

28 TRANSMITTER DISTRIBUTOR UNIT (LXD)

ADJUSTMENTS

CONTENTS	PAGE	CONTENTS	PAGE
1. GENERAL . . . . .	2	Start-Stop Switch Assembly and Tight-Tape Mechanism	
2. BASIC UNITS . . . . .	4	Start-stop switch bracket. . . . .	17
Basic Gear Adjustments		Start-stop switch bracket (for units equipped with tape lid sensing lever) .	18
Intermediate gear — transmitter distributor gear backlash. . . . .	31	Tight-tape intermediate arm . . . . .	19
Clutch Mechanism		Tight-tape intermediate arm spring . . . . .	19
Armature bail spring . . . . .	7	Tight-tape start-stop contact spring . . . . .	17
Clutch latchlever spring . . . . .	6	Tape Lid	
Clutch magnet assembly . . . . .	7	Start-stop detent bail spring. . . . .	10
Clutch shoe lever. . . . .	5	Tape guide . . . . .	9
Clutch shoe lever spring . . . . .	4	Tape guideplate . . . . .	11
Clutch shoe spring . . . . .	4	Tape lid . . . . .	8
Clutch trip lever . . . . .	6	Tape lid release plunger spring . . . .	10
Clutch trip lever spring. . . . .	6	Tape lid spring . . . . .	10
Main bail latch spring. . . . .	7	Tape-Out Switch Assembly	
Feed Wheel Mechanism		Depressor bail torsion spring. . . . .	15
Feed pawl. . . . .	22	Intermediate tape-out bail spring . . .	15
Feed pawl spring . . . . .	22	Tape-out contact assembly. . . . .	14
Feed ratchet detent spring. . . . .	20	Tape-out contact bracket. . . . .	14
Feed wheel detent. . . . .	21	Tape-out sensing pin. . . . .	15
Main bail . . . . .	20	Tape-out sensing pin (for units with tape lid sensing lever) . . . . .	16
Main bail spring. . . . .	20	Tape-out sensing pin spring. . . . .	14
Main bail trip lever . . . . .	20	Top and Cover Plates	
Sensing pin spring . . . . .	21	Cover plate. . . . .	13
Main Bail and Transfer Mechanisms		Cover plate detent spring. . . . .	13
Locking bail spring. . . . .	23	Top plate . . . . .	12
Main bail . . . . .	24	3. VARIABLE FEATURES. . . . .	32
Stabilizer spring . . . . .	25	Auxiliary Contacts	
Transfer bail stabilizer. . . . .	25	Auxiliary contact operating bail spring . . . . .	41
Transfer lever spring. . . . .	23	Contact sensing arm. . . . .	41
Signal Contacts			
Drive link spring . . . . .	26		
Signal contact clearance . . . . .	26		
Signal contacts — electrical . . . . .	27		
Signal contact spring. . . . .	26		

SECTION 573-127-703TC

CONTENTS	PAGE
Contact swinger — operating bail clearance . . . . .	42
Normally closed contacts . . . . .	40
Normally open contacts . . . . .	40
Code Reading Contacts	
Contact assembly positioning . . . . .	37
Contact sensing arm — up-stop clearance . . . . .	38
Contact swinger — sensing arm clearance . . . . .	37
Contact swinger — sensing arm clearance (strobing) . . . . .	39
Normally closed contacts — backstop . . . . .	36
Normally closed contacts — spring . . . . .	36
Normally open contacts — gap . . . . .	36
Normally open contacts — spring . . . . .	36
Sensing arm spring . . . . .	38
Sensing arm — transfer lever alignment . . . . .	38
Split bail eccentric . . . . .	38
Rub-Out Deleter	
Rub-out deleter bail guide . . . . .	47
Rub-out deleter bail spring . . . . .	47
Sensing pin spring . . . . .	47
Start-Stop Pulse Contact	
Contact bracket . . . . .	45
Contact bracket (strobing) . . . . .	46
Contact gap (start and stop contacts) . . . . .	45
Contact lever . . . . .	45
Tape Deflector	
Tape deflector bracket . . . . .	44
Tape deflector spring . . . . .	44
Tape Feed Assurance Mechanism	
Detent lever spring . . . . .	33
Tape motion contact gap . . . . .	33
Tape motion contact swinger . . . . .	33
Tape sensing feed wheel phasing . . . . .	33

CONTENTS	PAGE
Tape Lid Sensing Lever	
Switch lever . . . . .	43
Switch lever spring . . . . .	43
Tape Notch Sensing Mechanism	
Contact bracket (strobing) . . . . .	49
Tape notch sensing contact . . . . .	48
Tape notch sensing pin spring . . . . .	48
Tape-Out Mechanism	
Tape-out bail torsion spring . . . . .	34
Tape-out contact . . . . .	34
Tape-out pin . . . . .	35
Tape-out pin spring . . . . .	35
Tape Slack Arm	
Tape slack contacts . . . . .	51
Tape Withhold Mechanism	
Blocking bail arm eccentric . . . . .	52
Blocking bail eccentric pivot . . . . .	52
Magnet armature gap . . . . .	52
Tight-Tape and Tape Shoe Mechanism	
Tape shoe . . . . .	32
Tight-tape switch . . . . .	32
Torsion spring . . . . .	32
Transmitter Stop Mechanism	
Start-stop contact gap (for tabulator control) . . . . .	50
Timing bail spring . . . . .	50
4. EARLY MODELS . . . . .	53
Tape Lid Mechanism	
Tape lid . . . . .	53
Tape lid release plunger spring (for units without tape lid spring) . . . . .	54

1. GENERAL

1.01 This section provides specific adjustments for the single contact 28 transmitter distributor. It reflects 5- and 6-level operation for LXD unit.

1.02 The adjustments are arranged in a sequence that should be followed if a complete readjustment is undertaken. The tools and

spring scales required to perform these adjustments are found in tool section 570-005-800TC. A complete adjusting procedure should be read before attempting to make the adjustment. After an adjustment is completed, be sure to tighten any nuts or screws that may have been loosened. Where an illustration shows interrelated parts, the sequence that should be followed in checking the requirements and making the adjustments is indicated by the letters, (A), (B), (C), etc.

1.03 The adjusting illustrations indicate tolerances, positions of moving parts, spring tensions, and the angle at which scales should be applied. Coil springs which do not meet the requirements, and for which there are no adjusting procedures, should be discarded and replaced with new springs. If a part mounted on shims is removed, the number of shims used at each mounting screw should be noted so that the same number is replaced when the part is remounted.

Note: Remove power from unit before making adjustments.

1.04 When the requirement calls for the clutch to be disengaged, the clutch shoe lever must be fully latched between its trip lever and latchlever so that the clutch shoes release their tension on the clutch drum. When engaged, the clutch shoe lever is unlatched and the clutch shoes are wedged firmly against the clutch drum. When the main shaft is rotated by hand, the clutch does not fully disengage upon reaching its stop position. In order to relieve the drag on the clutch and permit the main shaft to rotate freely, apply pressure on a lug of the clutch disc with a screwdriver to cause it to engage its latchlever and thus disengage the internal expansion clutch shoes from the clutch drum.

1.05 The covers may be removed for inspection and minor repair of the unit; however, when more extensive maintenance is to be undertaken, it is recommended that the unit be disconnected from its source of power as a safety precaution.

1.06 References made to left, right, up, down, front, or rear, apply to the set in its operating position, as viewed from the operator's position.

1.07 All electrical contact points should meet squarely. Contacts with the same diameter should not be out of alignment more than 25 percent of the contact diameter. Check contacts for pitting and corrosion and clean or burnish them before making specified adjustment or tolerance measurement. Avoid sharp kinks or bends in the contact springs.

**CAUTION: KEEP ALL ELECTRICAL CONTACTS FREE OF OIL AND GREASE.**

1.08 Units may have signal contacts made of either unplated or gold-plated tungsten. If in doubt as to the type of contacts, remove contact box cover and inspect contacts for gold

plating. Do not use burnishers, files, etc which will remove gold plating.

1.09 Use twill jean cloth (KS2423) (TP107162) to clean gold-plated contacts. Open contacts. Allow contacts to close on surface of twill jean. Draw twill jean part way through. Open contacts and withdraw twill jean.

1.10 This procedure prevents small fibers at edges of twill jean strip from becoming lodged between contacts.

1.11 Clean unplated tungsten contacts in accordance with standard procedures (Paragraph 1.07).

#### Servicing For Certain Low-Voltage Applications

1.12 For standard applications, including those with data sets, observe standard maintenance procedures and intervals. Certain low-voltage applications are covered below.

1.13 For optimum reliable operation in these low-voltage applications, clean gold-plated contacts with twill jean, as instructed above, at intervals of approximately 50 hours of actual contact operation. Since maintenance interval and life expectancy of the contacts are dependent on the signal circuit, maintenance interval may be lengthened for specific applications.

Note 1: Applying operating voltage of standard Distortion Test Set directly to contacts may damage gold plating and impair low-voltage operation. When electrically adjusting or testing contacts (2.23), use an intermediate device, keyed by the contacts, to interrupt current to stroboscopic lamp of test set. This intermediate device must be capable of being keyed by a 3 to 20 volt change at maximum of 20 milliamperes.

Note 2: Normally for low-voltage applications, contacts should be used in circuits operating between 3 and 20 volts dc at a current level not to exceed 60 milliamperes. Between 20 and 70 volts dc the current should be adjusted so as not to exceed a 120 milliwatt power level. The contacts are not normally intended for use with voltages above 70 volts dc. Exceeding this level for an appreciable length of time may result in damage to the gold plating and make them unfit for low-voltage applications.

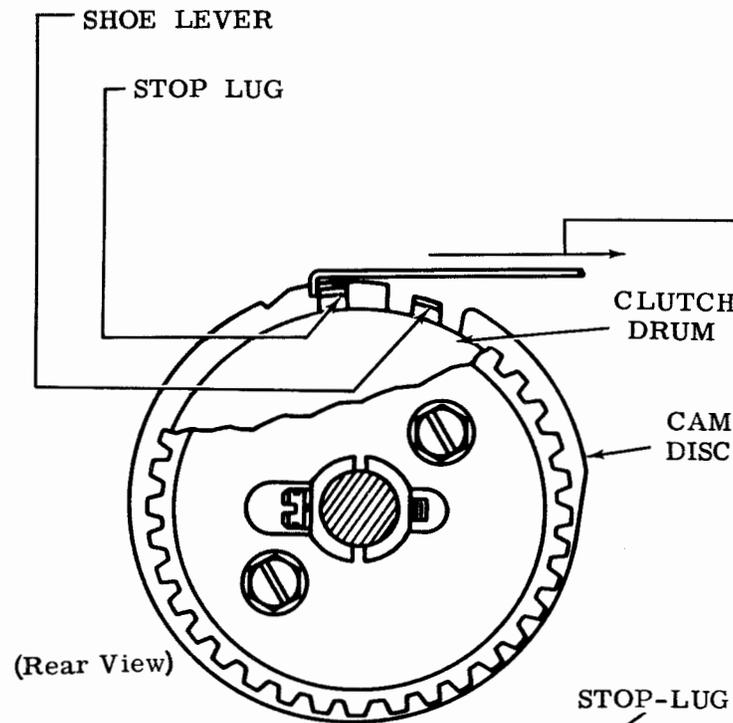
2. BASIC UNITS

2.01 Clutch Mechanism

Note 1: Remove the transmitter distributor from its base before making a complete re-adjustment or spring tension checks.

Note 2: Adjustments (A) and (B) are made at the factory and should not be disturbed unless good reasons exist that the requirements are not met.

(A) CLUTCH SHOE LEVER SPRING



To Check

Invert unit and rotate main shaft until clutch shoe lever and stop lug are up. With clutch engaged, hold cam disc to prevent turning.

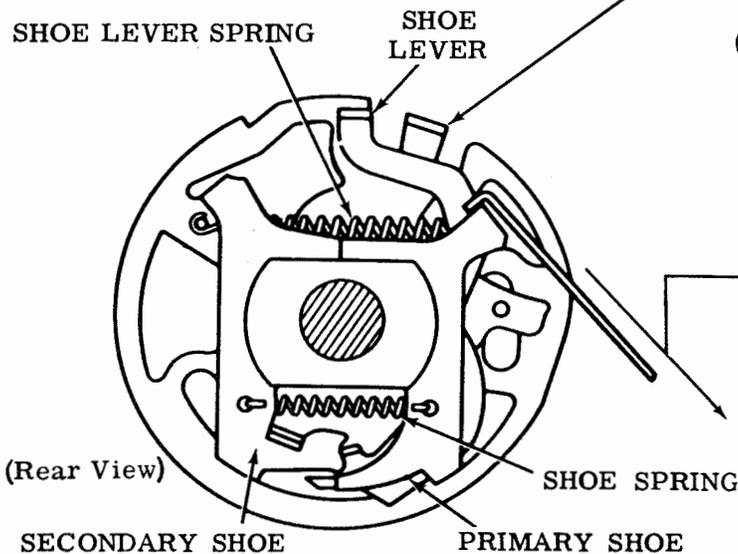
Requirement

Min 15 oz---Max 20 oz  
to move shoe lever in contact with stop lug.

(Where set is equipped with tape slack mechanism)

Min 9 oz---Max 11 oz

(Rear View)



(B) CLUTCH SHOE SPRING

To Check

Remove the clutch from the main shaft. With the clutch drum removed, hook spring scale as shown.

Requirement

Min 3 oz---Max 5 oz  
to start primary shoe moving away from secondary shoe at point of contact.

(Rear View)

## 2.02 Clutch Mechanism (continued)

Note: Remove transmitter distributor from base before making adjustments.

(A) CLUTCH SHOE LEVER

## To Check

Trip transmitter distributor clutch. Pull shoe lever opposite the stop lug with a force of 32 oz. Release the force slowly to engage clutch shoes. Note clearance between clutch shoe lever and stop lug. Disengage the clutch, and again pull the lever opposite the stop lug with a force of 32 oz. Release the force slowly. Note clearance between the shoe lever and the stop lug.

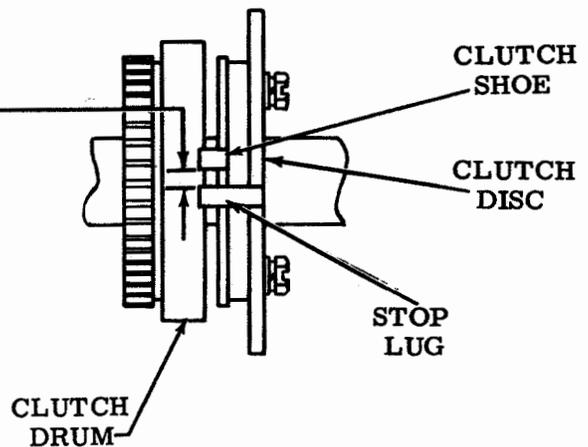
## Requirement

Min 0.055 inch---Max 0.085 inch greater clearance with clutch engaged than with clutch disengaged.

## To Adjust

Loosen clutch disc clampscrews. Place wrench over stop lug and move disc. Retighten screws.

Note: Drum must not drag on shoes when clutch is disengaged and rotated in its normal direction. Refine CLUTCH SHOE LEVER adjustment to correct shoe drag.



(Left Side View)

2.03 Clutch Mechanism (continued)

(D) CLUTCH LATCHLEVER SPRING

To Check

Trip clutch and rotate until latchlever is on low part of disc.

Requirement

Min 3 oz---Max 5 oz  
to start clutch latchlever moving.

MAIN BAIL  
(Front View)

CLAMP NUT

(B) CLUTCH TRIP LEVER

To Check

Trip transmitter distributor clutch.  
With main bail in highest position,  
rotate clutch until stop lug is opposite  
trip lever.

(1) Requirement

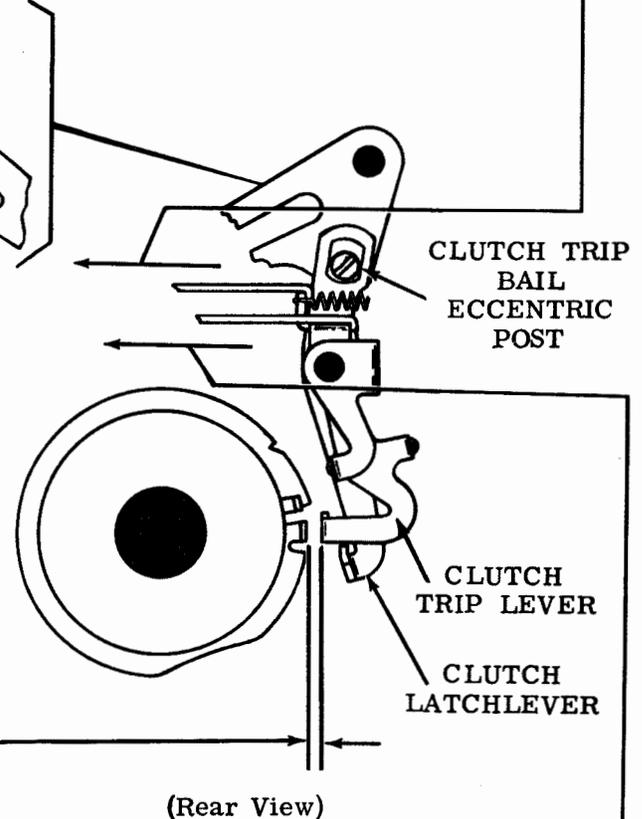
With trip bail play taken up to  
make clearance maximum.  
Min 0.012 inch---Max 0.025 inch  
between stop lug and trip lever.

(2) Requirement

With trip bail play taken up to make  
clearance minimum  
some clearance  
between stop lug and trip lever.

To Adjust

Loosen clamp nut friction tight and  
rotate trip bail eccentric post. Check  
Requirement (1). Retighten clamp-  
screw.



(C) CLUTCH TRIP LEVER SPRING

Requirement

With clutch engaged  
Min 7 oz---Max 10-1/2 oz  
to start clutch trip lever moving.

2.04 Clutch Mechanism (continued)

(A) CLUTCH MAGNET ASSEMBLY

(1) To Check

Place armature in attracted (energized) position.

Requirement

Armature to contact core face of top magnet with  
 Min some---Max 0.004 inch  
 between armature and core face of bottom magnet at point of least clearance. (Sets with Tape Shoe and Tape Feed Assurance Mechanisms  
 Min 0.004 inch---Max 0.007 inch)

To Adjust

Remove magnet mounting bracket screws and lift clutch magnet assembly from the unit. Loosen mounting screws and position hinge.

(2) To Check

Place high part of backstop eccentric toward top of unit. Hold armature in attracted (energized) position.

Requirement

Min 0.045 inch---Max 0.055 inch  
 between armature bail and backstop eccentric.

To Adjust

Loosen backstop clamp nut and position eccentric. Retighten backstop clamp nut.

(3) To Check

If clutch magnet assembly was removed in (1) To Check, replace it in unit to its lowest position. Tighten magnet mounting bracket screws friction tight. Disengage clutch.

Requirement

Min 0.007 inch---Max 0.015 inch  
 between end of armature bail extension and main bail latch.

To Adjust

Position clutch magnet assembly using adjusting slot.

Note: Under ac power, armature "chatter" must be at a minimum. If excessive "chatter" is present, refine requirement under (1) To Check, and recheck requirements under (2) and (3) To Check.

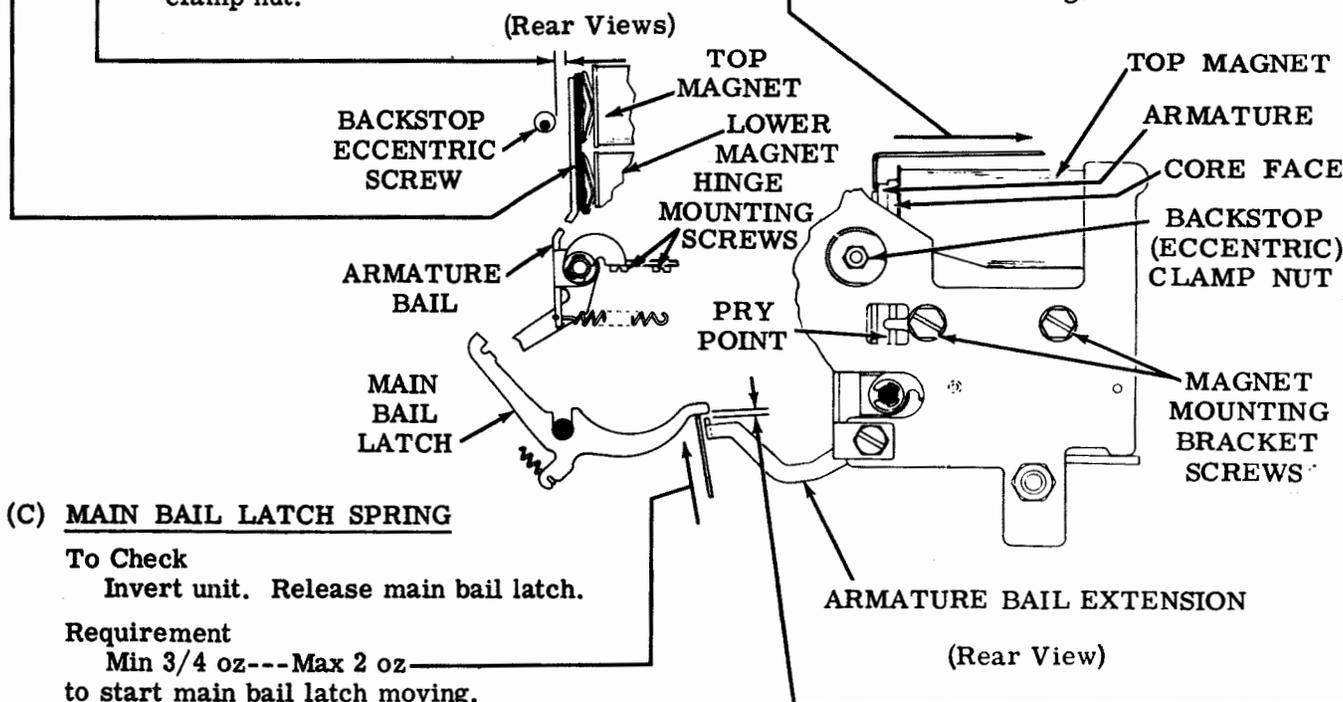
(B) ARMATURE BAIL SPRING

To Check

Place armature in de-energized position and hold main bail latch lever away from armature bail extension.

Requirement

Min 1 oz---Max 2 oz  
 (Sets with Tape Shoe and Tape Feed Assurance Mechanisms only  
 Min 3-3/4 oz---Max 4-3/4 oz)  
 to start bail moving.



(C) MAIN BAIL LATCH SPRING

To Check

Invert unit. Release main bail latch.

Requirement

Min 3/4 oz---Max 2 oz  
 to start main bail latch moving.

2.05 Tape Lid

TAPE LID

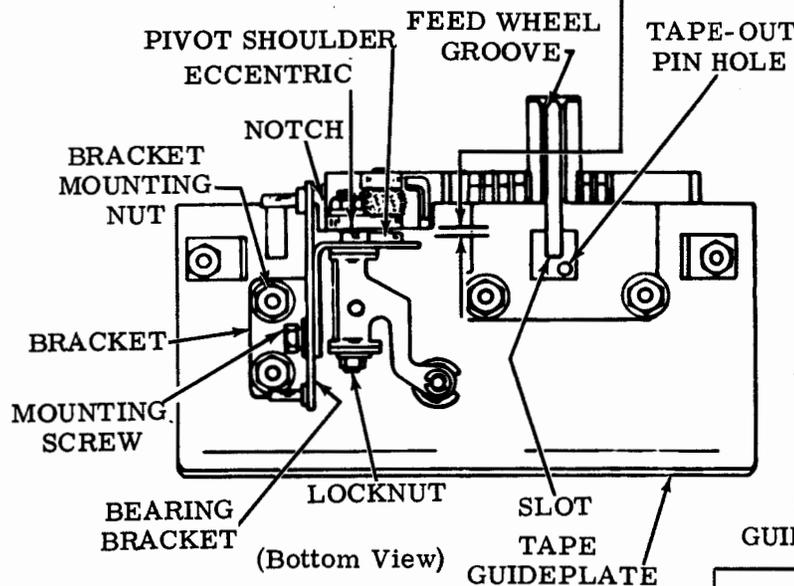
To Check

Remove top plate and tape guideplate.  
Lubricate before adjustment.

(1) Requirement

With tape lid held against notch in tape guideplate, feed wheel groove lined up with slot in tape guideplate, and tape-out pin holes lined up

Min some---Max 0.010 inch  
between tape lid and pivot shoulder.



To Adjust

Loosen bracket mounting nuts. Insert tip of appropriate gauge (Note 1) through slot in tape guideplate and into feed wheel groove. Position bracket. Tighten nuts.

Note 1: Use one of the following three gauges in making this adjustment:

<u>TAPE</u>	<u>GAUGE</u>
5-Level	TP156743
6-Level	TP170311 (In-Line Feed Hole)
6-Level	TP173503 (Advance Feed Hole)

(2) Requirement

With front bearing surface of tape lid touching tape guideplate

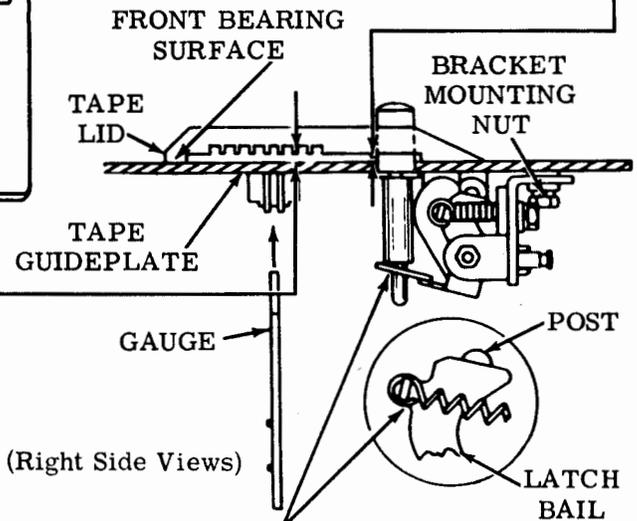
Min 0.010 inch---Max 0.018 inch  
between fin indicated and tape guideplate.

To Adjust

Loosen bearing bracket mounting screws. While pressing tape lid against tape guideplate, position bearing bracket. Recheck Requirement (1).

Note 2: If Requirement (2) cannot be met, position bearing bracket so that its mounting screws are located in centers of holes in bracket. Repeat Requirements (1) and (2).

Note 3: When tape guideplate and top plate are assembled to reader, tape lid may touch top plate, and a different clearance from that specified in Requirement (2) can be expected. However, with tape lid closed, there must always be at least 0.002 inch clearance between tape guideplate and heel pad.



(Right Side Views)

(3) Requirement

With tape lid latched against tape guideplate, release plunger must have some endplay.

To Adjust

Loosen locknut. Raise tape lid and rotate high part of eccentric towards bearing bracket. Close tape lid and continue rotating high part of eccentric towards bearing bracket until latch bail just falls under flat on post. Recheck operation of latch bail by depressing release plunger with tape lid held down.

2.06 Tape Lid (continued)

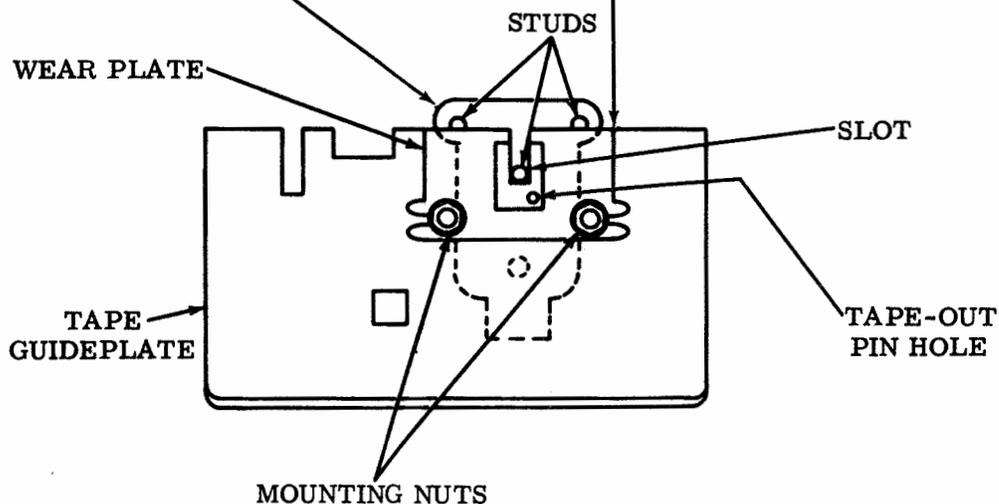
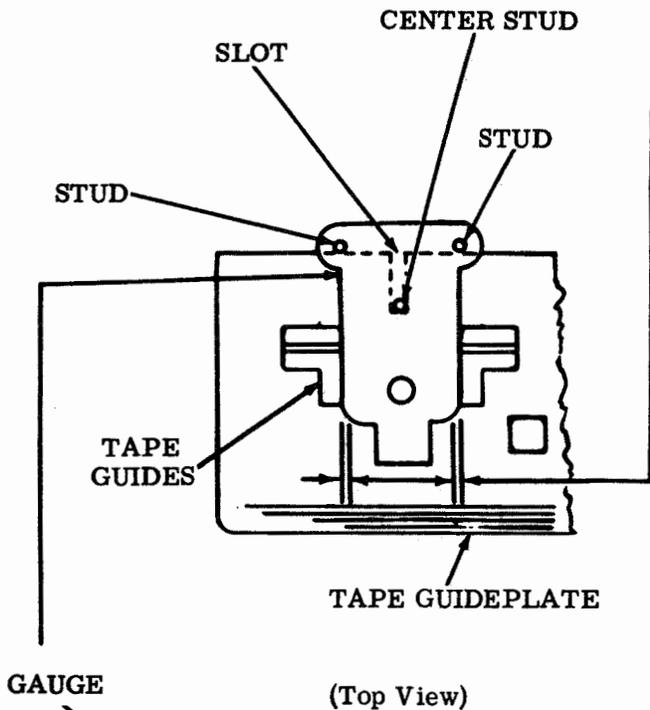
TAPE GUIDE

To Check  
Unlatch tape lid and position gauge as illustrated.

- (1) Requirement  
Min some---Max 0.003 inch between gauge and each tape guide.
- (2) Requirement  
Edge of wear plate flush with edge of tape guideplate.
- (3) Requirement  
Tape must not ride up the sides of the tape guides.

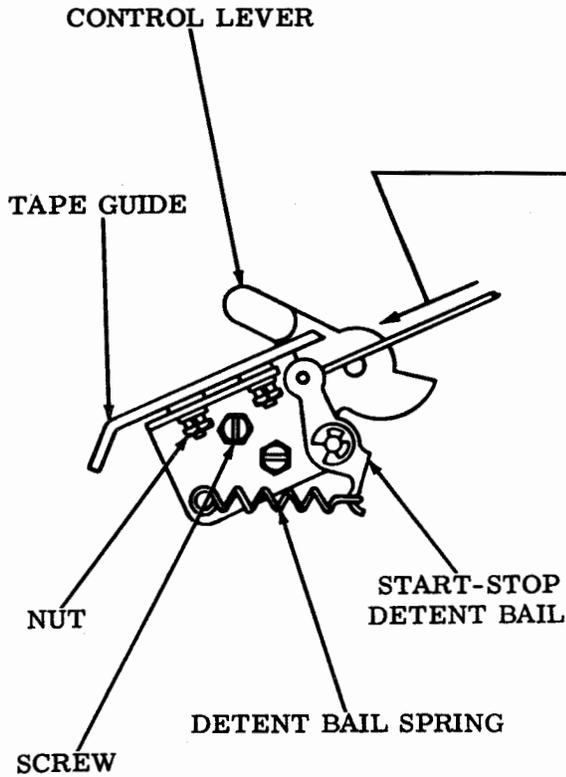
To Adjust  
Loosen mounting nuts. Position wear plate until it overhangs tape guideplate. Push gauge down until top two studs butt up against tape guideplate thus positioning edge of wear plate flush with edge of tape guideplate. Hold gauge and wear plate and position each tape guide to meet Requirement (1). Tighten mounting nuts.

Note: Tape guides may touch gauge, but they must not bind against gauge when it is removed.



(Bottom View)

2.07 Tape Lid (continued)



(Rear View)

(A) START-STOP DETENT BAIL SPRING

To Check  
Place control lever in run position.

Requirement  
Min 14 oz---Max 22 oz  
to start detent bail moving away from control lever.

(B) TAPE LID RELEASE PLUNGER SPRING

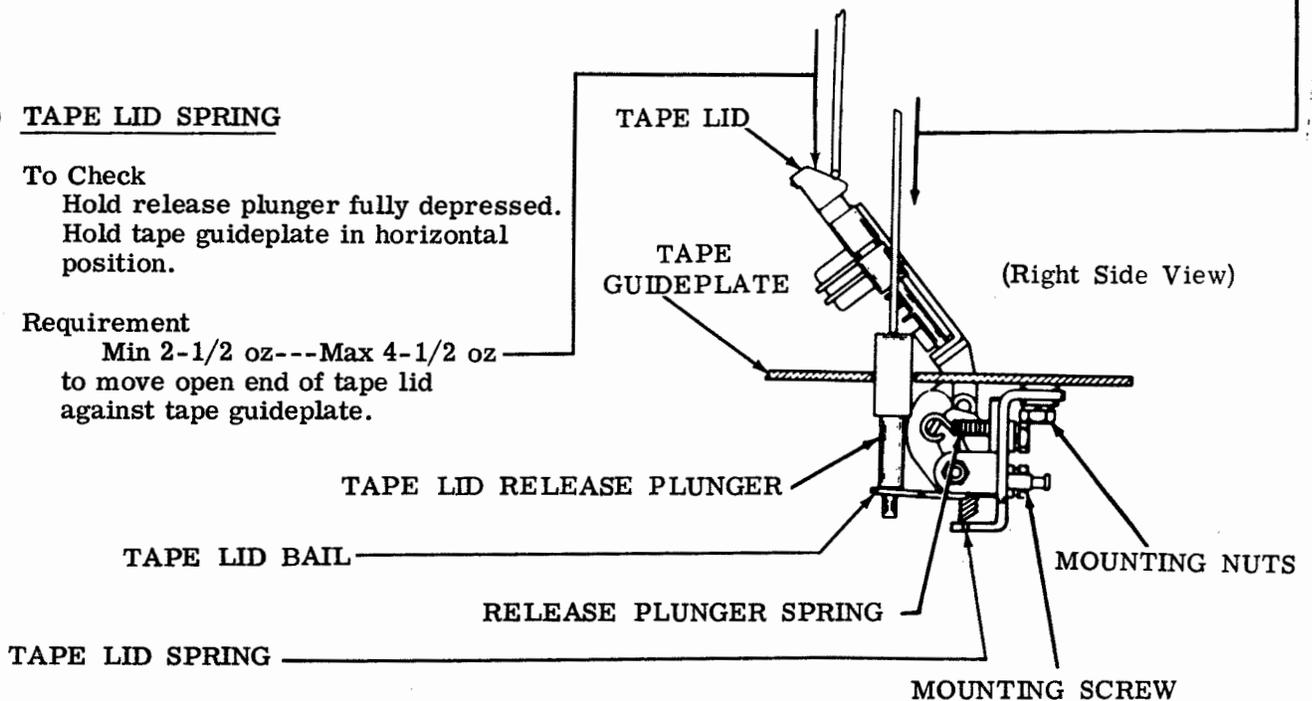
To Check  
Unlatch tape lid. Place tape guideplate in a horizontal position and hold it there.

Requirement  
Min 28 oz---Max 48 oz  
to start tape lid bail moving.

(C) TAPE LID SPRING

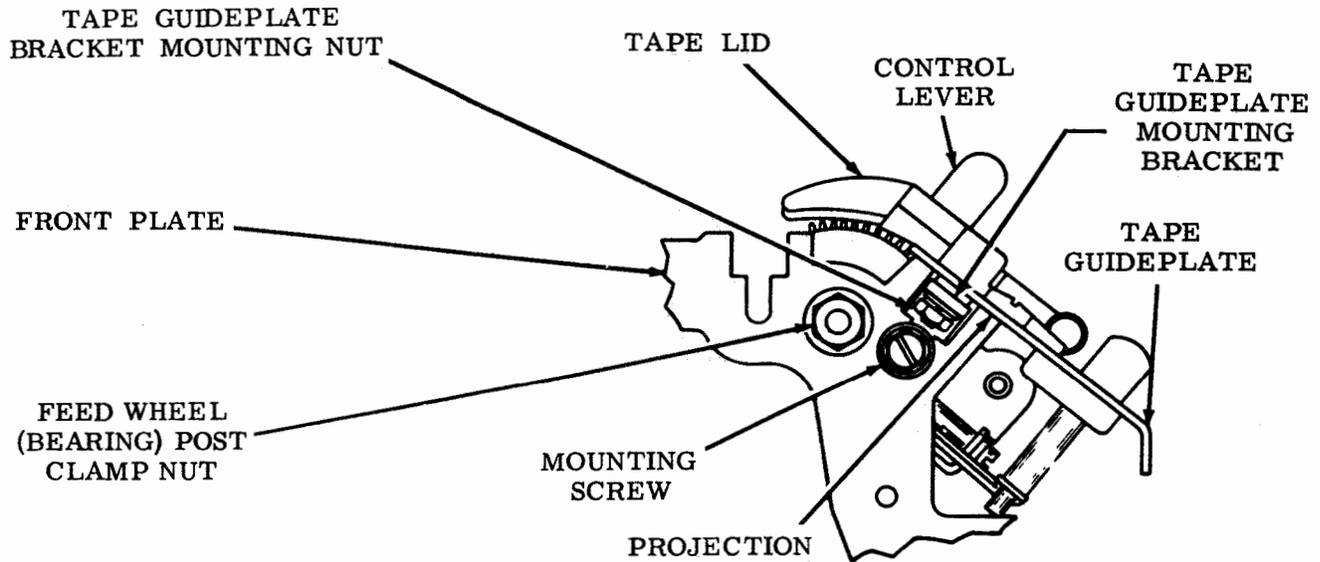
To Check  
Hold release plunger fully depressed.  
Hold tape guideplate in horizontal position.

Requirement  
Min 2-1/2 oz---Max 4-1/2 oz  
to move open end of tape lid against tape guideplate.



(Right Side View)

## 2.08 Tape Lid (continued)



Note 1: To prevent damage to the tape-out pin, position stop arm to its lowest position and hold control lever bail extension from feed wheel ratchet.

(Front View)

### TAPES GUIDEPLATE

#### (1) Requirement

Feed wheel post is not to interfere with mounting brackets of top plate and tape guideplate.

#### To Adjust

Loosen clamp nut and rotate feed wheel post.

#### (2) Requirement

Tape guideplate to rest firmly against a minimum of three of the four projections on side plates.

#### To Adjust

Rotate unit clutch to its stop position. Trip clutch to put sensing pins in their highest positions. Unlatch tape lid and place control lever to run position. Loosen mounting screws and mounting nuts. Position tape guideplate on reader to meet Requirement (2). Position tape-out pin into hole in tape guideplate. Tighten mounting screws.

Note 2: Mounting nuts loosened in Requirement (2) are tightened after performing Requirement (3) and TOP PLATE adjustment.

#### (3) Requirement

Edge of tape guideplate to project over side plates by equal amounts as gauged by eye.

#### To Adjust

Position type guideplate.

Note 3: Tight-tape bail extension must be under top plate.

2.09 Top Plate

TOP PLATE

To Check

Remove cover plate and unlatch the tape lid.

(1) Requirement

Min flush---Max 0.003 inch  
below top surface of tape guideplate  
along width of tape lid when top plate  
is resting on a minimum of five of the  
six projections on side plates.

To Adjust

Loosen mounting screws and mounting  
nuts friction tight. Position top plate.  
Tighten mounting screws. Tighten tape  
guideplate mounting nuts left friction  
tight in TAPE GUIDEPLATE adjustment.

Note: Mounting nuts loosened in  
Requirement (1) above are tightened  
after performing Requirement (2)  
below.

(2) Requirement

Feed wheel slot to align with slot in  
tape guideplate so that feed wheel ro-  
tates freely with control lever in free  
position.

To Adjust

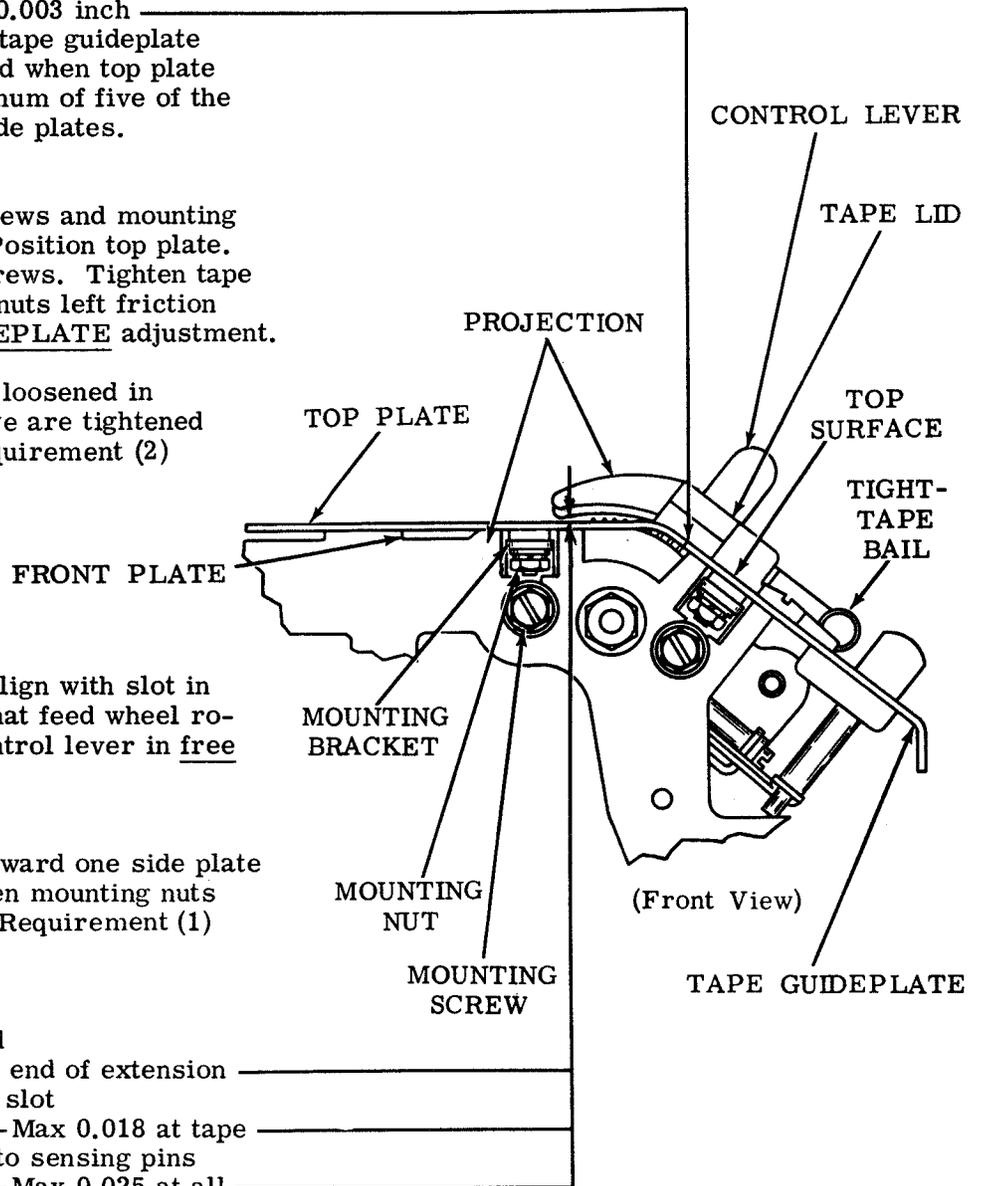
Position top plate toward one side plate  
or the other. Tighten mounting nuts  
left friction tight in Requirement (1)  
above.

(3) Requirement

With tape lid latched  
Min 0.010 inch at end of extension  
covering feed wheel slot  
Min 0.010 inch---Max 0.018 at tape  
guideplate adjacent to sensing pins  
Min 0.010 inch---Max 0.025 at all  
other areas  
between tape lid projection and top plate  
with play taken up toward tape guide-  
plate.

To Adjust

Loosen tape lid bearing bracket mount-  
ing screws. Position tape lid. Recheck  
TAPE LID adjustment, Requirements  
(1) and (2).



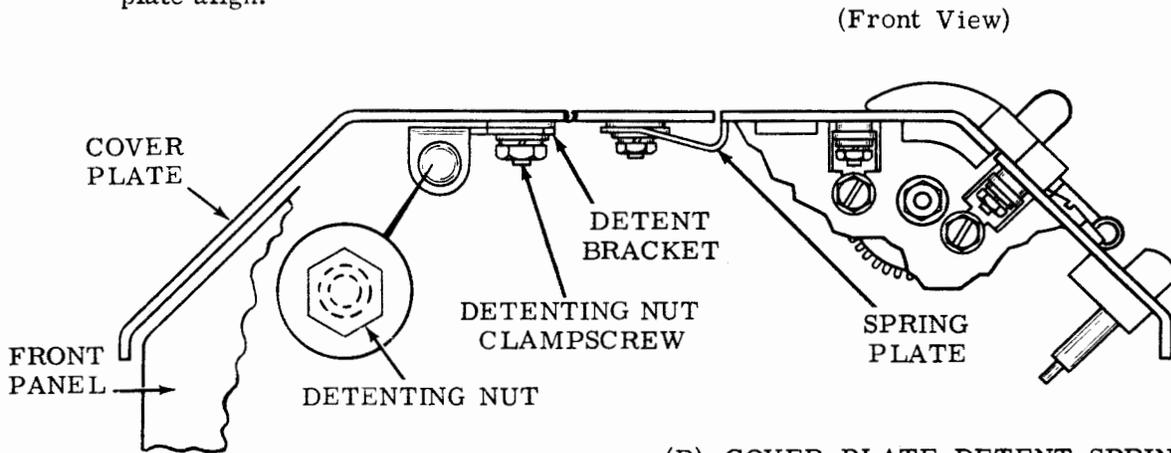
2.10 Cover Plate

(A) COVER PLATE

- (1) Requirement  
Right edge of cover plate holds flush against left edge of top plate by the cover plate detents.
- (2) Requirement  
Cover plate rests against at least three of the four projections (front and rear plate).
- (3) Requirement  
Front edge of cover plate and top plate align.

To Adjust

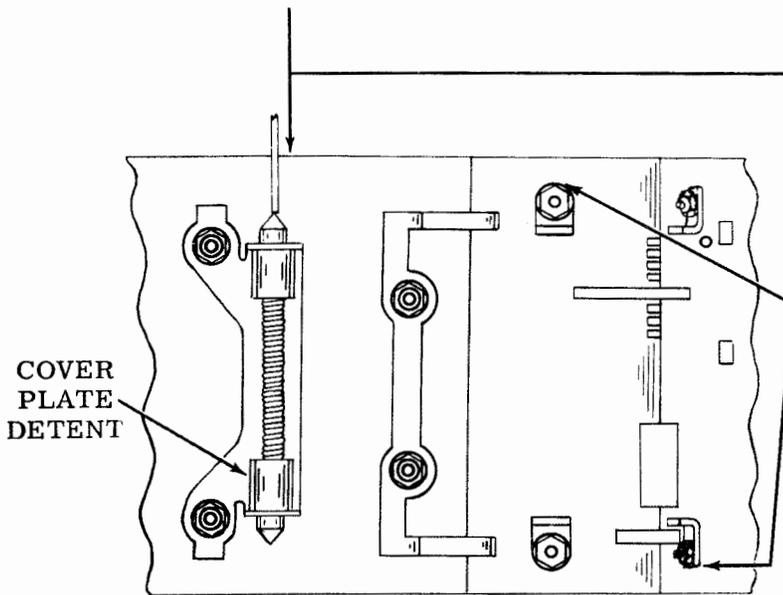
With detenting nut clampscrew (front and rear plate) friction tight, move clampscrews to their extreme lower right position, then tighten screws. Loosen detent bracket and spring plate mounting nuts. Place cover on unit and position horizontally to meet requirements. Retighten mounting nuts.



(B) COVER PLATE DETENT SPRING

Requirement

With spring scale applied to center of one detent  
 --- Min 28 oz---Max 48 oz  
 to start plunger moving.



Note: Outer edge of each mounting bracket should be approximately in line with shoulder of its mounting stud. Replace tape guideplate, tape-out tension spring, top plate, and cover plate.

(Bottom View)

2.11 Tape-Out Switch Assembly

(A) TAPE-OUT CONTACT ASSEMBLY

To Check

Loosen spring bracket and move downward until tape-out pin extension no longer touches insulation on contact swinger.

(1) Requirement

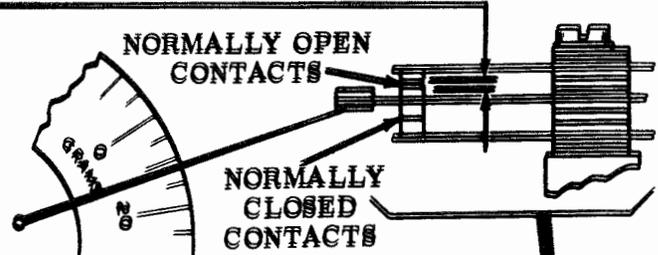
Min 8 grams---Max 15 grams to separate normally closed contacts.

(2) Requirement

Min 0.008 inch---Max 0.015 inch between normally open contacts.

To Adjust

Remove tape-out contact assembly from unit by unhooking tape-out pin spring and removing bracket mounting screws. Form contact swinger using TP110445 spring bender. Replace contact assembly with swinger over tape-out pin extension. Place spring bracket shoulder bushing on upper hole and the washer on lower mounting hole. Rehook tape-out pin spring.



(B) TAPE-OUT SENSING PIN SPRING

To Check

Place control lever in run position.

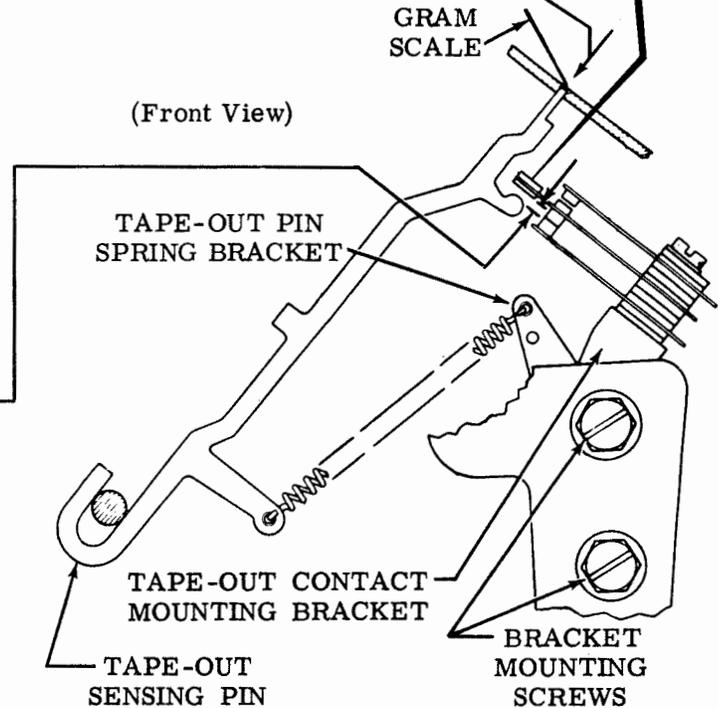
Requirement

Min 38 grams---Max 45 grams to move tape-out pin to a position flush with tape guideplate.

To Adjust

Loosen lower bracket mounting screw and position spring bracket to meet requirement. Retighten bracket mounting screw.

(Front View)



(C) TAPE-OUT CONTACT BRACKET

To Check

Insert tape under tape lid to hold tape-out pin down.

Requirement

Min 0.006 inch---Max 0.020 inch between tape-out pin upper extension and underside of insulation on swinger contact.

To Adjust

Loosen bracket mounting screws and adjust bracket. Retighten mounting bracket screws.

2.12 Tape-Out Switch Assembly (continued)

(B) DEPRESSOR BAIL TORSION SPRING

To Check

Place control lever in stop position.  
Unhook one end of intermediate tape-out bail spring.

Requirement

Min 2-3/4 oz---Max 5-1/2 oz  
to start tape-out bail moving away from tape-out pin depressor bail.

(C) INTERMEDIATE TAPE-OUT BAIL SPRING

To Check

Place control lever in run position.  
Unhook intermediate tape-out bail spring at post end.

Requirement

Min 3 oz---Max 5 oz  
\*Min 2 oz---Max 3 oz  
to pull intermediate tape-out bail to its installed length.  
\*5-level only

(A) TAPE-OUT SENSING PIN

(1) To Check

Place control lever in stop position.

Requirement

Top of pin to be  
Min flush---Max 0.010 inch  
below surface of tape guideplate.

To Adjust

Loosen stop arm clampscrew.  
friction tight. Position stop arm to meet requirement. Retighten clampscrew.

(2) To Check

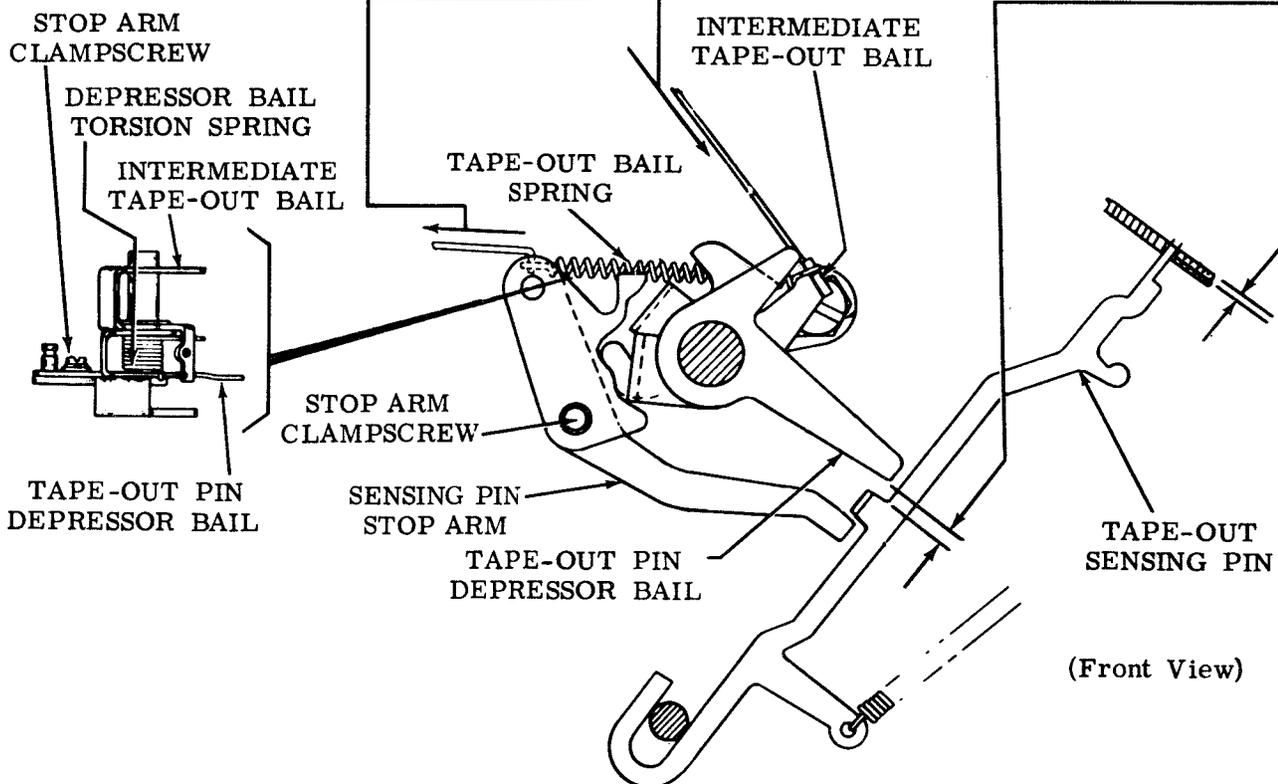
Place control lever in run position.

Requirement

Clearance as shown should be  
Min 0.055 inch

To Adjust

Loosen tape-out bail clampscrew.  
Position extension arm to meet requirement. Retighten clamp screw. Recheck requirement under (1) To Check.



SECTION 573-127-703TC

2.13 Tape-Out Switch Assembly (continued)

TAPE-OUT SENSING PIN (For Units Equipped with  
Tape Lid Sensing Lever)

To Check

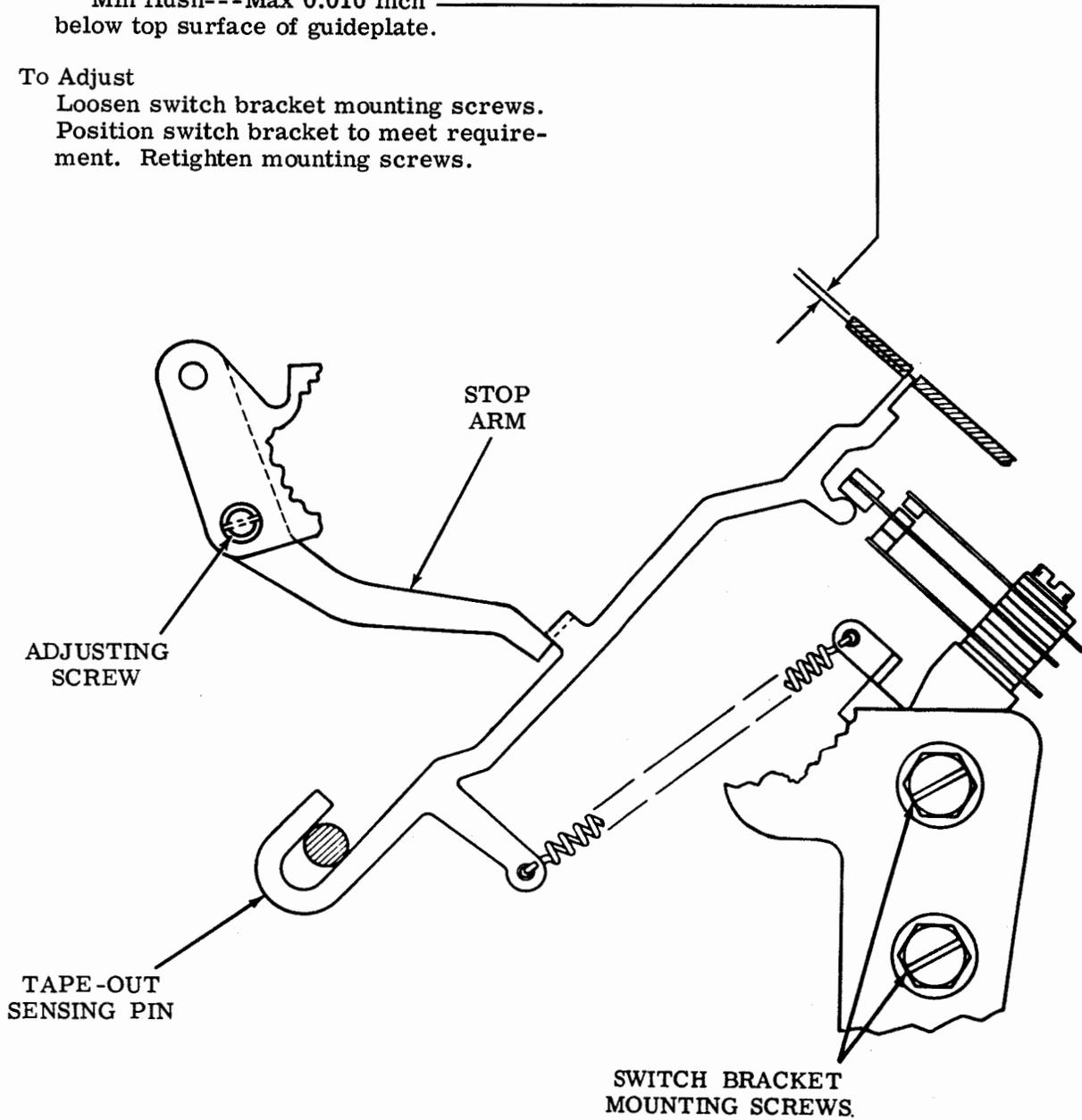
Hold tape-out pin manually against stop  
arm.

Requirement

Top of pin to be  
Min flush---Max 0.010 inch  
below top surface of guideplate.

To Adjust

Loosen switch bracket mounting screws.  
Position switch bracket to meet require-  
ment. Retighten mounting screws.



(Front View)

2.14 Start-Stop Switch Assembly

(A) START-STOP SWITCH BRACKET

To Check  
Place control lever in run position.  
Disengage clutch.

(1) Requirement  
Min 0.006 inch---Max 0.015 inch  
between start-stop bail extension  
and insulator on start-stop switch  
swinger.

To Adjust  
Loosen switch bracket mounting  
screws. Position switch bracket  
to meet requirement. Retighten  
bracket mounting screws.

(2) Requirement  
Start-stop bail extension and con-  
tact arm to fully engage insulated  
portion of start-stop switch  
swinger.

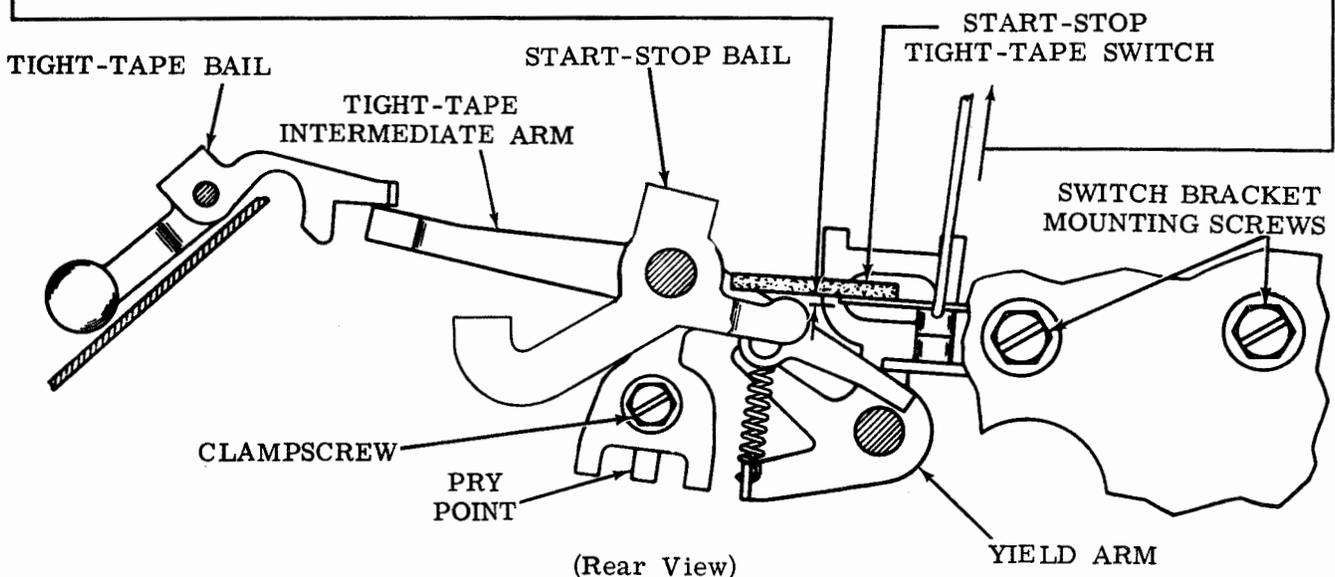
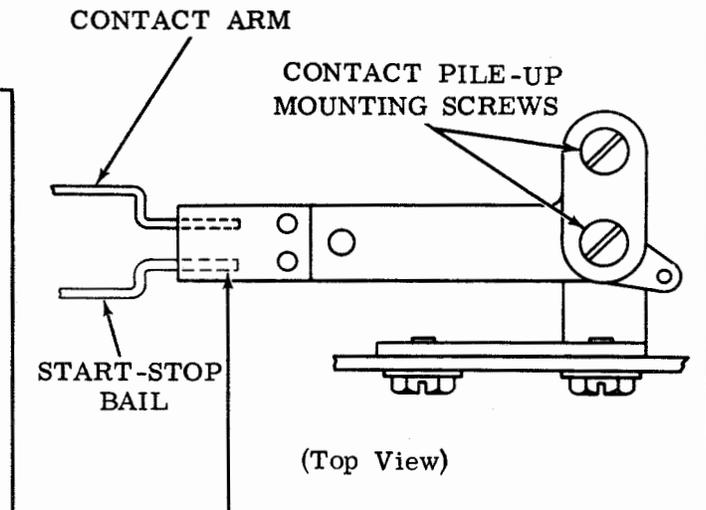
To Adjust  
Loosen mounting screws and  
position start-stop switch swinger  
to meet requirement. Retighten  
mounting screw.

(B) TIGHT-TAPE START-STOP CONTACT SPRING

To Check  
Place control lever in run position.

Requirement  
Min 3 oz---Max 4 oz---  
to separate contacts.

To Adjust  
Bend break contact spring with  
TP110445 bending tool. Recheck  
START-STOP SWITCH BRACKET  
adjustment.



2.15 Tight-Tape Mechanism

START-STOP SWITCH BRACKET (For Units Equipped with Tape Lid Sensing Lever)

To Check

Place intermediate tight-tape arm to center of its adjusting range with the contact arm.

(1) Requirement

Tight-tape start-stop contacts to:

- (a) Remain closed when tight-tape bail is raised 0.045 inch
- (b) Open as bail is raised to 0.075 inch.

To Adjust

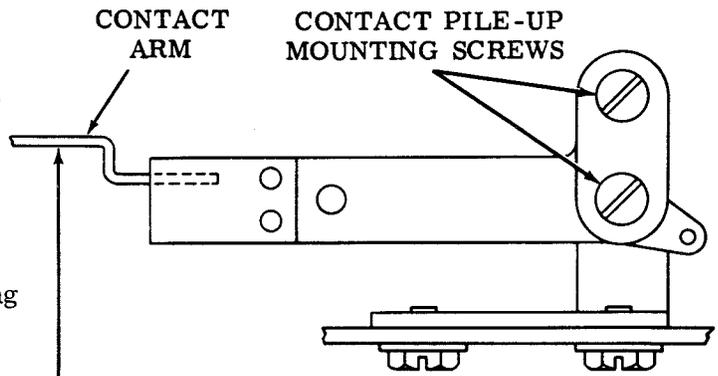
- (a) Loosen tight-tape intermediate arm clampscrew. Position pry point midway in contact operating arm adjusting slot. Retighten clampscrew.
- (b) Loosen switch bracket screws friction tight. Position contact pile-up to meet requirement.

(2) Requirement

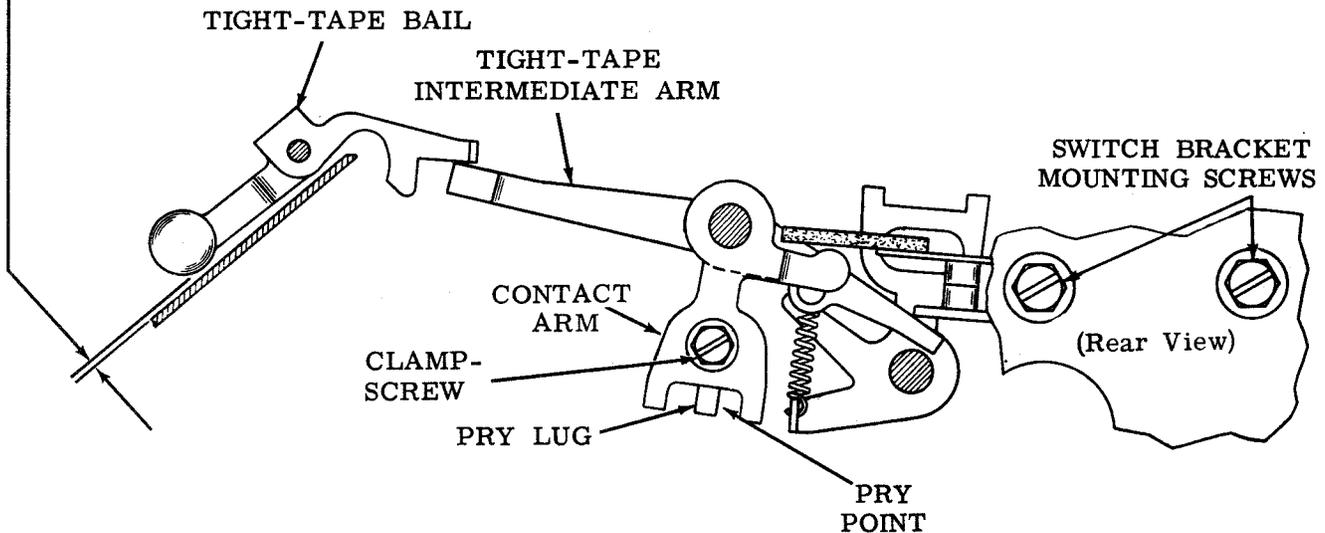
Contact arm to fully engage insulated part of switch swinger.

To Adjust

Loosen contact pile-up mounting screws. Position contact pile-up mounting bracket. Retighten mounting screws.



(Top View)



(Rear View)

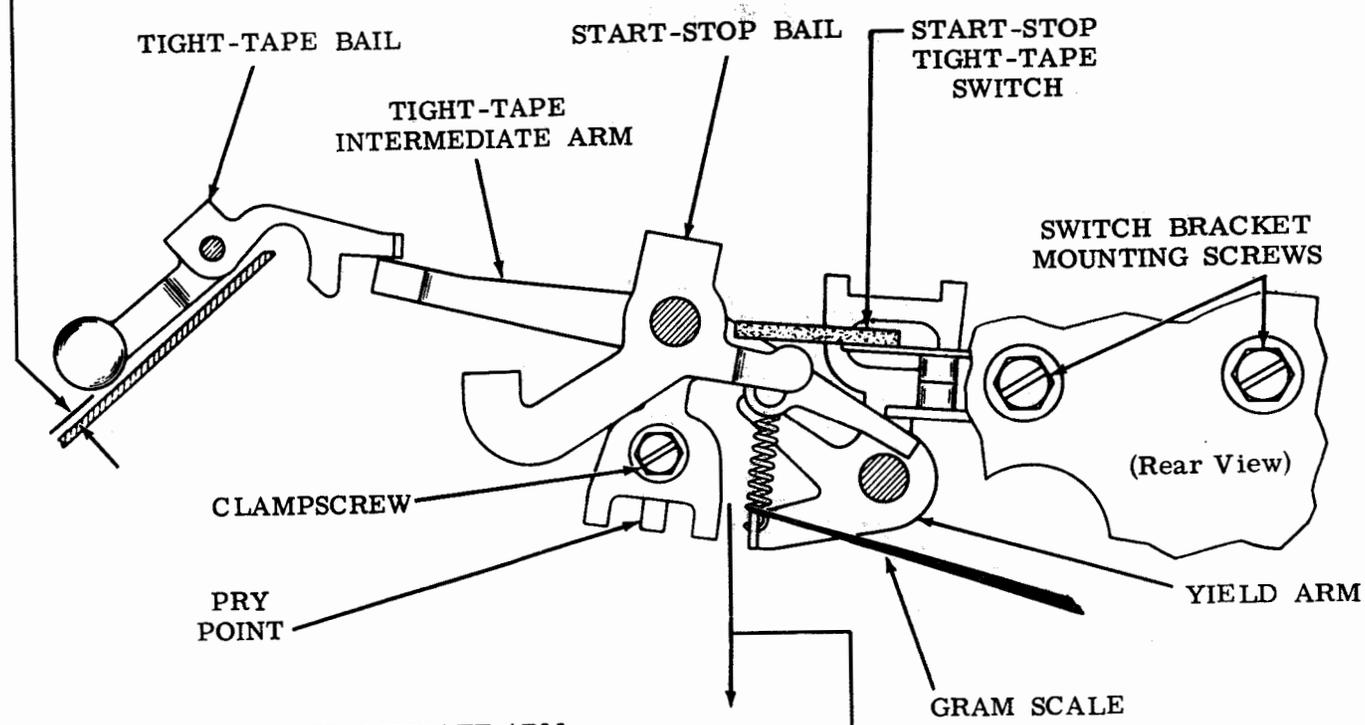
2.16 Tight-Tape Mechanism (continued)

(A) TIGHT-TAPE INTERMEDIATE ARM

To Check  
Place control lever in run position.

Requirement  
Start-stop contacts when tight-tape bail is raised away from tape guideplate:  
(a) Remain closed when bail is raised 0.045 inch.  
(b) Open as bail is raised to 0.075 inch.

To Adjust  
Loosen clampscrew and position tight-tape intermediate arm using pry points. Retighten clampscrew.



(B) TIGHT-TAPE INTERMEDIATE ARM SPRING

To Check  
Place control lever in run position.

Requirement  
Min 20 grams (3/4 oz)---Max 40 grams (1-1/2 oz) to start yield arm moving.

2.17 Feed Wheel Mechanism

(D) MAIN BAIL

To Check  
Place sensing pins in their lowest position.

Requirement  
Highest sensing pin should be  
Min 0.010---Max 0.020 inch  
below surface of tape guideplate.

To Adjust  
Loosen nut on main bail eccentric.  
Keeping high part towards right, adjust  
eccentric to meet this requirement.  
Retighten nut on main bail eccentric.

(B) FEED RATCHET DETENT SPRING

To Check  
Rotate clutch to stop position. Hold  
feed pawl away from feed wheel  
ratchet.

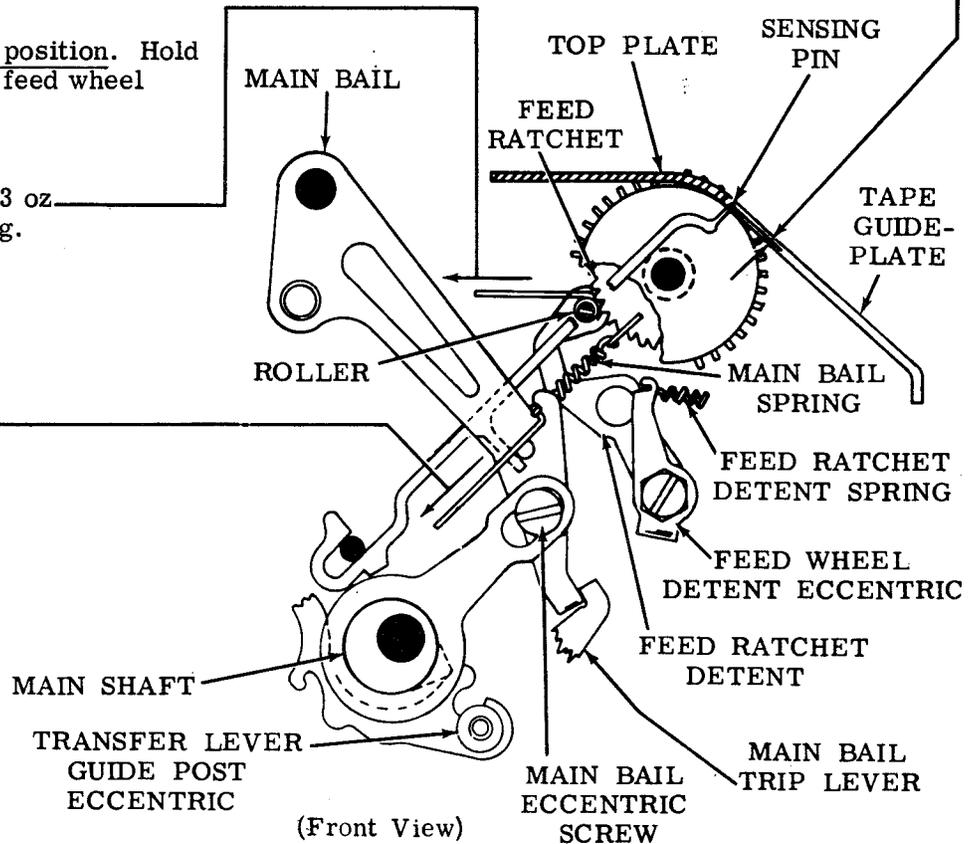
Requirement  
Min 8 oz---Max 13 oz  
to start detent moving.

(C) MAIN BAIL TRIP LEVER

To Check  
Replace top plate. Disengage unit  
clutch.

Requirement  
Tip of highest sensing pin to be  
Min flush---Max 0.005 inch  
below top surface of tape guideplate.

To Adjust  
Loosen nuts which secure transfer  
lever guide post and rotate it so that  
guide post eccentric positions main  
bail trip lever to meet requirement.  
Tighten nuts. Trip clutch and rotate  
it while checking operation of moving  
parts.



(A) MAIN BAIL SPRING

To Check  
Remove top plate. Disengage clutch.  
Unhook spring end from main bail.

Requirement  
Min 6 oz---Max 10 oz  
to pull main bail to installed length.

2.18 Feed Wheel Mechanism (continued)

(A) SENSING PIN SPRING

To Check

Open tape lid, and disengage unit clutch. Then hold armature in the attracted position to unlatch main bail and place sensing pins in their uppermost position. Hold rub-out deleter bail (if present) away from the sensing pins.

Requirement

\*Chadless tape

Min 3 oz---Max 5 oz

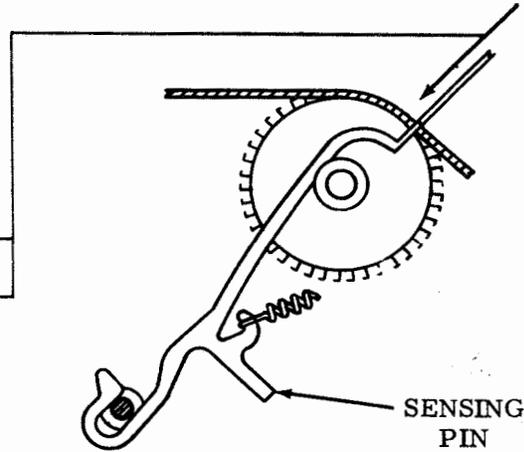
\*\*Perforated tape

Min 2 oz---Max 3 oz

to move each sensing pin flush with tape guide plate.

\*For units using TP154349 spring —  
5-level units

\*\*For units using TP151103 spring —  
6-level units



(Front View)

(B) FEED WHEEL DETENT

To Check

Open tape lid. Disengage the unit clutch to place sensing pins in their lowest position. Place high part of feed wheel ratchet detent eccentric toward the right. With an all marking code combination punched into a new piece of tape, place the tape on the feed wheel and over the sensing pins. Take up play in tape lightly toward the right.

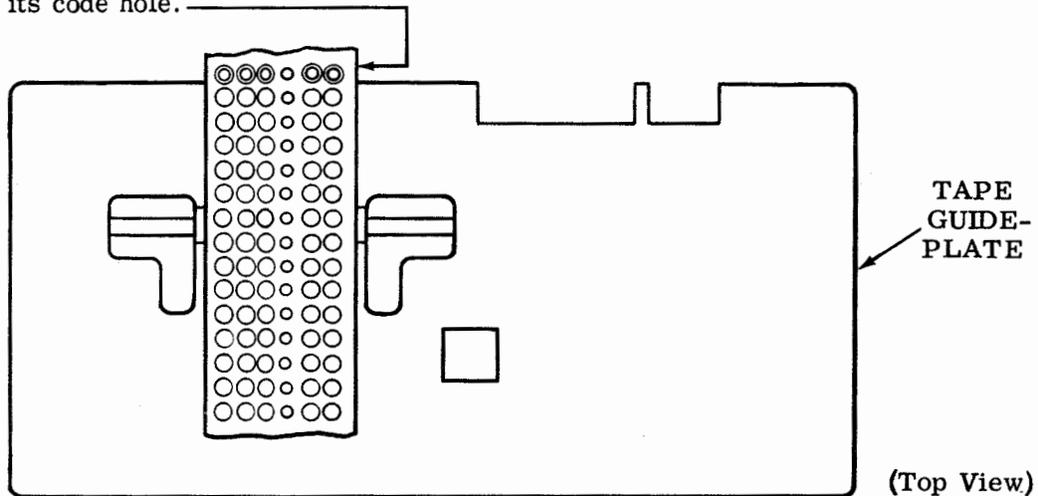
To Adjust

Loosen feed wheel ratchet detent eccentric friction tight and hold feed pawl away from feed wheel ratchet. Rotate feed wheel ratchet detent eccentric, keeping high part of eccentric towards the right.

Note: When unit is used to read chadless spliced tape, the sensing pins should be made to favor the trailing edge of the code hole.

Requirement

Tip of each sensing pin to be centrally located in its code hole.



(Top View)

SECTION 573-127-703TC

2.19 Feed Wheel Mechanism (continued)

(A) FEED PAWL

To Check

Remove the top plate. With the high part of the feed pawl eccentric towards the right,\* (viewed from rear plate) disengage the clutch to place the sensing pins in their lowest position.

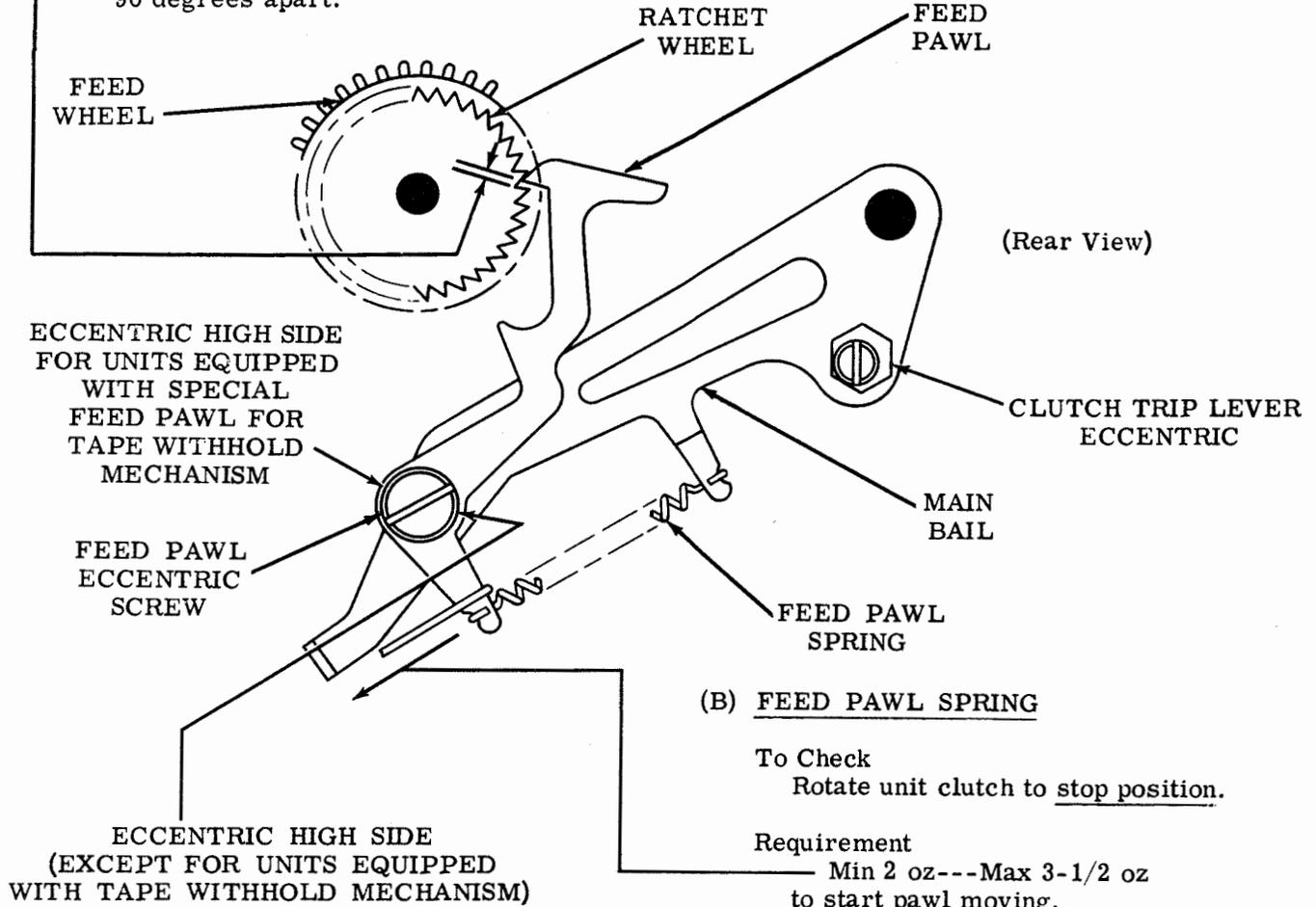
\*Left for units equipped with tape withhold mechanism.

Requirement

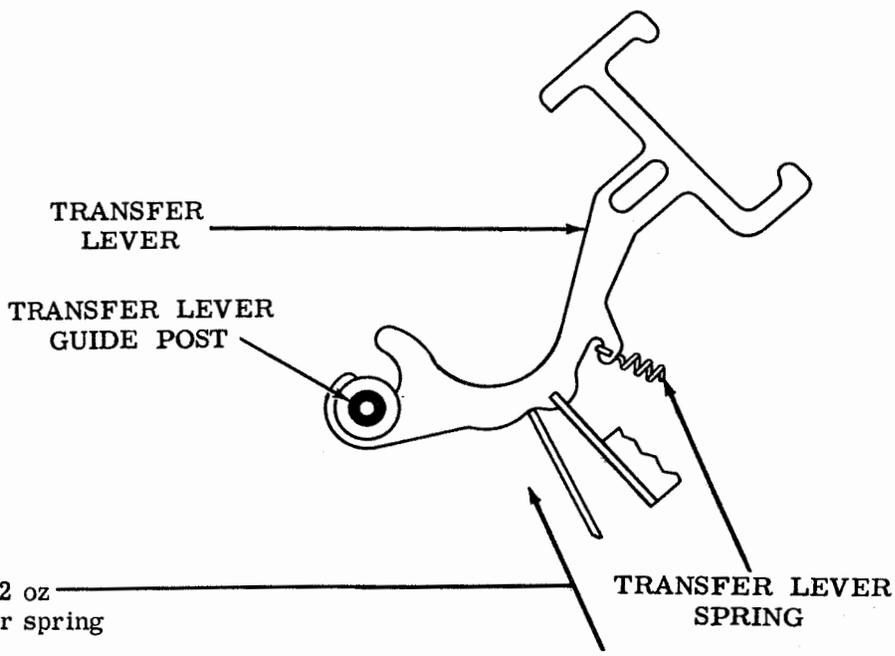
Min some---Max 0.003 inch between feed pawl and ratchet tooth just engaged.

To Adjust

Loosen feed pawl eccentric locknut, and position feed pawl eccentric. Re-check requirement at four positions on feed wheel ratchet approximately 90 degrees apart.



2.20 Transfer Mechanism

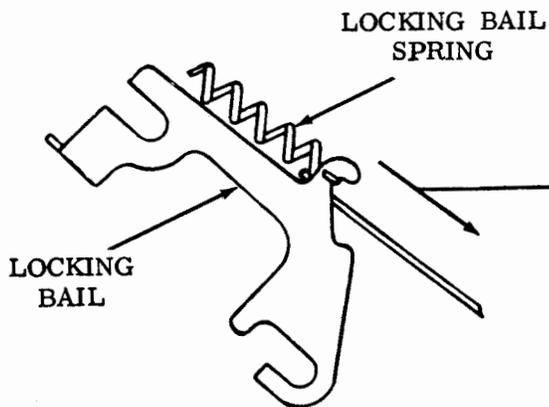


(A) TRANSFER LEVER SPRING

To Check  
Disengage unit clutch.

Requirement  
Min 1/2 oz---Max 1-1/2 oz  
to start each transfer lever spring  
moving.

(Rear View)

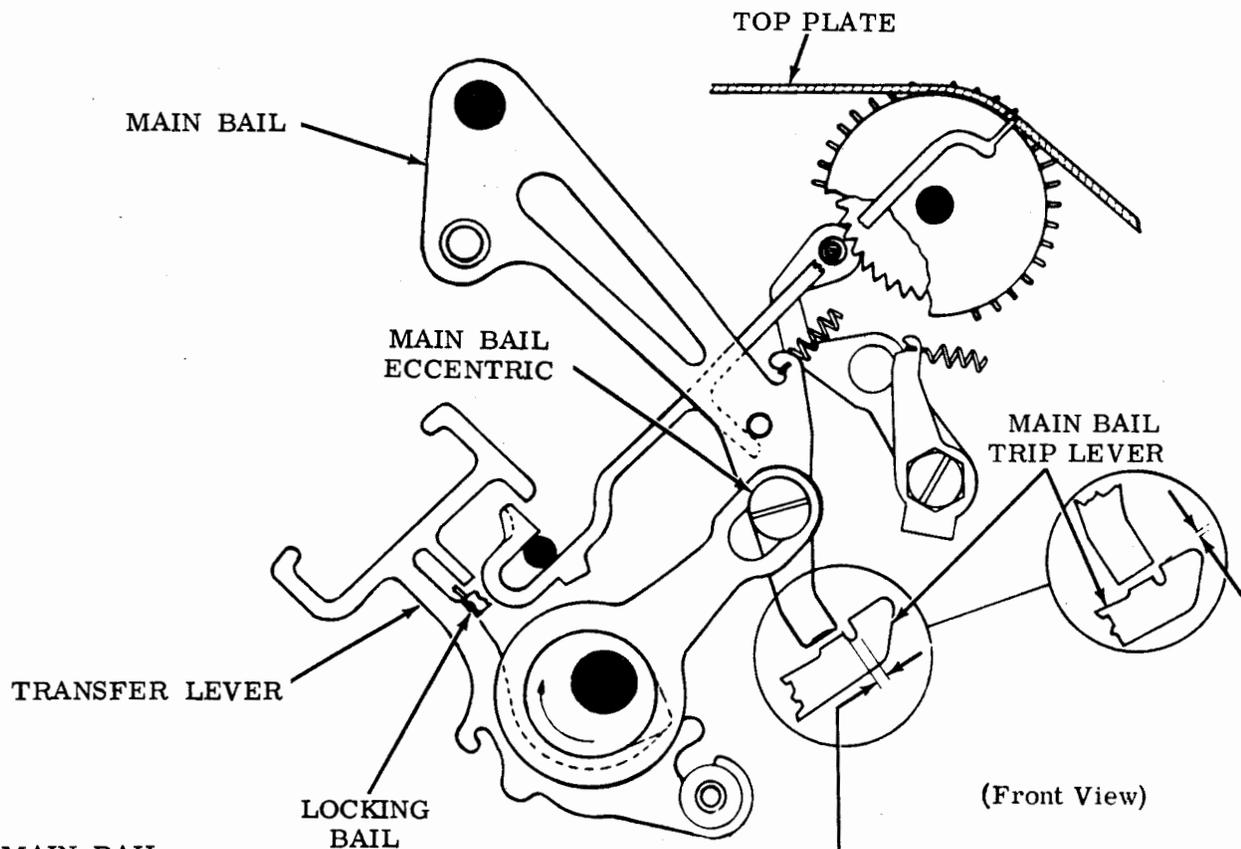


(B) LOCKING BAIL SPRING

Requirement  
Min 10 oz---Max 14 oz  
to pull locking bail spring to its  
installed length.

(Front View)

2.21 Main Bail



MAIN BAIL

- (1) To Check  
 Hold armature in its attracted (energized) position and rotate clutch until main bail is on its lowest position.

Requirement

Min 0.005 inch---Max 0.015 inch  
 between main bail and main bail trip lever.

- (2) To Check  
 Hold armature in its attracted (energized) position and rotate clutch until main bail is in its highest position.

Requirement

Min 0.005 inch  
 between vertical surfaces of main bail and main bail trip lever.

To Adjust

Loosen nut on main bail and position main bail eccentric. Retighten nut. Check MAIN BAIL TRIP LEVER adjustment. Refine, if necessary.

## 2.22 Transfer Bail

(A) TRANSFER BAIL STABILIZER

- (1) To Check  
 Select a LETTERS combination.  
 Rotate main shaft until #3 transfer lever is on high part of its cam.  
 Check clearance between side of transfer bail extension and marking latch.
- (2) To Check  
 Select a BLANKS combination.  
 Rotate main shaft until #3 transfer lever is on high part of its cam.  
 Check clearance between side of transfer bail extension and spacing latch.

Requirement  
 Clearance in marking and spacing positions should be equal within 0.002 inch.

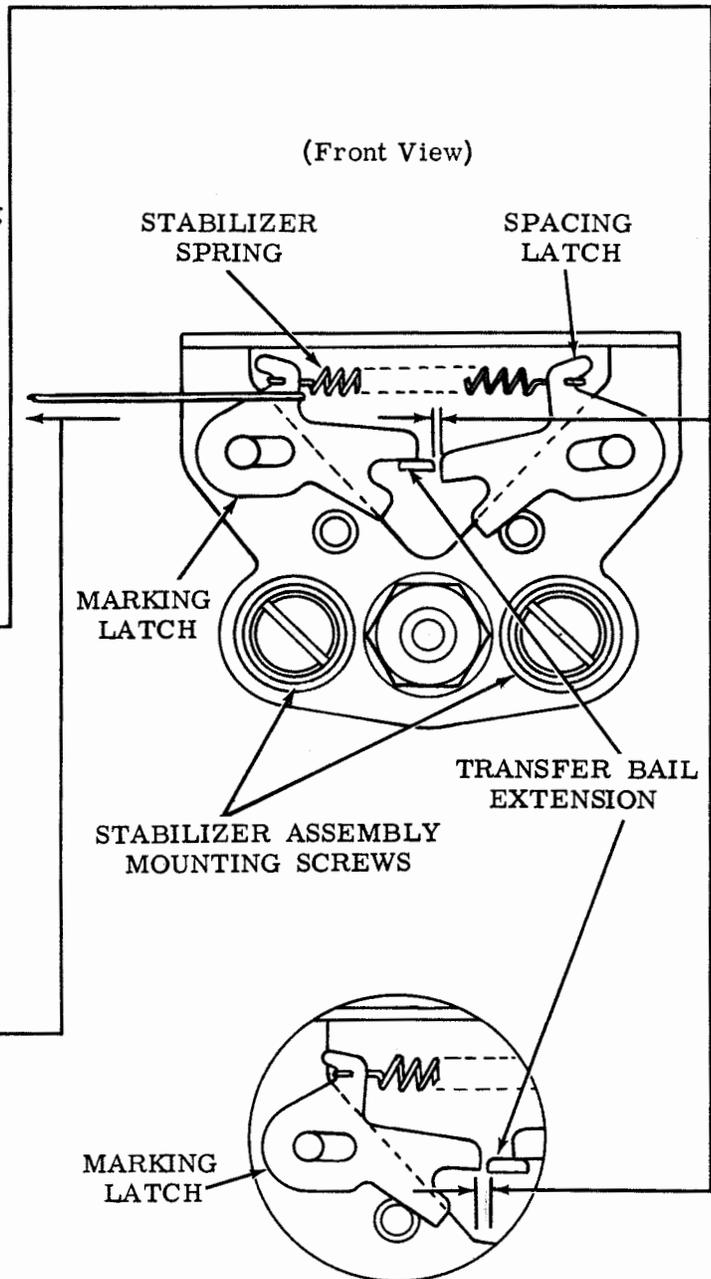
To Adjust  
 Loosen stabilizer assembly mounting screws friction tight, and position the assembly. Retighten assembly mounting screws.

(B) STABILIZER SPRING

To Check  
 Rotate clutch to stop position.

Requirement  
 Min 2-1/2 oz---Max 5 oz  
 to start stabilizer latch moving.

Note: Latches should drop in place as other transfer levers cam the transfer bail.



2.23 Signal Contacts

(A) SIGNAL CONTACT CLEARANCE

To Check

Remove cover plate and signal contact box cover. Engage the unit clutch and rotate main shaft slowly until spacing contact is fully open. Measure the gap. Continue rotating the main shaft until marking contact is fully open. Measure the gap.

Requirement

Marking and spacing contact gaps measured in To Check to be equal within 0.001 inch.

To Adjust

Loosen mounting screws and position contact box using eccentric.

Note: Before operating, refine SIGNAL CONTACT CLEARANCE adjustment in accordance with Signal Contacts — Electrical.

**CAUTION:** IF CONTACTS ARE GOLD PLATED, CLEAN THEM BY PARTIALLY DRAWING A STRIP OF TP107162 TWILL JEAN BETWEEN THEM.

(B) DRIVE LINK SPRING

To Check

Trip clutch and rotate main shaft to stop position. Unhook stabilizer spring, and move latches away from transfer bail extension. Hold toggle firmly against spacing contact.

Requirement

Min 6 oz---Max 12 oz to start transfer bail extension moving.

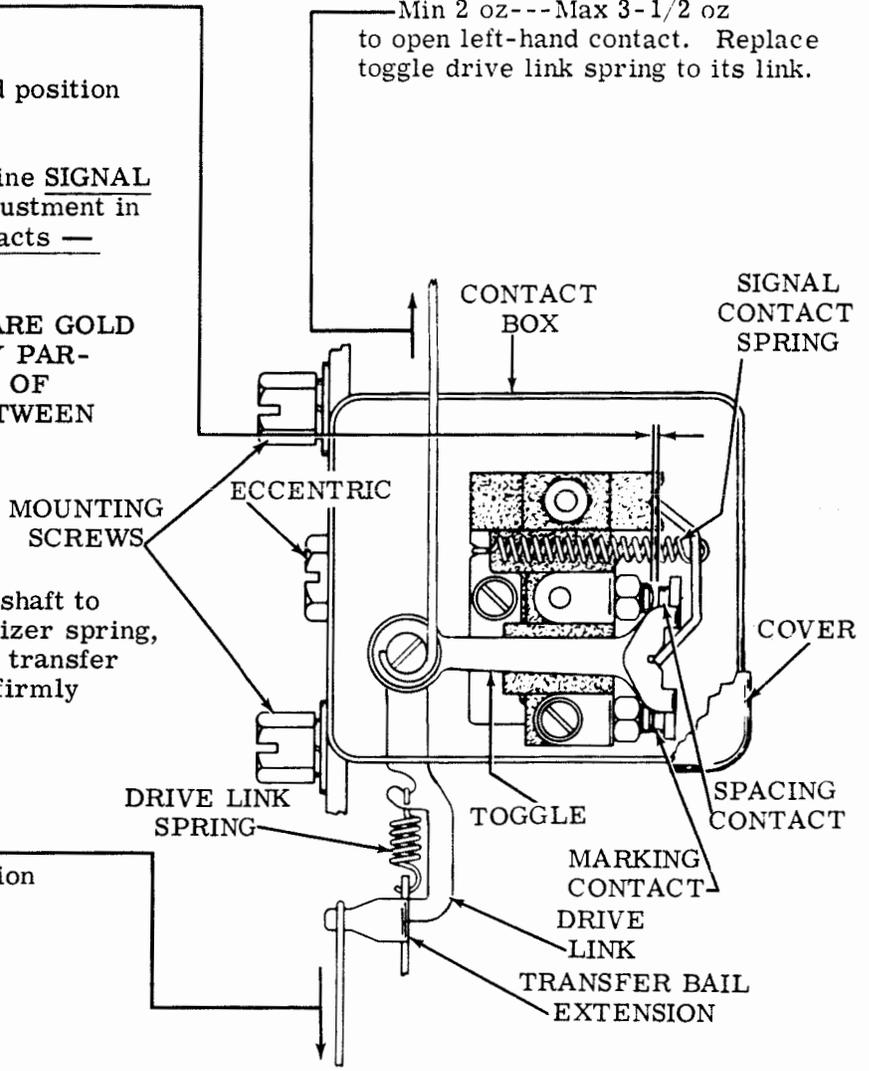
(C) SIGNAL CONTACT SPRING (TRANSMITTER DISTRIBUTOR SETS ONLY)

To Check

Place transmitter in stop position. Remove contact box cover, and toggle drive link spring from its link end. Move transfer bail towards the right (spacing) position, so that both toggle contacts are closed. Hook an 8-oz scale over the pivot screw and pull horizontally to the left.

Requirement

Min 2 oz---Max 3-1/2 oz to open left-hand contact. Replace toggle drive link spring to its link.



(Top View - Right Side)

## Signal Contacts — Electrical

2.24 The strobing adjustment procedure is used for checking and adjusting signal contacts electrically, and at the same time, refining the mechanical adjustments for the transmitter distributor. The same procedure is used for checking both the marking and spacing pulses for both 5 and 6 level, and all unit codes. Differences exist, however, in the number, width, and tolerance of pulses, and in the allowable break width. The data appropriate to each level and unit code is tabulated on the associated Pulse Data Table. By following the general procedures given in Paragraphs 2.25 and 2.26 following, and using data from the appropriate table, the marking and spacing pulse adjustment can be made for all units. To illustrate the procedure further, the data appropriate to a 5-level, 7.42 unit code is added parenthetically as an example in the general adjustment procedure following.

Note: Gold-plated signal contacts should not be electrically adjusted unless there is an intermediate device available which, when keyed by the signal contacts, will interrupt the current to the stroboscopic test set. The intermediate device must be capable of being keyed by a 3- to 20-volt change in voltage at a current not in excess of 20 milliamperes. The standard stroboscopic test set operating voltage must not be applied directly to the signal contacts because of the possibility of damaging the contacts' gold plating and thus impairing their operating efficiency in this low-energy level application. (Refer to Paragraphs 1.08 through 1.13.)

## 2.25 Marking Pulse Adjustments

(a) Plug a signal distortion test set having the appropriate scale (eg, 7.42) into the signal line so that the marking contacts of the transmitter-distributor unit under test will interrupt the current to the stroboscopic lamp within the DXD. Have the transmitter-distributor transmitting "Y" or "R" continuously and the test set and transmitter-distributor operating at the same speed (100 wpm). Rotate the test scale to align the 0-scale mark of the START segment (end of STOP segment) with the end of the stop pulse image indicated by the rotating strobe light.

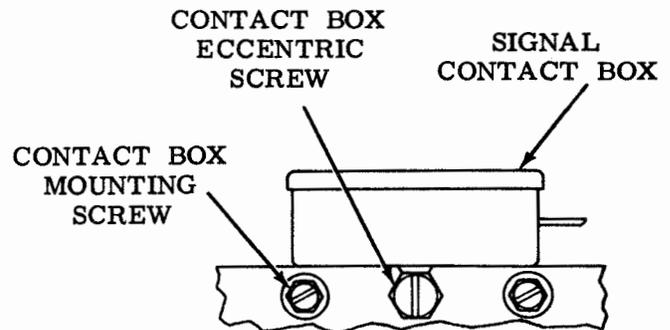
Note: The end of the stop pulse image should not vary more than one division in

either direction when the scale is positioned so that the variation is centered about the 0-scale mark of the START segment.

(b) Check the position of each of the pulses against the position tabulated. Each pulse should be in its designated segment on the test scale, within the specified tolerance figure (eg, 15 div).

Note: Each marking code pulse may have one break, provided the break is not longer than the allowable break width specified (eg, 1 div) and the break comes within the tolerance range (eg, 5 div) and the end of the pulse.

(c) To adjust, loosen the two contact box mounting screws until they are friction tight. Rotate the eccentric of the contact box mounting bracket toward the right or left until the requirements are met. Tighten the mounting screws and recheck the adjustment.



(Front View)

Note: If these signal requirements cannot be met, refine the TRANSMITTER DISTRIBUTOR GEAR BACKLASH adjustment (See BASES) and the TRANSFER BAIL STABILIZER adjustment, viewing the signal on the test set.

2.26 Spacing Pulse Adjustments: The general procedure for adjusting the spacing pulse is identical to that outlined for marking pulses. The tolerances for spacing pulses may not be the same as for marking pulses however. Refer to the appropriate Pulse Data Table when making adjustments.

SECTION 573-127-703TC

Note: On units equipped with signal regenerators, remove regenerator circuit card before applying test set probes to contact access terminals.

THEM UNSUITABLE FOR LOW-VOLTAGE APPLICATIONS. REFER TO 1.12 FOR SERVICING INSTRUCTIONS.

CAUTION: APPLYING OPERATING VOLTAGE OF DISTORTION TEST SET DIRECTLY TO GOLD-PLATED CONTACTS MAY MAKE

2.27 Follow the general procedure outlined in Paragraphs 2.25 and 2.26 substituting the appropriate data from the following table.

PULSE DATA TABLE  
FIVE-LEVEL UNITS, 7.00 UNIT CODE

PULSE	MARKING		SPACING	
	*NOMINAL	TOLERANCE	*NOMINAL	TOLERANCE
STOP PULSE	36 (STOP) TO 142 (STOP)	BEGIN ±5 DIV END ±1/2 DIV	36 (STOP) TO 142 (START)	BEGIN ±6 DIV END ±1/2 DIV
START PULSE	142 (STOP) TO 6 (ONE)	BEGIN ±5 DIV END ±5 DIV	142 (STOP) TO 6 (ONE)	BEGIN ±6 DIV END -5, ±6 DIV
PULSE 1	6 (ONE) TO 12 (TWO)	BEGIN ±5 DIV END ±5 DIV	6 (ONE) TO 12 (TWO)	BEGIN ±6 DIV END -5, ±6 DIV
PULSE 2	12 (TWO) TO 18 (THREE)	BEGIN ±5 DIV END ±5 DIV	12 (TWO) TO 18 (THREE)	BEGIN ±6 DIV END -5, ±6 DIV
PULSE 3	18 (THREE) TO 24 (FOUR)	BEGIN ±5 DIV END ±5 DIV	18 (THREE) TO 24 (FOUR)	BEGIN ±6 DIV END -5, ±6 DIV
PULSE 4	24 (FOUR) TO 30 (FIVE)	BEGIN ±5 DIV END ±5 DIV	24 (FOUR) TO 30 (FIVE)	BEGIN ±6 DIV END -5, ±6 DIV
PULSE 5	30 (FIVE) TO 36 (STOP)	BEGIN ±5 DIV END ±5 DIV	30 (FIVE) TO 36 (STOP)	BEGIN ±6 DIV END -5, ±6 DIV
ALLOWABLE BREAK WIDTH	1 DIV	MUST FALL WITHIN PULSE TOLERANCE	1 DIV	MUST FALL WITHIN PULSE TOLERANCE

\*Ranges specified apply only for test sets (DXD) having a 7.42 unit code scale.

2.28 Follow the general provisions outlined in Paragraphs 2.25 and 2.26 substituting the appropriate data from the following table.

PULSE DATA TABLE  
FIVE-LEVEL UNITS, 7.42 UNIT CODE

PULSE	MARKING		SPACING	
	RANGE	NOMINAL	TOLERANCE	NOMINAL
STOP PULSE	0 (STOP) TO 0 (START)	BEGIN $\pm 5$ DIV END $\pm 1/2$ DIV	0 (STOP) TO 0 (START)	BEGIN $\pm 6$ DIV END $\pm 1/2$ DIV
START PULSE	0 (START) TO 0 (ONE)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (START) TO 0 (ONE)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
PULSE 1	0 (ONE) TO 0 (TWO)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (ONE) TO 0 (TWO)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
PULSE 2	0 (TWO) TO 0 (THREE)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (TWO) TO 0 (THREE)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
PULSE 3	0 (THREE) TO 0 (FOUR)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (THREE) TO 0 (FOUR)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
PULSE 4	0 (FOUR) TO 0 (FIVE)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (FOUR) TO 0 (FIVE)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
PULSE 5	0 (FIVE) TO 0 (STOP)	BEGIN $\pm 5$ DIV END $\pm 5$ DIV	0 (FIVE) TO 0 (STOP)	BEGIN $\pm 6$ DIV END $\pm 6$ DIV
ALLOWABLE BREAK WIDTH	$\pm 1$ DIV	MUST FALL WITHIN TOLERANCE LIMITS	$\pm 1$ DIV	MUST FALL WITHIN TOLERANCE LIMITS

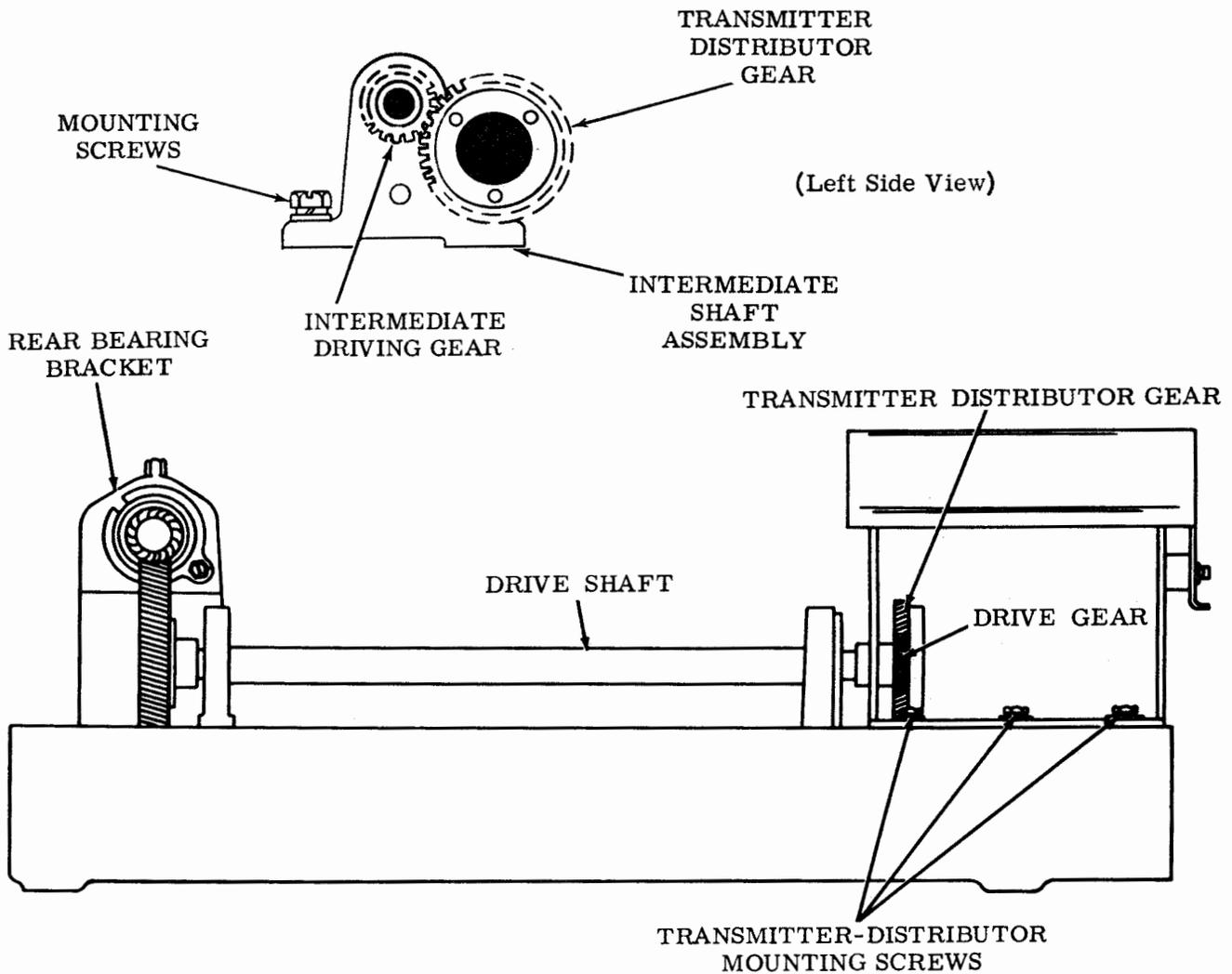
SECTION 573-127-703TC

2.29 Follow the general provisions outlined in Paragraphs 2.25 and 2.26 substituting the appropriate data from the following table.

PULSE DATA TABLE  
SIX-LEVEL UNITS, 8.50 UNIT CODE

PULSE	MARKING		SPACING	
	RANGE	NOMINAL	TOLERANCE	NOMINAL
STOP PULSE	0 (STOP) TO 0 (START)	BEGIN ±7 DIV END ±1/2 DIV	0 (STOP) TO 0 (START)	BEGIN ±8 DIV END ±1/2 DIV
START PULSE	0 (START) TO 0 (ONE)	BEGIN ±7 DIV END ±7 DIV	0 (START) TO 0 (ONE)	BEGIN ±8 DIV END ±8 DIV
PULSE 1	0 (ONE) TO 0 (TWO)	BEGIN ±7 DIV END ±7 DIV	0 (ONE) TO 0 (TWO)	BEGIN ±8 DIV END ±8 DIV
PULSE 2	0 (TWO) TO 0 (THREE)	BEGIN ±7 DIV END ±7 DIV	0 (TWO) TO 0 (THREE)	BEGIN ±8 DIV END ±8 DIV
PULSE 3	0 (THREE) TO 0 (FOUR)	BEGIN ±7 DIV END ±7 DIV	0 (THREE) TO 0 (FOUR)	BEGIN ±8 DIV END ±8 DIV
PULSE 4	0 (FOUR) TO 0 (FIVE)	BEGIN ±7 DIV END ±7 DIV	0 (FOUR) TO 0 (FIVE)	BEGIN ±8 DIV END ±8 DIV
PULSE 5	0 (FIVE) TO 0 (SIX)	BEGIN ±7 DIV END ±7 DIV	0 (FIVE) TO 0 (SIX)	BEGIN ±8 DIV END ±8 DIV
PULSE 6	0 (SIX) TO 0 (STOP)	BEGIN ±7 DIV END ±7 DIV	0 (SIX) TO 0 (STOP)	BEGIN ±8 DIV END ±8 DIV
ALLOWABLE BREAK WIDTH	1 DIV	MUST LIE WITHIN TOLERANCE LIMITS	1 DIV	MUST LIE WITHIN TOLERANCE LIMITS

## 2.30 Basic Gear Adjustments



INTERMEDIATE GEAR — TRANSMITTER DISTRIBUTOR GEAR BACKLASH

(Left Side View)

**To Check**

With the MOTOR POSITION and TRANSMITTER DISTRIBUTOR POSITION adjustments completed, check the backlash between the gears.

**(1) Requirement**

Only a perceptible amount of backlash between the intermediate driving gear and the transmitter distributor gear.

**To Adjust**

Loosen three mounting screws that secure the transmitter distributor unit to its base. Position transmitter distributor to meet the requirement. Retighten the mounting screws.

**(2) Requirement**

Only a perceptible amount of backlash between the drive gear and the transmitter distributor gear.

**To Adjust**

Loosen three mounting screws that secure the transmitter distributor to its base. Position transmitter distributor to meet this requirement. Retighten the screws.

3. VARIABLE FEATURES

3.01 Tight-Tape and Tape Shoe Mechanism

(A) TIGHT-TAPE SWITCH

To Check

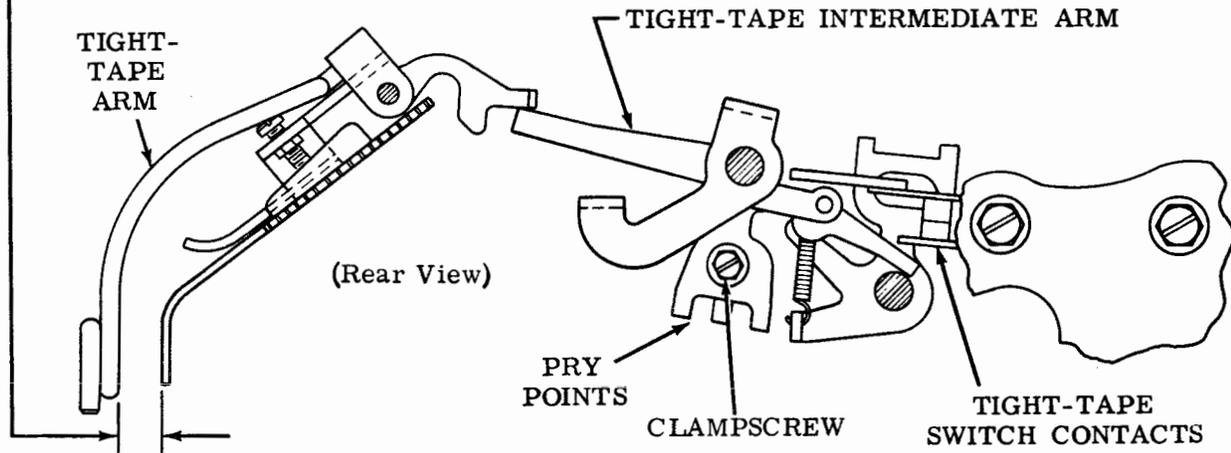
Place control lever in run position.

Requirement

Min  $9/32$  inch---Max  $13/32$  inch to open contacts when tight-tape arm is raised.

To Adjust

Loosen clampscrew. Using adjusting slot, position tight-tape intermediate arm to meet this requirement. Re-tighten clampscrew.



(B) TORSION SPRING

Requirement

Min 2-1/2 oz to lift tape shoe.

(C) TAPE SHOE

To Check

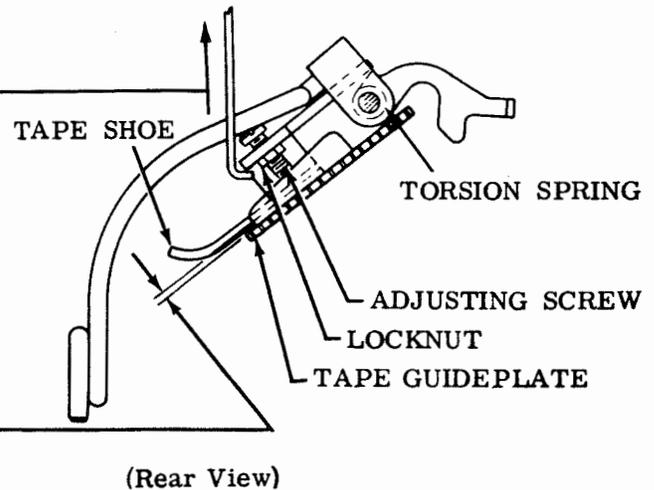
Latch tape lid in position. Check clearance between tape guideplate and tape shoe.

Requirement

Min 0.005 inch---Max 0.008 inch

To Adjust

Loosen locknut. Rotate adjusting screw to meet the requirement. Retighten locknut.



3.02 Tape Feed Assurance Mechanism

**(A) TAPE SENSING FEED WHEEL PHASING**

**To Check**

Place fresh, fully perforated tape (10 holes per inch) on tape guideplate across the feed wheel and tape feed assurance wheel. Set detent adjusting lever screw at midrange.

**Requirement**

Tape must lie flat on tape guideplate between feed wheel and tape feed assurance wheel.

**To Adjust**

Loosen bracket mounting screws friction tight. Position bracket to meet requirement. Retighten bracket mounting screws. Refine adjustment (if necessary) by rotating the detent lever adjusting screw.

Note: If tape is not available, use TPI65800 gauge.

**(D) DETENT LEVER SPRING**

**To Check**

Hold contact lever away from detent lever.

**Requirement**

Min 3 oz---Max 4 oz to move the roller from the ratchet.

**(B) TAPE MOTION CONTACT GAP**

**To Check**

Place detent lever in detented position.

**Requirement**

Min 0.005 inch---Max 0.010 inch gap between the normally closed contacts.

**To Adjust**

Bend contact leaf and stiffener to meet requirement.

**(C) TAPE MOTION CONTACT SWINGER**

**To Check**

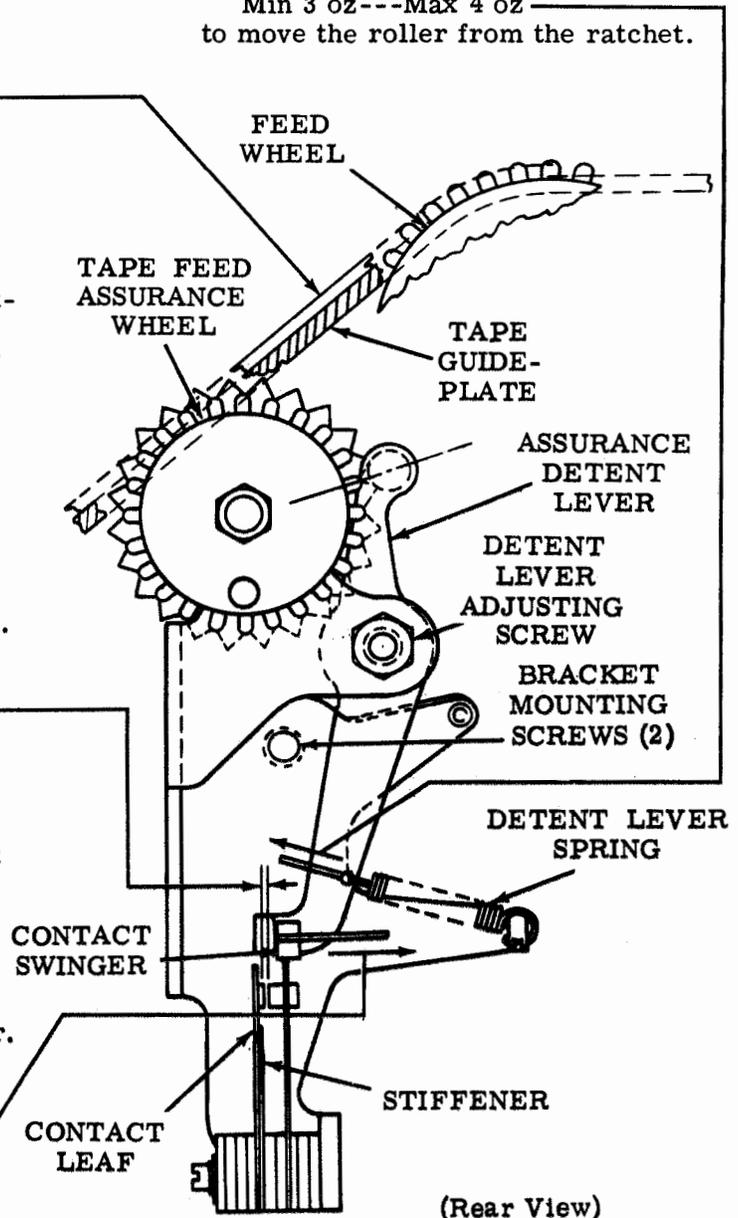
Hold detent lever from contact swinger.

**Requirement**

Min 15 grams---Max 25 grams to separate contacts.

**To Adjust**

Bend swinger to meet requirement. Recheck TAPE MOTION CONTACT GAP.



(Rear View)

3.03 Tape-Out Mechanism

(A) TAPE-OUT CONTACT

- (1) To Check  
Loosen contact bracket mounting screws. Pivot contact assembly until pad on tape-out pin extension is not touching the swinger pad. Check gap between normally open (top) contact points.

Requirement  
Min 0.015 inch---Max 0.025 inch between normally open (top) contacts.

To Adjust  
Bend upper contact spring to meet requirement.

- (2) To Check  
With assembly still in position, check force required to just separate normally closed (lower) contacts.

Requirement  
Min 8 grams---Max 15 grams to just separate normally closed (lower) contacts.

To Adjust  
Bend contact swinger. Recheck requirement under (1) To Check above.

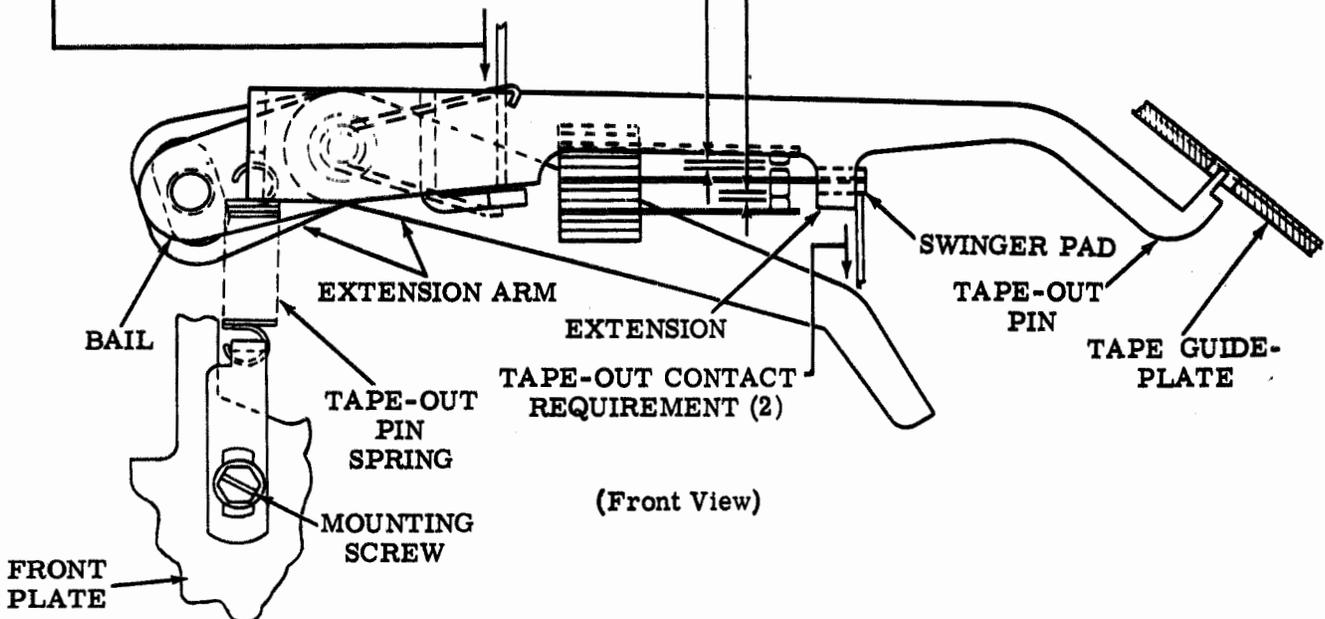
- (3) To Check  
Hold tape-out pin down. With some clearance between tape-out pin extension and underside of contact swinger, without tape, tape lid closed, and unit in run position, check gap between normally closed contacts.

Requirement  
Min 0.008 inch---Max 0.018 inch gap between normally closed contacts.

To Adjust  
With contact bracket mounting screws loosened, adjust contact mounting bracket to meet requirement. Retighten contact bracket mounting screws.

(B) TAPE-OUT BAIL TORSION SPRING

Requirement  
Min 8 oz---Max 12 oz to separate bail from tape-out pin.



3.04 Tape-Out Mechanism (continued)

(C) TAPE-OUT PIN SPRING

To Check

Remove tape and open tape lid.

Requirement

Min 38 grams---Max 45 grams  
to press pin flush with tape guideplate.

To Adjust

Loosen tape-out spring bracket mounting screw and position bracket to meet requirement. Retighten bracket mounting screw.

To Adjust

With control lever in stop position, loosen screw which secures the stop arm to the bracket with posts. Adjust stop arm to meet requirement. Tighten screw.

(2) To Check

Place control lever in run position. Check clearance between lower tape-out pin extension and tape-out bail extension.

Requirement

Min 0.055 inch  
clearance between lower tape-out pin extension and tape-out bail extension.

To Adjust

With control lever in run position, loosen screw which secures the extension arm to the intermediate tape-out bail. Using a tommy wrench or suitable tool, change relative position of extension arm to bail to obtain required clearance. Tighten screw. Check requirement under (1) To Check and refine, if necessary.

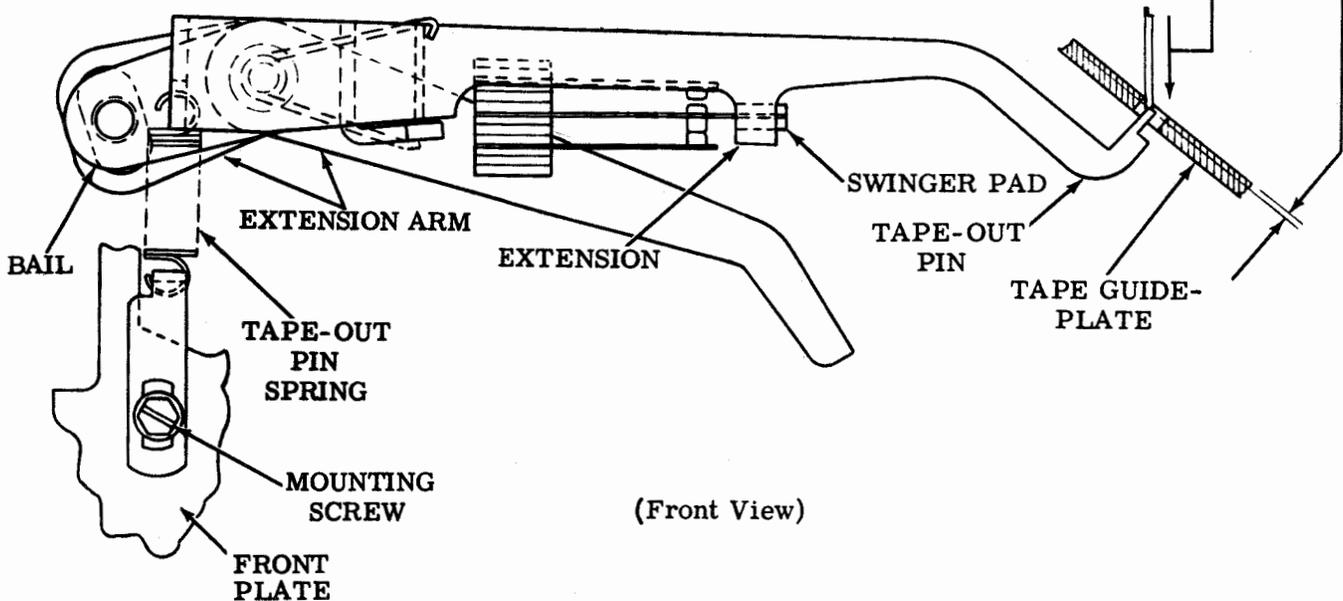
(D) TAPE-OUT PIN

(1) To Check

Place control lever in free or stop position. Check position of tape-out pin in relation to tape guideplate.

Requirement

Tape-out pin should be  
Min flush---Max 0.010 inch  
below surface of tape guideplate.



3.05 Code Reading Contacts

**Note 1:** Remove code reading contact assembly from transmitter distributor unit before making initial adjustments.

**Note 2:** When using the contact spring bender, start with the handle of the tool and work toward the handle so as not to disturb adjustments already made.

(A) NORMALLY CLOSED CONTACTS — BACKSTOP

**Requirement**

Lower contact leaves for all levels should be parallel with the mounting plate and in line with one another.

**To Adjust**

Bend backstop to meet the requirement.

(B) NORMALLY CLOSED CONTACTS — SPRING

(1) **Requirement**

With swinger held away  
Min 2 oz---Max 6 oz  
to move lower contact leaf from backstop.

**To Adjust**

Bend lower leaf.

(2) **Requirement**

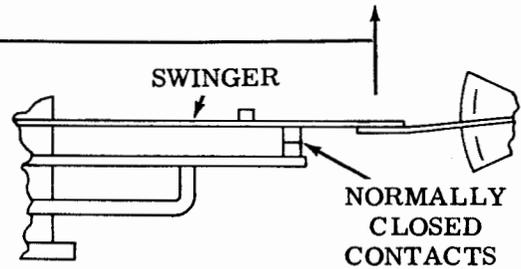
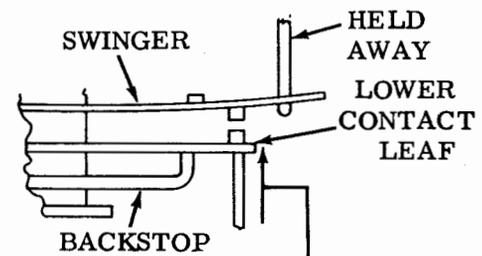
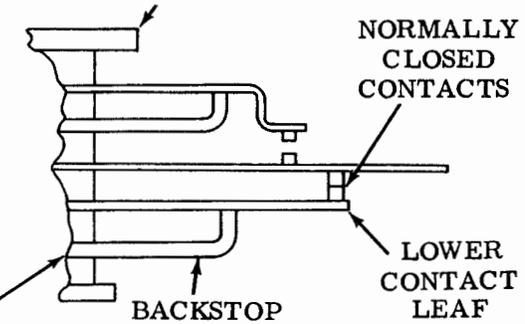
Min 30 grams---Max 40 grams  
to open normally closed contacts.

**To Adjust**

Bend swinger.

**Note 3:** If it is necessary to bend backstop to obtain required tension, reposition backstop to meet NORMALLY CLOSED CONTACTS — BACKSTOP requirement.

MOUNTING PLATE



(C) NORMALLY OPEN CONTACTS — GAP

**Requirement**

Min 0.010 inch---Max 0.015 inch  
gap between normally open contacts.

**To Adjust**

Bend associated backstop to meet requirement.

(D) NORMALLY OPEN CONTACTS — SPRING

**Requirement**

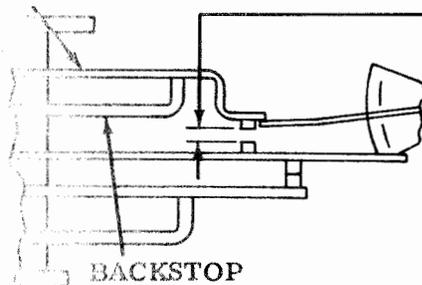
Min 30 grams---Max 40 grams  
to move normally open contact away from backstop.

**To Adjust**

Bend upper contact leaf.

**Note 4:** If it is necessary to bend backstop to obtain required tension, reposition backstop to meet NORMALLY OPEN CONTACTS — GAP requirement.

UPPER CONTACT LEAF



(Front Views)

3.06 Code Reading Contacts (continued)

Note: Secondary adjustments should be made with code reading contact assembly installed in the transmitter distributor and with the contact assembly bracket approximately centered in its adjustment range. (Remove contact box to facilitate adjustment.)

(A) CONTACT ASSEMBLY POSITIONING

To Check

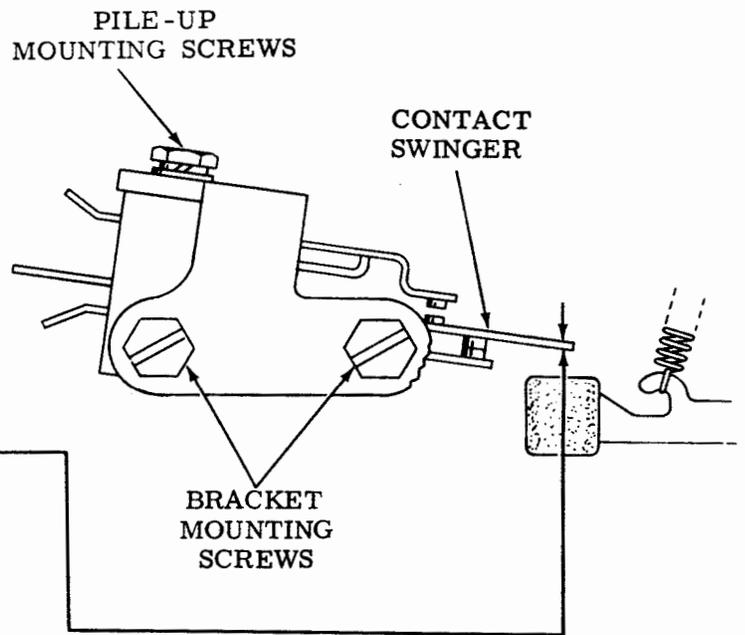
Align each swinger with its associated sensing arm. (Gauge by eye.)

Requirement

Swinger to be aligned with its sensing arm.

To Adjust

Loosen screws which mount the contact assembly to the contact bracket. Position the assembly to meet the requirement.



(Front Views)

(B) CONTACT SWINGER — SENSING ARM CLEARANCE

To Check

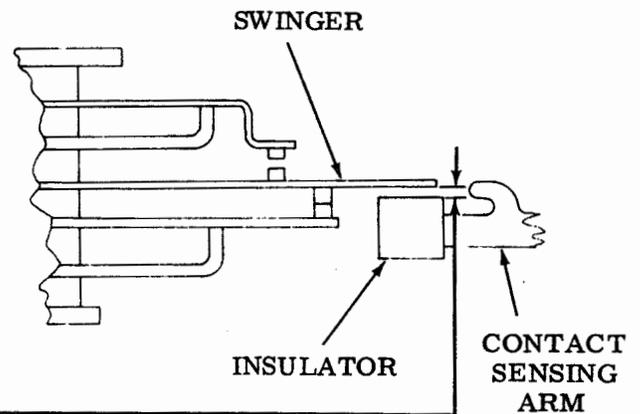
Place up-stop post out of the way and sensing arms in their uppermost positions. Select a BLANK combination.

Requirement

Min some---Max 0.010 inch gap between contact assembly swinger and insulator on contact sensing arm.

To Adjust

Loosen contact bracket mounting screws. Position bracket to meet the requirement. Tighten contact bracket mounting screws.



3.07 Code Reading Contacts (continued)

(A) CONTACT SENSING ARM — UP-STOP CLEARANCE

To Check

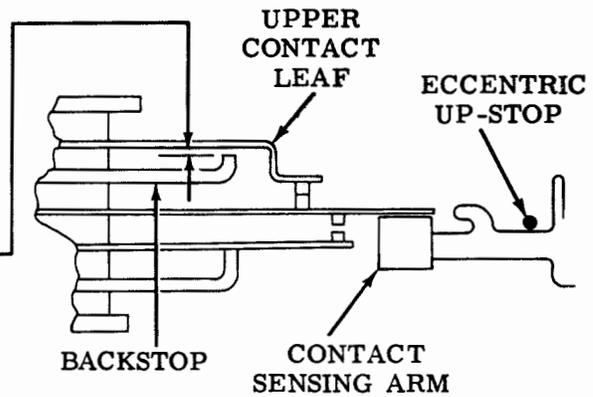
Rotate main shaft until sensing arms are in their highest positions. Engage clutch. Select a LETTERS combination.

Requirement

Min some---Max 0.008 inch clearance between upper contact leaf and its backstop.

To Adjust

Loosen nut that secures the eccentric up-stop to the front plate. Turn the eccentric to meet requirement. (High part of the eccentric should be toward the left.) Retighten eccentric nut.



(B) SENSING ARM — TRANSFER LEVER ALIGNMENT

To Check

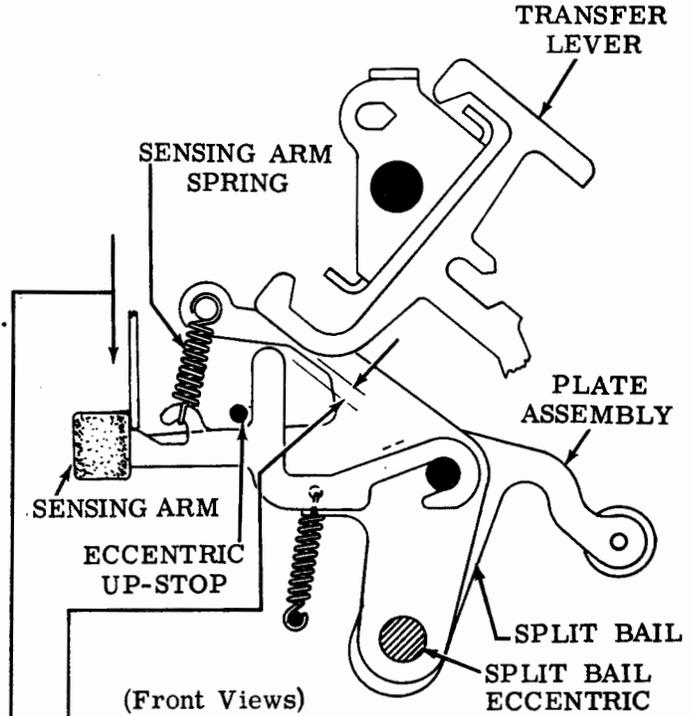
Trip clutch. Select BLANK combination.

Requirement

Sensing arms must engage a minimum of 2/3 of their respective transfer levers.

To Adjust

Add TP8896 shims between plate assembly and the split bail spacer to meet requirement. (Store remaining shims under flat washer at end of split bail eccentric screw.)



(Front Views)

(C) SENSING ARM SPRING

To Check

Disengage clutch.

Requirement

Min 2-1/2 oz---Max 3-1/2 oz to start sensing arm moving.

(D) SPLIT BAIL ECCENTRIC

To Check

Trip clutch. Select BLANK combination. Check clearance between closest transfer lever and its associated sensing arm.

Requirement

Min 0.005 inch---Max 0.010 inch

To Adjust

Loosen split bail eccentric locknut. Rotate split bail eccentric to meet requirement. Retighten locknut.

## 3.08 Code Reading Contacts (continued)

CONTACT SWINGER — SENSING ARM  
CLEARANCE (STROBING)

Note 1: When strobing the code reading contacts, use a DXD scale whose unit corresponds to that of the unit being checked. Refer to Contact Operating Requirements Table. The signal generator on the transmitter distributor must be synchronized with the DXD so that the end of the stop pulse image is in line with the end of the stop pulse on the DXD scale when transmission is continuous. Use a normal signal line direct current of 60 ma  $\pm 10\%$  or 20 ma  $\pm 10\%$  to strobe the contacts.

## (1) Requirement

Contacts must open and close within the range specified on the Contact Operating Requirements Table.

## (2) Requirement

Breaks in the pulses must be confined to the first and last 10 divisions of the trace.

CONTACT OPERATING REQUIREMENTS TABLE

Levels	Unit Code	Beginning Pulse			End of Pulse			Max. Pulse Length Osc (Div)
		Scale Segment	Scale Division	Tolerance (Div)	Scale Segment	Scale Division	Tolerance (Div)	
5	7.00	Pulse 1	25	$\pm 20$	Pulse 5	15	$\pm 20$	3
5	7.42	Pulse 1	30	$\pm 20$	Pulse 5	40	$\pm 20$	3
6	8.50	Pulse 0	45	$\pm 25$	Pulse 5	5	$\pm 25$	4

## To Adjust

Loosen contact bracket mounting screws.  
Position bracket to meet requirements.  
Retighten contact bracket mounting screws.

Note 2: After making the adjustment, check clearance between contact swinger and insulator on the contact sensing arm when a BLANK combination has been selected and the main shaft rotated to place the sensing arms in their highest position. There must be some clearance. If the requirements cannot be met, recheck initial mechanical adjustments.

3.09 Auxiliary Contacts

Note: Make initial adjustments with the auxiliary contactors removed from the transmitter distributor unit.

(A) NORMALLY OPEN CONTACTS

(1) Requirement

Min 5-1/2 oz---Max 6 oz  
to move normally open contact  
away from stiffener.

To Adjust

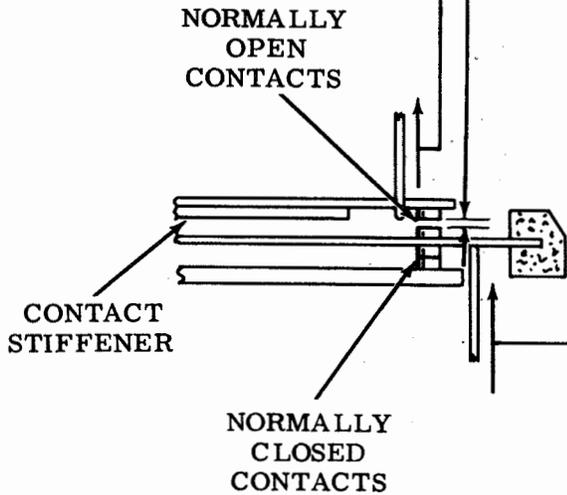
Bend normally open contact leaf  
to meet requirement.

(2) Requirement

Min 0.015 inch---Max 0.020 inch  
gap between normally open contacts.

To Adjust

Bend contact stiffener to meet  
requirements.



(Front View)

(B) NORMALLY CLOSED CONTACTS

Requirement

Min 4 oz---Max 5 oz  
to open normally closed contact.

To Adjust

Bend swinger contact to meet re-  
quirement.

3.10 Auxiliary Contacts (continued)

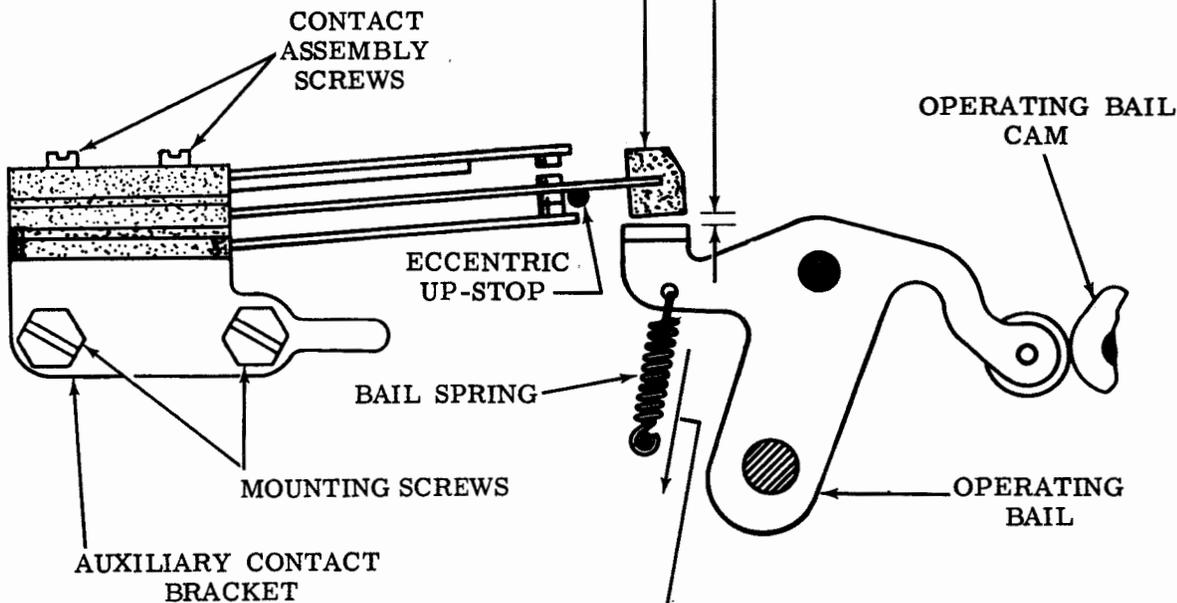
Note: Make secondary adjustments with the auxiliary contacts installed in the transmitter distributor.

(A) CONTACT SENSING ARM

- (1) To Check  
Disengage and latch clutch. Check clearance between insulator on swinger and bail.

Requirement  
Swinger insulator should be centrally located with respect to its operating bail.

To Adjust  
Loosen contact assembly screws. Position swinger and contact springs. Retighten contact assembly screws.



(Front View)

- (2) To Check  
Check position of swinger with respect to its bail.

Requirement  
Min 0.040 inch—Max 0.050 inch between insulator on swinger and its bail.

To Adjust  
Loosen contact bracket mounting screws. Position contact bracket to meet requirement. Retighten contact bracket mounting screws.

(B) AUXILIARY CONTACT OPERATING BAIL SPRING

- To Check  
Disengage clutch.

Requirement  
Min 5 oz---Max 7 oz to pull spring to its installed length.

## 3.11 Auxiliary Contacts (continued)

CONTACT SWINGER — OPERATING BAIL  
CLEARANCE

Note: When strobing the auxiliary contacts, use a DXD scale whose unit code corresponds to that of the unit being checked. (Refer to Contact Operating Requirements Table.) Synchronize the signal generator of the transmitter distributor with the DXD so that the end of the stop pulse image is in line with the end of the stop pulse on the DXD scale when transmission is continuous. Use normal direct current line signal of 60 ma  $\pm 10\%$  or 20 ma  $\pm 10\%$  to strobe the contacts.

**Requirement**

The contacts must open and close within the range specified in the Contact Operating Requirements Table.

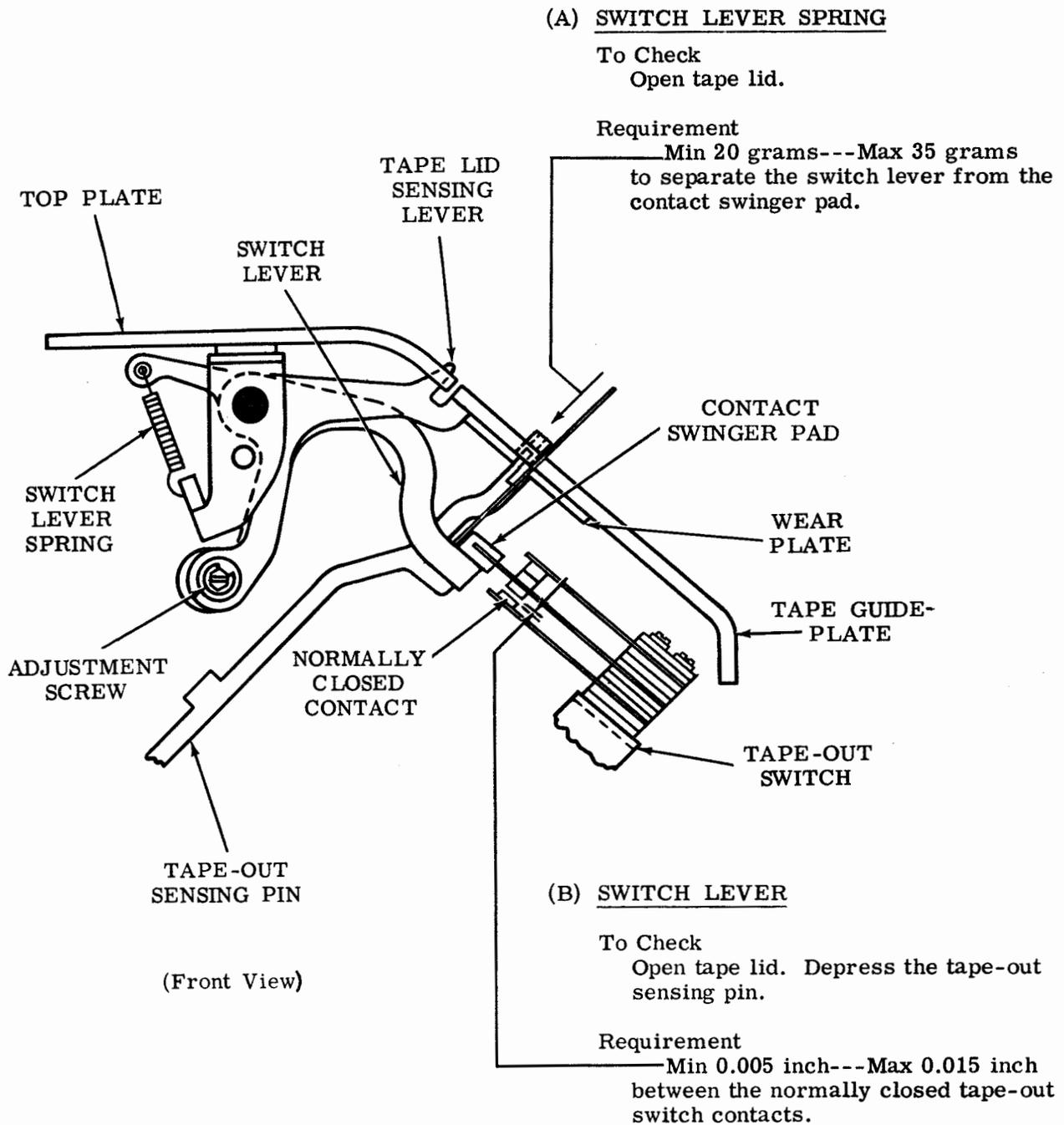
**To Adjust**

Loosen the contact bracket mounting screws. Position the contacts to meet the requirements. Retighten contact bracket mounting screws.

CONTACT OPERATING REQUIREMENTS TABLE

Levels	Unit Code	Start of Pulse			End of Pulse		
		Scale Segment	Scale Division	Tolerance (Div)	Scale Segment	Scale Division	Tolerance (Div)
5	7.00	Pulse 1	65	$\pm 15$	Pulse 4	65	$\pm 15$
5	7.42	Pulse 1	75	$\pm 15$	Pulse 4	90	$\pm 15$
6	8.50	Pulse 1	0	$\pm 20$	Pulse 4	60	$\pm 20$

3.12 Tape Lid Sensing Lever



**To Adjust**  
 Loosen the adjustment screw. With the tape lid sensing lever seated firmly against the tape guideplate, rotate the switch lever clockwise or counter-clockwise to meet requirement. Re-tighten adjustment screw.

3.13 Tape Deflector

(A) TAPE DEFLECTOR BRACKET

To Check

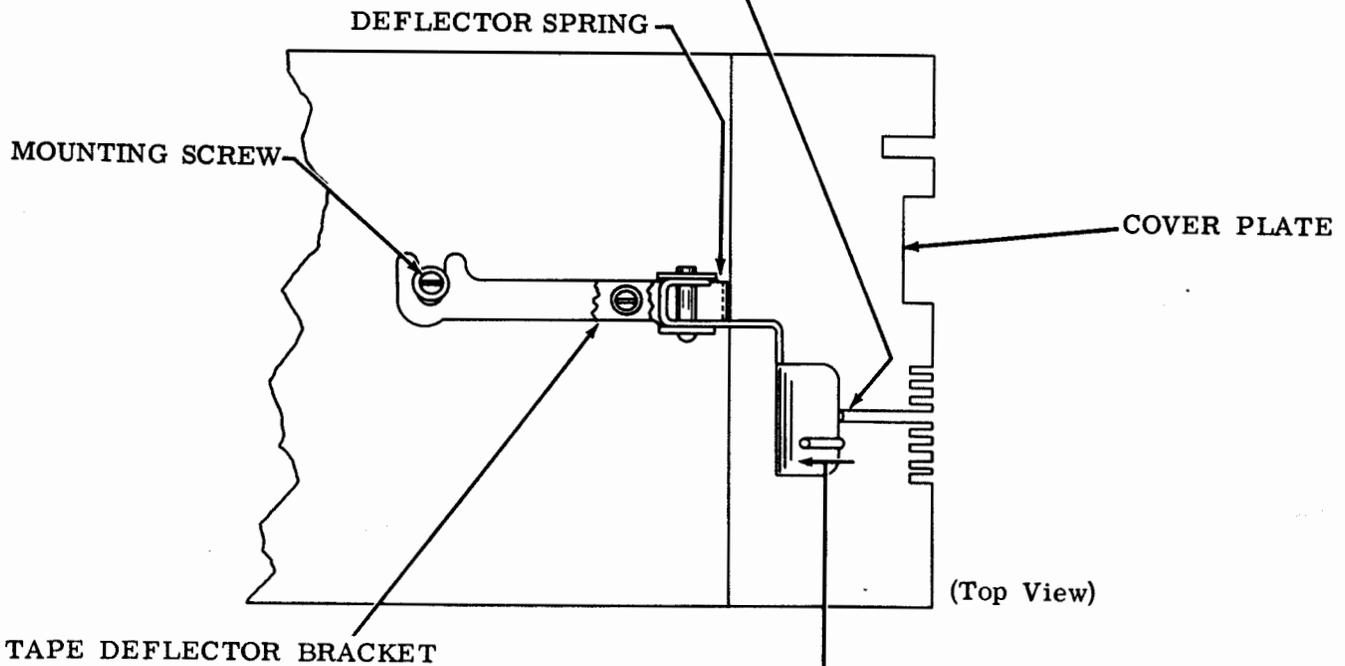
Check position of deflector tang in relation to its hole in top plate when the unit is in its operating position.

Requirement

Deflector tang should be located centrally in its hole in the top plate.

To Adjust

Remove rear screw which secures tape deflector spring to the cover plate. Loosen forward screw. Position tape deflector. Replace rear screw, and tighten both forward and rear screws.



(B) TAPE DEFLECTOR SPRING

Requirement

Min 1-1/2 oz---Max 4 oz  
to start the deflector moving from its operating position.

To Adjust

Loosen mounting screw. Position the spring using the enlarged mounting slot. Retighten mounting screw.

3.14 Start-Stop Pulse Contact

(A) CONTACT LEVER

To Check

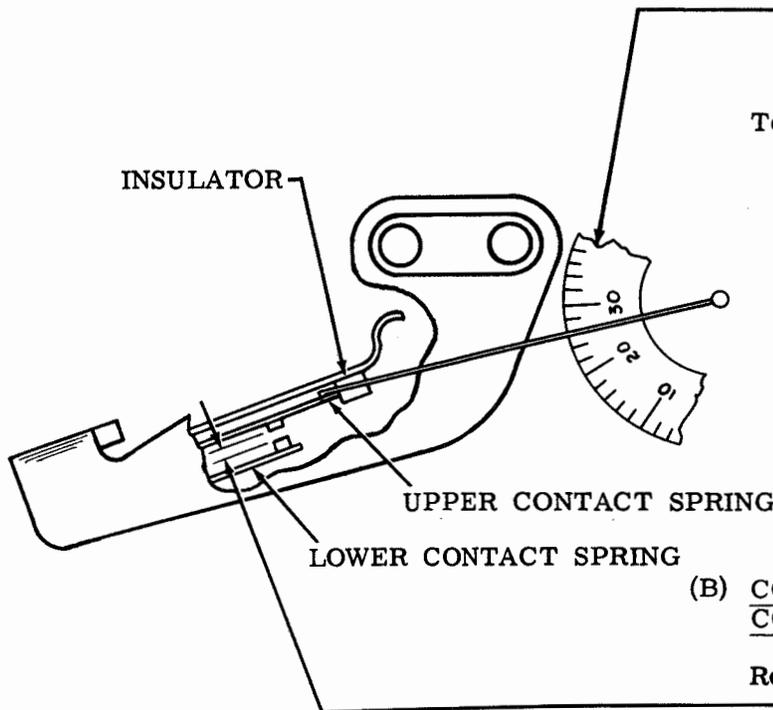
Remove contact assembly from unit. Insure that no clearance exists between the contact lever and insulator.

Requirement

Min 20 grams---Max 30 grams to move insulator from contact operating lever.

To Adjust

Bend upper contact spring.



(B) CONTACT GAP (START AND STOP CONTACTS)

Requirement

Min 0.012 inch---Max 0.018 inch

To Adjust

Bend lower contact spring.

(Front Views)

(C) CONTACT BRACKET

To Check

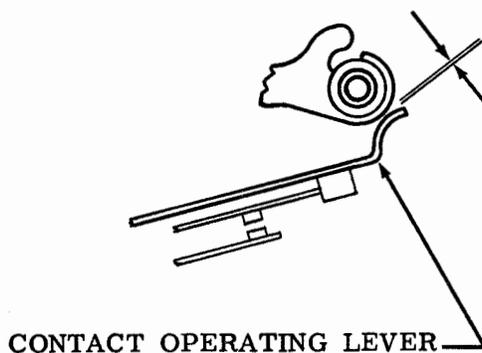
Place unit in stop position. Latch clutch. Check clearance between contact operating lever and transfer lever.

Requirement

Min 0.012 inch---Max 0.018 inch

To Adjust

Loosen mounting bracket screws. Position contact assembly to meet requirement. Retighten mounting bracket screws. Replace contact assembly in unit.



**SECTION 573-127-703TC**

**3.15 Start-Stop Pulse Contact (continued)**

**CONTACT BRACKET (STROBING)**

**Note 1:** When strobing auxiliary contacts, use a 7.42 unit DXD scale. Synchronize the signal generator of the transmitter distributor with the DXD so that the end of the stop pulse image is in line with the end of the stop pulse on the DXD scale when transmission is continuous. Use normal signal line direct current of 60 ma  $\pm$  10% or 20 ma  $\pm$  10% to strobe the contacts.

**Requirement**

Contacts must close within the following range.

	MIN CLOSURE	CLOSURE RANGE
STOP CONTACT	95 DIV	0 DIV OF STOP SEGMENT TO 142ND DIV OF STOP SEGMENT
START CONTACT	60 DIV	122ND DIV OF STOP SEGMENT TO 95TH DIV OF START SEGMENT

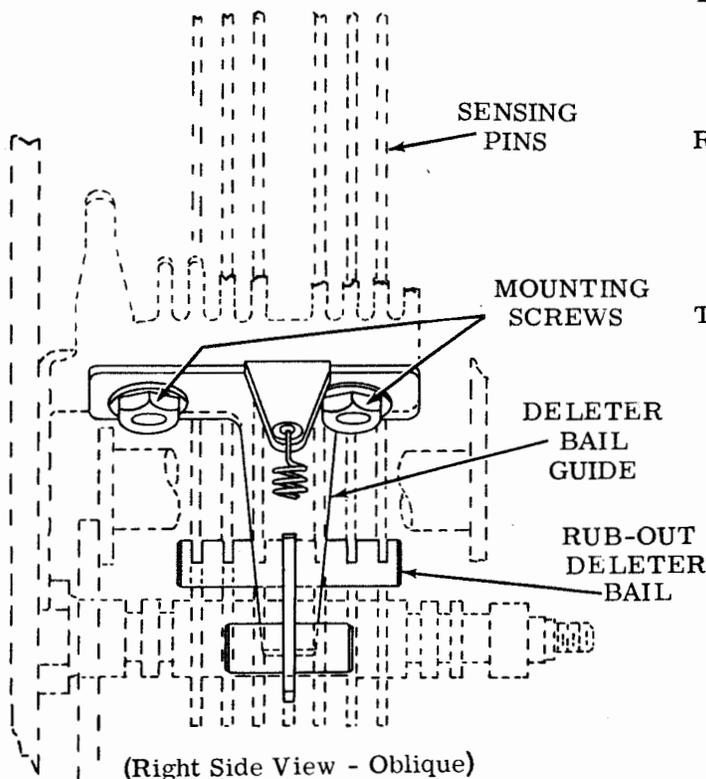
**Note 2:** Breaks are permissible within 5 divisions of the beginning or end of a trace.

**To Adjust**

Loosen contact bracket mounting screws. Position the contact bracket to meet requirements. Retighten contact bracket mounting screws.

3.16 Rub-Out Deleter

(A) RUB-OUT DELETER BAIL GUIDE



To Check

Place sensing pins in their highest position. Check that deleter bail moves freely in its guide.

Requirement

When the rub-out permutation code is present, the rub-out deleter bail should rest against the lower projection of the sensing pin.

To Adjust

Loosen mounting screws friction tight. Position deleter bail guide. Retighten mounting screws.

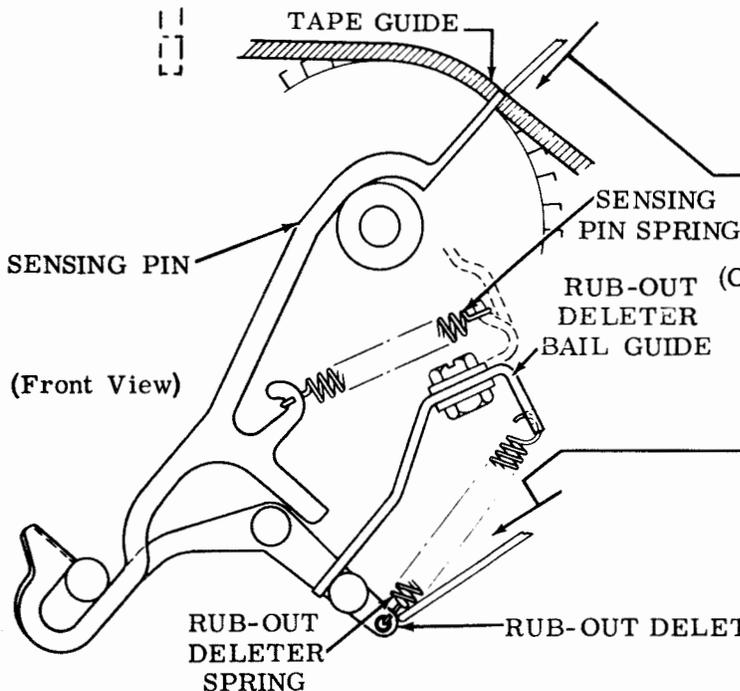
(B) SENSING PIN SPRING

To Check

Place sensing pin in its highest position. Hold rub-out deleter bail away from the pin.

Requirement

Min 3 oz --- Max 5 oz to move pin flush with tape guide.



(C) RUB-OUT DELETER BAIL SPRING

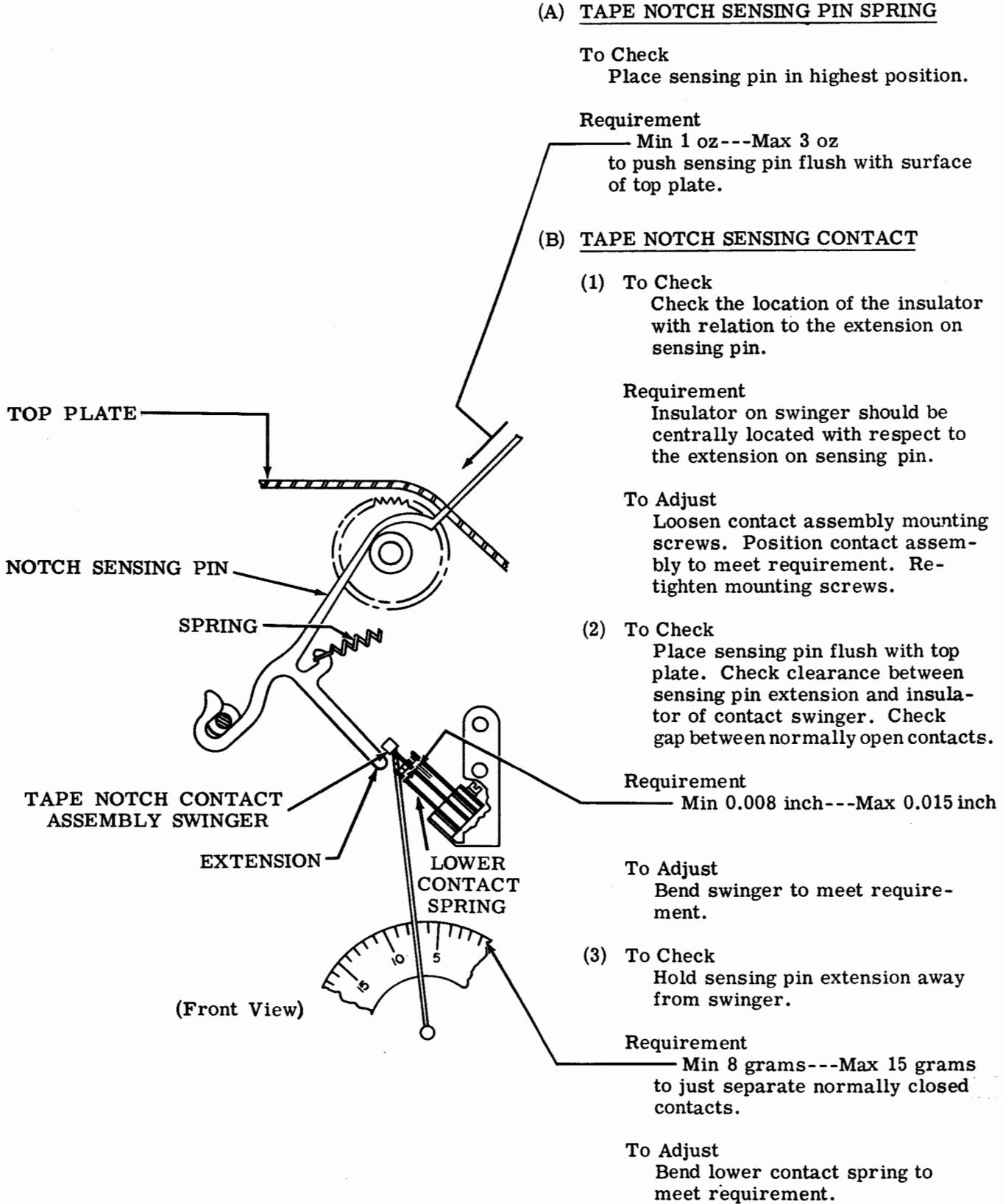
To Check

Place sensing pin in highest position.

Requirement

Min 1 oz --- Max 2-1/2 oz to move bail away from the sensing pin.

3.17 Tape Notch Sensing Mechanism



(A) TAPE NOTCH SENSING PIN SPRING

To Check

Place sensing pin in highest position.

Requirement

Min 1 oz---Max 3 oz  
to push sensing pin flush with surface  
of top plate.

(B) TAPE NOTCH SENSING CONTACT

(1) To Check

Check the location of the insulator  
with relation to the extension on  
sensing pin.

Requirement

Insulator on swinger should be  
centrally located with respect to  
the extension on sensing pin.

To Adjust

Loosen contact assembly mounting  
screws. Position contact assem-  
bly to meet requirement. Re-  
tighten mounting screws.

(2) To Check

Place sensing pin flush with top  
plate. Check clearance between  
sensing pin extension and insula-  
tor of contact swinger. Check  
gap between normally open contacts.

Requirement

Min 0.008 inch---Max 0.015 inch

To Adjust

Bend swinger to meet require-  
ment.

(3) To Check

Hold sensing pin extension away  
from swinger.

Requirement

Min 8 grams---Max 15 grams  
to just separate normally closed  
contacts.

To Adjust

Bend lower contact spring to  
meet requirement.

## 3.18 Tape Notch Sensing Mechanism (continued)

CONTACT BRACKET (STROBING)

**Note:** When using the tape notch sensing contacts, use a 7.42 unit DXD scale. Synchronize the transmitter distributor so that the end of the stop pulse image is in line with the end of the stop pulse on the DXD scale when transmission is continuous. Use a normal direct current line signal of 60 ma  $\pm 10\%$  or 20 ma  $\pm 10\%$  to strobe these contacts.

**(FOR UNITS WITH TAPE SLACK ARM)**

- (1) Requirement  
The contact should open no earlier than the 15 mark of the first pulse and open no later than the 55 mark of the first pulse.
- (2) Requirement  
The contact should close no earlier than the 15 mark of the fifth pulse and close no later than the 55 mark of the fifth pulse.
- (3) Requirement  
Contact breaks will be permitted between the 15 mark and the 55 mark of the fifth pulse. The magnitude of the breaks must not extend beyond these limits.

**To Adjust**

Loosen bracket contact mounting screws. Position contact bracket to meet requirements. Retighten mounting screws.

**(FOR UNITS WITHOUT TAPE SLACK ARM)**

- (1) Requirement  
The contact should close no earlier than the 15 mark of the first pulse and close no later than the 55 mark of the first pulse.
- (2) Requirement  
The contact should open no earlier than the 15 mark of the fifth pulse and open no later than the 55 mark of the fifth pulse.
- (3) Requirement  
Contact breaks will be permitted between the 15 and 55 marks of the first pulse. The magnitude of the breaks must not extend beyond these limits.

**To Adjust**

Loosen bracket contact mounting screws. Position contact bracket to meet requirements. Retighten mounting screws.

SECTION 573-127-703TC

3.19 Transmitter Stop Mechanism

(A) START-STOP CONTACT GAP (FOR TABULATOR CONTROL)

To Check

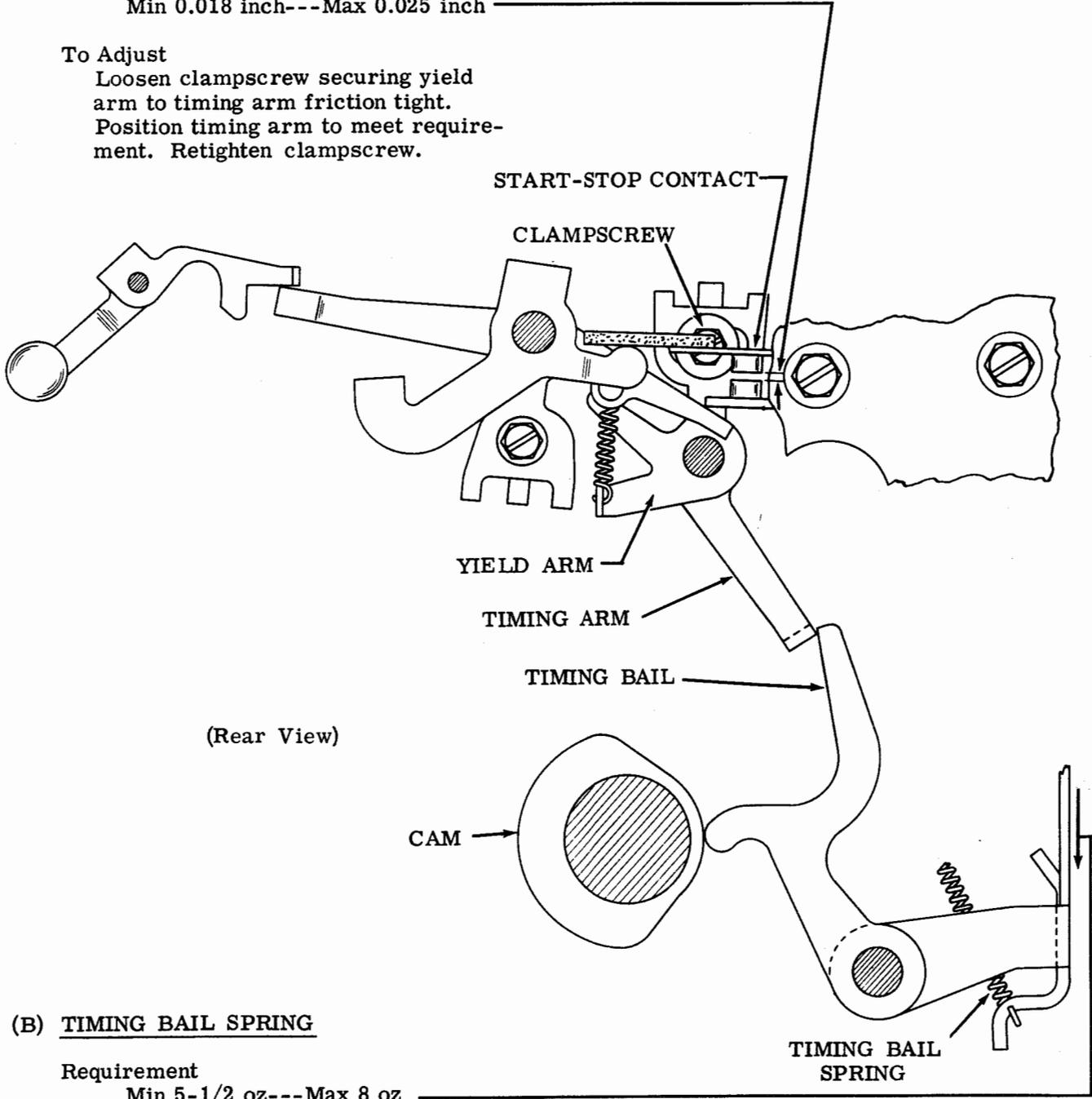
Place timing bail on lower part of its cam. Check start-stop contact gap.

Requirement

Min 0.018 inch---Max 0.025 inch

To Adjust

Loosen clampscrew securing yield arm to timing arm friction tight. Position timing arm to meet requirement. Retighten clampscrew.



(Rear View)

(B) TIMING BAIL SPRING

Requirement

Min 5-1/2 oz---Max 8 oz  
to start the bail moving.

3.20 Tape Slack Arm

TAPE SLACK CONTACTS

To Check

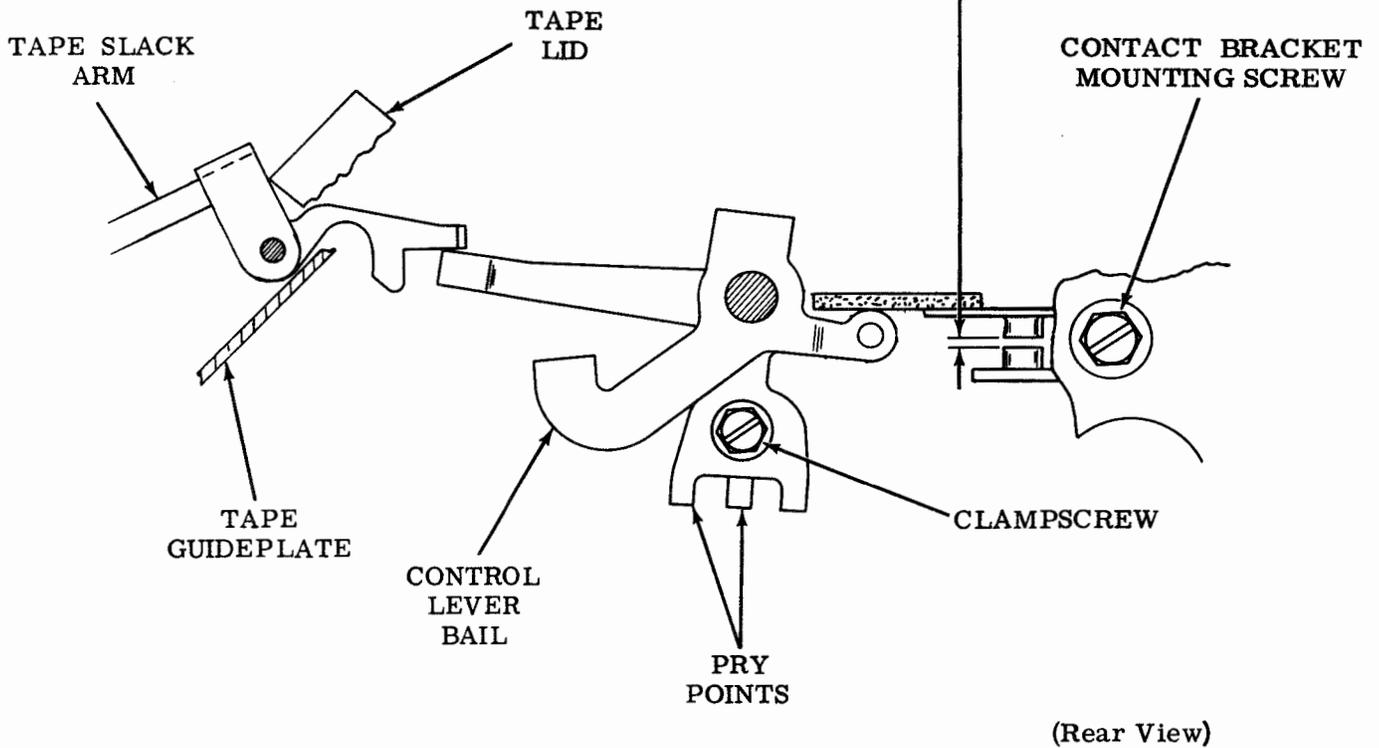
Close tape lid. Place control lever in run position. Check clearance between contacts when tape slack arm is raised to its maximum height.

Requirement

Min 0.010 inch---Max 0.020 inch

To Adjust

Loosen clampscrew. Set contact gap by positioning pry points. Retighten clampscrew.



3.21 Tape Withhold Mechanism

(A) MAGNET ARMATURE GAP

To Check

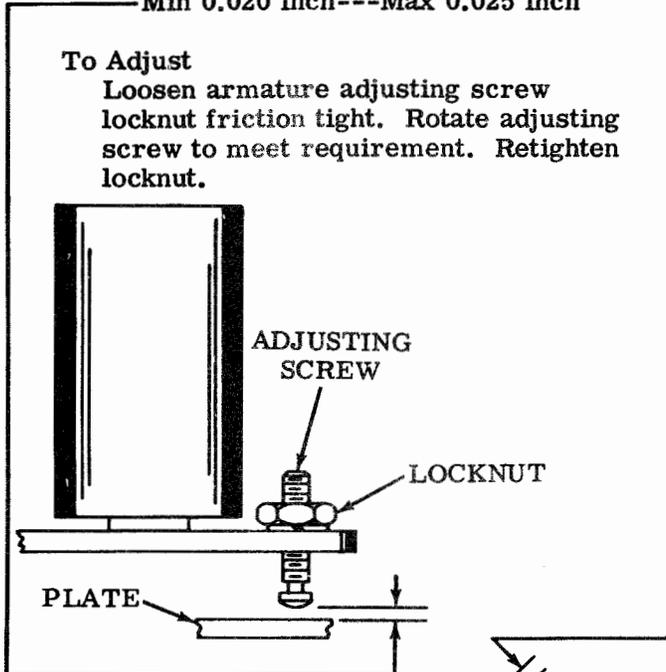
With the armature attracted, check the gap between the end of the armature adjusting screw and the plate.

Requirement

Min 0.020 inch---Max 0.025 inch

To Adjust

Loosen armature adjusting screw locknut friction tight. Rotate adjusting screw to meet requirement. Retighten locknut.



(B) BLOCKING BAIL ARM ECCENTRIC

To Check

Place sensing pins in their lowest position. Place high part of block bail arm eccentric pivot to right at approximately the same angular position as the feed pawl eccentric.

Requirement

some clearance between the extension on the blocking bail and the tail of the feed pawl.

To Adjust

Loosen arm eccentric clampscrew. Rotate arm eccentric to meet requirement. Retighten clampscrew.

(C) BLOCKING BAIL ECCENTRIC PIVOT

To Check

Trip clutch. Hold armature attracted. Hold main shaft latched in stop position. Check clearance between blocking bail extension and feed pawl at closest point.

Requirement

Min 0.002 inch---Max 0.035 inch

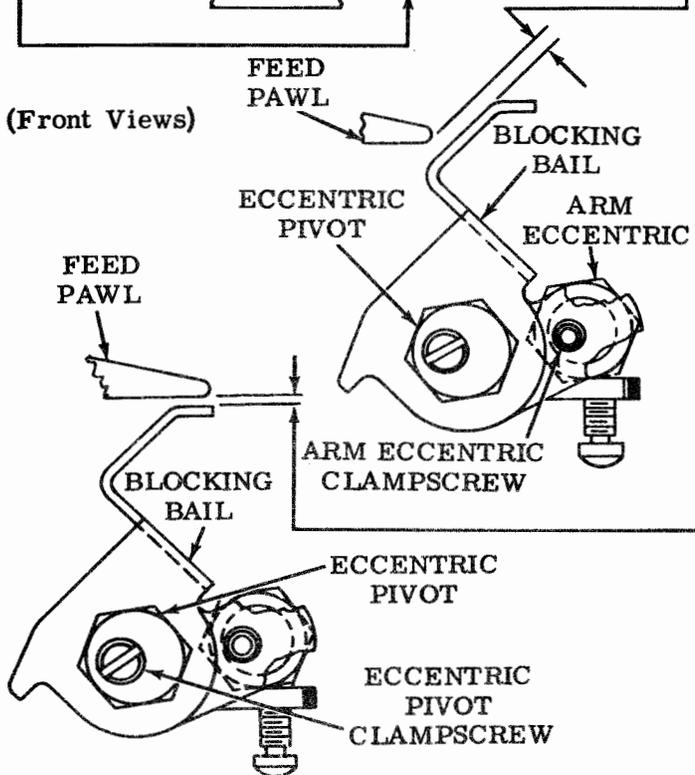
To Adjust

Loosen eccentric pivot clampscrew friction tight. Rotate eccentric pivot to meet requirement. Retighten clampscrew.

Note 1: Check BLOCKING BAIL ARM ECCENTRIC adjustment, and refine if necessary.

Note 2: As a final check on this adjustment there should be some---to---0.015 inch clearance between the feed pawl and the feed ratchet at the closest point, as the feed pawl is cammed out of the ratchet during the blocking operation (magnet armature attracted). If necessary, refine BLOCKING BAIL ARM ECCENTRIC PIVOT adjustments to meet this requirement.

(Front Views)



4. EARLY MODELS

4.01 Tape Lid Mechanism

**Note:** Remove top and tape guideplate.  
Lubricate before adjustment.

TAPE LID

(1) To Check

Hold tape against notch in tape guideplate. Align feed wheel groove in tape lid with slot in plate. Align tape-out pin hole in plate tape lid with hole in plate. Check clearance between tape lid and pivot shoulder.

**Requirement**

Min some---Max 0.010 inch clearance between tape lid and pivot shoulder.

**To Adjust**

Loosen tape lid mounting nuts friction tight. Insert tip of TP156743 gauge through slot and into groove of lid. Position tape lid bracket. Retighten nuts.

(2) To Check

Tape lid front bearing surface should rest squarely against tape guideplate. Check rear bearing surface clearance.

**Note:** When both plates are assembled on unit, left edge of lid may touch top plate and some change in this clearance may be expected.

**Requirement**

Min some---Max 0.003 inch clearance between rear bearing surface and tape guideplate.

**To Adjust**

Loosen tape lid bracket mounting screws friction tight. Press tape lid against tape guideplate. Position bracket. Recheck requirement. Retighten bracket mounting screws.

(3) To Check

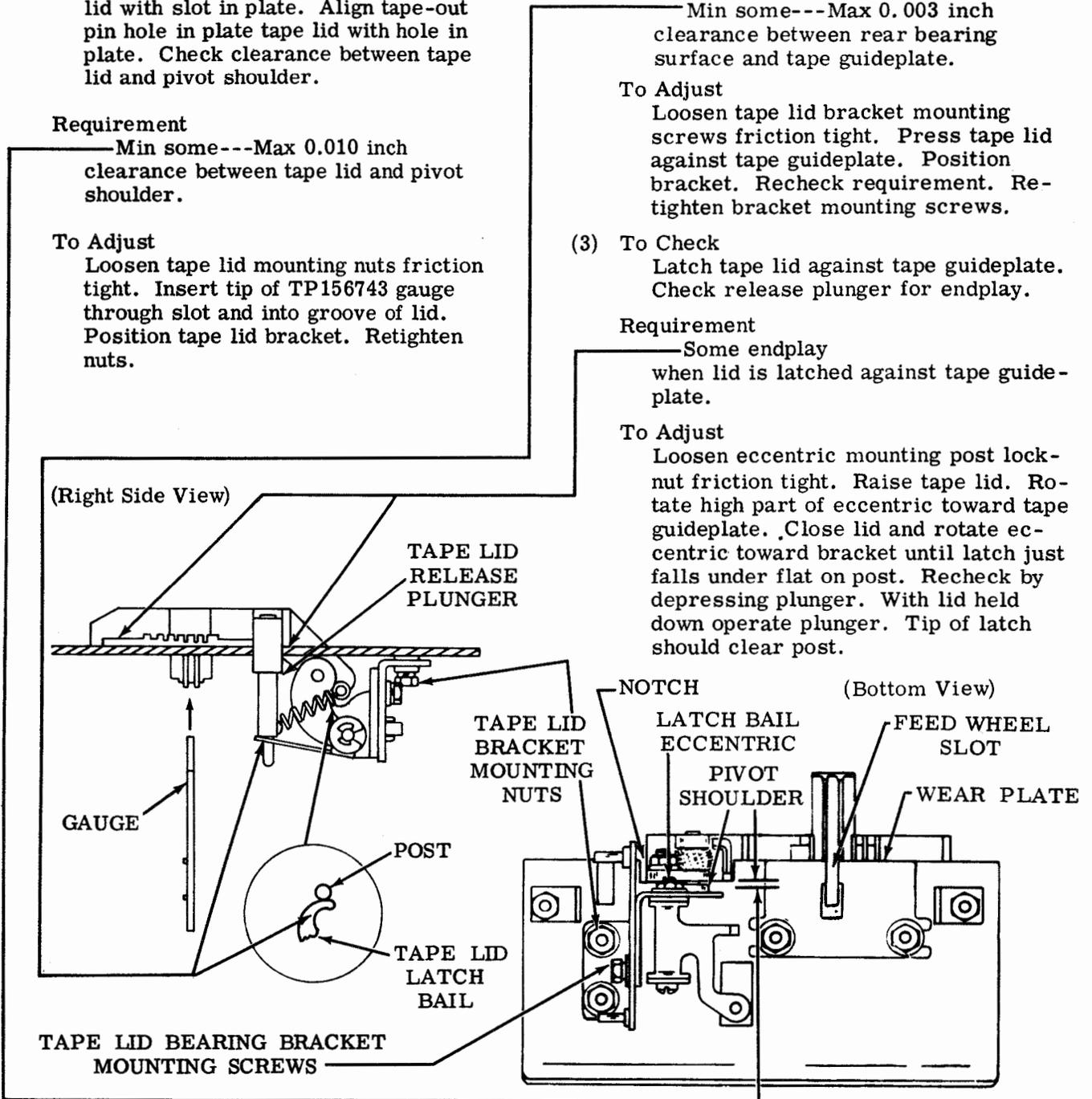
Latch tape lid against tape guideplate. Check release plunger for endplay.

**Requirement**

Some endplay when lid is latched against tape guideplate.

**To Adjust**

Loosen eccentric mounting post lock-nut friction tight. Raise tape lid. Rotate high part of eccentric toward tape guideplate. Close lid and rotate eccentric toward bracket until latch just falls under flat on post. Recheck by depressing plunger. With lid held down operate plunger. Tip of latch should clear post.



SECTION 573-127-703TC

4.02 Tape Lid (continued)

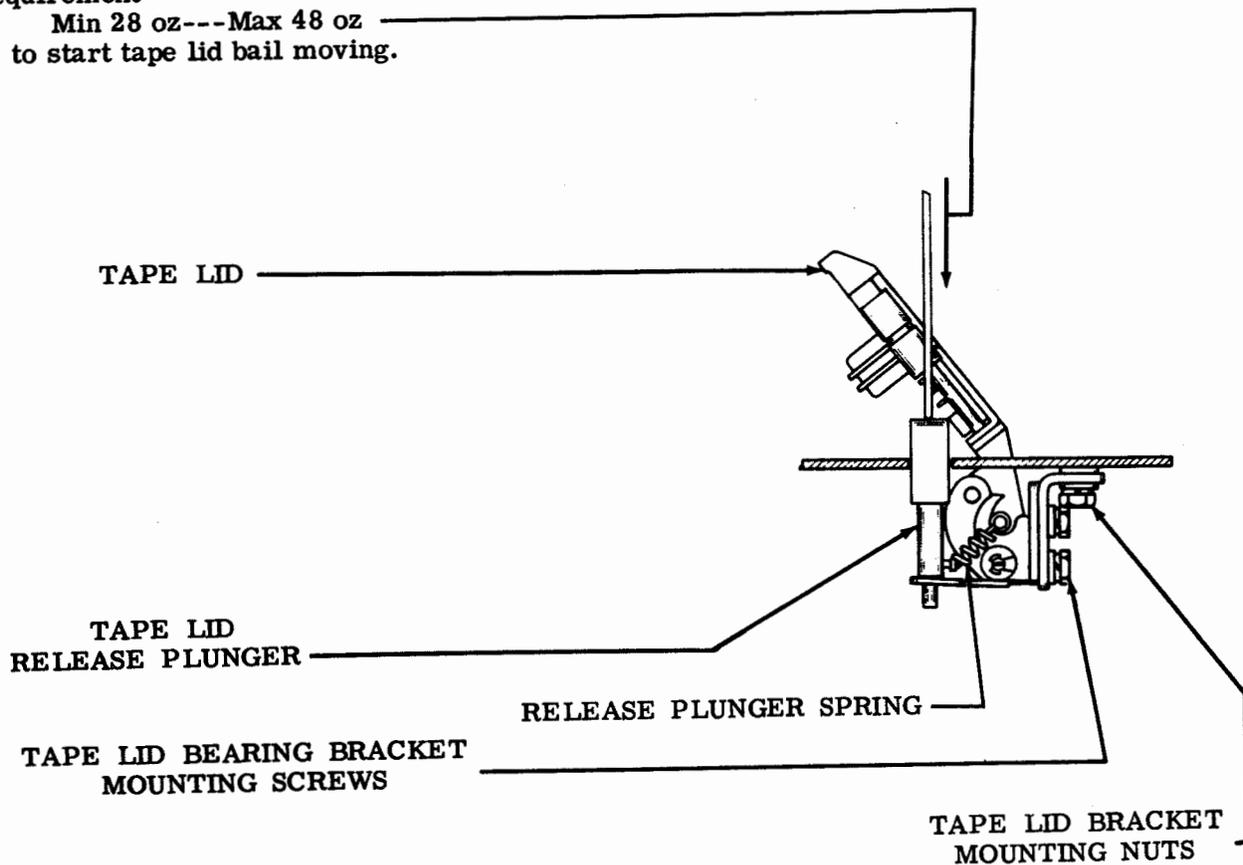
TAPE LID RELEASE PLUNGER SPRING (For Units without  
Tape Lid Spring)

To Check

Hold tape guideplate horizontally. Unlatch  
tape lid.

Requirement

Min 28 oz---Max 48 oz  
to start tape lid bail moving.



(Right Side View)