



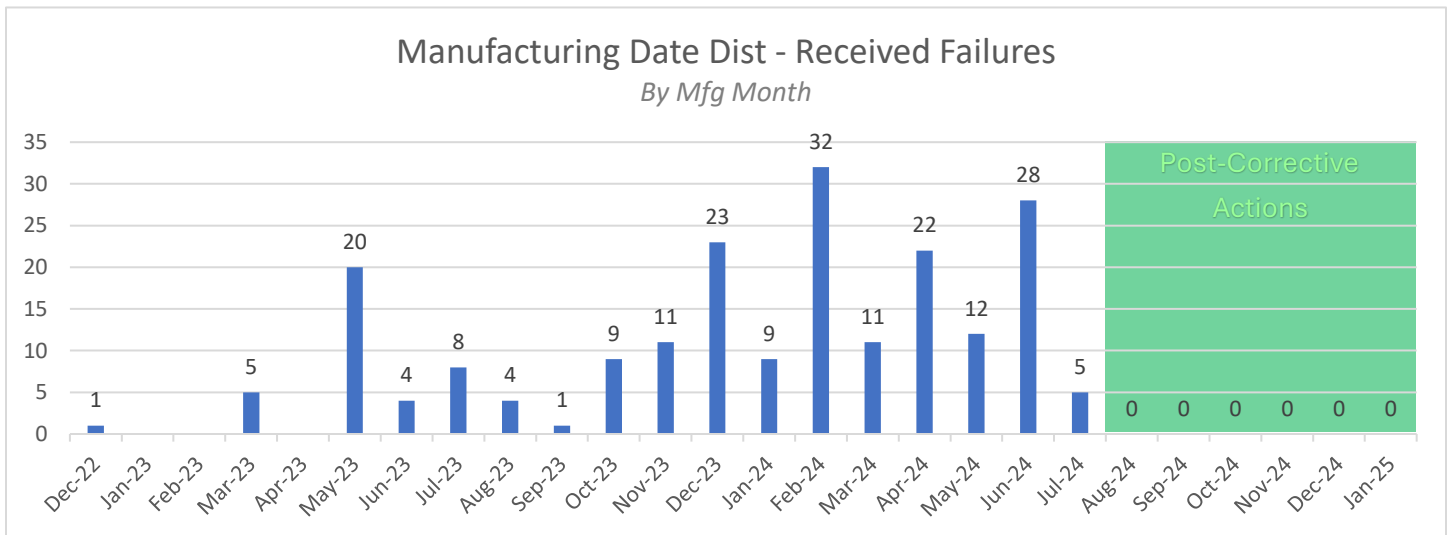
TECHNICAL BULLETIN

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Creeping Pressure on Primary Regulators – CAR202407-01

Field complaints have been received relating to creeping pressure in certain models of primary regulators. Beginning in March of 2024 and recurring in June and July with an upward trend in the 3rd and 4th quarter. The problem has been identified as relaxation of the compression force on the Teflon seat in the regulator’s Capsule. Internal testing is yet to determine if there is actual movement of the thread, or if the behavior is isolated to the flow properties of the seat under tension.

The graph below shows the build dates in which this defect has been confirmed. The total volume of failures received represents a .06% failure rate of the parts sold in those same months.



This failure can be identified by gradual rising of the regulated pressure up to activation of the safety relief valve.

Internal Corrective Action

The problem was related to a new process implemented in 2023 which introduced variability to the fastening torque applied to the Capsule. This process change has been reversed, and new heavier duty and higher precision drivers were implemented in July of this year. As part of the containment measures, a secondary manual torquing process was implemented in July and remains in effect until more reliability data is available.

These changes allow for greater consistency and accuracy of the fastening process for the Capsule.

Field Corrective Action

Regulators inside the 12-month warranty period which are experiencing creep, as defined in Taprite’s work instruction EWI-0101 when tested with a C02 bottle, should be returned to Taprite for replacement.

Alternatively, these can be field serviced by removing the capsule, clearing shavings and other debris from the capsule area and Teflon seat, and then retorquing the capsule to 40 inlbs.