

## KEYS

### 580 AND 581 TYPES AND ASSOCIATED KEYSHELF BUSHING

### PIECE-PART DATA AND REPLACEMENT PROCEDURES

#### 1. GENERAL

1.01 This section covers information for ordering parts to be used in the maintenance of Nos. 580A and 581A keys and the approved procedures for replacing these parts. It also covers the approved procedure for replacing the keyshelf bushing.

1.02 Part 2 of this section covers the piece-part numbers and the corresponding names of the parts which it is practicable to replace in the field in the maintenance of these keys. No attempt should be made to replace parts not designated. Part 2 also contains an explanatory figure showing the different parts. This information is called Piece-part Data.

1.03 Part 3 of this section covers the approved procedures for the replacement

of the parts covered in Part 2. This information is called Replacement Procedures.

#### 2. PIECE-PART DATA

2.01 The figure included in this part shows the various parts of the keys and their piece-part numbers together with their corresponding names.

2.02 Where the names of the piece parts as used by the Western Electric Company Merchandise Department differ from those in general use in the field, the latter names, in some cases, are shown in parentheses.

2.03 When ordering piece parts for replacement purposes, give both the number and the name of the piece part; for example, P-384083 cotter pin. Do not refer to the BSP number or to any explanatory information

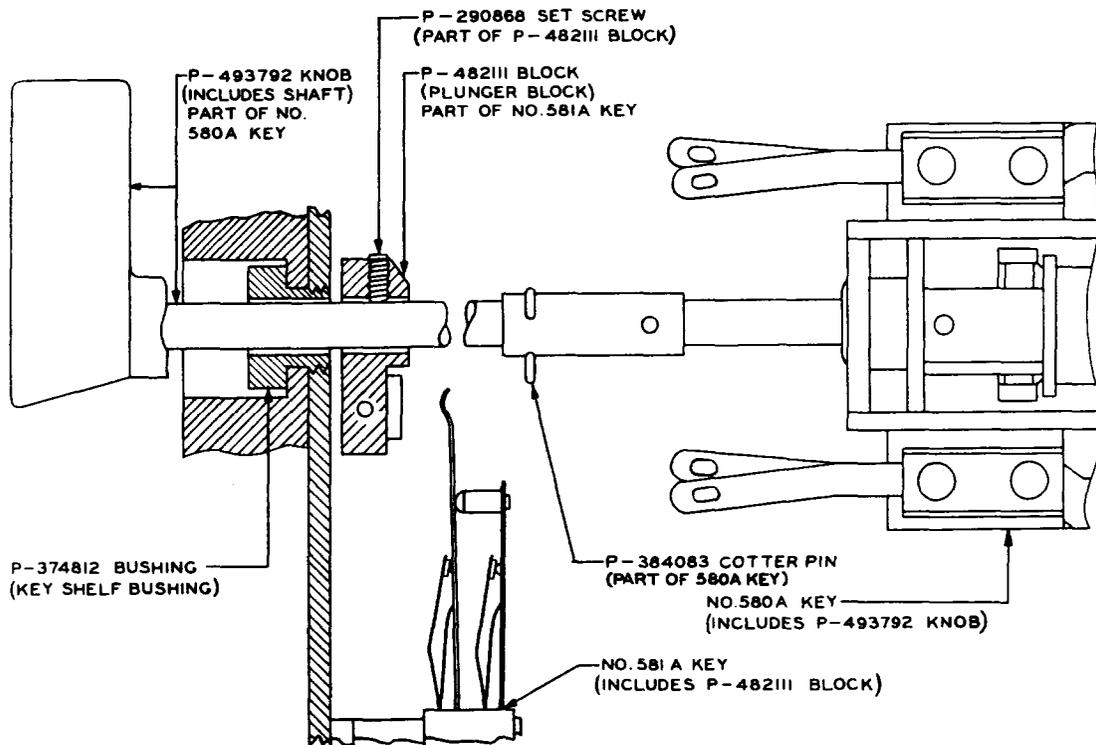


Fig. 1 - Nos. 580A and 581A Keys and  
Associated Keyshelf Bushing

## SECTION 032-726-801

shown in parenthesis following the piece-part number.

### 3. REPLACEMENT PROCEDURES

#### 3.01 List of Tools

- 3-inch Cabinet Screwdriver
- 4-inch Regular Screwdriver
- 564A Offset Screwdriver
- 6-1/2-inch P-long-nose Pliers
- R-2959 Allen Socket Screw Wrench

3.02 No replacement procedures are specified for screws and other parts where the replacement consists of a simple operation.

#### No. 580A Key

3.03 General: The No. 580A key is composed of the knob and shaft assembly which is mounted on the keyshelf, and the key frame and spring combination which is mounted on the rear mounting plate of the cord unit. If only the key frame and spring combination is to be replaced, the knob and shaft furnished with the replacing key need not be used.

3.04 Key Frame and Spring Combination: To replace the key frame and spring combination of the No. 580A key, remove the No. 348A plug from the connector. Loosen the two cowl fasteners located at the top and bottom of the cord unit by turning them toward the left (counterclockwise) with the 4-inch regular screwdriver and remove the cord unit. Remove the cover. Tag and unsolder the wires from the springs of the key spring combination. Remove the cotter pin from the coupling and shaft with the 6-1/2-inch P-long-nose pliers. Remove the two screws that mount the key frame on the mounting plate with the No. 564A offset screwdriver. Mount the new key frame and spring combination, tighten the mounting screws securely, resolder the leads, insert and clinch the new cotter pin as shown in Fig. 2, and remount the cord unit.

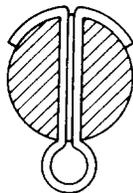


Fig. 2 - Method of Clinching Cotter Pin to Clear Wiring

3.05 Knob: To replace the knob, remove the cord unit as covered in 3.04. Loosen the two setscrews that hold the plunger block of the No. 581A key to the shaft with the R-2959 Allen socket screw wrench. Remove the cotter pin from the coupling and shaft with the 6-1/2-inch P-long-nose pliers. While supporting the plunger block, remove the knob and its associated shaft. If the keyshelf bushing is worn, replace the bushing as covered in 3.09. Slide the shaft of the new knob through the keyshelf bushing and through the hole in the plunger block. During this operation, the finger portion of the knob should be in the upward position and the spring combination of the No. 580A key should be in the unoperated position but with the shaft pulled out. Insert a new cotter pin as shown in Fig. 2. The two setscrews in the plunger block should then be tightened on the shaft with the Allen socket screw wrench so that the position of the plunger block is in accordance with the requirements for plunger block position for the No. 581A key as outlined in Section 032-726-701. A slight burr on the shaft at a previous position of the setscrew may prevent the plunger block from moving freely on the shaft or cause it to shift when the setscrew is tightened. In this case, remove the burr by scraping with the blade edge of a screwdriver. Remount the cord unit.

#### No. 581A Key

3.06 General: The No. 581A key is composed of the plunger block which is mounted on the shaft of the No. 580A key, and the key bracket and spring pile-up which is mounted on the side plate of the cord unit. If only the key bracket and spring pile-up are to be replaced, the plunger block furnished with the replacing key need not be used.

3.07 Key Bracket and Spring Pile-up: To replace the key bracket and spring pile-up of the No. 581A key, remove the cord unit as covered in 3.04. Tag and unsolder the leads from the springs, remove the bracket mounting screws with the 3-inch cabinet screwdriver, and remove the key bracket from the side plate. Mount the new key bracket and spring pile-up on the side plate, tighten the bracket mounting screws securely, and reconnect and solder all leads. Remount the cord unit.

3.08 Plunger Block: To replace the plunger block, remove the cord unit as covered in 3.04. Loosen the two setscrews that hold the plunger block of the No. 581A key to the shaft with the R-2959 Allen socket screw wrench. Remove the cotter pin from the coupling and shaft with the 6-1/2-inch P-long-nose pliers. While supporting the plunger block, remove the knob and its associated shaft. Remount the knob, replace the plunger block, remount the setscrews and replace the cotter pin, etc., as covered in 3.05.

Keyshelf Bushing

3.09 To replace the bushing, remove the knob and its associated shaft and the plunger block as covered in 3.05.

Remove the bushing through the hole in the keyshelf by unscrewing it from the side plate with the 4-inch regular screwdriver. Insert a new bushing. Reassemble the knob and its associated shaft, and the plunger block as covered in 3.05.