



# R67 Installation and Maintenance

**MASTER PNEUMATIC - DETROIT, INC.**

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JAA 10-02-07  
REV 8-14-08  
(ECN 4453)

## PRODUCT NUMBERS:

R67-1  
R67-2  
R67-3

## THANK YOU!

You have just purchased a quality Regulator from Master Pneumatic.

With care in its installation and maintenance, you can expect it to have a long and economical service life. Before you go any further, please take a few minutes to look over this information, then save it for future reference and for the useful service information it contains.

## Installation & Operation Procedures

### INSTALLATION:

1. Depressurize and lockout air pressure.
2. Upstream pipes must be free of dirt and liquids.
3. Filters should be installed immediately ahead of Regulators to insure a clean supply of air.
4. Install the Regulator as near as possible to the device it is to serve.
5. Install the Regulator so that air flows in direction of arrow on the head.
6. The Regulator can be installed in any orientation.
7. The Regulator has gauge ports on both sides of the head. It is necessary to install a pressure gauge or pipe plugs into each port before operating.
8. Regulators should be installed upstream of any Lubricators in the airline.

### OPERATION:

1. Before turning on air pressure, turn the Adjustment Knob counter-clockwise until compression is released from spring. After air pressure is on, turn Adjustment Knob clockwise to desired pressure.
2. To decrease pressure setting, always reset from a pressure lower than the final setting desired. For example, lowering pressure from 100 psi to 50 psi should be done by decreasing pressure to 30 psi then increasing to 50 psi.
3. When desired pressure is set, tighten the Nut to the Dome.

### TO CLEAN OR REPAIR:

1. Depressurize and lockout air pressure.
2. Loosen Nut, and turn Adjustment Knob counter-clockwise until compression is released from spring.
3. Dome can be removed by turning counter-clockwise.
4. Piston and U-Cup can now be removed.
5. Visually inspect Piston and U-Cup for defects. If necessary replace.
6. The Valve Seat can be removed by turning counter-clockwise.
7. The Valve and Valve Spring can now be removed.
8. Visually inspect Valve for defects. If necessary replace.
9. When re-assembling, be sure that all seals are correctly located. Torque Valve Seat 10-20 in-lbs. Torque Dome minimum 150 in-lbs.
10. If the Regulator cannot be repaired by cleaning with soap and water, the parts should be replaced.

## Replacement Parts

### Replacement Parts

KIT DESCRIPTION	PART NUMBER
Valve Assembly	A33-533
Valve Assembly - Viton	A33-533V
Piston Assembly - Relieving	A60R-29
Piston Assembly - Non-Relieving	A60R-29A



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## Parts Listing

KEY	DESCRIPTION
1	Head
2	Valve Guide
3	Valve Spring
4	Valve
5	O-Ring
6	Valve Seat
7	U-Cup
8	Piston
9	Main Spring
10	Dome
11	Spring Rest
12	Lock Nut
13	Adjustment Knob

