



Kirby Morgan Dive Systems, Inc.®

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Part # 825-041 Metal Buckle Assembly Kit

Parts Needed (In Order Of Assembly):

Part #	Description	Qty
845-001	Buckle Assembly, Metal	2
820-026	Buckle Tab Hold Plug	2
820-030	Buckle Cap	2
820-031	Buckle Cap Retainer	2
820-025	Lock Plug	2
820-225	Strap Keeper	2

Points Of Importance:

P/N 820-026, Buckle Tab Hold Plug:

Note the 4 small engagement arms and hooks. When inserting into the mask, be careful to make sure that all 4 go evenly into the mounting hole. If not done carefully, it is possible for 1 or more of the legs to slip out of the hole when inserting, and possibly damaging the part. See Figure 1.

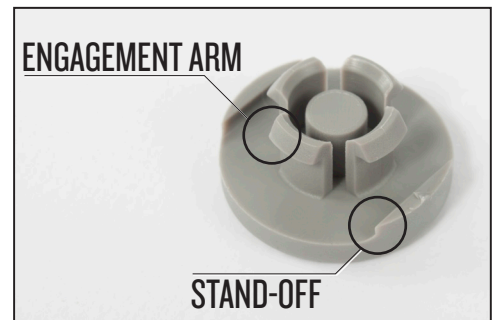


Figure 1

The underside of this part also has 2 small spacing stand-offs. These should be aligned with the sides of the buckle mount tab and Not the rounded end of the tab, when installing. Once this plug is properly installed, the stand-offs can be aligned anywhere. See Figure 1 and Figure 2.

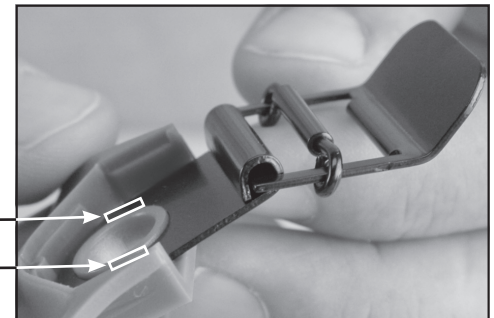


Figure 2

Procedures:

- 1) Place P/N 845-001, Metal Buckle onto the mask jaw frame as shown, making sure the release tab of the buckle is pointing **AWAY** from the center of the mask. See Figure 2.
- 2) Insert P/N 820-026, Buckle Tab Hold Plug, as shown. Keep in mind the important point previously mentioned. When properly installed, the hooks should look as shown. See Figure 3.
- 3) Insert the 2 legs with hooks onto P/N 820-030 Buckle Cap, into the mask frame, at a slight angle so the small alignment pin at the front of the cap will fit into its mating hole. Now press forward



Figure 3

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and down, until the buckle cap snaps into place on the mask / jaw frame. The Cap assembly should fit as shown. See Figure 4.

- 4) On the back side of the mask, jaw, frame, you will see where the buckle cap attachment hooks fit with the frame. P/N 820-031 Buckle Cap Retainer has 2 small tabs that fit against the hooks and fill in the space there. See Figure 5. This prevents the buckle cap from coming free.
- 5) Press P/N 820-025 Lock Plug in between the 4 hooks as shown. This prevents the hooks from flexing and causing the entire assembly from coming away from the mask. If the buckle is rotated by hand, the lock plug should follow the same movement. See Figure 6.
- 6) Install P/N 820-225 Strap Keeper as shown in figure 7 below. Take note that the flat edge is facing inward and the open ends facing outward.



Figure 4

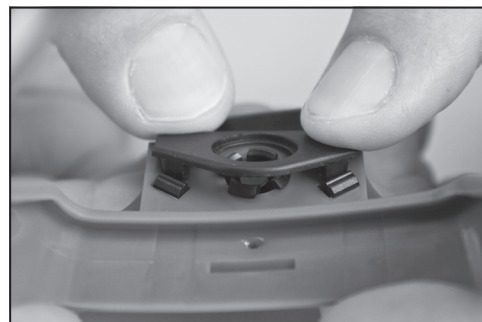


Figure 5

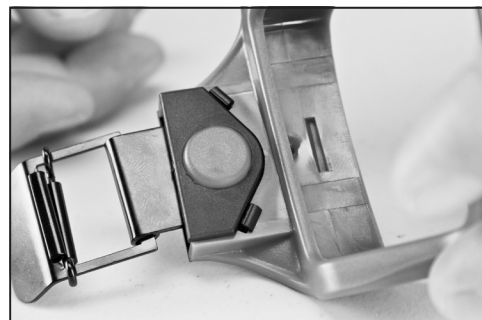


Figure 6

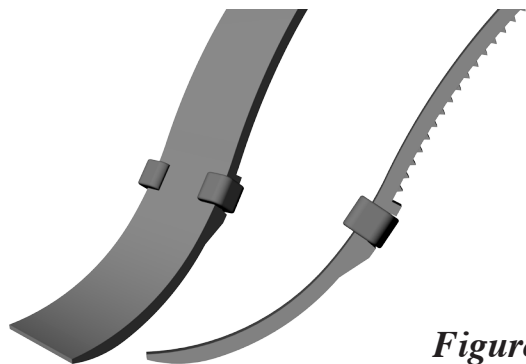


Figure 7

NOTE: Be certain to check fit of all the components on a regular basis, at the beginning of every dive and also after final cleanup. If these parts loosen, this may allow the buckle assembly to separate from the mask.

