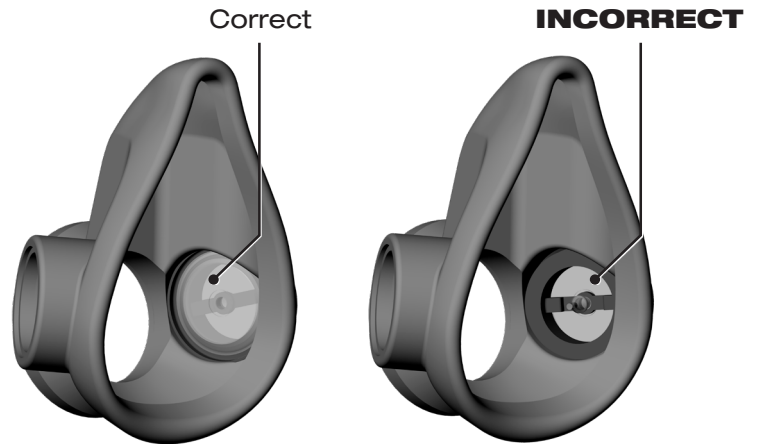
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indicate the order in which the screws and nuts that retain the pod are tightened to connect the pod to the helmet. See figure 4. Tighten the screws gradually, moving from one to another. Do not overtighten. Carefully watch the gasket as you tighten the screws—tightening until the gasket barely begins to extrude from between the pod and helmet shell.



the new oral nasal mask. Make certain the valve direction is correct.



11) Install the bent tube into the inlet nipple, 3 or 4 turns. If needed, turn the regulator assembly on the helmet to allow alignment of the bent tube to the side block.

12) Lightly lubricate the male threads on the side block and swing the bent tube up into place and torque the bent tube to the side block.

13) Apply medium strength Loctite® to whisker screws before installing. Install the whisker spacers, zinc anodes or kidney plates if present, and screws that secure the whiskers. Torque whisker screws to 15 in/lbs.



Tighten the nuts in a staggered pattern.

9) The whisker should have a straight angled surface from the helmet shell towards the outer edge of the regulator. Realign if needed.

10) Install the oral nasal valve body and valve into



The whiskers are fastened to the face port using two screws on each side.



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Only use a torque screwdriver to tighten the screws that secure the whiskers to the face port.