

459-TYPE PLUGS

MOUNTING AND USE ON SMALL CROSSBAR SWITCHES

1. GENERAL

1.01 This section covers the method of mounting 459-type plugs on small crossbar switches for service observing, line test, and make-busy applications.

1.02 This section is reissued for the following reasons:

- (a) To add electrical tape to List of Tools and materials in 3.01
- (b) To add 3.02(b) which provides instructions for obtaining operating clearance on the front tab of the holding off-normal (HON) restoring spring on some switches of early manufacture
- (c) To revise 3.03 and 3.04 to add reference to 3.02(b)
- (d) To make other changes as required.

1.03 The 459-type plug (Fig. 1 and 2) consists of a 2-part, molded shell containing preformed contact springs and, in some cases, a grounding spring. Clamp springs fasten the shell halves together and prevent reopening of the shell after assembly. When mounted in position on the switch, the plug is self-supporting.

2. USE OF 459-TYPE PLUGS

2.01 The 459-type plug design covers seven variations that are distinguished by code suffix A through G. Selection of a particular code depends on the intended use of the plug and the number of multiple strips in the associated vertical unit.

2.02 The types and their prospective uses are described in Table A.

3. MOUNTING PROCEDURES

3.01 *List of Tools and Materials*

CODE OR
SPEC NO.

DESCRIPTION

TOOLS

363 Spring adjuster

Materials

— ◆Plastic electrical tape, 0.007 inch thick◆

3.02 *General*

(a) Before inserting the plug on the vertical unit, as shown in Fig. 3, position the slots of the plug in line with the vertical bars of the switch and the jaw of the plug in line with the metal lug of the frame.

(b) ◆*Vertical Units With HON Springs:* On some switches of early manufacture, the front tab of the HON restoring spring may have been bent slightly forward during adjustment and a fully inserted plug may touch the tab. To provide operating clearance in this case, the fully inserted plug should be backed out approximately 0.020 inch. If desired, the plug may be modified to limit the extent of insertion by applying two layers of plastic electrical tape, approximately 1/8 inch by 3/4 inch by 0.007 inch thick, across the rear surface of the plug jaw. Later manufacture of the switches and plugs will insure clearance in all cases.◆

3.03 *Mounting the 459A or 459B Plug*

(1) When inserting or withdrawing the plug, slightly rock the heel end of the plug up and down to avoid applying excess contact force that might disengage the vertical bars.

(2) Carefully insert the plug until the rear surface of the plug jaw just presses against the metal lug of the frame. ◆See 3.02(b).◆

3.04 *Mounting the 459C D, E, F, or G Plug*

TABLE A

PLUG CODE	INTENDED USE	NO. OF MULTIPLE STRIPS	NO. OF CONTACT SPRINGS	ON CORD NUMBER	CONTACT POSITION GROUNDED	COLOR OF SHELL
459A*	Service Observing	3	3	P3BE	None	Black
459B*	Service Observing	6	6	P6R	None	Black
459C	Mk Bsy	6	6	None	0	Red
459D	Mk Bsy	6	6	None	3	Yellow
459E	Mk Bsy	3	3	None	0	Red
459F See Note	Line Test	3	3	W3BK	None	White
459G	Mk Bsy	3	3	None	2	Green

* Available only on associated cord.

Note: Connected to 471A jack - cord includes KS-8010 switch and 2000 ohms resistance.

- (1) When inserting or withdrawing a plug having a ground spring, slightly rock the heel end of the plug up and down to facilitate depressing and moving the ground spring along the underside of the metal lug.
- (2) Take care to avoid butting the ground spring against the metal lug. The loop of the ground spring, in its free position, should extend $.022 \pm .003$ inch, as gauged by eye, above the front end of the plug jaw.
- (3) If it becomes necessary to reposition the ground spring, use the 363 spring adjuster as follows. Carefully engage the horizontal right end of the ground spring in the slot of the tool. Rotate the tool clockwise to lower or counter-clockwise to raise the height of the loop on the spring.
- (4) Insert the plug until the rear surface of the plug jaw just presses against the metal lug of the frame. See 3.02(b).

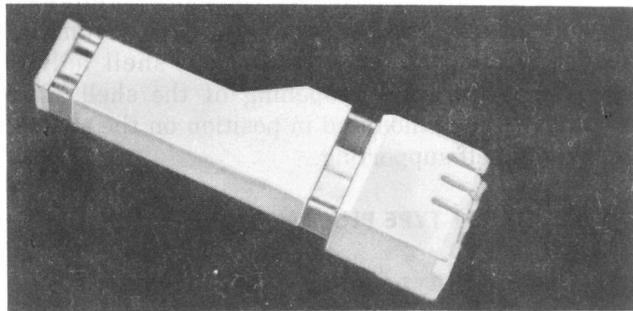


Fig. 1—459-Type Plug (3-Wire Switches)

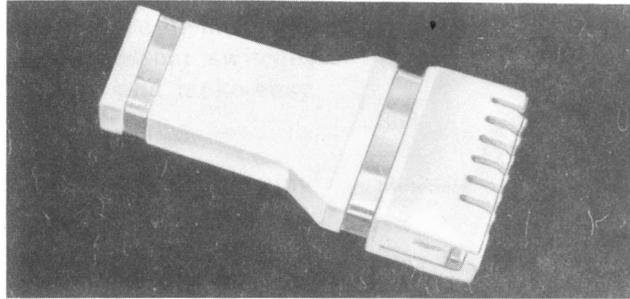


Fig. 2—459-Type Plug (6-Wire Switches)

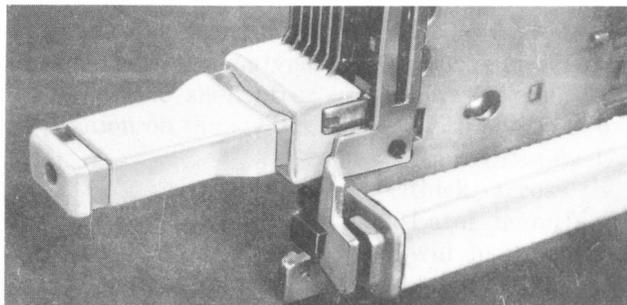


Fig. 3—459-Type Plug (On 6-Wire Switch)