

## SMALL CROSSBAR SWITCH REQUIREMENTS AND ADJUSTING PROCEDURES

### 1. GENERAL

- 1.001** This addendum supplements Section 030-721-701, Issue 5.
- 1.002** This addendum is issued to:
- Revise requirement in 2.11(f)(2) to add information concerning minimum working length of paddle wire.
  - Revise note following 2.11(g)(2) to provide additional instructions for preventing select wire flipping.
  - Change Figure 12 to identify outermost face of core.
  - Revise 3.001 to add tools and gauges to list.
  - Add 3.11(4)(c) concerning use of additional tools and gauges for checking the holding armature.

### 2. CHANGES TO SECTION

- 2.001** On Page 8, revise Paragraph 2.11(f)(2) to read:

When the associated operate card is operated, a minimum working length equivalent to a one paddle wire diameter for a test condition or a two paddle wire diameters for a readjust condition shall remain between the select wire and the free end of the paddle. Maximum travel toward the free end of the paddle occurs when the level is selected and the hold armature is operated.

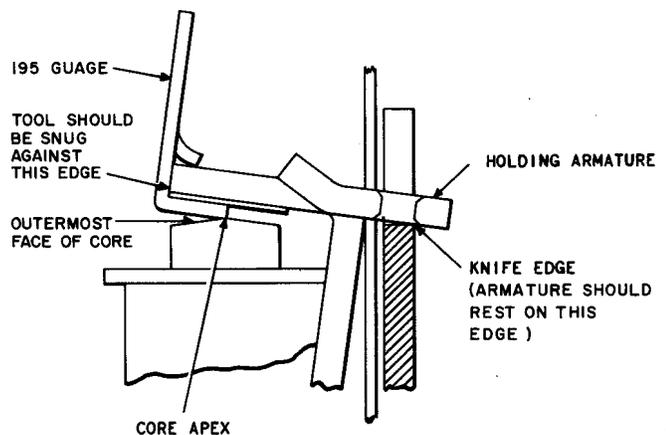
Gauge by eye.

- 2.002** On Page 8, revise Paragraph 2.11(g) note to read:

**Note:** Failure to comply with Requirements 2.11(f) and (g) can result in flipping the hairpin select wire

so that both legs rest on the same side of the paddle with the loss of one level of crosspoint operation. In some instances hairpin select wire flipping may occur even though Requirements 2.11(f) and (g) are met. When this occurs it is necessary to readjust the holding core to eliminate the flipped hairpin select wire trouble condition which is occurring because the holding armature is buckling the select wire against the vertical unit base. Such undesirable buckling action is caused by the armature seating on the outermost face of the holding core and rocking away from the knife edge at the closed gap position.

- 2.003** On Page 12, change Figure 12 to identify the location of the "Outermost Face of Core."



**Fig. 12—Method of Measuring Holding Armature Core Gap**

- 2.004** On Page 15, add the following to the list of tools and gauges, Paragraph 3.001.

Tools	Description
376-A	Mirror, Magnifying

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**Gauges**

195J            Hold Armature Core Gap Gauge,  
                  .050 thick, with tab.

195K            Hold Armature Core Gap Gauge,  
                  .055 thick, with tab.

**2.005**    On Page 19, add (c) to Paragraph 3.11(4).

(c) Where a flipped hairpin select wire occurs even though the paddle to select wire positioning conforms to Requirement 2.11(f) readjust the associated vertical unit holding core as follows.

(1) Install the 195J or 195K gauge on the holding armature as shown in figure 10.

(2) Loosen the core mounting screw with the 541A wrench and move the core up against the mounted gauge.

(3) Apply a light force to the end of the core with a KS-6320 orange stick to keep it seated against the mounted armature gauge and retighten the core mounting screw.

(4) Remove the gauge from the armature and with the 376-A mirror insure that the armature is not seating on the outermost face of the holding core.

(5) Check for Requirement 2.28 and Requirement 2.33.

(6) Readjust the core and stop bracket if necessary.