

1A AND 1B TELETYPEWRITER

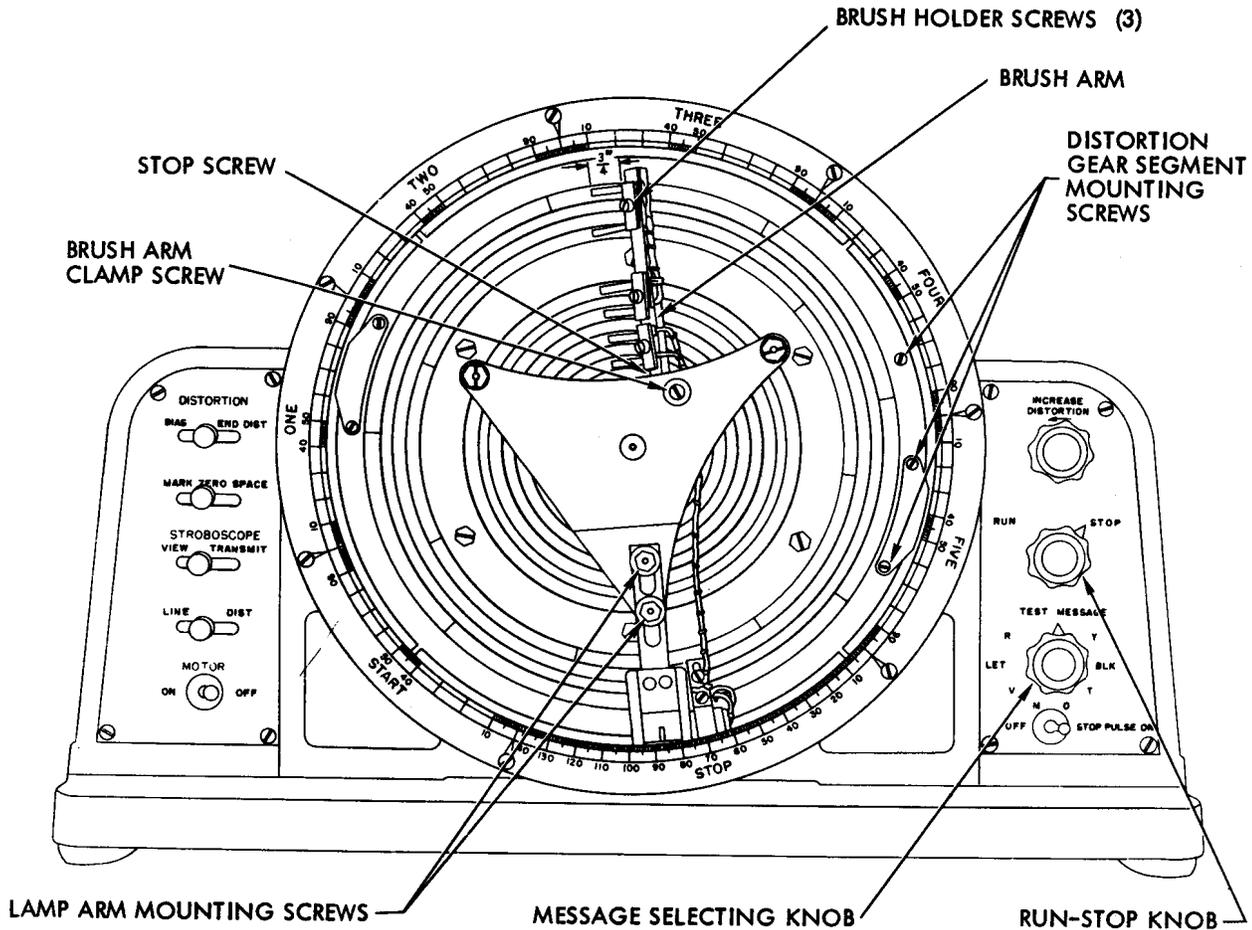
TEST SETS

REQUIREMENTS AND ADJUSTMENTS

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2. REQUIREMENTS AND ADJUSTMENTS

2.01 Distributor Discs

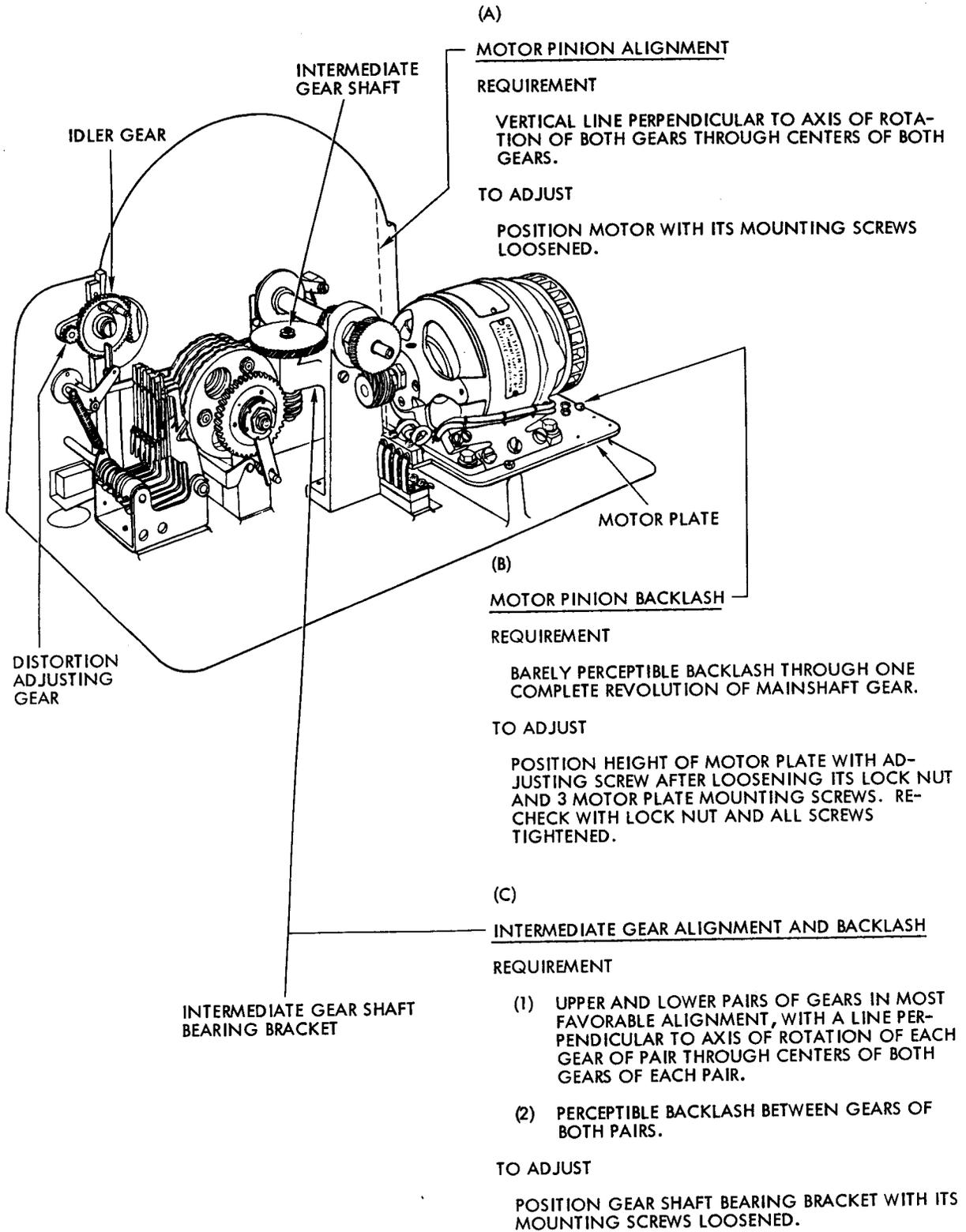


DISTRIBUTOR DISCS

REQUIREMENT

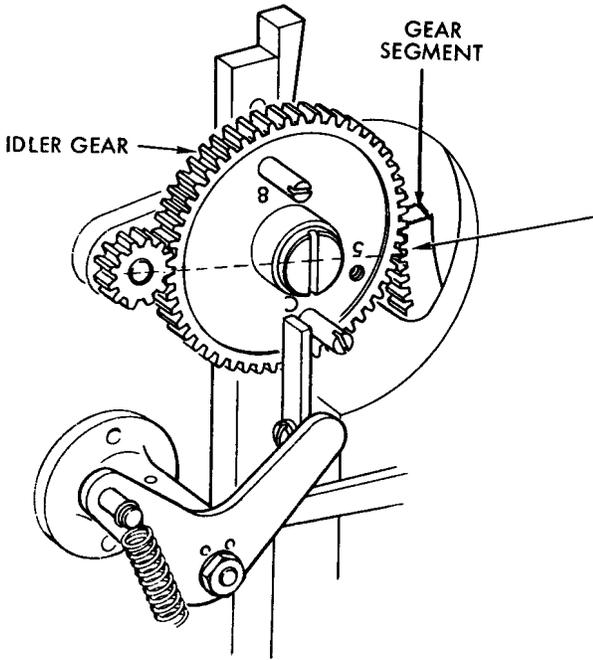
GAPS BETWEEN SEGMENTS IN THE TWO OUTER COMMUTATOR RINGS SHOULD BE CLEANED APPROXIMATELY EVERY 300 OPERATING HOURS. LOOSEN BRUSH ARM SET SCREW AND ROTATE BRUSH ARM SO THAT BRUSHES CLEAR COMMUTATOR RINGS. CLEAN ENTIRE AREA OF DISTRIBUTOR DISCS AND CHECK FOR BRUSH WEAR. REPOSITION BRUSH ARM AND TIGHTEN SET SCREW.

2.02 Motor and Intermediate Gear



2.03 Distortion Adjusting Gears

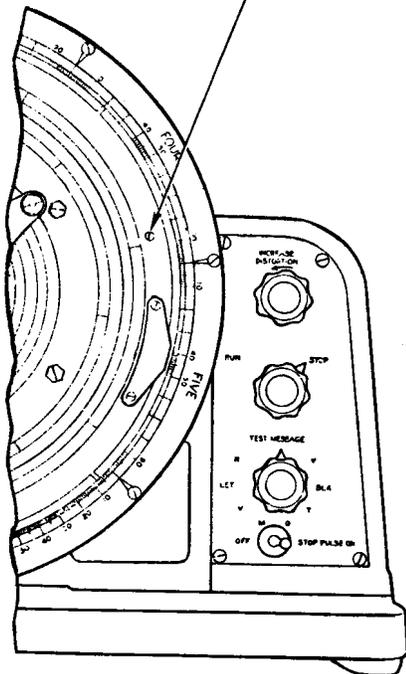
CAUTION
 TO PROTECT BRUSHES, INCREASE DISTORTION KNOB MUST NEVER BE TURNED CLOCKWISE WHEN UNIT IS NOT OPERATING UNLESS BRUSH ARM ASSEMBLY HAS BEEN ROTATED TO LIFT BRUSHES OFF SEGMENTED COMMUTATOR RINGS.



DISTORTION ADJUSTING GEAR SEGMENT
 REQUIREMENT

- (1) WITH INCREASE DISTORTION KNOB IN MAXIMUM CLOCKWISE POSITION, GEAR SEGMENT ON MOVEABLE COMMUTATOR RING SHOULD HAVE ONE OR TWO TEETH REMAINING ABOVE HORIZONTAL CENTER LINE OF IDLER GEAR.

- (2) SLIGHT AMOUNT OF BACKLASH BETWEEN GEAR AND GEAR SEGMENT THROUGHOUT GEAR SEGMENT TRAVEL.



TO ADJUST

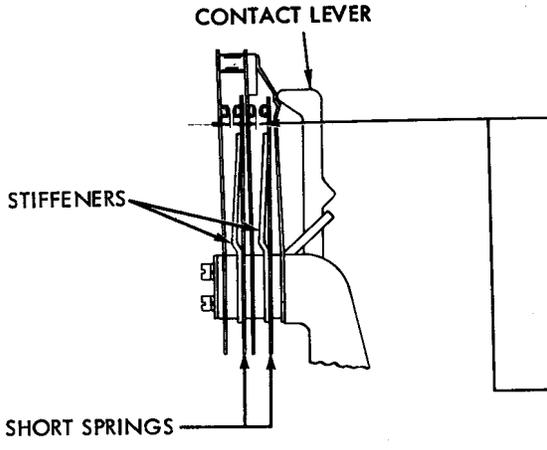
- (1) REMOVE DISTORTION ADJUSTING IDLER GEAR (SECURED BY ONE MOUNTING SCREW) AND REPOSITION IN TEETH OF GEAR SEGMENT TO MEET REQUIREMENT (1). REINSTALL MOUNTING SCREW.
- (2) LOOSEN GEAR SEGMENT MOUNTING SCREWS (THREE SCREWS IN FRONT OF UNIT) FRICTION TIGHT. POSITION GEAR SEGMENT TO MEET REQUIREMENT (2). TIGHTEN MOUNTING SCREWS.

2.04 Transmitting Contacts

TRANSMITTING CONTACTS

NOTE

TRANSMITTING CONTACT ASSEMBLIES ARE NUMBERED FROM 1 TO 5 (1 TO 8 ON 1B), THE NUMBER 5 (8 ON 1B) NEAREST THE FRONT OF UNIT.



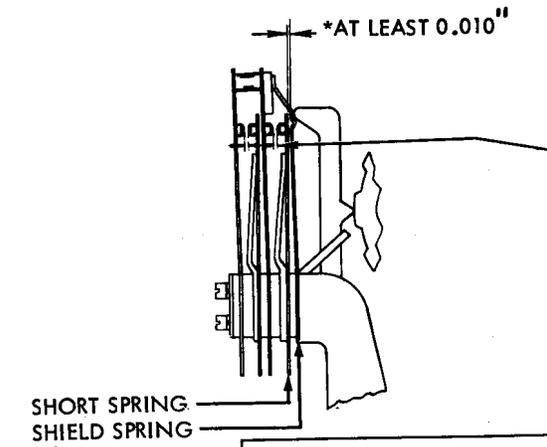
- (1) REQUIREMENT
WITH CODE (MESSAGE) SELECTING KNOB (2.01) IN THE R POSITION (2.05 FOR 1B),
MIN. 0.015 INCH --- MAX. 0.025 INCH
GAP BETWEEN EACH PAIR OF CONTACT POINTS OF CONTACT ASSEMBLIES 1, 3, AND 5.

TO ADJUST
BEND THE SHORT CONTACT SPRINGS AND THEIR STIFFENERS.

- (2) REQUIREMENT
WITH MESSAGE SELECTING KNOB IN THE Y POSITION (SEE 2.05 FOR 1B)

MIN. 0.015 INCH --- MAX. 0.025 INCH
GAP BETWEEN EACH PAIR OF CONTACT POINTS OF CONTACT ASSEMBLIES 2 AND 4.

TO ADJUST
BEND THE SHORT CONTACT SPRINGS AND THEIR STIFFENERS.



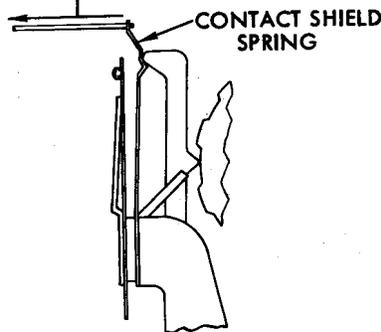
- (3) REQUIREMENT
WITH MESSAGE SELECTING KNOB IN THE TEST MESSAGE POSITION AND CONTACT LEVERS ON HIGH PART OF CAMS
MIN. 0.015 INCH --- MAX. 0.030 INCH
GAP BETWEEN EACH PAIR OF CONTACT POINTS.

TO ADJUST
WITH TRANSMITTING CONTACT ASSEMBLY MOUNTING SCREWS LOOSENED, POSITION THE ASSEMBLY. TIGHTEN MOUNTING SCREWS.

- (4) REQUIREMENT
WITH MESSAGE SELECTING KNOB IN TEST MESSAGE POSITION, CODE CAMS ROTATED UNTIL NUMBER 1 CONTACT LEVER RESTS ON LOW PART OF CAM, AND NUMBER 1 CONTACT LEVER HELD AGAINST ITS CAM,
MIN. 1 OZ. --- MAX. 2 OZS.

TO PULL SPRING AWAY FROM CONTACT LEVER. CHECK EACH CONTACT SHIELD SPRING IN SIMILAR MANNER WITH EACH CONTACT LEVER ON LOW PART OF CAM.

TO ADJUST
BEND CONTACT SHIELD SPRING.

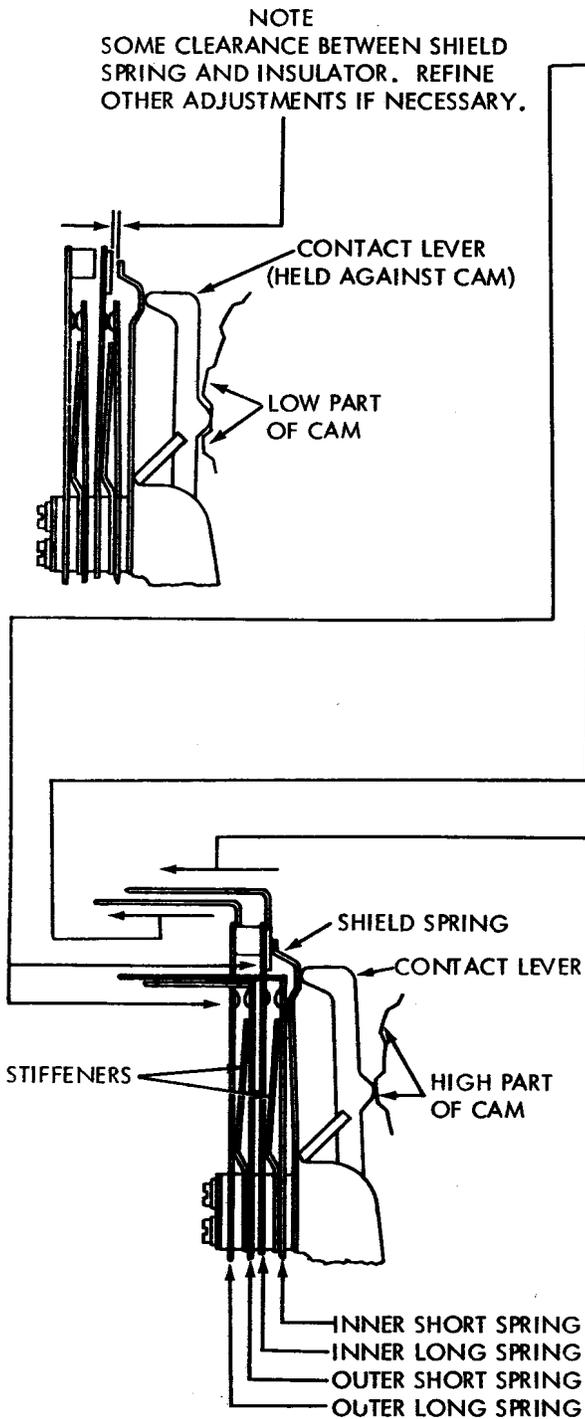


NOTE

- * THERE SHOULD BE A MINIMUM CLEARANCE OF 0.010 INCH BETWEEN CONTACT SHIELD SPRING AND INSIDE SHORT CONTACT SPRING. IF CONTACT SHIELD SPRING POSITIONS ARE CHANGED IN ANY MANNER, RE-CHECK CONTACT GAPS.

CONTINUED

2.05 Transmitting Contacts (Cont)



TRANSMITTING CONTACTS (CONTINUED)

(5) REQUIREMENT WITH SCALE END APPLIED TO SHORT CONTACT SPRING AND PUSHED AT RIGHT ANGLES TO SPRING, MIN. 1 OZ. TO START EACH SHORT CONTACT SPRING MOVING AWAY FROM ITS STIFFENER.

TO ADJUST BEND THE SHORT CONTACT SPRING.

(6) REQUIREMENT WITH SCALE HOOKED ON TOP OF OUTER LONG CONTACT SPRING AND PULLED AT RIGHT ANGLES TO SPRING, MIN. 1 OZ. --- MAX. 2 OZS. TO START EACH OUTER LONG CONTACT SPRING MOVING AWAY FROM ITS INNER LONG CONTACT SPRING.

TO ADJUST BEND OUTER LONG CONTACT SPRING.

(7) REQUIREMENT WITH OUTER LONG CONTACT SPRING HELD AWAY FROM INNER LONG CONTACT SPRING AND SCALE HOOKED OVER TOP OF INNER LONG CONTACT SPRING, MIN. 1 OZ. --- MAX. 2 OZS. TO START EACH INNER LONG CONTACT SPRING MOVING AWAY FROM ITS SHIELD SPRING.

TO ADJUST BEND INNER LONG CONTACT SPRING.

(8) RECHECK REQUIREMENTS (3) AND (5).

TRANSMITTING CONTACTS (1B)

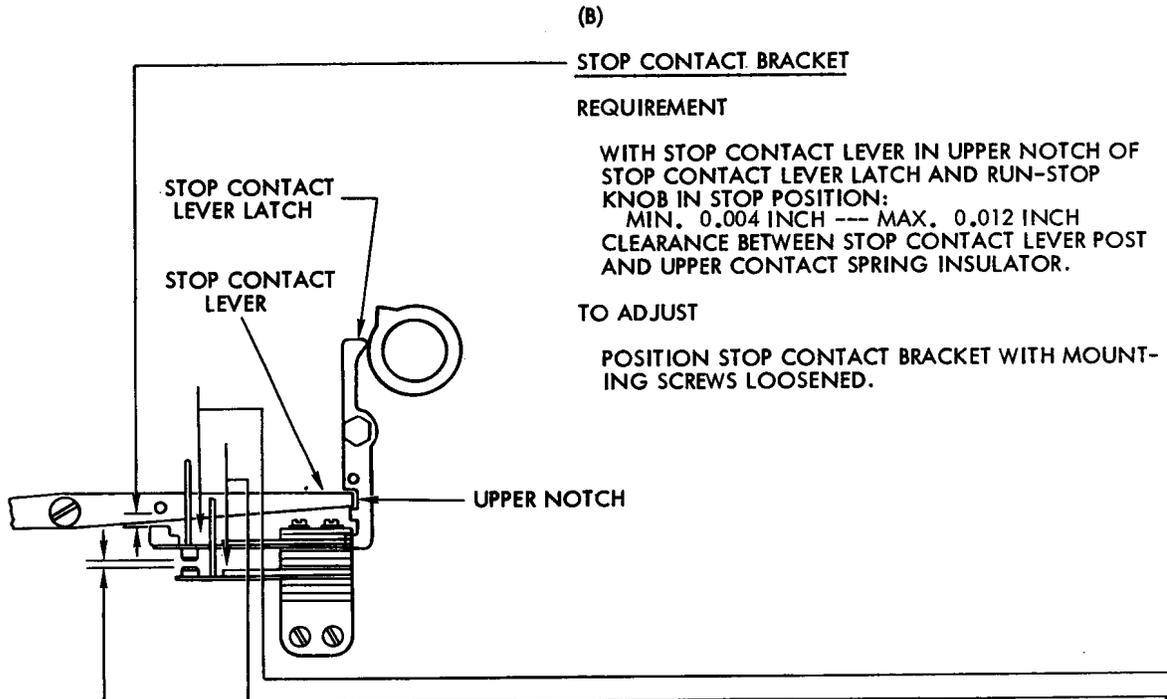
REQUIREMENT

ALL REQUIREMENTS AND ADJUSTMENTS GIVEN ABOVE APPLY EXCEPT WHEN MESSAGE SELECTING KNOB POSITION Y OR R IS SPECIFIED. WHEN MESSAGE SELECTING KNOB POSITION Y IS SPECIFIED, USE MESSAGE SELECTOR KNOB POSITIONS 1, 3, 5, 7 AND CHECK ASSOCIATED CONTACTS. WHEN MESSAGE SELECTING KNOB POSITION R IS SPECIFIED, USE POSITIONS 1, 3, 5, 7 ALT. 2, 4, 6, 8 AND CHECK CONTACTS 2, 4, 6, 8.

NOTE

TRANSMITTER CONTACT ASSEMBLIES ARE NUMBERED FROM 1 TO 8 WITH NUMBER 8 CONTACT NEAREST THE FRONT OF 1B

2.06 Stop Contact Mechanism



(B)

STOP CONTACT BRACKET

REQUIREMENT

WITH STOP CONTACT LEVER IN UPPER NOTCH OF STOP CONTACT LEVER LATCH AND RUN-STOP KNOB IN STOP POSITION:
 MIN. 0.004 INCH --- MAX. 0.012 INCH
 CLEARANCE BETWEEN STOP CONTACT LEVER POST AND UPPER CONTACT SPRING INSULATOR.

TO ADJUST

POSITION STOP CONTACT BRACKET WITH MOUNTING SCREWS LOOSENED.

(A)

STOP CONTACT

(1) REQUIREMENT

WITH STOP CONTACT LEVER HELD AWAY FROM STOP CONTACTS:
 MIN. .006 INCH --- MAX. .015 INCH
 GAP BETWEEN CONTACT POINTS.

TO ADJUST

BEND STOP CONTACT SPRING STIFFENERS.

(2) REQUIREMENT

WITH SCALE APPLIED TO LOWER CONTACT SPRING AT CONTACT POINT:
 MIN. 1 OZ. --- MAX. 2 OZS.
 TO START CONTACT SPRING MOVING AWAY FROM STIFFENER.

TO ADJUST

BEND LOWER CONTACT SPRING.

(3) REQUIREMENT

WITH STOP CONTACT LEVER HELD AWAY FROM STOP CONTACTS:
 MIN. 1 OZ. --- MAX. 2 OZS.
 TO START CONTACT SPRING MOVING AWAY FROM STIFFENER.

TO ADJUST

BEND UPPER CONTACT SPRING.

2.07 Stop Contact Mechanism (Cont)

(C)

STOP CONTACT LEVER LATCH CAM

TO CHECK

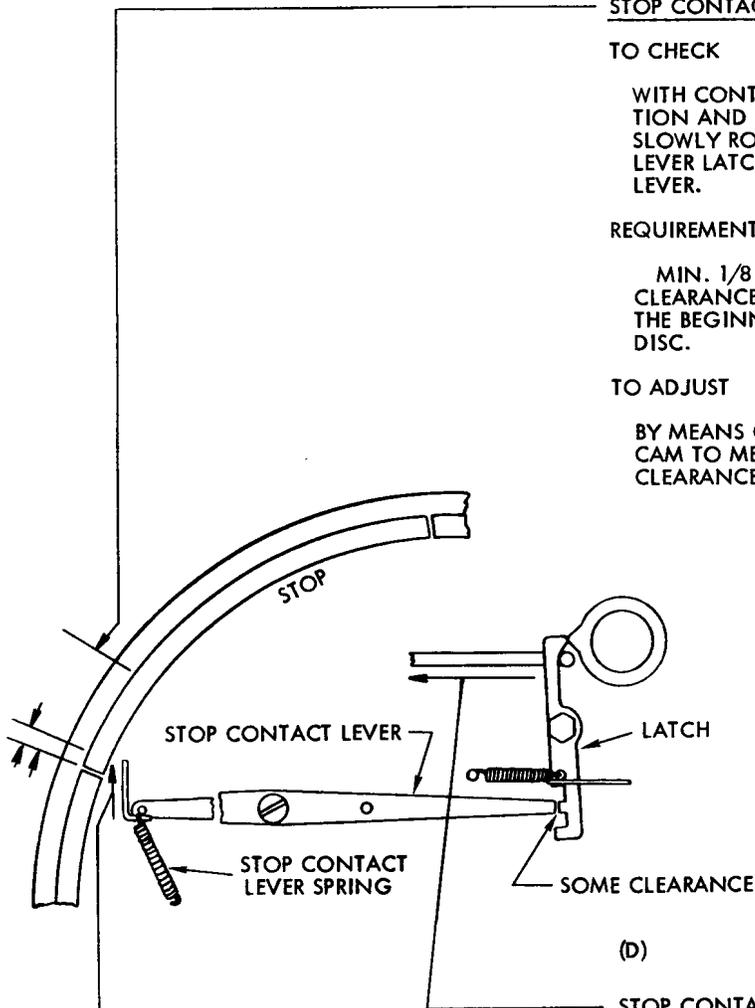
WITH CONTACT LEVER IN UPPER LATCHED POSITION AND RUN-STOP KNOB IN STOP POSITION, SLOWLY ROTATE MAIN SHAFT BY HAND UNTIL LEVER LATCH CAM JUST UNLATCHES CONTACT LEVER.

REQUIREMENT

MIN. 1/8 INCH --- MAX. 1 INCH CLEARANCE BETWEEN DISTRIBUTOR BRUSHES AND THE BEGINNING OF STOP SEGMENT ON FIXED DISC.

TO ADJUST

BY MEANS OF ITS SETSCREW ADJUST LEVER LATCH CAM TO MEET REQUIREMENT AND ALLOWING CLEARANCE BETWEEN CAM AND BACK CASTING.



(D)

STOP CONTACT LEVER LATCH SPRING

REQUIREMENT

WITH STOP CONTACT LEVER LATCH ON HIGH PART OF CAM AND STOP CONTACT LEVER HELD AWAY FROM SHOULDERS OF LATCH:
MIN. 4-1/2 OZS. --- MAX. 6-1/2 OZS.
TO START LATCH MOVING.

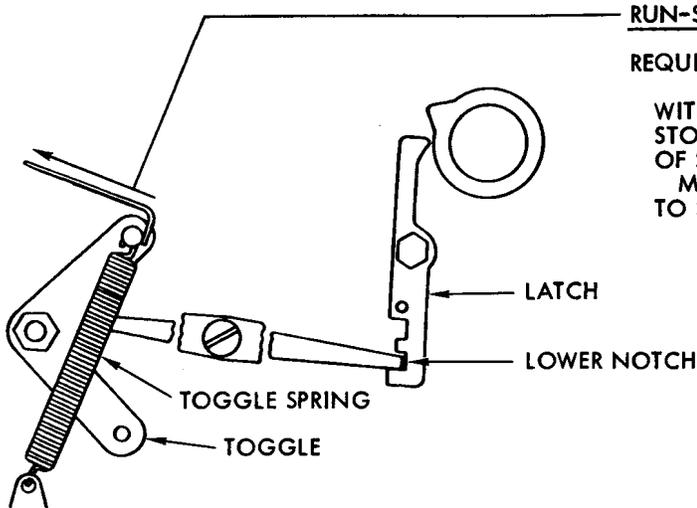
(E)

STOP CONTACT LEVER SPRING

REQUIREMENT

WITH STOP CONTACT LEVER LATCH ON HIGH PART OF CAM AND RUN-STOP KNOB IN RUN POSITION:
MIN. 5 OZS. --- MAX. 8 OZS.
TO START LEVER MOVING.

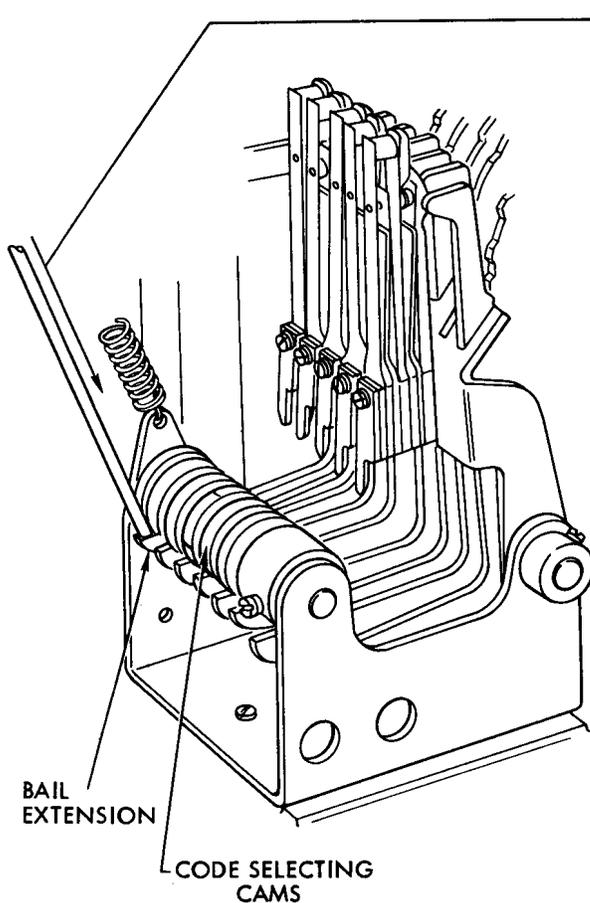
2.08 RUN-STOP Toggle Stop Plate and Transmitting Contact Bail Spring



RUN-STOP SWITCH TOGGLE STOP PLATE SPRING

REQUIREMENT

WITH RUN-STOP KNOB IN RUN POSITION AND STOP CONTACT LEVER LATCHED IN LOWER NOTCH OF STOP CONTACT LEVER LATCH:
MIN. 4 OZS.
TO START TOGGLE STOP PLATE MOVING.



TRANSMITTING CONTACT BAIL SPRING

REQUIREMENT

WITH MESSAGE SELECTING KNOB IN TEST MESSAGE POSITION:
MIN. 2 LBS.
TO START BAIL EXTENSION MOVING AWAY FROM CODE SELECTING CYLINDER.

2.09 Code Disc Assembly (1A TTY Test Set)

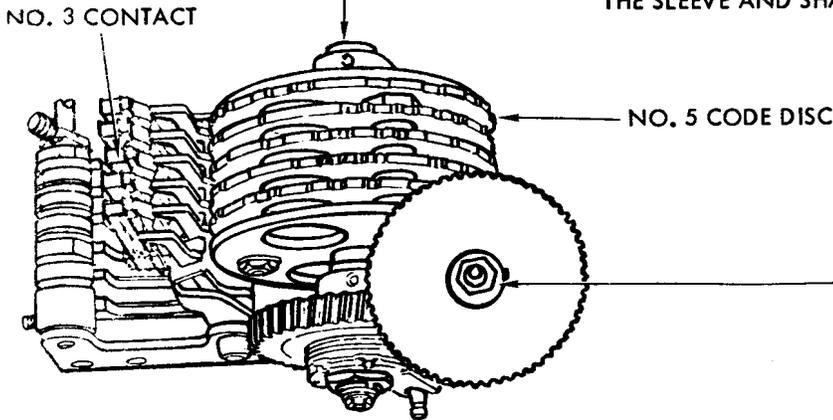
(A)
CODE DISC SHAFT END PLAY (NOT APPLICABLE TO 1 B)

REQUIREMENT

CODE DISC SHAFT SHOULD HAVE:
MIN. SOME --- MAX. 0.005 INCH
END PLAY.

TO ADJUST

WITH SLEEVE MOUNTING SCREW LOOSENED, POSITION
THE SLEEVE AND SHAFT.



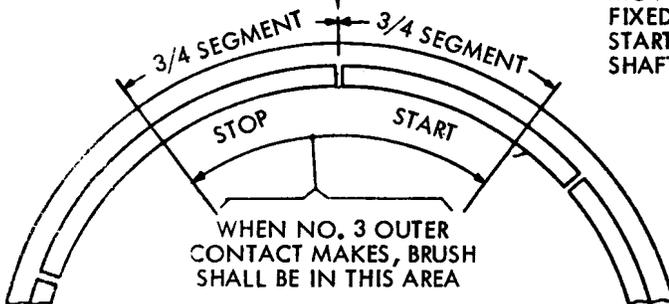
(B)
CODE DISC PHASING (NOT APPLICABLE TO 1 B)

REQUIREMENT

WITH MESSAGE SELECTING KNOB IN TEST MESSAGE
POSITION AND BRUSH SHAFT ROTATED UNTIL NUM-
BER 3 OUTER CONTACTS CLOSE, THE FIXED DISC
OUTER RING BRUSH SHOULD BE NOT MORE THAN
3/4 OF A SEGMENT LENGTH IN EITHER DIRECTION
FROM THE GAP BETWEEN STOP AND START SEGMENTS.

TO ADJUST

WITH NUT ON INTERMEDIATE GEAR SHAFT UPPER
END LOOSENED, ROTATE CODE DISCS UNTIL NUM-
BER 3 OUTER CONTACTS CLOSE. HOLD DISCS FROM
MOVING. ROTATE BRUSH SHAFT UNTIL OUTER RING
FIXED DISC BRUSH IS AT THE GAP BETWEEN STOP AND
START SEGMENTS. TIGHTEN INTERMEDIATE GEAR
SHAFT NUT.



2.10 Code Disc Assembly and Relay Pulsing Cam (1B TTY Test Set)

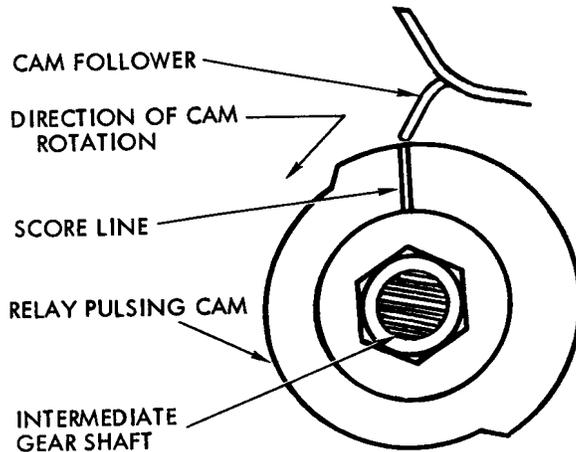
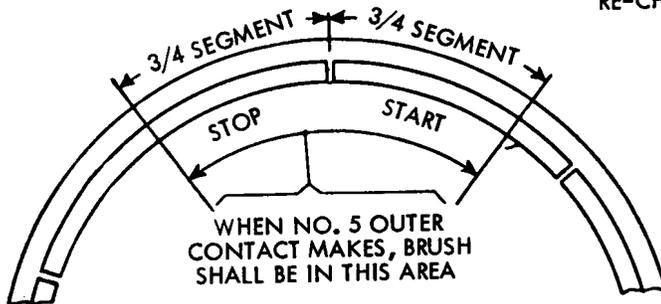
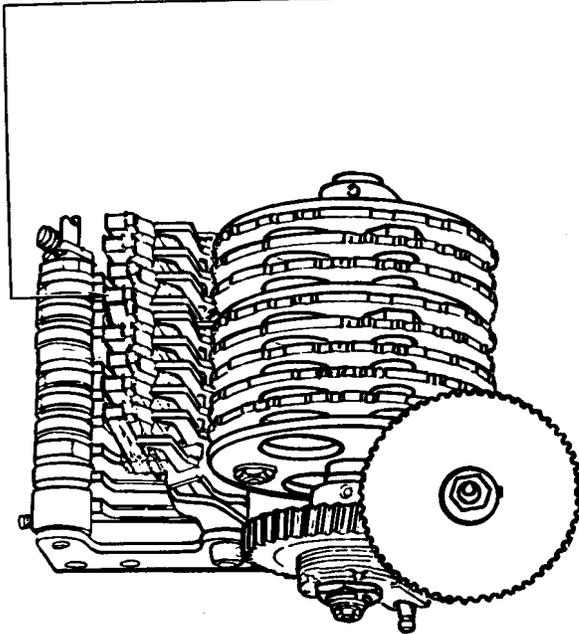
CODE DISC AND RELAY PULSING CAM PHASING (1 B)

REQUIREMENT

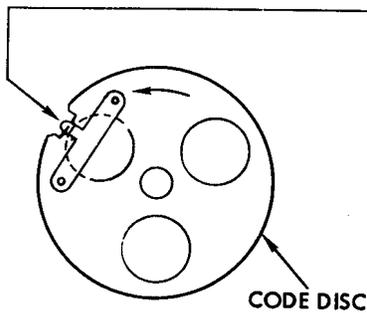
- (1) WITH MESSAGE SELECTOR KNOB IN TEST MESSAGE POSITION AND BRUSH SHAFT ROTATED UNTIL NUMBER 5 OUTER TRANSMITTER CONTACTS CLOSE, FIXED DISTRIBUTOR DISC OUTER RING BRUSH SHOULD BE NOT MORE THAN 3/4 OF A UNIT SEGMENT LENGTH IN EITHER DIRECTION FROM GAP BETWEEN STOP AND START SEGMENTS.
- (2) WITH DISTRIBUTOR SHAFTED POSITIONED SO THAT RELAY PULSING CAM SCORE LINE IS DIRECTLY UNDER CAM FOLLOWER, FIXED DISTRIBUTOR DISC OUTER RING BRUSH SHOULD BE ON THE START PULSE SEGMENT.

TO ADJUST

WITH NUT ON INTERMEDIATE GEAR SHAFT UPPER END LOOSENED, ROTATE CODE DISCS UNTIL NUMBER 5 OUTER TRANSMITTER CONTACTS CLOSE. HOLD DISCS FROM MOVING. POSITION BRUSH ARM BY TURNING DISTRIBUTOR SHAFT UNTIL FIXED DISC OUTER RING BRUSH IS AT THE GAP BETWEEN STOP AND START SEGMENTS. WITH BRUSHES IN THIS POSITION AND WITHOUT MOVING CODE DISCS, LOCATE RELAY PULSING CAM TO MEET REQUIREMENT (2). TIGHTEN INTERMEDIATE GEAR SHAFT NUT AND RE-CHECK REQUIREMENTS.



2.11 Code Disc Segment Retaining Spring and Relay Pulsing Contact Assembly



CODE DISC SEGMENT RETAINING SPRING REQUIREMENT

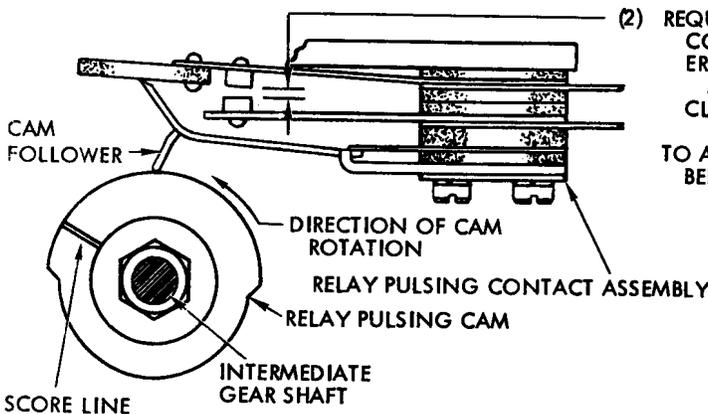
SPRINGS SHALL HOLD EACH SEGMENT FIRMLY IN PLACE. CLEARANCE BETWEEN ADJACENT SPRINGS WITH ALL SEGMENTS IN PLACE IS NOT NECESSARY.

TO ADJUST
REFINE POSITION OF SPRING ON ITS MOUNTING SCREWS AS REQUIRED.

RELAY PULSING CONTACT ASSEMBLY (1 B)

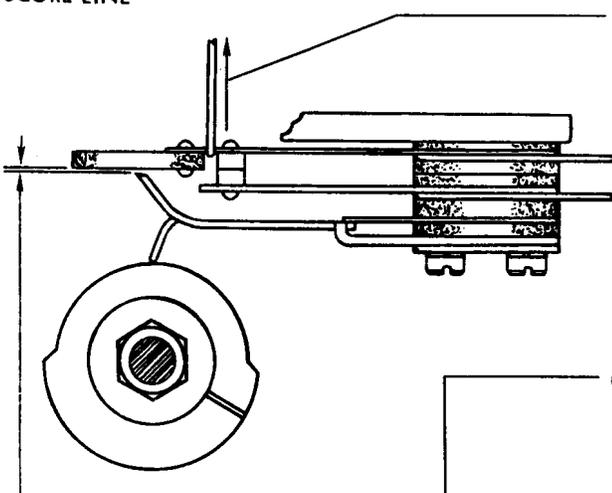
(1) REQUIREMENT
CONTACT ALIGNMENT. CAM FOLLOWER MUST RIDE CENTRALLY ON CAM AND CONTACT POINTS MUST BE IN ALIGNMENT.

TO ADJUST
LOOSEN SCREWS AND SHIFT CONTACT ASSEMBLY.



(2) REQUIREMENT
CONTACT CLEARANCE. WITH CAM FOLLOWER ON HIGH PART OF CAM, MIN. 0.010 INCH --- MAX. 0.020 INCH CLEARANCE BETWEEN CONTACTS.

TO ADJUST
BEND LOWER SPRING.



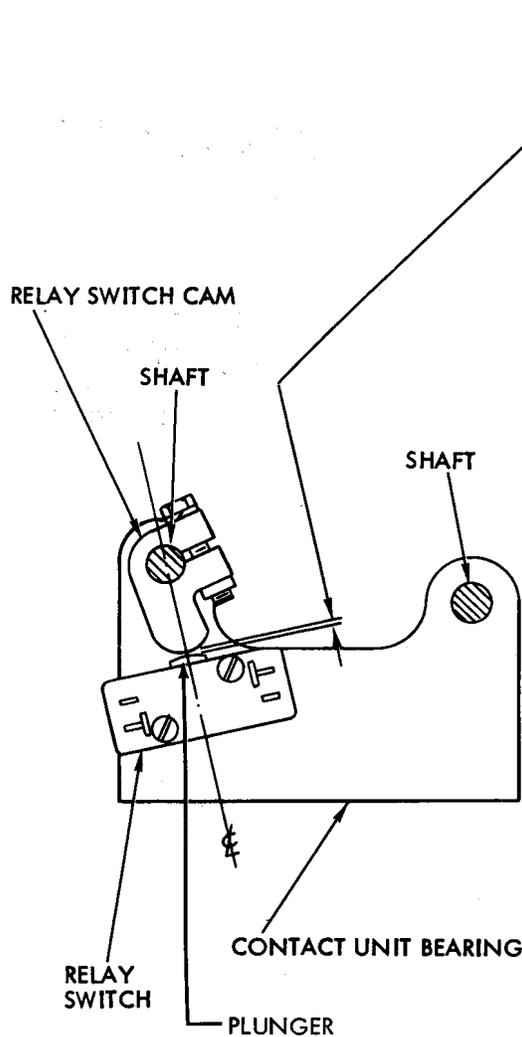
(3) REQUIREMENT
CONTACT TENSION. WITH CAM FOLLOWER ON LOW PART OF CAM, MIN. 3-1/2 OZS. --- MAX. 4-1/2 OZS. TO JUST SEPARATE CONTACTS.

TO ADJUST
BEND SPRINGS AND RE-CHECK CONTACT CLEARANCE REQUIREMENT (2).

(4) REQUIREMENT
CAM FOLLOWER CLEARANCE. WITH CAM FOLLOWER IN THE CAM INDENT, THERE MUST BE SOME CLEARANCE BETWEEN CAM FOLLOWER AND CONTACT SPRING EXTENSION.

TO ADJUST
REFINE AND RE-CHECK REQUIREMENTS (1), (2) AND (3).

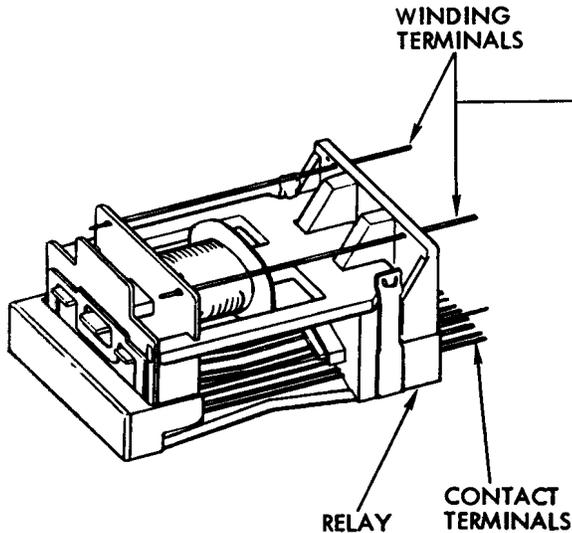
2.12 Relay Switch and Cam (1B TTY Test Set)



RELAY SWITCH AND RELAY SWITCH CAM (1 B)

- (1) REQUIREMENT
 WITH MESSAGE SELECTOR KNOB IN THE 1, 3, 5, 7 ALT. 2, 4, 6, 8 POSITION, RELAY SWITCH CAM SHOULD BE POSITIONED ON MESSAGE SELECTING SHAFT TO GIVE MAXIMUM DEPRESSION OF RELAY SWITCH PLUNGER AND BE CENTRALLY LOCATED ON PLUNGER.
- TO ADJUST
 WITH CAM MOUNTING SCREW LOOSENED, POSITION CAM ON THE SHAFT. TIGHTEN CAM MOUNTING SCREW.
- (2) REQUIREMENT
 WITH MESSAGE SELECTOR KNOB IN THE 2, 4, 6 POSITION THERE SHOULD BE SOME CLEARANCE BETWEEN RELAY SWITCH PLUNGER AND RELAY SWITCH CAM.
- TO ADJUST
 REFINE REQUIREMENT (1).
- (3) REQUIREMENT
 WITH MESSAGE SELECTOR KNOB IN THE 1, 3, 5, 7 ALT. 2, 4, 6, 8 POSITION, RELAY SWITCH CAM SHOULD OPERATE RELAY SWITCH. WHEN RELAY SWITCH PLUNGER IS HELD FULLY DEPRESSED MANUALLY, THERE SHOULD BE SOME CLEARANCE BETWEEN RELAY SWITCH PLUNGER AND RELAY SWITCH CAM.
- TO ADJUST
 WITH RELAY SWITCH MOUNTING SCREWS LOOSENED, POSITION SWITCH. TIGHTEN MOUNTING SCREWS AND RE-CHECK REQUIREMENT (1).
- (4) REQUIREMENT
 RELAY SWITCH SHOULD BE ALIGNED PERPENDICULAR TO A LINE THROUGH CENTER OF SWITCH PLUNGER AND CENTER OF RELAY SWITCH CAM MOUNTING SHAFT, AS GAUGED BY EYE.
- TO ADJUST
 WITH RELAY SWITCH MOUNTING SCREWS LOOSENED, POSITION SWITCH. TIGHTEN MOUNTING SCREWS AND RE-CHECK REQUIREMENTS (1) AND (3).

2.13 Relay Test and Motor Unit Slip Connector



RELAY TEST (1 B)

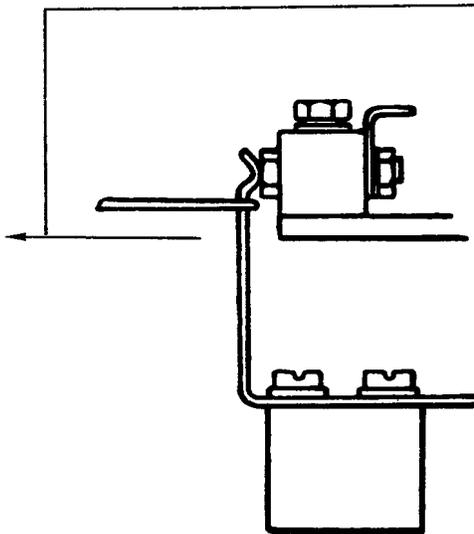
REQUIREMENT

CIRCUIT TEST REQUIREMENTS FOR 165212 RELAY (WECO RELAY AJ9 WITH SPRING COMBINATION #234) ARE:

OPERATE --- 0.040 AMPERES D.C.

NOTE

RELAY IS DESIGNED FOR MINIMUM FIELD MAINTENANCE AND IS USUALLY REPLACED RATHER THAN READJUSTED. INSPECT RELAY TO ASSURE THAT ARMATURE AND CONTACTS ARE FREE OF FOREIGN MATERIAL THAT MAY OBSTRUCT PROPER MOVEMENT. CHECK THAT CONTACT SPRING WIRES ARE IN CORRECT GUIDES.



MOTOR UNIT SLIP CONNECTION SPRING

- (1) REQUIREMENT
WITH MOTOR UNIT ON BASE

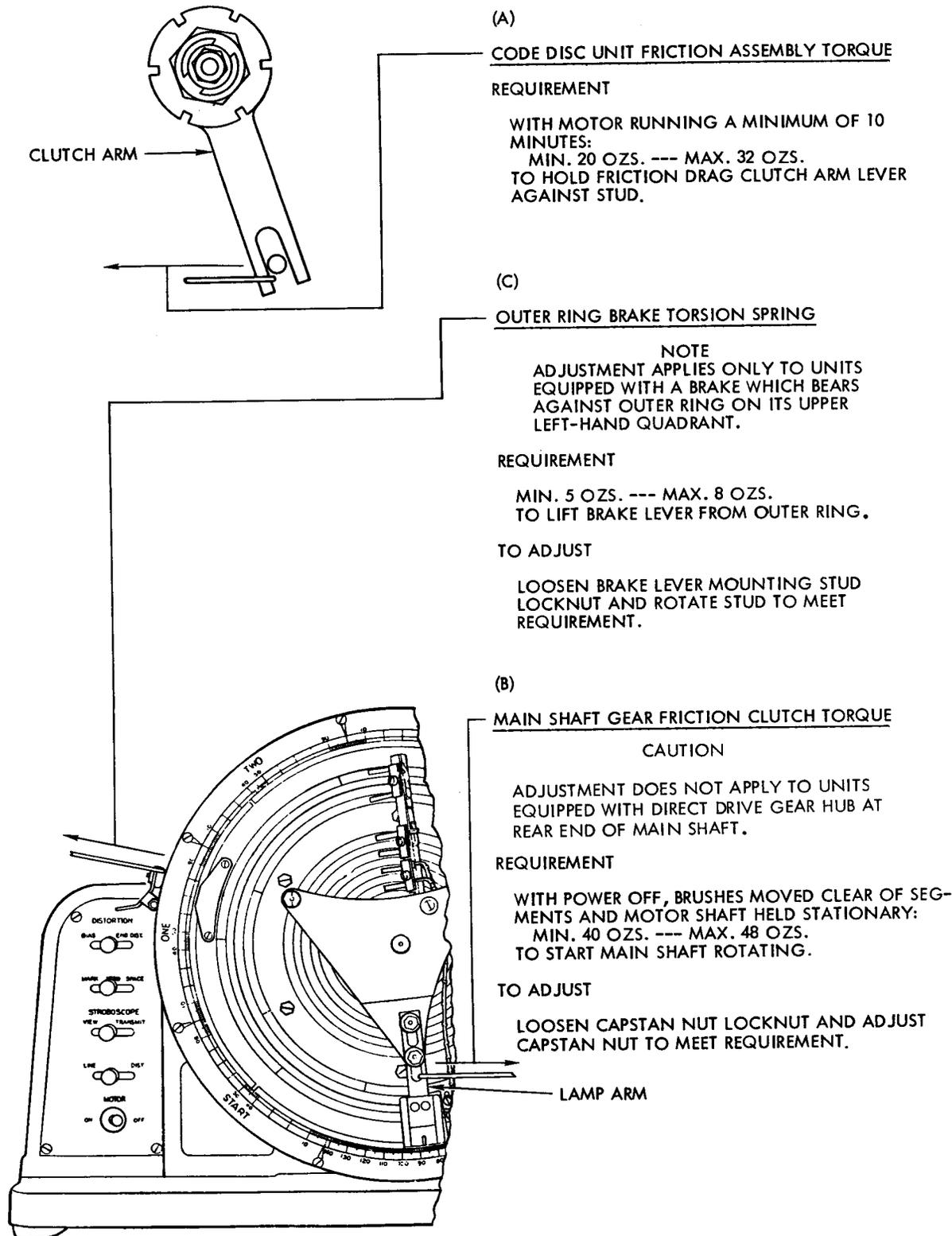
MIN. 2-1/4 LBS. --- MAX. 3-3/4 LBS.
TO BREAK CONTACT AS MEASURED BY PULLING AT RIGHT ANGLES TO SPRING. MEASURE PRESSURE OF OPPOSITE END SLIP CONNECTION SPRING IN SAME MANNER. USE TEST LAMP TO DETERMINE WHEN CONTACT BREAKS.

TO ADJUST
REMOVE MOTOR UNIT AND BEND SLIP CONNECTION SPRINGS.

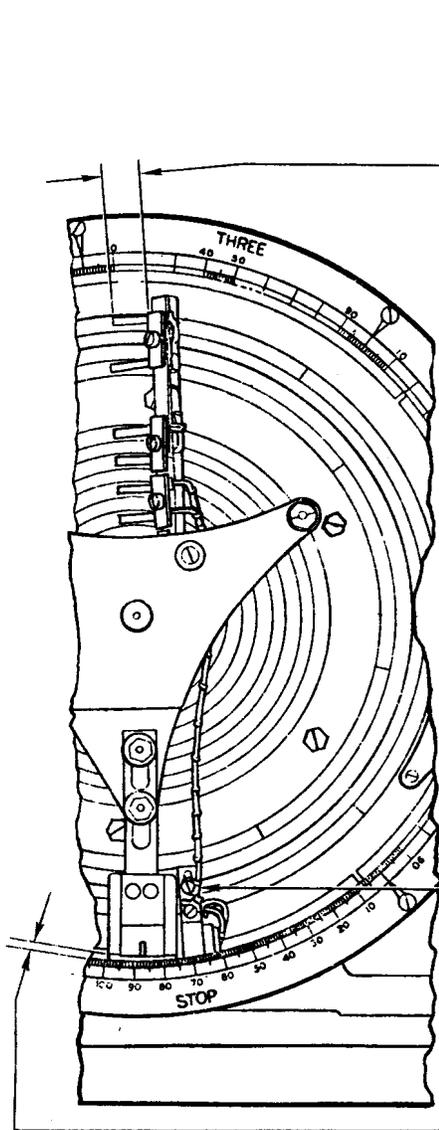
- (2) REQUIREMENT
WITH MOTOR UNIT REMOVED AND A STRAIGHT EDGE PLACED ACROSS THE TWO END SLIP CONNECTION SPRINGS,
MIN. SOME --- MAX. 0.015 INCH
CLEARANCE BETWEEN THE TWO INNER CONNECTION SPRINGS AND STRAIGHT EDGE.

TO ADJUST
BEND THE TWO INNER CONNECTION SPRINGS TO MEET REQUIREMENT.

2.14 Clutches and Outer Ring Brake



2.15 Distributor Brushes and Indicating Lamp



(B)

DISTRIBUTOR BRUSHES

REQUIREMENT

BRUSH ENDS SHOULD BE CUT SQUARE AND FREE FROM FRAGMENTS. BRUSHES SHOULD BE STRAIGHT AND EXTEND AT RIGHT ANGLES TO, AND 3/4 INCH FROM, BRUSH ARM.

TO ADJUST

LOOSEN BRUSH CLAMP SCREWS AND POSITION BRUSHES. TIGHTEN BRUSH CLAMP SCREWS. LOOSEN BRUSH ARM CLAMPSCREW, MOVE BRUSHES AGAINST RESPECTIVE DISCS UNTIL BRUSH ARM POST IS AGAINST STOP POST.

(C)

INDICATING LAMP POSITION

REQUIREMENT

INDICATING LAMP SHOULD ILLUMINATE WITH MAXIMUM BRILLIANCY, AS OBSERVED WITH FRONT COVER INSTALLED, LIGHTED SIDE OF LAMP FILAMENT TOWARD UNIT FRONT, DC ON, AND MOTOR RUNNING.

TO ADJUST

REMOVE FRONT COVER. WITH LAMP BRACKET MOUNTING SCREW LOOSENED, POSITION BRACKET AND LAMP WITHIN BRACKET TO MEET REQUIREMENT. TIGHTEN SCREWS AND REPLACE COVER.

(A)

INDICATING LAMP ARM

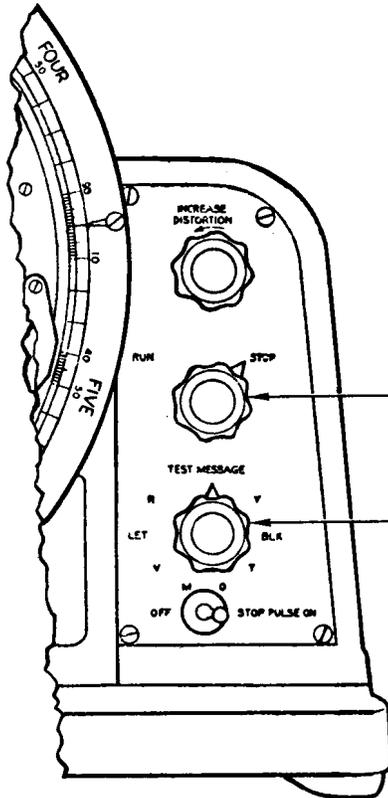
REQUIREMENT

- (1) FACE OF SLOTTED PART OF LAMP ARM SHOULD BE APPROXIMATELY IN LINE WITH FACE OF SCALE.
- (2) AT POINT OF LEAST CLEARANCE BETWEEN END OF SLOTTED PART OF LAMP ARM AND EDGE OF SCALE PLATE
MIN. SOME --- MAX. .006 INCH CLEARANCE.

TO ADJUST

LOOSEN LAMP ARM MOUNTING SCREWS AND POSITION LAMP ARM TO MEET REQUIREMENTS (1 AND 2).

2.16 RUN-STOP and TEST MESSAGE knobs



(B)

RUN-STOP KNOB POSITION

REQUIREMENT

WITH RUN-STOP KNOB IN EXTREME CLOCKWISE POSITION, KNOB POINTER SHOULD ALIGN WITH STOP POSITION LABEL ON PANEL.

TO ADJUST

WITH SET SCREW LOOSENED, POSITION KNOB ON ITS SHAFT. TIGHTEN SET SCREW AND CHECK KNOB POINTER ALIGNMENT IN RUN POSITION (COUNTER-CLOCKWISE). REFINE ADJUSTMENT AS REQUIRED.

(A)

MESSAGE SELECTING KNOB POSITION

REQUIREMENT

WITH CODE CYLINDER POSITIONED TO TRANSMIT TEST MESSAGE (TRANSMITTER CONTACTS POSITIONED FOR OPERATION BY CODE DISCS), MESSAGE SELECTING KNOB POINTER SHOULD POINT TOWARD TEST MESSAGE POSITION ON RIGHT PANEL PLATE AND BE POSITIONED VERTICALLY AS GAUGED BY EYE.

TO ADJUST

WITH MESSAGE SELECTING KNOB SET SCREW LOOSENED, POSITION KNOB ON ITS SHAFT. CHECK ALIGNMENT OF POINTER IN OTHER DETENT POSITIONS AND REFINE ADJUSTMENT AS REQUIRED.