

KEYS 570-TYPE REQUIREMENTS AND ADJUSTING PROCEDURES

1. GENERAL

- 1.01 This section covers 570 type keys.
- 1.02 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.

2. REQUIREMENTS

- 2.01 Cleaning: The contacts shall be cleaned when necessary in accordance with the section covering cleaning procedures for key contacts.

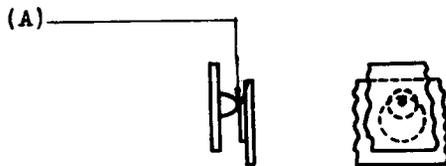


Fig. 1 - Contact Alignment

- 2.02 Contact Alignment - Fig. 1 (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.
- 2.03 Stud Clearance - Fig. 2 (A): The stud shall not rub against the spring through which it passes. Gauge by eye and feel.
- 2.04 Plunger Spring Tension - Fig. 2 (B): With the key unoperated, the plunger spring shall rest against the cam but the tension against the cam shall be
Max. 225 grams
Use the No. 62B gauge.
- 2.05 Contact Separation - Fig. 2 (C): The separation between any pair of contacts normally open or between any pair of contacts that are opened when the key is operated shall be
Min. .012"
Gauge by eye. Use the .012" blade of the KS-6909 gauge as a reference.
- 2.06 Contact Follow - Fig. 2 (D): The contact follow for the contacts of the break spring combination shall be
Min. .010"
Gauge by eye.

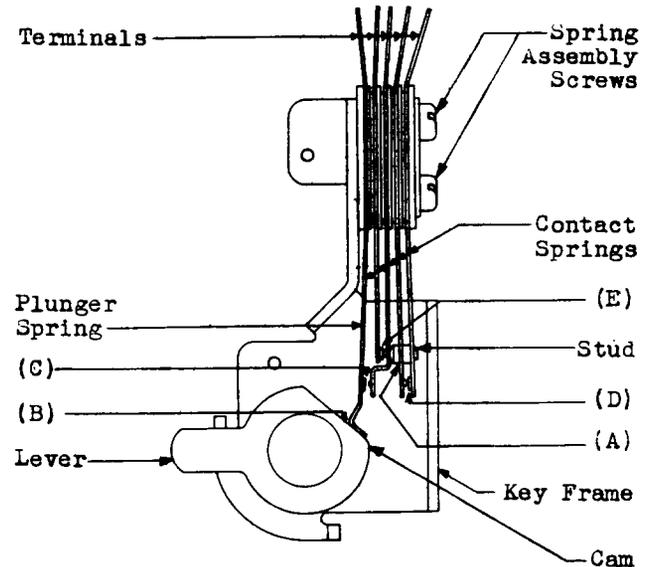


Fig. 2 - No. 570A Key

- 2.07 Contact Pressure - Fig. 2 (E): The contact pressure of the normally closed contacts shall be
Min. 55 grams
Use the No. 68B gauge.
- 2.08 Spring Clearance
- (a) There shall be a clearance between springs designed never to make contact and between any spring and the frame of
Min. .015"
Gauge by eye. Use the .015" blade of the KS-6909 gauge as a reference.
- (b) There shall be a clearance between springs designed to make contact, except at the contact, of
Min. .008"
Gauge by eye.

3. ADJUSTING PROCEDURES

3.001 List of Tools and Gauges

Code No.	Description
<u>Tools</u>	
485A	Smooth Jaw Pliers
-	3" Cabinet Screwdriver
<u>Gauges</u>	
62B	0-700 Gram Gauge
68B	70-0-70 Gram Gauge
-	KS-6909 Thickness Gauge Nest

SECTION 032-725-701

3.002 When necessary, to facilitate checking requirements or making adjustments, remove the switch on which the key is mounted, from the frame.

3.01 Cleaning (Rq.2.01)

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

3.02 Contact Alignment (Rq.2.02)

3.03 Stud Clearance (Rq.2.03)

(1) If the contacts do not line up properly or the stud rubs against the contact spring through which it passes, loosen the spring assembly screws with the 3" cabinet screwdriver and shift the springs as required. Tighten the assembly screws securely.

3.04 Plunger Spring Tension (Rq.2.04)

3.05 Contact Separation (Rq.2.05)

3.06 Contact Follow (Rq.2.06)

3.07 Contact Pressure (Rq.2.07)

3.08 Spring Clearance (Rq.2.08)

(1) Adjust for spring tension, contact separation, contact follow or contact pressure with the No. 485A pliers. Adjust the springs near the base at the point where they leave the clamping plate and insulators.

(2) 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 springs. Straighten bent springs, as required, with the No. 485A pliers. Reassemble the spring assembly and tighten the assembly mounting screws securely.