

36A CONTROL UNIT REQUIREMENTS AND ADJUSTING PROCEDURES

1. GENERAL

1.01 This section covers the No. 36A Control Unit.

1.02 This section is reissued to incorporate material from the addendum in its proper location. In this process marginal arrows have been omitted.

1.03 Reference shall be made to Section 020-010-711 covering General Requirements and Definitions for additional information necessary for the proper application of the requirements listed herein.

*1.04 **Asterisk:** Requirements are marked with an asterisk (*) when to check for them would necessitate the dismantling or dismantling of apparatus, or would affect the adjustment involved or other adjustments. No check need be made for these requirements unless the apparatus or part is made accessible for other reasons or its performance indicates that such a check is advisable.

1.05 Before checking or readjusting to meet the requirements the equipment should be taken out of service.

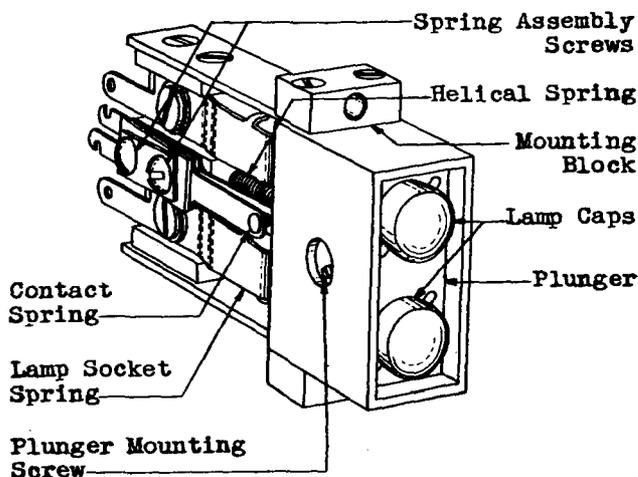


Fig. 1 - No. 36A Control Unit

2. REQUIREMENTS

2.01 *Cleaning*

(a) The contacts shall be cleaned when necessary in accordance with the section covering cleaning procedures for key contacts.

(b) Other parts shall be cleaned when necessary in accordance with approved procedures.

2.02 **Plunger Movement:** The plunger shall work freely and when released unrestrained shall return to its normal position with a snap. Gauge by eye and feel.



Fig. 2 - Contact Alignment

*2.03 **Contact Alignment** — Fig. 2 (A): The contacts shall line up so that the contact point falls wholly within the boundary of the opposing contact disc at all times during contact. Gauge by eye.

*2.04 **Contact Separation:** The separation between the normally open contacts shall be
Min. .016"

Gauge by eye. Use the .016" blade of the KS-6909 gauge as a reference.

*2.05 **Contact Follow:** The follow of the front contact spring shall be

Min. .010"

Gauge by eye.

*2.06 **Contact Pressure:** With the plunger operated to the end of its stroke, the contact pressure shall be

Min. 55 grams

Use the No. 68B gauge.

***2.07 Separation Between Springs:** There shall be a separation between springs, whether in their operated or unoperated position, of Min. .016"

Gauge by eye. Use the .016" blade of the KS-6909 gauge as a reference.

3. ADJUSTING PROCEDURES

3.001 List of Tools, Gauges and Material

CODE NO.	DESCRIPTION
TOOLS	
319B	Lamp Cap and Number Plate Extractor
485A	Smooth Jaw Pliers
—	3" Cabinet Screwdriver
GAUGES	
68B	70-0-70 Gram Gauge
—	KS-6909 Thickness Gauge Nest
MATERIAL	
—	KS-7860 Petroleum Spirits
—	KS-2423 Cloth
—	or
—	D-98063 Cloth

3.002 When necessary, to check requirements or make adjustments, remove the mounting screws at the rear of the frame with the 3" cabinet screwdriver and withdraw the unit from the mounting.

3.01 Cleaning (Rq. 2.01)

(1) Clean the contacts as outlined in the section covering cleaning procedures for key contacts. Clean the plunger and plunger rod as outlined in 3.02 (1).

3.02 Plunger Movement (Rq. 2.02)

(1) If the plunger does not work freely, remove the plunger mounting screw with the 3" cabinet screwdriver and remove the plunger. Wipe off the plunger and inside of

the plunger housing with a clean dry D-98063 cloth. Place a few drops of petroleum spirits on the plunger rod and replace and operate the plunger a few times. Wipe off the plunger rod with the D-98063 cloth. Repeat this operation until all dirt has been removed.

(2) If the plunger still does not work smoothly, remove the lamp caps with the No. 319B lamp cap and number plate extractor, note whether the lamps are binding in the plunger and if they appear to bind adjust the position of the lamps. If the plunger still does not work smoothly the helical spring is probably weak. Replace the helical spring (P-125297 — Coil Spring) with a new spring.

3.03 Contact Alignment (Rq. 2.03)

(1) If the contacts do not line up satisfactorily, loosen the spring assembly screws with the 3" cabinet screwdriver and shift the springs until the contact point lies wholly within the opposing contact disc, preferably as near the center as possible. Tighten the assembly screws securely.

3.04 Contact Separation (Rq. 2.04)

3.05 Contact Follow (Rq. 2.05)

3.06 Contact Pressure (Rq. 2.06)

3.07 Separation Between Springs (Rq. 2.07)

(1) Adjust the front contact spring with the No. 485A pliers applied near the base of the spring where it leaves the clamping plate and insulators.

(2) If the contact separation, contact follow or contact pressure requirement cannot be met due to a wide gap between the curved end of the plunger spring and the plunger or if there is insufficient separation between springs due to bent springs remove the spring assembly mounting screws with the 3" cabinet screwdriver and remove the plunger springs. Straighten bent springs and adjust the plunger springs, as required, with the No. 485A pliers. Reassemble the spring assembly and tighten mounting screws securely.