

“DATASPEED\*” 40 STATION AND COMPONENT REMOVAL

CONTENTS	PAGE	CONTENTS	PAGE
1. GENERAL .....	2	40BSE201 OPERATOR CONSOLE BASE .....	39
2. TOOLS REQUIRED .....	2	40BSE202 OPERATOR CONSOLE BASE .....	40
3. STATION AND COMPONENT REMOVAL .....	2	40/9140 STATION CONTROLLER .....	41
DISPLAY MONITOR .....	5	EIA SWITCH .....	43
LOGIC, PRINTER, AND PRINTER CABINET .....	7	KEYBOARD DISPLAY AMPLIFIER (KDA) .....	44
FRICTION FEED PRINTER (80-COLUMN) .....	9	40K00X AND 40K100 OPERATOR CONSOLE .....	45
TRACTOR FEED PRINTER (80-COLUMN) .....	11	40K200 OPERATOR CONSOLE ...	47
TRACTOR FEED PRINTER (132-COLUMN) .....	13	40PSU101 POWER SUPPLY .....	48
TRACTOR FEED PRINTER (72-COLUMN) .....	16	40PSU102 POWER SUPPLY .....	49
TRACTOR FEED PRINTER (80-COLUMN, FORMS ACCESS) .....	18	40DL291 DISPLAY LOGIC .....	50
40CAB201 AND 40CAB251 CABINETS .....	20	40C101, 40C102, 40C201, 40C202, AND 40C204 CONTROLLERS ....	51
40CAB351 AND 40CAB371 CABINETS .....	21	40C103 CONTROLLER .....	53
40CAB353 CABINET .....	23	40C400, 40C401, 40C402, AND 40C403 CONTROLLERS .....	55
40CAB901 CABINET .....	25	40C430, 40C431, AND 40C432 CONTROLLERS .....	57
40CAB902 CABINET .....	32	40C303 CONTROLLER .....	58
40CAB904 CABINET .....	33	40C304 AND 40C305 CONTROLLERS .....	59
40CAB302 CABINET .....	35	40C434, 40C435, AND 40C436 CONTROLLERS .....	62
40AB101 ANSWER-BACK .....	37	401200 COPY HOLDER .....	63
40BSE101 CIRCULAR BASE .....	38	40PWU101 AND 40PWU102 PAPER WINDERS .....	64
		4. WORKING STATION .....	65

\*Registered Trademark of AT&TCo.  
†Issue 1 Did Not Receive Standard Distribution

1. GENERAL

1.01 This section provides station and component removal (station disconnect) information for DATASPEED 40/0, 40/1, 40/2, 40/3, and 40/4. Packing instructions and illustrations are provided to insure proper handling and packing for service disconnects.

1.02 Whenever this section is reissued, the reason for reissue will be listed in this paragraph.

1.03 Station and component removal should be performed under the direction of a service disconnect order indicating the packing materials required, date, and location.

1.04 Do not pack "used" printer ribbon when printers are removed from service (remove and discard). For reference the appropriate packing procedure is shown in this section for packing new ribbon when printer is packed for shipment to service.

1.05 ALL STATIONS AND COMPONENTS REMOVED SHOULD BE RETURNED TO WESTERN ELECTRIC SERVICE CENTER WITHOUT INCURRING DAMAGE. THE PACKING METHODS SPECIFIED HEREIN REPRESENT ONE WAY TO HELP ASSURE SAFE TRANSPORT. A RETURNED MATERIAL TAG

SHOULD BE AFFIXED TO EACH ITEM. (SEE 4. WORKING STATION)

1.06 Pressure sensitive tape, tissue paper, glue, or sealing tape may be obtained locally.

1.07 Factory-type packing may be duplicated by ordering the required PK materials from Teletype Corporation. All other packing materials may be obtained from your local Western Electric Service Center.

2. TOOLS REQUIRED

2.01 The tools required for service disconnects of DATASPEED 40 apparatus are standard and should be present in standard maintenance tools kits.

3. STATION AND COMPONENT REMOVAL

3.01 Reverse the procedures in Part 2 of 579-505-352 for 40/0, Part 7 of 582-200-200 for 40/0 and 40/1, Part 3 of 582-200-202 for 40/2, Part 3 of 582-200-203 for 40/3, and Part 3 of 582-200-201 for 40/4, to remove the station from service (service disconnect).

3.02 When equipment is removed from service, use suitable quantities of packing containers for reshipment of station arrangements or components.

3.03 The following illustrations show some of the recommended packing procedures for reshipment.

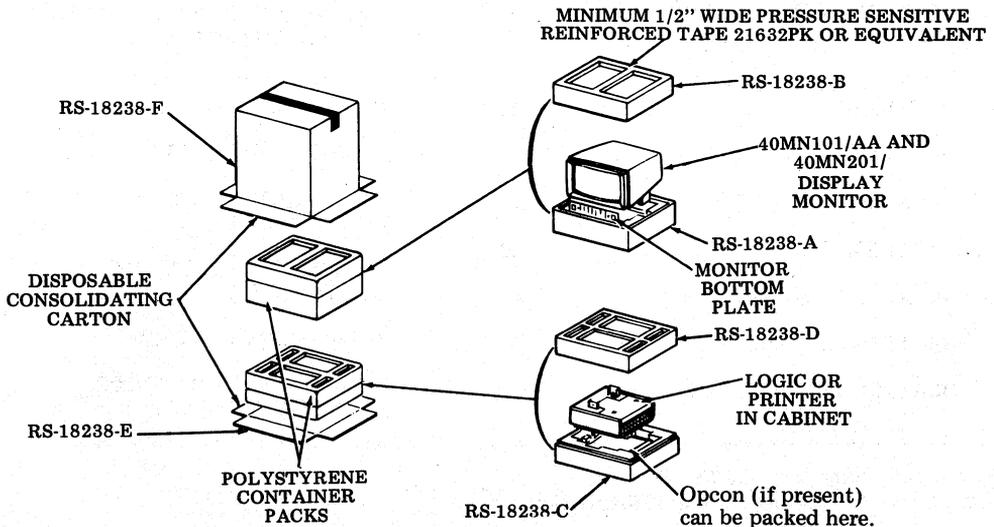


Fig. 1

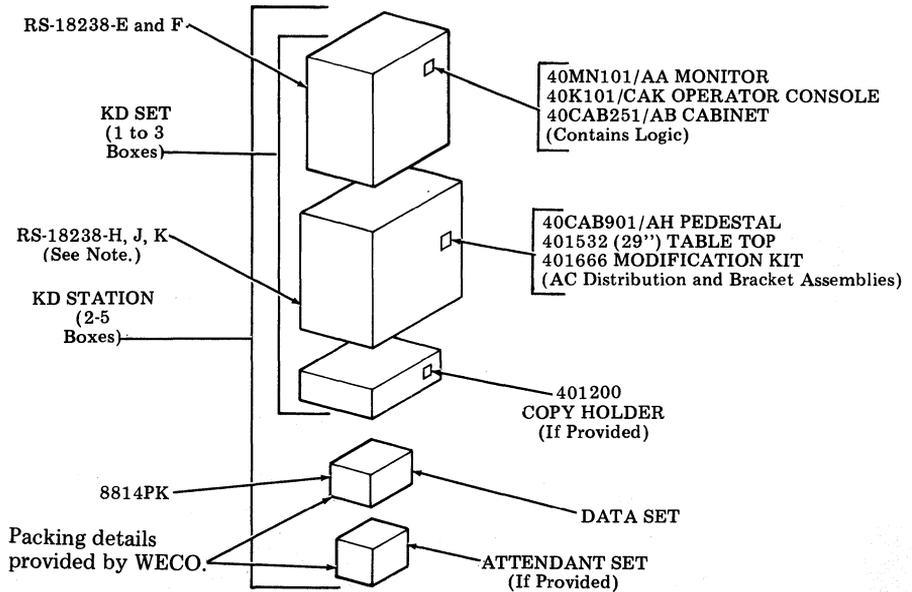


Fig. 2—Typical Packing Details for DATASPEED 40 Station Arrangements

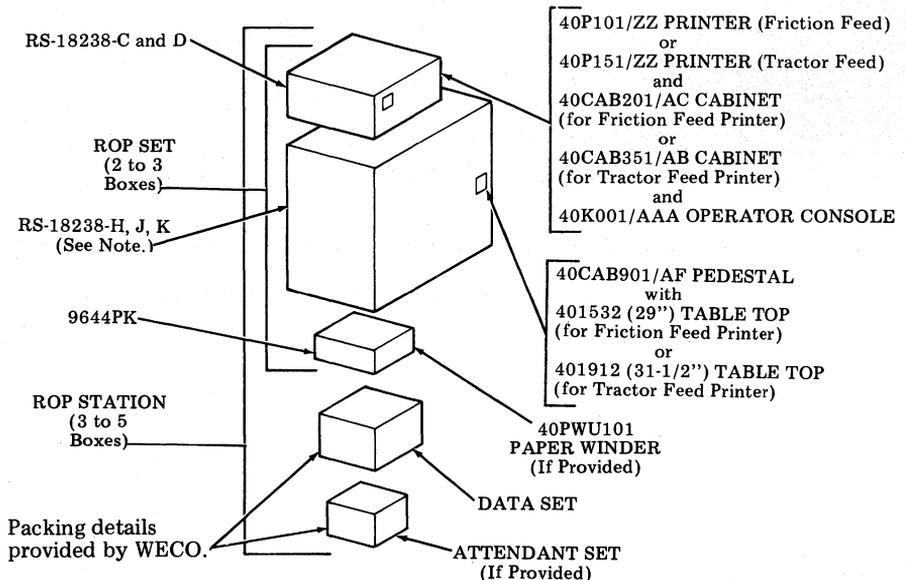
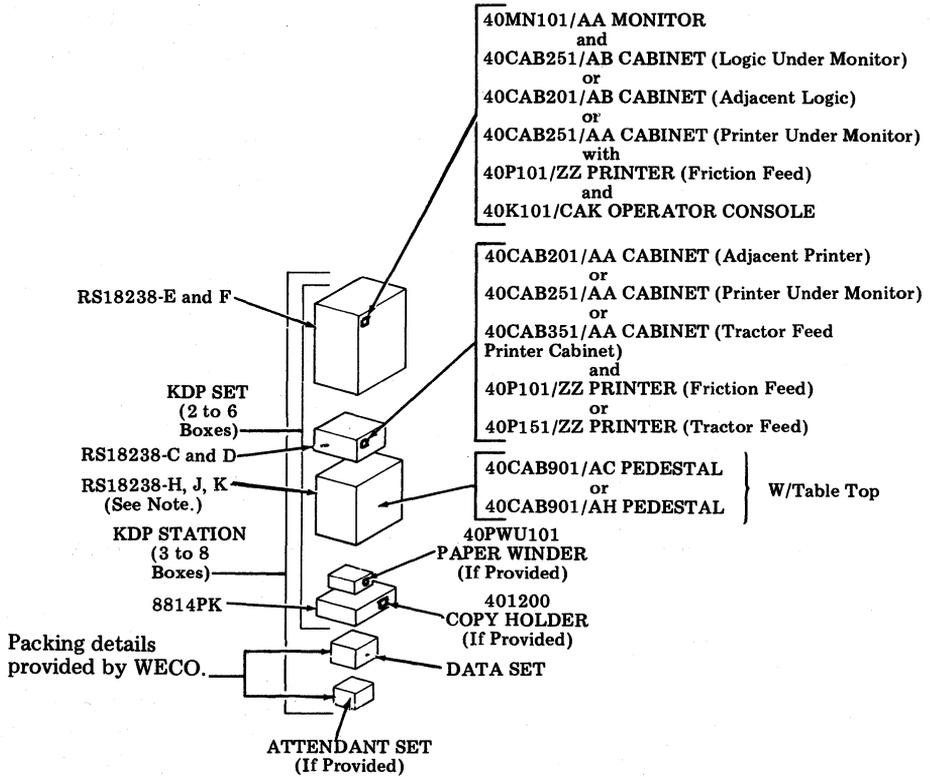


Fig. 3—Typical Packing Details for DATASPEED 40 Station Arrangements (Cont)

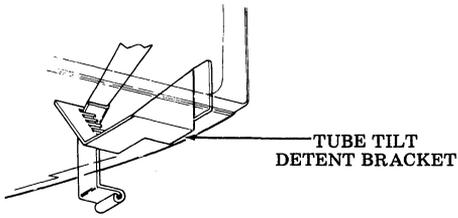
Note: Use two RS-18238-K blocking details when packing the pedestal (see Fig. 27).



*Note:* In a KDP w/tractor feed printer on pedestal, two 40CAB901/AH pedestals must be packed.

Fig. 4—Typical Packing Details for DATASPEED 40 Station Arrangements (Cont)

DISPLAY MONITOR



(Late Design)

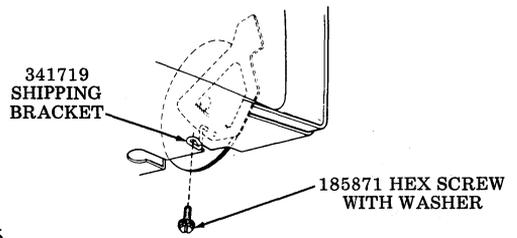


Fig. 5

(Early Design)

- Step 1. Remove the 401108 bottom plate from monitor.
- Step 2. Move the tilt lever to the front of monitor and engage the lever in the first or second detent position.

- Step 1. Remove the 401108 bottom plate from monitor.
- Step 2. Immobilize tube tilt mechanism with 341719 shipping bracket as illustrated in Fig. 5.

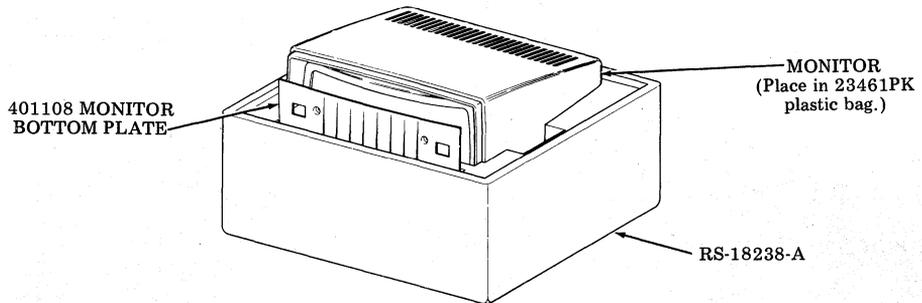


Fig. 6

- Step 3. Position monitor and bottom plate in position shown in Fig. 6. Position cover and secure with a band of pressure sensitive reinforced tape, as illustrated in Fig. 7.

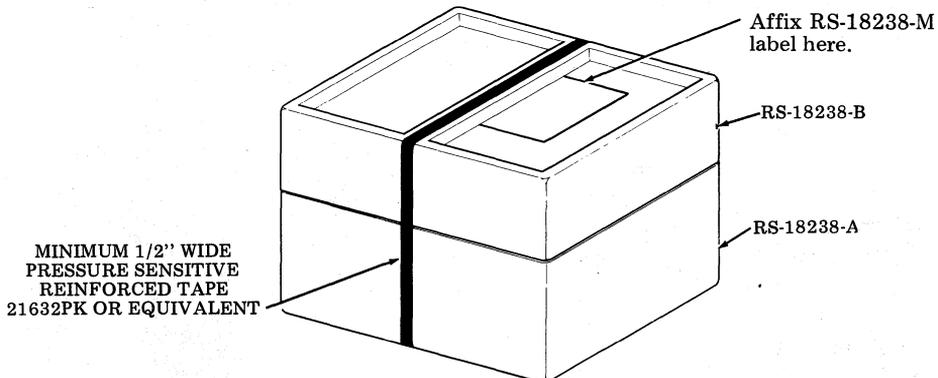
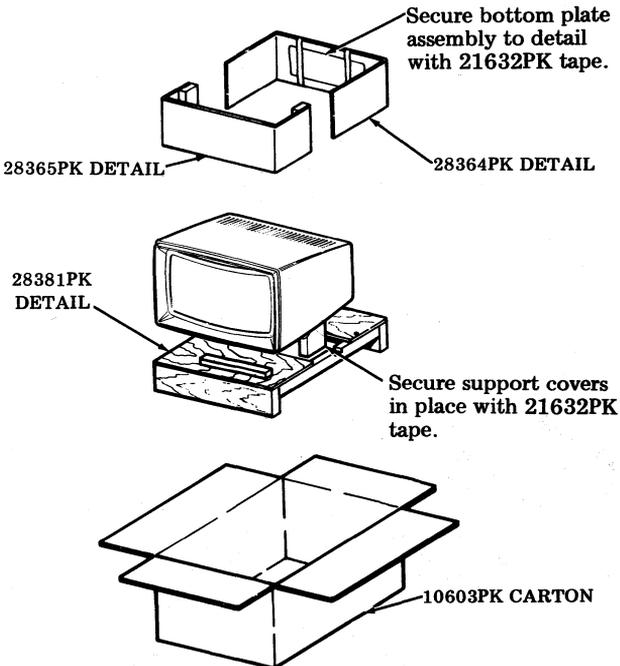


Fig. 7

MONITOR (Alternate Packing Procedure)

- Step 1. Preassemble all parts to bottom of main frame. Mount assembly to a 28381PK pallet with two 28051PK spacers, four 71699RM screws, four 72316RM lock-washers and four 72296RM flat washers. Tighten screws securely. (See Fig. 8.)
- Step 2. Complete assembly of monitor less cover. Invert monitor.
- Step 3. Mount and latch cover. Secure monitor support covers in place with 21632PK tape.
- Step 4. Form 10603PK carton. Close and seal bottom flaps with a strip of 21719PK tape applied along the center seam. The tape should extend approximately three inches down the ends of the carton.
- Step 5. Place unit in carton. Place a 23457PK plastic bag around unit.
- Step 6. Form a 28365PK detail and place in carton at front of unit as illustrated in Fig. 8.



Note: 23457PK Plastic Bag deleted for clarity.

Fig. 8

- Step 7. Wrap the bottom plate assembly in a sheet of 21298PK tissue paper. Form a 28364PK detail and secure the wrapped bottom plate to the detail with two bands of 21632PK tape.
- Step 8. Position the detail and bottom plate in the carton.
- Step 9. Close and seal the top flaps of the carton as outlined in Step 4.
- Step 10. Form a 11322PK carton and with bottom flaps down and outward, place around the inner carton.
- Step 11. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 12. Close and seal the top flaps of the carton with 21719PK tape as outlines in Step 4.
- Step 13. Carefully invert carton and contents. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 14. Close and seal bottom flaps of carton as outlined in Step 4. Invert carton.

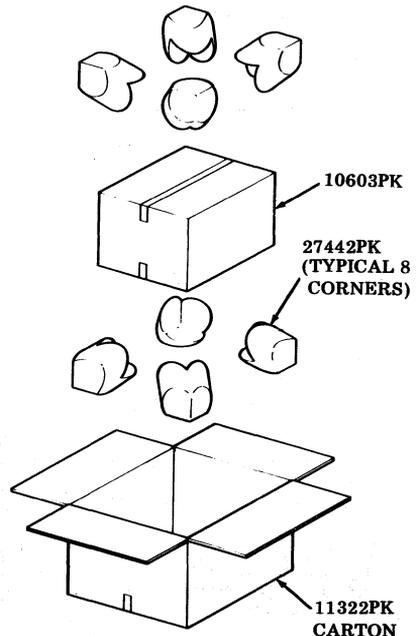


Fig. 9

LOGIC, PRINTER, AND PRINTER CABINET

Step 1. Position logic or printer cabinet in position shown in Fig. 10.

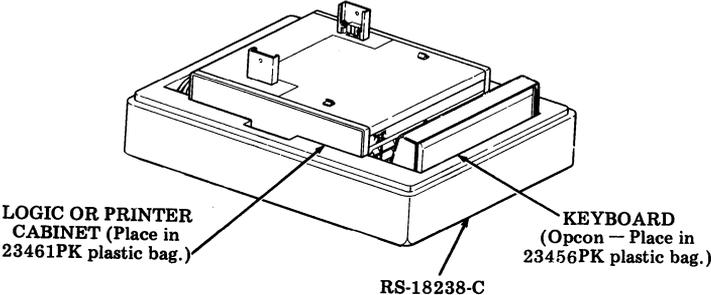


Fig. 10

Step 2. Insert keyboard and any loose cables in space provided in the RS-18238-C detail. See Fig. 11.

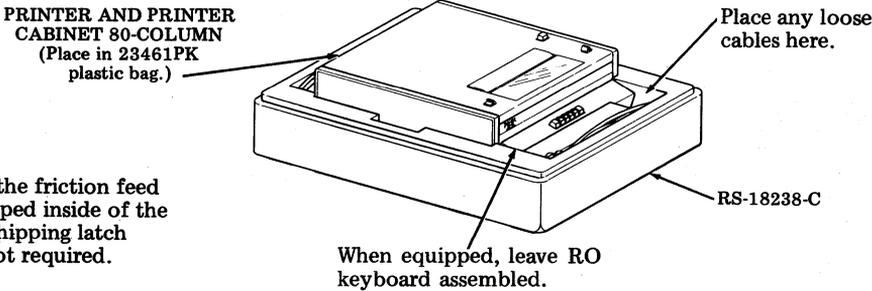


Fig. 11

Step 3. Position cover and secure with two bands of pressure sensitive reinforced tape. See Fig. 12.

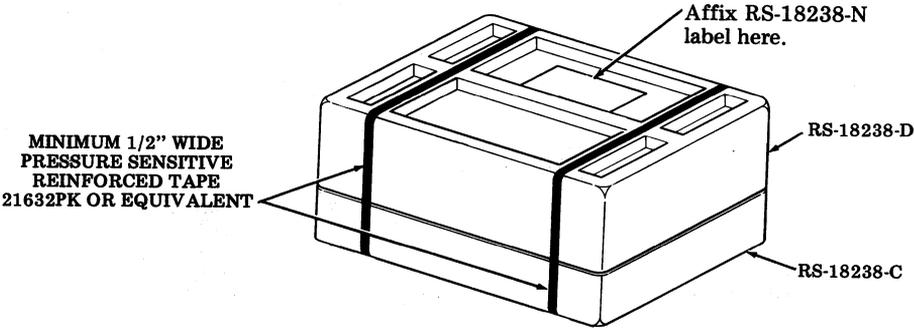


Fig. 12

SECTION 582-200-290

*Note:* When available, use consolidating container body RS-18238-F, container base RS-18238-E, along with 1/2 inch wide steel strapping around the base of container. Nylon tape may be used to secure the container base during removal operation.

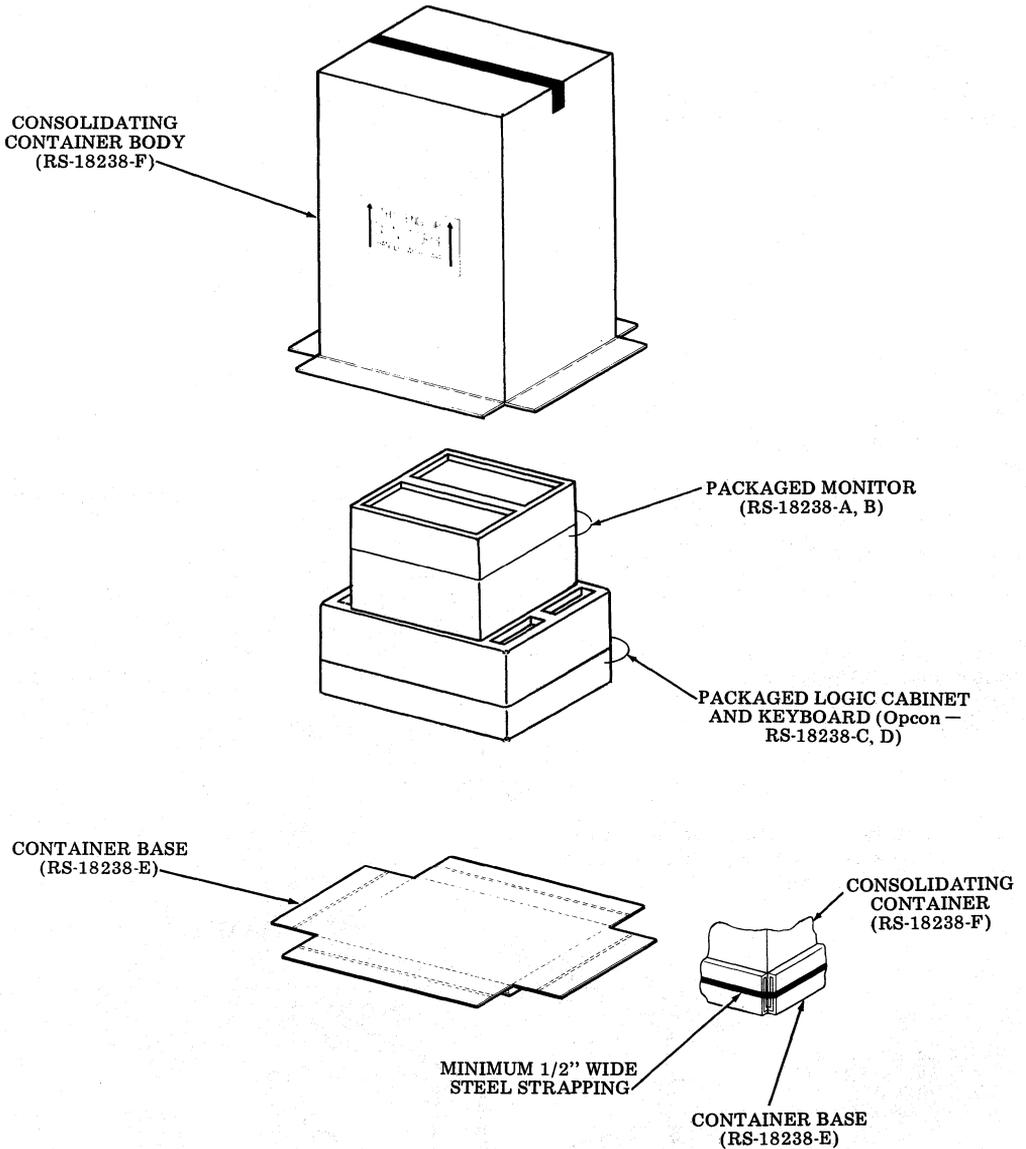


Fig. 13—Packing Logic, Printer, and Printer Cabinet

**FRICION FEED PRINTER (80-COLUMN)**

**Packing Procedure for 40P101 and 40P102 Printers**

- Step 1. Remove printer from printer cabinet.
- Step 2. Remove ribbon spools from printer and discard.
- Step 3. Place paper spindle in position on unit with ribbon spools positioned down.
- Step 4. Form shipping container 10160PK. Close and seal bottom flaps with glue or sealing tape.
- Step 5. Place a plastic detail 28249PK Detail A in the container as illustrated in Fig. 14.
- Step 6. Position unit in plastic base (see Fig. 14).
- Step 7. Position a plastic cover 28249PK Detail B over top of unit (see Fig. 14).
- Step 8. Close and seal top flaps of container as outlined in Step 4.

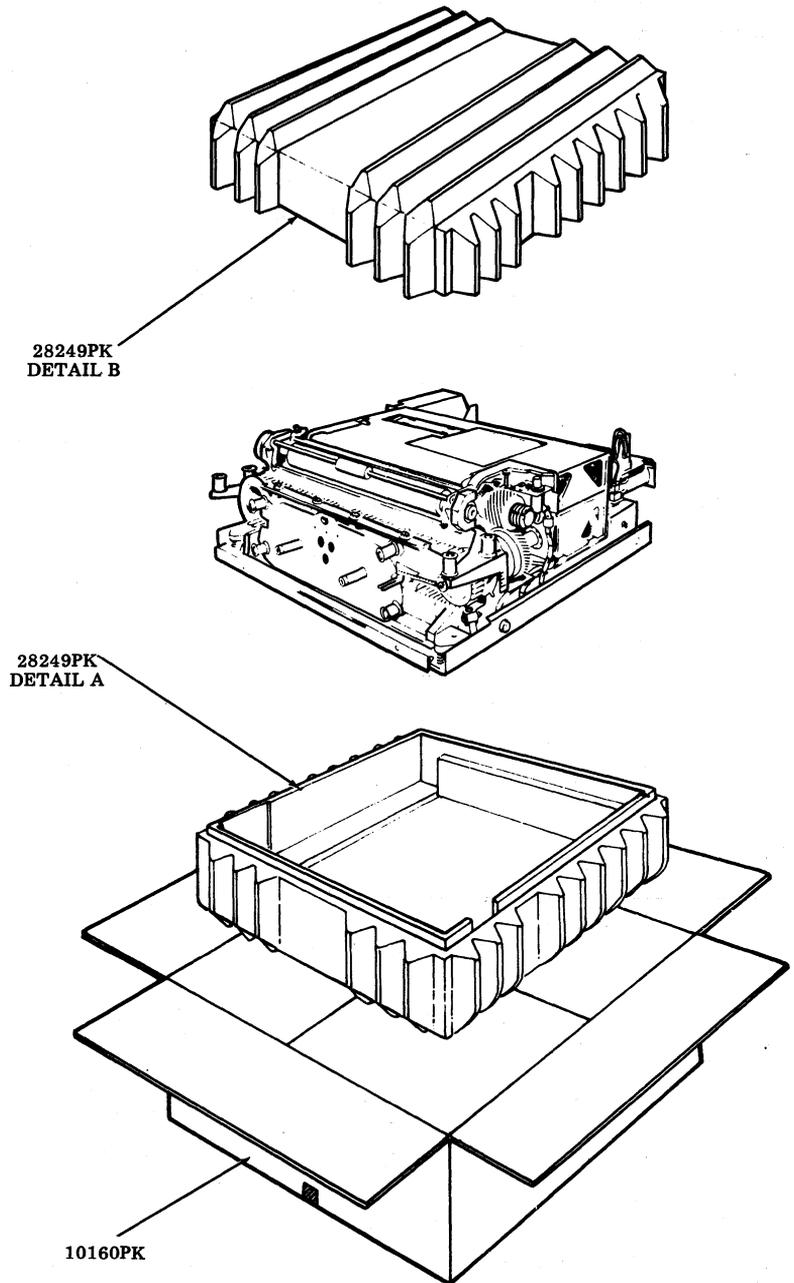


Fig. 14

**TRACTOR FEED PRINTER (80-COLUMN)****Packing Procedure for 40P150, 40P151, 40P152, 40P153, and 40P154 Printers**

- Step 1.** Remove printer from printer cabinet.
- Step 2.** Position printer on its back. Immobilize unit vibration mounts by tightening the four immobilizing screws. See Fig. 15.

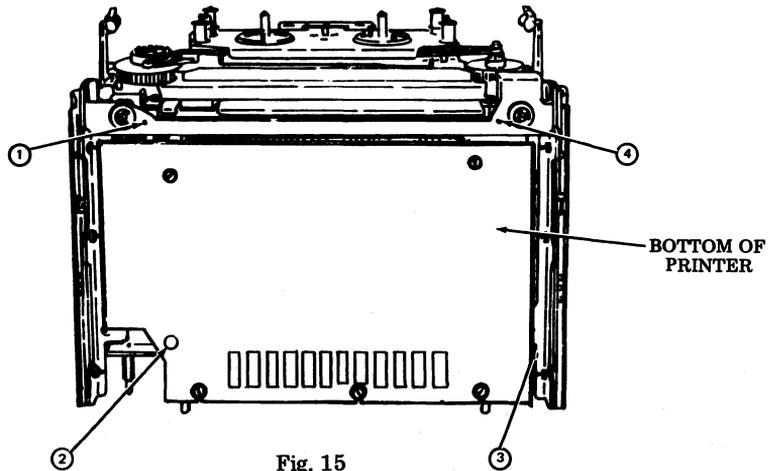


Fig. 15

- Step 3.** Set unit upright, secure each of the two ribbon tensioning arms in latched position with 50136PK twist ties as illustrated in Fig. 16.
- Caution:** Do not tightly apply twist ties. Damage to tensioning arms may result.
- Step 4.** Place a plastic base (28279PK Detail A) on work bench as illustrated in Fig. 16. Place printer in base.
- Step 5.** Position a 28279PK Detail C along the side of mounting rail at left side of printer and a 28279PK Detail D along the side of the mounting rail at right side of printer. See Fig. 16.
- Step 6.** Position a plastic cover (28279PK Detail B) over printer as illustrated in Fig. 16.
- Step 7.** Secure details A and B together by applying a band of 21632PK tape around the details as shown in Fig. 16.
- Step 8.** Form a 10523PK shipping container. Close and seal bottom flaps with glue or sealing tape.
- Step 9.** Place prepacked printer in container. Close and seal top flaps of container as outlined in Step 8.

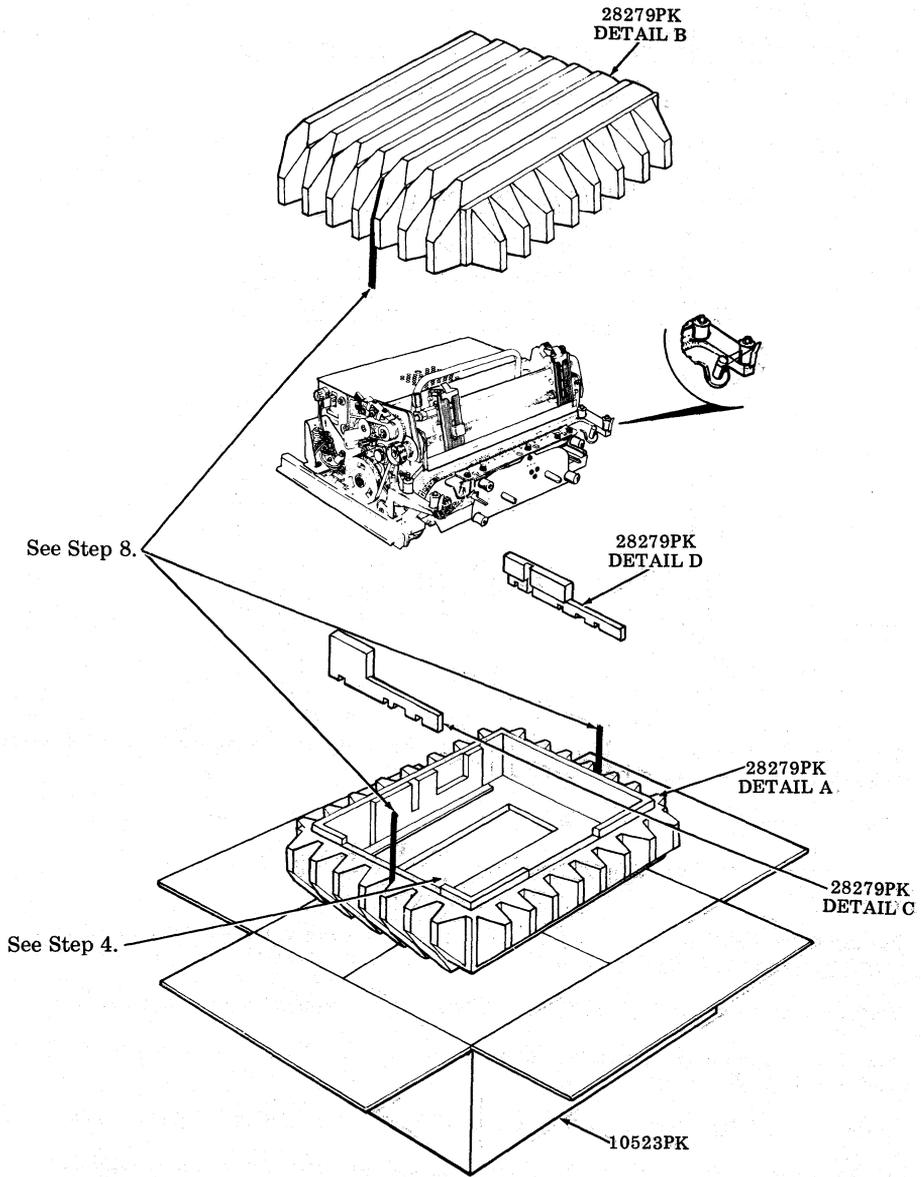


Fig. 16

## TRACTOR FEED PRINTER (132-COLUMN)

Packing Procedure for 40P200, 40P201, 40P202, 40P203 and 40P204 Printers

- Step 1. Remove printer from printer cabinet.
- Step 2. Remove ribbon spools from printer and discard.

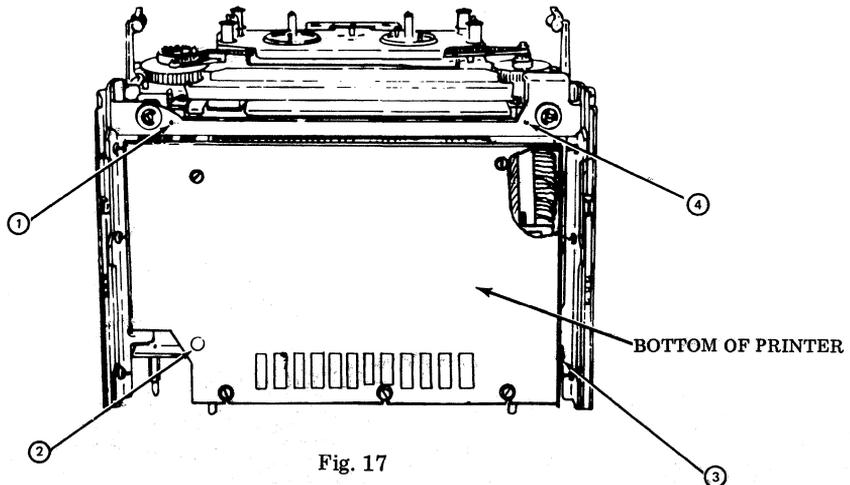


Fig. 17

- Step 3. Position printer on its back. Immobilize unit vibration mounts by tightening the four immobilizing screws. See Fig. 17.
- Step 4. Set unit upright. Secure each of the two ribbon tensioning arms in latched position with 50136PK twist ties.

*Caution: Do not tightly apply twist ties. Damage to tensioning arms may result.*

- Step 5. Position wood details 28250PK A and B against bottom of unit. Secure in place with two bands of tape 21632PK. See Fig. 18.
- Step 6. Form shipping container 10634PK. Close and seal bottom flaps with glue or sealing tape.
- Step 7. Position a plastic corner 27442PK against each of the four corners of the container. See Fig. 18.
- Step 8. Form carton 9902PK. Close and seal bottom flap as outlined in Step 6. Position carton in shipping container so bottom corners of carton fit in the corner details. See Fig. 18.
- Step 9. Carefully position the prepackaged printer in the carton-container assembly. See Fig. 18.
- Step 10. Position a wood top detail 28252PK over top of printer. See Fig. 18.
- Step 11. Close and seal top flaps of carton, as outlined in Step 6.
- Step 12. Position a 27442PK plastic corner on each of the four corners of the carton. See Fig. 18.
- Step 13. Close and seal top flaps of carton as outlined in Step 6.

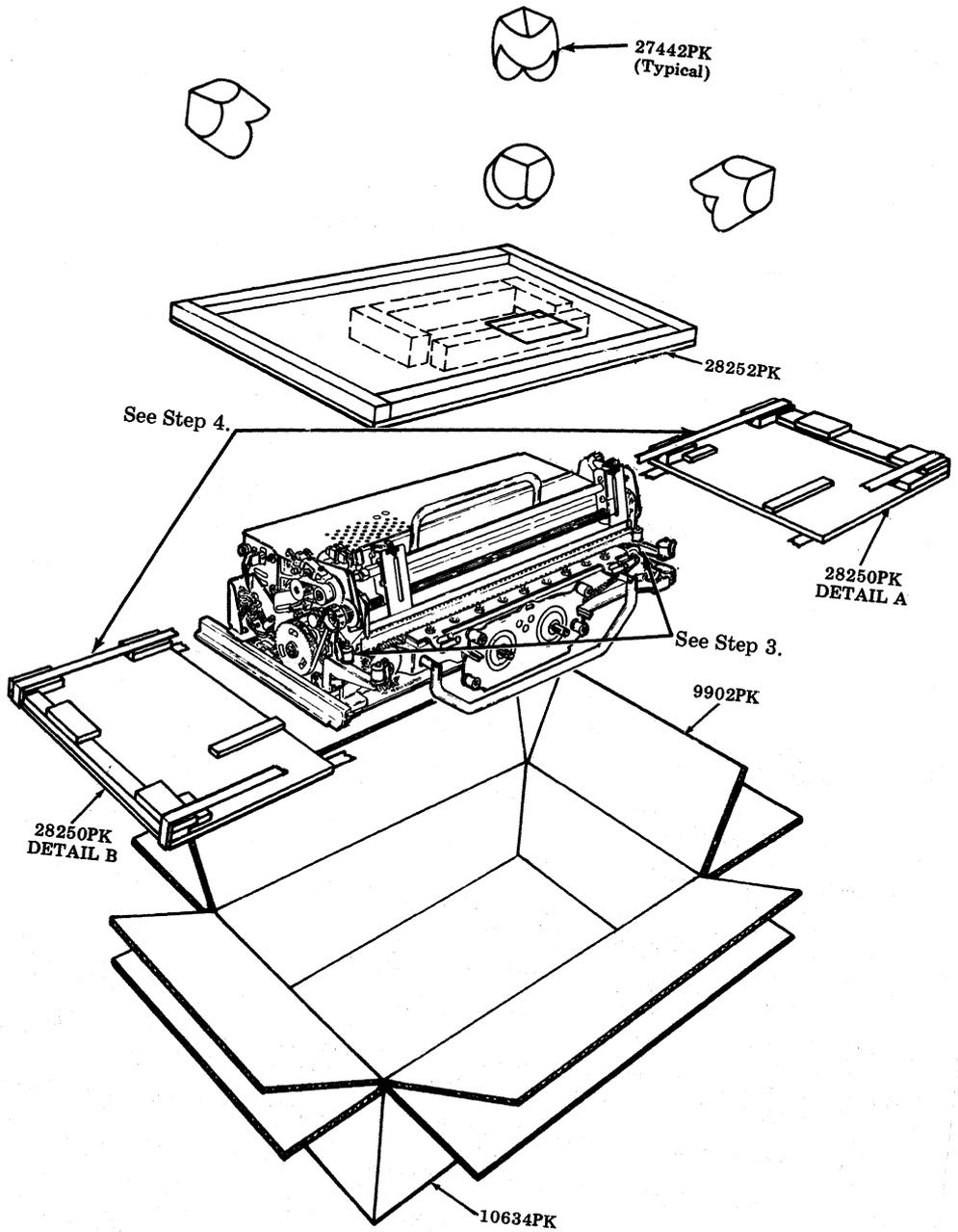


Fig. 16

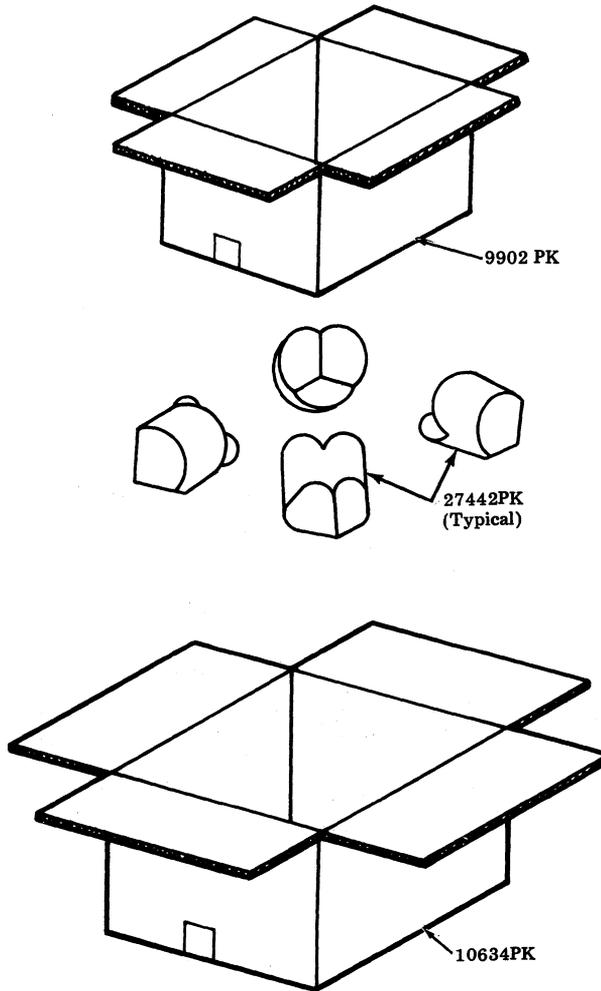


Fig. 19

TRACTOR FEED PRINTER (72-COLUMN)

Packing Procedure for 40P250 (Forms Access) Printer

- Step 1. Remove printer from printer cabinet.
- Step 2. Remove ribbon spools from printer and discard.
- Step 3. Position printer on its back. Immobilize unit vibration mounts by tightening the four immobilizing screws.
- Step 4. Position wood details 28283PK A and B against bottom of unit. Secure in place with two bands of 21632PK tape at front and rear of details.
- Step 5. Form a 10762PK carton. Close bottom flaps and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the ends of the carton.
- Step 6. Place one 27442PK plastic corner in each of the four corners of the bottom of the carton. See Fig. 20.
- Step 7. Form a 10305PK carton. Close and seal bottom flaps as indicated in Step 5.
- Step 8. Carefully place the 10305PK carton in the 10762PK carton so the plastic corners fit in the corners of the 10305PK carton. See Fig. 20.

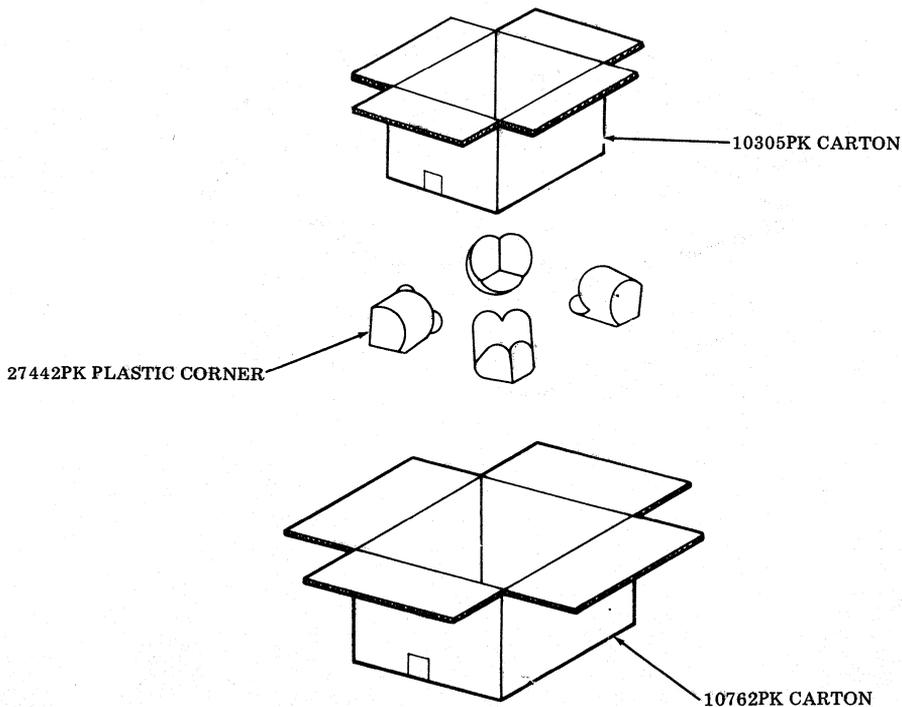


Fig. 20

- Step 9. Place the printer with pallets in the inner carton. See Fig. 21.
- Step 10. Place one 28284PK wood detail in carton on top of printer. See Fig. 21.
- Step 11. Close and seal top flaps of inner carton as indicated in Step 5.
- Step 12. Position a 27442PK plastic corner on each of the four corners of the inner carton. See Fig. 21.
- Step 13. Close top flaps of outer carton and seal center seam with a strip of 21719PK tape as indicated in Step 5.

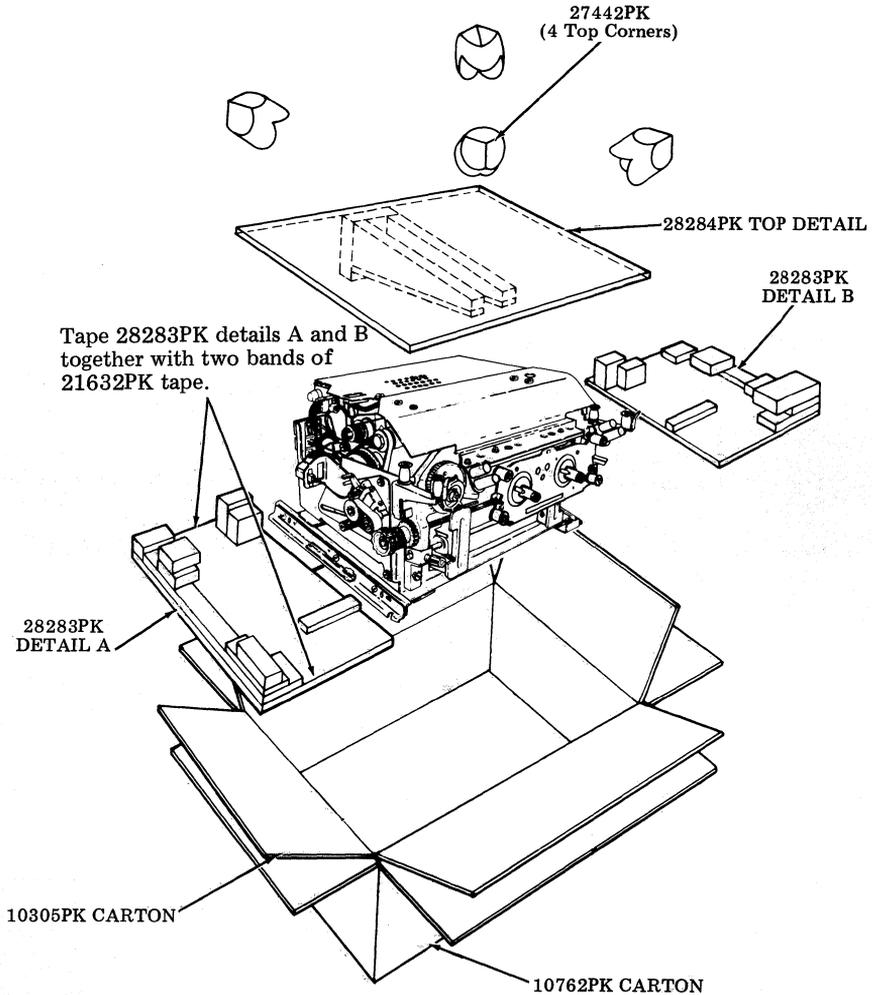


Fig. 21

## SECTION 582-200-290

### TRACTOR FEED PRINTER (80-COLUMN, FORMS ACCESS)

#### Packing Procedure for 40P252, 40P253, and 40P255 (Forms Access) Printers

- Step 1. Remove printer from printer cabinet.
- Step 2. Remove the ribbon spools and discard.
- Step 3. Position printer on its back. Immobilize unit vibration mounts by tightening the four immobilizing screws.
- Step 4. Position wood details 28283PK A and B against bottom of unit. Secure in place with two bands of 21632PK tape at front and rear of details.
- Step 5. Form a 10770PK carton. Close bottom flaps and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the ends of the carton.
- Step 6. Form and place one 28366PK cushion detail in each of two sides of the bottom of the carton. See Fig. 22.
- Step 7. Form a 10305PK carton. Close and seal bottom flaps as indicated in Step 5.
- Step 8. Carefully place the 10305PK carton in the 10770PK carton so the cushion details fit in the corners of the 10305PK carton. See Fig. 22.
- Step 9. Place the printer with pallets in the inner carton.
- Step 10. Place a 28284PK wood detail in carton on top of printer. See Fig. 23.
- Step 11. Close and seal top flaps in inner carton as indicated in Step 5.
- Step 12. Form and place a 28366PK cushion detail on each of two sides of the inner carton. See Fig. 22.
- Step 13. Close top flaps of outer carton and seal center seam with a strip of 21719PK tape as indicated in Step 5.

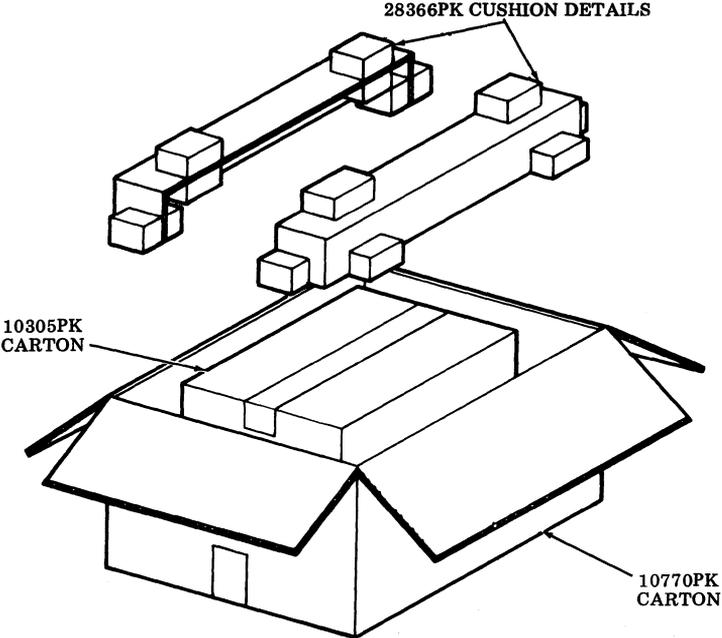


Fig. 22

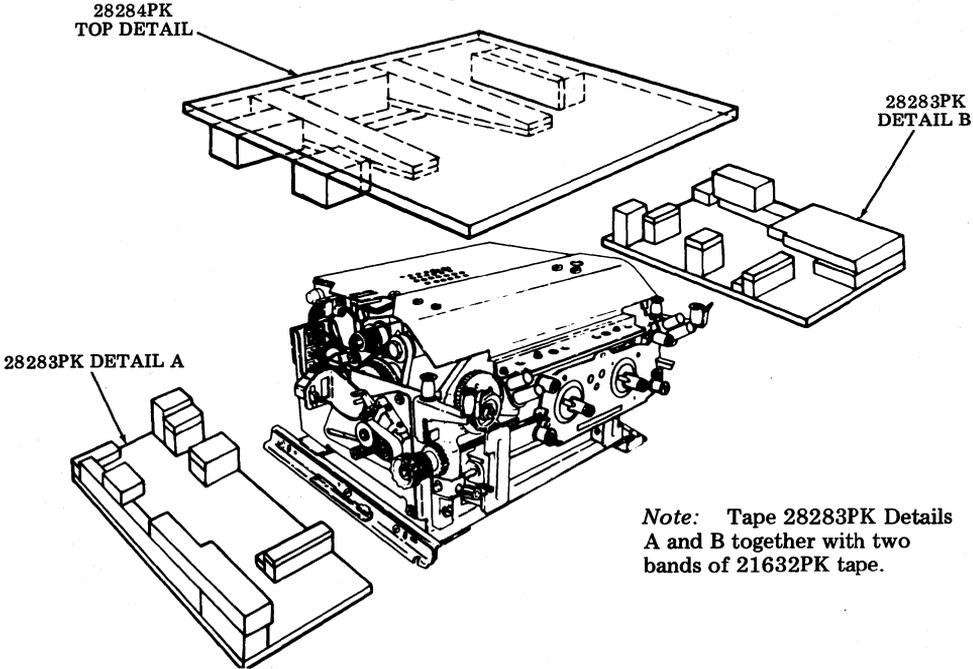


Fig. 23

40CAB201 AND 40CAB251 CABINETS

Packing Procedures

- Step 1. Form a 9867PK carton. Close and seal bottom flaps with glue or sealing tape.
- Step 2. Make certain shipping latches and bar on cabinet are properly installed. Cover cabinet with 23457PK plastic bag.
- Step 3. Position a plastic 28218PK Detail A on right side of cabinet. (See Fig. 24).
- Step 4. Position a plastic 28218PK Detail B on left side of cabinet. (See Fig. 24).
- Step 5. Coil cable on top of cabinet and position prepacked cabinet in shipping container. (See Fig. 24).
- Step 6. Close and seal top flaps of shipping container as outlined in Step 1.

Note: 40CAB201 series is pictured.

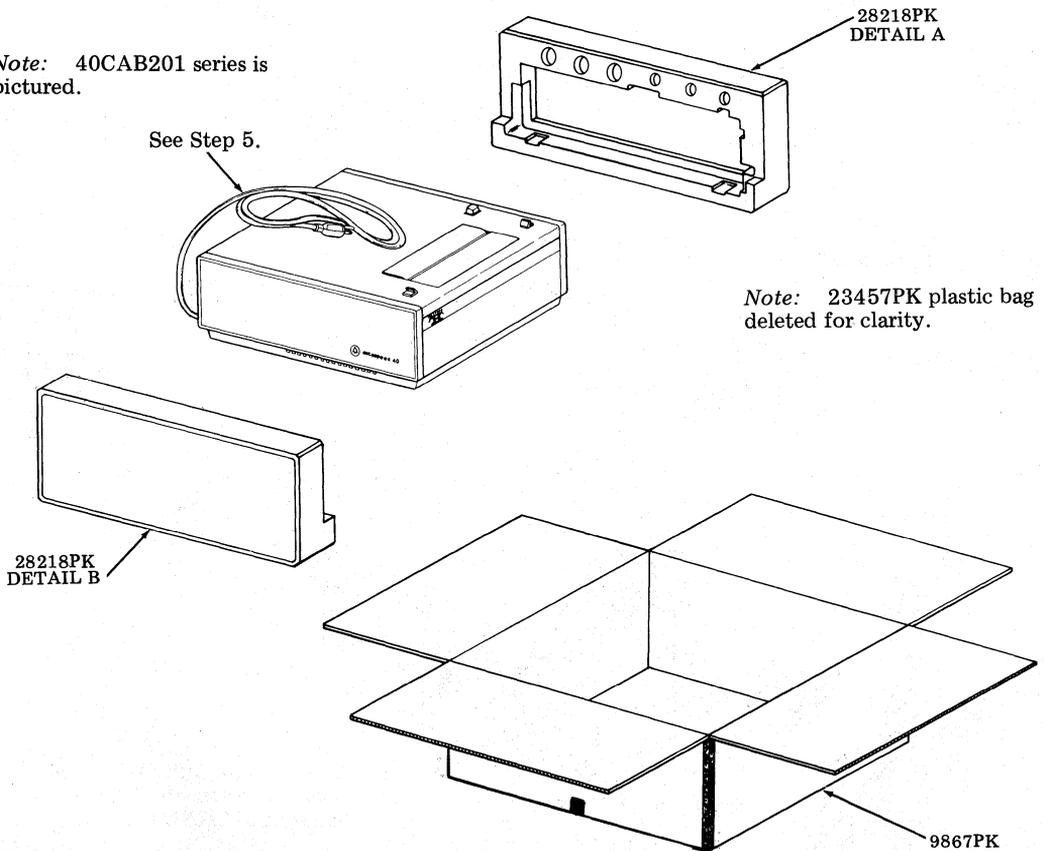
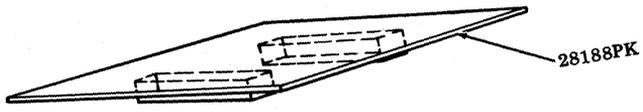


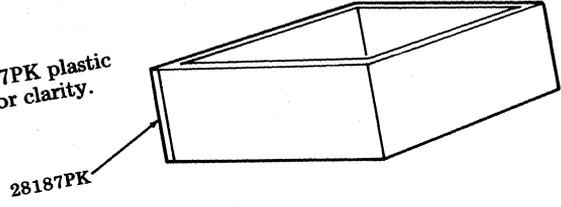
Fig. 24

**40CAB351 AND 40CAB371 CABINETS****Packing Procedure for 40CAB351 Cabinet and 40CAB371 Cabinet**

- Step 1. Place a 28186PK detail on work bench. Position cabinet on detail as illustrated in Fig. 25. The end of the detail that has the largest blocks must be to the front of the cabinet.
- Step 2. Secure cover of cabinet with two bands of 21632PK tape applied around cover and body of cabinet. See Fig. 25.
- Step 3. Place a 23457PK plastic bag over cabinet. Leave cable extending outside of bag. Place cable on top of cabinet.
- Step 4. Fold flaps on 28186PK detail up against sides of cabinet. Secure in place with a strip of 21480PK tape applied to flaps at diagonally opposite corners.
- Step 5. Form a 10532PK carton. With bottom flaps down and outward, place carton around cabinet and detail. Drape cable outside of carton.
- Step 6. Form a 28187PK detail and place in carton around cabinet dome. See Fig. 25. Coil cable and place between side of carton and 28187PK detail. See Fig. 25.
- Step 7. Place a 28188PK detail in carton as illustrated in Fig. 25.
- Step 8. Close top flaps of carton and seal center seam with 21719PK tape. Invert carton.
- Step 9. Close bottom flaps of carton and seal as outlined in Step 8. Invert carton.



Note: 23457PK plastic bag deleted for clarity.



Coil cable and place between side of 28187PK detail and carton wall.

Secure cover with 2 bands of 21632PK tape applied around cabinet, as shown.

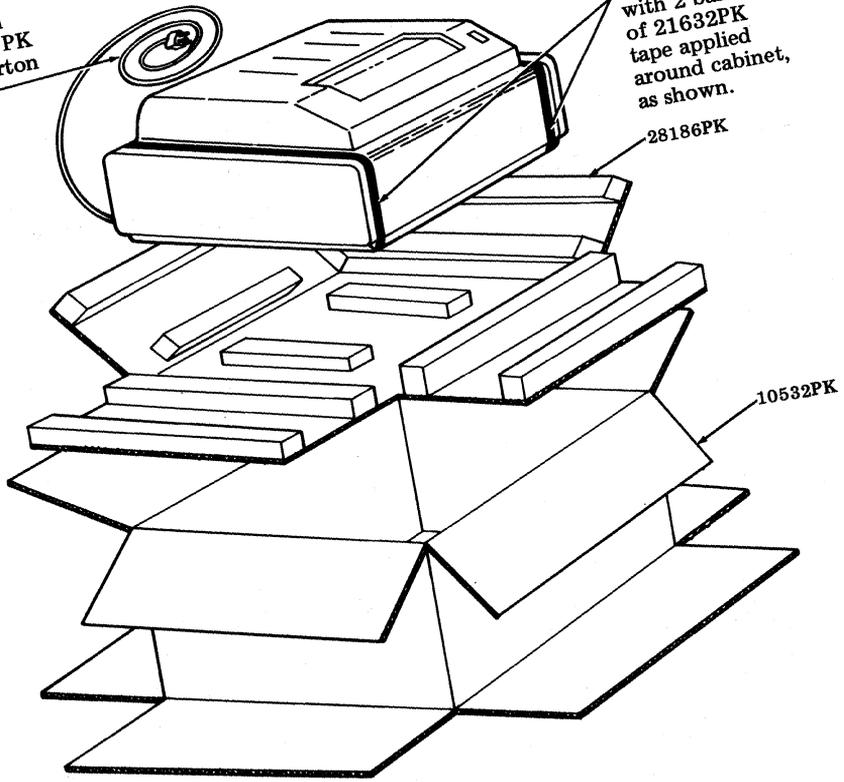


Fig. 25

**40CAB353 CABINET****Packing Procedure for 40CAB353 Cabinet**

- Step 1. Secure cover of cabinet with two strips of 21632PK tape. Follow contour of cabinet. (See Fig. 26).
- Step 2. Place a 23461PK plastic bag over cabinet. Leave cable extending outside of bag. Place cable on top of cabinet.
- Step 3. Form a 10672PK carton. Close and seal bottom flaps with 21719PK tape. Apply one strip on the center seam and a strip on each of the end seams.
- Step 4. Form a 28224PK detail and place in carton. See Fig. 26.
- Step 5. Center cabinet in carton left to right. Butt back of cabinet against the plastic blocks.
- Step 6. Position a 28225PK detail along each side and front of cabinet. See Fig. 26.
- Step 7. Extend cable outside of cabinet. Form and place a 28227PK liner on cabinet dome. See Fig. 26.
- Step 8. Coil cable and place in recess formed by the 28227PK liner and carton wall.
- Step 9. Place a 28226PK detail in carton as illustrated in Fig. 26.
- Step 10. Close and seal top flaps of carton as outlined in Step 3.

Note: 23461PK plastic bag deleted for clarity.

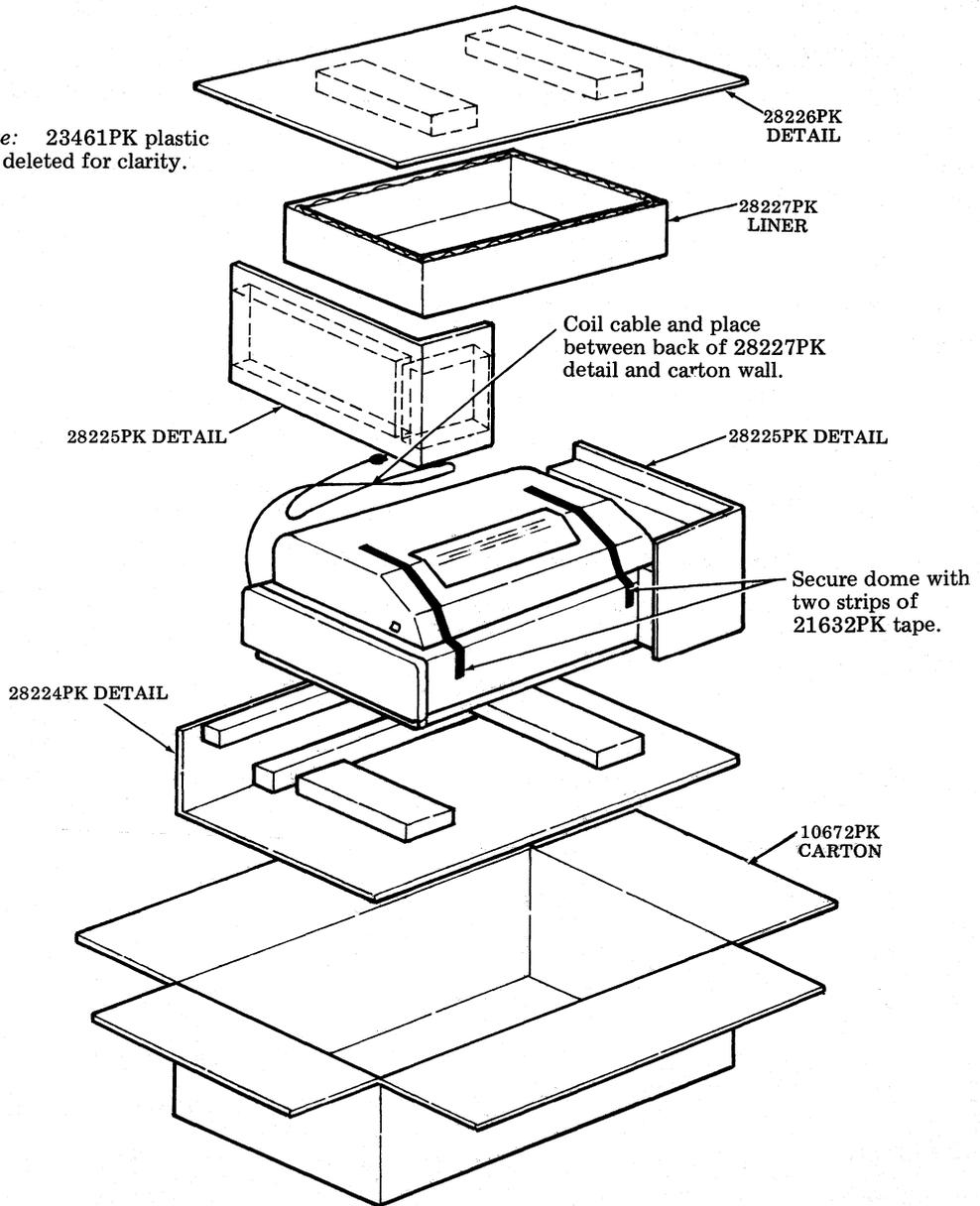
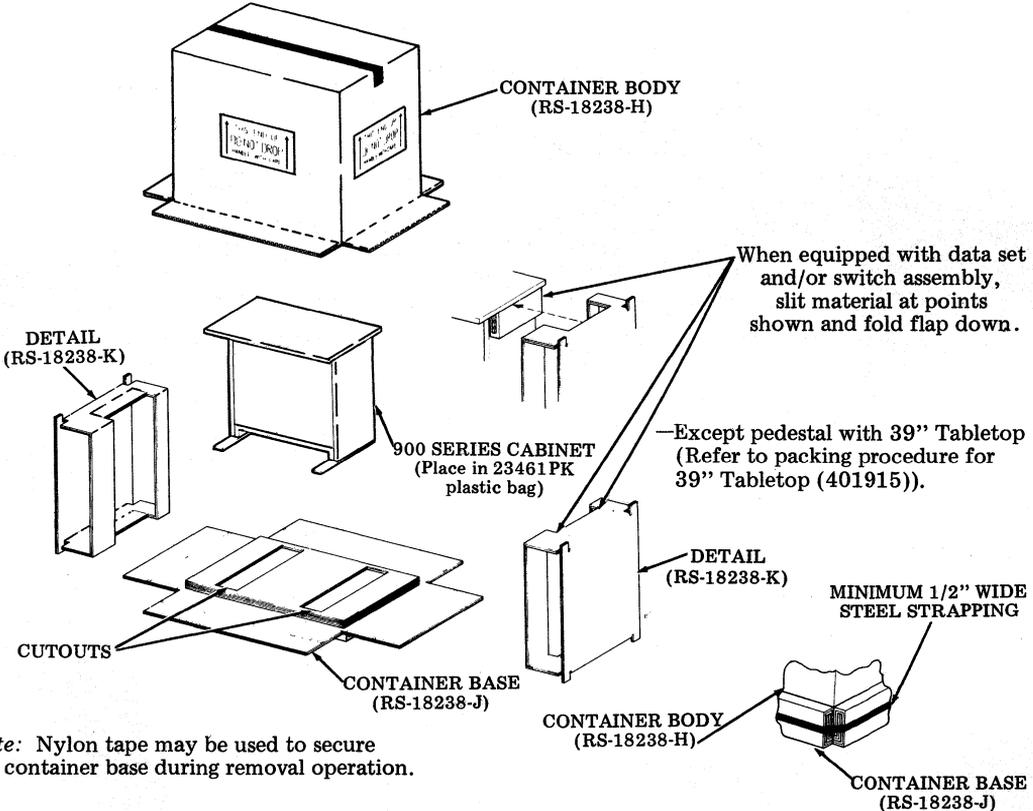


Fig. 26

40CAB901 CABINET

Packing Procedure for 40CAB901 Pedestal With Table Top

- Step 1. Open door in bottom of pedestal (when equipped). Secure line cord (if equipped) to line cord holding brackets with 50136PK twist ties. Place cord in bottom of pedestal.
- Step 2. Close door. Close latches located at either end on top of door.
- Step 3. Place a 23461PK plastic bag around unit.
- Step 4. Place container base (RS-18238-J) on floor as shown.
- Step 5. Position pedestal in container base cutouts.
- Step 6. Form and position side details (RS-18238-K left and right) to pedestal.
- Step 7. Form a RS-18238-H container body and position over pedestal. Secure base with nylon reinforced tape. Standard procedure is to apply a band of steel strapping around the base of the container.



Note: Nylon tape may be used to secure the container base during removal operation.

Fig. 27

Packing Procedure for 20 inch Tabletop (401911)

- Step 1. Place tabletop in a 23457PK plastic bag.
- Step 2. Form a 8565PK folder. Center top in folder. Place a 28214 wood detail at either end of top as illustrated.
- Step 3. Fold tabs on inner flaps of folder as illustrated.
- Step 4. Close flaps and seal center seam with 21719PK tape.

*Note:* Packing procedure and packing materials for 24 inch tabletops (401531 and 401914) are identical to (401911) except that 28214PK wood details are not required in (401531 and 401914).

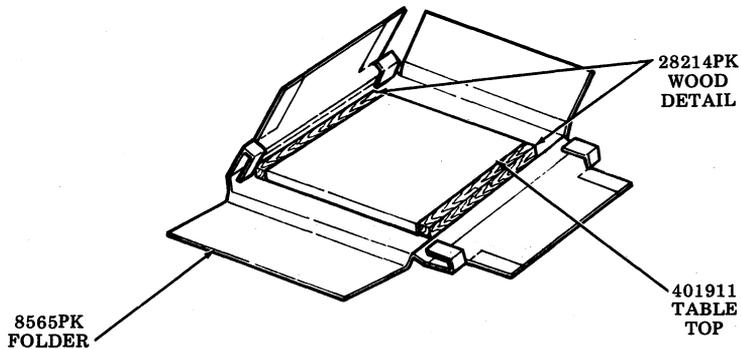


Fig. 28

Packing Procedure for 27 1/2 inch Tabletop (401913)

- Step 1. Place tabletop in a 23451PK plastic bag.
- Step 2. Form a 8564PK folder. Center top and a 28254PK wood detail in folder. Fold tabs on inner flaps of folder as illustrated.
- Step 3. Close flaps and seal center seam with 21719PK tape.

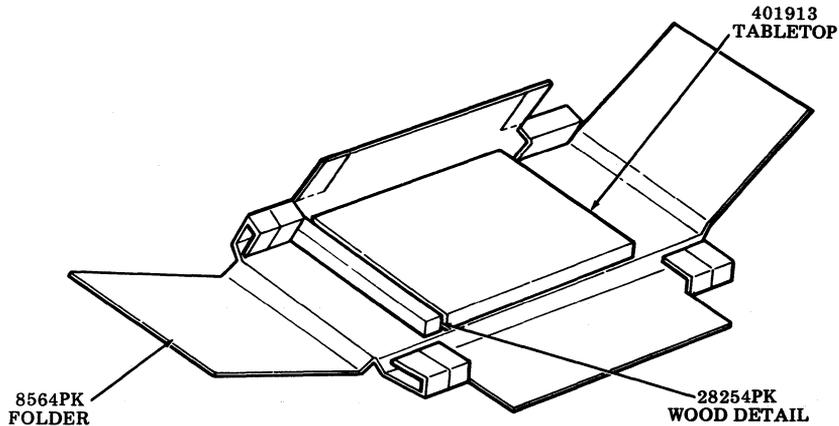


Fig. 29

Packing Procedure for 29 inch Tabletops (401532 and 411035)

- Step 1. Place tabletop in a 23451PK plastic bag.
- Step 2. Form a 8564PK folder. Center top in folder. Fold tabs on inner flaps of folder as illustrated.
- Step 3. Close flaps and seal center seam with 21719PK tape.

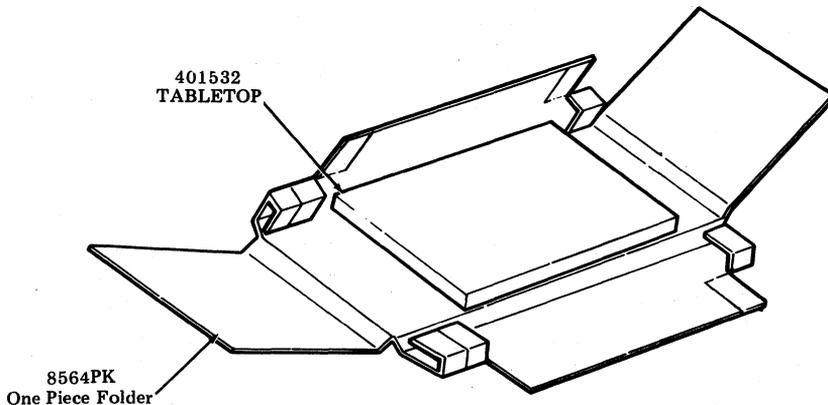


Fig. 30

Packing Procedure for 31 inch Tabletop (401912)

- Step 1. Place tabletop in a 23451PK plastic bag.
- Step 2. Form a 8564PK folder. Position top in folder. Fold tabs on inner flaps of folder as illustrated.
- Step 3. Close flaps and seal center seam with 21719PK tape.

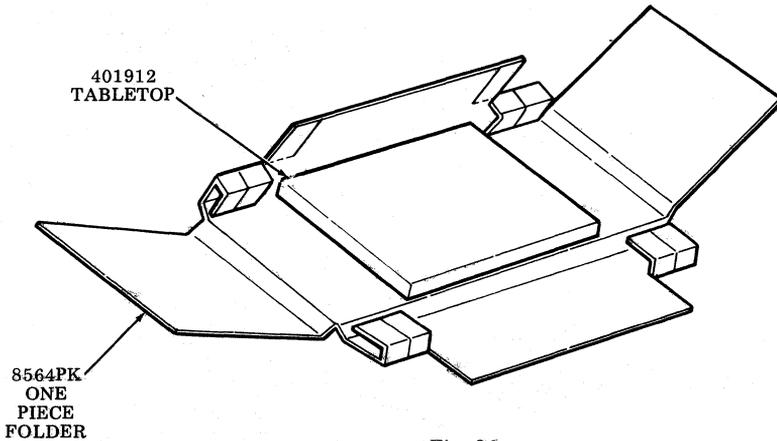


Fig. 31

Packing Procedure for 34 inch Tabletop (401533)

- Step 1. Place tabletop in a 23451PK plastic bag.
- Step 2. Form a 8564PK folder. Center top in folder. Fold tabs on inner flaps of folder as illustrated.
- Step 3. Close flaps and seal center seam with 21719PK tape.

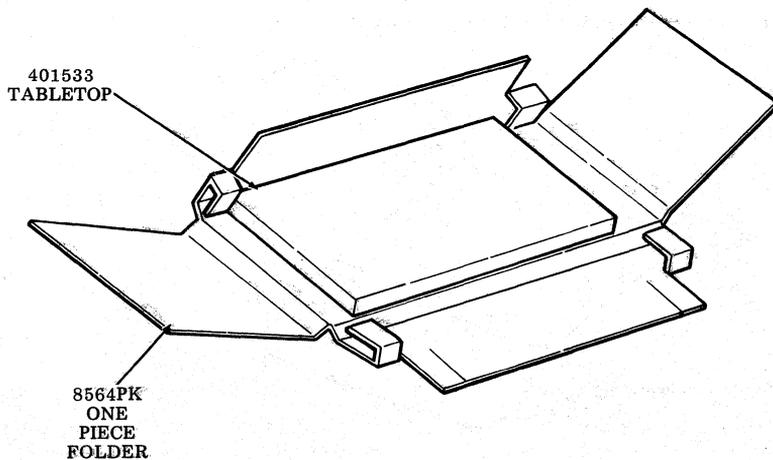


Fig. 32

Packing Procedure for 39 inch Tabletop (401915)

- Step 1. Place tabletop in a 23464PK plastic bag.
- Step 2. Form a 8573PK two piece folder. Center top upside down in folder. Place a 28214PK wood detail at either end of top as illustrated.
- Step 3. Close flaps and seal center seam with 21719PK tape.

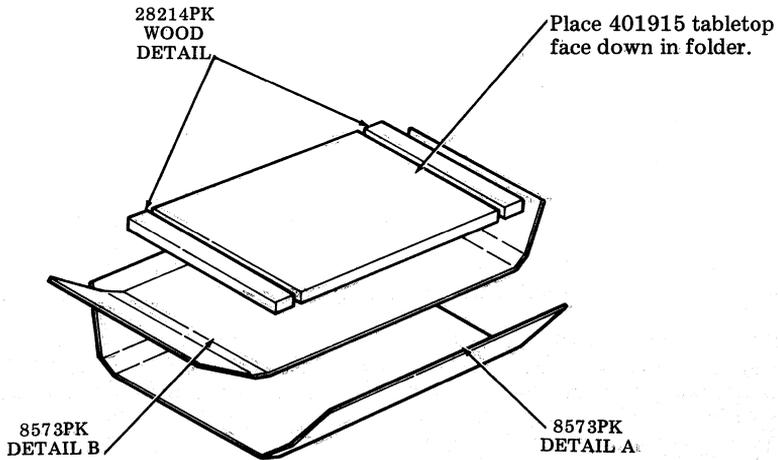


Fig. 33

Packing Procedure for 40CAB901 Pedestal Without Tabletop

- Step 1. Open door in bottom of table (when equipped). Secure line cord (if equipped) to line cord holding brackets with 50136PK twist ties.
- Step 2. Close door. Close latches located at either end at top of door.
- Step 3. Secure bag of parts in recess at upper right front corner of cabinet with a strip of 21632PK tape. Cover cabinet with a 23461PK plastic bag.
- Step 4. Place a 70133PK Detail B end cap on floor.
- Step 5. Position cabinet on top of bottom end cap.
- Step 6. Lift left side of cabinet and place a 28253PK Detail A onto the left foot. Set cabinet with detail back down on end cap.
- Step 7. Lift right side of cabinet and place a 28253PK Detail B onto right foot as indicated in Step 6.
- Step 8. Place a 28253PK Detail C on left top corner of the cabinet. See Fig. 34.
- Step 9. Place a 28253PK Detail C on right top corner of the cabinet. See Fig. 34.
- Step 10. Form one 70133PK Detail A and with bottom flanges down and outward, place over top of cabinet and details and slide to bottom.
- Step 11. Interlock flanges of bottom end cap with corrugated carton flanges. Apply a band of 21207PK strapping around the center of flanges of end cap. Seal strapping with one 21431PK clip seal. The tension of strapping should be sufficiently tight to bite into corners so that strapping will not shift.
- Step 12. Close top flaps of carton and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the sides of the carton.

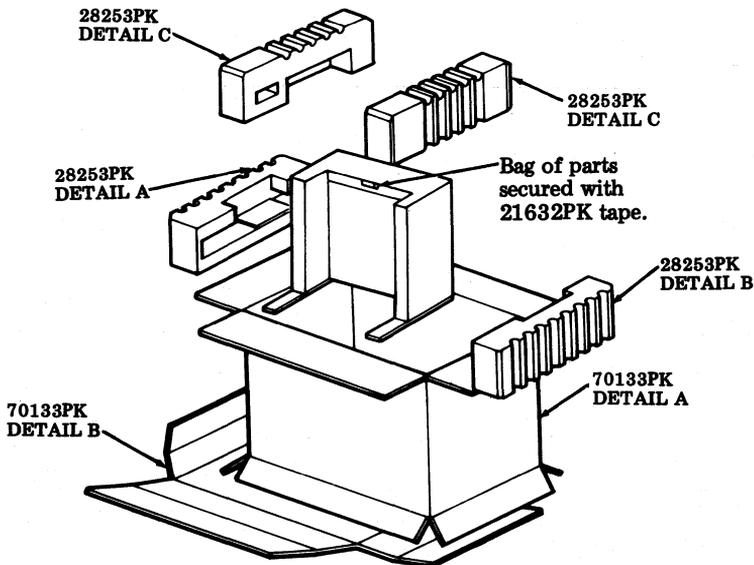


Fig. 34

Packing Procedure for 40CAB901 Pedestal Without Table Top and Feet

- Step 1. Open door in bottom of table (when equipped). Secure line cord (if equipped) to line cord holding brackets with 50136PK twist ties.
- Step 2. Close door. Close latches located at either end at top of door.
- Step 3. Secure muslin bag of parts to top of cabinet with two strips of 21632PK tape. Cover cabinet with a 23461PK plastic bag.
- Step 4. Form a 11946PK carton. With bottom flaps down and outward, place carton around cabinet.
- Step 5. Place a 27442PK plastic corner on each of the four corners of the cabinet top. See Fig. 35.
- Step 6. Close and seal top flaps of carton. Seal the center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the ends of the carton. Invert carton.
- Step 7. Place a 27442PK plastic corner on each of the four corners of the cabinet bottom.
- Step 8. Close and seal the bottom flaps of the carton as outlined in Step 6. Invert carton.

*Note:* 23461PK plastic bag deleted for clarity.

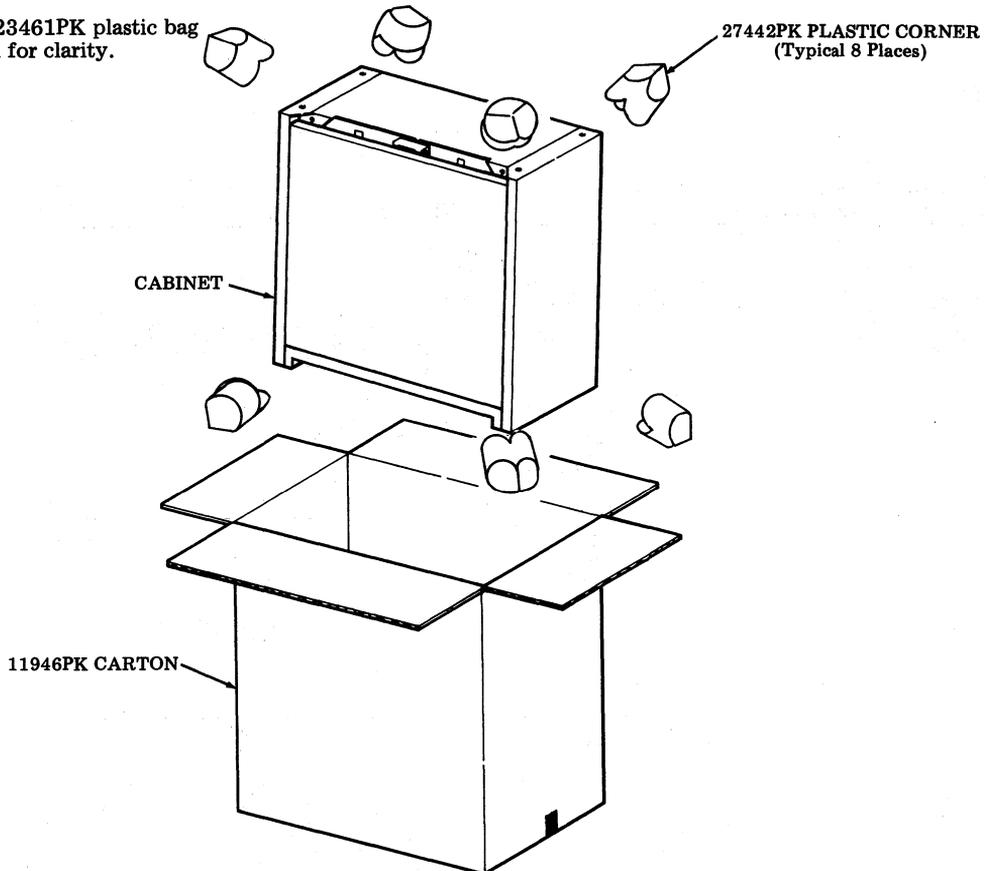


Fig. 35

40CAB902 CABINET

Packing Procedure for 40CAB902 Cabinet

- Step 1. Open door in bottom of table (when equipped). Secure line cord (if equipped) to the line cord holding brackets with 50136PK twist ties. Close door. Close latch located at either end at top of door.
- Step 2. Cover cabinet with a 23461PK plastic bag (not shown).
- Step 3. Place one 70144PK Detail B end cap on floor.
- Step 4. Position cabinet on top of bottom end cap.
- Step 5. Lift left side of cabinet and place a 28253PK Detail A onto the left foot. Set cabinet with detail back down on end cap.
- Step 6. Lift right side of cabinet and place a 28253PK Detail B onto the right foot as indicated in Step 5.
- Step 7. Place a 28253PK detail on left and right top corner of the cabinet. See Fig. 36.
- Step 8. Form a 70144PK carton Detail A and with bottom flanges down and outward, place carton over top of cabinet and details and slide to bottom.
- Step 9. Interlock flanges of bottom end cap with corrugated carton flanges. Standard procedure is to apply a band of 21207PK strapping around center of flanges of end cap. For standard removal, use nylon reinforced tape.
- Step 10. Close top flaps of carton and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the sides of the carton.

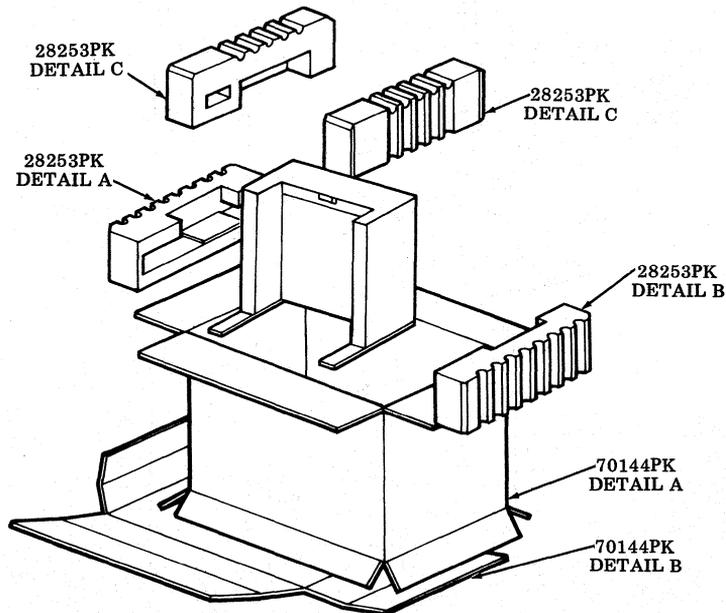


Fig. 36

## 40CAB904 CABINET

Packing Procedure for 40CAB904 Cabinet

- Step 1. Open door in bottom of pedestal (when equipped). Secure line cord (if equipped) to line cord holding brackets with 50136PK twist ties.
- Step 2. Close door. Close latches located at either end of top of door.
- Step 3. Secure bag of parts in recess at upper right front corner of cabinet with a strip of 21632PK tape (see Fig. 37). Cover cabinet with a 23461PK plastic bag.
- Step 4. Form a 28223PK detail. Tape folds of detail together with two strips of 21719PK tape. Secure to cabinet legs with a strip of 21632PK tape. See Fig. 37.
- Step 5. Position a 28185PK Detail A on left leg and a 28185PK Detail B on right leg of pedestal. See Fig. 37.
- Step 6. Form details against sides and back of pedestal and secure in place with a strip of 21632PK tape. See Fig. 37.
- Step 7. Form a 12005PK carton, and with bottom flaps down and outward, place around cabinet and details.
- Step 8. Form a 28185PK Detail B and place it on left top corner of the cabinet. See Fig. 37.
- Step 9. Form a 28185PK Detail A and place it on right top corner of the cabinet. See Fig. 37.
- Step 10. Close top flaps of carton and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the sides of the carton. Carefully invert carton.
- Step 11. Close bottom flaps of carton and seal as outlined in Step 10. Carefully invert carton.

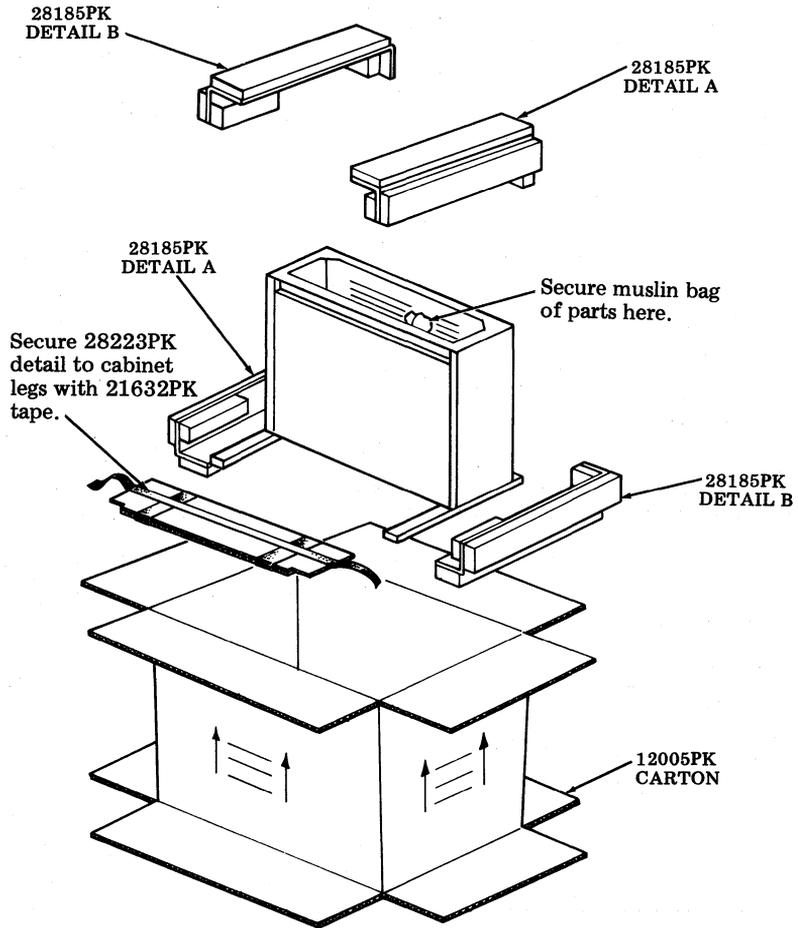


Fig. 37

## 40CAB302 CABINET

Packing Procedure for 40CAB302 Cabinet

- Step 1. Place skidded bottom end cap Detail A of 16937PK details on floor. See Fig. 38.
- Step 2. Place and center the bottom cushion cap Detail B of 16937PK details on top of A. See Fig. 38.
- Step 3. Place the cabinet on Detail B with the rear edge of the legs in line with the rear edge of the built up pads.
- Step 4. Place a 23461PK plastic bag over top of cabinet. Cover bottom of cabinet with sheets of 21298PK tissue and tape to cabinet with 21480PK tape.
- Step 5. Coil cable at bottom of cabinet and tape to cabinet with 21632PK tape.
- Step 6. Fold the flaps of the bottom cushion cap Detail B against the plastic enclosed cabinet. Tape the flaps against the cabinet with a complete band of 21632PK tape. Make sure cable is not pinched between flap and cabinet.
- Step 7. Form a 16937PK carton Detail D and with bottom flanges down and outward, place over top of cabinet and detail and slide to bottom. See Fig. 38.
- Step 8. Form and place one top cushion cap Detail C of 16937PK within carton on top of cabinet. The portion of the detail without a corrugated block must be placed to the front of the cabinet. See Fig. 38.
- Step 9. Interlock flanges of bottom end cap with corrugated carton flanges. Standard procedure is to apply a band of 21207PK strapping around center of flanges of end cap. For standard removal, use nylon reinforced tape.
- Step 10. Close top flaps of carton and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down the sides of the carton.

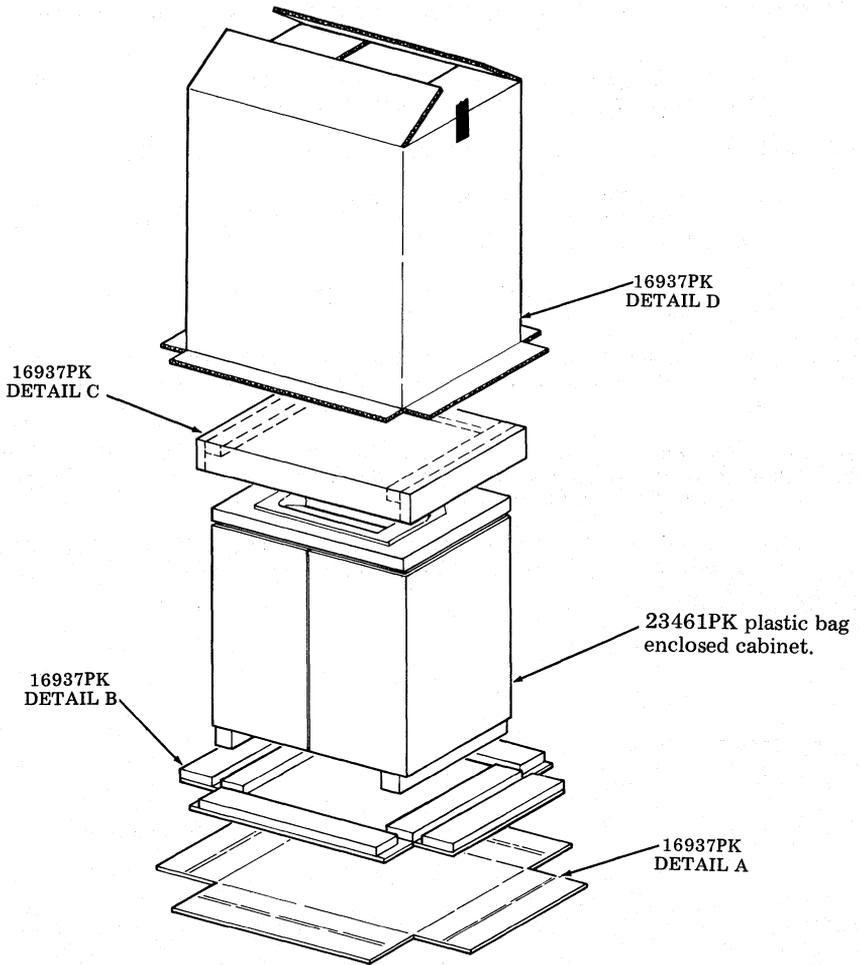


Fig. 38

## 40AB101 ANSWER-BACK

Packing Procedure for 40AB101 Answer-Back

- Step 1. Remove answer-back from station.
- Step 2. Form a 28203PK corrugated detail and position against answer-back as illustrated in Fig. 39. The tabs on the ends of the detail must be positioned in the slots on either end of the answer-back.
- Step 3. Place answer-back with detail in a 23465PK plastic bag (not shown in illustration).
- Step 4. Form a 9022PK carton. Close bottom flaps and seal with a strip of 21719PK tape applied to the center seam. The tape should extend approximately three inches down the ends of the carton.
- Step 5. Center prepacked answer-back unit in carton as shown.
- Step 6. Form a 28204PK detail and place in carton on top and sides of unit as illustrated.
- Step 7. Coil the cable in the void formed by the 28204PK detail. Fill void space with 21298PK tissue paper (not shown in illustration).
- Step 8. Close and seal top flaps of carton as outlined in Step 4.

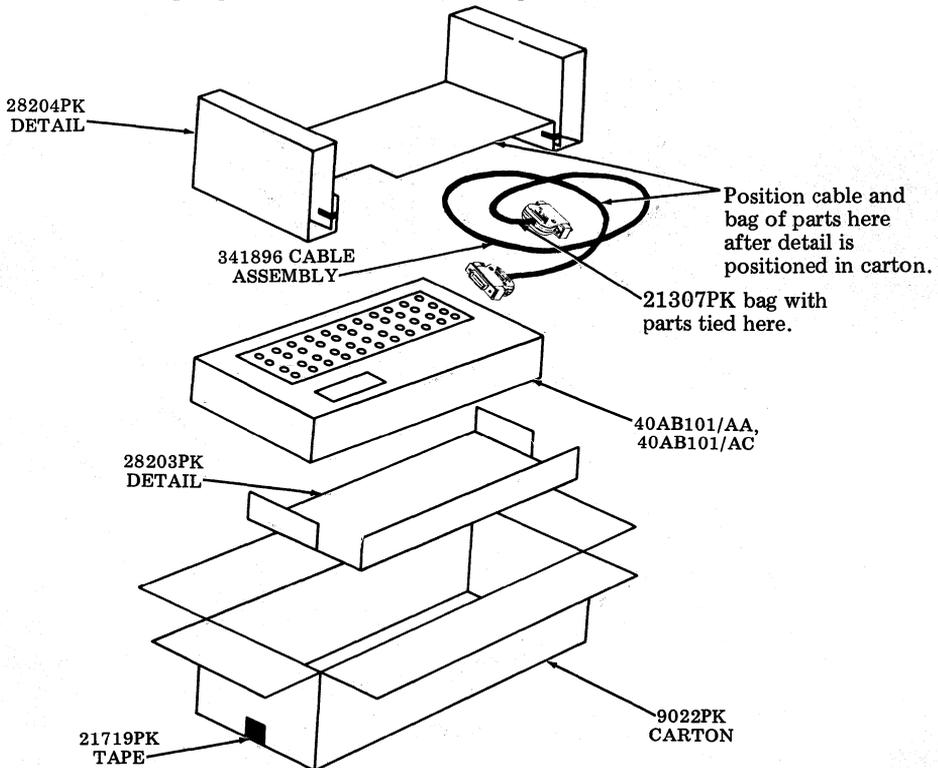


Fig. 39

40BSE101 CIRCULAR BASE

Packing Instructions for 40BSE101 Circular Base

- Step 1. Form shipping container 8956PK. Close and seal bottom flaps with glue or 2 inch minimum width sealing tape.
- Step 2. Place unit in a 23457PK plastic bag.
- Step 3. Form 28206PK detail around unit as illustrated in Fig. 40.
- Step 4. Place unit and detail in carton. See Fig. 40.
- Step 5. Close and seal top flaps of container as outlined in Step 1.

*Note: 23457PK plastic bag deleted for clarity.*

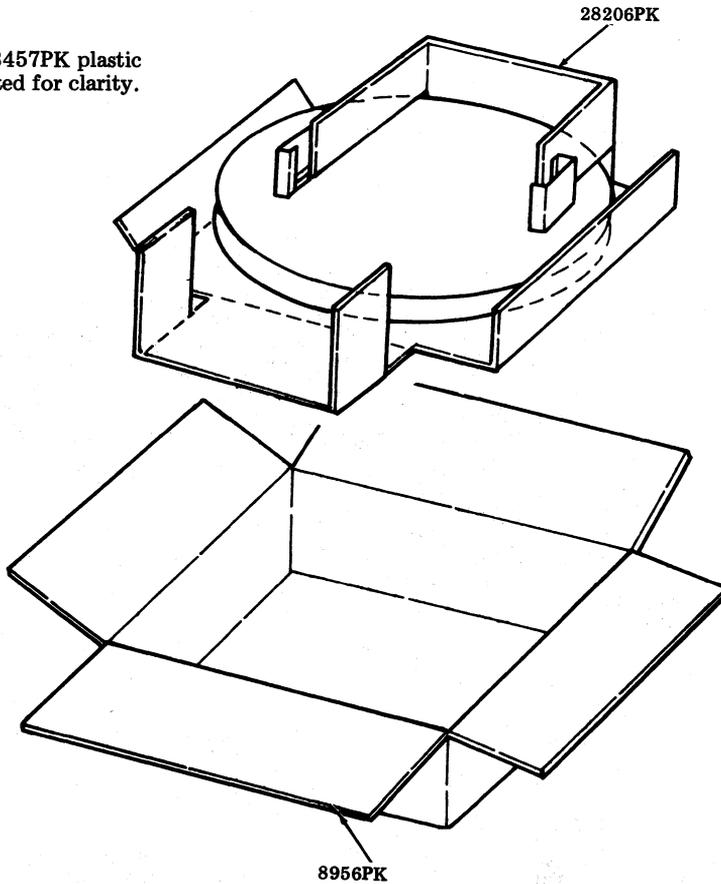


Fig. 40

**40BSE201 OPERATOR CONSOLE BASE****Packing Instructions for 40BSE201 Operator Console Base**

- Step 1. Form 9022PK shipping container. Close and seal bottom flaps with glue or 2 inch minimum width sealing tape.
- Step 2. Place unit in a 23456PK plastic bag (not shown).
- Step 3. Form detail 28208PK around unit as illustrated in Fig. 41.
- Step 4. Place unit and detail in carton. See Fig. 41.
- Step 5. Close and seal top flaps of container as outlined in Step 1.

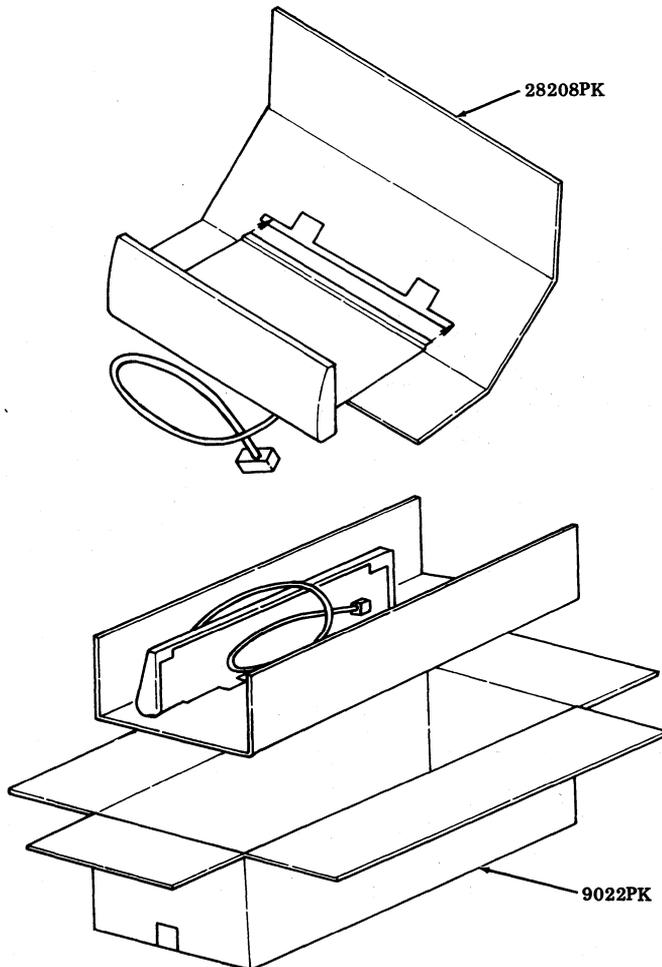


Fig. 41

40BSE202 OPERATOR CONSOLE BASE

Packing Instructions For 40BSE202 Operator Console Base

- Step 1. Form a 28329PK detail. Slide unit base in slot in detail as illustrated in Fig. 42. Secure base of unit to bottom of detail with two strips of 21632PK tape. Buff tape firmly.
- Step 2. Form a 9255PK carton. Close and seal bottom flaps with a strip of 21719PK tape. The tape should extend approximately three inches down the ends of the cartons.
- Step 3. Position unit and detail in carton. Nest cable in 21298PK tissue. Fill all void space with tissue.
- Step 4. Fold detail over to form tray at top. Wrap cover assembly in 21298PK tissue and place in tray. Fill void space with tissue.
- Step 5. Close and seal top flaps of carton as outlined in Step 3.

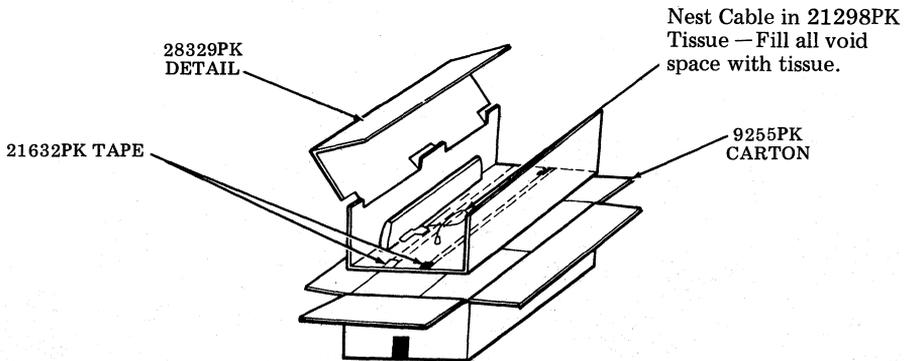


Fig. 42

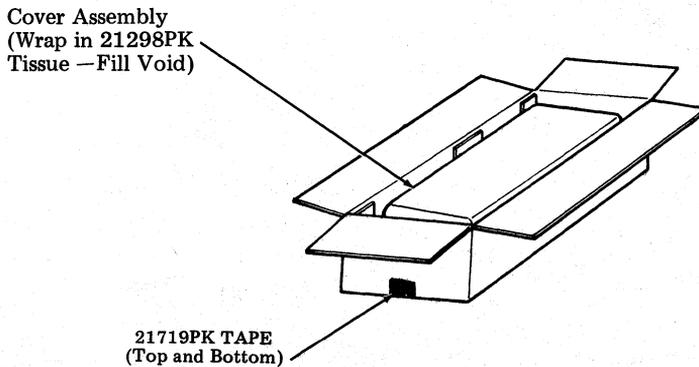


Fig. 43

## 40/9140 STATION CONTROLLER

Packing Procedure for 9140 Station Controller

- Step 1. Remove 9140 station controller from unit.
- Step 2. Place loose parts in a RM652472 cloth bag. Tie securely.
- Step 3. Position the unit on a 27708PK plywood pallet. Secure unit to pallet with four 28055PK wood screws. (See illustration.)
- Step 4. Coil cable. Place bag of parts in center of coil and secure to end of unit with 21632PK tape.
- Step 5. Form a 9785PK shipping container. Close and seal bottom flaps with glue or sealing tape.
- Step 6. Place a polystyrene 21690PK corner on each of the four corners of the shipping container.
- Step 7. Place a palletized unit in container between the plastic details.
- Step 8. Position a 27711PK liner over the palletized unit.
- Step 9. Form and position a corrugated 28161PK detail in container as illustrated in Fig. 44.
- Step 10. Close and seal top flaps of shipping container as outlined in Step 5.

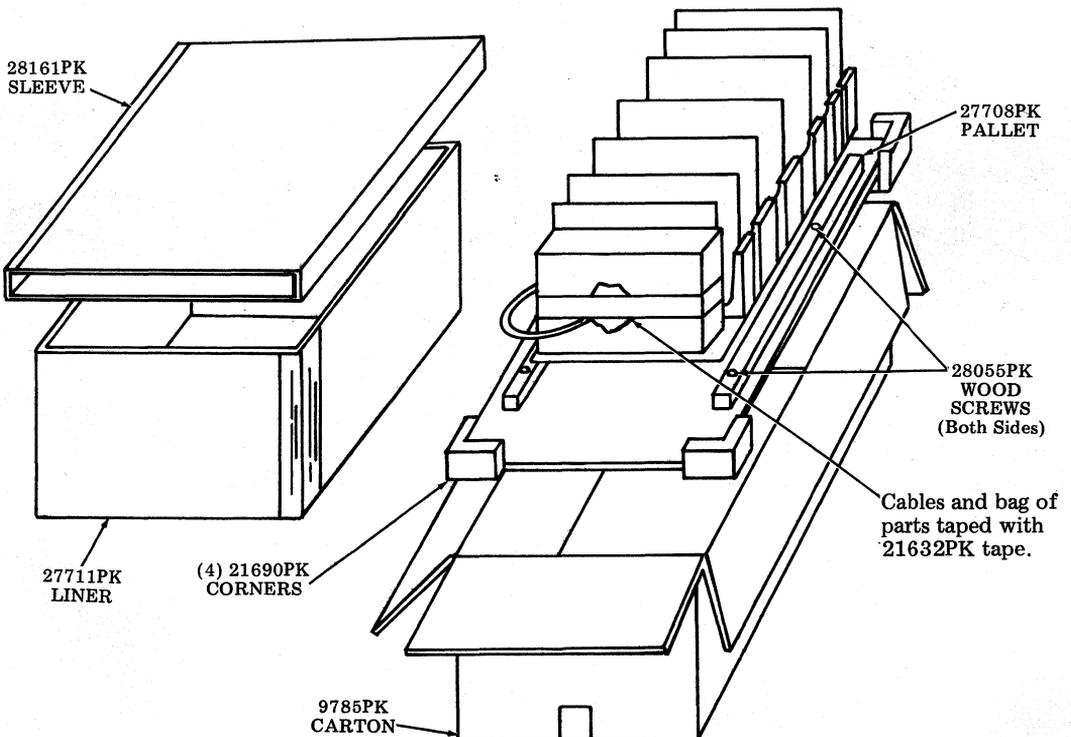


Fig. 44

Packing Procedure for 345605 Mounting Frame

- Step 1. Form 9292PK shipping container. Close and seal bottom flaps with glue or sealing tape.
- Step 2. Insert a 28158PK detail inside the 9292PK shipping container.
- Step 3. Position the mounting frame in the 9292PK shipping container.
- Step 4. Form a 28159PK detail and place it over the raised portion of the mounting frame.
- Step 5. Form a 28160PK detail and place it in the void area as shown in Fig. 45.
- Step 6. Close top flaps of carton and seal center seam with glue or sealing tape.

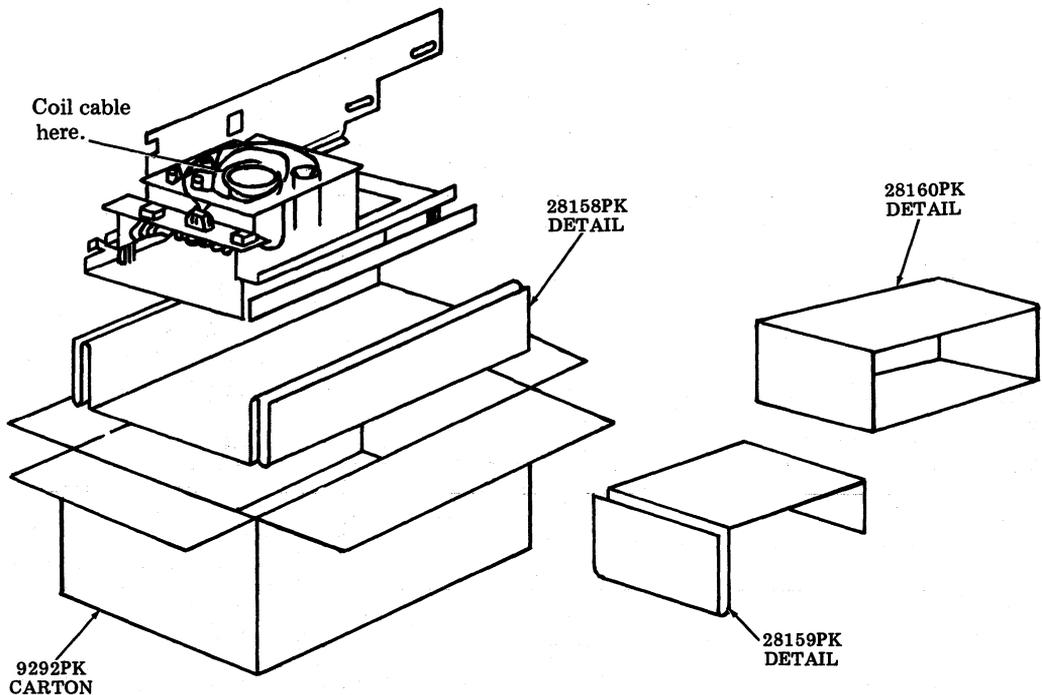


Fig. 45

## EIA SWITCH

Packing Procedure for EIA Switch

- Step 1. Immobilize the three switches in the following manner: With the switches in their unoperated position, apply a piece of 21480PK tape approximately six inches long to the front bottom half of the buttons and tape to the cover.
- Step 2. Apply a piece of 21480PK tape approximately six inches long to the front upper half of the buttons and tape to the cover.
- Step 3. Wrap the switch assembly in triple thickness of 21298PK tissue paper.
- Step 4. Coil the 341986 cable assembly and wrap it in a double thickness of 21298PK tissue paper.
- Step 5. Tape the cable assembly to the top of the switch assembly with two wraps of 21480PK tape.
- Step 6. Wrap the switch and cable package in a four or five layer continuous length of 27951PK air cap packing. The switch front and rear surfaces should be equidistant from the 27951PK air cap front and rear edges, respectively.
- Step 7. Form 9030PK carton. Close bottom flaps and seal center seam with 21719PK tape. Extend tape three inches down carton sides.
- Step 8. Fold in open ends of the wrapped package of Step 6 so as to protect the switch front and rear surfaces. Insert wrapped package into 9030PK carton. The package should fit snugly in the carton. If loose, remove package and add additional wrap of 27951PK air cap packing.
- Step 9. Close top flaps of 9030PK carton and seal center seam with 21719PK tape as indicated in Step 7.

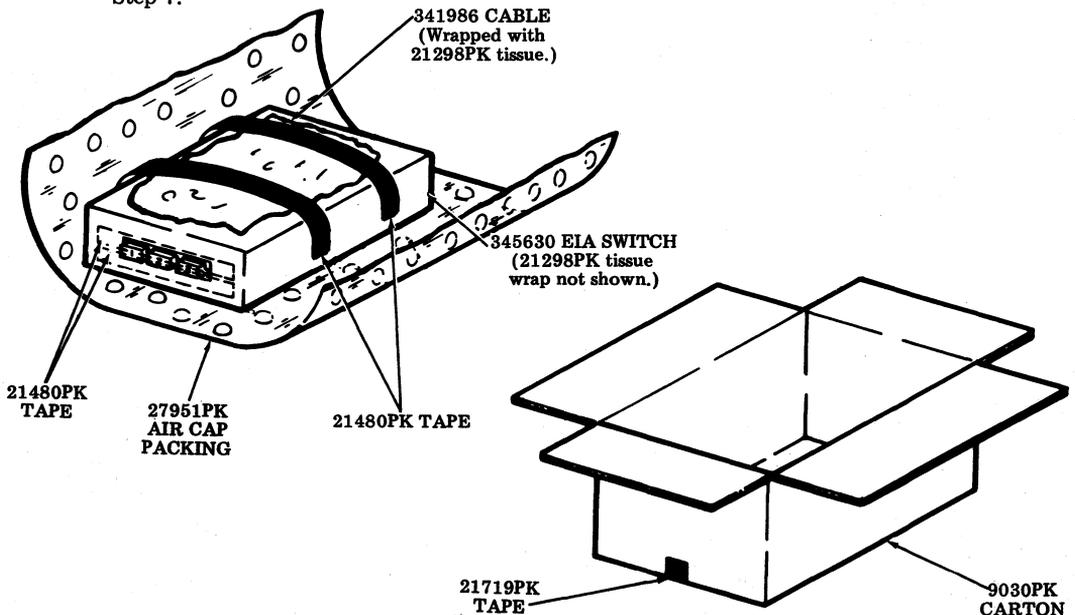


Fig. 46

**KEYBOARD DISPLAY AMPLIFIER (KDA)**

Packing Procedure for KDA

- Step 1. Place unit in a 23465PK plastic bag (not shown in illustration).
- Step 2. Form a 8889PK carton. Close and seal bottom flaps of carton with a strip of 21719PK tape.
- Step 3. Form a 28258PK detail and place in carton as shown in Fig. 47.
- Step 4. Place unit in carton between folds in detail.
- Step 5. Form a 28257PK detail and place in carton over and against sides of unit.
- Step 6. Close and seal top flaps of carton as outlined in Step 2.
- Step 7. Form a 9064PK carton as shown in Fig. 48. Close and seal bottom flaps as outlined in Step 2.
- Step 8. Place a 28153PK plastic corner in each of the four corners of the carton.
- Step 9. Place prepacked unit inside the plastic corners.
- Step 10. Place a 28153PK plastic corner on each of the four corners of the carton.
- Step 11. Close and seal top flaps of carton.

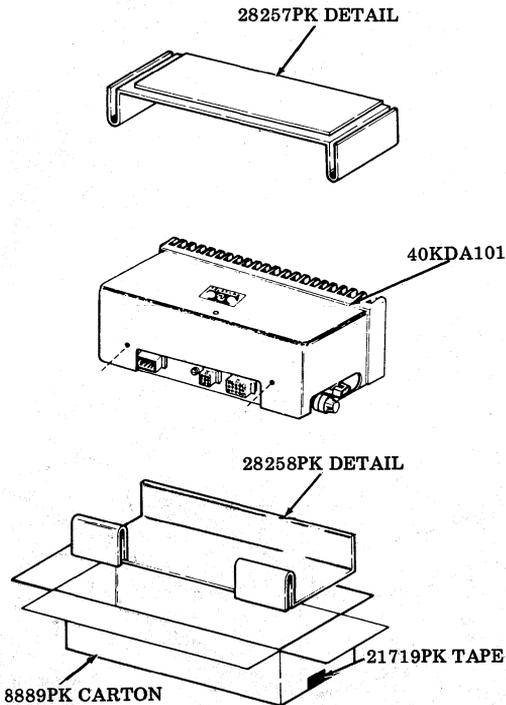


Fig. 47

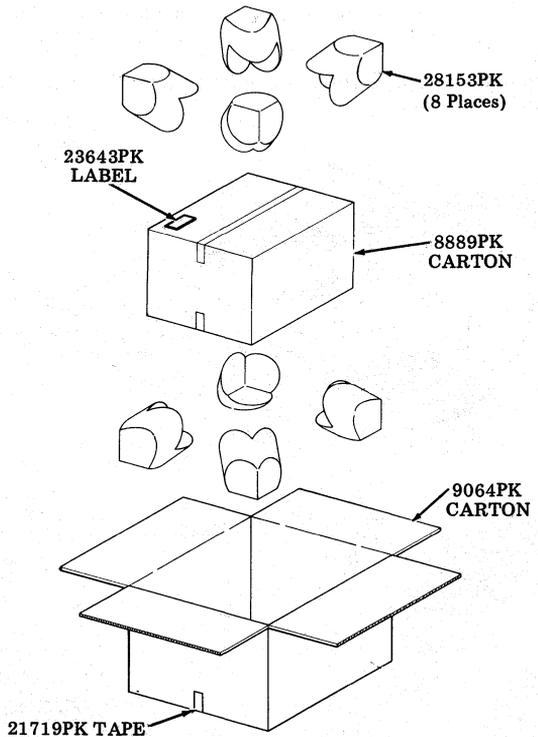


Fig. 48

**40K00X OPERATOR CONSOLE****Packing Procedure for ROP Opcon**

- Step 1. Form an 8762PK carton. Close and seal bottom flaps with a strip of 21719PK tape applied to the center seam and extending three inches down the ends of the carton.
- Step 2. Place one 28327PK corrugated pad on top of the keytops. Tape securely to keyboard with two pieces of 21632PK tape (one piece across the length and one piece across the width of the pad). (See Fig. 39.)
- Step 3. Cut a seventy six inch long piece of 27952PK air cap and place on bench.
- Step 4. Place unit with open end down lengthwise on center of air cap approximately six inches from the end.
- Step 5. Wrap the unit lengthwise and tape end of air cap with a strip of 21480PK tape.
- Step 6. With manufacturers joint on the carton to the right side, place the unit into the carton with the keytops to the side of the carton. (See Fig. 49).
- Step 7. Close and seal top flaps of carton as indicated in Step 1.

*Note:* 27952PK air cap deleted for clarity.

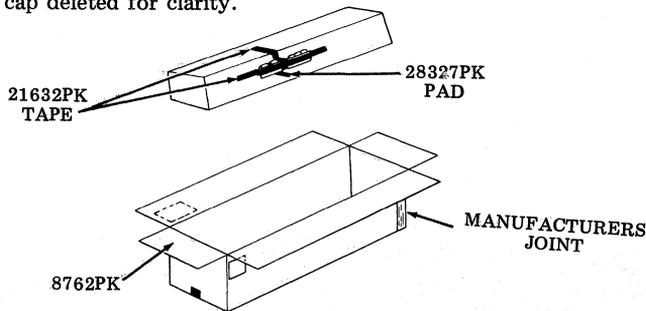


Fig. 49

**40K100 OPERATOR CONSOLE****Packing Procedure for Opcon**

- Step 1. Place spare keytops in a 21307PK muslin bag and set aside.
- Step 2. Place a 28164PK Detail A base on work bench. Place muslin bag containing keytops in cavity provided.
- Step 3. Remove KD opcon cover; if late design, 2816PK packing details are used.
- Step 4. Place unit in a 23456PK plastic bag. Close open end of bag and secure with a strip of 21480PK tape.
- Step 5. Place a 28164PK Detail B cover over keyboard and place KD opcon cover in cavity provided in late design 28164PK Detail B.
- Step 6. Secure 28164PK Detail A base to Detail B cover with a band of 21632PK tape applied around each end of plastic details.
- Step 7. Form a 9526PK carton. Close bottom flaps and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down ends of carton. (See Figs. 50 and 51.)
- Step 8. Place prepacked unit in carton. Close top flaps of carton and seal as outlined in Step 7.

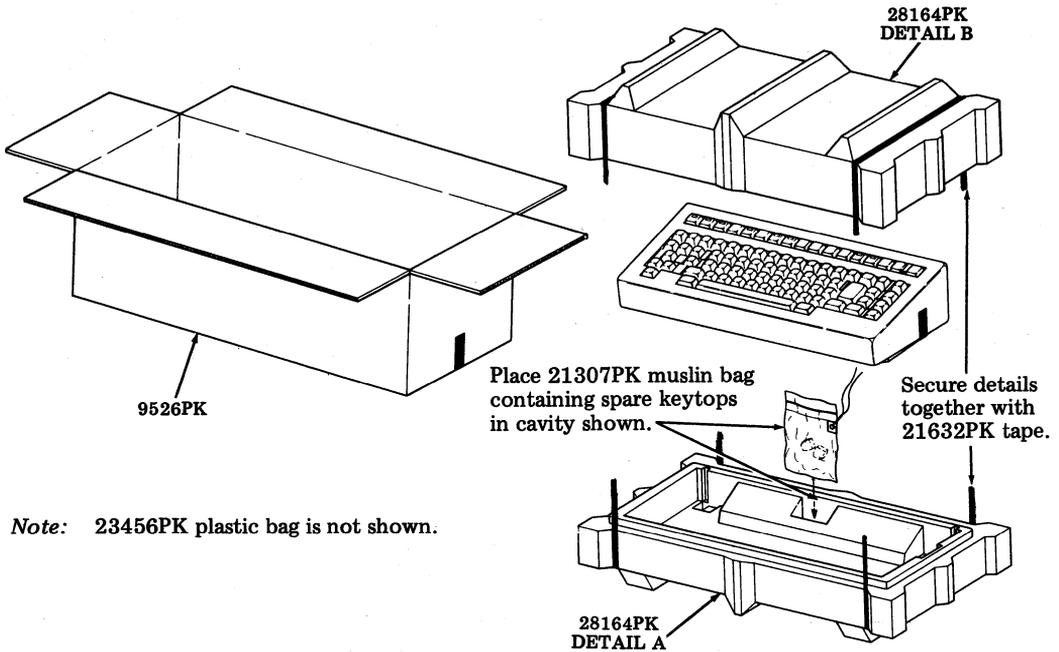


Fig. 50—Early Design Packing Detail

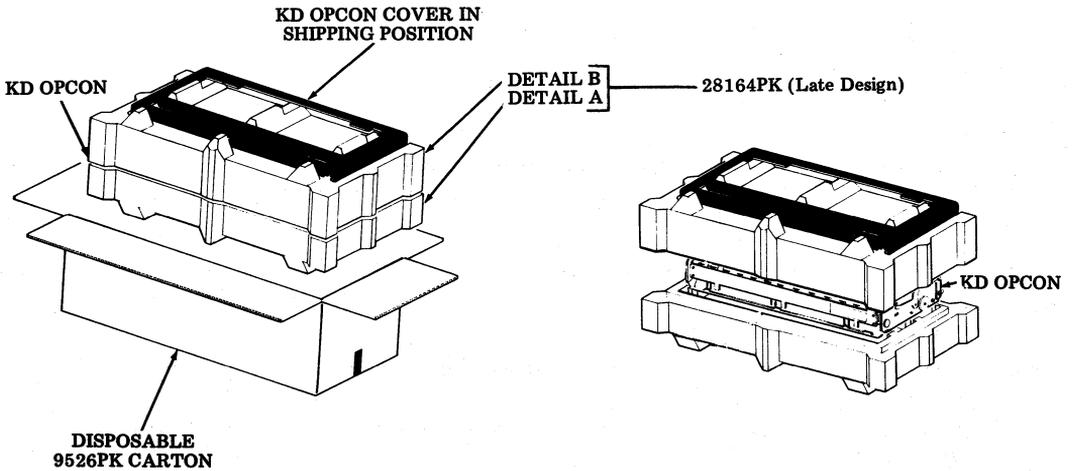


Fig. 51—Late Design Packing Detail

## 40K200 OPERATOR CONSOLE

Packing Procedure for Opcon

- Step 1. Place spare keytops in a 21307PK muslin bag and secure in cavity of 28335PK Detail B, as shown in Fig. 52.
- Step 2. Place a 28335PK Detail A base on work bench.
- Step 3. Remove opcon cover and secure in top cavity of 28335 Detail B.
- Step 4. Place unit in a 23457PK plastic bag. Plastic bag is deleted from illustration for clarity. Close open end of bag and secure with a strip of 21480PK tape.
- Step 5. Place a 28335PK Detail B cover over opcon as shown in Fig. 52.
- Step 6. Secure 28335PK Detail A base to Detail B cover with a band of 21632PK tape applied around each end of plastic details.
- Step 7. Form a 9403PK carton. Close bottom flaps and seal center seam with a strip of 21719PK tape. The tape should extend approximately three inches down ends of carton.
- Step 8. Place prepacked unit in carton. Close top flaps of carton and seal as outlined in Step 7.

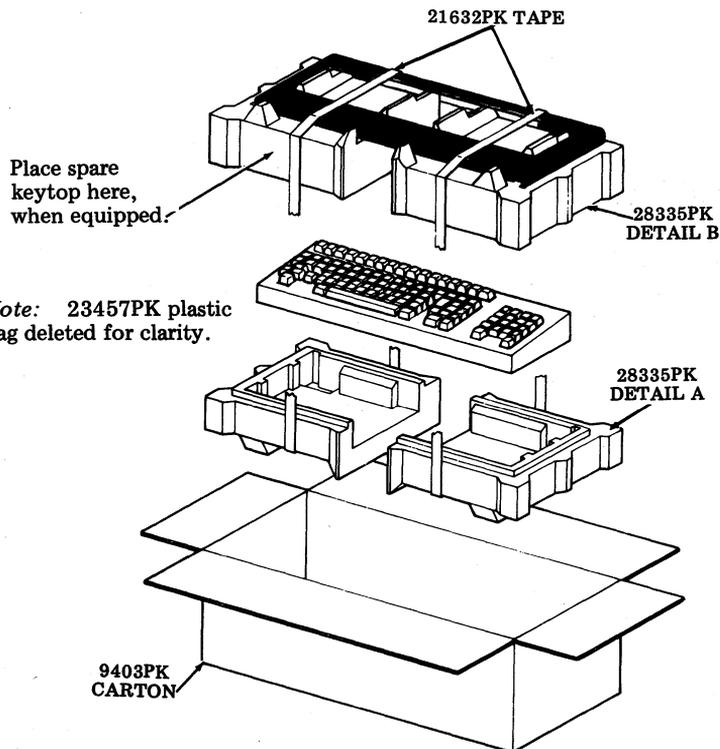


Fig. 52

## 40PSU101 POWER SUPPLY

Packing Procedure for 40PSU101 Power Supply

- Step 1. Form a 28210PK corrugated detail. Position detail in end of unit as illustrated in Fig. 43. The edge on short end of detail must butt against transformer, and the edge on long end of detail must butt against the inside of power supply cover. Secure detail in place with two strips of 21632PK tape as shown in Fig. 53.
- Step 2. Form a 9229PK carton. Close and seal bottom flaps with a strip of 21719PK tape. The tape should extend approximately three inches down ends of carton.
- Step 3. Form a 28211PK Detail A and place in carton as illustrated in Fig. 53. Center detail in carton.
- Step 4. Position a 28211PK Detail B in either end of carton as illustrated in Fig. 53.
- Step 5. Place unit in a 23456PK plastic bag. Position unit in carton as illustrated in Fig. 53.
- Step 6. Fold the 28211PK Detail A flap over top of unit. Close and seal top flaps of carton as outlined in Step 2.

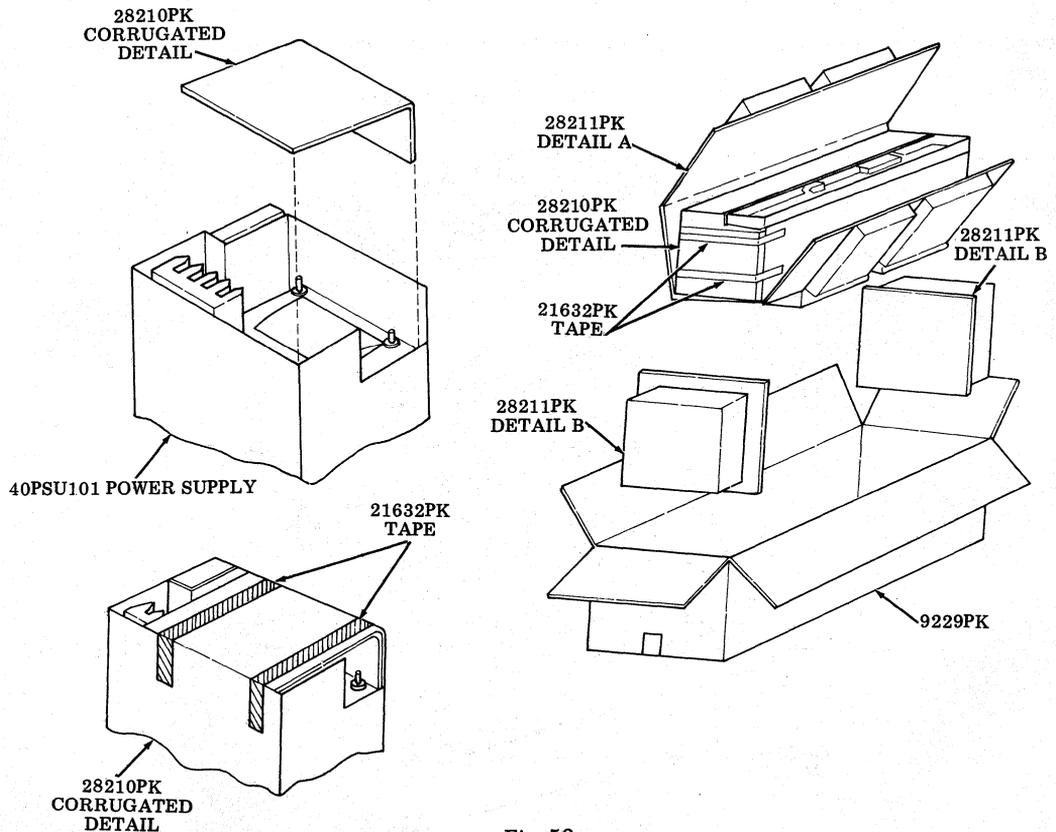


Fig. 53

## 40PSU102 POWER SUPPLY

Packing Procedure for 40PSU102 Power Supply

- Step 1. Assemble pallet No. 28212PK to bottom of power supply with one 71692RM screw, one 72295RM flat washer, and one 2669 lockwasher, as illustrated in Fig. 54.
- Step 2. Form a 9362PK corrugated detail. Close and seal bottom flaps with a strip of 21719PK tape. The tape should extend approximately three inches down ends of carton.
- Step 3. Place palletized unit in carton. Form a 28213PK detail and place in carton as illustrated in Fig. 54.
- Step 4. Close and seal top flaps of carton as outlined in Step 2.
- Step 5. Form a 9822PK shipping container. Form bottom flaps outward and place over inner container as illustrated in Fig. 55.
- Step 6. Position a 28153PK corner detail on each of the four corners of the inner container as illustrated in Fig. 55.

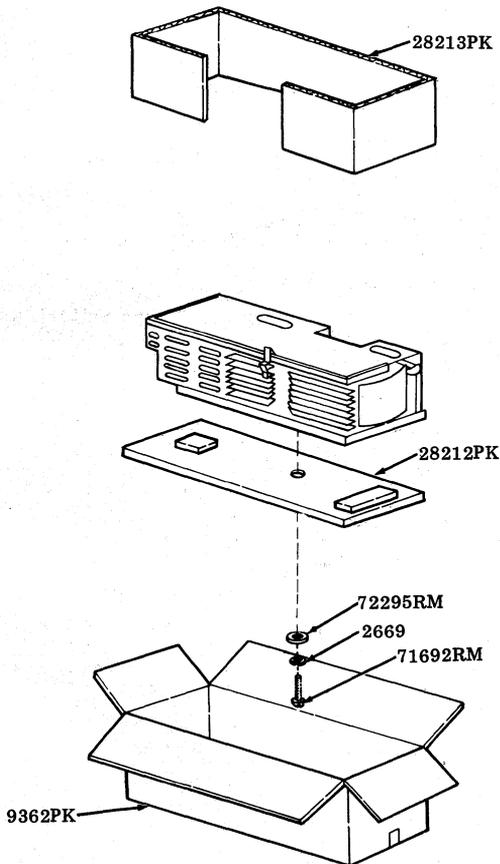


Fig. 54

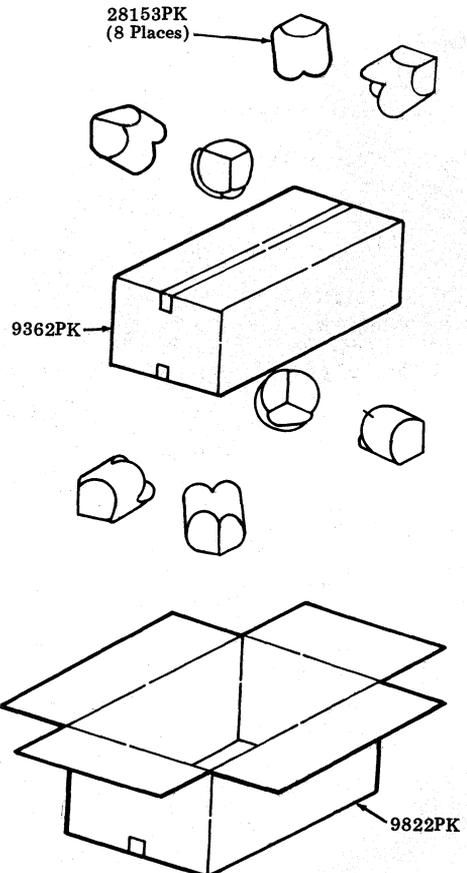


Fig. 55

40DL291 DISPLAY LOGIC

Packing Procedure for 40DL291 Display Logic

- Step 1. Form 9504PK carton. Close and seal bottom flaps with glue or 2 inch minimum width sealing tape.
- Step 2. Form detail 28141PK and position in carton as illustrated in Fig. 56.
- Step 3. Place unit in 23456PK plastic bag. Position unit in carton. Let cable extend outside of carton.
- Step 4. Form 28142PK detail and position in carton on top of unit as illustrated in Fig. 56. Position cable in void formed by detail.
- Step 5. Close top flaps of carton and seal as outlined in Step 1.
- Step 6. Form 10188PK shipping container. Form bottom flaps outward and place over inner container as illustrated in Fig. 56.
- Step 7. Position a 21690PK corner detail on each of the four corners of the inner container as illustrated in Fig. 57.
- Step 8. Close and seal top flaps as outlined in Step 1. Invert shipping container and contents.
- Step 9. Position a 21690PK corner detail on each of the four corners of the inner container as illustrated in Fig. 57.
- Step 10. Close and seal bottom flaps as outlined in Step 1. Invert shipping container and contents.

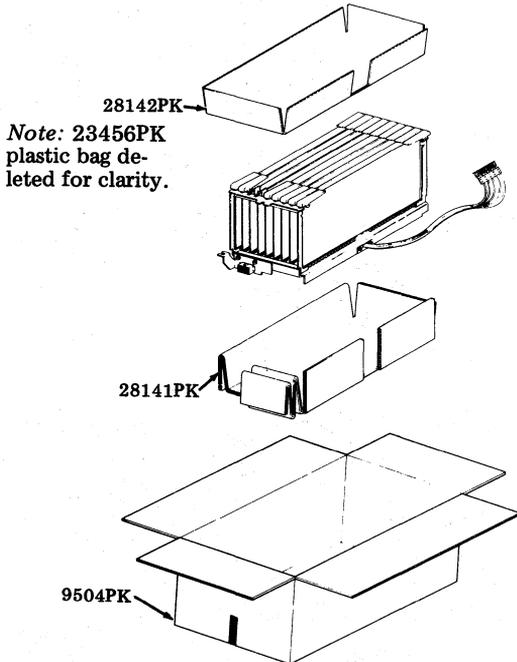


Fig. 56

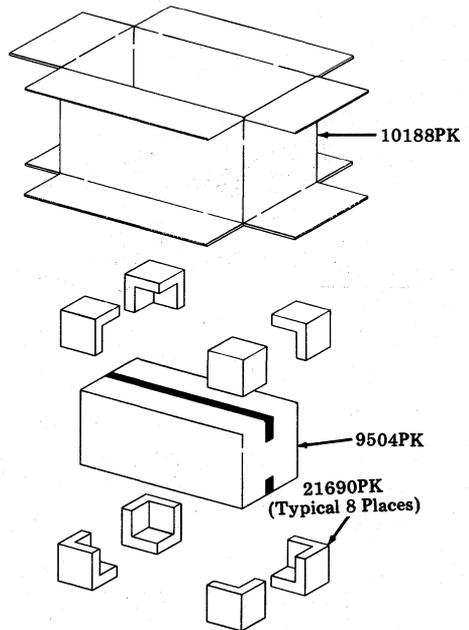


Fig. 57

## 40C101, 40C102, 40C201, 40C202, AND 40C204 CONTROLLERS

Packing Procedure for Controllers

- Step 1. Form a 9039PK carton. Fold bottom flaps closed and seal center seam with 21719PK tape. The tape should extend approximately three inches down the ends at the center seam.
- Step 2. Form a 28144PK detail. Position flap over top of connectors on end of controller and secure at ends with strips of 21632PK tape. See Fig. 58.

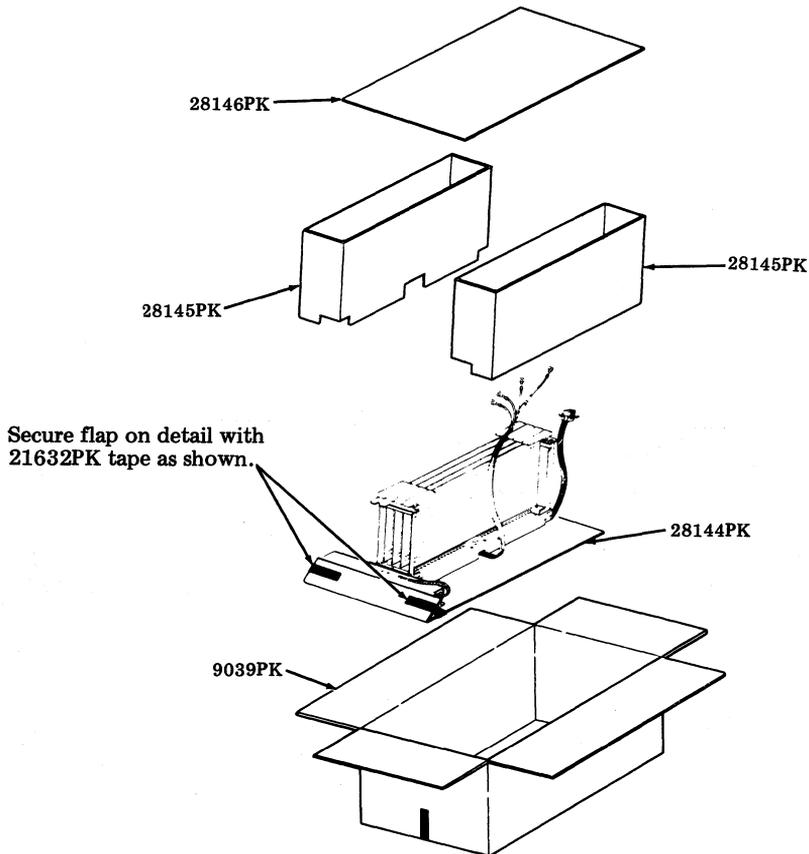


Fig. 58

- Step 3. Place unit and detail in carton.
- Step 4. Form two 28145PK details and position on either side of unit as illustrated in Fig. 58. The cable with connector must be positioned in the void formed by the 28145PK detail. See Fig. 58.
- Step 5. Place a 28146PK pad on top of the unit and details.
- Step 6. Close and seal top flaps of carton as indicated in Step 2.

Step 7. Form a 9640PK carton and with bottom of flaps outward place carton around prepacked unit. See Fig. 59.

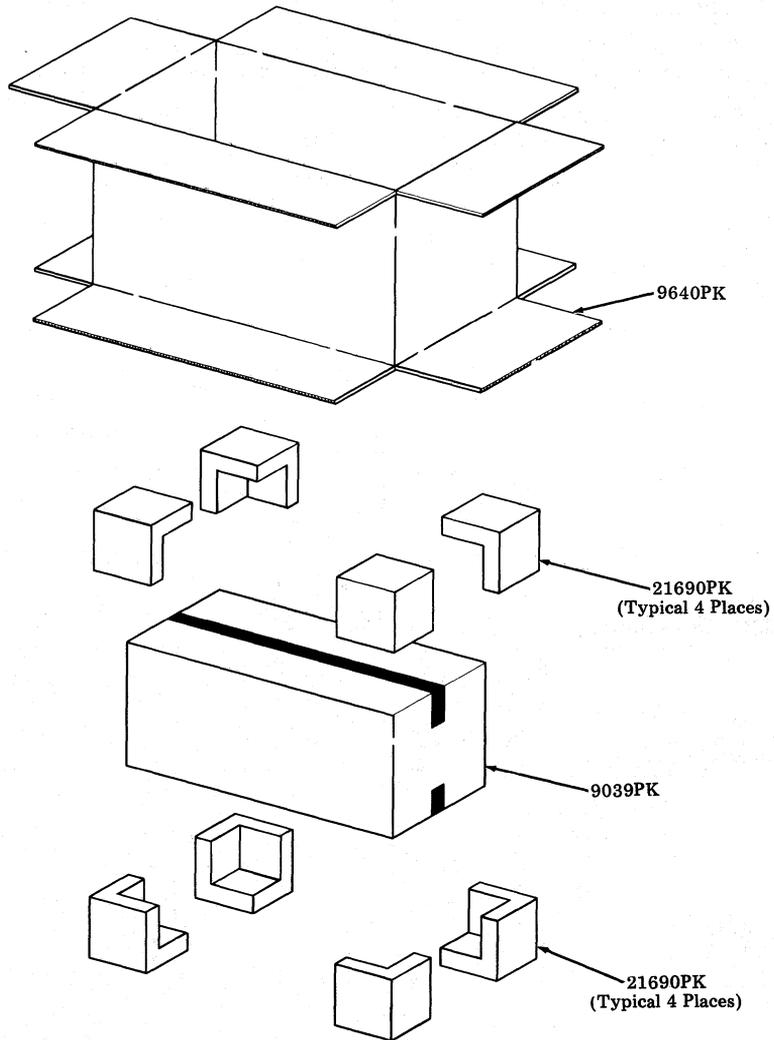


Fig. 59

Step 8. Place a 21690PK plastic corner on each of the four corners of the inner carton. See Fig. 59.

Step 9. Close and seal top flaps of carton as outlined in Step 2. Invert carton and contents.

Step 10. Place a 21690PK plastic corner on each of the four corners of the inner carton. See Fig. 59.

Step 11. Close and seal bottom flaps of carton as outlined in Step 2. Invert carton and contents.

## 40C103 CONTROLLER

Packing Procedure for Controller

- Step 1. Form a 8759PK carton. Close and seal top flaps with 21719PK tape. Apply the tape to the center seam and extend three inches down the ends of the carton.
- Step 2. Place two 28147PK details in carton as illustrated in Fig. 60.
- Step 3. Place unit in a 23465PK plastic bag.
- Step 4. Invert unit and place in carton so handles at top of unit fit in the cutout in the details. (See Fig. 60.)
- Step 5. Form a 28148PK detail and position around end of unit as illustrated in Fig. 60.
- Step 6. Form a second 28148PK detail and position around other end of unit as illustrated in Fig. 60.
- Step 7. Close and seal bottom flaps of carton as outlined in Step 1.

*Note:* 23465PK plastic bag deleted for clarity.

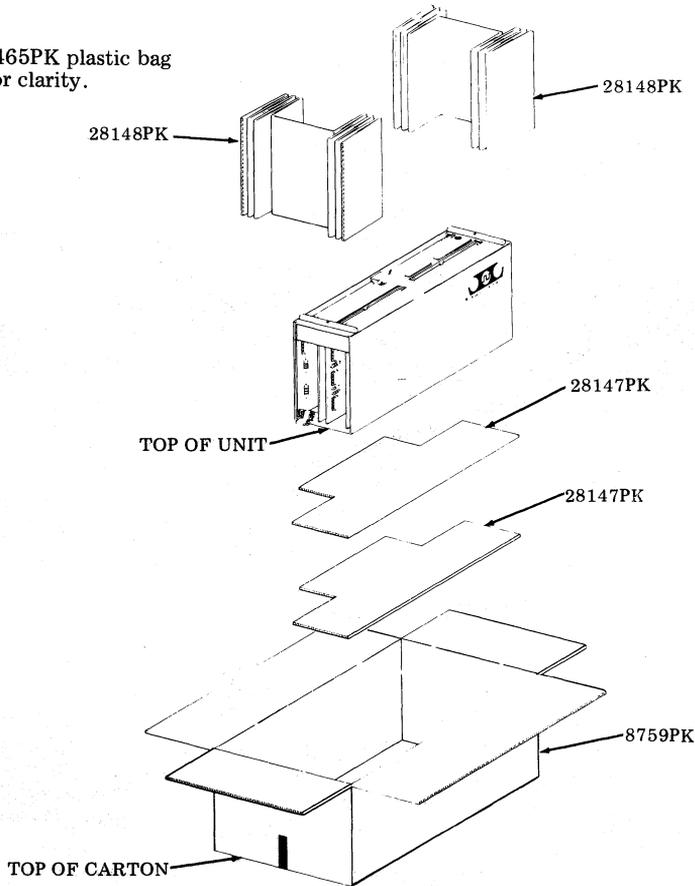


Fig. 60

- Step 8. Form a 9136PK carton. Fold top flaps outward and place around packed unit. See Fig. 61.
- Step 9. Place a 21690PK plastic detail on each of the four corners of the inner carton. See Fig. 61.
- Step 10. Close and seal bottom of flaps of carton as outlined in Step 1. Invert carton.
- Step 11. Place a 21690PK plastic detail on each of the four corners of the inner carton. See Fig. 61.
- Step 12. Close top flaps of carton and seal as outlined in Step 1.

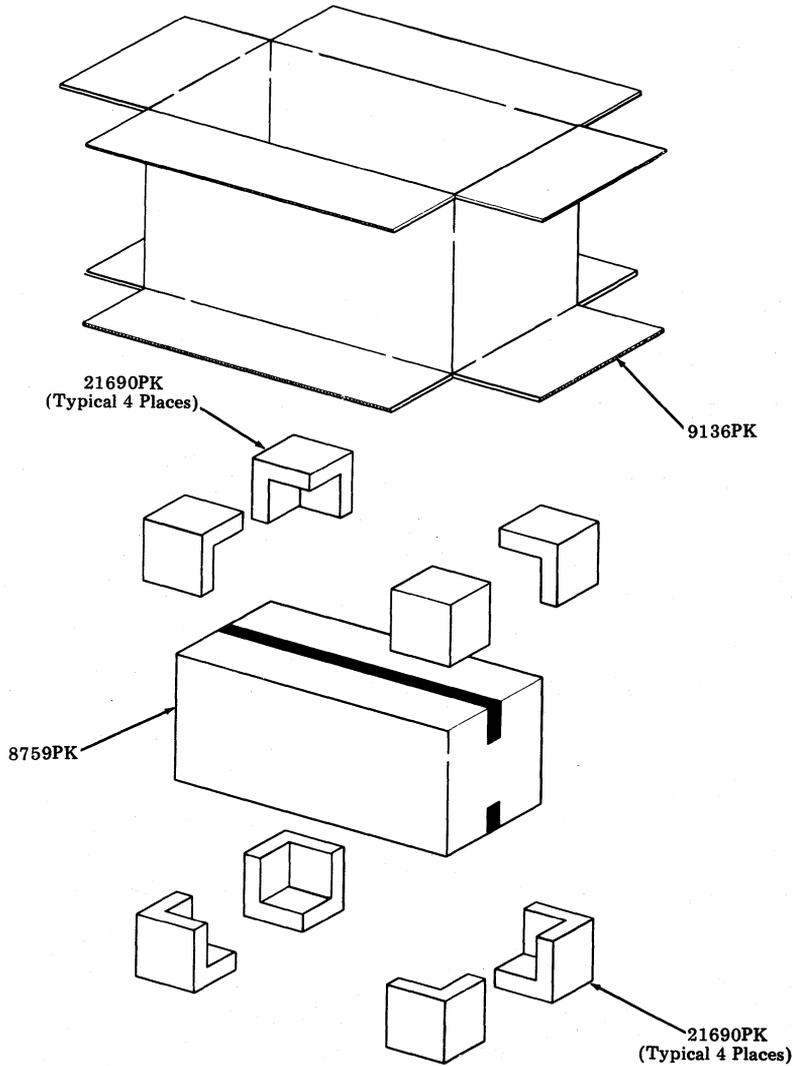


Fig. 61

## 40C400, 40C401, 40C402, AND 40C403 CONTROLLERS

Packing Procedure for Controller

- Step 1. Mount unit frame to a 28219PK plywood pallet with four 71676RM screws, four 2669 lockwashers and four 72295RM washers as illustrated in Fig. 62. The large hole in the pallet must be in line with the hole used to mount the PSU in the base.
- Step 2. Open cover of unit. Position a 28260PK pad on back surface of circuit cards. Close cover and secure in place. (See Fig. 62.)
- Step 3. Form a 9713PK carton. Close and seal bottom flaps with a strip of 21719PK tape. The tape should be applied to the center seam and extend approximately three inches down the ends of the carton.
- Step 4. Coil unit cable and secure with a 50136PK twist tie. Place palletized unit in carton. (See Fig. 62.)
- Step 5. Form a 28220PK liner and place in carton around unit. (See Fig. 62.)
- Step 6. Position cable at back of unit. Fill void space with 21298PK tissue to keep cable from shifting. (See Fig. 62.)
- Step 7. Close and seal top flaps of carton as outlined in Step 3.

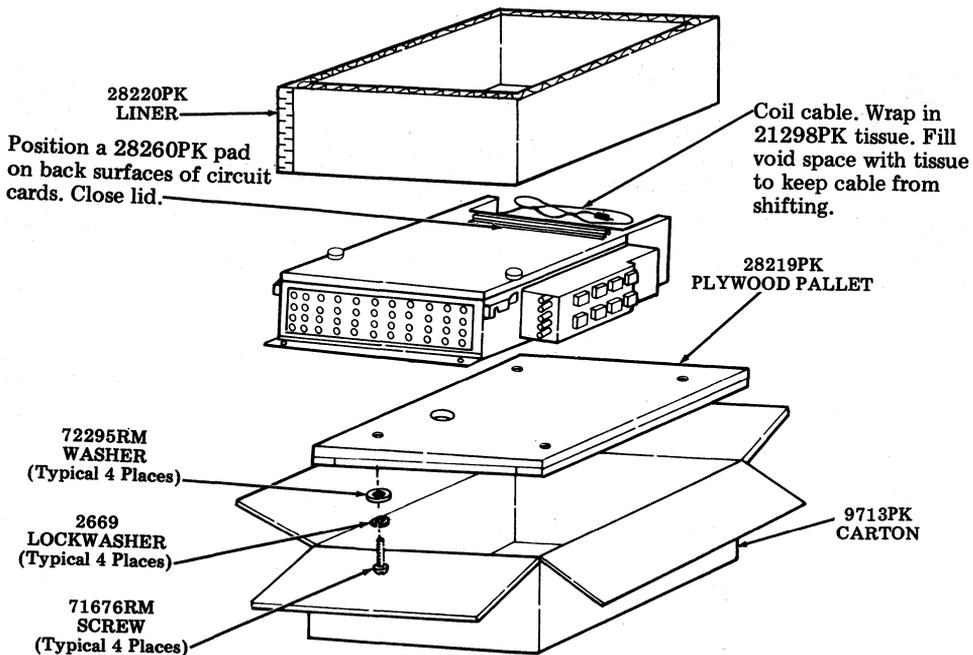


Fig. 62

- Step 8. Form a 10392PK carton. Fold bottom flaps outward and place around sealed carton. (See Fig. 63.)
- Step 9. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 10. Close top flaps and seal center seam with 21719PK tape as outlined in Step 3. Carefully invert carton and contents.
- Step 11. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 12. Close bottom flaps and seal center seam with 21719PK tape as outlined in Step 3. Carefully invert carton and contents.

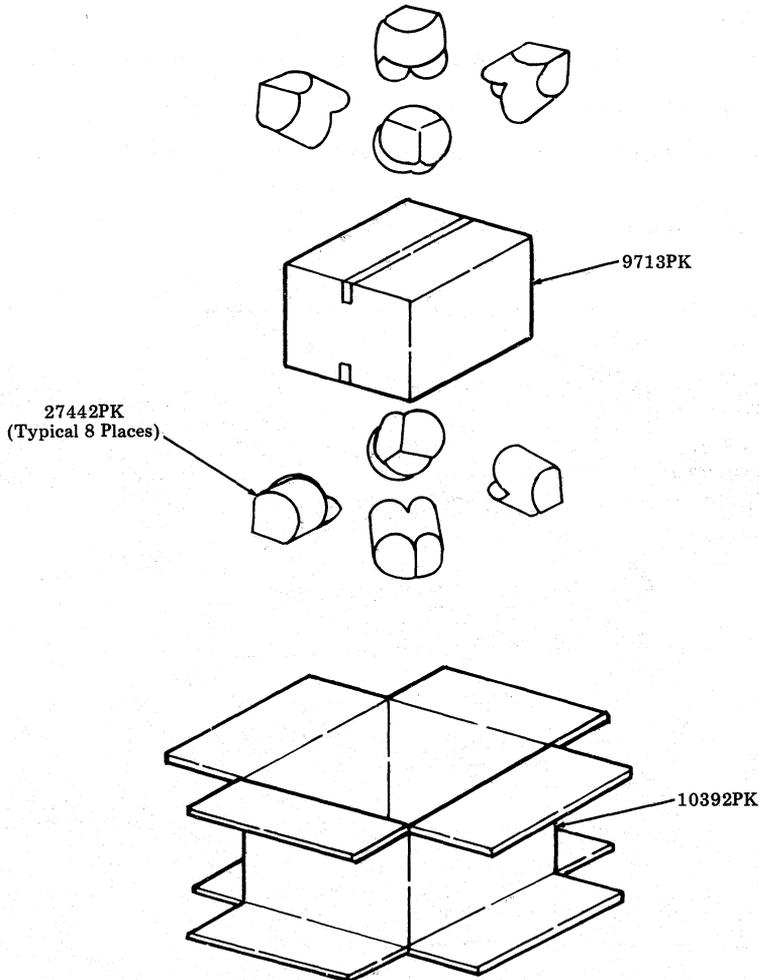


Fig. 63

## 40C430, 40C431, AND 40C432 CONTROLLERS

Packing Procedure for Controller

- Step 1. Position a 28235PK plywood detail against each end of controller. Securely tape details to unit with a band of 21632PK tape. See Fig. 64. Drape cables over top of unit.
- Step 2. Form a 10392PK carton. Close and seal bottom of flaps with a strip of 21719PK tape.
- Step 3. Position a 27442PK plastic corner in each of the four bottom corners of the carton. See Fig. 64.
- Step 4. Form a 9713PK carton. Close and seal bottom flaps with a strip of 21719PK tape.
- Step 5. Carefully place the 9713PK carton in the four plastic corners positioned in the 10392PK carton. (See Fig. 64.)
- Step 6. Place a 28236PK plywood detail in the 9713PK carton. (See Fig. 64.)
- Step 7. Grasp the front and rear of the controller and place in carton. (See Fig. 64.)
- Step 8. Wrap cables in 21298PK tissue paper. Fill void space with tissue.
- Step 9. Position a 28236PK plywood detail in the carton.
- Step 10. Close and seal top flaps of the 9713PK carton with a strip of 21719PK tape.
- Step 11. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 12. Close and seal top flaps of outer carton with a strip of 21719PK tape.

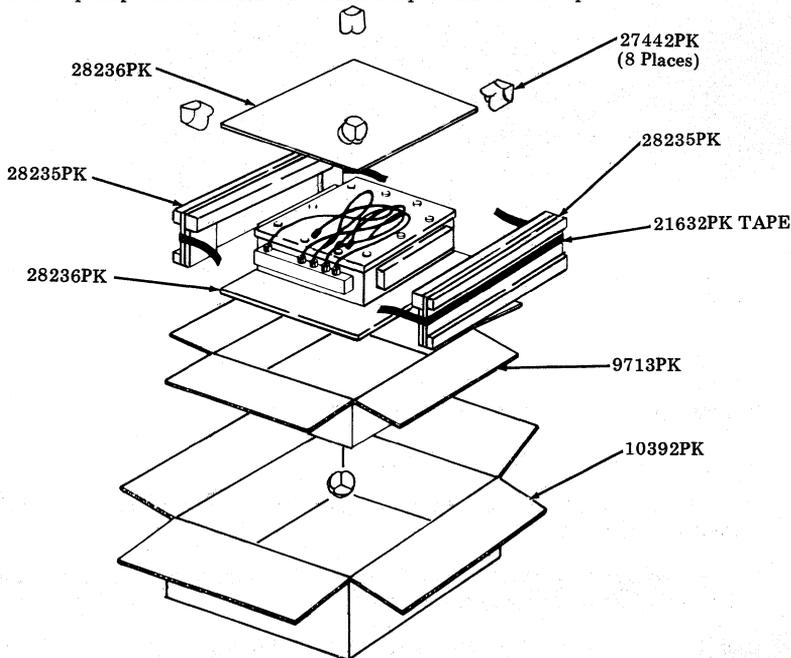
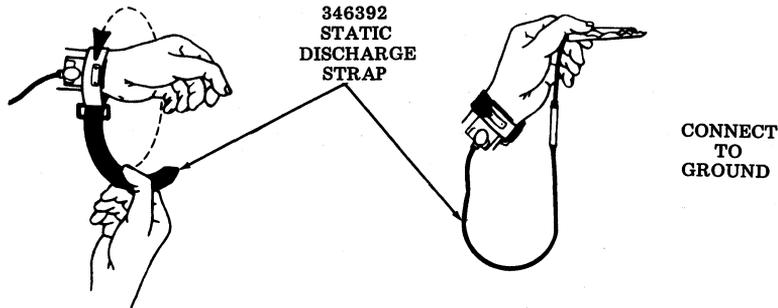


Fig. 64

40C303 CONTROLLER

Packing procedure for Controller

*Caution: To avoid possible internal damage to circuitry, wear a 346392 static discharge strap connected to ground to allow static discharge before handling circuit cards for removal or replacement. Avoid touching circuit lands and card components as much as possible.*



*Note: 79157RM antistatic plastic bag deleted for clarity.*

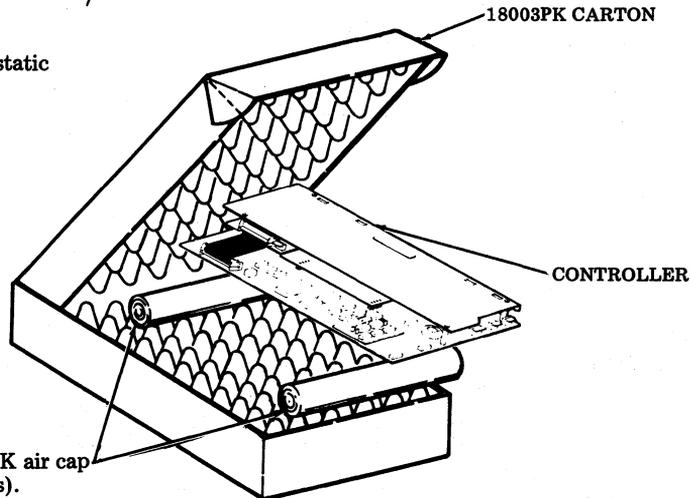


Fig. 65

- Step 1. Place controller in a 79157RM antistatic plastic bag.
- Step 2. Open one 18003PK carton with inserts.
- Step 3. Place the integrated controller into the carton on top of the foam, approximately centrally located. (See Fig. 65.)
- Step 4. Cut two 24 inch lengths of 27952PK air cap. Roll each length into a cylinder, position at either end of controller, and close carton.
- Step 5. Seal the bottom front flap with a strip of 21720PK tape.

**40C304 AND 40C305 CONTROLLERS****Packing Procedure for Controller**

- Step 1. Mount unit frame to a 28219PK plywood pallet with four 71676RM screws, four 2669 lock-washers and four 72295RM washers as illustrated in Fig. 55. The large hole in the pallet must be in line with the hole used to mount the PSU in the base. (See Fig. 66.)
- Step 2. After unit is completed, position a 28307PK plywood detail on top of the three circuit card grouping. Form and position a 28289PK corrugated detail over circuit cards and plywood detail as illustrated in Fig. 67.
- Step 3. Tightly secure the corrugated detail in place with four strips of 21632PK tape tightly applied over top of detail and extending down to bottom of unit at front and rear of unit. Pull tape firmly for good adhesion. (See Fig. 67.)
- Step 4. At power supply side of unit, remove front and rear screws holding unit to pallet. Loosen remaining two screws, two turns.
- Step 5. Separate unit and pallet on power supply side by wedging a 28308PK plywood detail between unit and pallet.
- Step 6. Tightly secure a 28308PK plywood detail to top of power supply with three double bands of 21632PK tape, applied over top of plywood detail and around front, bottom, and rear of unit. Tape should be in approximate position on plywood detail as shown in Fig. 67.
- Step 7. Remove 28308PK detail from between unit and pallet. Replace screw, washer, and lockwasher assemblies previously removed. Tighten all screws mounting unit to pallet.
- Step 8. Form a 9713PK carton. Close and seal bottom flaps with a strip of 21719PK tape. The tape should be applied to the center seam and extend approximately three inches down the ends of the carton.
- Step 9. Coil unit cable (when equipped) and secure to side of unit with 21632PK tape. Place palletized unit in carton. (See Fig. 66.)
- Step 10. Form a 28220PK liner and place in carton around unit. (See Fig. 66.)
- Note: Special Operations Step 12, 13, and 14 are for 40C305 controller only.*
- Step 11. Coil the following cables in a circle approximately 14 inches to 15 inches in diameter: two 406073, one 406074, and one 406075.
- Step 12. Tape each cable around the connectors with one strip of 21632PK tape.
- Step 13. Place cables between controller and 28220PK liner on side adjacent to fans. (See Fig. 66.)
- Step 14. Close and seal top flaps of carton as outlined in Step 8.

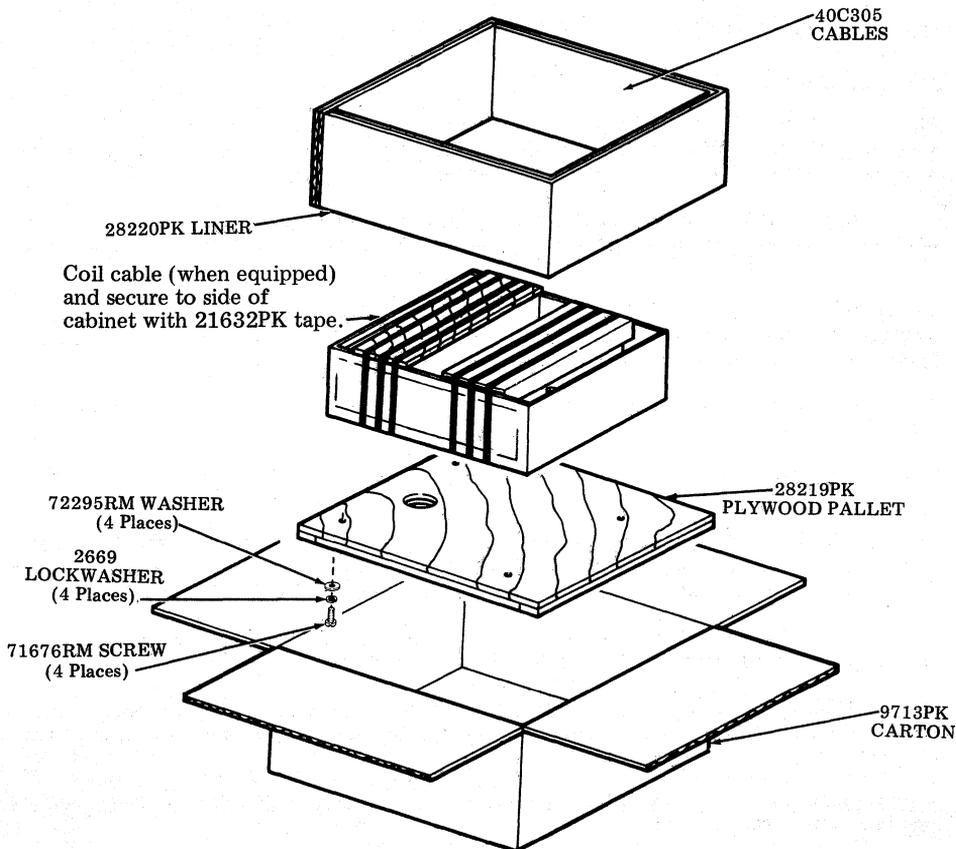


Fig. 66

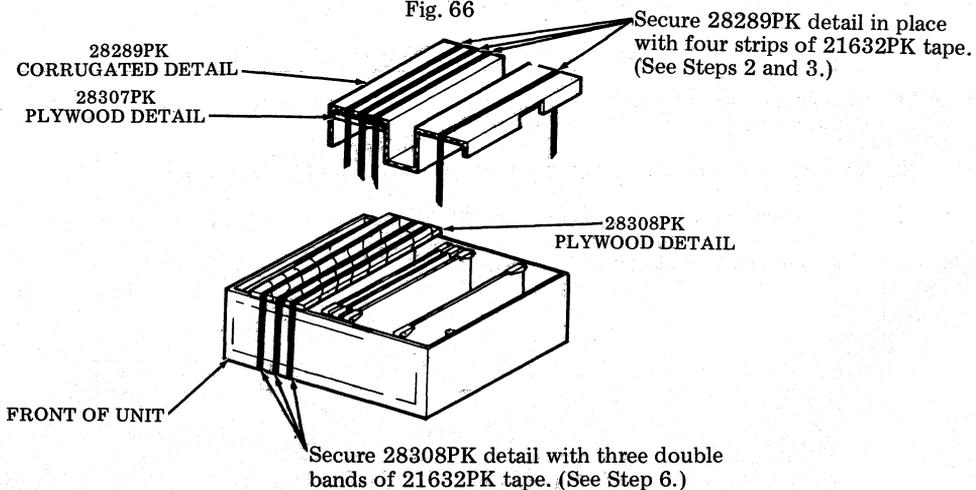


Fig. 67

- Step 15. Form a 10392PK carton. Fold bottom flaps outward and place around sealed carton. (See Fig. 68.)
- Step 16. Position a 27442PK plastic corner on each of the four corners of the inner carton. (See Fig. 68.)
- Step 17. Close top flaps and seal center seam with 21719PK tape as outlined in Step 8. Carefully invert carton and contents.
- Step 18. Position a 27442PK plastic corner on each of the four corners of the inner carton. (See Fig. 68.)
- Step 19. Close bottom flaps and seal center seam with 21719PK tape as outlined in Step 8. Carefully invert carton and contents.

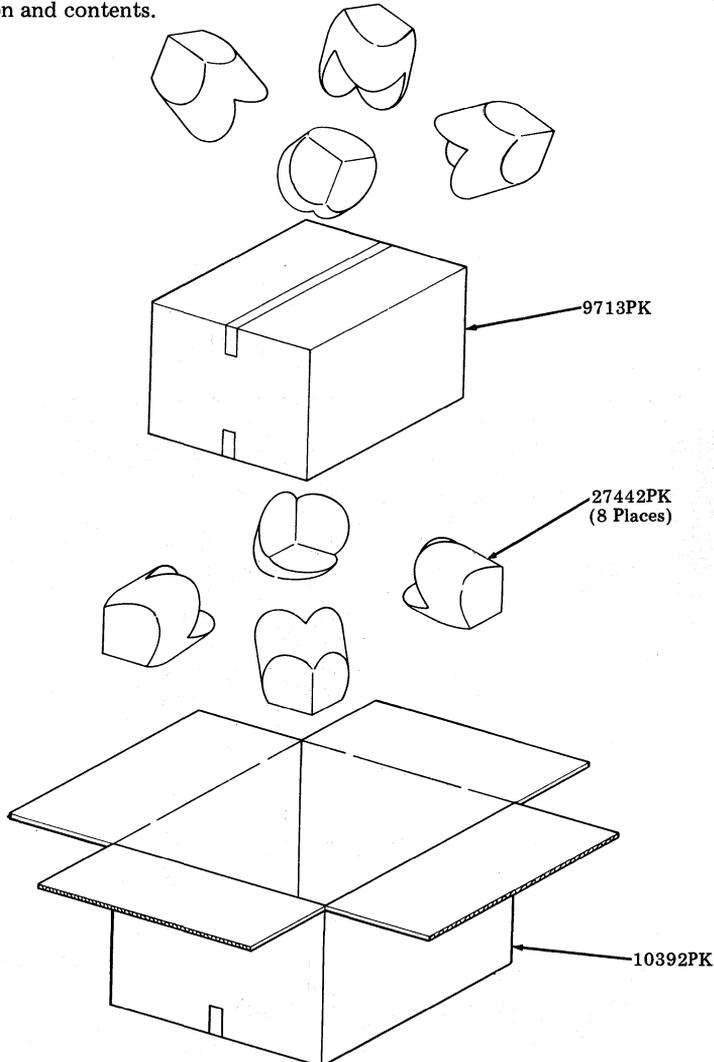


Fig. 68

40C434, 40C435, AND 40C436 CONTROLLERS

Packing Procedure for Controller

- Step 1. Position a 28293PK Detail A plywood detail against end of controller.
- Step 2. Position a 28293PK Detail B against opposite end of controller. See Fig. 69. Drape cables over top of unit.
- Step 3. Form a 10392PK carton. Close and seal bottom of flaps with a strip of 21719PK tape.
- Step 4. Position a 27442PK plastic corner in each of the four bottom corners of the carton. See Fig. 69.
- Step 5. Form a 9713PK carton. Close and seal bottom flaps with a strip of 21719PK tape.
- Step 6. Carefully place the 9713PK carton in the four plastic corners positioned in the 10392PK carton. (See Fig. 69.)
- Step 7. Place a 28236PK plywood detail in the 9713PK carton (See Fig. 69.)
- Step 8. Grasp the front and rear of the controller and place in carton. (See Fig. 69.)
- Step 9. Wrap cables in 21298PK tissue paper. Fill void space with tissue.
- Step 10. Position a 28236PK plywood detail in the carton.
- Step 11. Close and seal top flaps of the 9713PK carton with a strip of 21719PK tape.
- Step 12. Position a 27442PK plastic corner on each of the four corners of the inner carton.
- Step 13. Close and seal top flaps of outer carton with a strip of 21719PK tape.

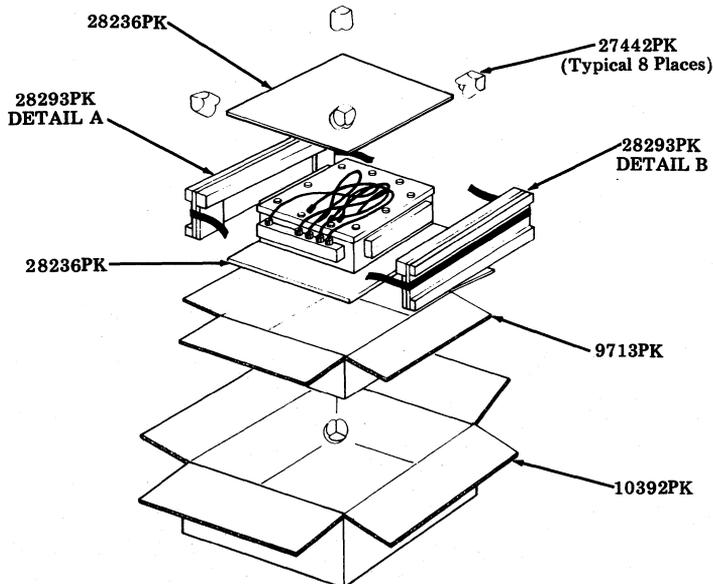


Fig. 69

## 401200 COPY HOLDER

Packing Procedure for Copy Holder

- Step 1. Form 8814PK shipping container. Close and seal bottom flaps with glue or sealing tape.
- Step 2. Insert copy holder in container, close and seal top flaps with glue or sealing tape.

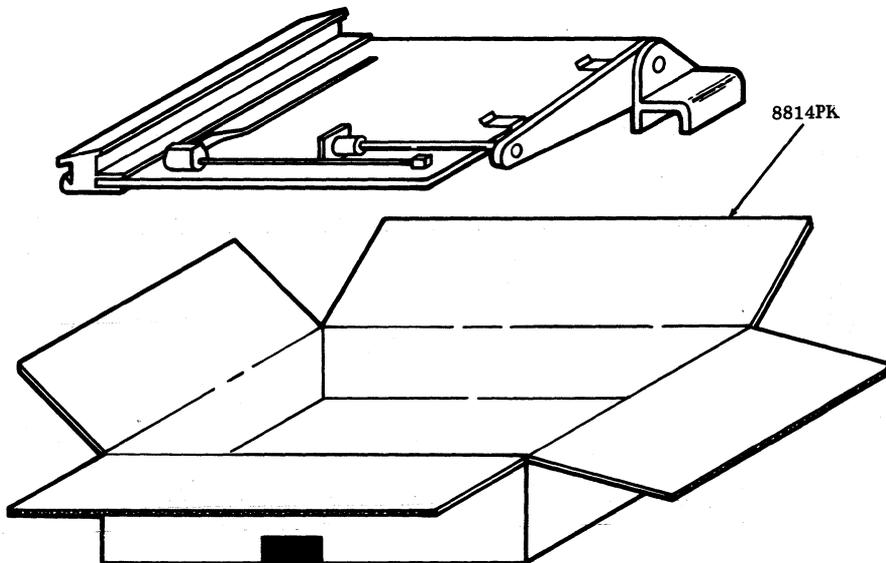


Fig. 70

## 40PWU101 AND 40PWU102 PAPER WINDERS

Packing Procedure for Paper Winders

- Step 1. Place loose parts in 652472RM cloth bag. Close bag and tie to hole in base plate as illustrated in Fig. 71.
- Step 2. Form 8563PK folder. Wrap base plate in tissue paper and place in folder.
- Step 3. Fold flaps of folder closed and seal with glue or sealing tape.
- Step 4. Form 9644PK shipping container. Close and seal bottom flaps with glue or sealing tape.
- Step 5. Place folder in container. Form 28193PK detail and place in container as illustrated in Fig. 71.
- Step 6. Remove paper spindle from unit. Place unit in a 23457PK plastic bag. Let cable extend outside of bag. Position unit in cutouts in detail as shown.
- Step 7. Form 28192PK detail. Position reel in detail. Secure flaps of detail in position (as shown in Fig. 71) with four strips of reinforced pressure sensitive tape.
- Step 8. Position prepacked reel in container as illustrated.
- Step 9. Coil line cord in void space formed by packing detail and the carton.
- Step 10. Secure the top of the shipping container (9644PK) with reinforced pressure sensitive tape.

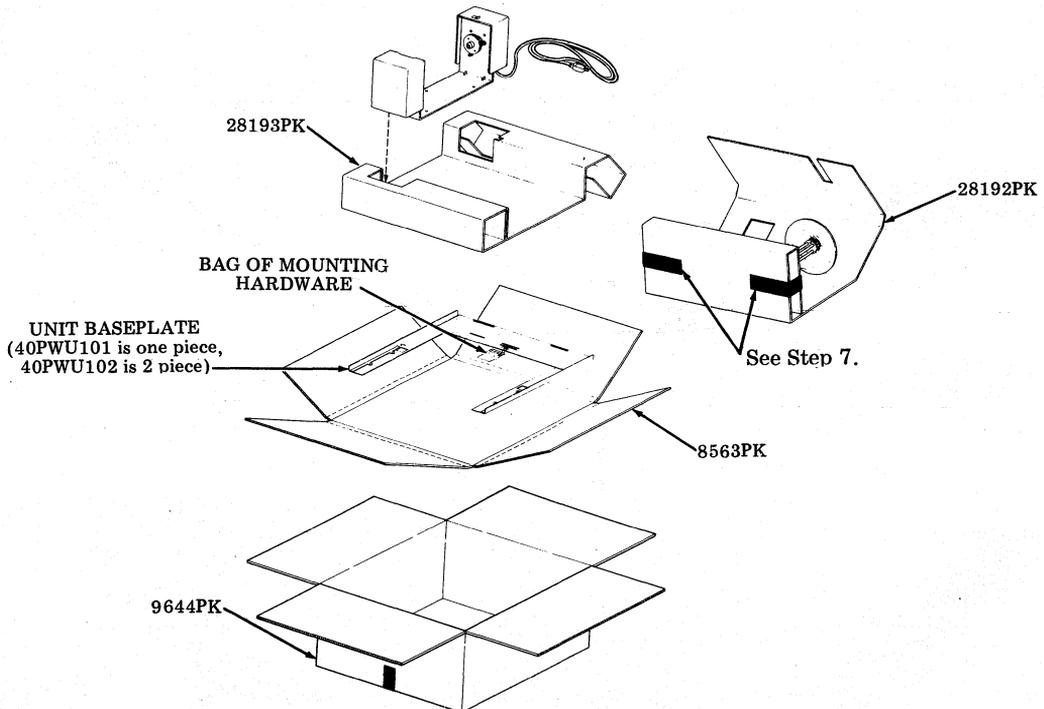


Fig. 71

#### 4. WORKING STATION

4.01 The Working Station (WS) plan should be considered in returning DATASPEED 40 terminal equipment which is functional to Western Electric. Qualified apparatus submitted via the WS plan will result in reduced shop repair costs.

4.02 Criteria for qualification for Working Station (WS) processing are listed below. A Returned Material Tag (see Fig. 72) affixed to each station/terminal/component should be completed to designate (WS) plan if appropriate.

##### CRITERIA FOR QUALIFICATION

4.03 Apparatus should be completely operable such that it is functionally acceptable as is for reinstallation.

4.04 Apparatus should have had normal routine maintenance throughout service.

4.05 Apparatus returned to service center should meet appearance standards (required minor cleanup permissible).

4.06 Apparatus returned to service center should be undamaged.

4.07 Apparatus returned to service center should have a Returned Material Tag designating Working Station (WS) affixed to each component.

4.08 A material list (or service order or station/apparatus disconnect order) identifying the Working Station components shall be included with the returned equipment.

4.09 Apparatus which is not or cannot be broken down to defined M-List items without adding components or rework does not qualify as a candidate for Working Station processing. Examples of nonqualifying candidates for Working Station processing are as follows: Damaged apparatus, apparatus with missing components or parts, and apparatus modified such that extensive rework is necessary to restore it to conform to defined USOC M-List items as stocked at the Service Centers in repaired class "C" stock.

RETURNED MATERIAL TAG	
Data Sets And Terminals	
CIMS/LV TRACKING	
Ship To:	_____
	_____
Date:	_____
Tag # :	_____
	_____
Returned From:	_____
	(Location)
Technician's Name:	_____
Supervisor:	_____
Tel. # :	_____
Area:	_____
Quantity:	_____
Equipment Type:	_____
	(Include Complete List # )
_____	
<b>Reason For Return</b>	
Good	<input type="checkbox"/> Service Order Disconnect
	<input type="checkbox"/> Surplus - Good
	<input type="checkbox"/> Job Cancelled
	<input type="checkbox"/> WS (Working Station)
_____	
Defective	<input type="checkbox"/> Defective On Arrival
	<input type="checkbox"/> Failed In Service
	<input type="checkbox"/> Pretest Failure
	<input type="checkbox"/> Surplus - Defective Or Unknown
Service Order #	_____
USSO # :	_____
Ckt # :	_____

Fig. 72—Returned Material Tag (Obtain Locally)