

“DATASPEED*” 40 CABINETS AND FACILITIES

DISASSEMBLY/REASSEMBLY, PARTS AND ADJUSTMENTS

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Cradle torsion spring —		1. GENERAL	
tractor feed (132-column)	140	1.01 This section provides the disassembly/	
Paper exit gap — noise reducing		reassembley, parts and adjustments for	
friction feed	141	DATASPEED 40 cabinets (hereafter referred to	
		as 40 type) and facilities shown in PART 2. UNIT	
		IDENTIFICATION.	
		1.02 This section is reissued to incorporate the	
		latest engineering changes available at this	
		time. Teletype Change Notice (TCN) information,	
		where applicable, is also included. Because this is	
		a general revision, marginal arrows have been	
		omitted.	

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1.03 This section includes the procedures for removing and replacing the principle components of the 40-type cabinets and facilities. If further removal of parts is required, refer to the appropriate illustrated parts figure which shows detailed arrangements of parts.

1.04 References to left, right, front and rear, etc, refer to the cabinet or assembly as viewed in its normal operating position facing forward.

1.05 Refer to Maintenance Tools Section 570-005-800 for a complete listing of the various types of hand tools available for maintenance of Teletype Corporation equipment.

1.06 Some mechanical adjustment procedures in this section require removing an assembly, part or component with no further disassembly required. Read all adjustment notes thoroughly before performing the necessary procedure.

1.07 Unless specifically stated, make screws or nuts friction tight to make an adjustment. Tighten them securely once the adjustment has been made.

1.08 Clean the cabinet after servicing. When cleaning the cabinet use a mild detergent, rinse with damp cloth and buff dry.

1.09 Scuffed or scratched painted surfaces may be touched up with air-dry brush lacquer 344963 (KB) black spattered texture brushing lacquer.

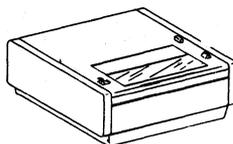
1.10 When ordering replaceable components, unless otherwise specified, prefix each part number with the letters "TP" (ie, TP344963).

2. UNIT IDENTIFICATION

2.01 All the units covered in this section are listed and shown in 2.02 through 2.10.

2.02 Friction Feed Printer Cabinets

- † Standard Serial Interface
- ‡ Electronic Industries Association
- § Original Equipment Manufacturer

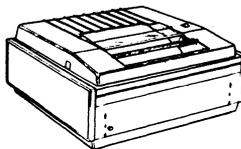


•40CAB201/ZZ PLUS
407042 MODIFICATION
KIT PRINTER
ADJACENT (SSI†)

•40CAB201/ZZ PLUS
407043 MODIFICATION
KIT RO PRINTER (SSI†)

•40CAB251/AA
PRINTER UNDER
MONITOR (SSI†)

(Noise Reduced)



•40CAB371/ZZ PLUS
407100 MODIFI-
CATION KIT
RO PRINTER (SSI†)

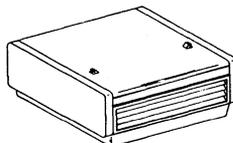
•40CAB371/ZZ PLUS
346744 MODIFICATION KIT
TO PROVIDE (OEM §)
INTERFACE

•40CAB371/ZZ PLUS
407102 MODIFICATION KIT
TO PROVIDE INTERFACE
FOR 40C103 CONTROLLER

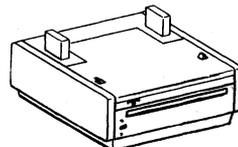
•40CAB371/ZZ PLUS
407101 MODIFI-
CATION KIT WITH
PROVISION FOR
OPCON (EIA‡)

•40CAB371/ZZ PLUS
406204 MODIFICATION KIT
TO PROVIDE INTERFACE
FOR 40C303/AD
INTEGRATED CONTROLLER
(EIA‡)

2.03 Logic Cabinets



•40CAB201/AB
LOGIC ADJACENT

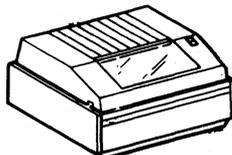


•40CAB251/ZZ PLUS
405563 MODIFICATION KIT
LOGIC UNDER MONITOR

•40CAB251/ZZ PLUS
405562 MODIFI-
CATION KIT
MONITOR AND
OPCON MOUNTING

•40CAB251/ZZ PLUS
406047 MODIFI-
CATION KIT LOGIC
UNDER MONITOR
(EIA‡)

2.04 80-Column Tractor Feed Printer Cabinets



•40CAB351/YZ PLUS
407026 MODIFICATION
KIT RO PRINTER (SSI†)
(80-Column)

•40CAB351/YZ PLUS
407025 MODIFICATION KIT
PRINTER W/PROVISION
FOR OPCON (SSI†)
(80-Column)

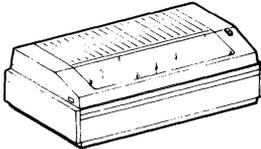
•40CAB351/YZ PLUS 346732
MODIFICATION KIT TO PROVIDE
(OEM ‡) INTERFACE

•40CAB351/YZ PLUS 407024 MODIFICATION
KIT ROP PRINTER W/PROVISION FOR OPCON
(EIA ‡) (80-Column)

•40CAB351/YZ PLUS 406190 MODIFICATION
KIT TO PROVIDE INTERFACE FOR 40C303/AA
INTEGRATED CONTROLLER
(DUAL EIA ‡)

•40CAB351/YZ PLUS 406207
MODIFICATION KIT TO PROVIDE
INTERFACE FOR 40C303/AC OR
40C303/AD INTEGRATED
CONTROLLER (Dual EIA ‡)

2.05 132-Column Tractor Feed Printer Cabinets



•40CAB353/YZ PLUS
405671 MODIFICATION KIT
(SSI †) (132-Column)

•40CAB353/YZ PLUS 407024
MODIFICATION KIT RO PRINTER
W/PROVISION FOR OPCON
(EIA ‡) (132-Column)

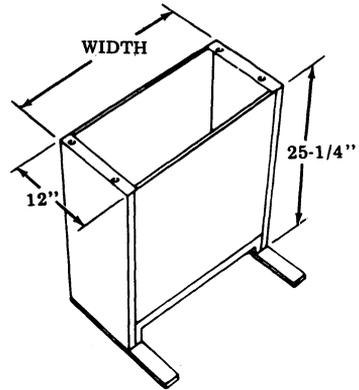
•40CAB353/YZ PLUS 406190
MODIFICATION KIT RO PRINTER
W/PROVISION FOR OPCON
(Dual EIA ‡) (132-Column)

•40CAB353/YZ PLUS 406207
MODIFICATION KIT TO PROVIDE
INTERFACE FOR 40C303/AC OR
40C303/AD INTEGRATED
CONTROLLER (Dual EIA ‡)

•40CAB353/YZ PLUS 346731
MODIFICATION KIT TO PROVIDE
(OEM ‡) INTERFACE

- † Standard Serial Interface
- ‡ Electronic Industries Association
- § Original Equipment Manufacturer

2.06 Cabinets (Pedestal-Type)



PEDESTAL WITHOUT TABLE TOP		
CODE	TYPE	WIDTH
40CAB901/AF	RO Printer Terminal — Contains Logic Module	24"
40CAB901/AG	KDP Terminal — Contains Logic Module	24"
40CAB901/AH	KD Terminal — Empty	24"
40CAB901/AJ	AC Facilities and Cable Bracket	24"
40CAB902/AA	RO Tractor Terminal — Empty	20"
40CAB902/AB	RO Tractor Terminal — Contains Logic Module	20"
40CAB904/AA	Empty	27-1/2"

2.07 Table Tops for Pedestal-Type Cabinets

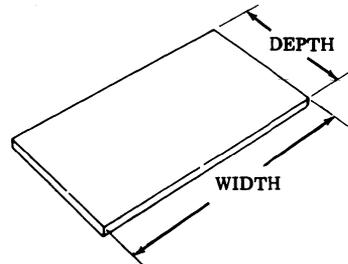


TABLE TOPS FOR PEDESTALS — FRICTION FEED		
PART NO.	WIDTH	DEPTH
401531	24"	17-3/8"
401532	29"	17-3/8"
401533	34"	17-3/8"
Ⓞ411035	29"	17-3/8"

Ⓞ Used only on 40CAB904.

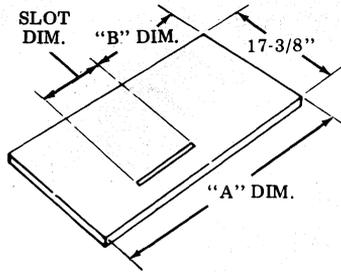
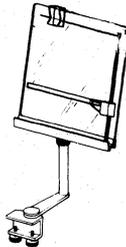
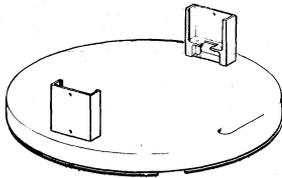


TABLE TOPS FOR PEDESTALS — TRACTOR FEED			
PART NO.	"A" DIM.	"B" DIM.	SLOT DIM.
401911①	20"	4-1/2"	11"
401912	31-1/2"	16"	11"
401913	27-1/4"	5"	17"
401914	24-1/2"	7"	11"
401915	39"	17"	17"

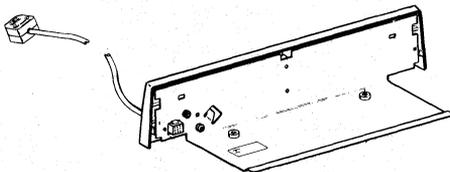
2.08 401200 Copyholder



2.09 40BSE101 Monitor Base

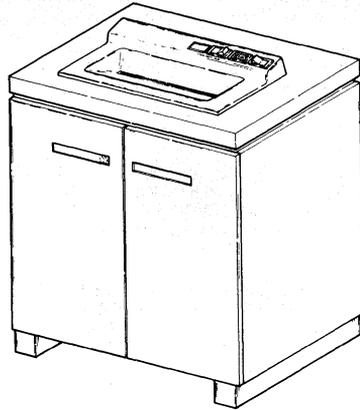


2.10 40BSE201 Opcon Base (KD) and 40BSE202 Wide Opcon Base



①Used only on 40CAB902.

2.11 Forms Access Printer Cabinet



40CAB302/ZZ Plus 406372 Modification Kit — EIA Interface With Provision for Mounting Integrated Controller and Opcon 40CAB302/ZZ Plus 406370 Modification Kit — SSI Interface to Cabinet

3. CONVERSIONS

3.01 Conversions for 40-type cabinets (table top) can be performed by utilizing the coding plan.

3.02 The code plan is based upon using a common cabinet core, along with modification kit to make up a specific cabinet, (ie, the 40CAB201/ZZ cabinet core + 407042 = 40CAB201/AA adjacent printer cabinet).

3.03 The table specification references when used with 5. PARTS IDENTIFICATION of this section should be sufficient in assembling or disassembling the various cabinet combinations.

3.04 When cabinets are converted to make up a particular cabinet or disassembled to its common cabinet core, an identification plate provided with the cabinet should be marked with the cabinet code and date of conversion.

3.05 The table lists the various cabinet combinations presently utilized. Description and type of cabinet information is also listed to help in determining the kind of cabinet that might be desired (refer to PART 2. UNIT IDENTIFICATION).

CABINET CODE (Table Top)	CODE	MOD KIT	DESCRIPTION	TYPE	SPECIFICATION REFERENCE
40CAB201/AA = 40CAB201/AB = 40CAB201/AC =	40CAB201/ZZ NO CHANGE 40CAB201/ZZ	407042 407043	Printer Adjacent Logic Adjacent RO Printer	Friction — KDP (SSI) Friction (SSI)	50828S
40CAB251/AA = 40CAB251/AB = 40CAB251/AC =	NO CHANGE 40CAB251/ZZ 40CAB251/ZZ	405563 405562	Printer U/Monitor Logic U/Monitor Monitor/Opcon Support	Friction (SSI) KD Used with 40C400 Series Controllers	50830S
40CAB251/AE =	40CAB251/ZZ	406047	Logic U/Monitor	KD (EIA) (Used with 40C304 Controller)	
40CAB351/AA = 40CAB351/AB =	40CAB351/YZ 40CAB351/YZ	407026 407025	RO Printer RO Printer w/ Provision for Opcon	80-Column Tractor (SSI) 80-Column Tractor (SSI)	50829S
40CAB351/AC =	40CAB351/YZ	407024	RO Printer w/ Provision for Opcon	80-Column Tractor (EIA) (Used with 40C303/AA Integrated Controller)	
40CAB351/AD	40CAB351/YZ	346732	RO Printer	80-Column Tractor (OEM) Printer Input Interface	50878S
40CAB351/AE =	40CAB351/YZ	406190	Houses 40C303/AC or 40C303/AD Integrated Controller and has Provision for Dual EIA Type Printer Interface	80-Column Tractor	50915S
—————	40CAB351/YZ	406207	Houses 40C303/AC or 40C303/AD Integrated Controller and has Provision for Dual EIA Type Printer Interface.	80-Column Tractor	51001S
40CAB353/AA = 40CAB353/AB =	40CAB353/YZ 40CAB353/YZ	405671 407024	RO Printer RO Printer w/ Provision for Opcon	132-Column Tractor (SSI) 132-Column Tractor (EIA) (Used with 40C303 Integrated Controller)	50829S
40CAB353/AC	40CAB353/YZ	346731	RO Printer	132-Column Tractor (OEM) Printer Input Interface	
40CAB353/AD =	40CAB353/YZ	406190	Houses 40C303/AC or AD Integrated Controller and has Provision for Dual EIA Type Printer Interface	132-Column Tractor	50915S
—————	40CAB353/YZ	406207	Houses 40C303/AC or 40C303/AD Integrated Controller and has Provision for Dual EIA Type Printer Interface	132-Column Tractor	51001S

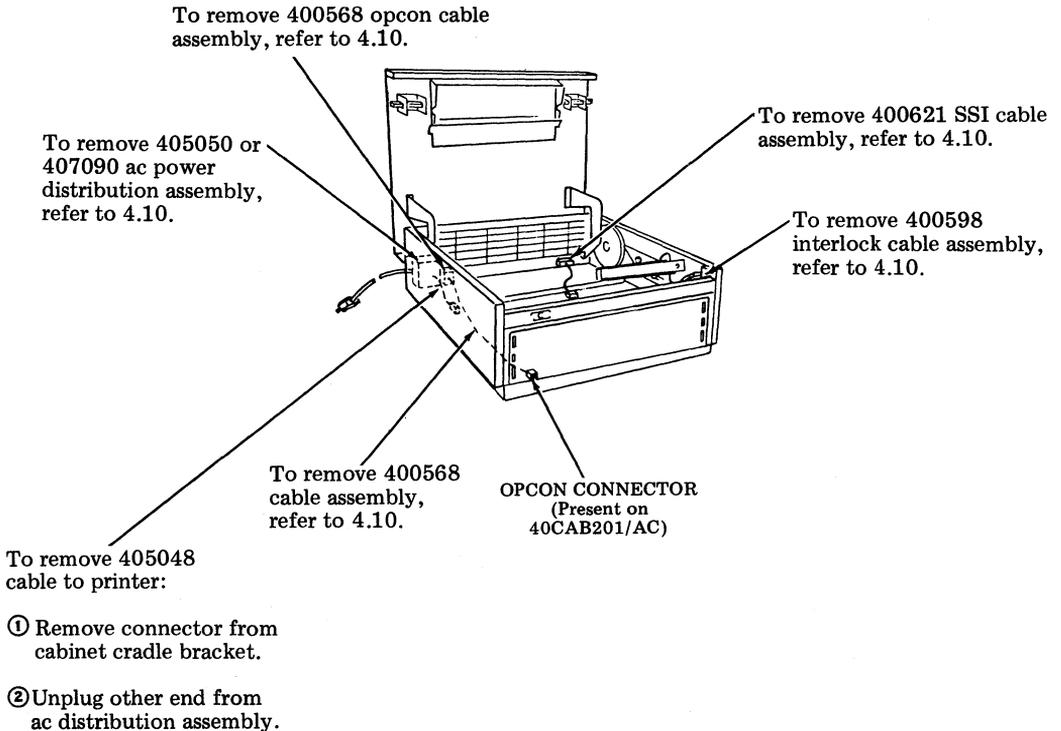
SECTION 582-212-700

CABINET CODE (Table Top)	ZZ CODE	MOD KIT	DESCRIPTION	TYPE	SPECIFICATION REFERENCE
40CAB371/AA =	40CAB371/ZZ	407100	RO Printer (Noise Reducing)	Friction (SSI)	50854S
40CAB371/AB =	40CAB371/ZZ	407101	RO Printer w/ Provision for Opcon (Noise Reducing)	Friction (EIA) (Used with 40C303/AA Integrated Controller)	
_____	40CAB371/ZZ	407102	RO Printer (Noise Reducing)	Friction (SSI) (40C103 Controller)	
40CAB371/AC	40CAB371/ZZ	346744	RO Printer (Noise Reducing)	Friction (OEM)	50881S
_____	40CAB371/ZZ	406204	Houses 40C303/AD Integrated Controller and has Provision for Dual EIA Type Printer Interface	Friction	50989S
40CAB302/AA =	40CAB302/ZZ	406372	RO Printer w/ Provision for Opcon	Forms Access (EIA) (Used with 40C303 Integrated Controller)	50953S
40CAB302/AB	40CAB302/ZZ	406370	RO Printer	Forms Access (SSI)	50951S
40CAB302/AC	40CAB302/ZZ	406371	RO Printer	Forms Access (OEM)	50952S

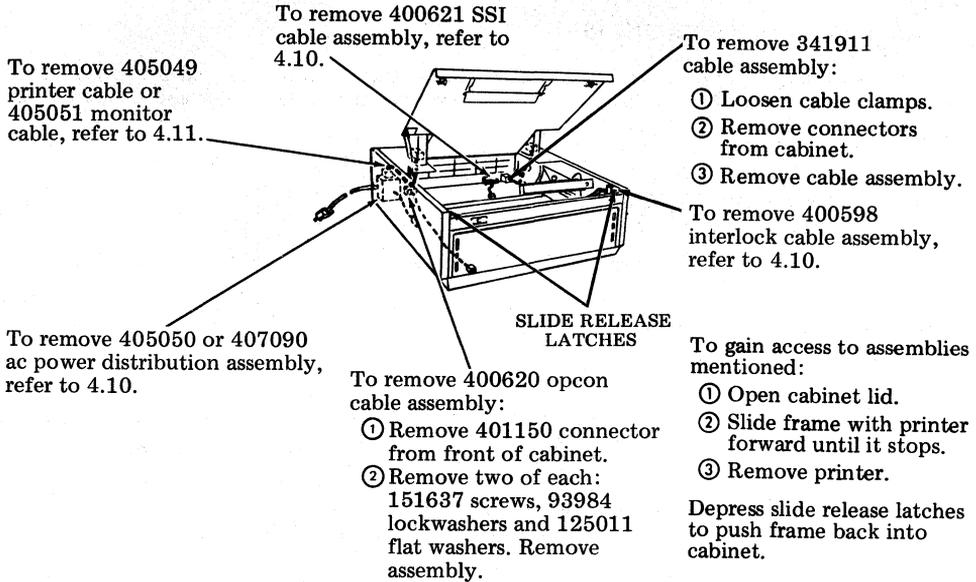
4. DISASSEMBLY/REASSEMBLY

FRICTION FEED PRINTER CABINETS

- 4.01 40CAB201/AA Printer Adjacent Cabinet (Includes internal interlock and printer cables):
 40CAB201/AC RO Printer Cabinet (Includes internal interlock, printer and opcon cables):

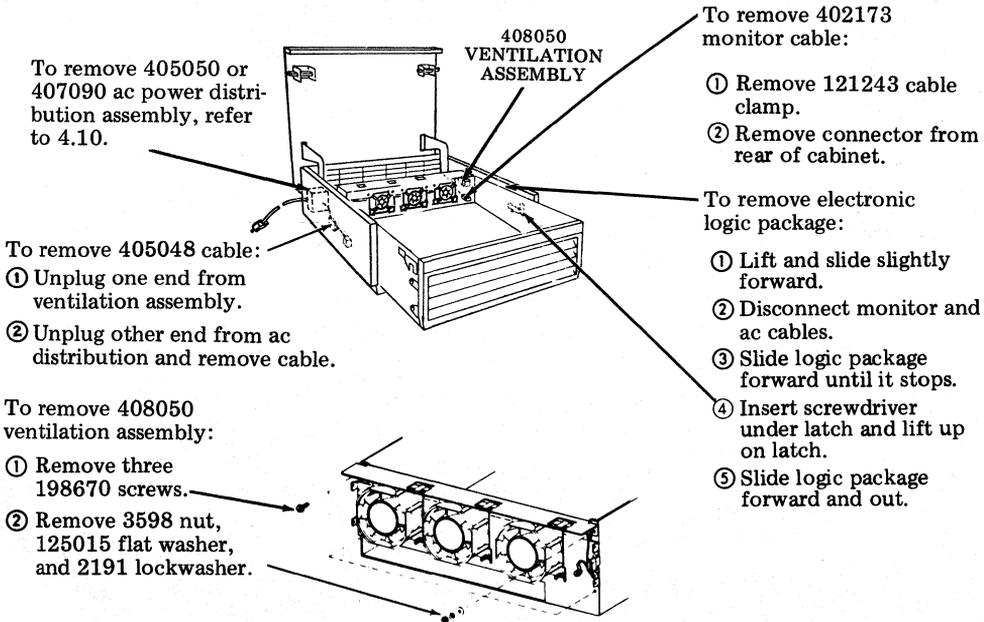


4.02 40CAB251/AA Printer Under Monitor Cabinet:



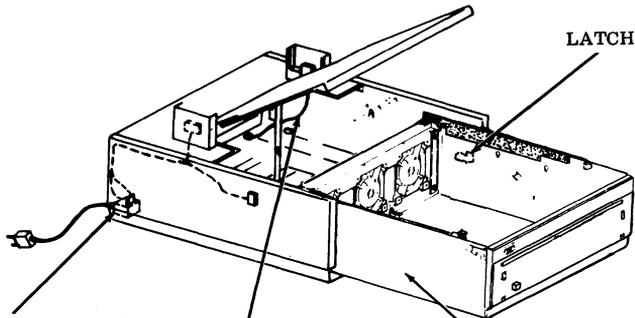
LOGIC CABINETS

4.03 40CAB201/AB Logic Adjacent Cabinet:



4.04 40CAB251/AB Logic Under Monitor Cabinet:
 40CAB251/AC Monitor/Opcon Support:
 40CAB251/AE Logic Under Monitor:

To remove 405051 monitor cable and 405047 fan cable (not used on 40CAB251/AC), refer to 4.11.



To remove 405050 or 407090 ac power distribution assembly, refer to 4.10.

To remove 341891 (used on 40CAB251/AB) or 406046 (used on 40CAB251/AE) monitor cables, refer to 4.11.

40CAB251/AB only — to remove electronic logic package and fan assembly:

- ① Lift and slide forward until logic package stops.
- ② Disconnect fan and monitor cables on rear of logic package.
- ③ Loosen 341819 shoulder screw from top of fan assembly frame.
- ④ Insert screwdriver under latch and slide logic package slightly forward.
- ⑤ Remove logic package.

To remove 408050 assembly, refer to 4.03.

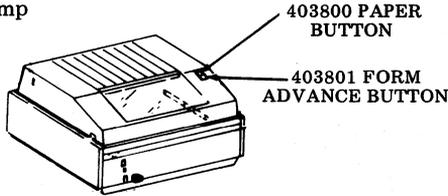
341891
MONITOR CABLE

TRACTOR FEED PRINTER CABINETS

4.05 40CAB351/AA and 40CAB353/AA Printer Adjacent Cabinets:
40CAB351/AB, 40CAB351/AC, and 40CAB353/AB RO Printer Cabinets:

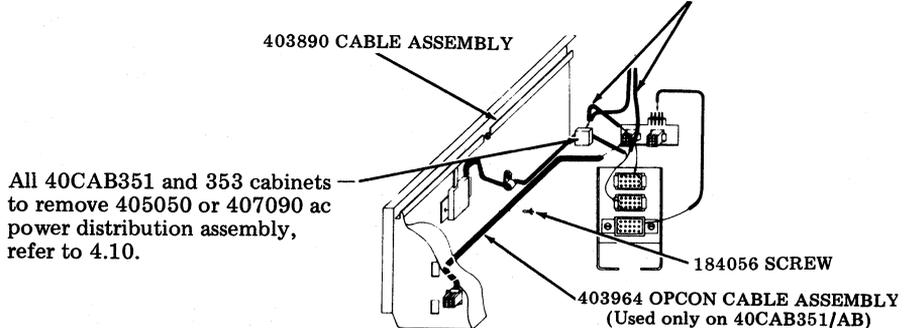
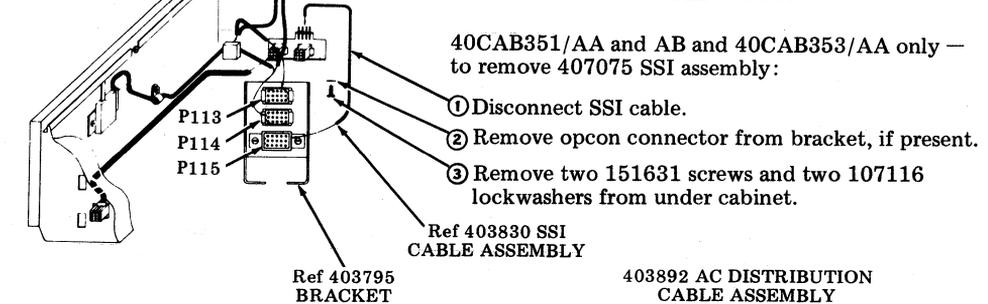
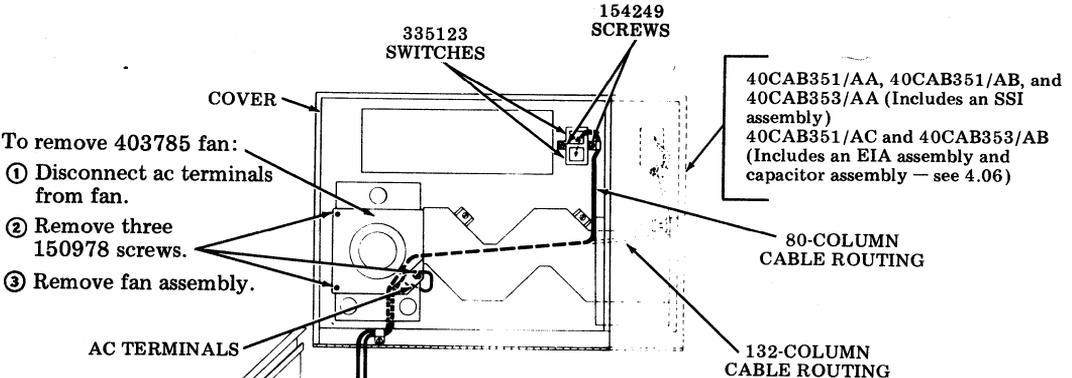
To replace 333588 lamp in 335123 switch:

- ① Remove 403800 button.
- ② Replace lamp.



To remove 335123 switches:

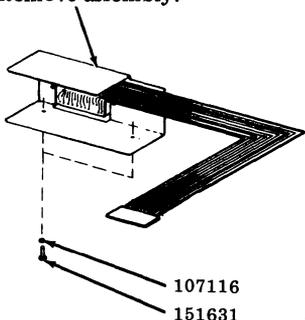
- ① Remove switch button.
- ② Remove nut from top of switch.
- ③ Unsolder leads.
- ④ Remove switch.



4.06 40CAB351/AC and 40CAB353/AB RO Printer Cabinets:

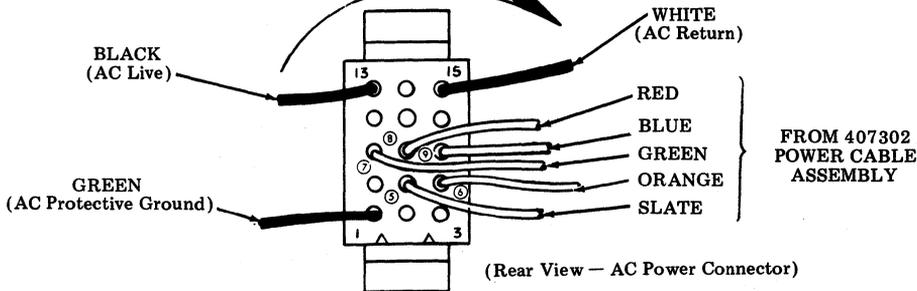
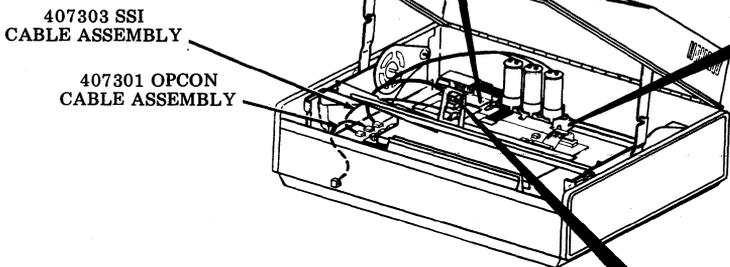
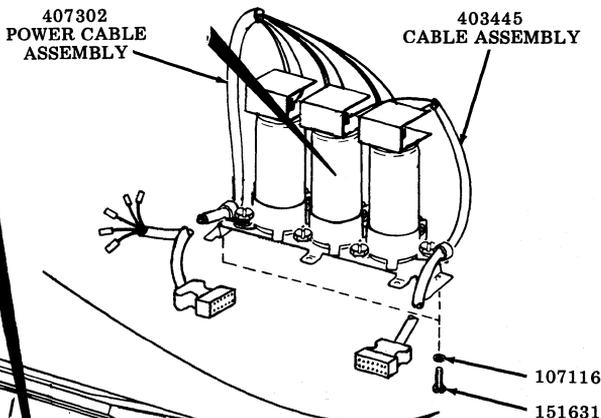
To remove 407077 EIA signal input assembly:

- ① Disconnect EIA plug from circuit card assembly.
- ② Remove two 151631 screws and two 107116 lockwashers from bottom of cabinet.
- ③ Remove assembly.



To remove 407076 capacitor assembly:

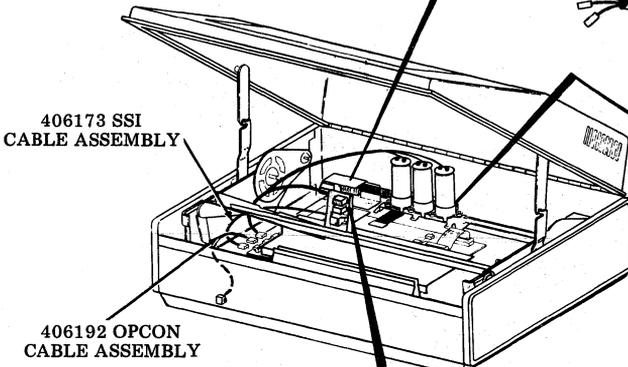
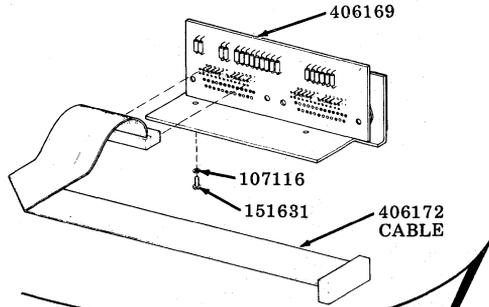
- ① Remove terminals of 407302 power cable from 341691 ac power connector. See wiring below.
- ② Disconnect 403445 and 407302 cables from circuit card assemblies.
- ③ Remove two 151631 screws and two 107116 lockwashers from bottom of cabinet.
- ④ Remove assembly.



4.07 40CAB351/AE and 40CAB353/AD Printer Cabinets

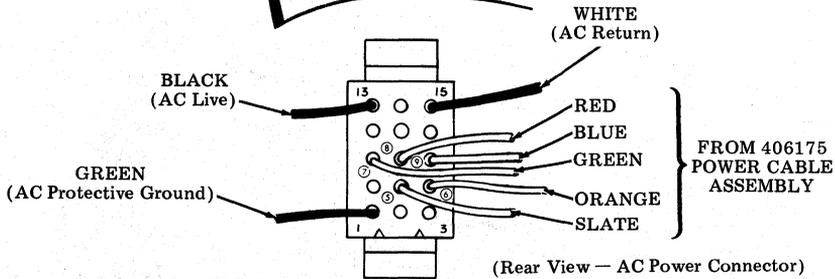
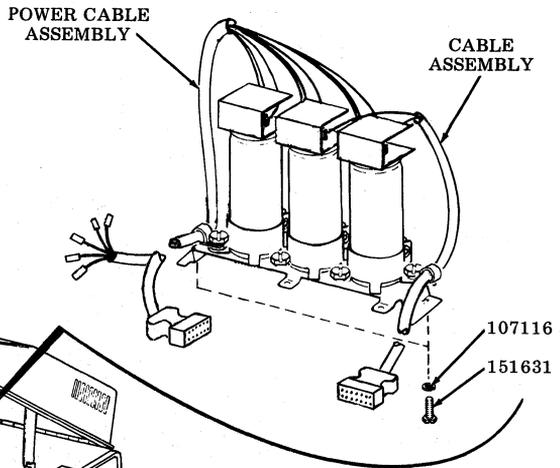
To remove 406169 EIA assembly:

- ① Disconnect EIA plug from circuit card assembly.
- ② Remove two 151631 screws and two 107116 lockwashers from bottom of cabinet.
- ③ Remove assembly.



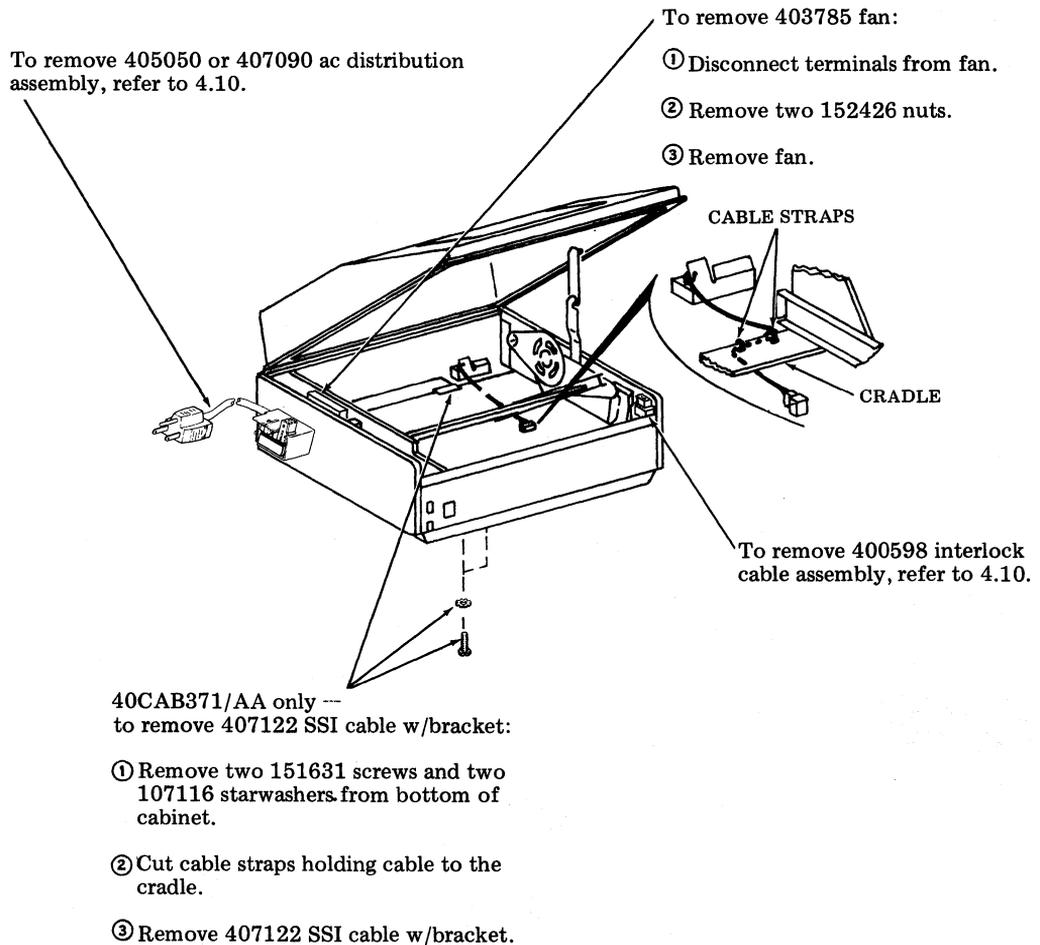
To remove 406189 capacitor assembly:

- ① Remove terminals of 406175 power cable from 341691 ac power connector. See wiring below.
- ② Disconnect cables from circuit card assemblies.
- ③ Remove two 151631 screws and two 107116 lockwashers from bottom of cabinet.
- ④ Remove assembly.



FRICTION FEED PRINTER CABINETS — NOISE REDUCING

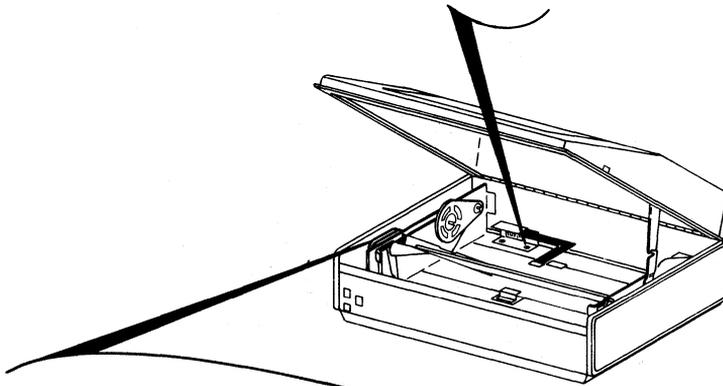
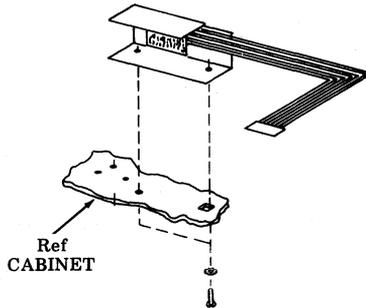
4.08 40CAB371/AA Printer Adjacent Cabinet:
40CAB371/AB RO Printer Cabinet:



4.09 40CAB371/AB RO Printer Cabinet:

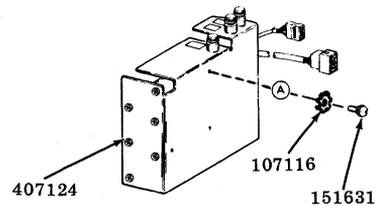
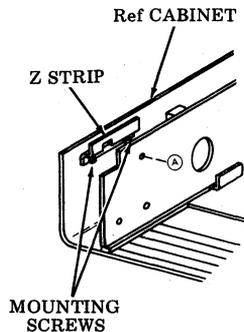
To remove 407077 EIA signal input assembly:

- ① Disconnect EIA plug from circuit card assembly.
- ② Remove two 151631 screws and two 107116 lockwashers from bottom of cabinet.
- ③ Remove assembly.



To remove 407124 power supply:

- ① Disconnect two connectors from circuit cards.
- ② In order to gain clearance to remove the 407124 power supply, two mounting screws on the Z strip are to be loosened and Z strip pivoted upwards.
- ③ Remove three 151631 screws and three 107116 lockwasher.
- ④ Remove power supply.

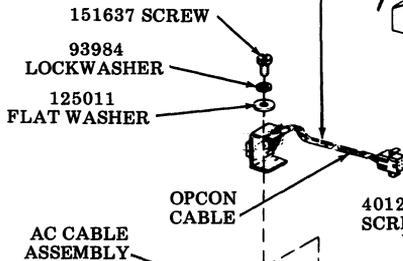


CABINET SUBASSEMBLIES (Table Top)

4.10 AC Distribution and Cable Assemblies:

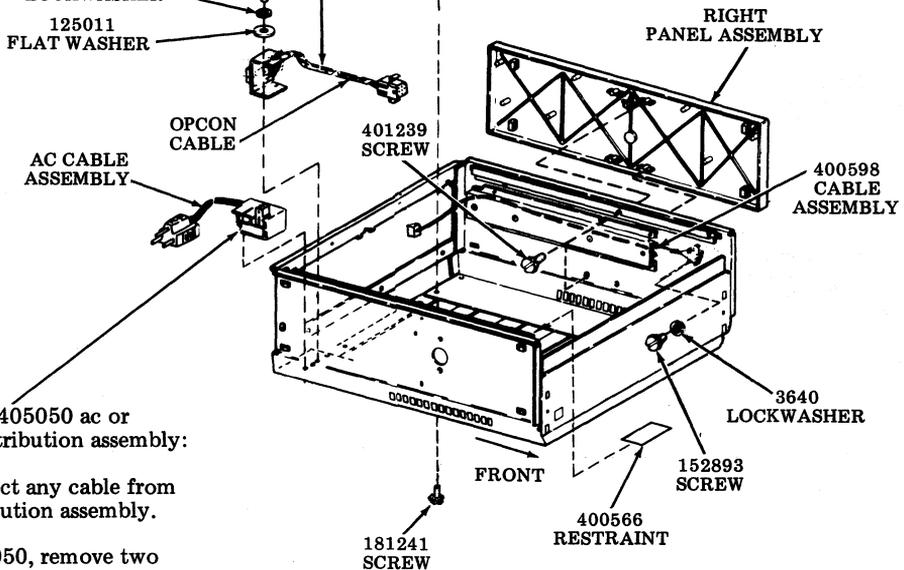
To remove 400568 or 400620 opcon cable assembly (includes 400577 bracket and opcon cable):

- ① Remove 401150 connector from front of cabinet.
- ② Remove six 400566 cable restraints.
- ③ Remove two of each: 151637 screws, 93984 lockwashers, and 125011 flat washers.
- ④ Remove assembly.



To remove 400621 SSI cable assembly:

- ① Remove three 181241 screws.
- ② Remove 400621 assembly.



To remove 405050 ac or 407090 distribution assembly:

- ① Disconnect any cable from ac distribution assembly.
- ② For 405050, remove two 408887 screws from bottom of cabinet. For 407090, remove two 2658 nuts from bottom of cabinet.
- ③ Remove assembly.

To remove 400598 interlock cable assembly:

- ① Remove two 401239 screws.
- ② Grasp center of side panel and gently pull outward to withdraw locating pin. While holding, pull toward front of the cabinet to remove.
- ③ Remove two 152893 screws and two 3640 lockwashers.
- ④ Remove assembly.

4.11 Fan and Monitor Power Cables, Monitor Signal Cables:

To remove 405047 ac fan cable or 405049 printer cable:

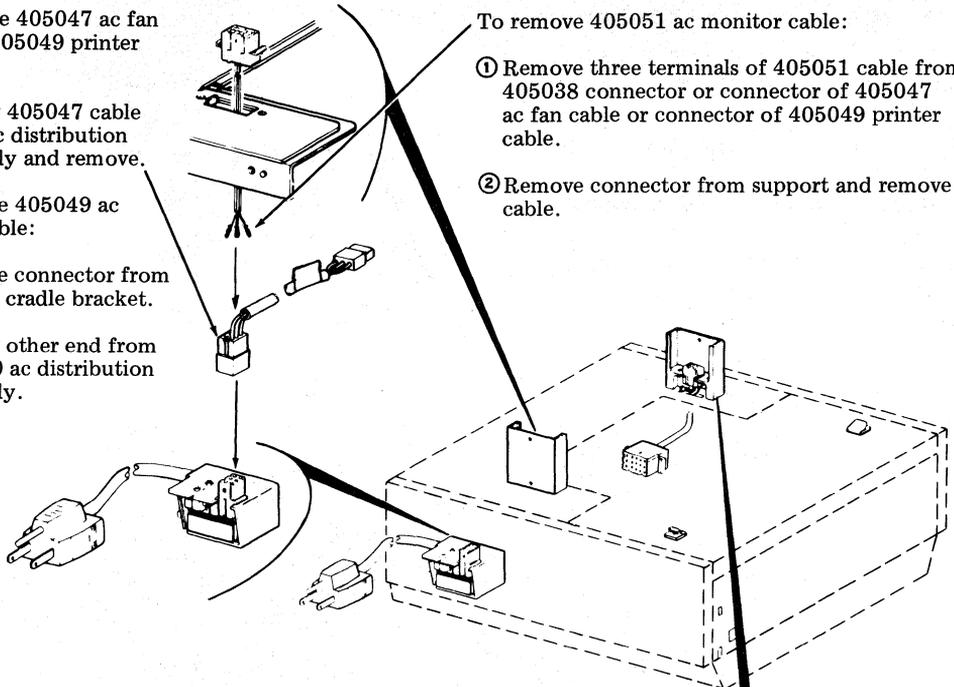
- ① Unplug 405047 cable from ac distribution assembly and remove.

To remove 405049 ac printer cable:

- ① Remove connector from cabinet cradle bracket.
- ② Unplug other end from 405040 ac distribution assembly.

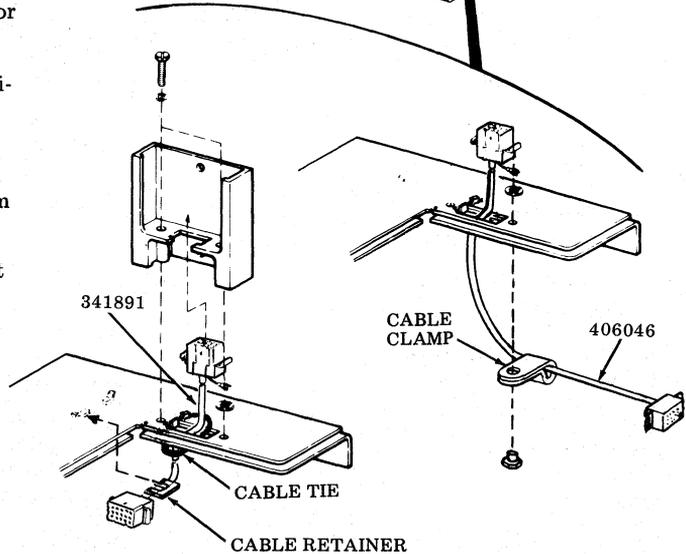
To remove 405051 ac monitor cable:

- ① Remove three terminals of 405051 cable from 405038 connector or connector of 405047 ac fan cable or connector of 405049 printer cable.
- ② Remove connector from support and remove cable.



To remove 341891 or 406046 monitor cables:

- ① Loosen hardware and remove terminal ground of the monitor cable.
- ② 341891 cable:
 - Cut cable tie.
 - Remove cable retainer plate from tabs on lower surface of cabinet top member.
 - Remove connector from support and remove cable.
- ③ 406046 cable:
 - Remove nut and cable clamp holding cable to lower surface of cabinet member.
 - Remove connector from support and remove cable.

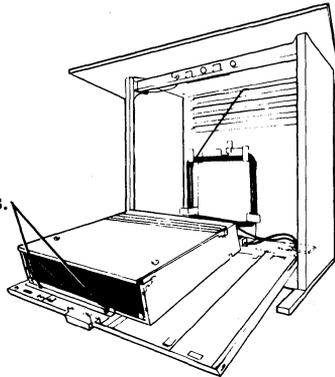


CABINET (Pedestal Type)

4.12 40CAB901/XX Cabinet (Pedestal Type):

To remove ventilation assembly and electronics package assembly:

Remove two 401225 screws with washers.

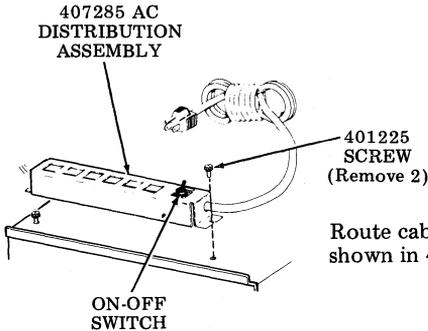


To remove 407285 ac distribution assembly (late design):

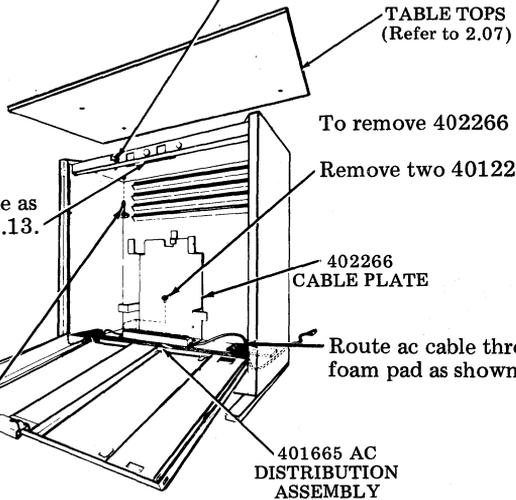
Note: New ac distribution assembly is equipped with 6 switched receptacles, and an ON-OFF switch mounted on the panel.

To remove 401665 ac distribution assembly (early design):

Remove two 401225 screws and 408052 ac switch assembly with hardware.



Route cable as shown in 4.13.



To remove 402266 cable plate:

Remove two 401225 screws.

To remove table tops:

Remove four 2449 lockwashers and 162730 screws.

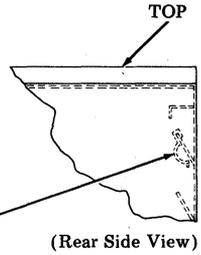
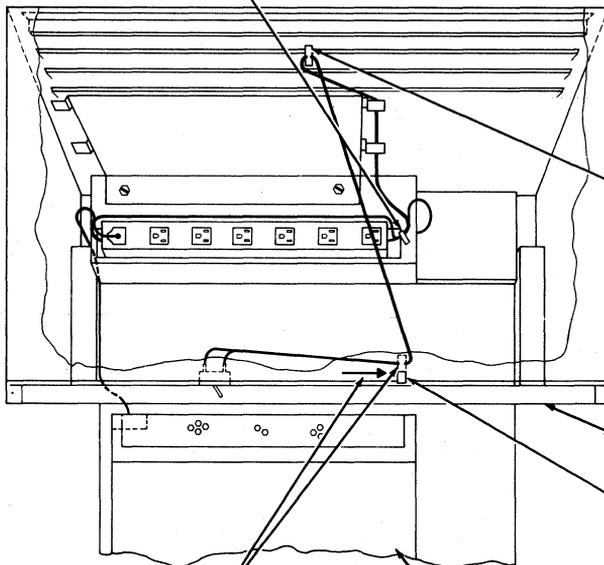
CABINET (Pedestal-Type)

4.13 40CAB901/XX Cable Routing

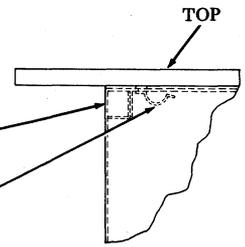
- ① Disassemble switch mounting bracket. Do not remove switch.
- ② Install cable clip to top of pedestal.
- ③ Install cable clip on louver at rear of pedestal.
- ④ Reassemble switch mounting bracket.
- ⑤ Route cable as shown.
- ⑥ Dress cable, taking up slack as shown, and install the cable strap.

CUT AWAY TOP VIEW OF THE PEDESTAL

312918 cable strap strapping the power switch cable to the ac strip power cord.



408042 cable clip approximately centered on the louver shown.



FRONT

408042 CABLE CLIP

Position this 408042 cable clip to take up all slack in the power switch cable in this direction as shown.

ELECTRONICS MODULE

4.14 40CAB902/XX

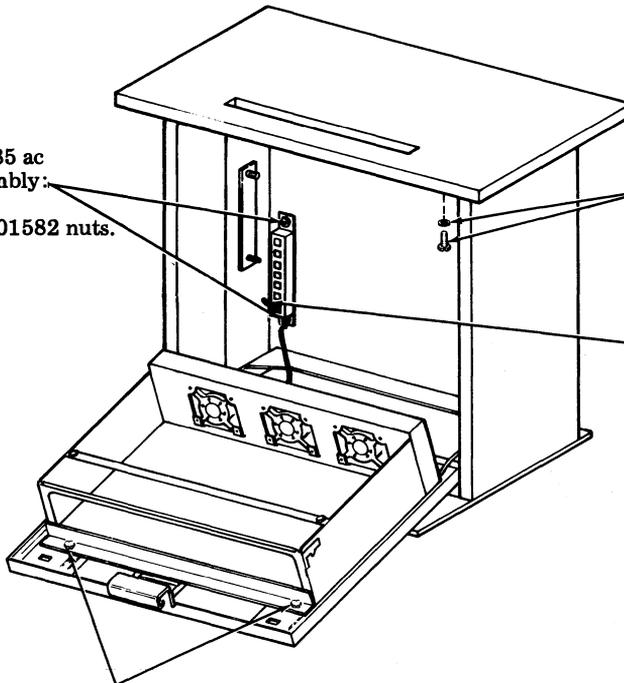
(Late Design)
To remove 407285 ac
distribution assembly:

- ① Remove two 401582 nuts.

To remove table tops:

Remove four 2449
lockwashers and four
162730 screws.

ON-OFF
SWITCH

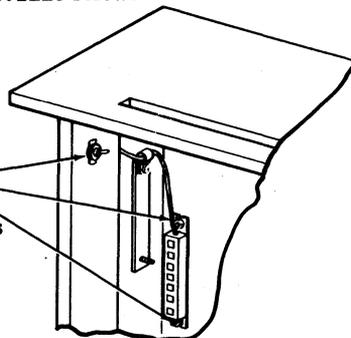


To remove ventilation assembly
and electronics package assembly:

Remove two 401225 screws.

(Early Design)
To remove 401665 ac
distribution assembly:

- ① Remove two 401582 nuts
and 408052 ac switch
assembly w/hardware.
- ② Remove hardware and
cable clamp.



CABINET (Pedestal Type) SUBASSEMBLIES

4.15 40CAB901/XX and 40CAB902/XX

④ If cover is present, remove front two captive screws and two rear screws. Retain cover and screws.

③ Remove two screws, retain.

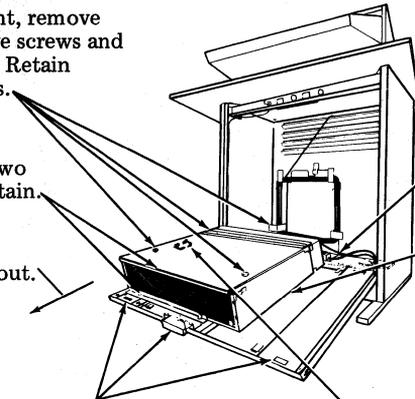
⑥ Slide package out.

① Slide tabs inward and open panel CAREFULLY (attached electronics package weighs approximately 30 pounds) by pressing handle up.

② Disconnect cables at the rear of electronics package.

⑤ If data set present, remove the two screws holding the bracket to cabinet door. Loosen two screws on the inside of electronics package. Lift bracket up and remove, retain all parts.

⑦ Disconnect cable from fan to power supply.



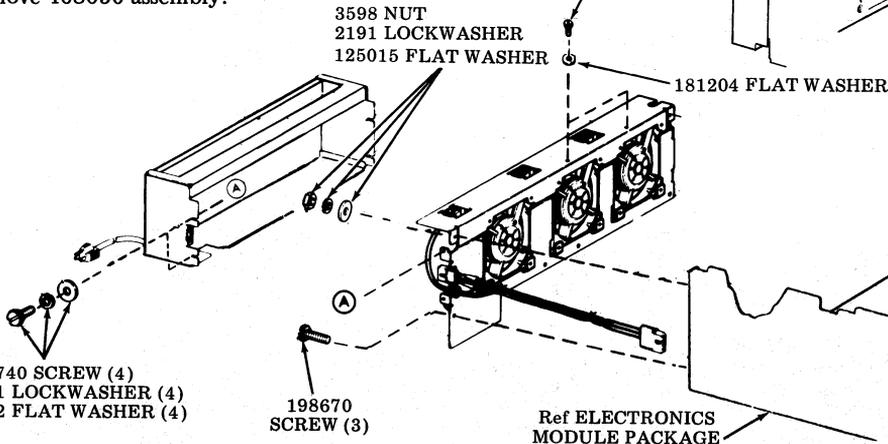
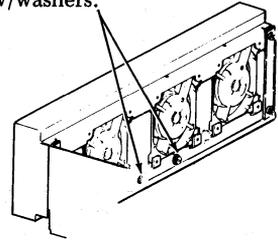
4.16 Ventilation Assembly Removal — 40CAB901/XX

① Remove four 156740 screws, four 2191 lockwashers and four 7002 flat washers. Remove 408030 fan guard assembly.

② Remove 3598 nut, 2191 lockwasher, 125015 flat washer and three 198670 screws.

③ Loosen two 341819 shoulder screws and remove 408050 assembly.

Note: On ROP electronics package, remove two 198670 screws w/washers.



156740 SCREW (4)
2191 LOCKWASHER (4)
7002 FLAT WASHER (4)

198670 SCREW (3)

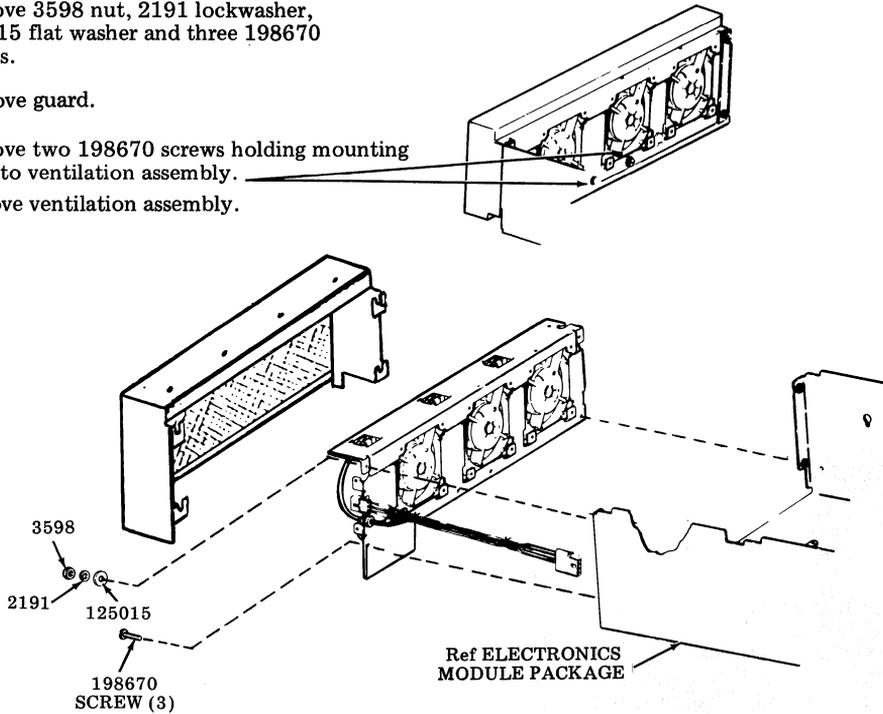
Ref ELECTRONICS MODULE PACKAGE

4.17 Ventilation Assembly Removal — 40CAB902/AB

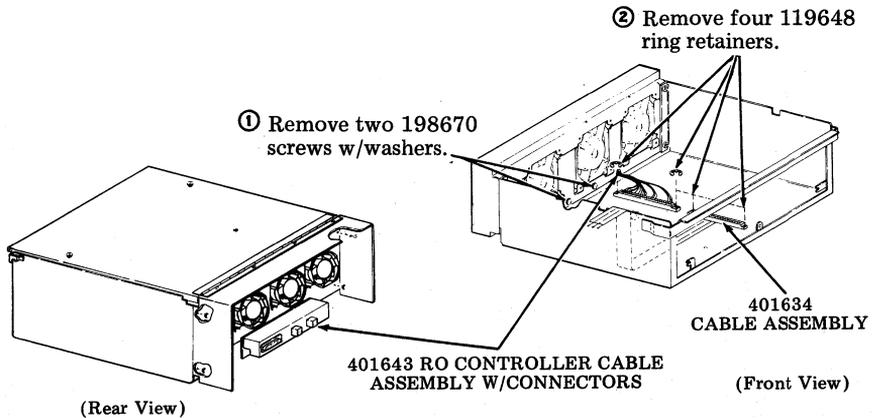
Remove 3598 nut, 2191 lockwasher, 125015 flat washer and three 198670 screws.

② Remove guard.

Remove two 198670 screws holding mounting plate to ventilation assembly.
Remove ventilation assembly.



4.18 ROP Controller Interface and Power Supply Cable:



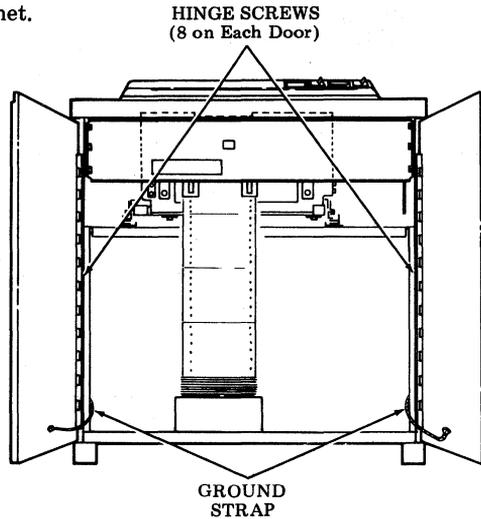
ROP ELECTRONICS LOGIC PACKAGE

FORMS ACCESS PRINTER CABINET

4.19 40CAB302/ZZ Forms Access Cabinet.

To remove access doors:

Remove respective hinge mounting screws and their respective ground straps from the cabinet.

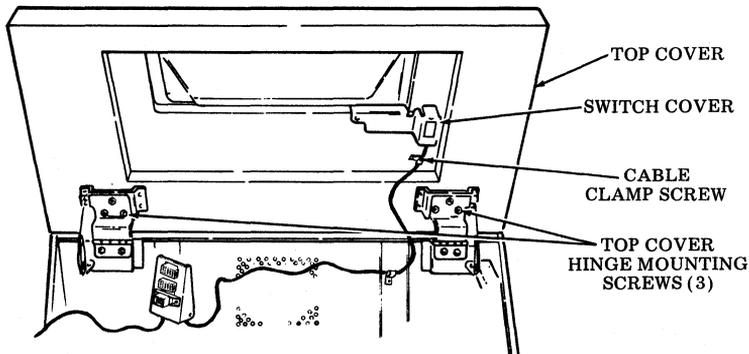


Note: Refer to 5. PARTS IDENTIFICATION for hardware numbers.

4.20 40CAB302/ZZ Forms Access Cabinet

To remove top cover from cabinet:

- ① Remove two screws holding the switch cover.
- ② Remove cable clamp screw.
- ③ Disconnect cable assembly terminals from respective component terminals on forms chute.
- ④ Remove six top cover hinge mounting screws.



Note: Refer to 5. PARTS IDENTIFICATION for hardware numbers.

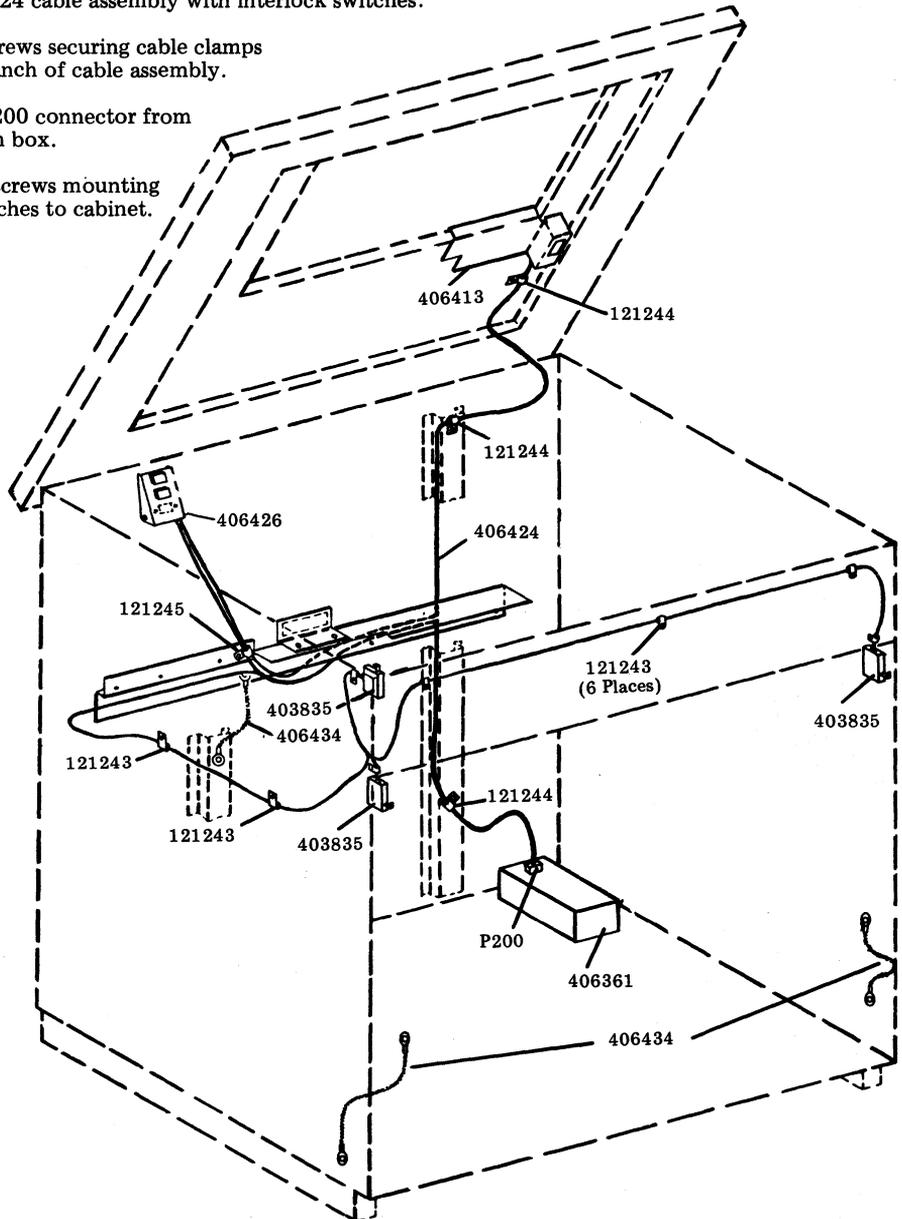
4.21 40CAB302/ZZ Forms Access Cabinet

To remove 406424 cable assembly with interlock switches:

Remove all screws securing cable clamps from each branch of cable assembly.

Disconnect P200 connector from ac distribution box.

Remove two screws mounting interlock switches to cabinet.



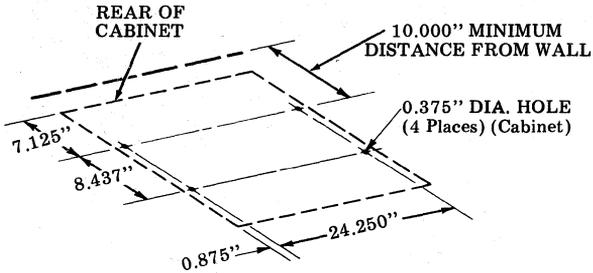
Note 1: To reinstall the 406424 cable assembly, reverse the above procedure.

Note 2: Refer to 5. PARTS IDENTIFICATION for hardware numbers.

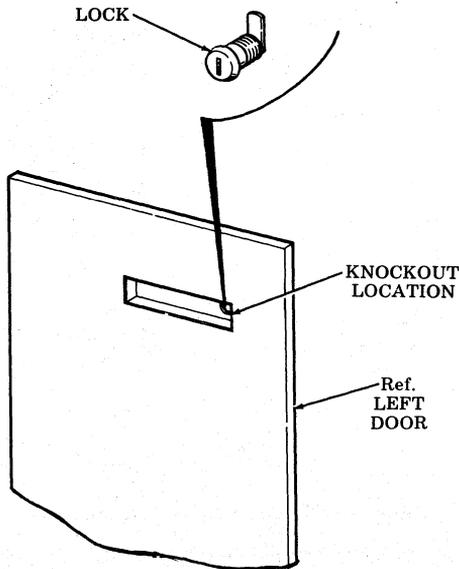
4.22 40CAB302/ZZ Forms Access Cabinet

- The 40CAB302/ZZ cabinets are provided with three security features that customers may desire for their installation: 1. Holes for securing cabinet to the floor, 2. an entry security lock knockout in the left front access door and 3. a secure location for the electrical forms switch.

Cabinet floor securing hole data.

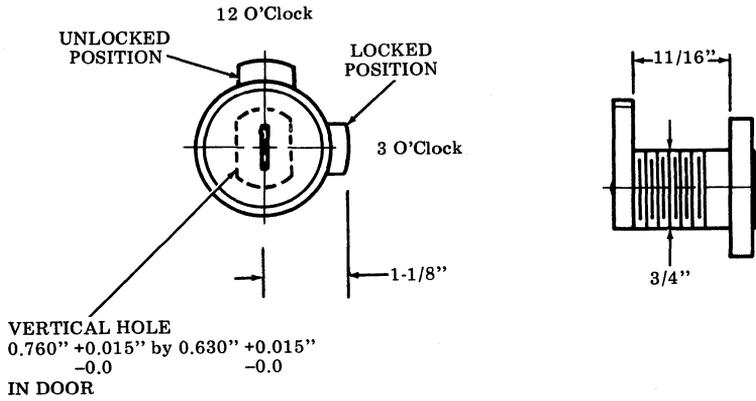


- ② To acquire entry security, remove the lock mounting hole knockout plug located in the handle well of the left front access door and install lock. Teletype Corporation does not supply the lock. Lock configuration is on the following page.

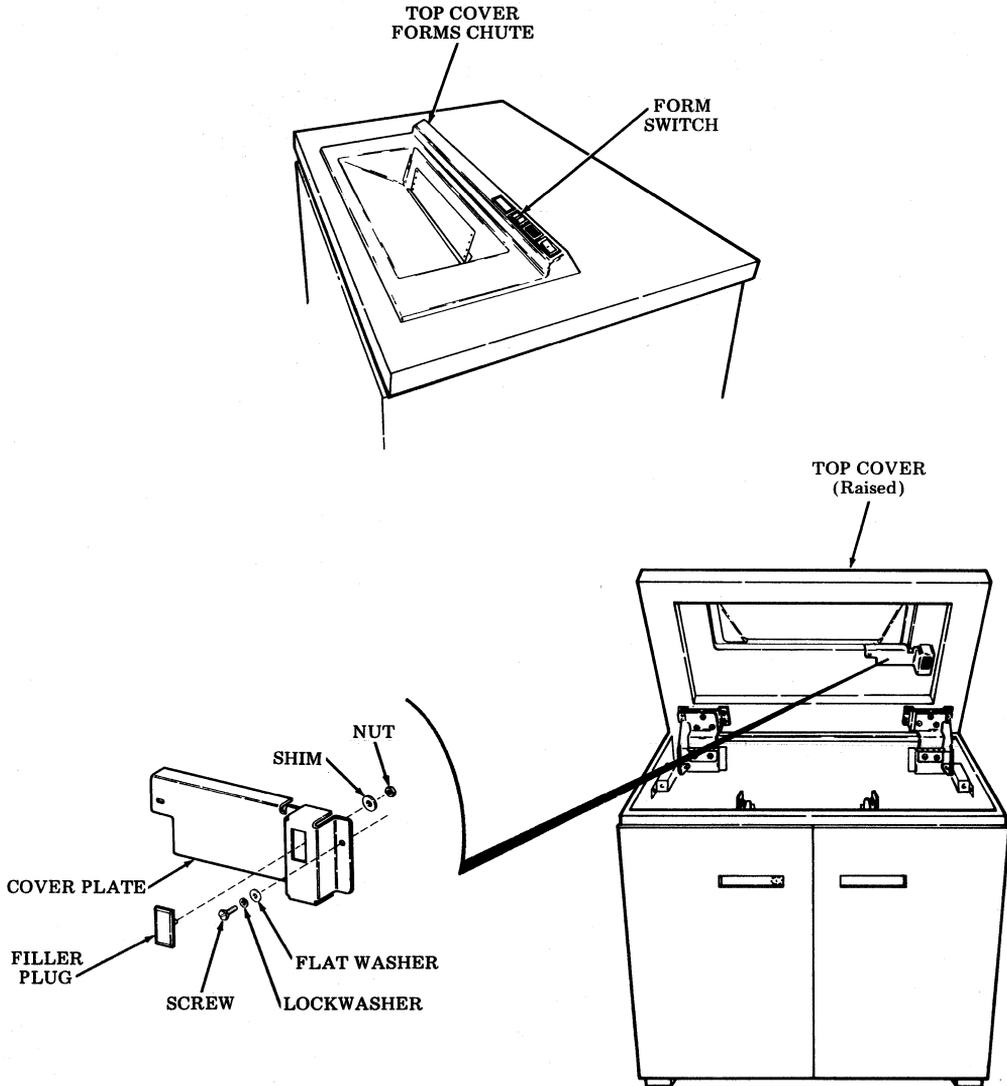


Lock Configuration

Key Removable in Locked Position Only



- ③ The FORM switch securing procedure is as follows: Disassemble cover plate with filler plug from the bottom side of cabinet top cover by removing two screws, lockwashers and flat washers. Disconnect the two terminals of the FORM switch and carefully remove FORM switch from the top cover forms chute. Remove the shim and nut that secure the filler plug to the cover plate and reassemble the filler plug in the hole vacated by FORM switch on the top cover forms chute. Insert FORM switch in cover plate and reconnect the two terminals. Reassemble the cover plate to the top cover and tighten mounting screws.



4.23 The 40CAB302/ZZ forms access cabinet with 406374 modification kit will provide paper-out contact closure below print line in the forms access printer cabinet.

4.24 This cabinet is arranged for use with the 40P253 forms access printer.

4.25 This printer differs from the rest of the 40-type printers principally in that it pushes rather than pulls the forms through the machine.

4.26 This pushing action means that the last form cannot clear the printing line and some information could be lost. For example, if the printer is printing six-inch forms, normal operation occurs until the last form clears the form out switch (this would occur after about 1-1/2 to 2 inches of copy has been printed).

• Option 48 on 410071 Printer Logic Circuit Card

(a) If the option switch had been selected to immediately drop all further data receiving (SWE9-9 Closed), the operator must now replenish the paper supply and in some fashion, retrieve the information printed on the last (wasted) form so that it may be printed on the new stock.

(b) Similarly, if the option switch had been selected so that the paper-out is gated with end of form (SWE9-9 Open), all the information would be sent, but the form would not move past the print line as the tractors end about 3-1/2 inches from the print line. Again, data retrieved of the last form's data would be required.

4.27 This modification kit is intended to operate the form out switch about 11 inches from the print line so that with the option switch set as in (b) of the preceeding paragraph, data being sent will be correctly printed on a form and no partial information will be printed on the last form.

4.28 This modification kit will operate as intended with forms up to and including 11 inches long. Forms longer than 11 inches will again be subjected to the condition explained. Forms shorter than 11 inches may result in more than one form being "wasted" at the end of a box. (Example: Using five-inch forms will result in the loss of the last two forms.)

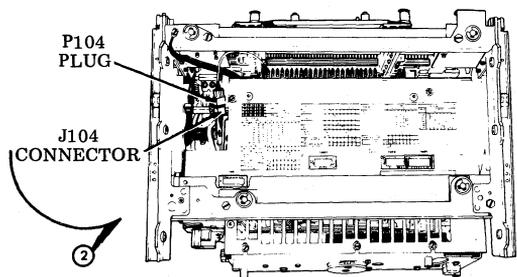
4.29 The 406374 modification kit consists of the following parts:

Qty	Part No.	Description
2	3606	Nut
2	198670	Screw W/Washer
1	406447	Paper-Out Assembly

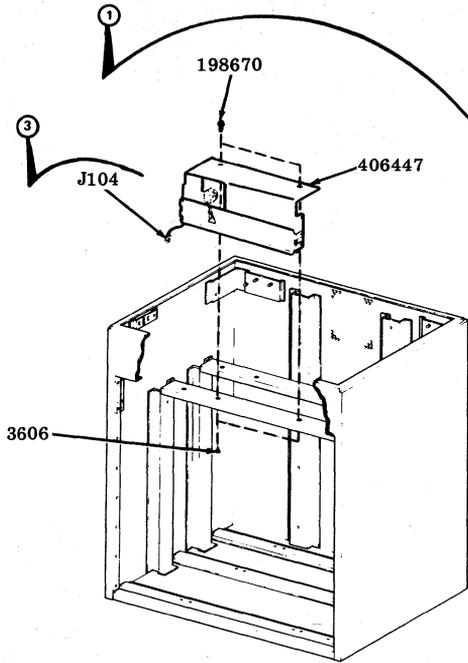
Assembly

4.30 Assembly of the 406374 modification kit requires the following steps:

- ① Take the 406447 paper-out switch assembly and mount to the front printer support bar using two 198670 screws with washers and two 3606 nuts in the holes provided. The bracket should be on top of the bar and the assembly should extend downward.
- ② Disconnect the cable leading from the paper-out switch which is mounted on the left-hand tractor from the printer cable.
- ③ Connect the cable from the new paper-out switch assembly to the printer cable.



Note: Check the Switch Adjustment.



• Reassemble by reversing assembly procedures.

Switch Adjustment

Requirement

With the lever passing from the rear guide into the front paper guide to a flush condition, the "NC" contact must be open. With the lever one stock thickness beyond flush with the front paper guide, the "NC" contact must be closed.

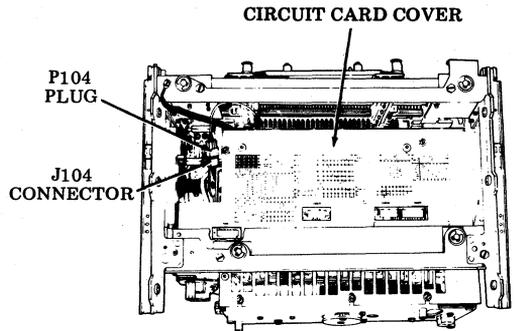
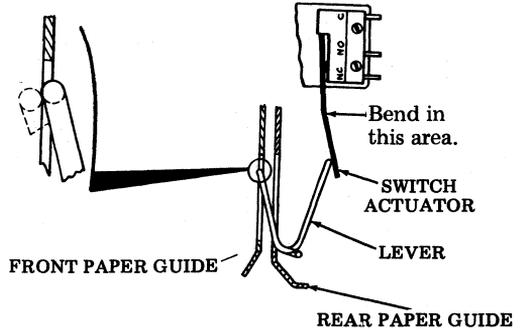
Note: Operation may be determined either by the "clicking noise" or by checking continuity across pins 1 and 4 of J104 cable connector.

To Adjust

Bend switch actuator in area shown.

Special Requirements

A stack of paper or supply box should not exceed 12-1/2 inches in height as this will cause difficulty in threading the paper through the modification kit.



Note: Refer to 5. PARTS IDENTIFICATION for hardware.

5. PARTS IDENTIFICATION

5.01 The following list contains the figure and page numbers of all the part illustrations.

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96	403418 Modification Kit to Provide an Audible Alarm With Integrated Controller	134
100	407105 Modification Kit to Provide Parts for Single-Ply Fanfold Friction Feed Paper Handling	134

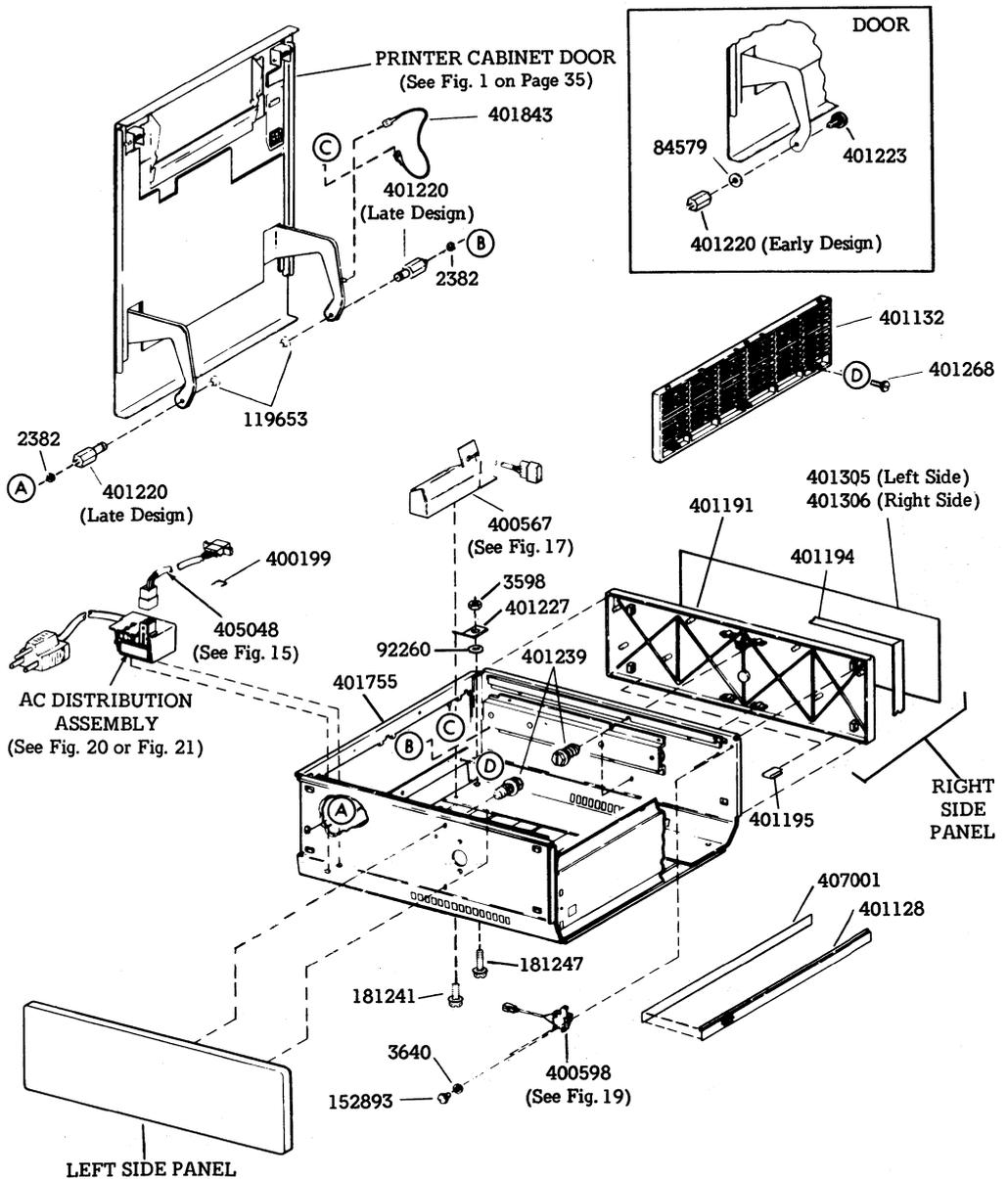


Fig 1-40CAB201/ZZ Printer Cabinet Core for Adjacent or RO Friction Feed Printer

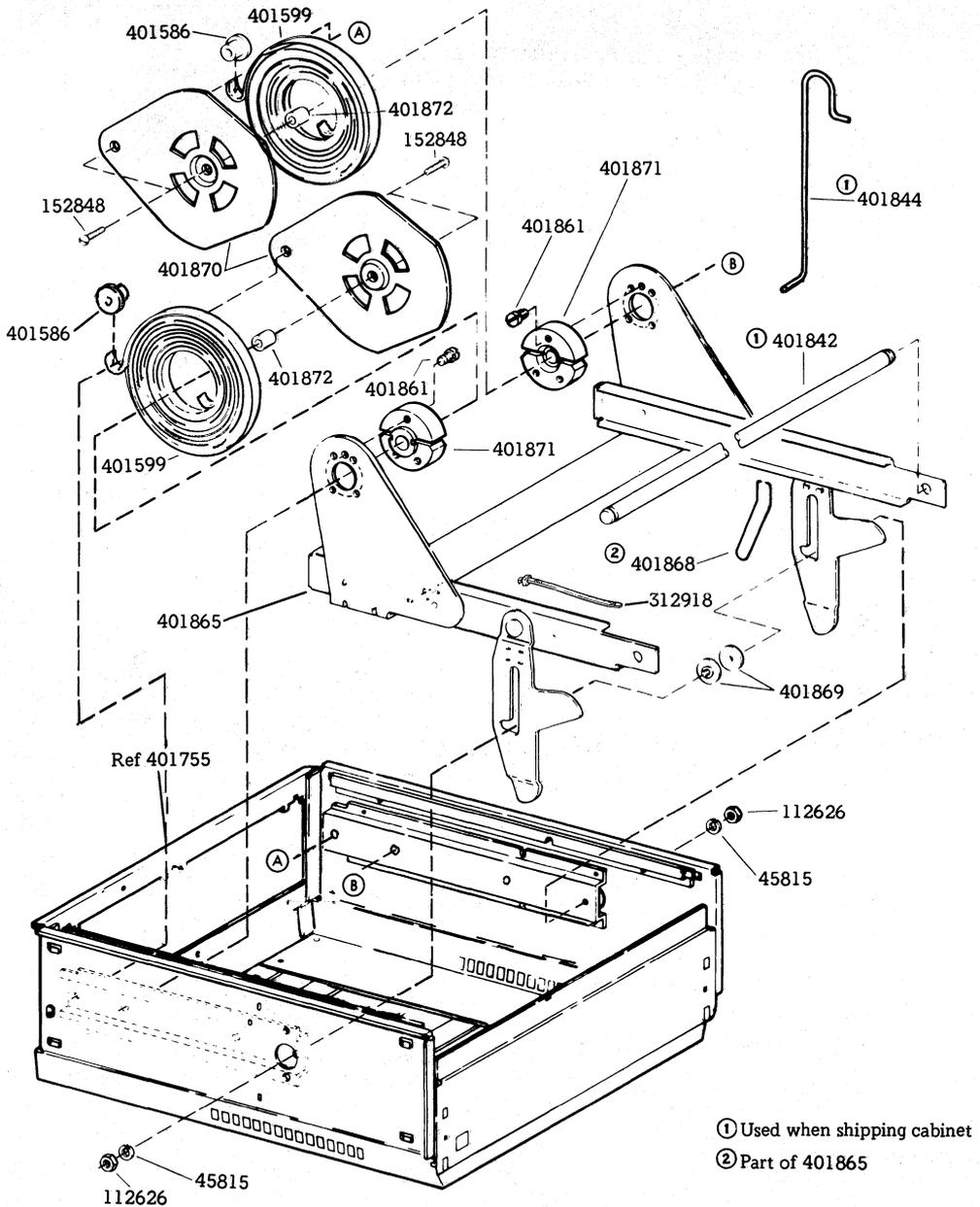


Fig. 1—40CAB201/ZZ Printer Cabinet Core for Adjacent or RO Friction Feed Printer (Cont)

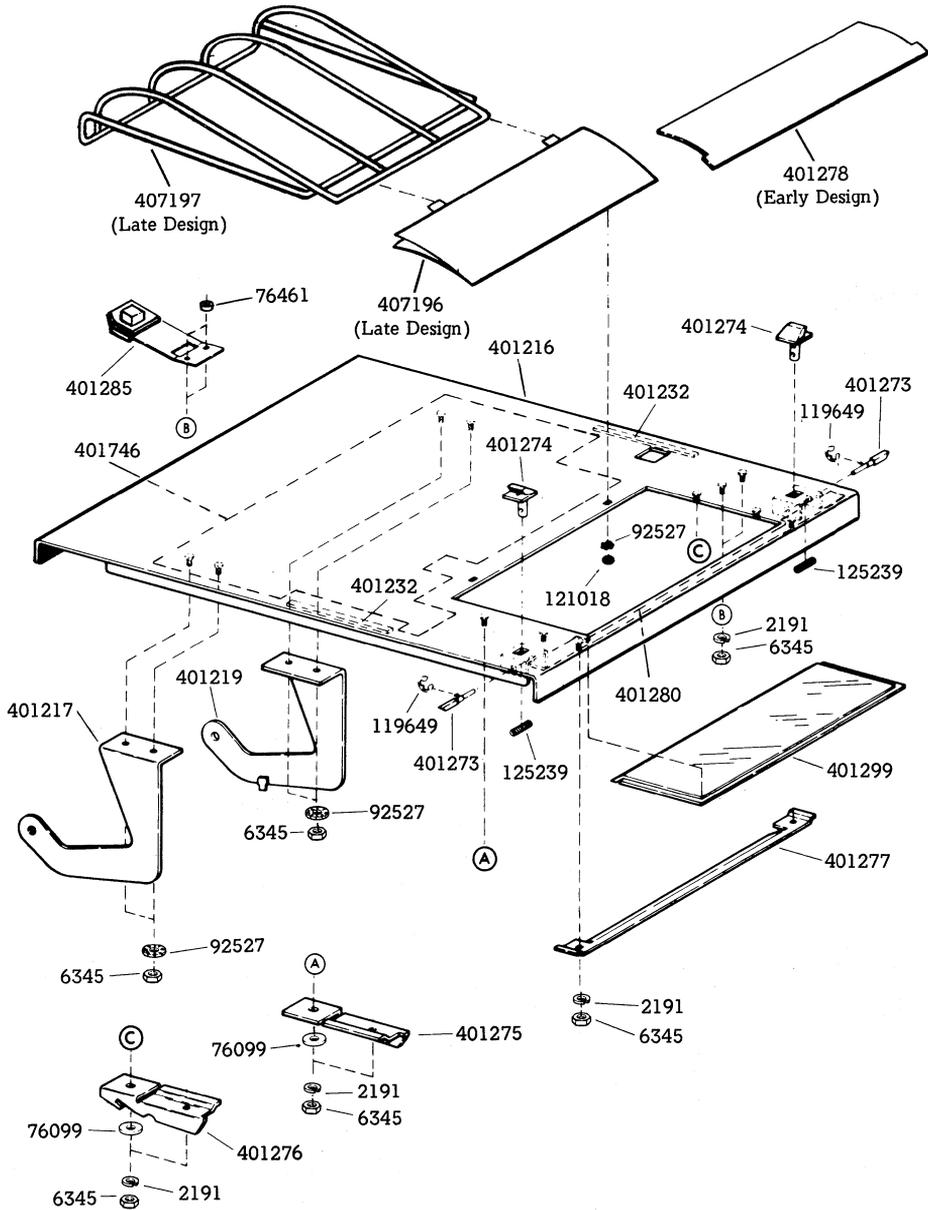


Fig. 1—40CAB201/ZZ Printer Cabinet Core for Adjacent or RO Friction Feed Printer (Cont)

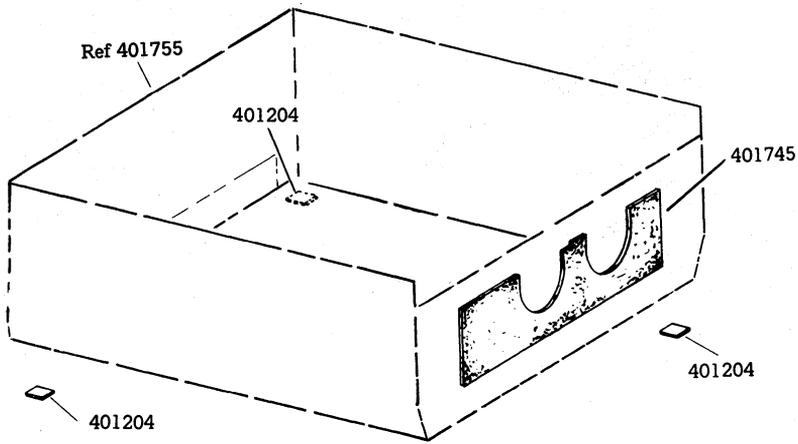


Fig. 1—40CAB201/ZZ Printer Cabinet Core for Adjacent or RO Friction Feed Printer (Cont)

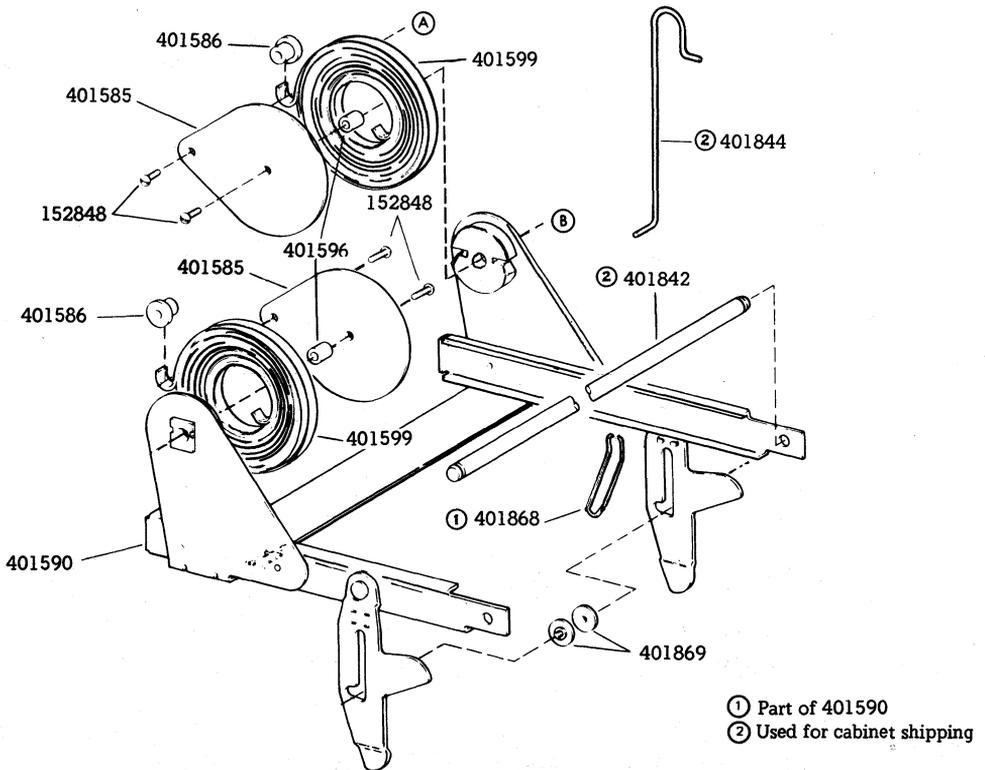


Fig. 2—Early Design Printer Mounting Cradle for Adjacent or RO Friction Feed Printer

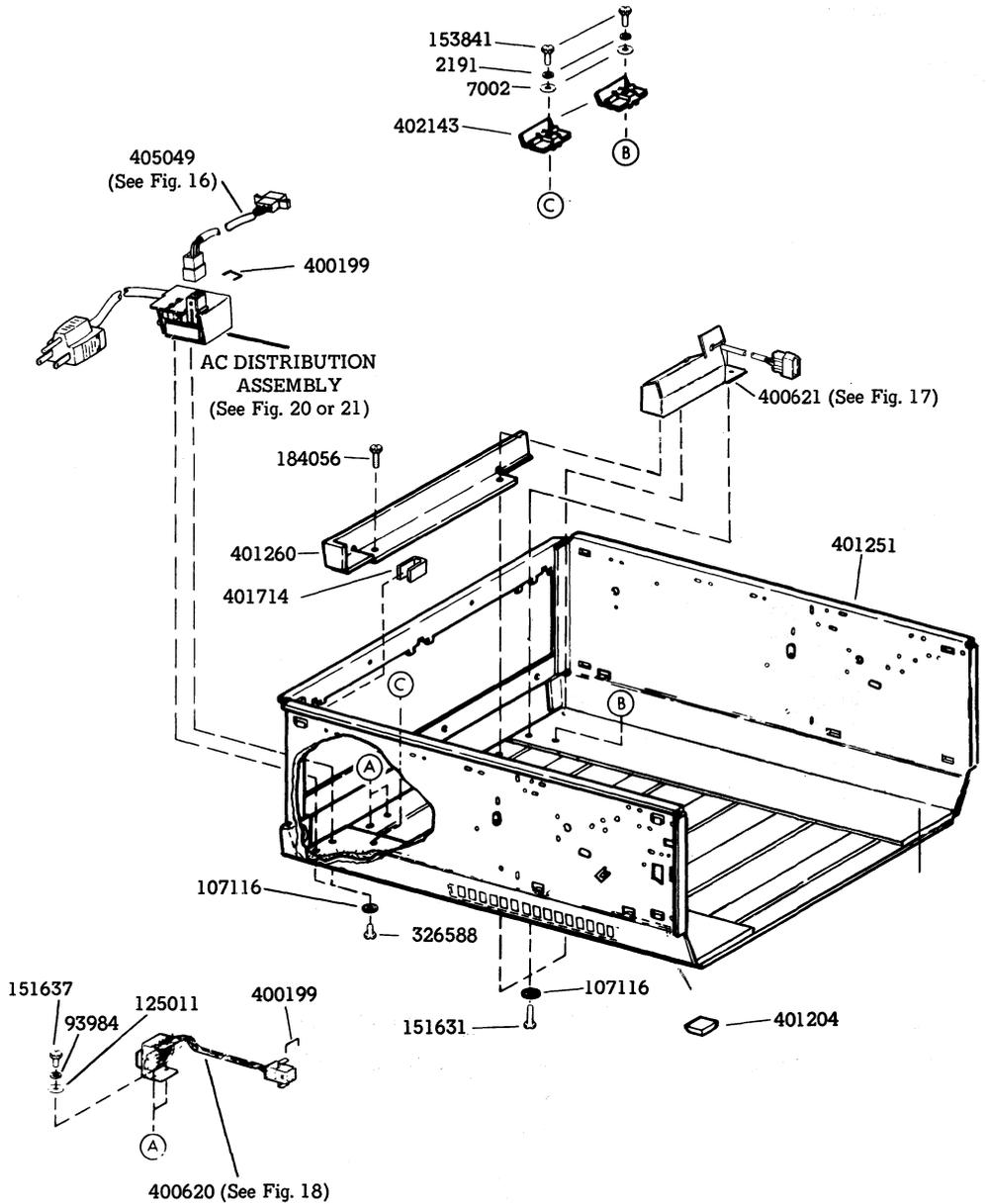


Fig. 3-40CAB251/AA Printer Under Monitor Cabinet

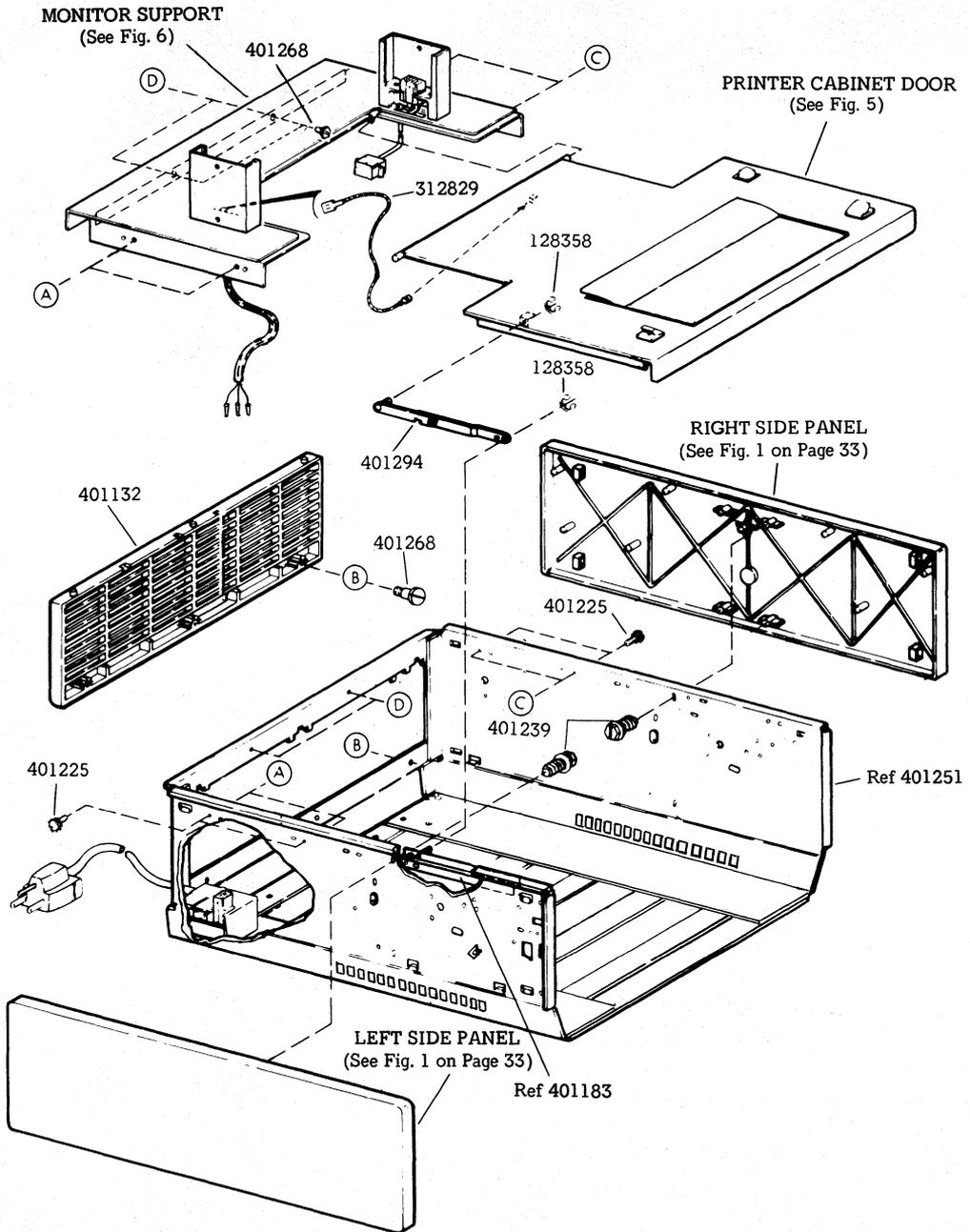


Fig. 3 - 40CAB251/AA Printer Under Monitor Cabinet (Cont)

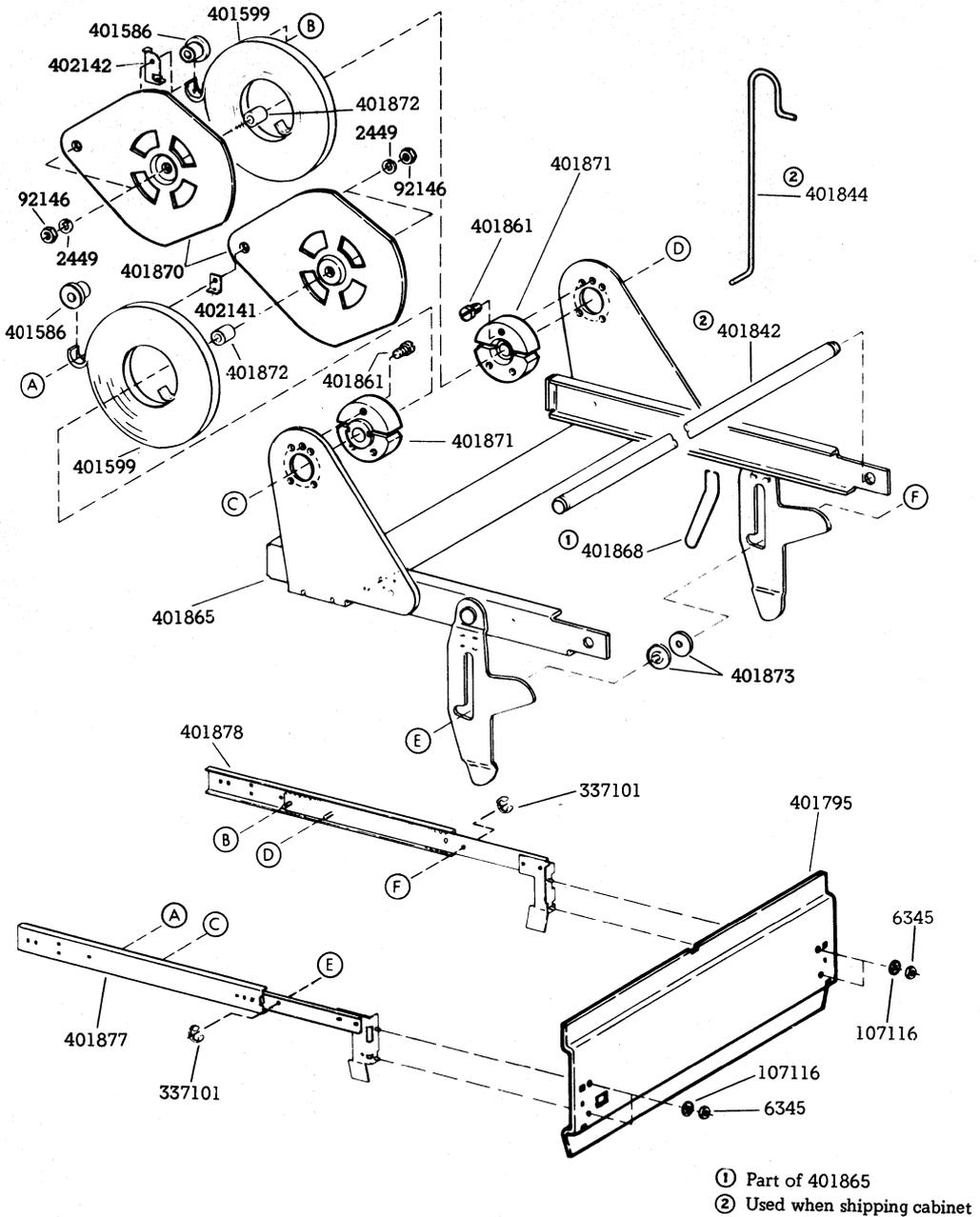


Fig. 4-40CAB251/AA Printer Under Monitor Cabinet Mounting Cradle

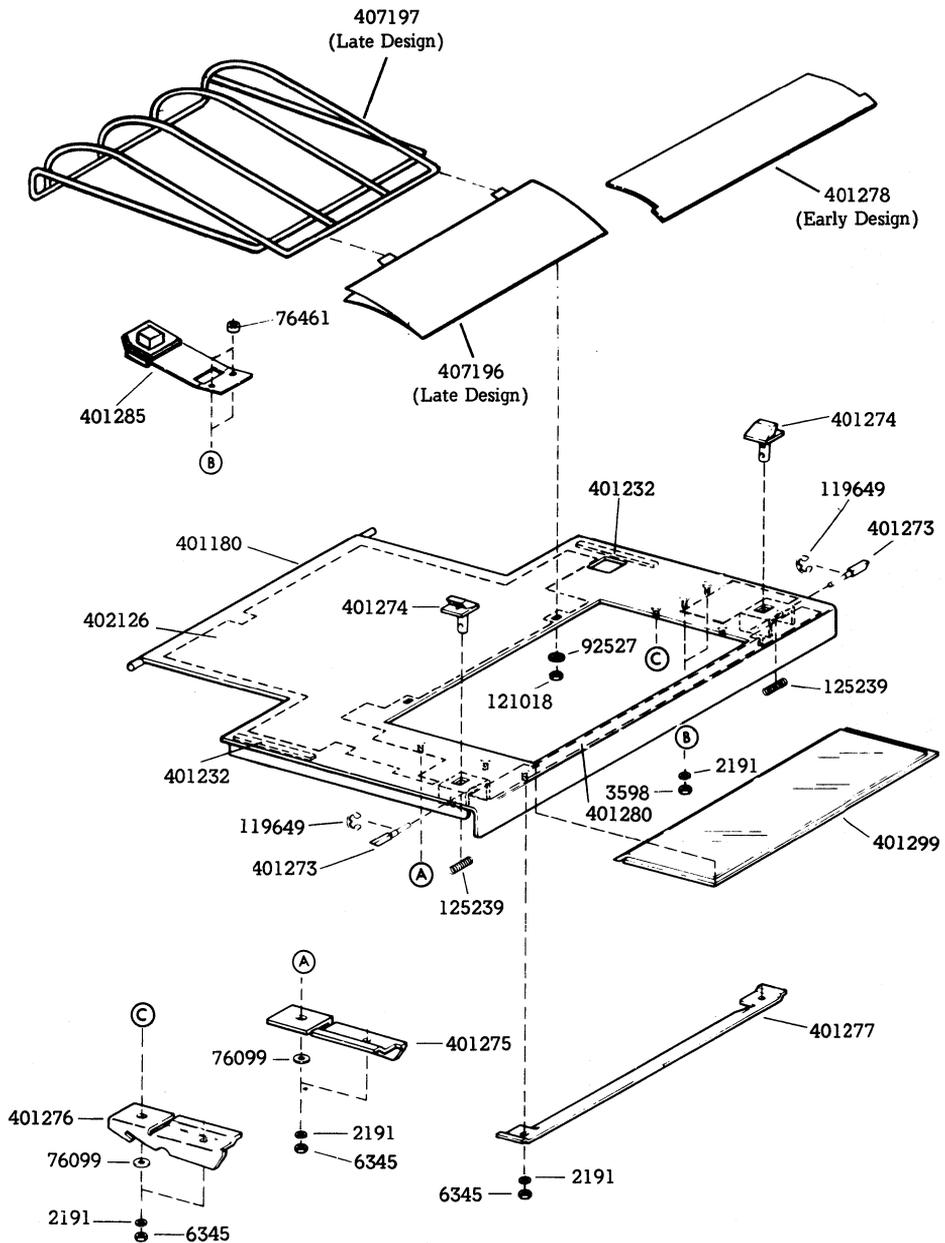


Fig. 5—40CAB251/AA Printer Under Monitor Cabinet Door

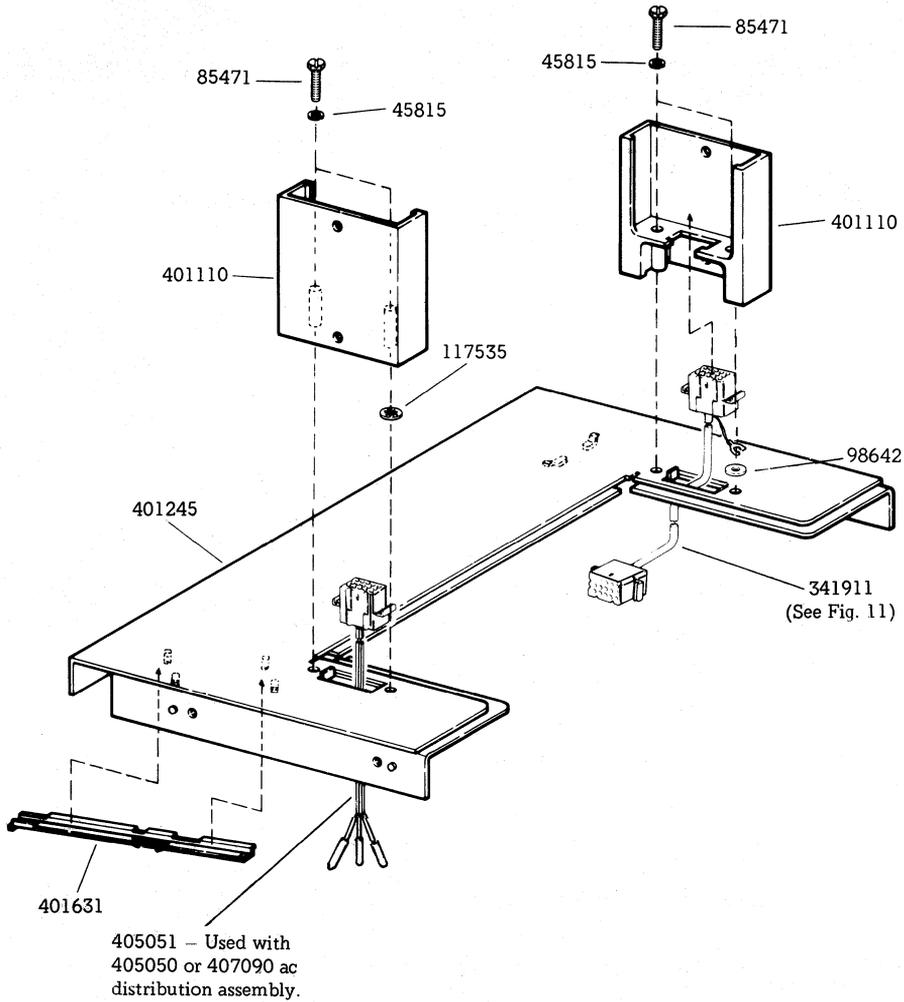


Fig. 6-40CAB251/AA Printer Under Monitor Cabinet Monitor Support

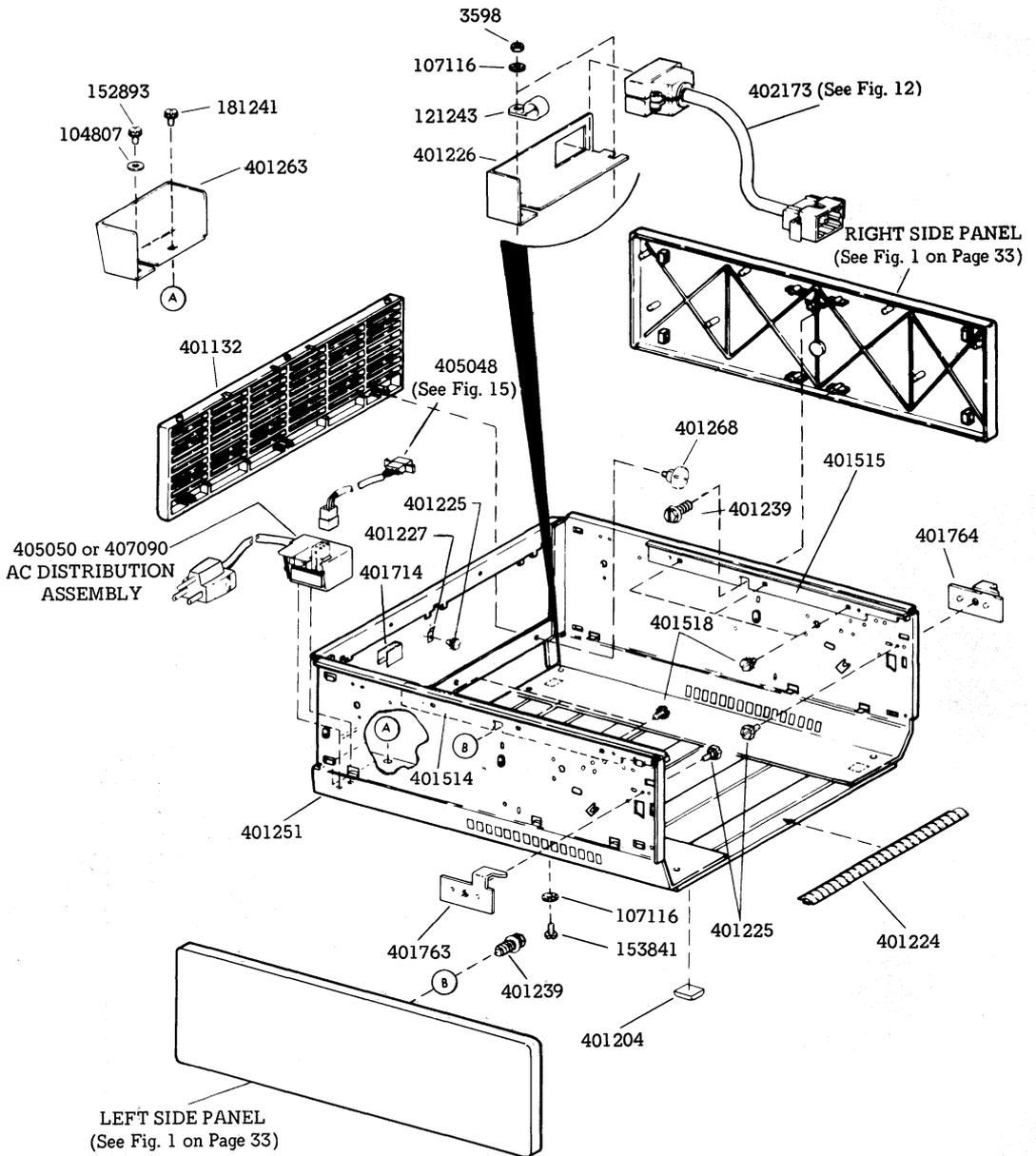


Fig. 7 - 40CAB201/AB Logic Adjacent Cabinet

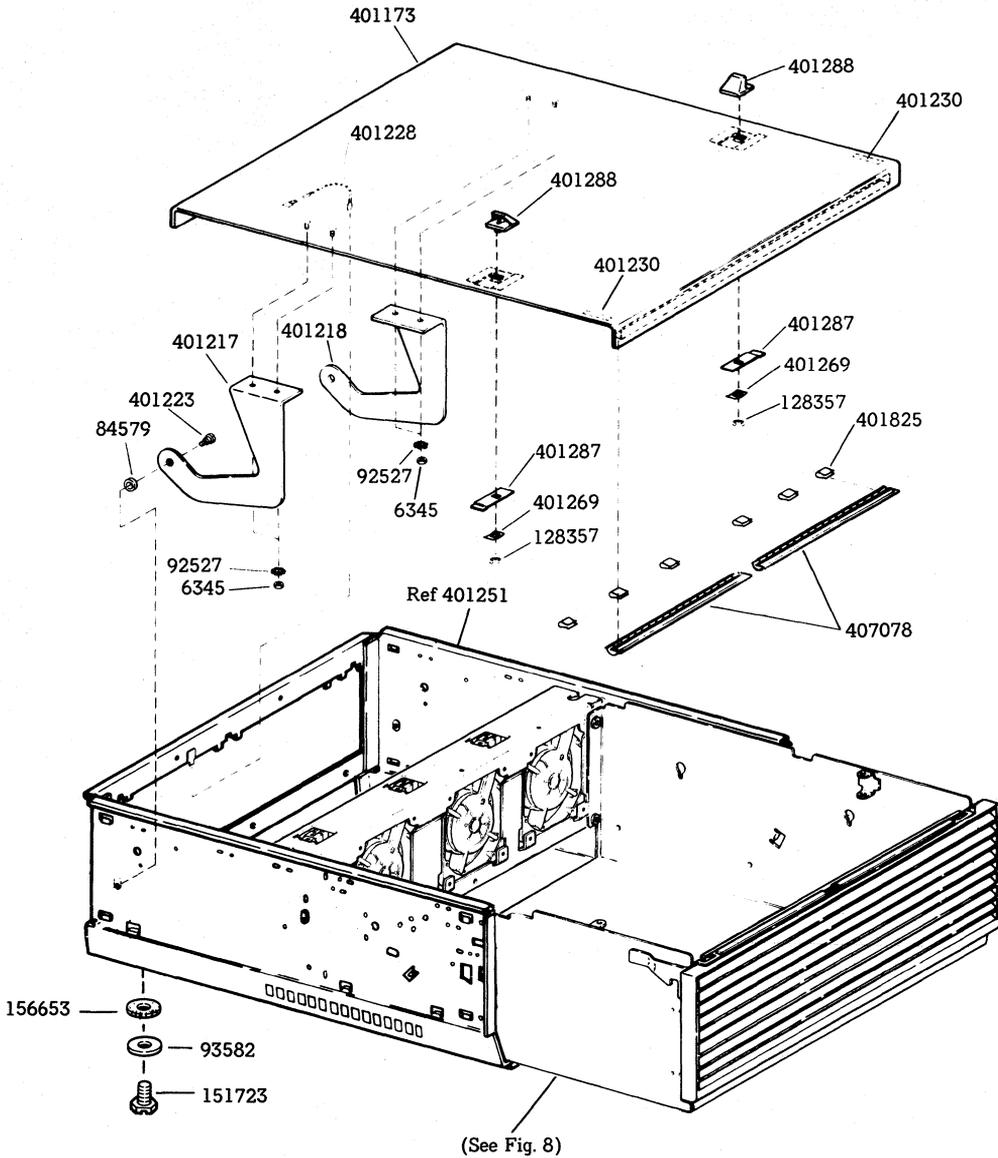


Fig. 7-40CAB201/AB Logic Adjacent Cabinet (Cont)

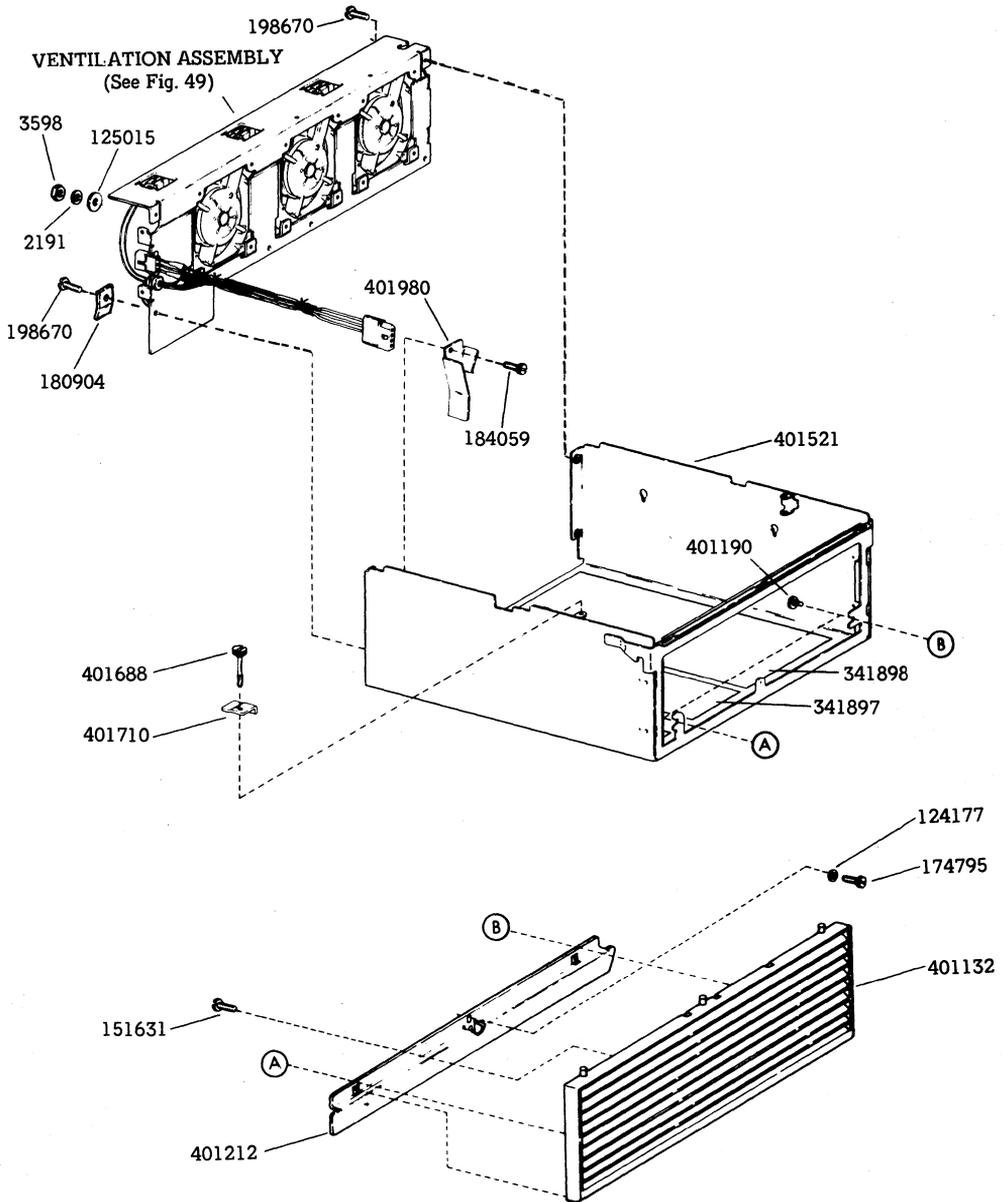


Fig. 8—40CAB201/AB Logic Adjacent Cabinet Module, Louver, and Fan Mounting

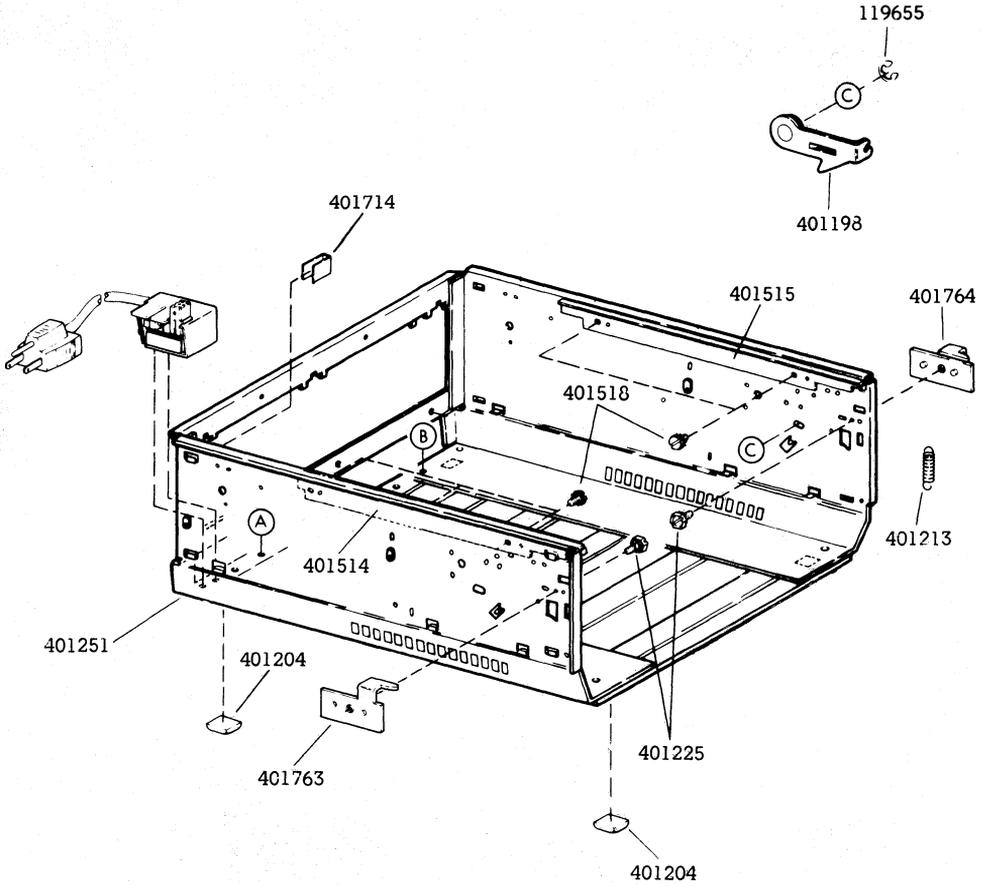


Fig. 9-40CAB251/ZZ Monitor Support Cabinet Core for Logic Under Monitor or Monitor/Opcon Support

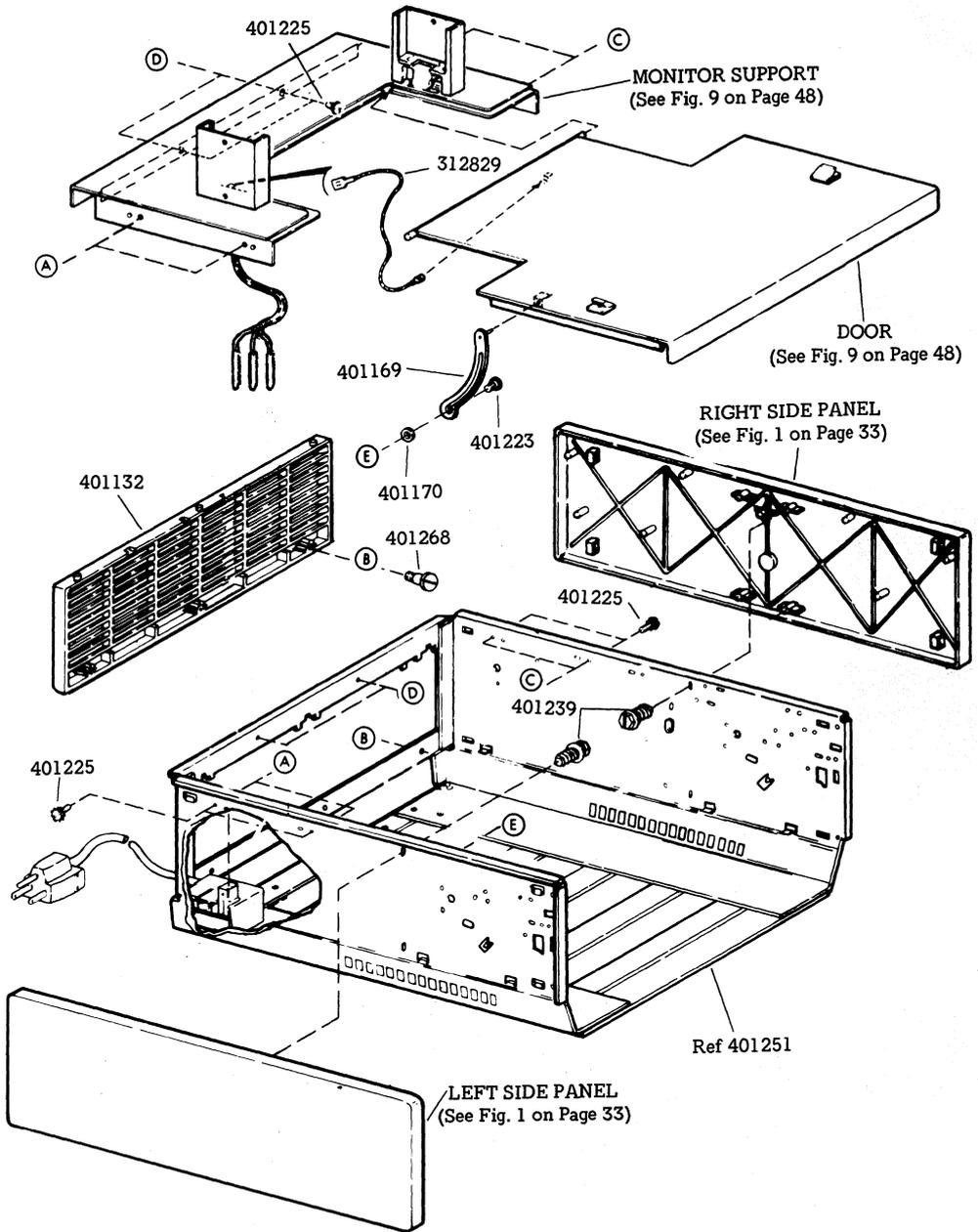


Fig. 9-40CAB251/ZZ Monitor Support Cabinet Core for Logic Under Monitor or Monitor/Opcon Support (Cont)

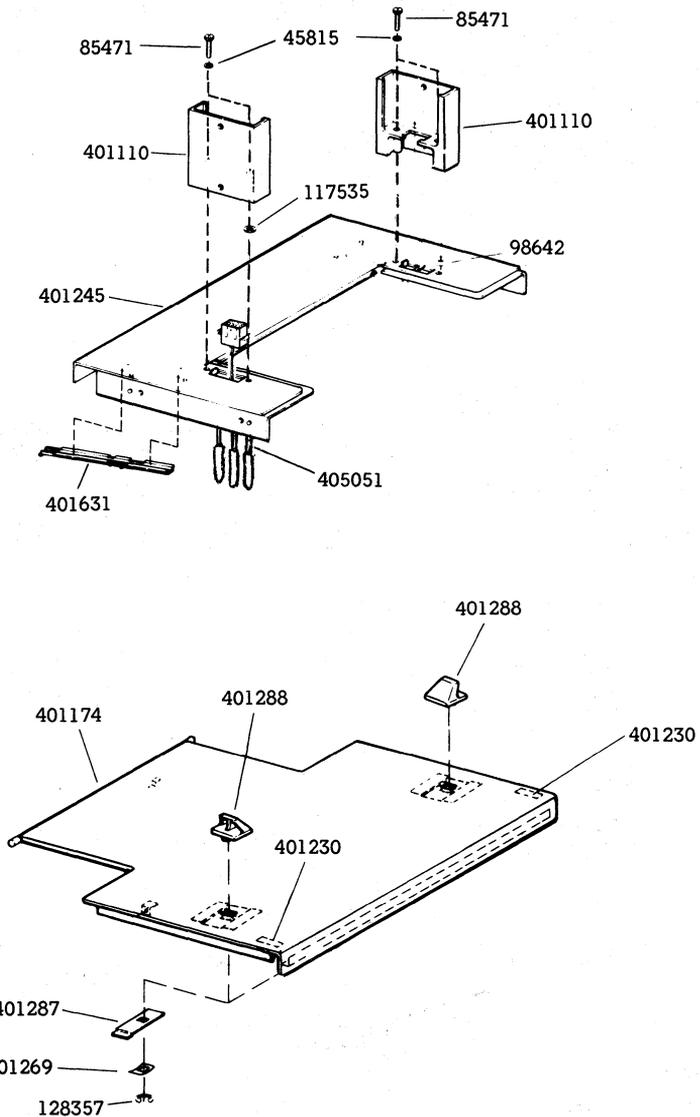


Fig. 9—40CAB251/ZZ Monitor Support Cabinet Core for Logic Under Monitor or Monitor/Opcon Support (Cont)

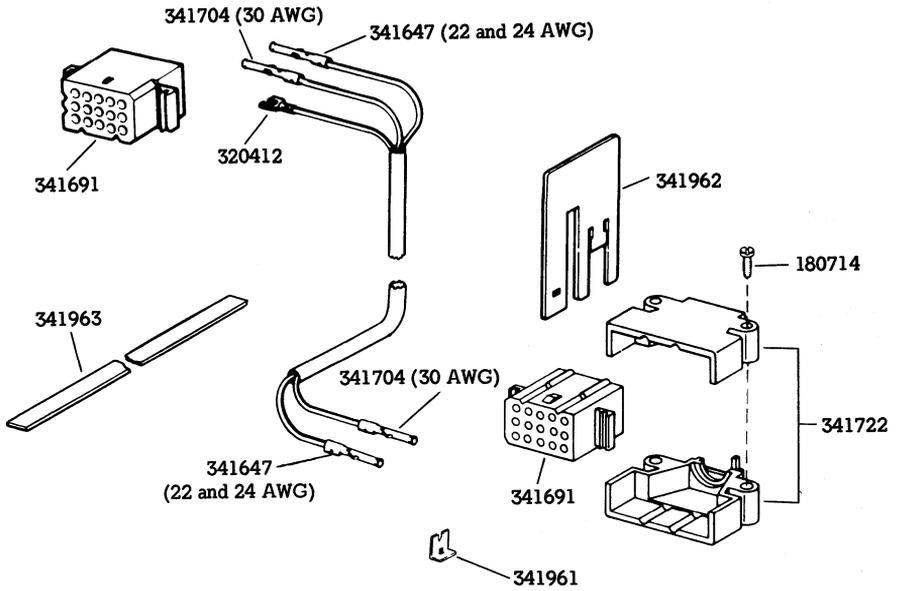


Fig. 10-341891 Monitor Cable - Logic Cabinet (Right Side)

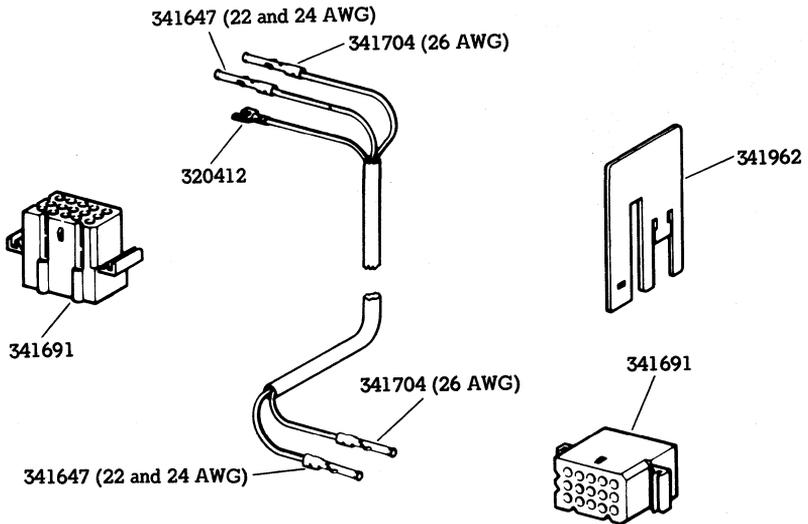


Fig. 11-341911 Monitor Cable - Printer Cabinet (Right Side)

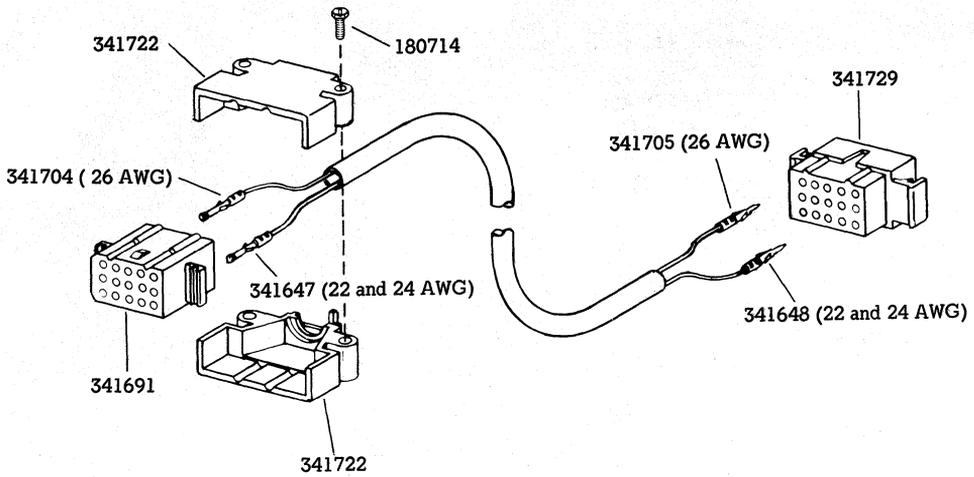


Fig. 12-402173 Monitor Cable (Logic Cabinet Adjacent)

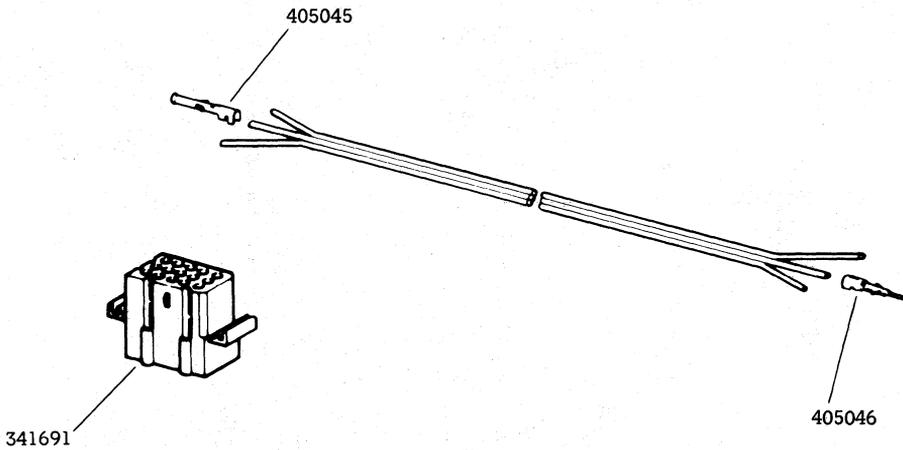


Fig. 13-405051 Monitor Cable - Logic Under Monitor, Printer Under Monitor, or Monitor Support Cabinet (Left Side)

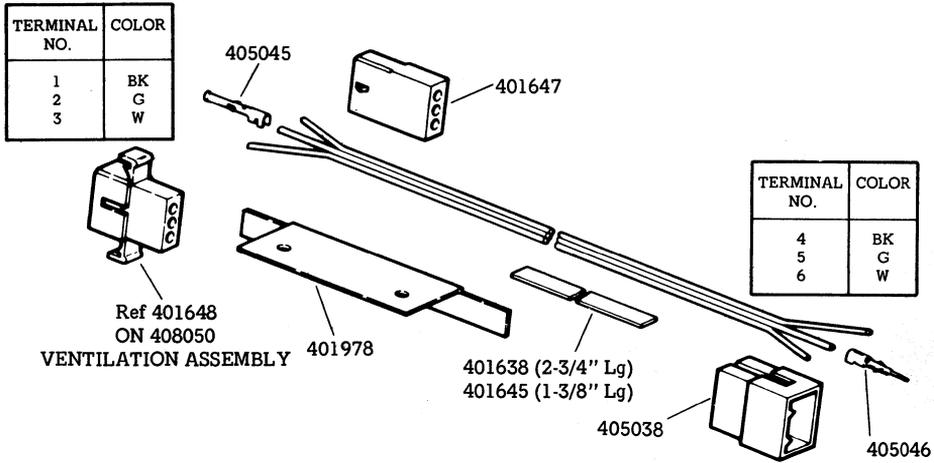


Fig. 14—405047 AC Input Cable Assembly – Logic Under Monitor or Adjacent Logic Cabinet

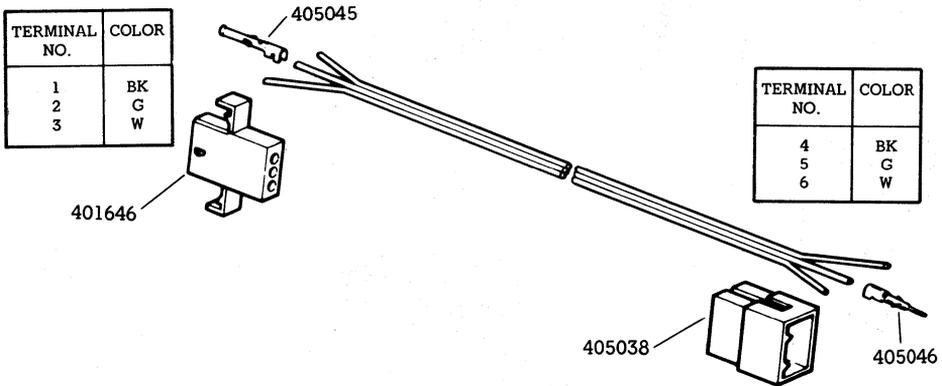


Fig. 15—405048 AC input Cable Assembly – Adjacent or RO Friction Feed Printer Cabinet and Logic Adjacent

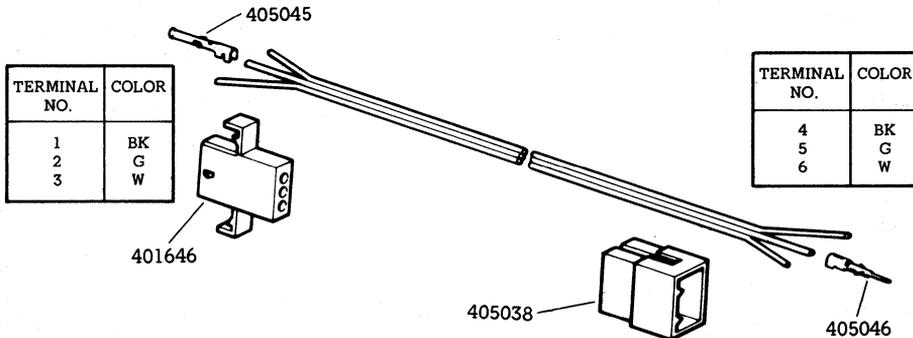


Fig. 16—405049 AC Input Cable Assembly – Printer Under Monitor Cabinet

① The 346318 cover (new) cannot be used with the early design 400567 or 400621 assemblies (which contains a 400576 bracket w/filters).

Filter Wiring Information	
Filter	Color
1	R
2	Y
3	G
4	O

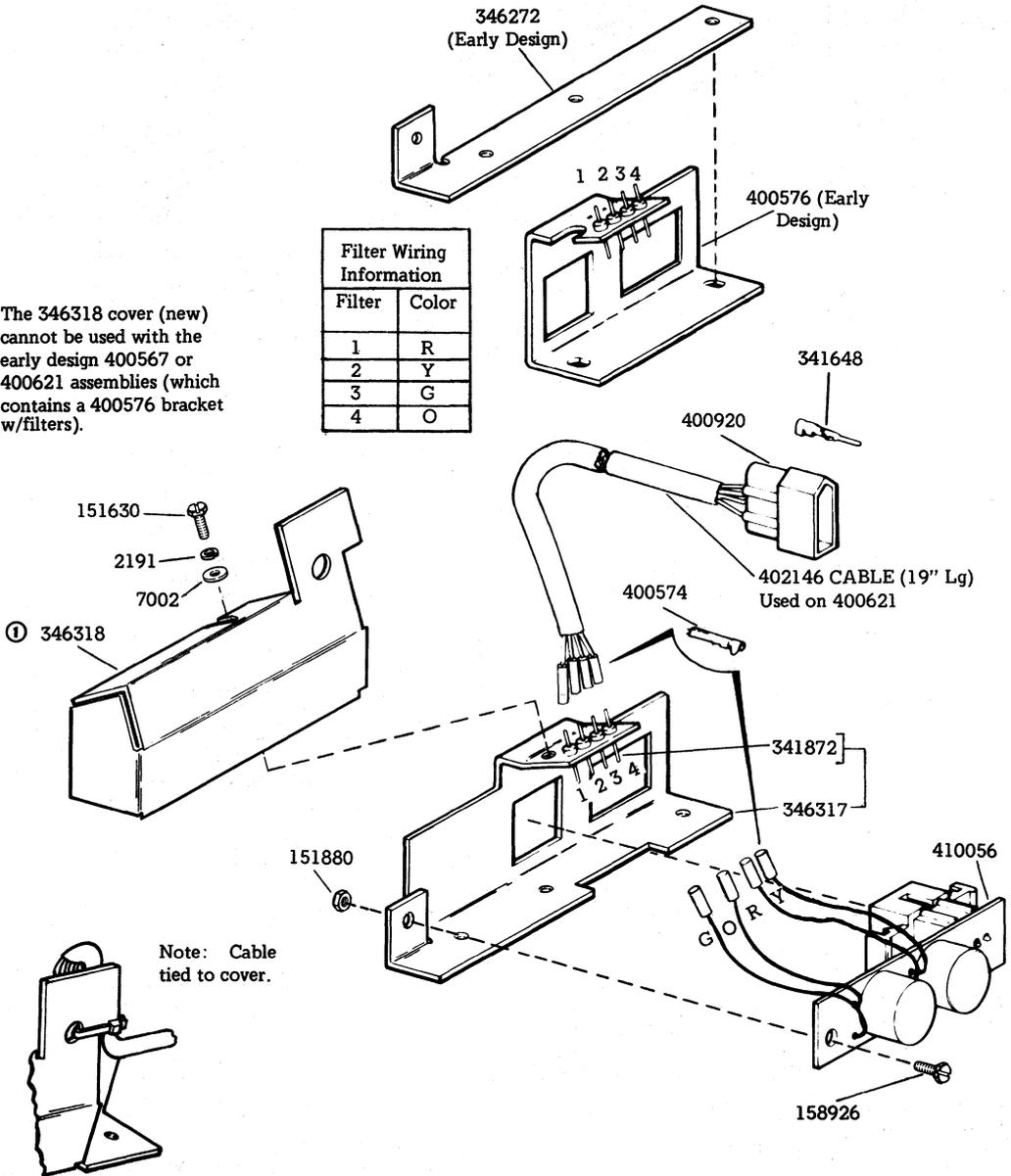
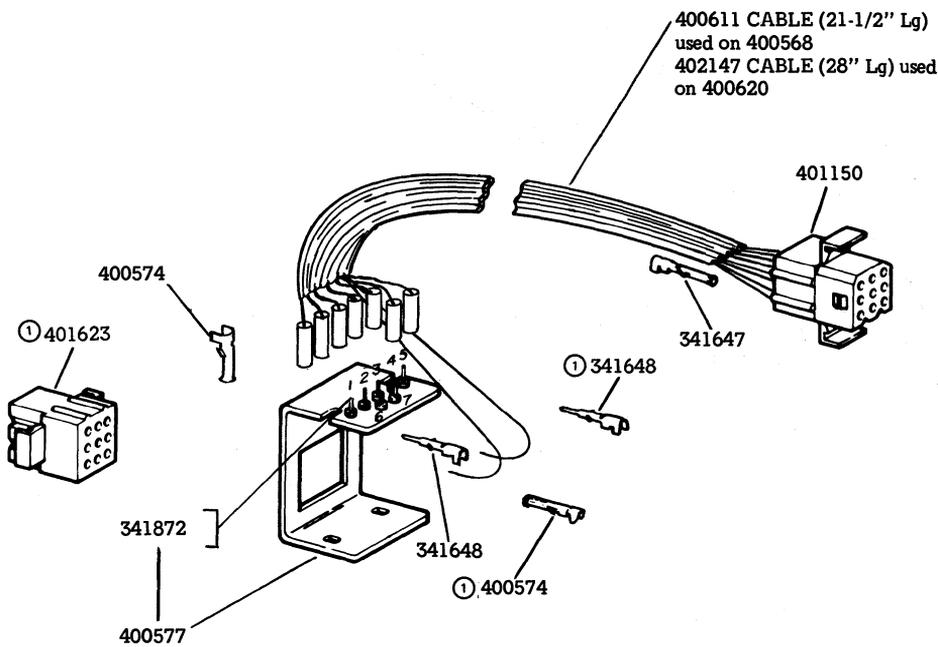


Fig. 17—400621 SSI Cable Assembly for Friction Feed Printer Under Monitor Cabinet

RUNNING LIST		
400607 CABLE ASSEMBLY		
FROM CONNECTOR	TO	COLOR
1	1-L	R
2	2-L	Y
3	3-L	G
4	4-L	W-Y
6	5-L	O
7	6-L	BL
8	7-L	W

FILTER WIRING INFORMATION	
FILTER	COLOR
1	R
2	Y
3	G
4	S
5	P
5	O
6	BL
7	W
9	BK



① 400607 Cable Assembly

Fig. 18—400568 Cable Assembly (Opcon) for RO Friction Feed Printer Cabinet
400620 Cable Assembly (Opcon) for Printer Under Monitor Cabinet

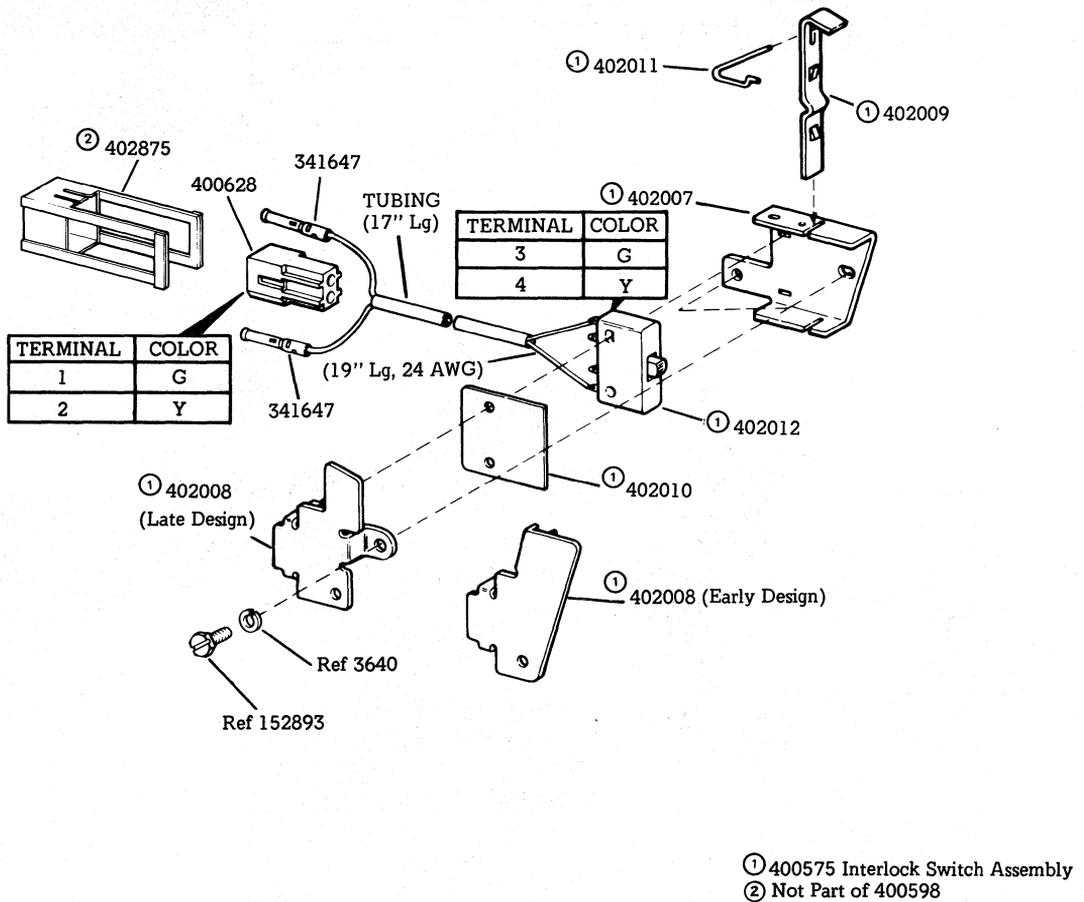


Fig. 19-400598 Interlock Cable Assembly for Friction Feed Printer Cabinet

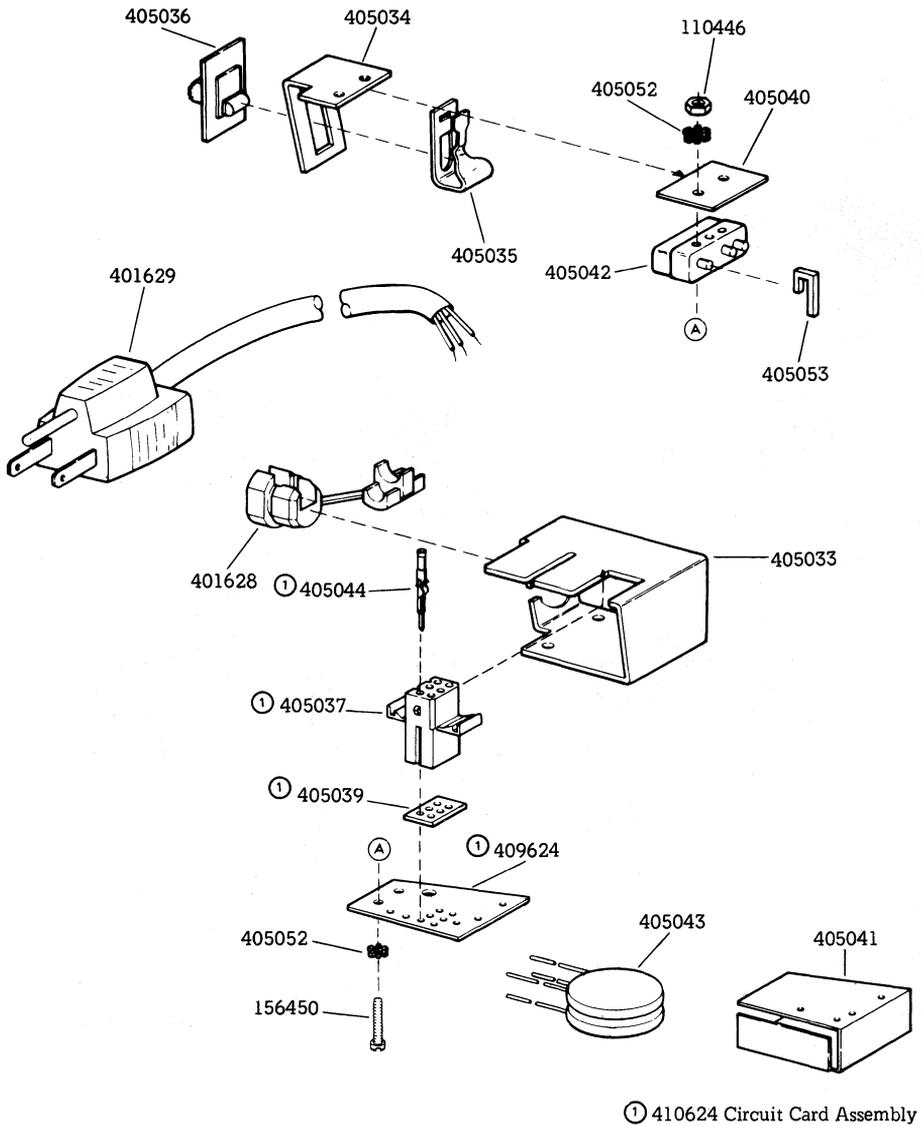


Fig. 20-405050 AC Distribution Assembly (Early Design)

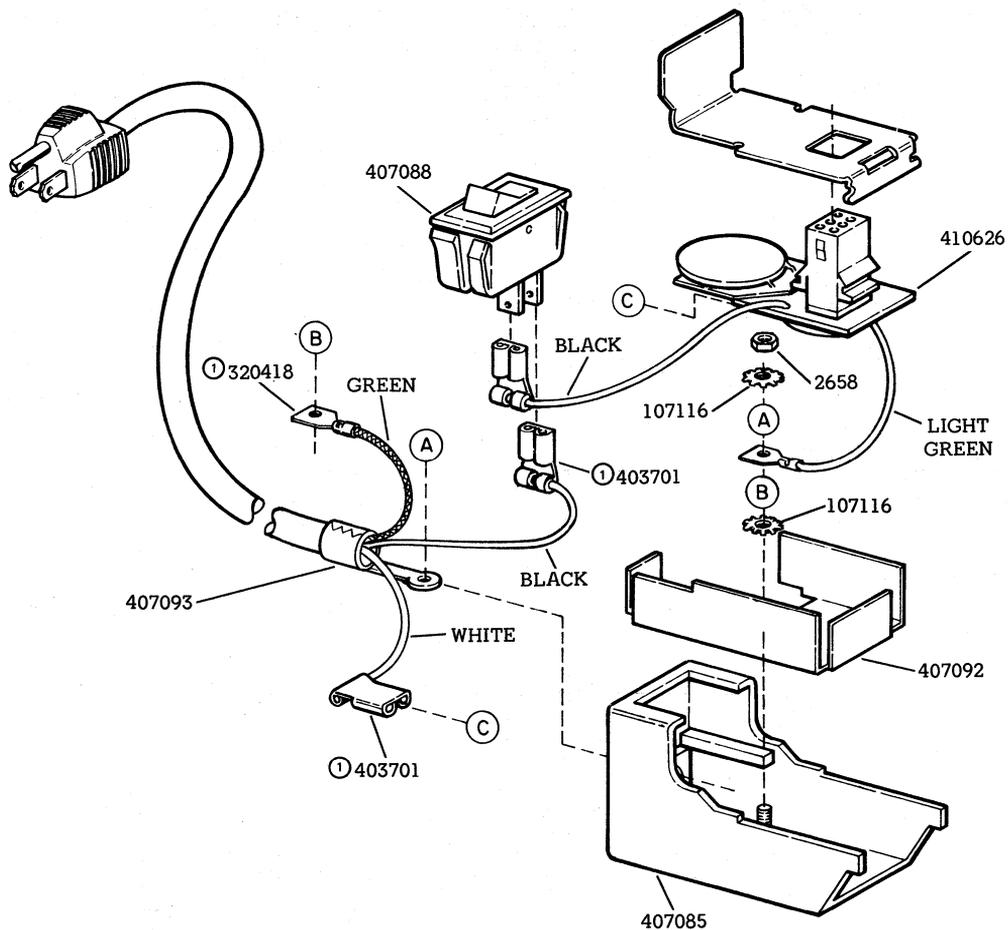


Fig. 21-407090 AC Switch Assembly (Late Design)

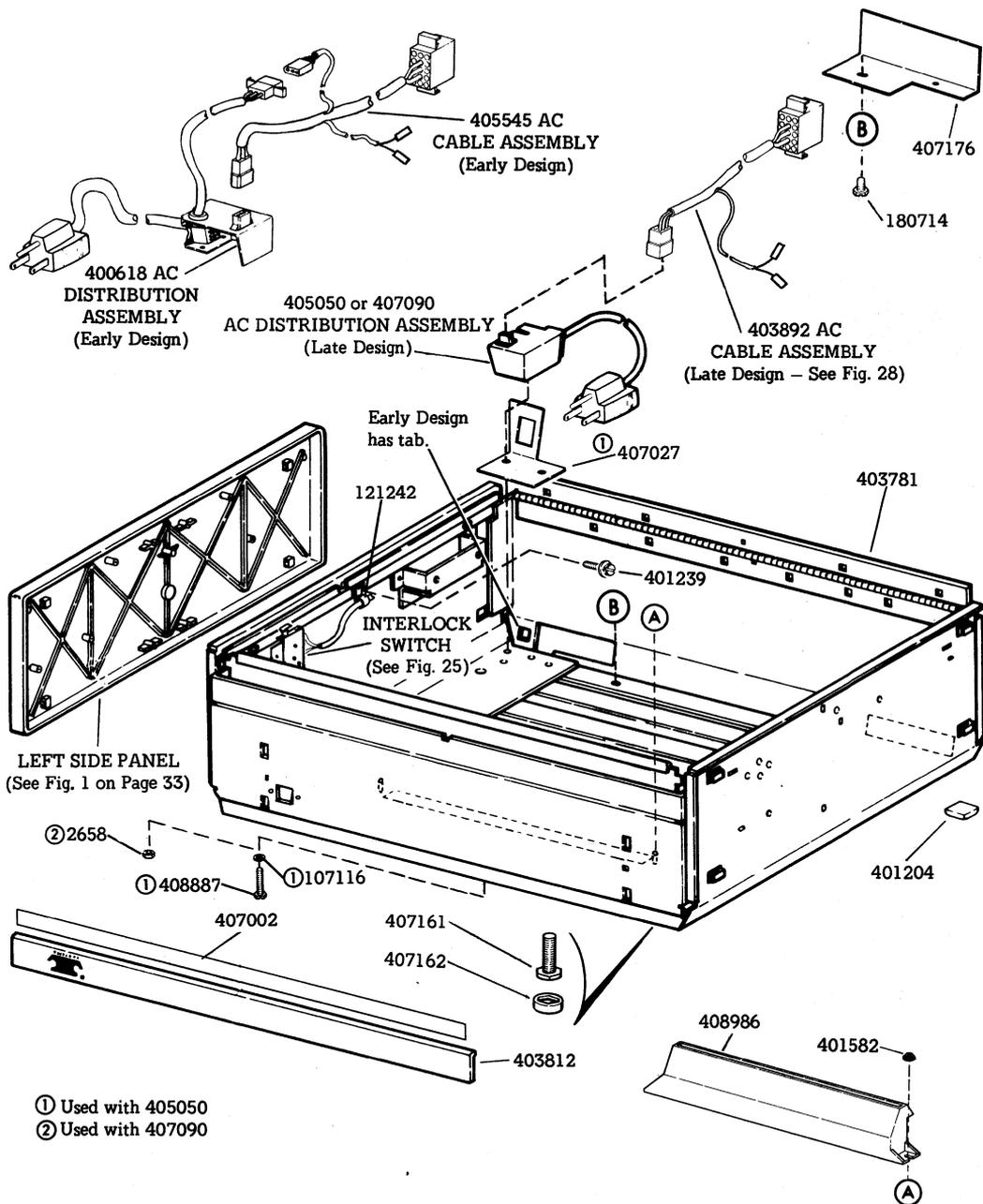


Fig. 22-40CAB351/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 80-Column

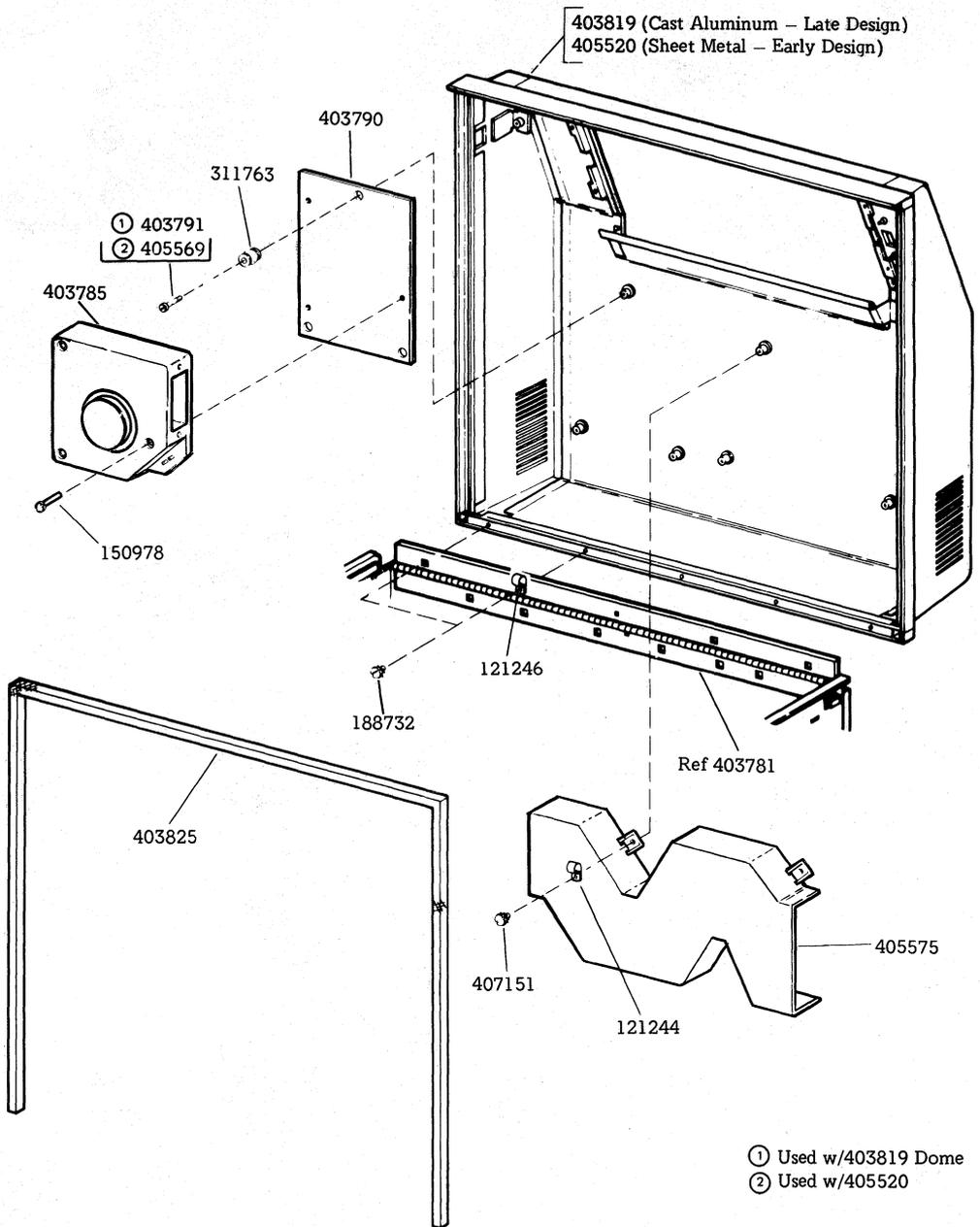
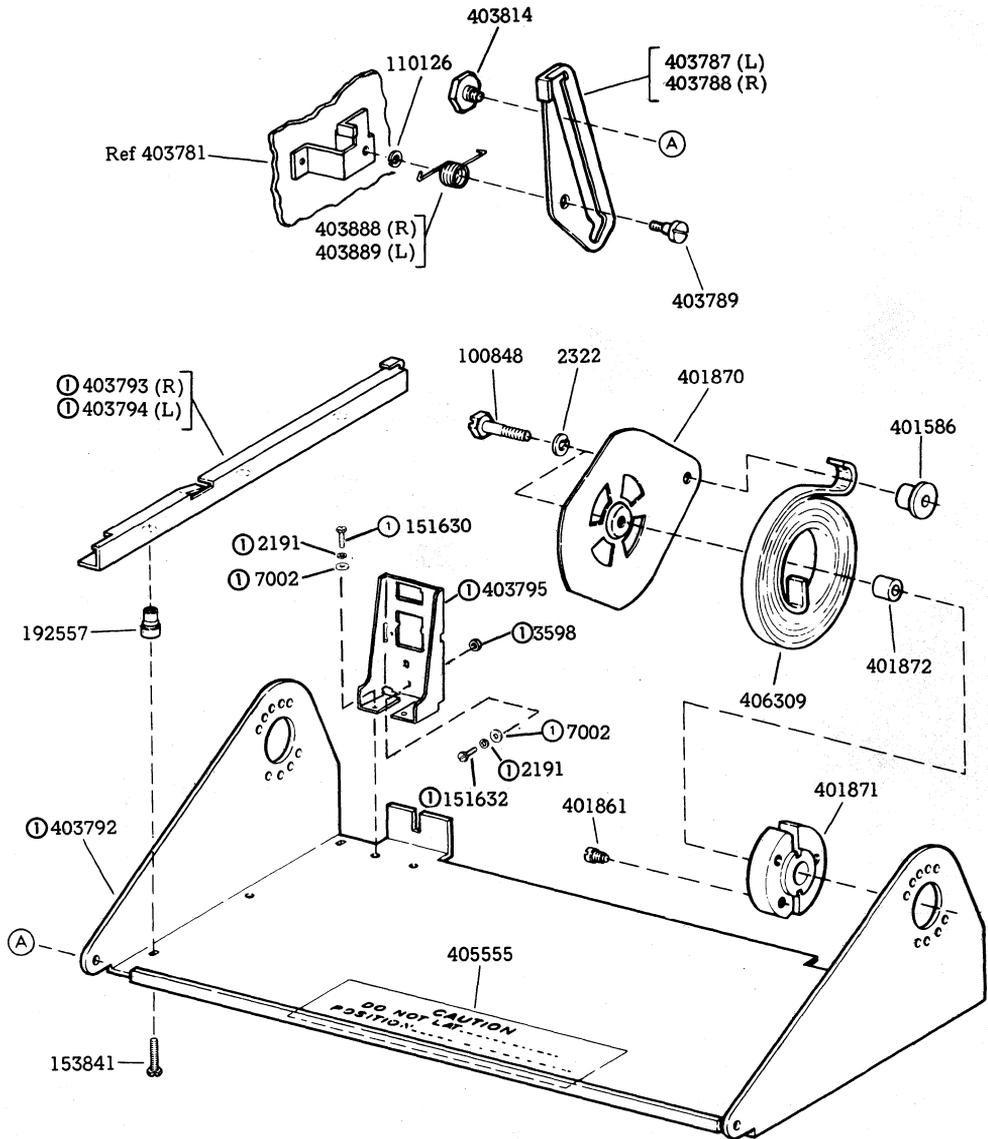
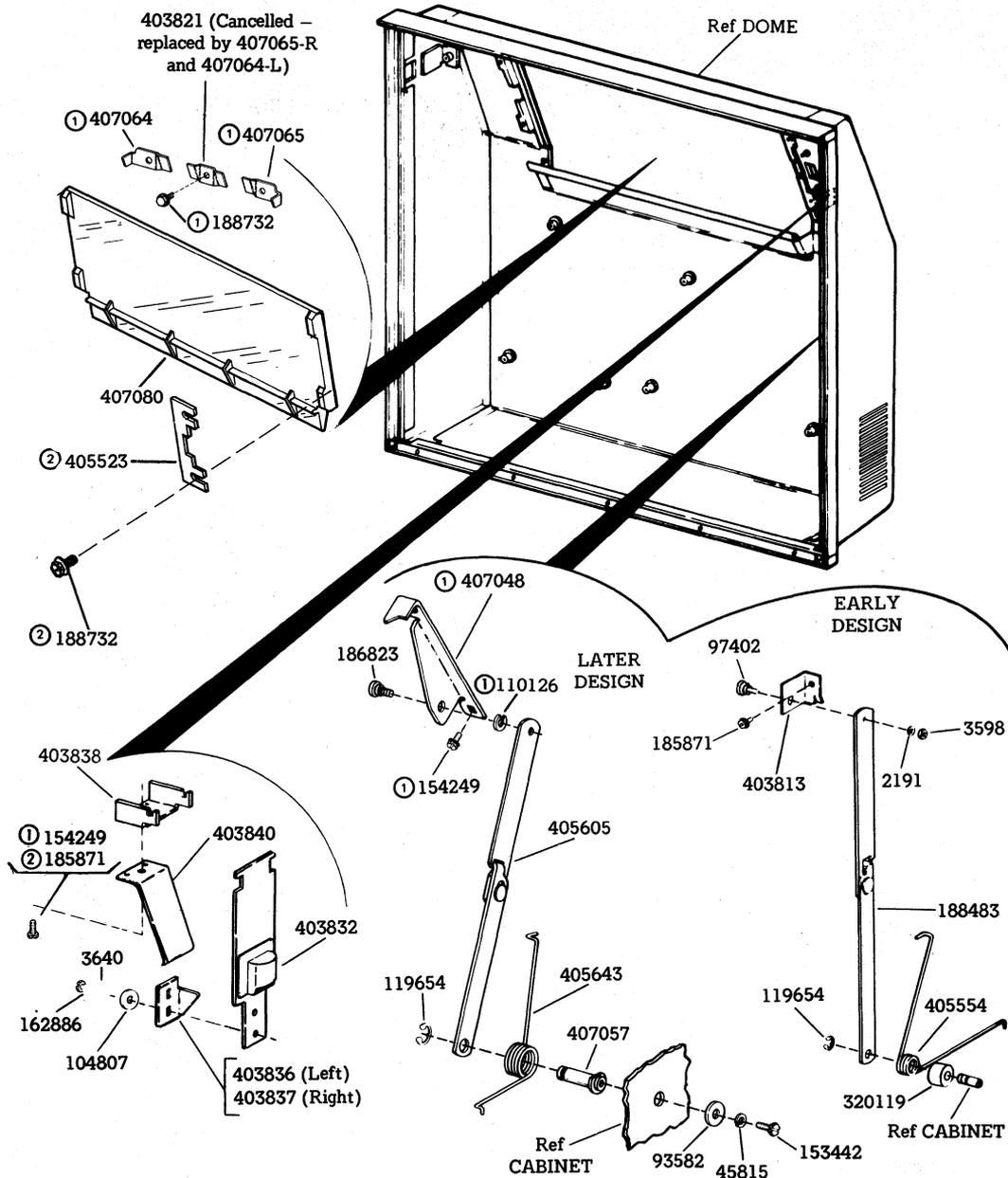


Fig. 22-40CAB351/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 80-Column (Cont)



① Early design. For late design parts, see Fig. 27.

Fig. 22-40CAB351/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 80-Column (Cont)



- ① Used w/403819 Dome – Aluminum Cast
- ② Used w/405520 Dome – Sheet Metal

Fig. 22—40CAB351/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer – 80-Column (Cont)

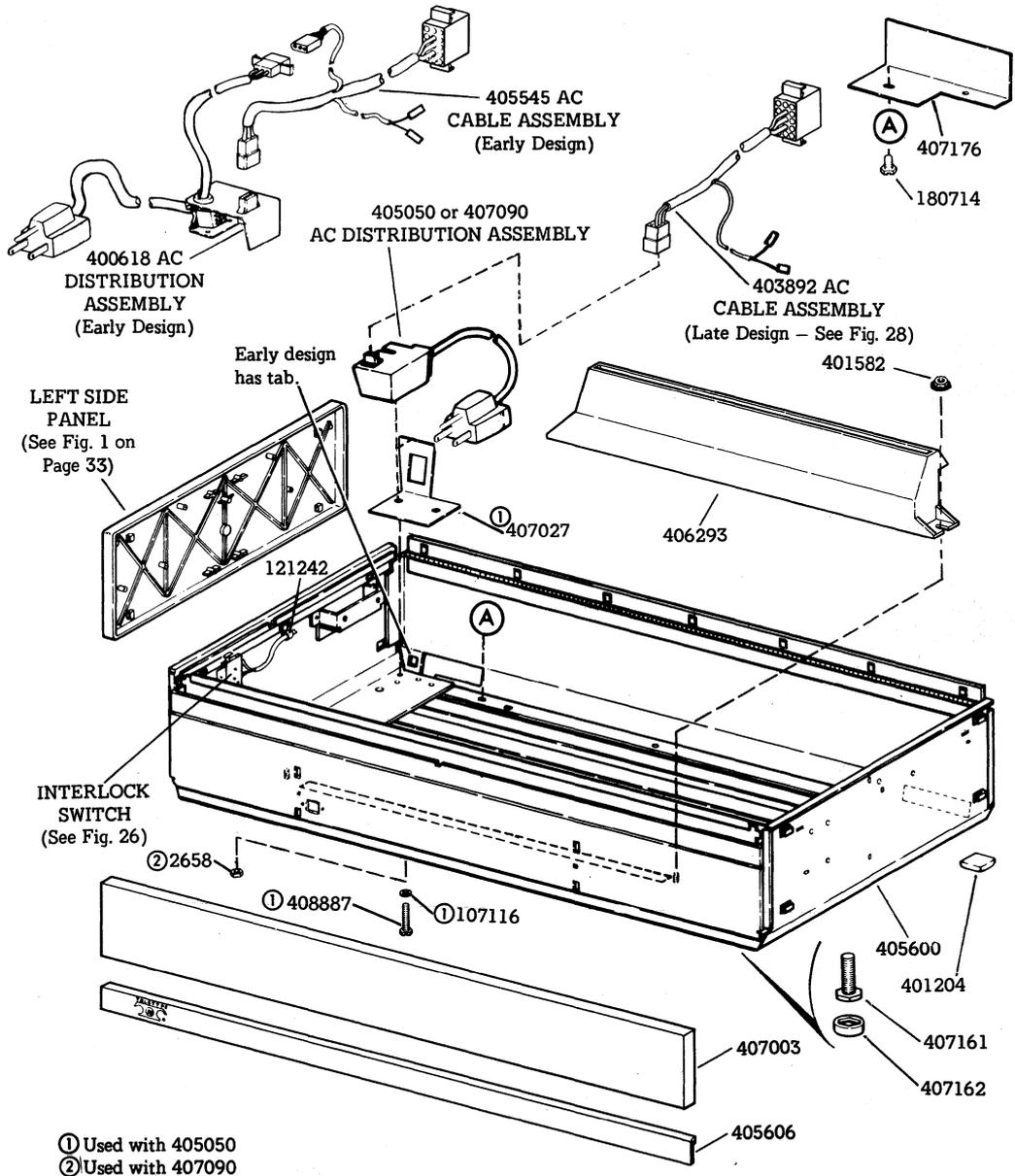


Fig. 23-40CAB353/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 132-Column

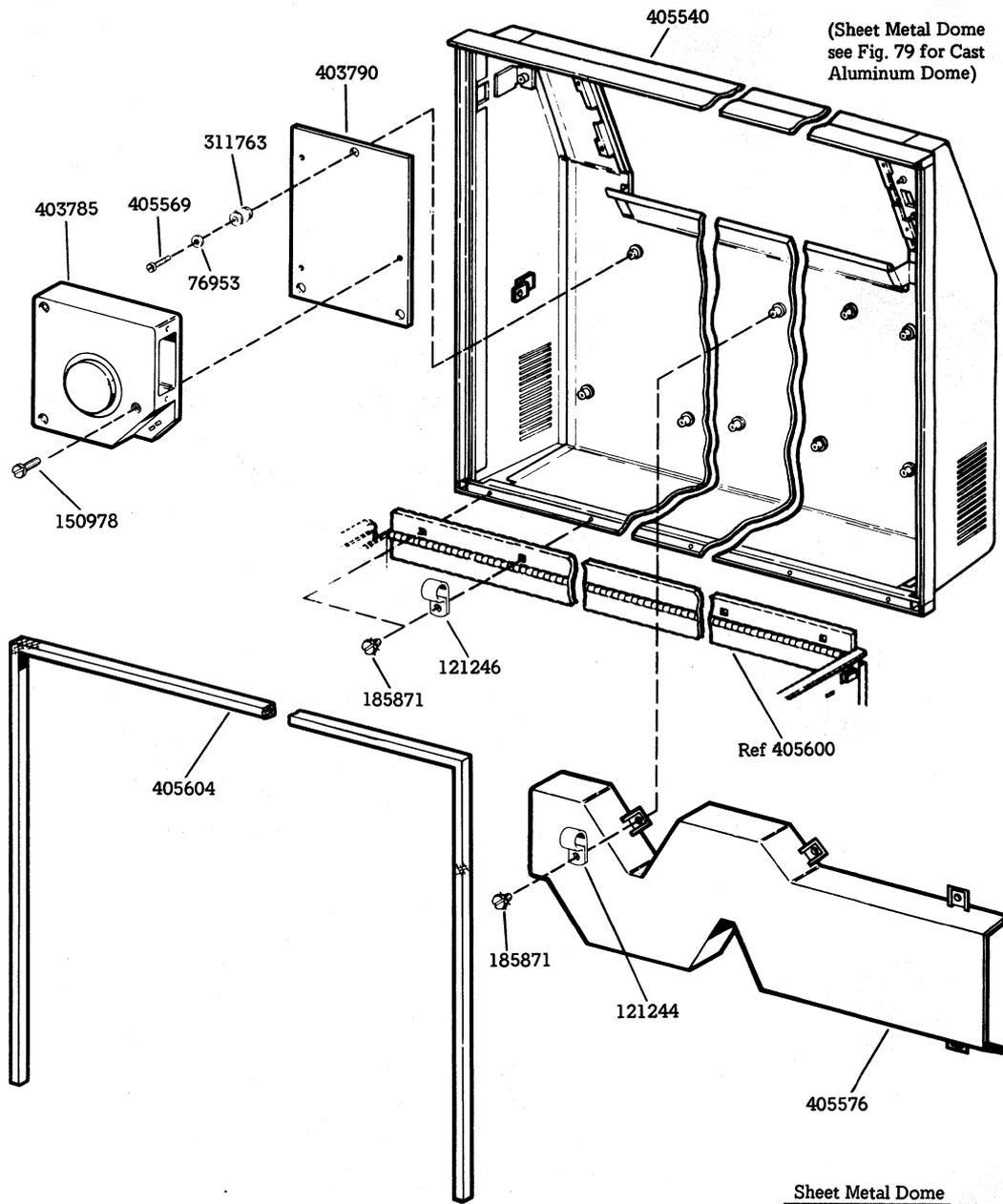


Fig. 23-40CAB353/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 132-Column (Cont)

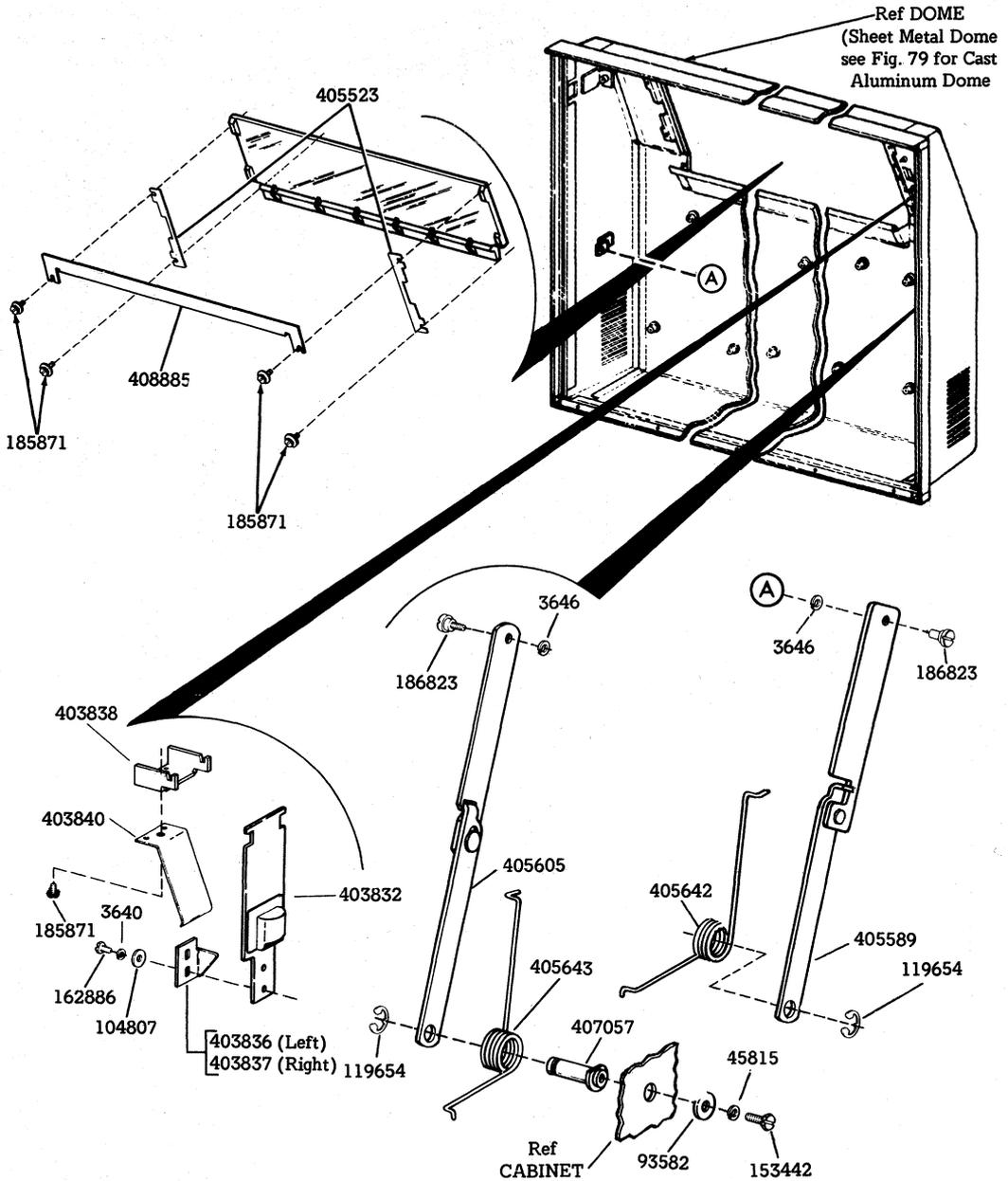


Fig. 23-40CAB353/YZ Printer Cabinet Core for Adjacent or RO
Tractor Feed Printer - 132-Column (Cont)

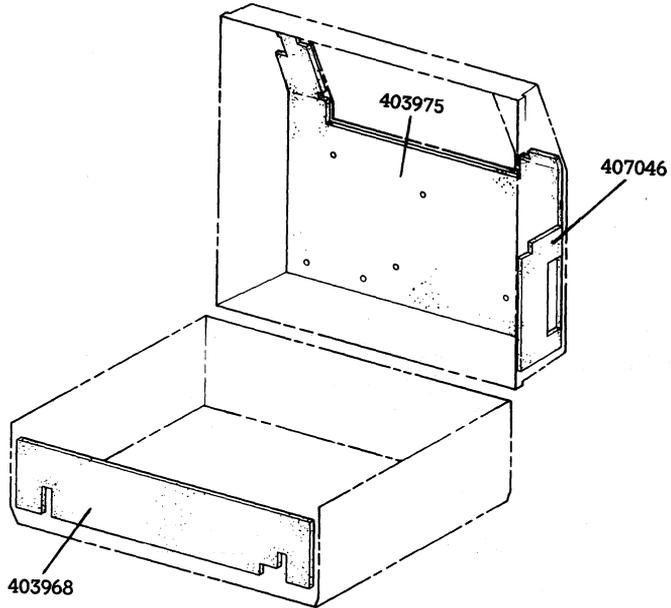


Fig. 24—Pads Used on 40CAB351/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer – 80-Column

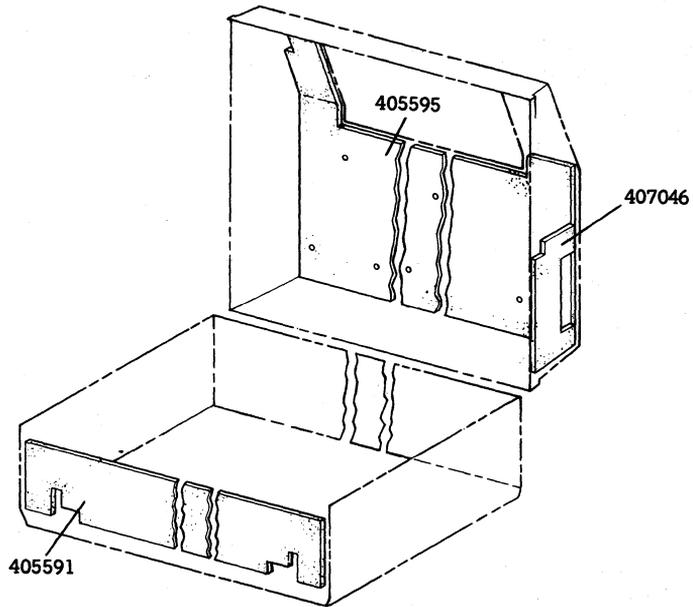
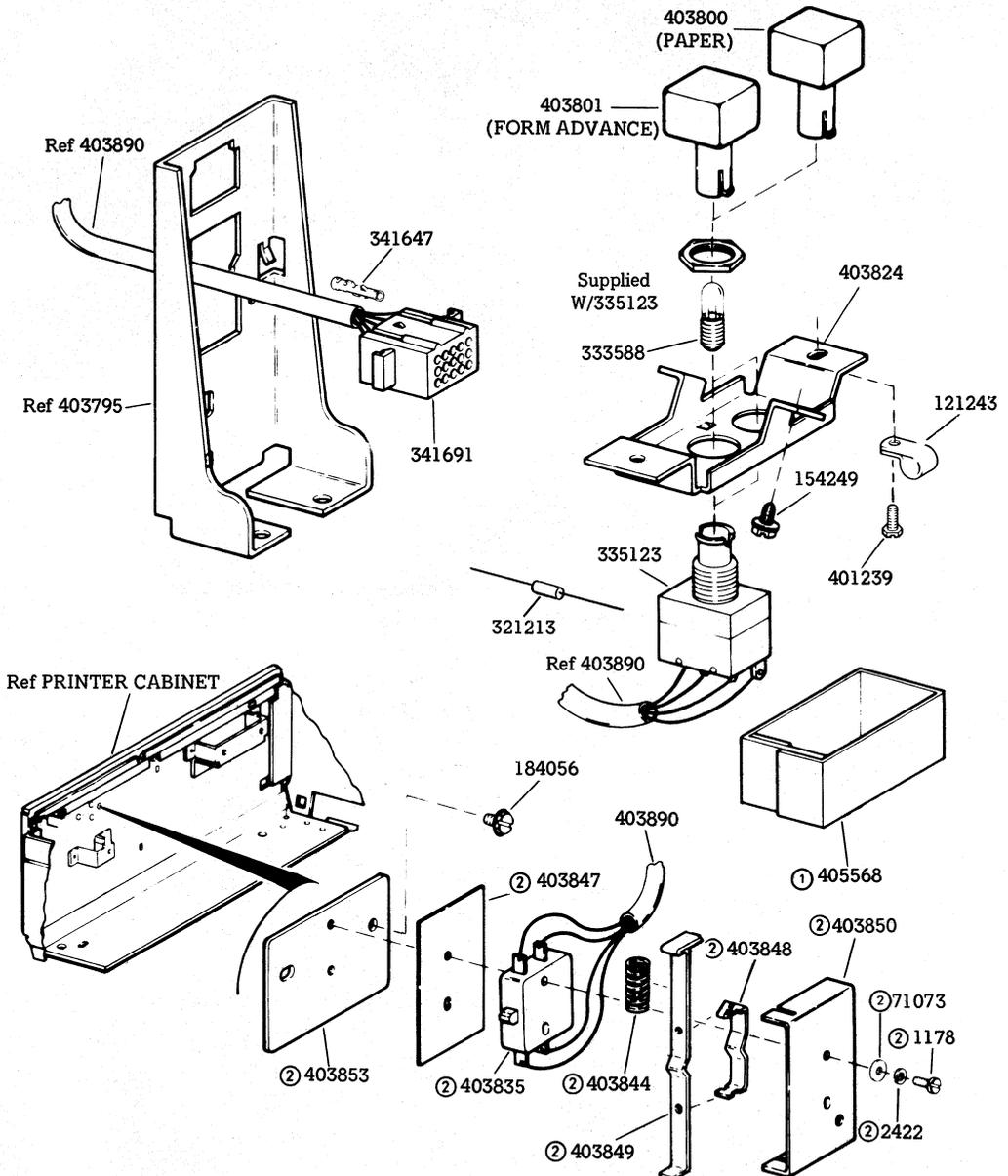


Fig. 25—Pads Used on 40CAB353/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer – 132-Column



- ① Required w/405520 Dome - Sheet Metal
- ② Part of 406442 Interlock Switch Assembly

Fig. 26 - Interlock and Paper Alarm for 80- and 132-Column Tractor Feed Printer Cabinets

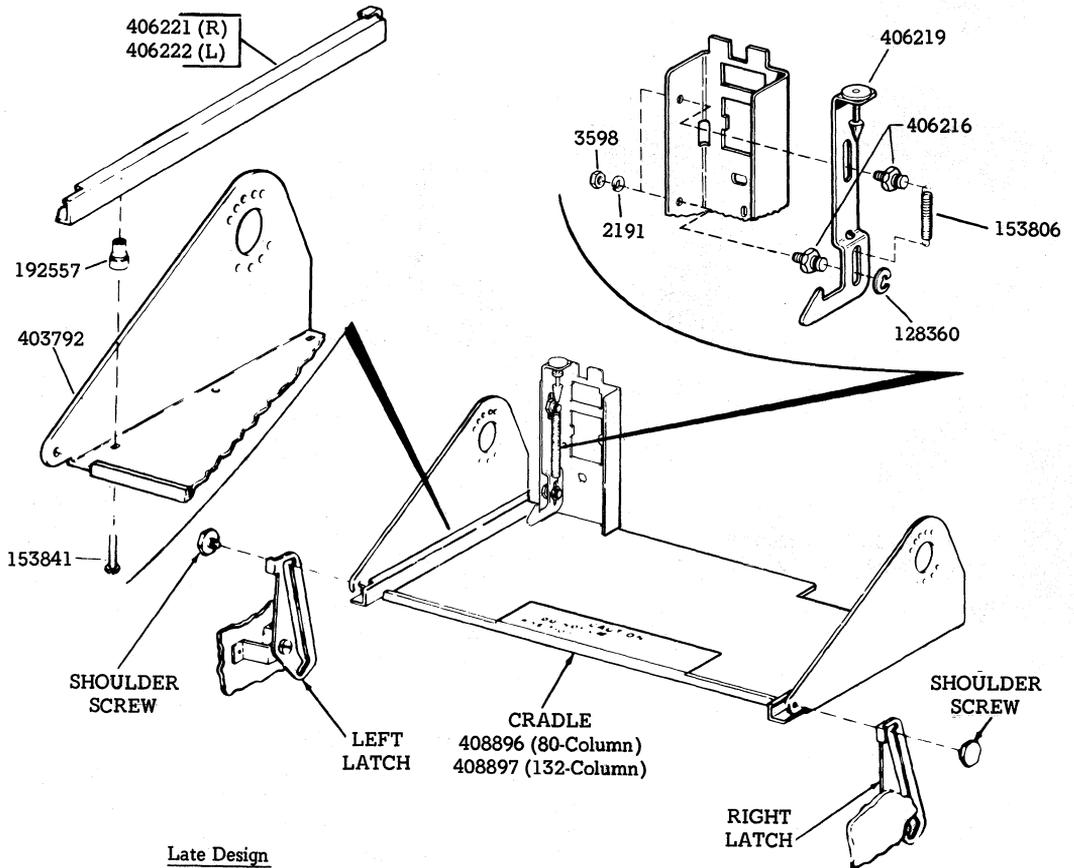


Fig. 27—Cradle and Latch Mechanism for Adjacent or RO Tractor Feed Printer

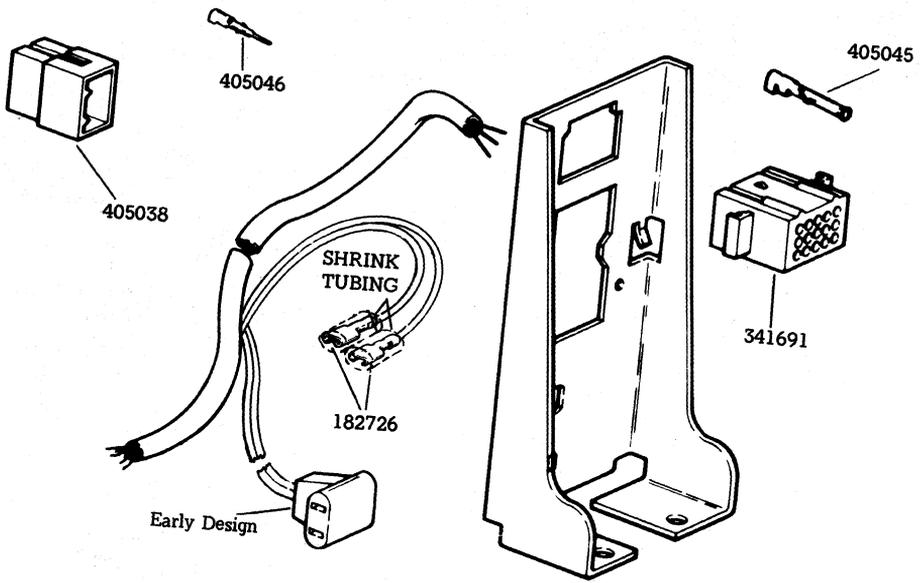


Fig. 28-403892 AC Cable Assembly - Tractor Feed Printer Cabinet

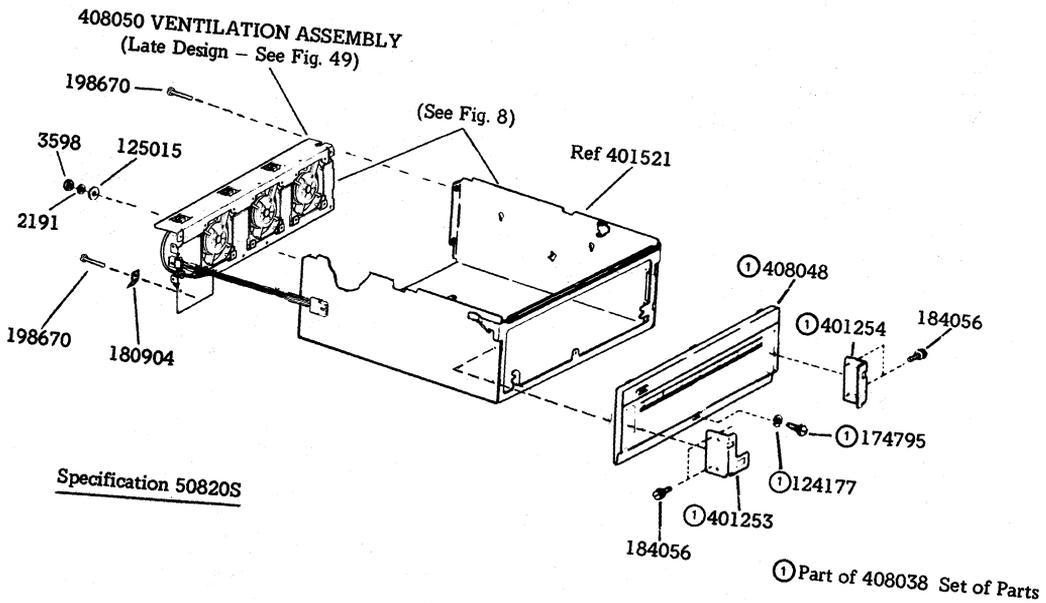
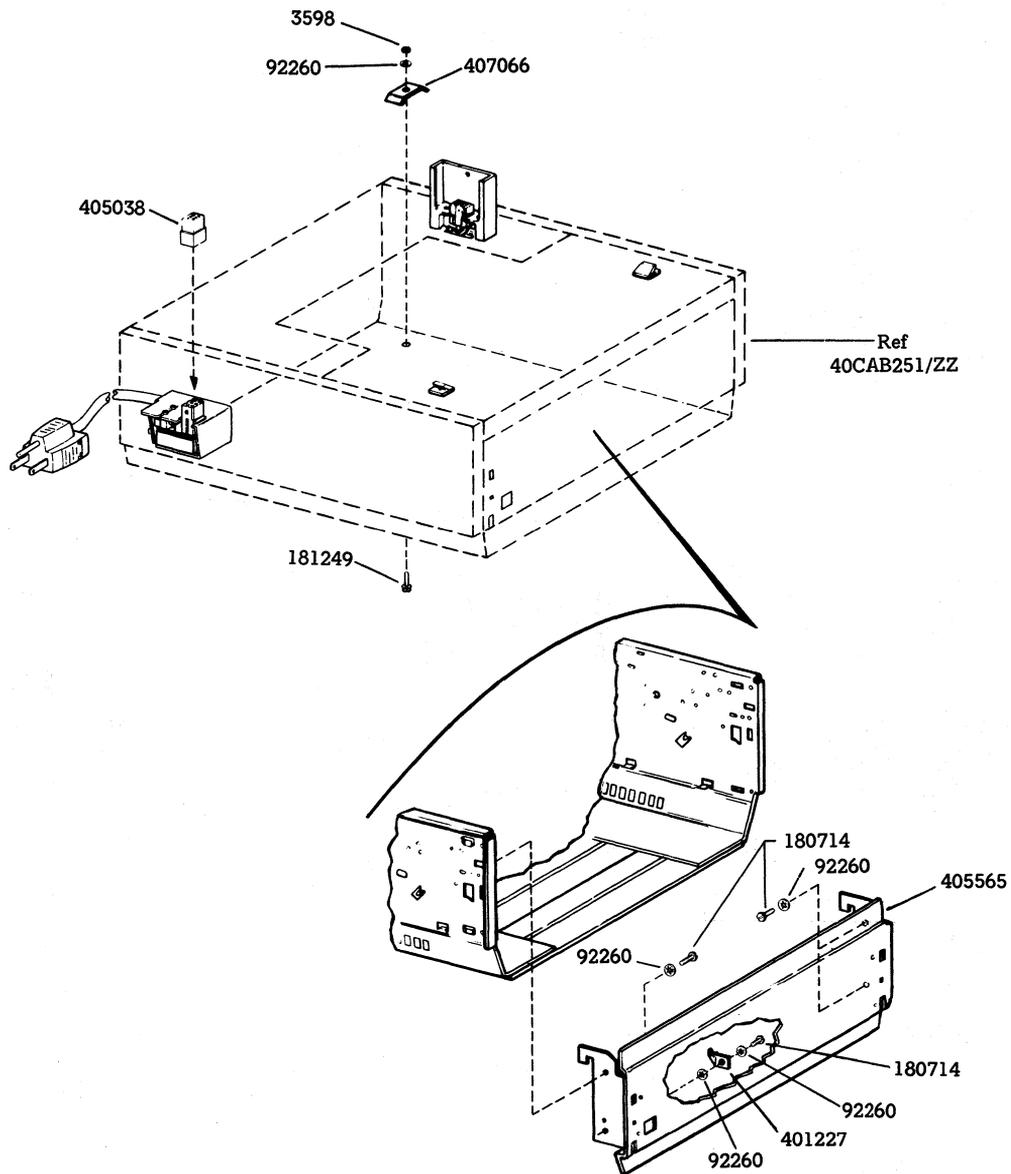


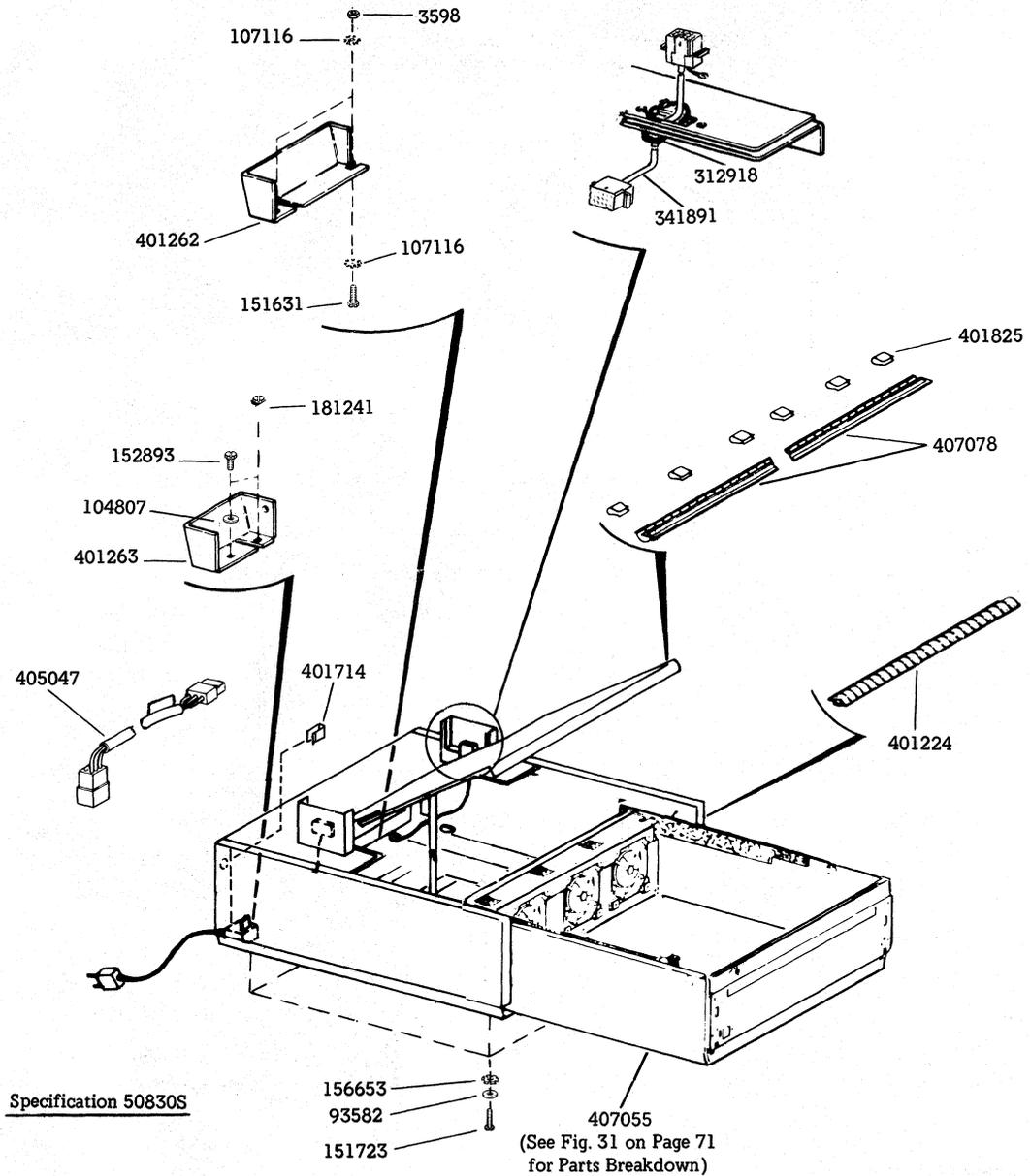
Fig. 29-408051 Modification Kit to Provide Logic Under Monitor Cabinet With Late Design Ventilation Assembly

Specification 50820S



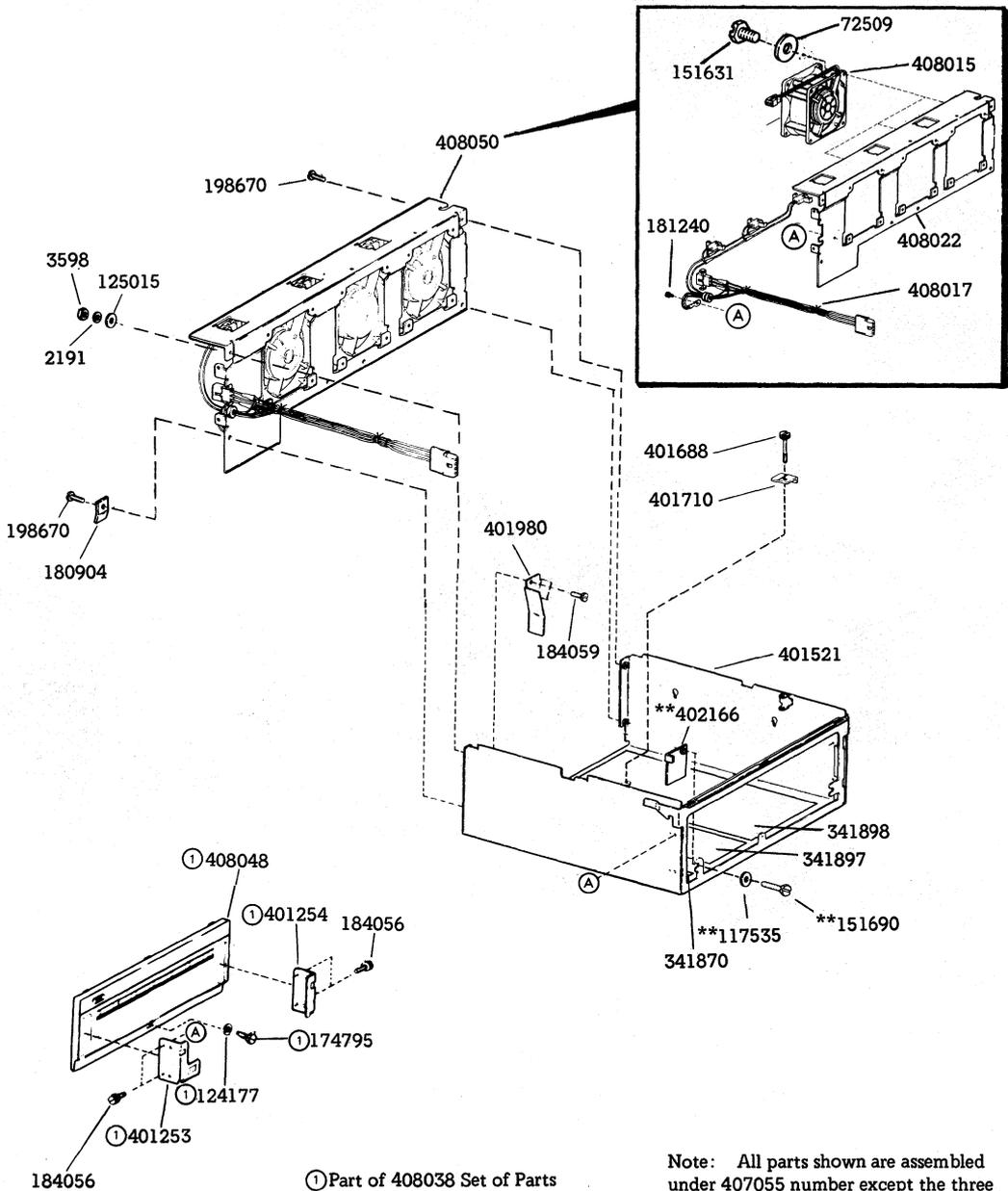
Specification 50830S

Fig. 30-405562 Modification Kit for Monitor/Opcon Support Cabinet



Specification 50830S

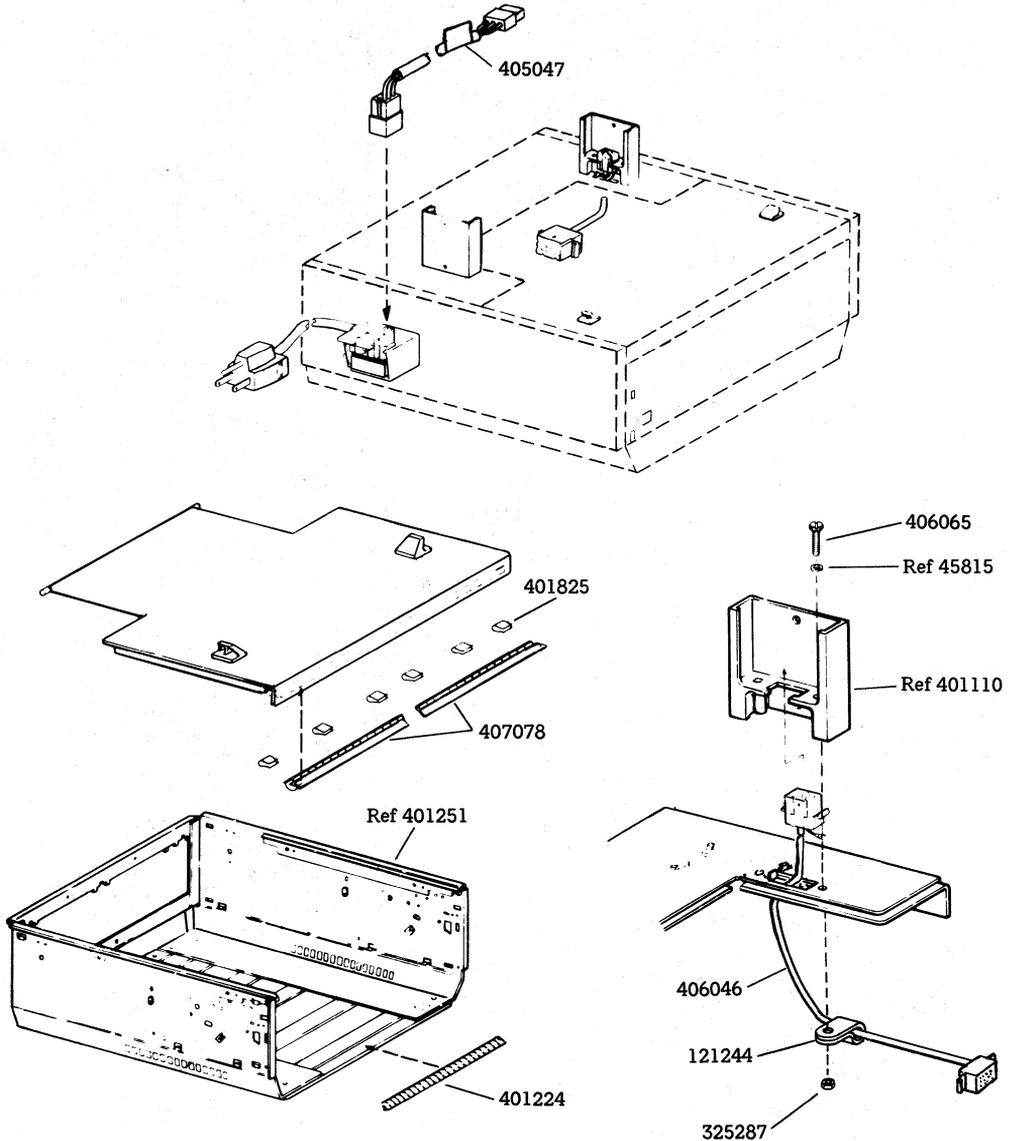
Fig. 31-405563 Modification Kit Used on 40CAB251/ZZ Cabinet to Form a 40CAB251/AB Cabinet



① Part of 408038 Set of Parts

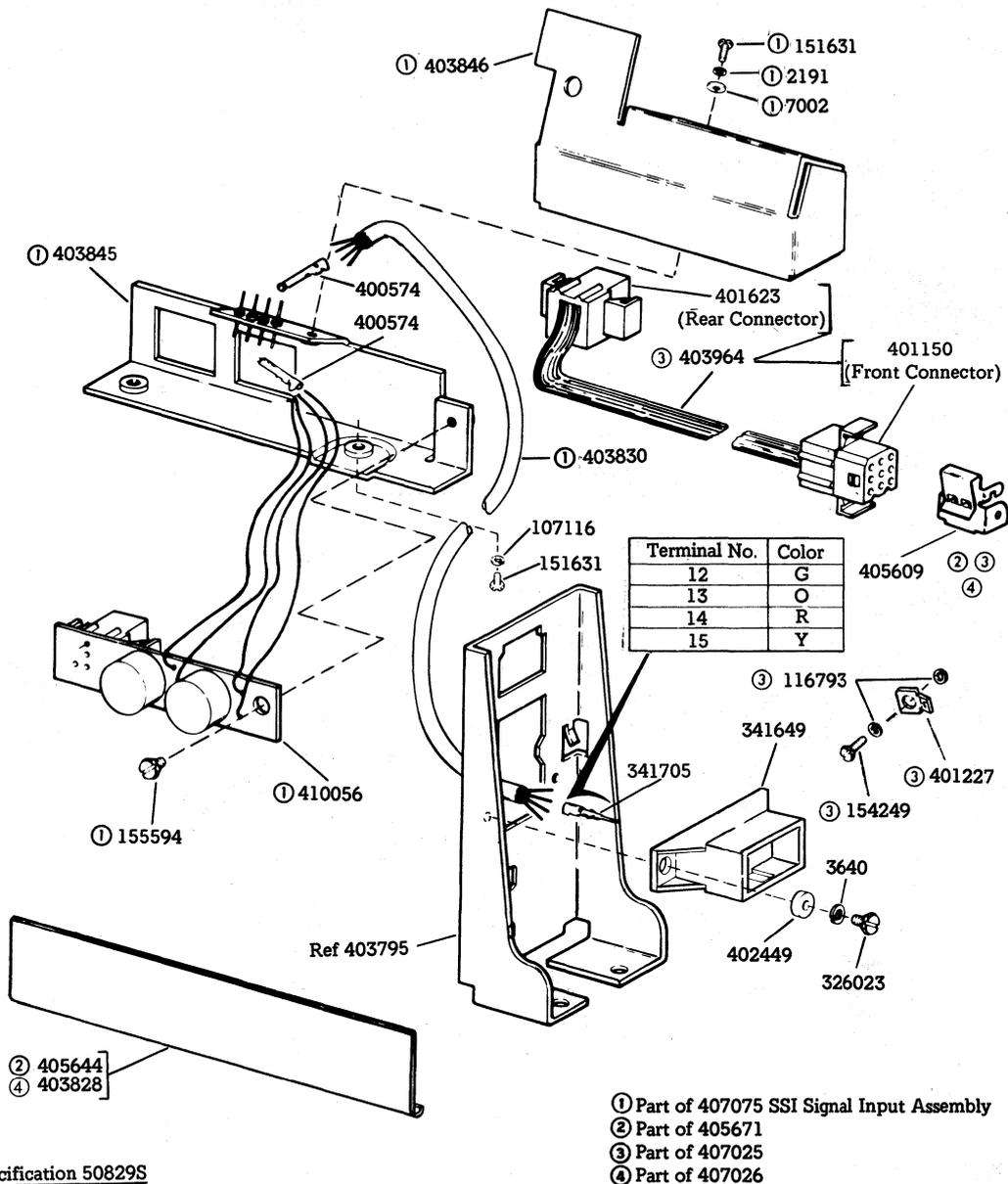
Note: All parts shown are assembled under 407055 number except the three double asterisked (**) parts.

Fig. 31—405563 Modification Kit Used on 40CAB251/ZZ Cabinet to Form a 40CAB251/AB Cabinet (Cont)



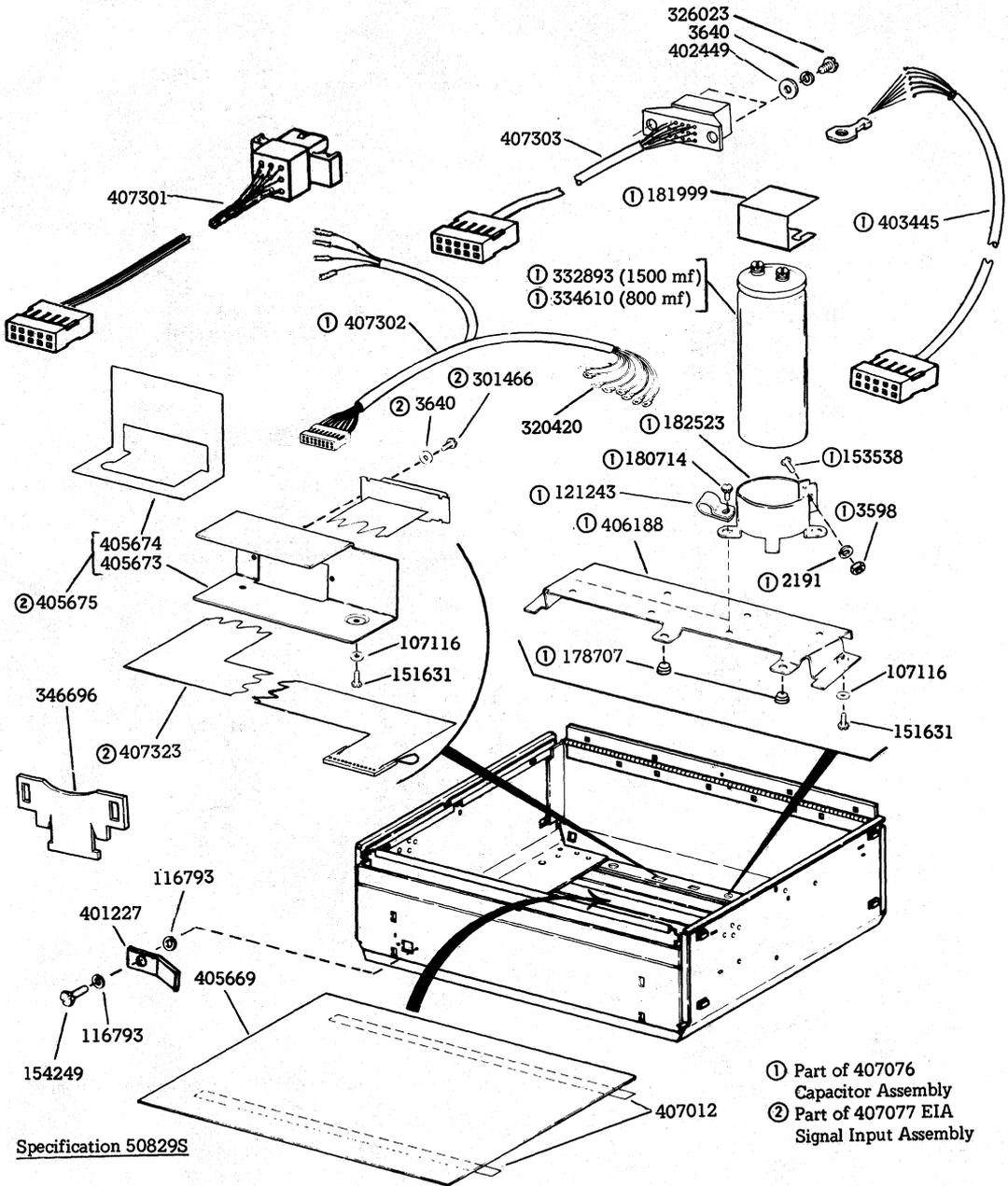
Specification 50830S

Fig. 32—406047 Modification Kit Used on 40CAB251/ZZ Cabinet to Form a 40CAB251/AE Cabinet



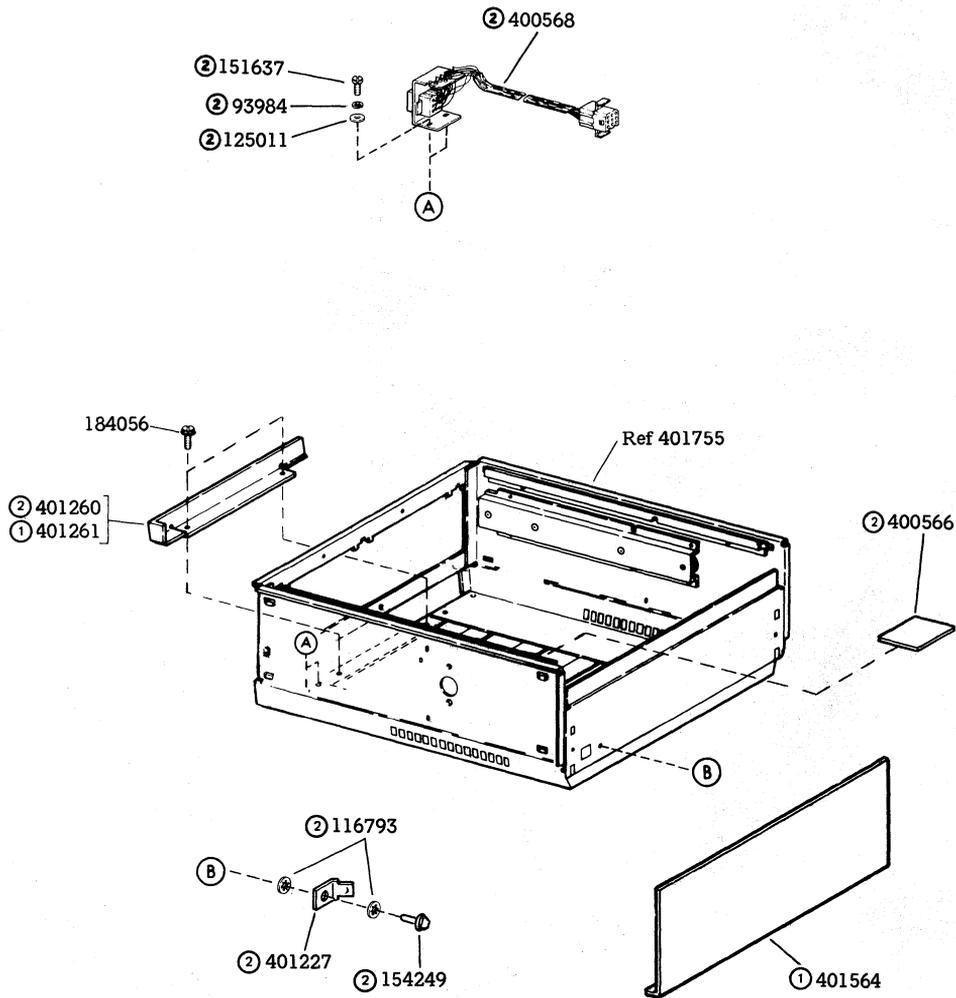
Specification 50829S

Fig. 33-405671 (40CAB353/ZZ - 132-Column), 407025 (40CAB351/ZZ - 80-Column) and 407026 (40CAB351/ZZ - 80-Column) Modification Kits



Specification 50829S

Fig. 34—407024 EIA Integrated Controller Modification Kit for 40CAB351/ZZ (80-Column) and 40CAB353/ZZ (132-Column) Cabinets



Specification 50828S

- ① Part of 407042
- ② Part of 407043

Fig. 35—407042 Modification Kit for Adjacent Friction Feed Printer Cabinet and
407043 Modification Kit for RO Friction Feed Printer Cabinet

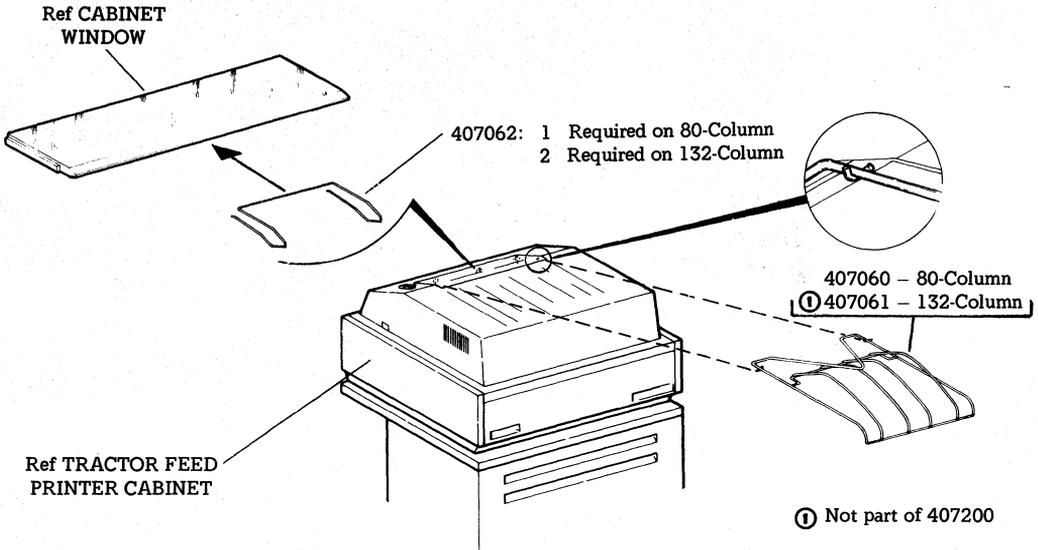
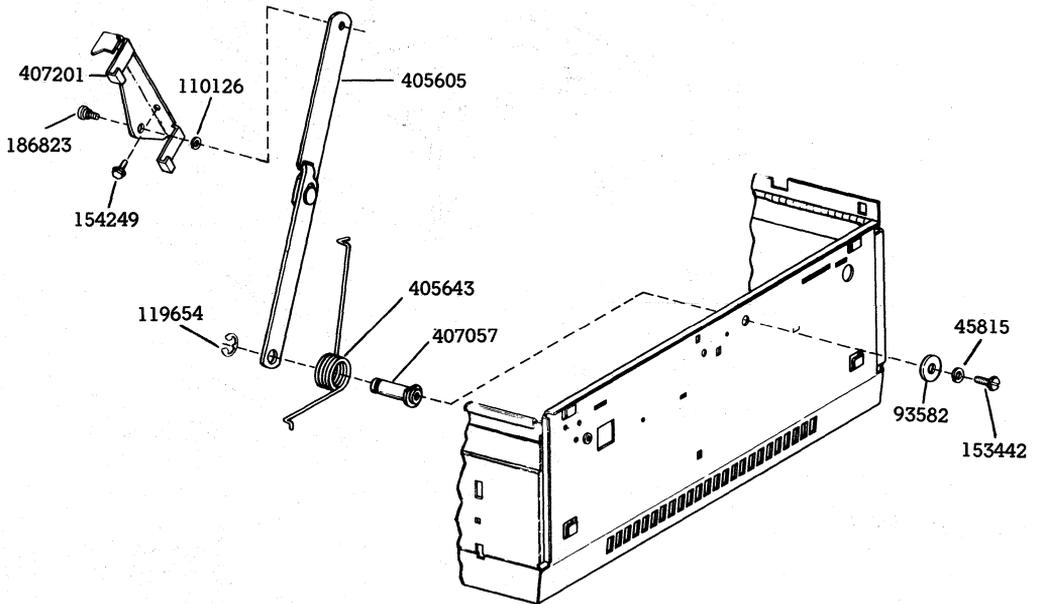


Fig. 36 - 407200 Modification Kit to Facilitate Handling Single-Ply Fanfold Paper



Specification 50871S

Fig. 37 - 407202 Dome Counterbalance Modification Kit for 80-Column Tractor Feed Cabinets

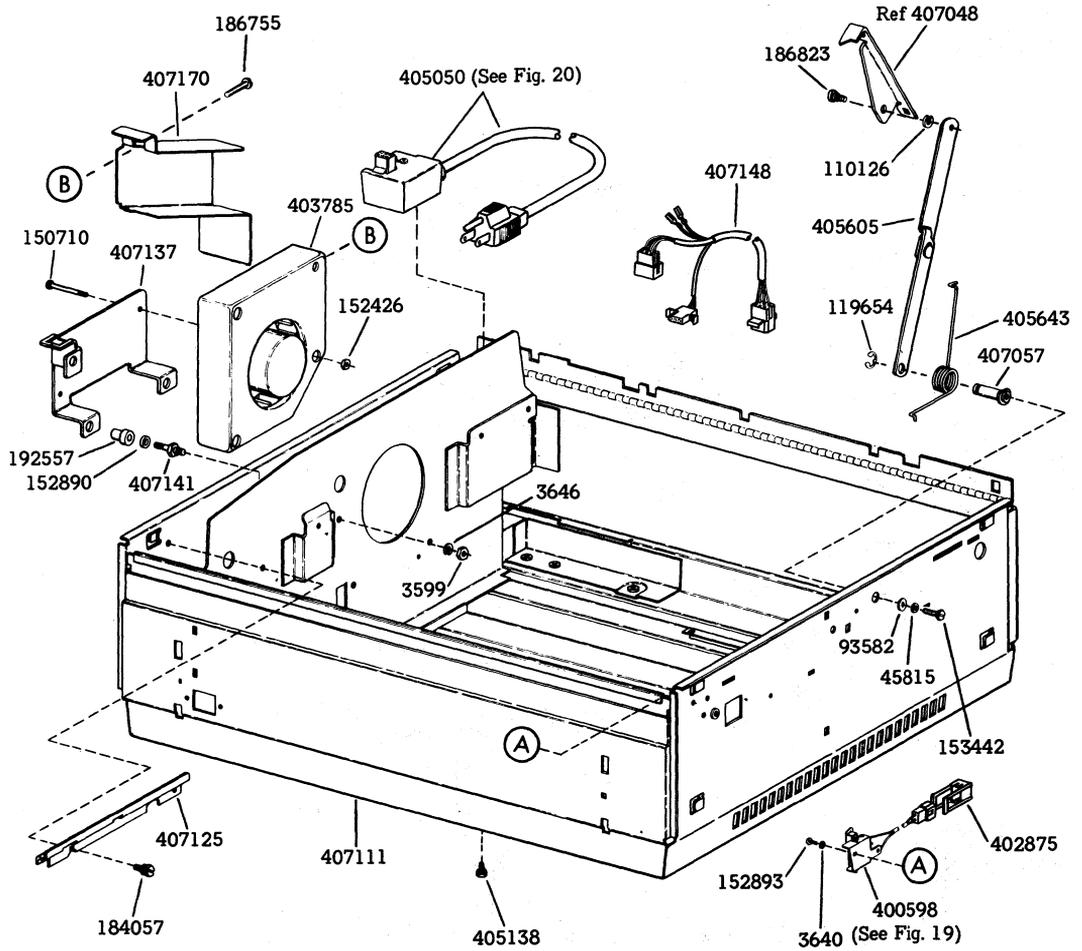


Fig. 38—40CAB371/ZZ Printer Cabinet Core for Noise Reduced Friction Feed Cabinet

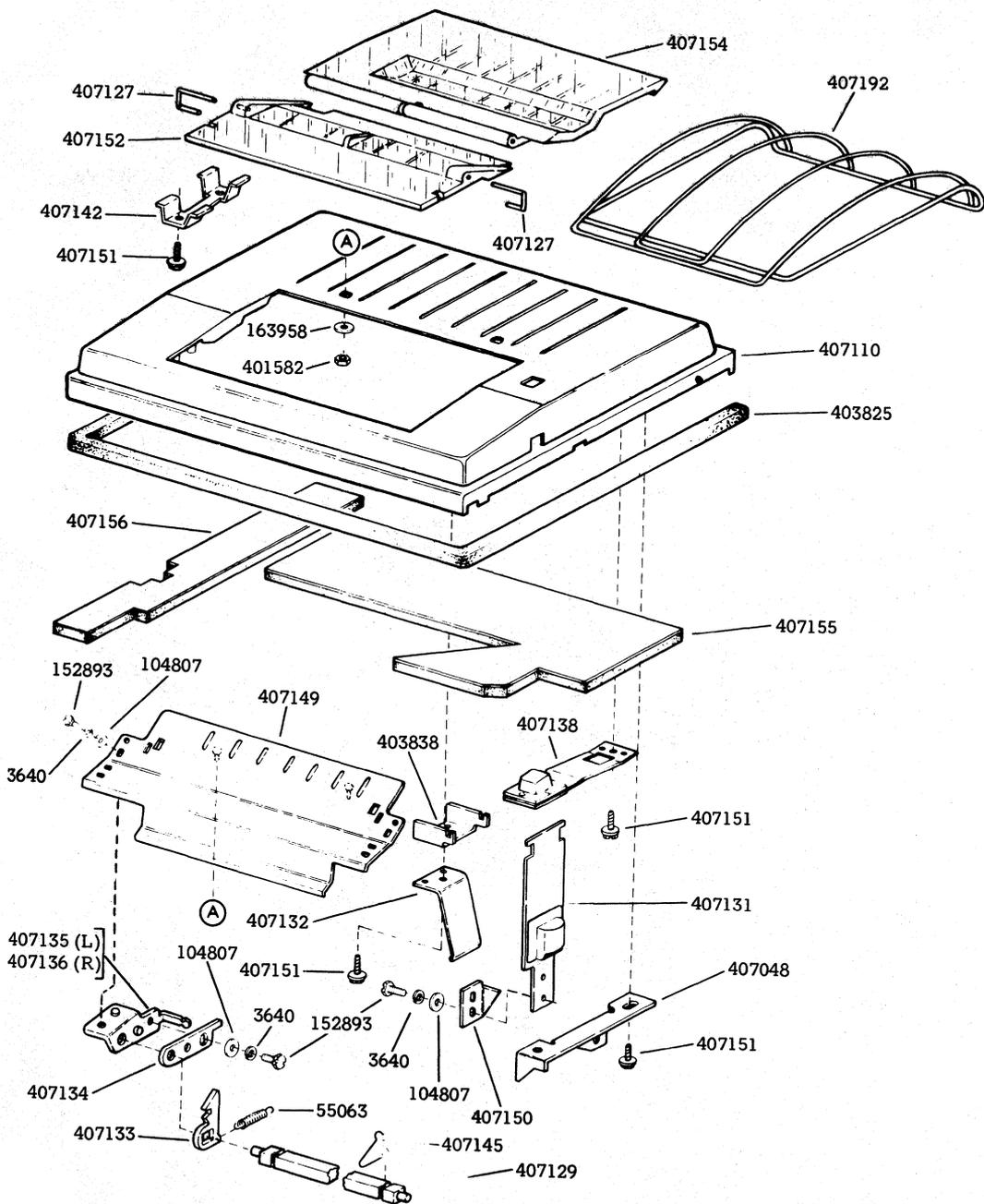
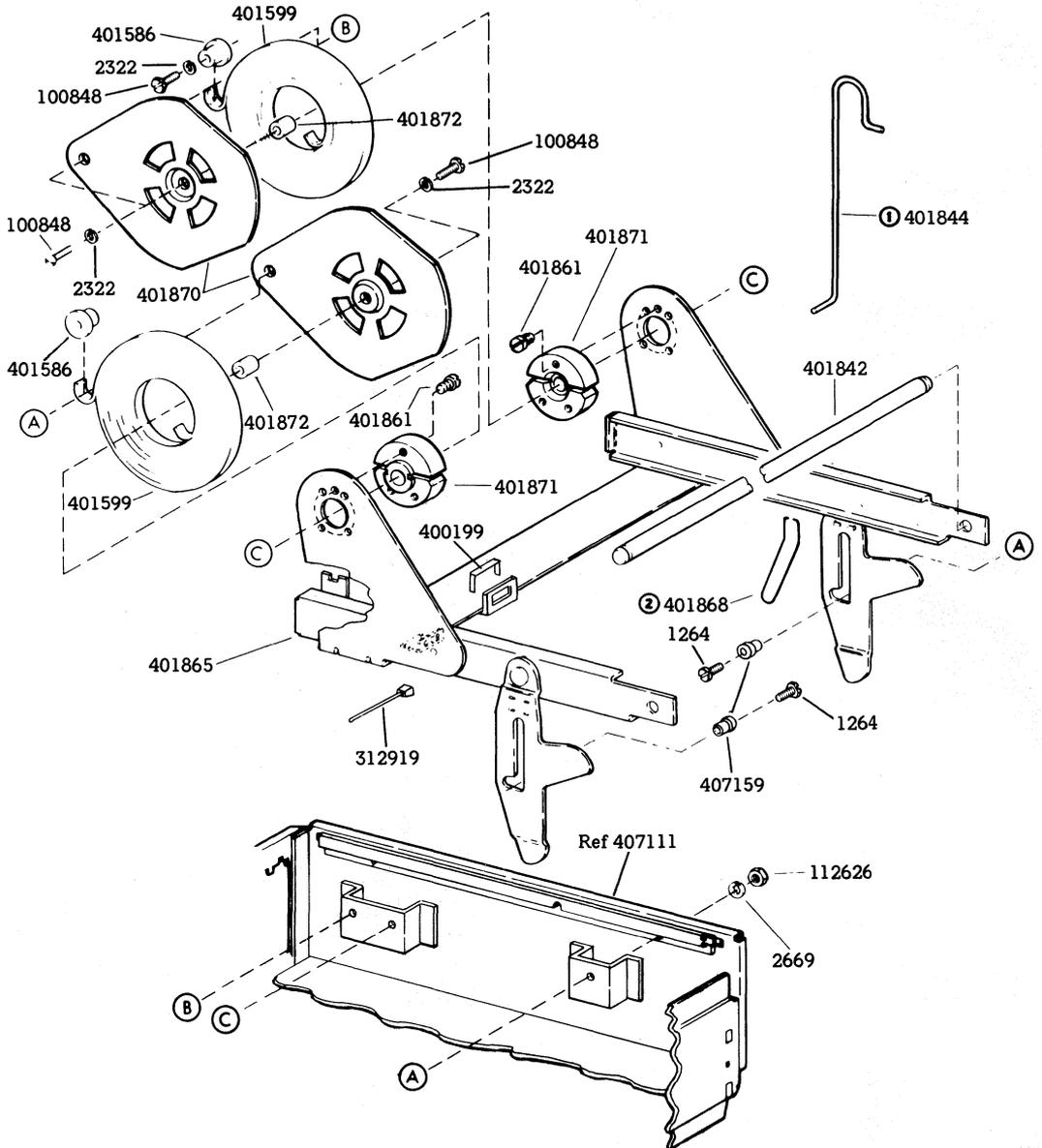


Fig. 38-40CAB371/ZZ Printer Cabinet Core for Noise Reduced Friction Feed Cabinet (Cont)



- ① Used when shipping cabinet
- ② Part of 401865

Fig. 38-40CAB371/ZZ Printer Cabinet Core for Noise Reduced Friction Feed Cabinet (Cont)

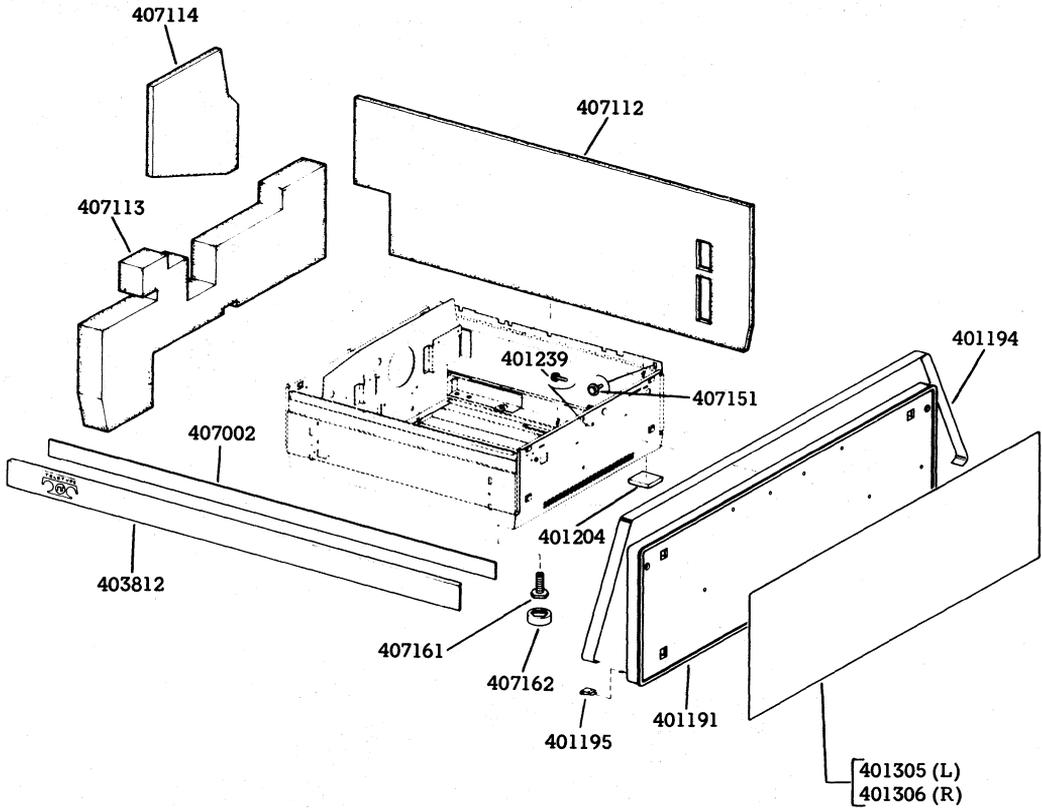


Fig. 38-40CAB371/ZZ Printer Cabinet Core for Noise Reduced Friction Feed Cabinet (Cont)

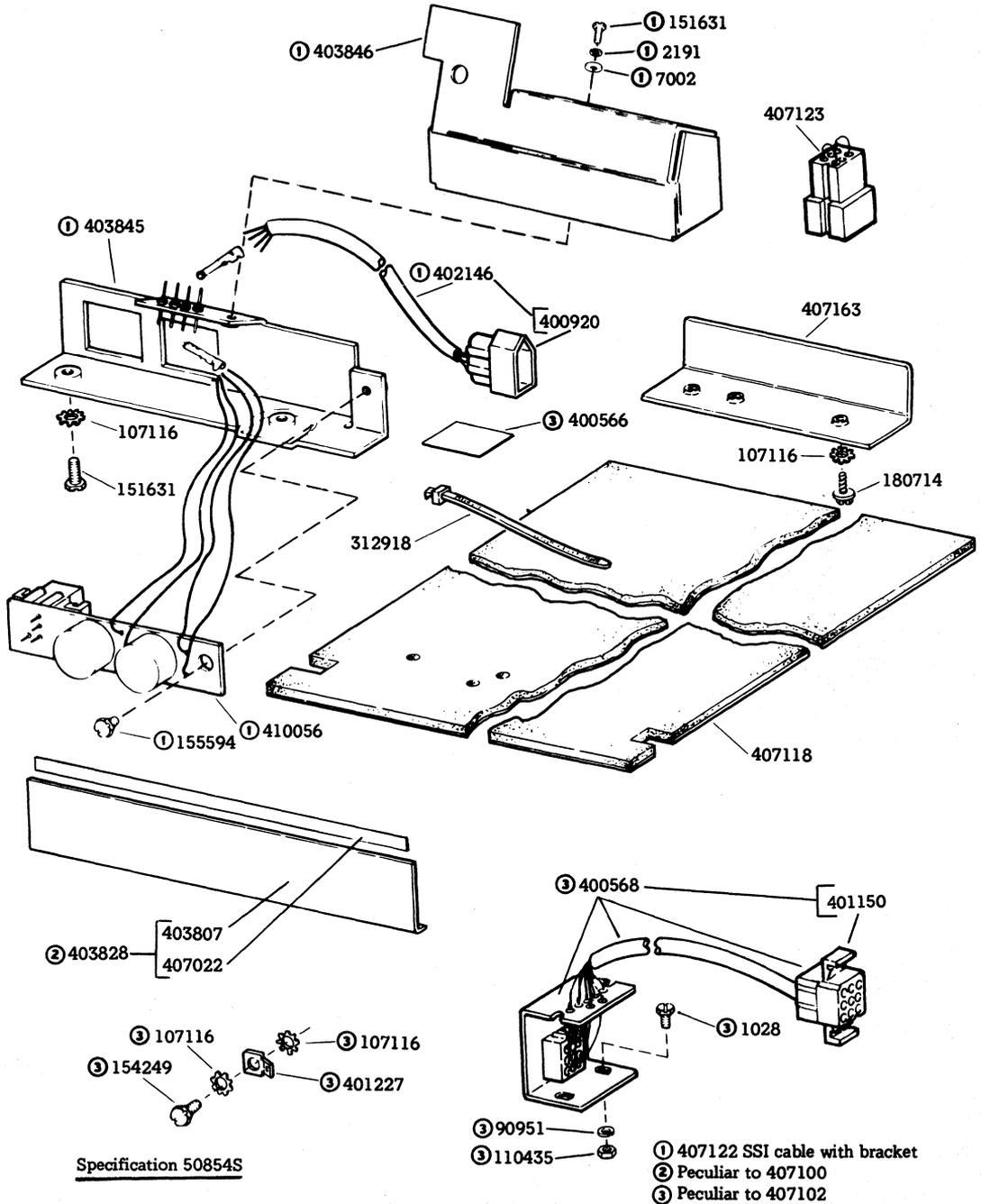
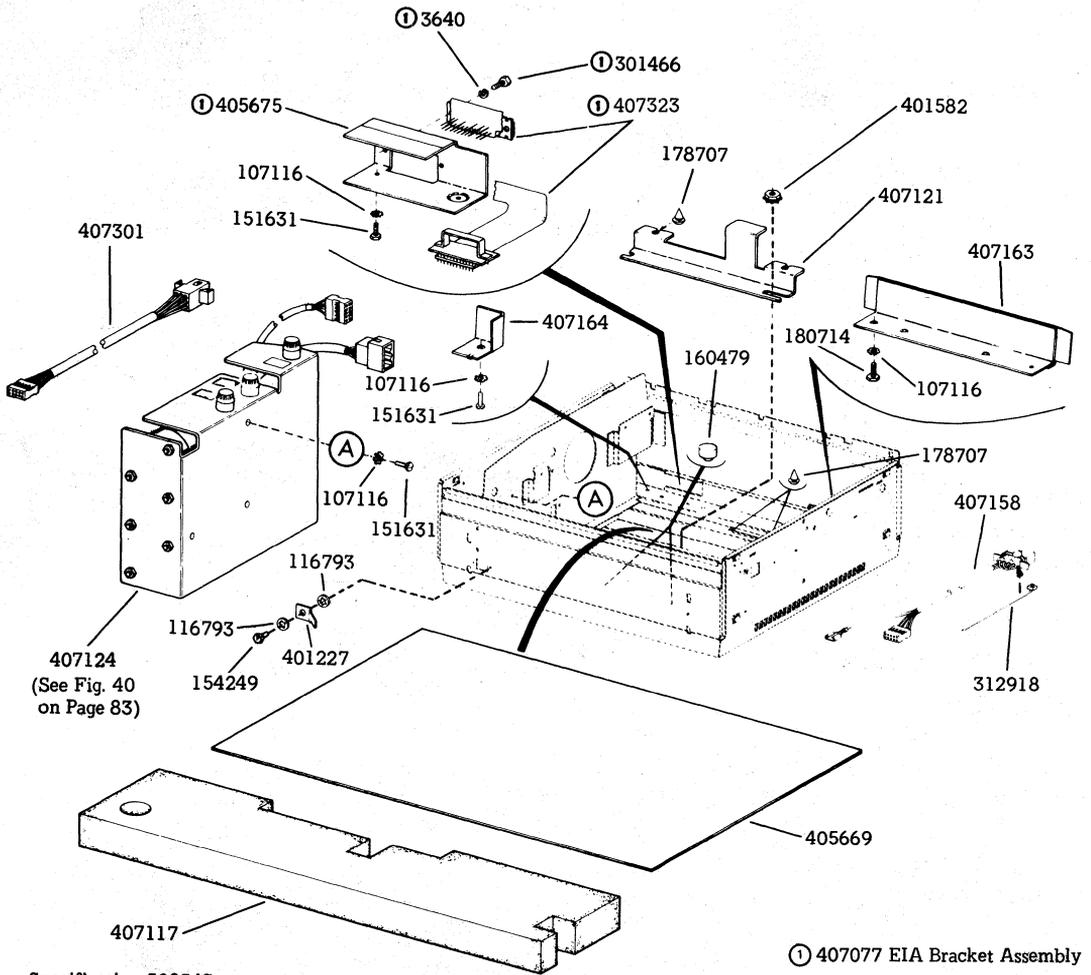
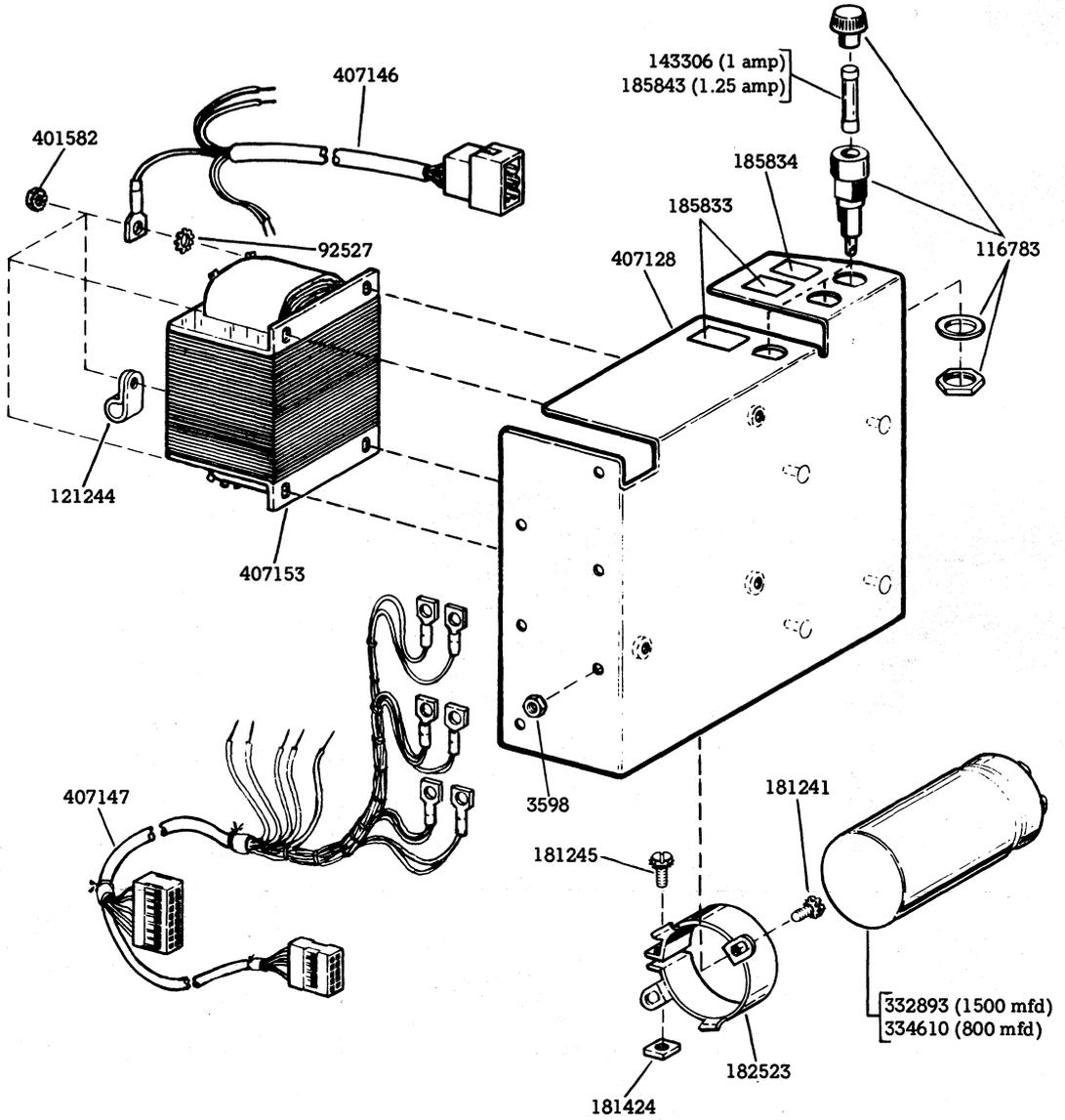


Fig. 39-407100 and 407102 Modification Kits for 40CAB371/ZZ Cabinets



Specification 50854S

Fig. 40—407101 Modification Kit for 40CAB371/ZZ Cabinet



Specification 50854S

Note: All parts shown are assembled as 407124 power supply.

Fig. 40-407101 Modification Kit for 40CAB371/ZZ Cabinet (Cont)

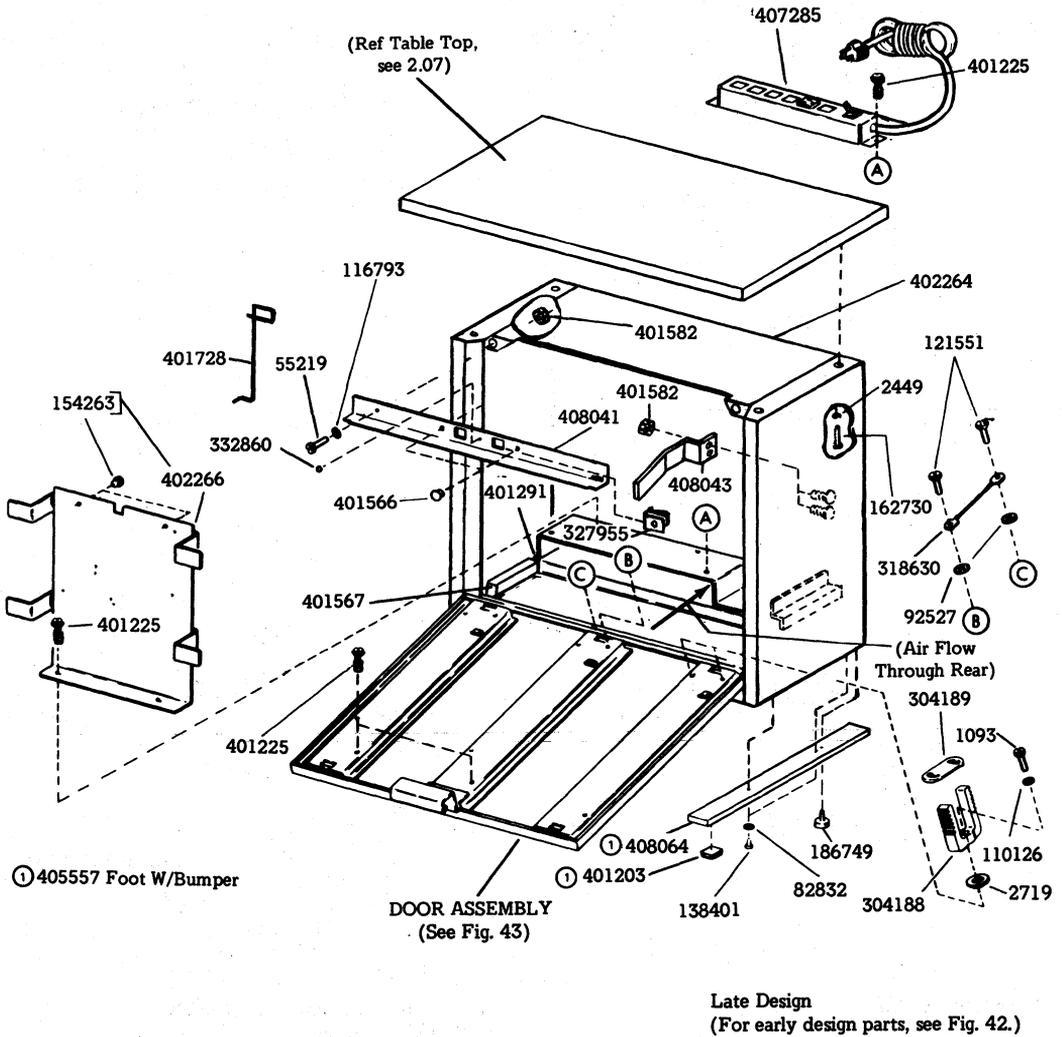
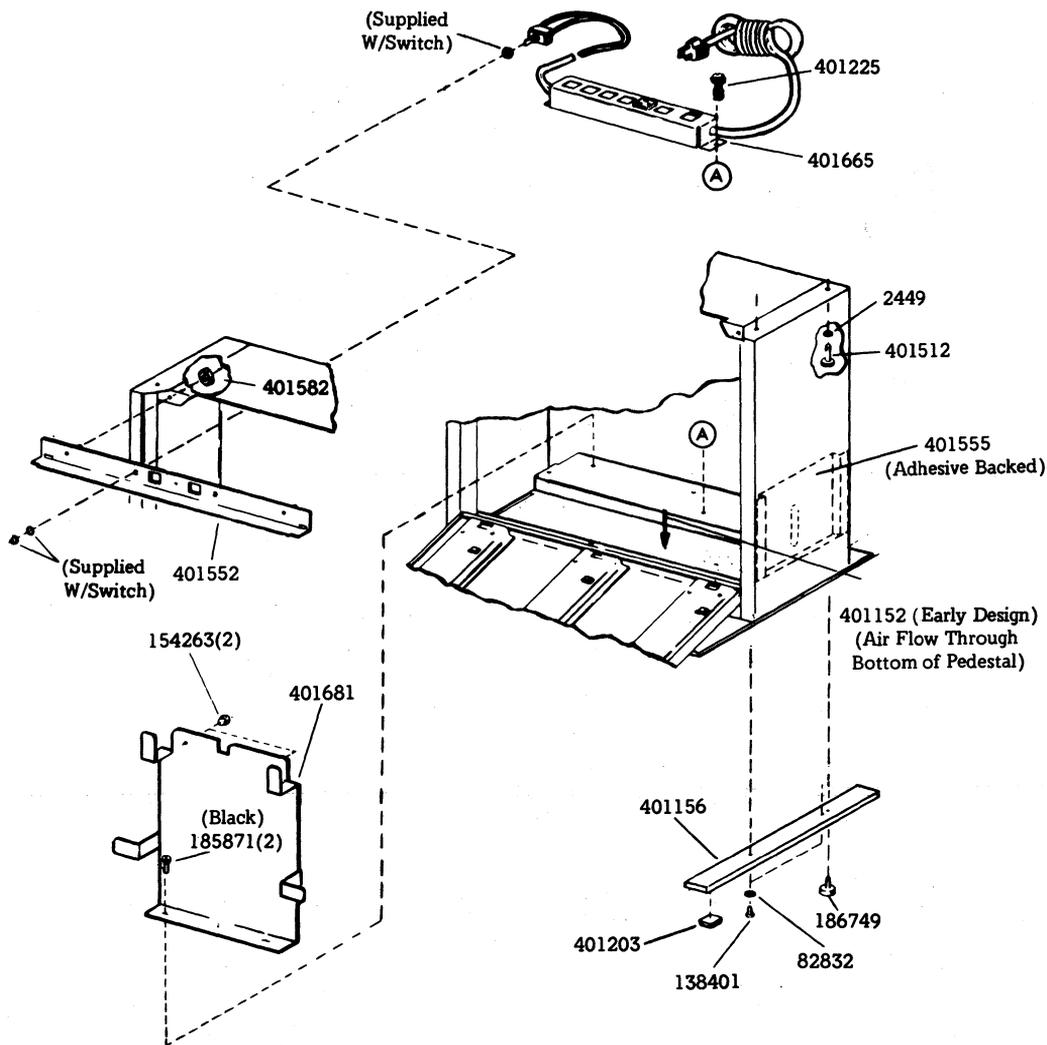


Fig. 41-40CAB901 Series Cabinet (Late Design)



Early Design
(For late design parts, see Fig. 41.)

Fig. 42-40CAB901 Series Cabinet (Early Design)

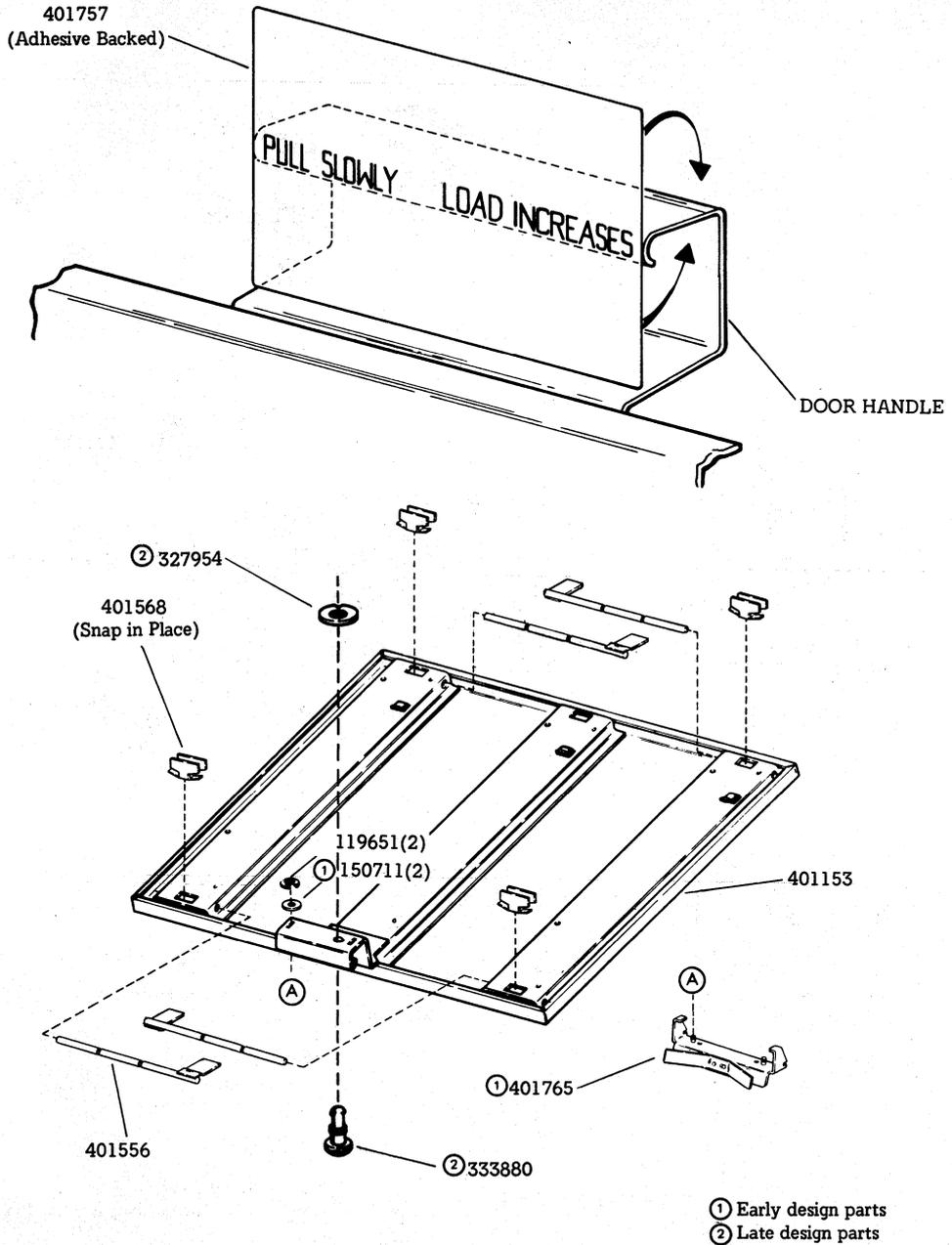


Fig. 43—Pedestal Door Components

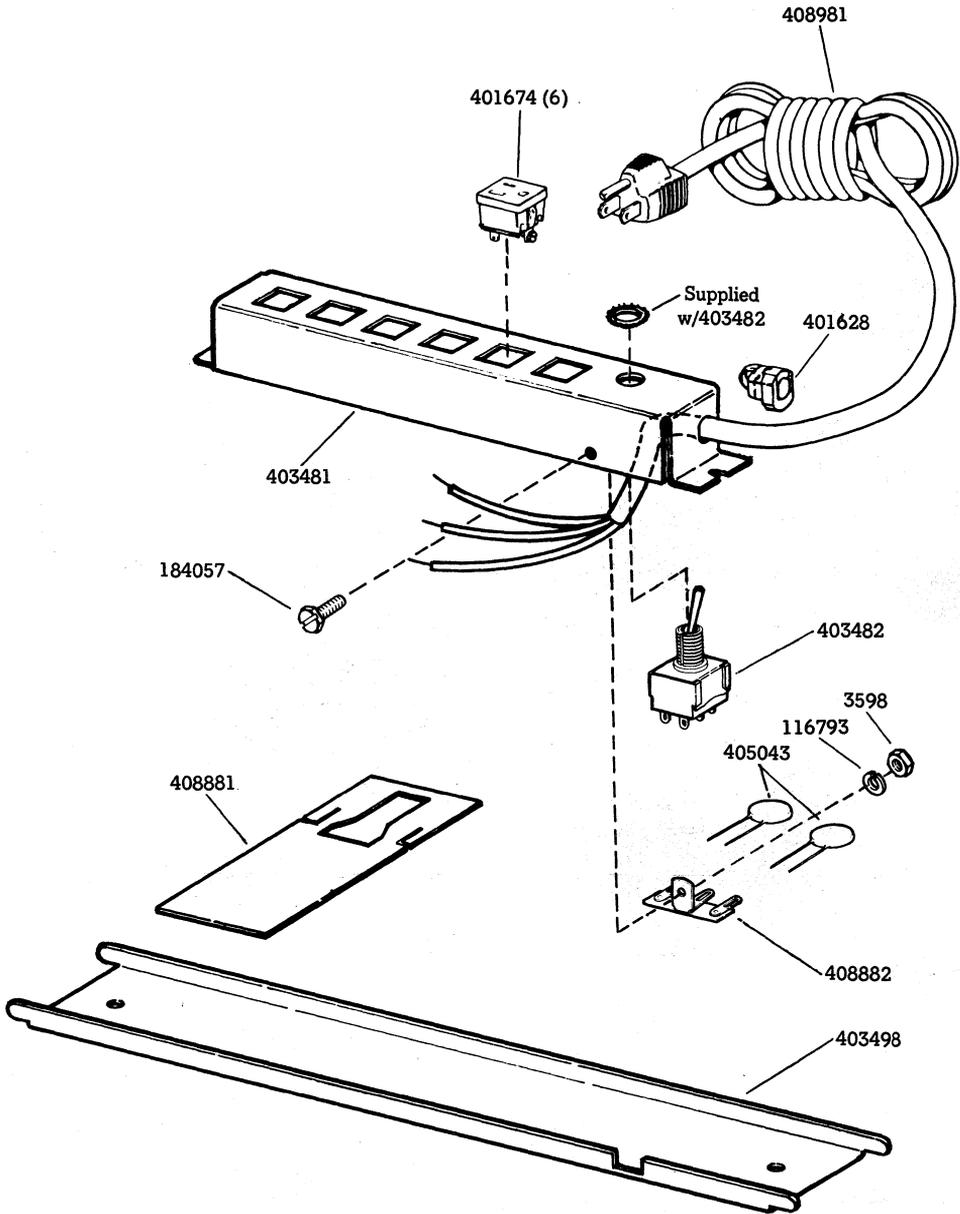
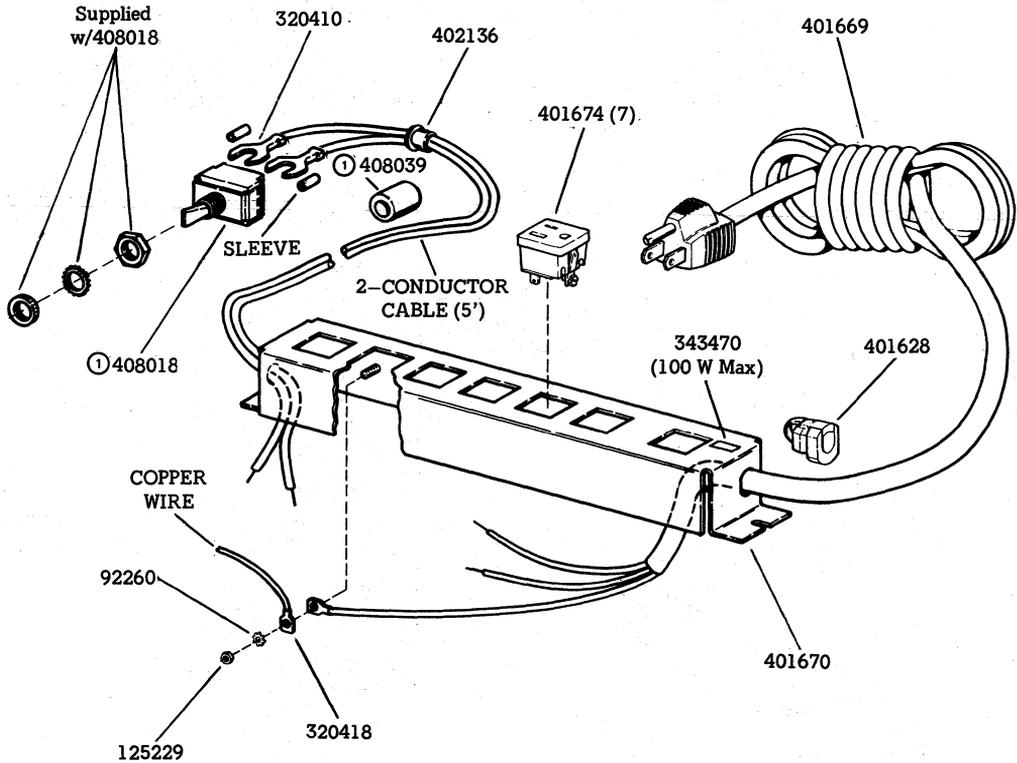


Fig. 44-407285 AC Distribution Assembly (Late Design)



① 408052 Switch Assembly

Fig. 45-401665 AC Distribution Panel Assembly (Early Design)

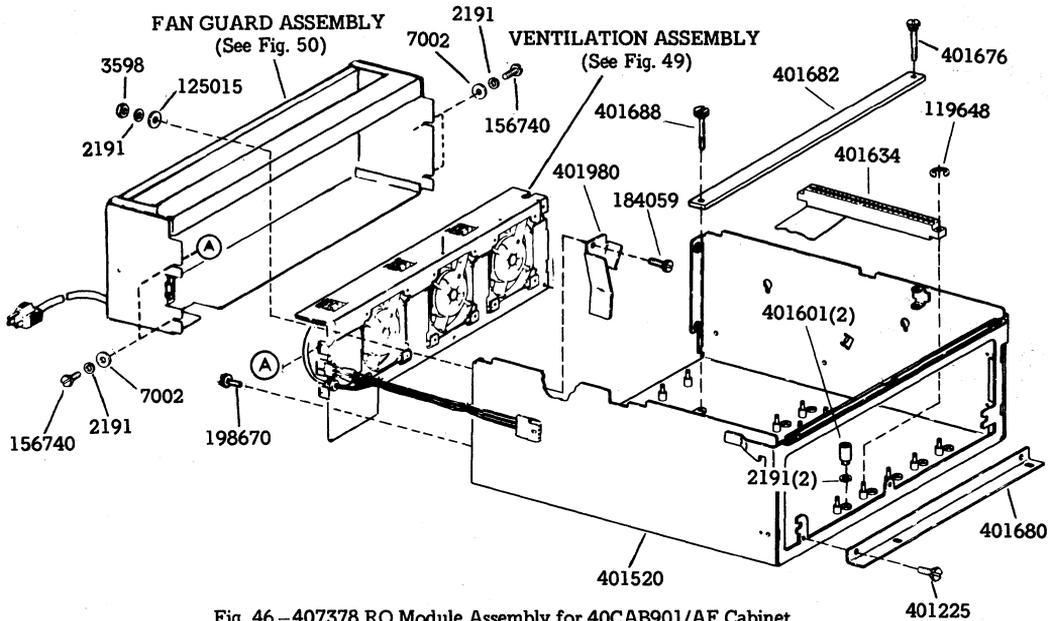


Fig. 46 - 407378 RO Module Assembly for 40CAB901/AF Cabinet
(Air-Flow Through Rear)

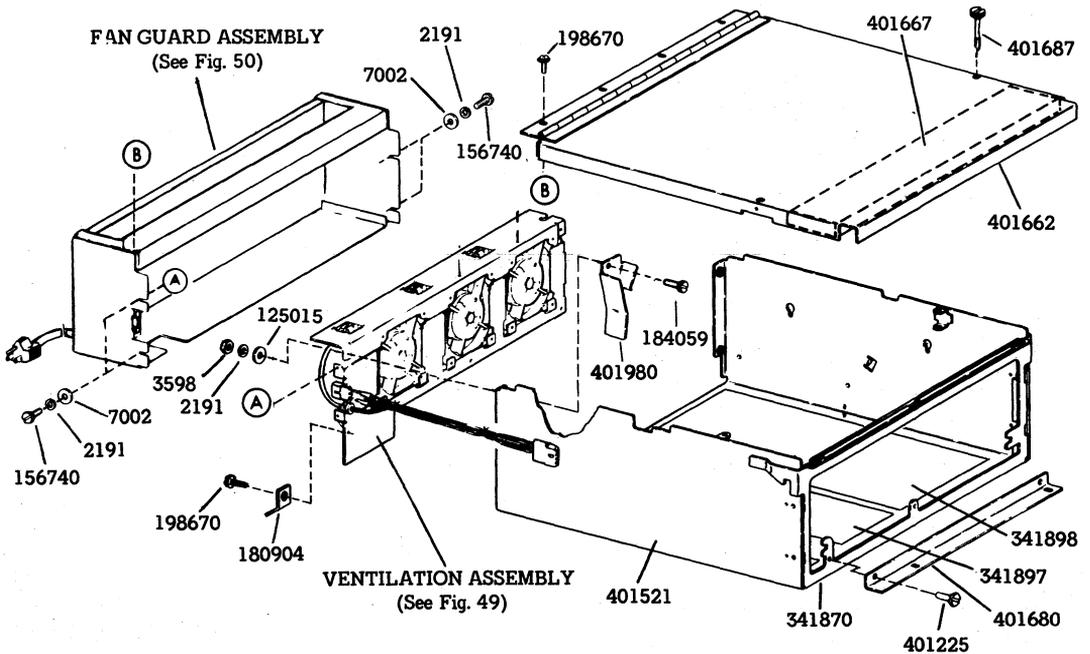
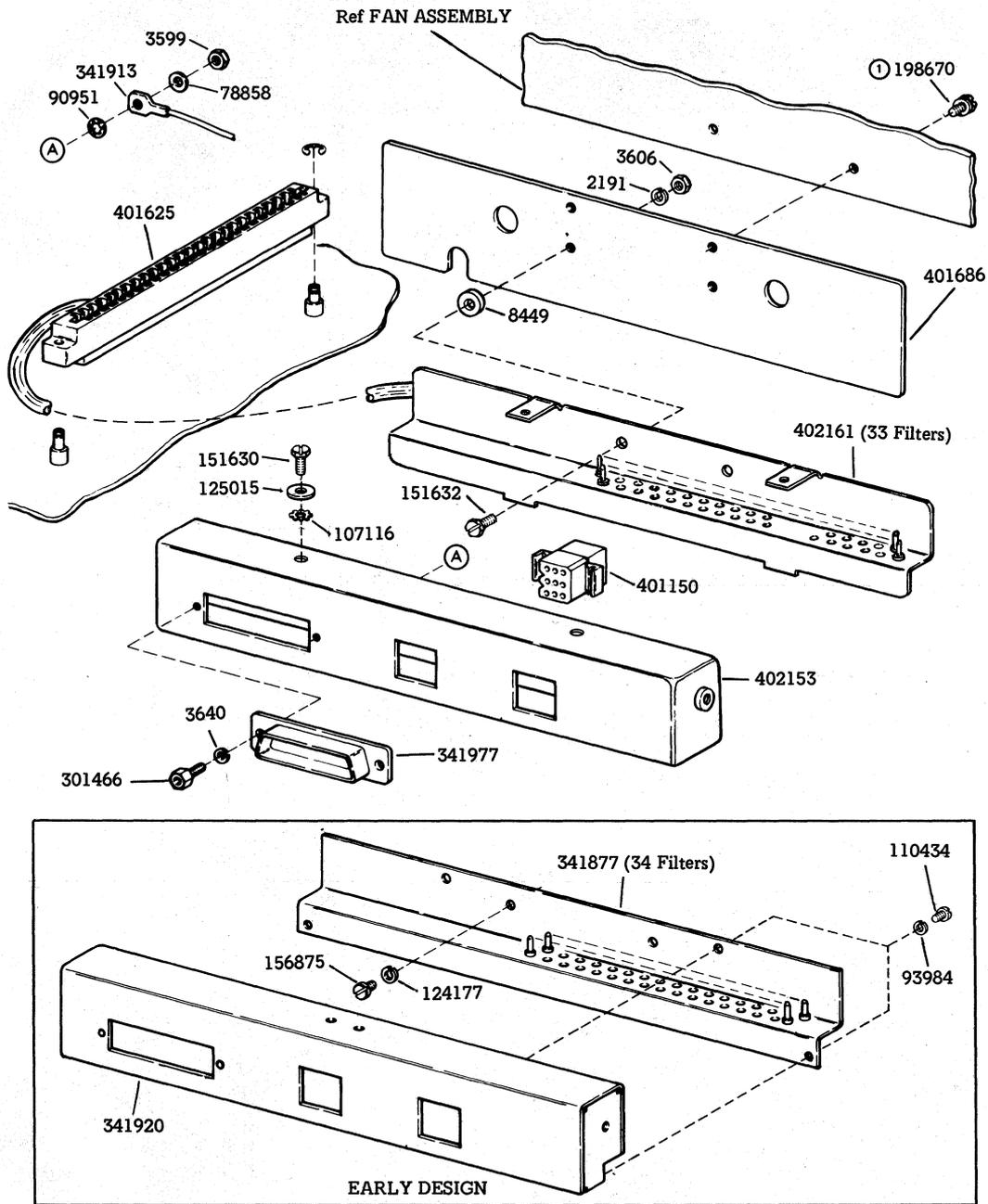


Fig. 47 - KDP Module Assembly for 40CAB901/AG Cabinet
(Air-flow Through Rear)



① Not Part of 401643

Fig. 48-401643 RO Controller Cable Assembly

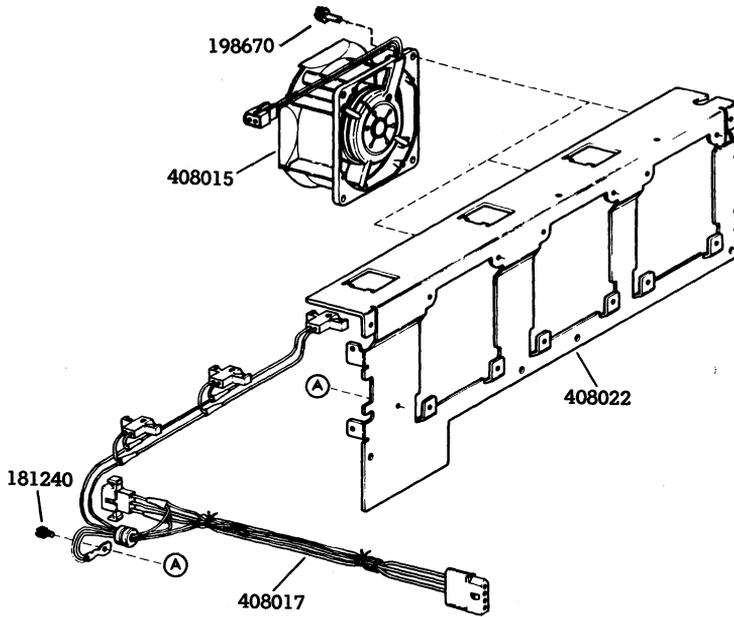


Fig. 49-408050 Ventilation Assembly

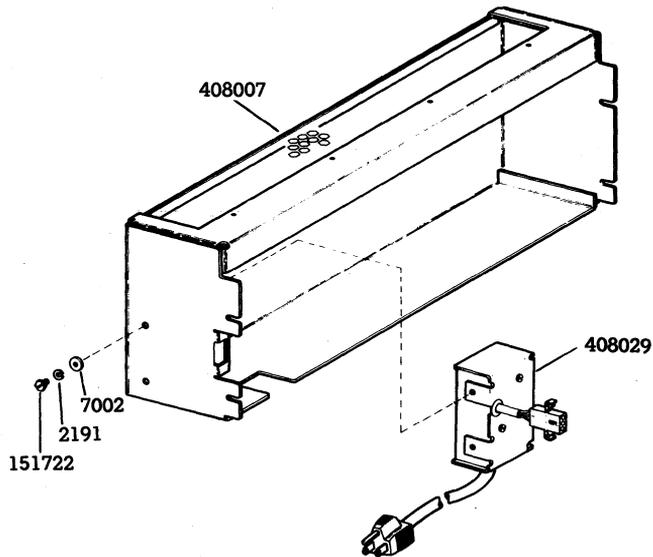


Fig. 50-408030 Fan Guard Assembly

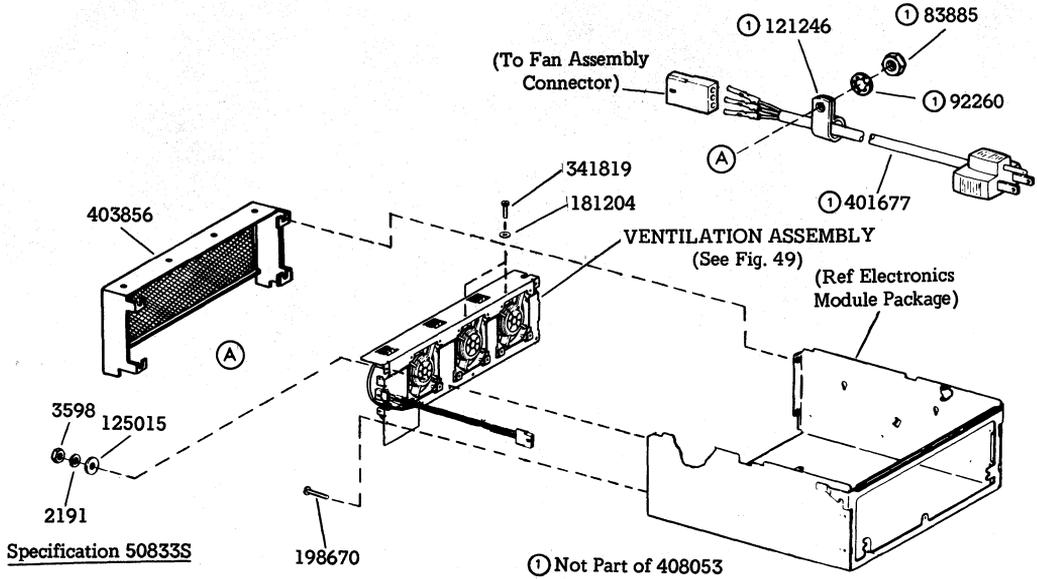


Fig. 51—408053 Modification Kit to Provide Ventilation Assembly to 40CAB901/AF, AG (Air-flow Through Bottom) and 40CAB902/AB Cabinets

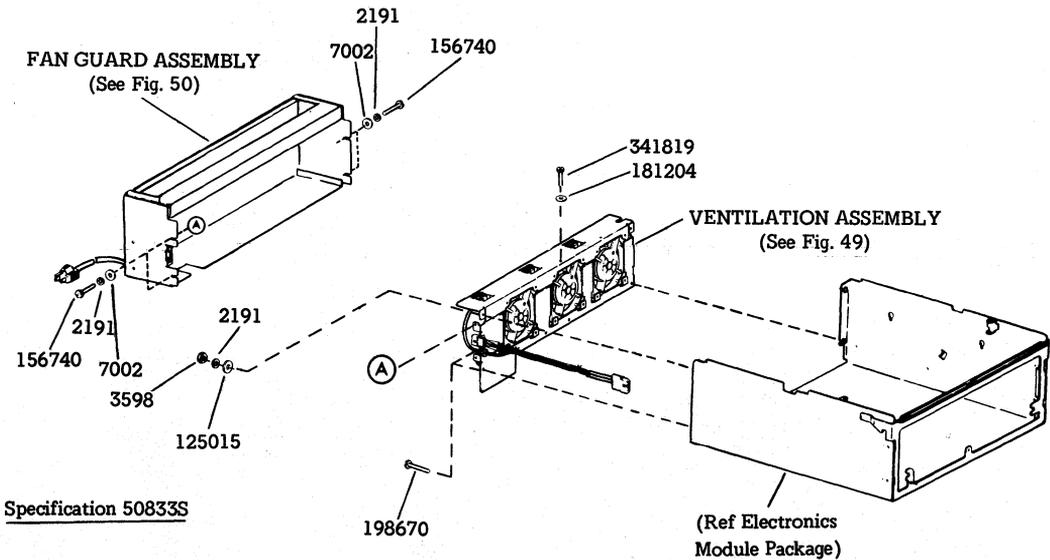


Fig. 52—408054 Modification Kit to Provide Ventilation Assembly to 40CAB901/AF and AG (Air-Flow Through Rear)

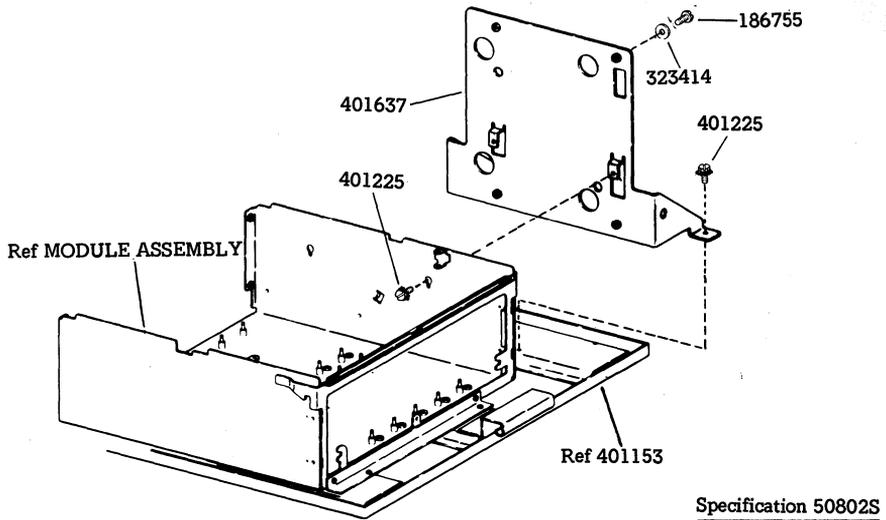
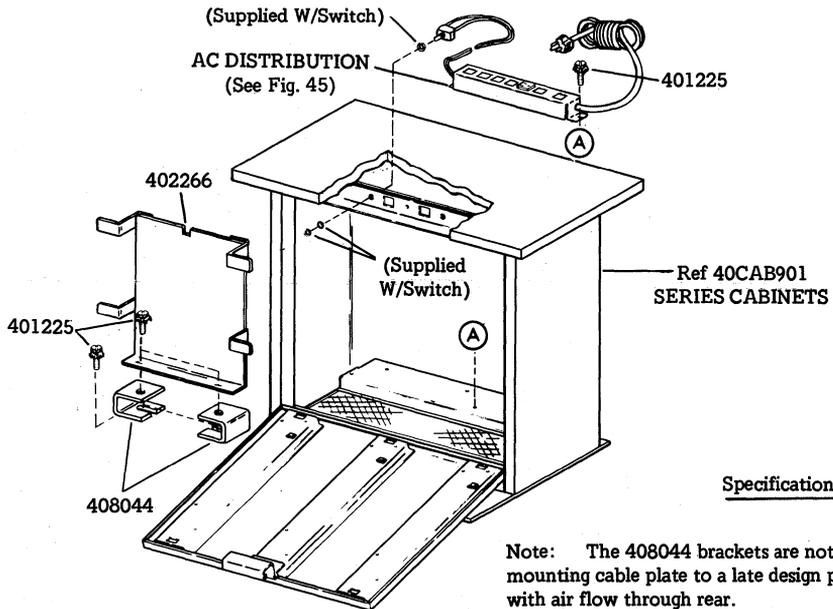
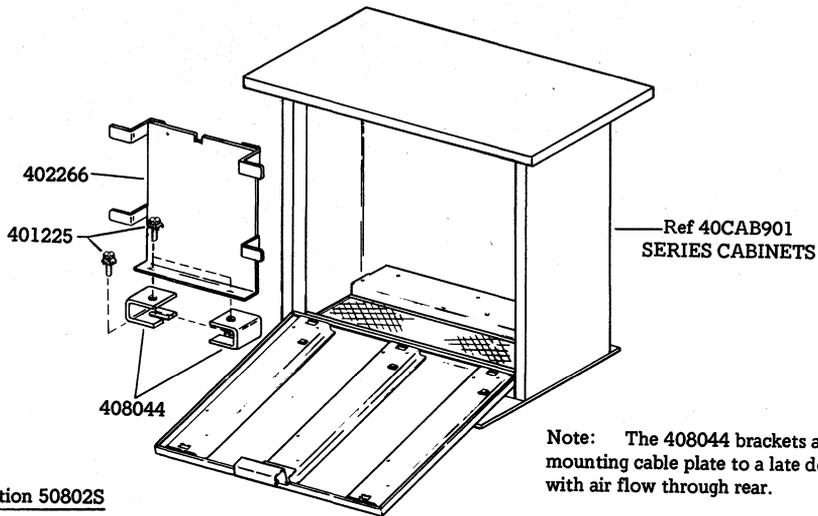


Fig. 53—401725 Modification Kit to Provide a Pedestal Type DATASPEED 40 Cabinet With Data Set 202D or 202R Mounting Facilities (40CAB901/XX)



Note: The 408044 brackets are not used when mounting cable plate to a late design pedestal with air flow through rear.

Fig. 54—408045 Modification Kit to Provide a Pedestal With AC Power Distribution, Terminal Block, Transformer Mounting Facility and Cable Storage



Specification 50802S

Fig. 55—408047 Modification Kit to Provide Cable Storage Facilities

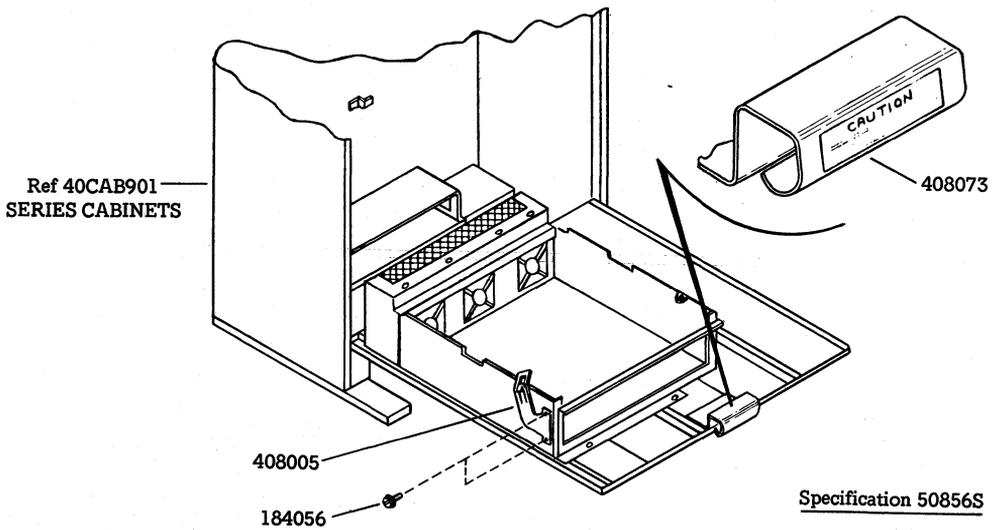


Fig. 56—408049 Modification Kit to Provide Warning Latch and Label

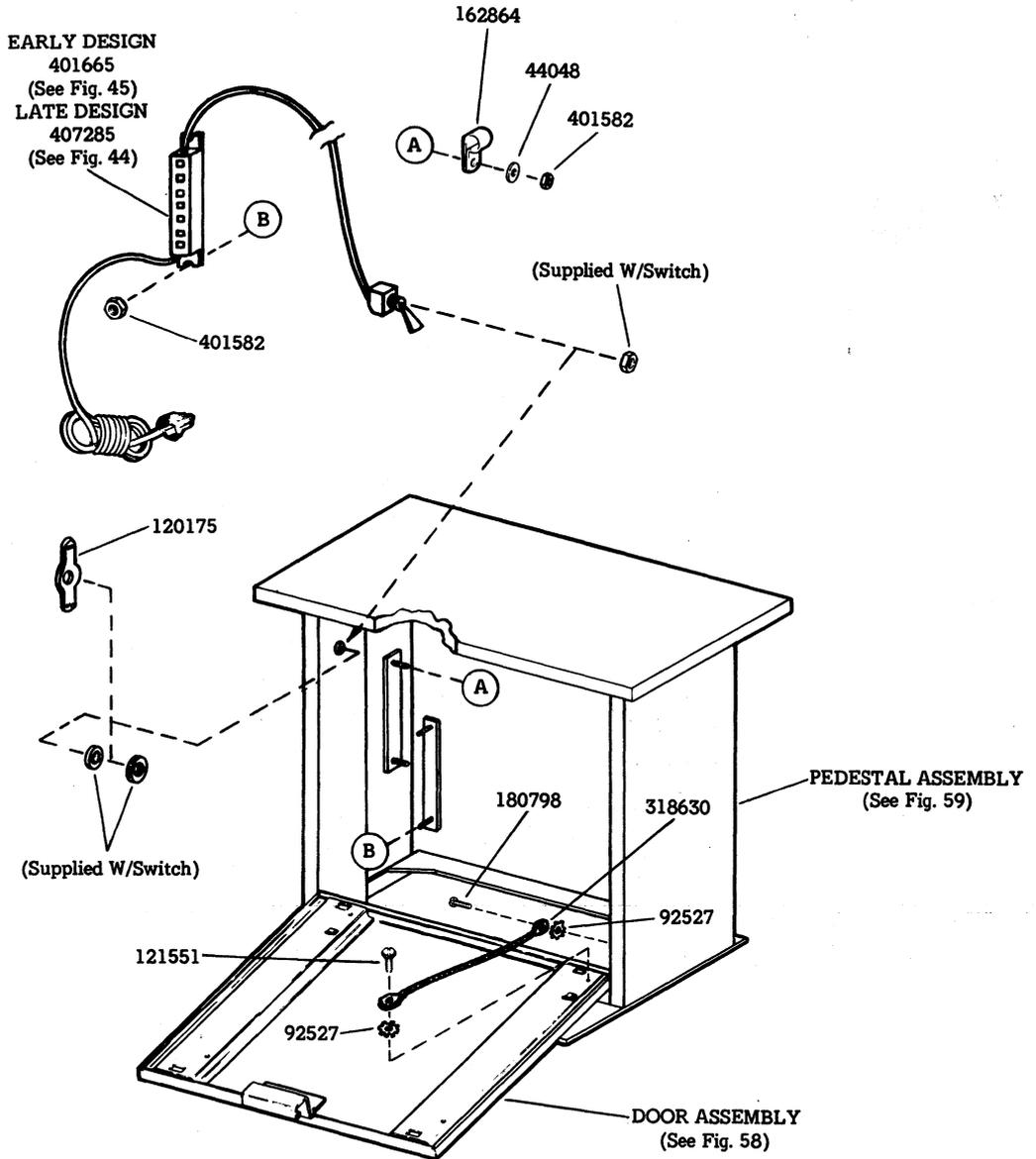


Fig. 57-40CAB902/XX Cabinet (Pedestal Type)

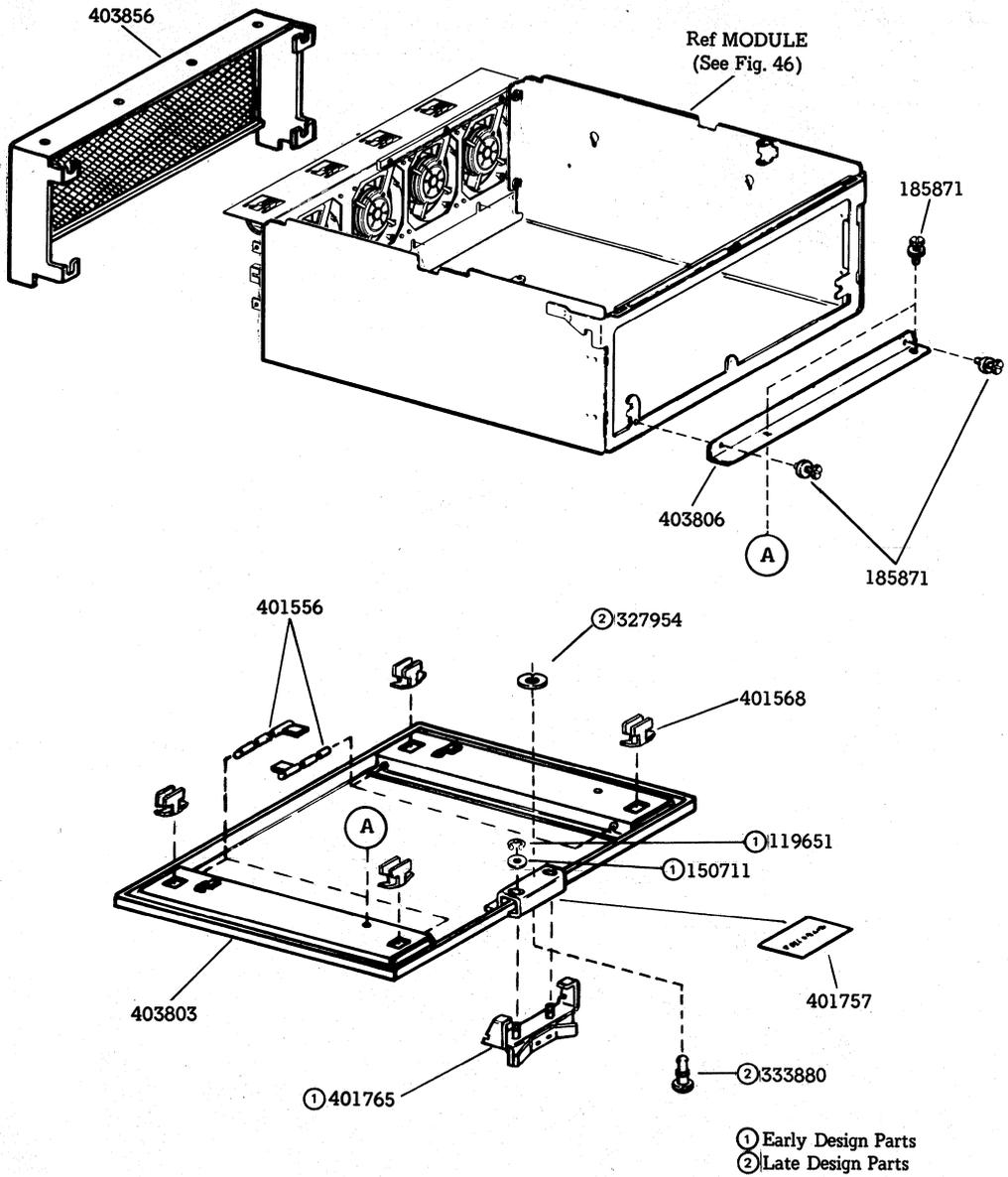
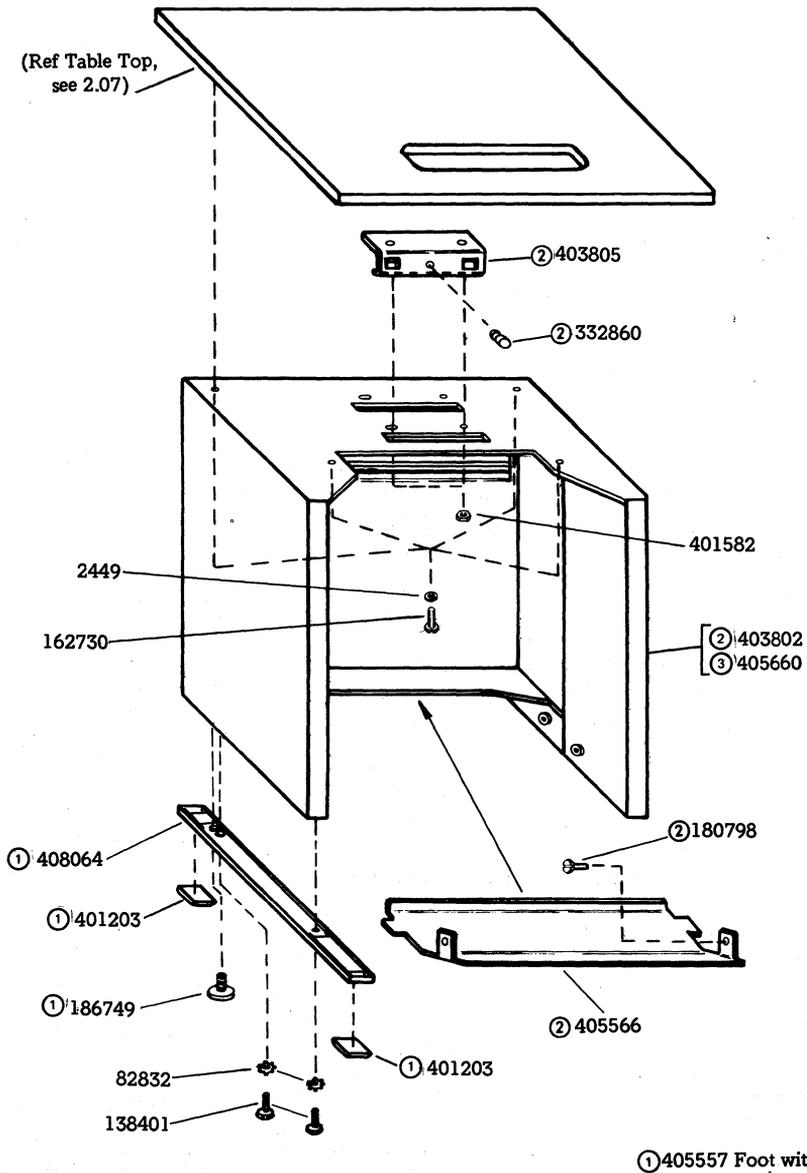


Fig. 58—Pedestal Door and Module



- ② Peculiar to 40CAB902
- ③ Peculiar to 40CAB904

Fig. 59—40CAB902 and 40CAB904 Pedestals

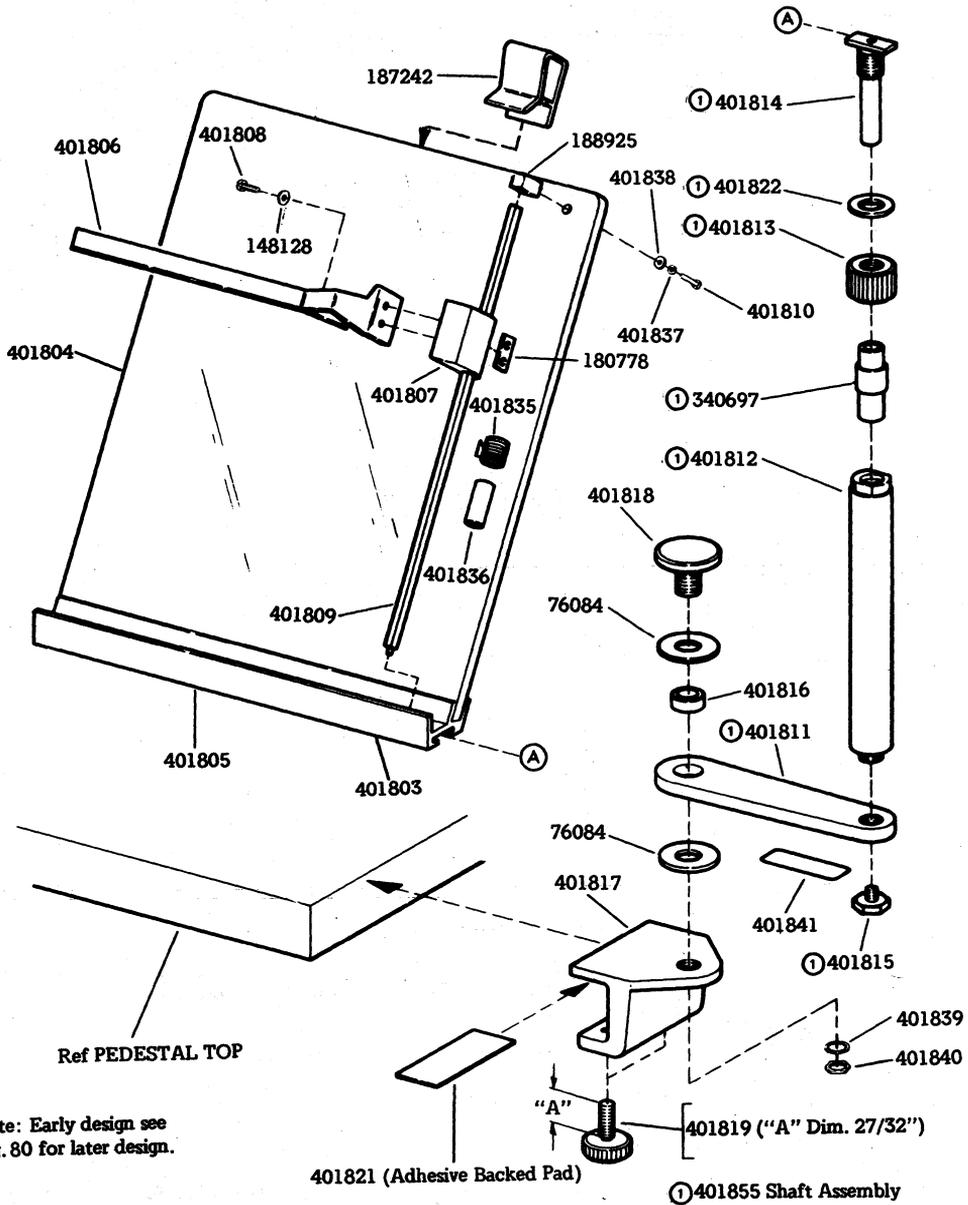


Fig. 60-401200 DATASPEED 40 Copyholder (Early Design)

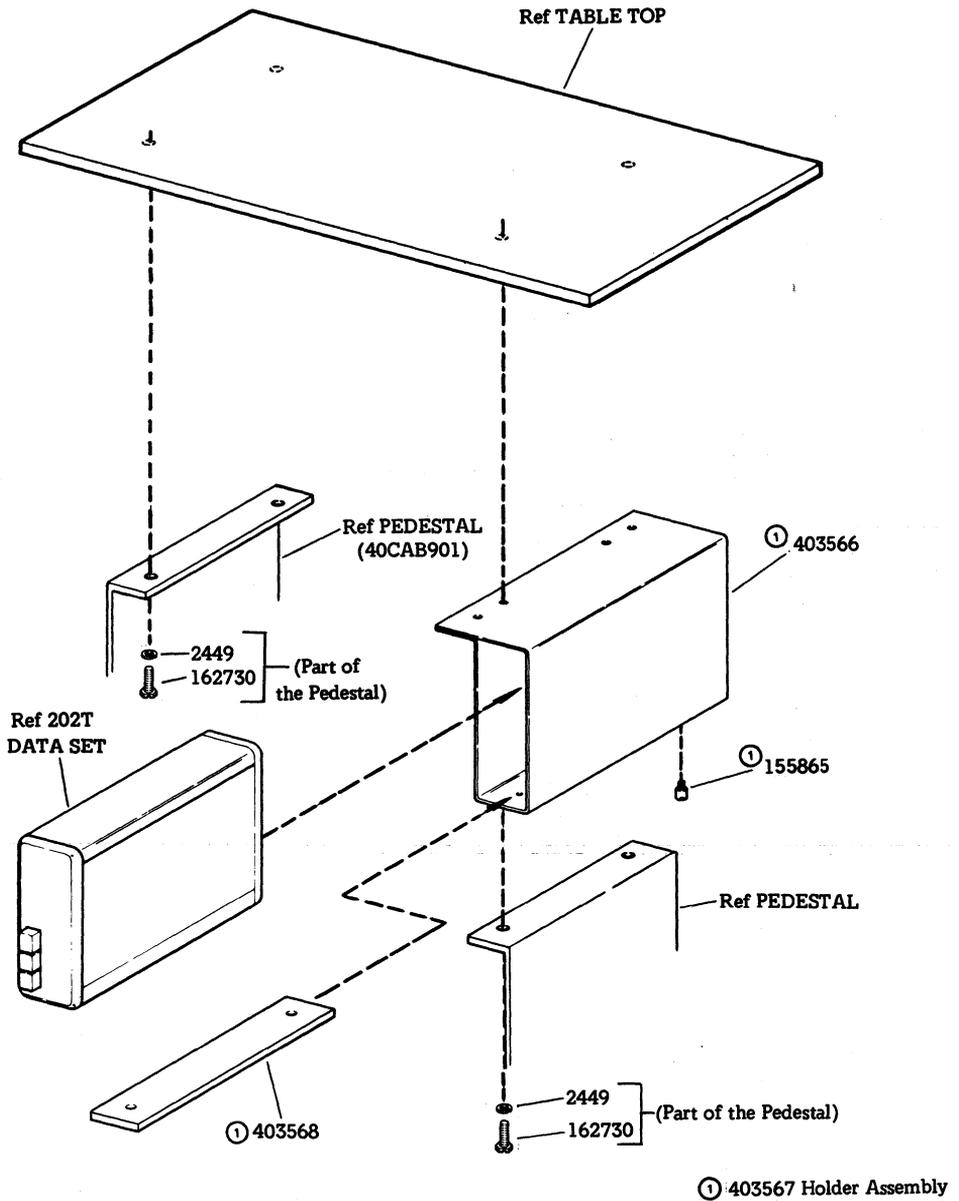


Fig. 61—403567 Holder Assembly for Mounting a Data Set 202S or 202T to a Pedestal Type DATASPEED 40 Cabinet

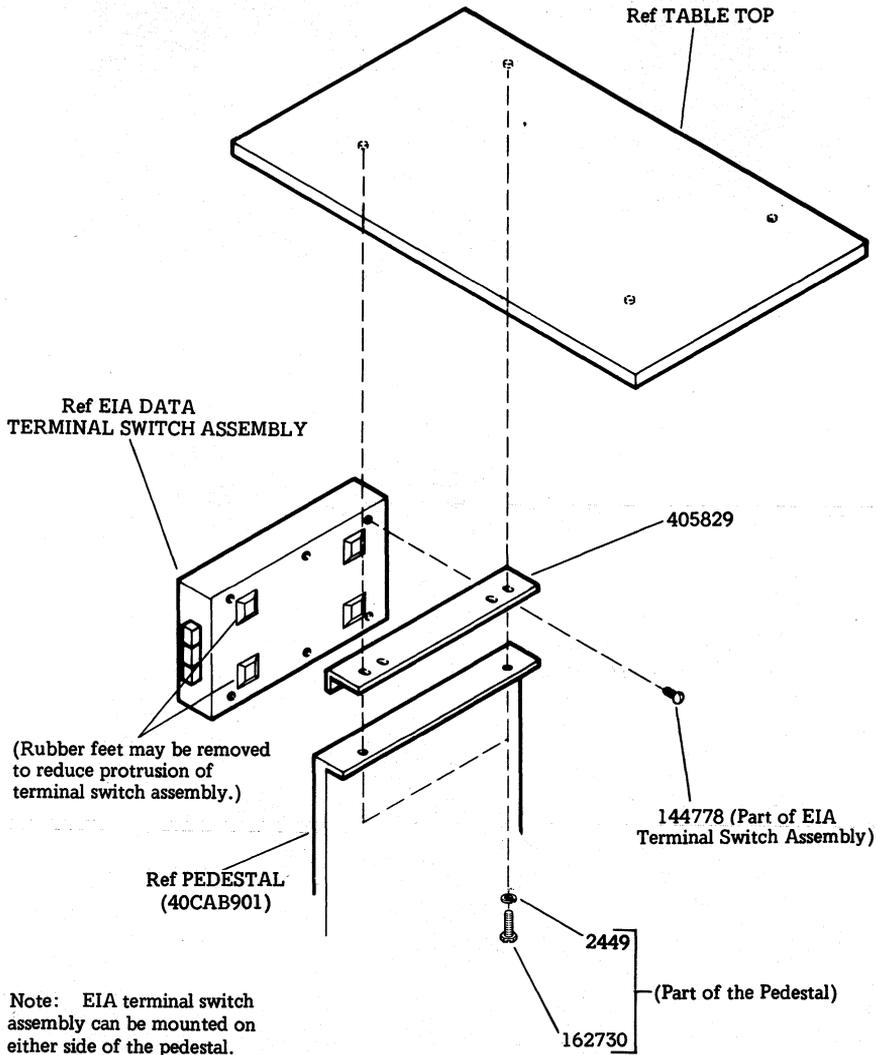


Fig. 62—Mounting for the 345630 EIA Terminal Switch Assembly

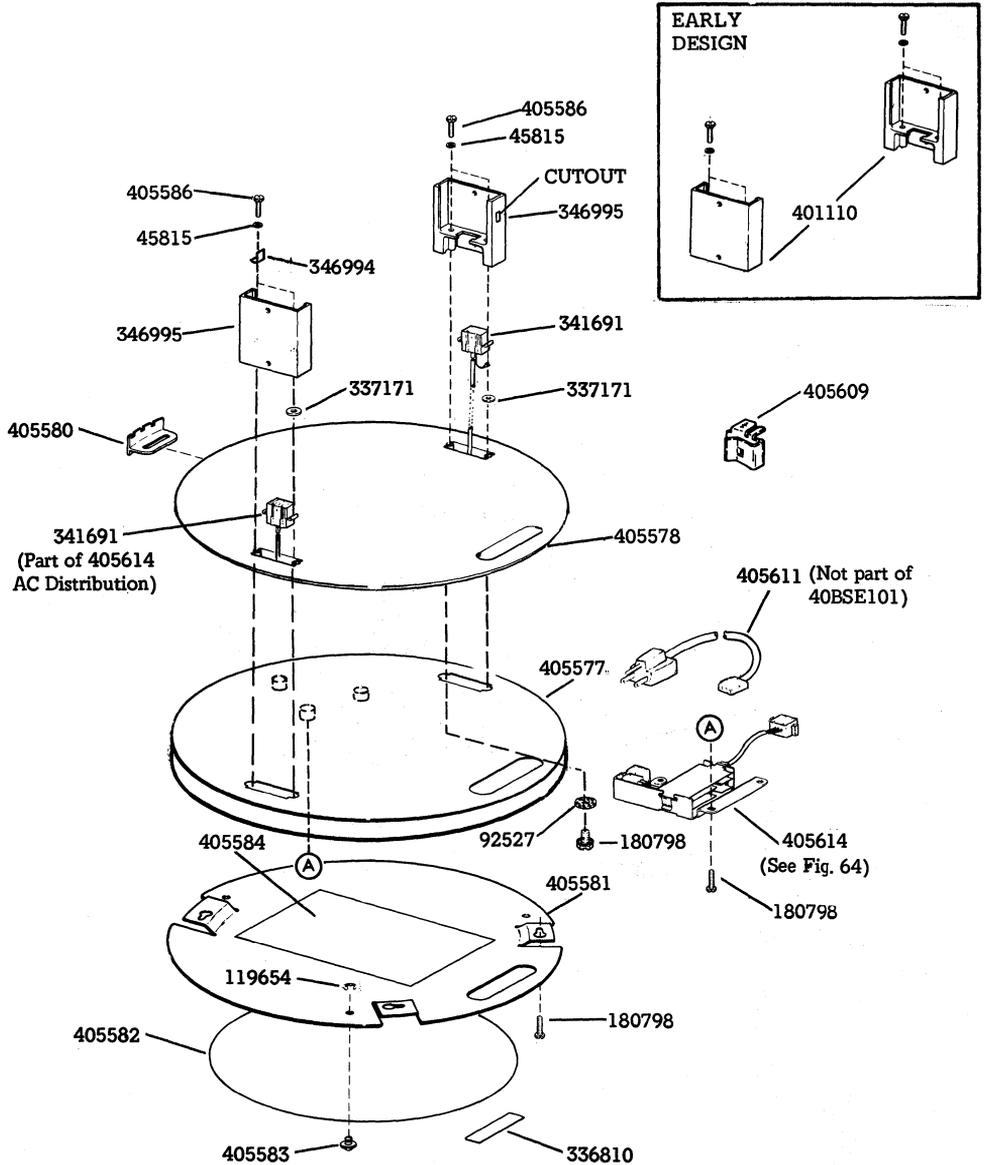


Fig. 63-40BSE101 Monitor Base

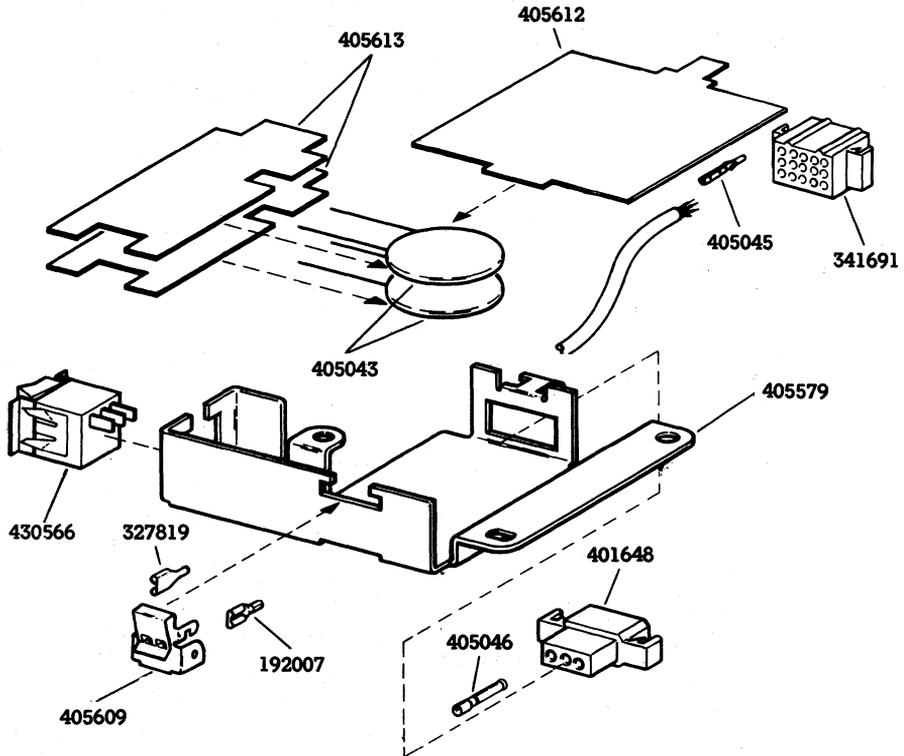


Fig. 64-405614 AC Distribution Assembly

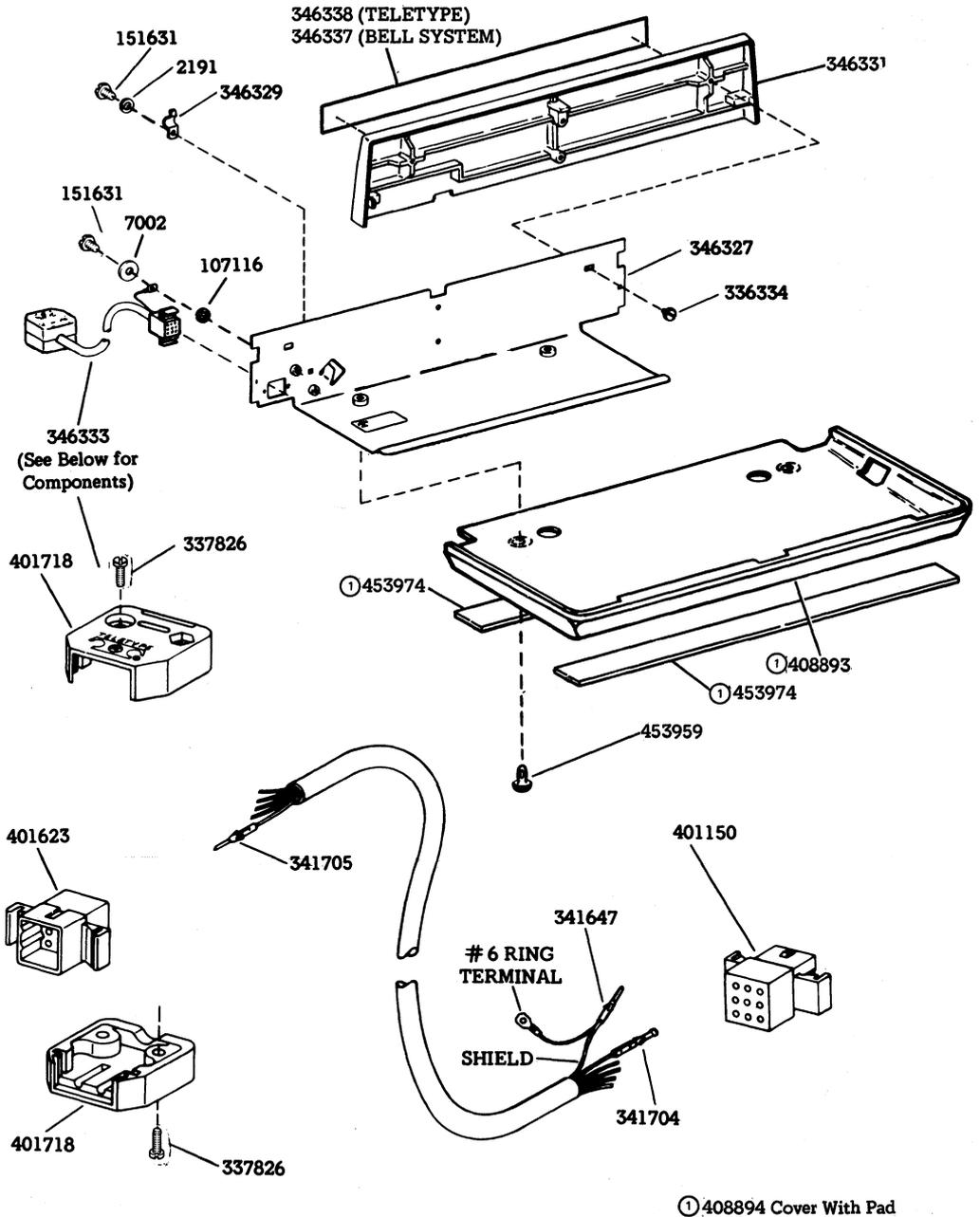


Fig. 65-40BSE201 Operator Console (KD) Base

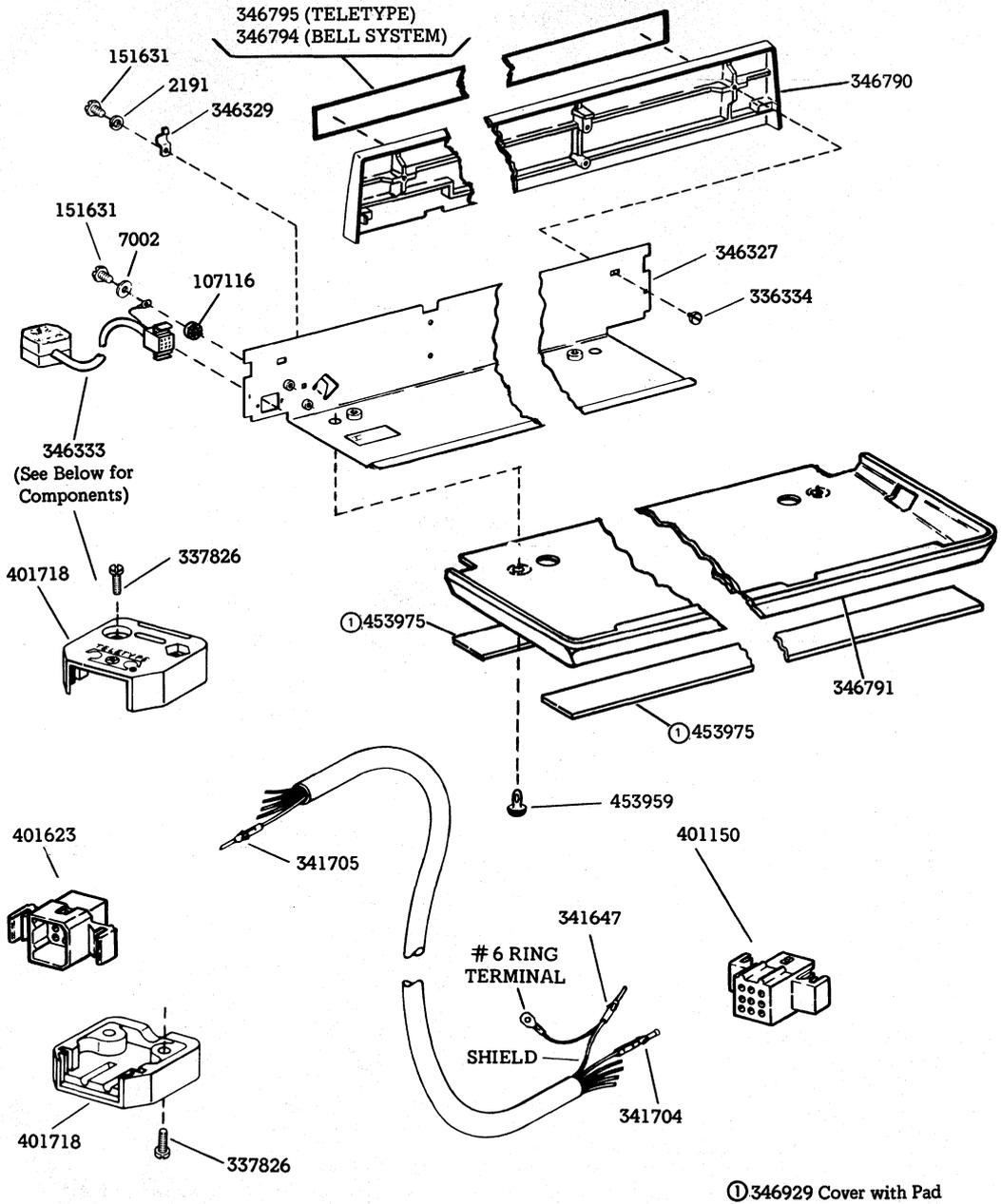


Fig. 66-40BSE202 Operator Console (KD) Wide Base

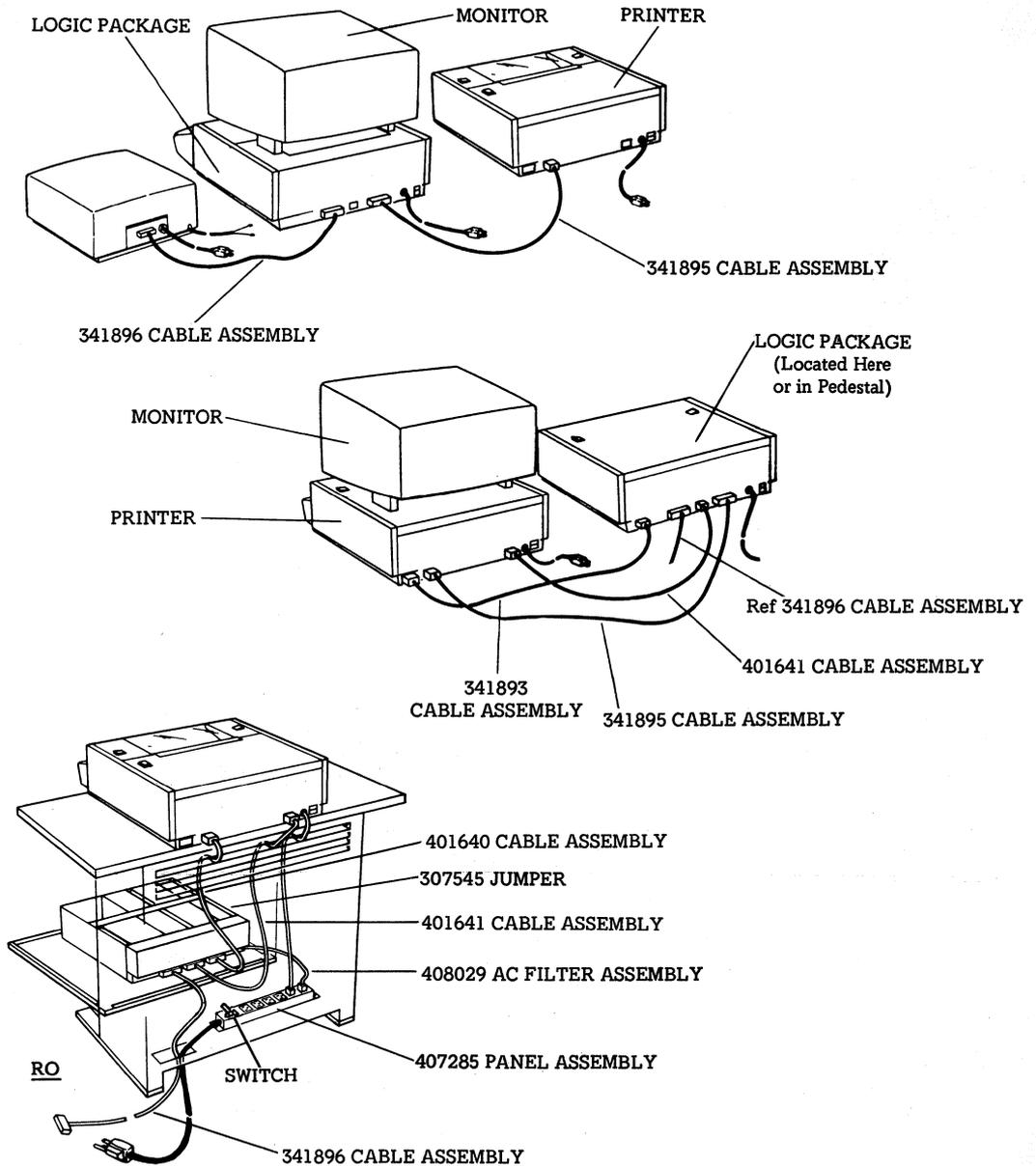


Fig. 67 - Interconnecting Cables for KDP and RO Sets

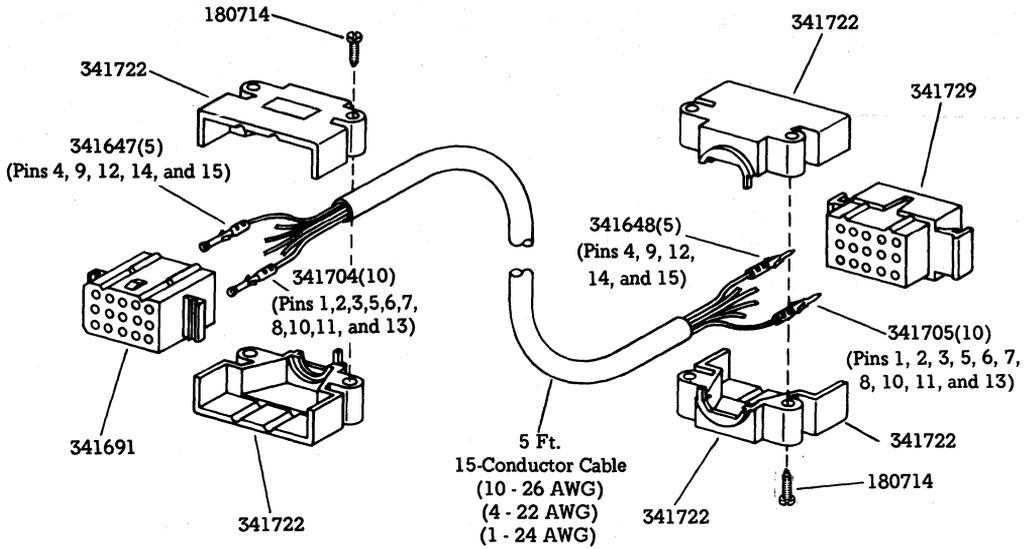


Fig. 68—341893 Monitor Extension Cable Assembly

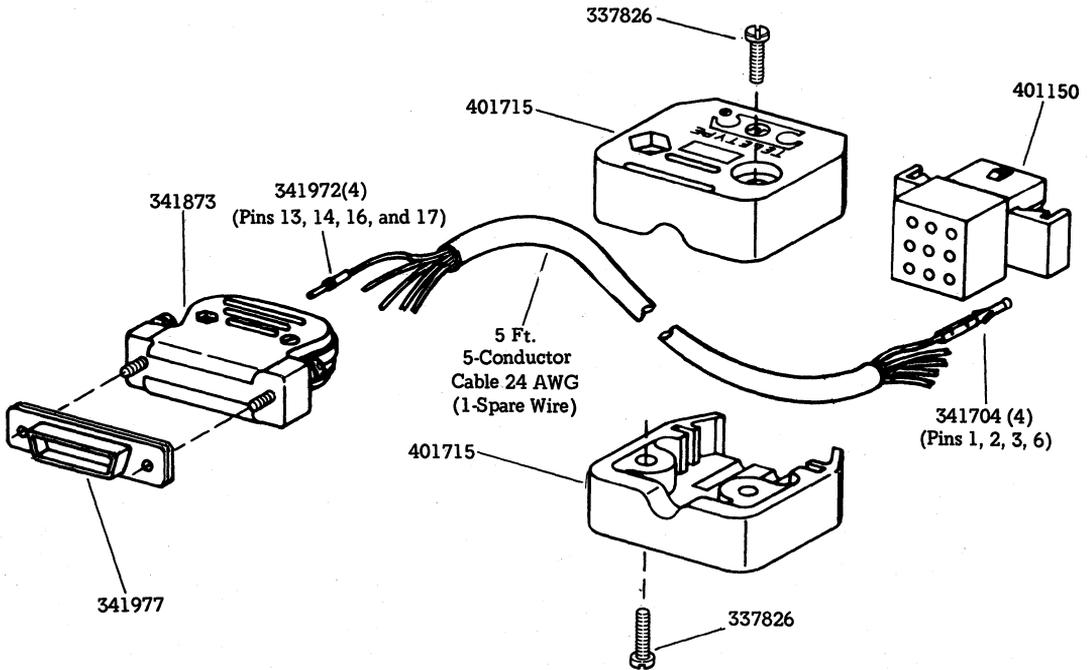


Fig. 69—341895 Printer Extension Cable Assembly

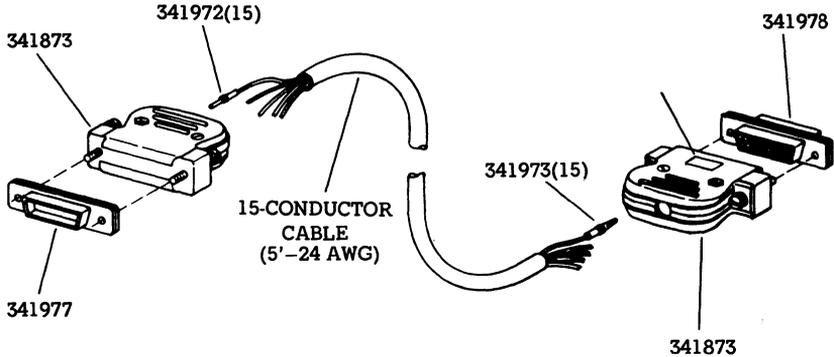
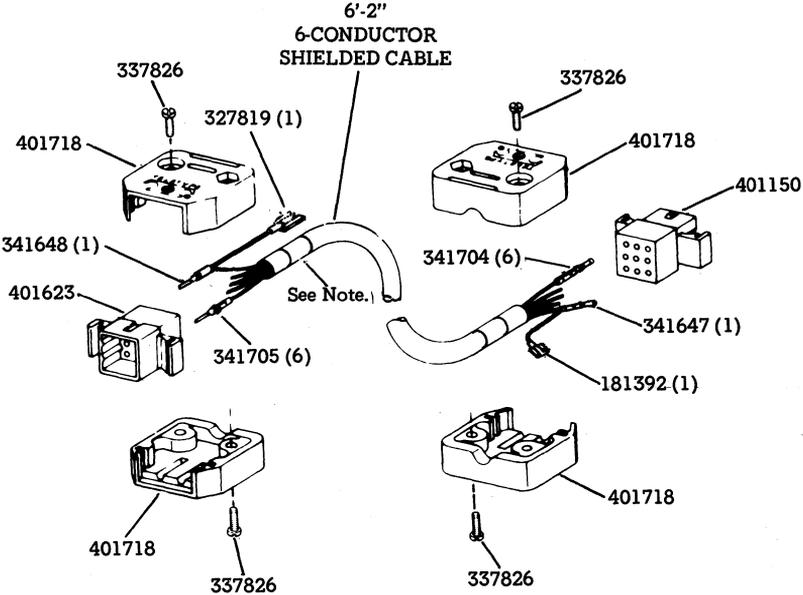
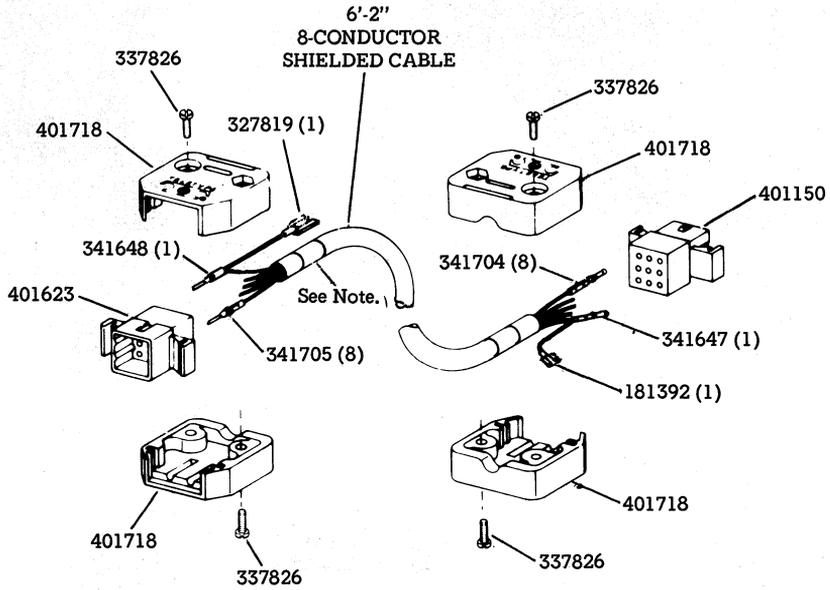


Fig. 70-341896 Data Set Cable Assembly



Note: Cable marker at each end identifies part number of cable.

Fig. 71-401640 Printer Extension Cable Assembly



Note: Cable marker at each end identifies part number of cable.

Fig. 72-401641 Opcon Extension Cable Assembly

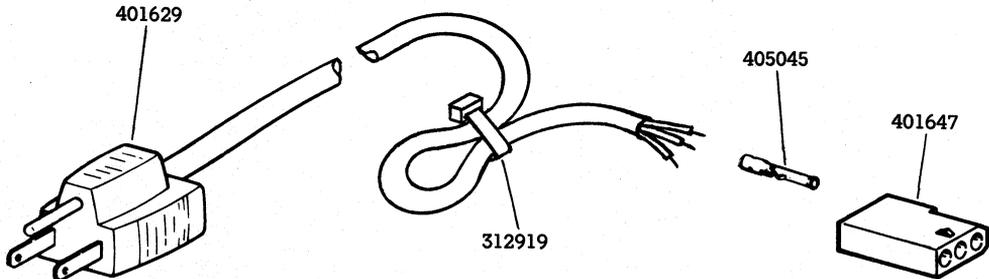


Fig. 73-405611 AC Cord Assembly

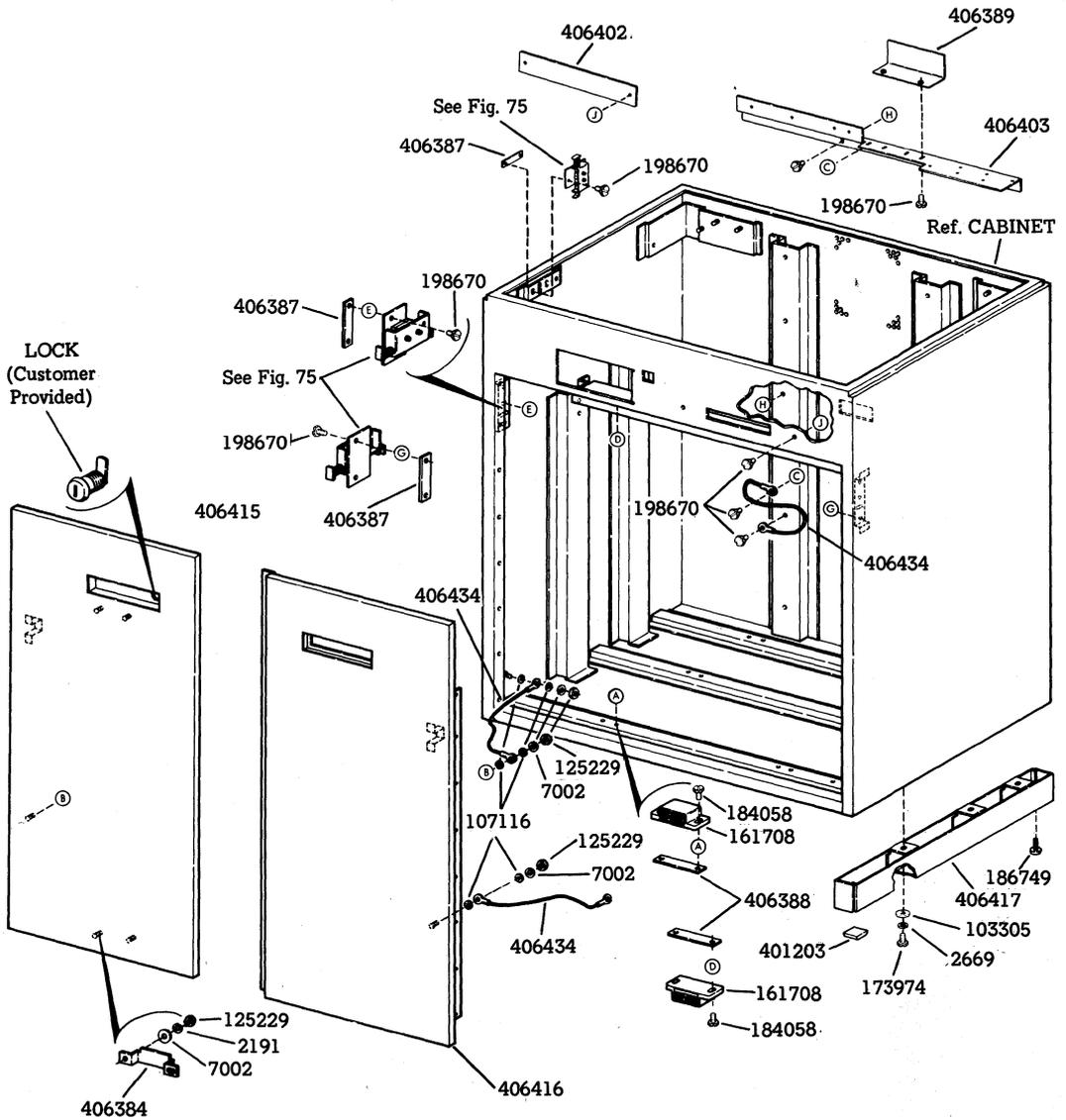


Fig. 74-40CAB302/ZZ Printer Cabinet Core for Forms Access Printer Cabinet

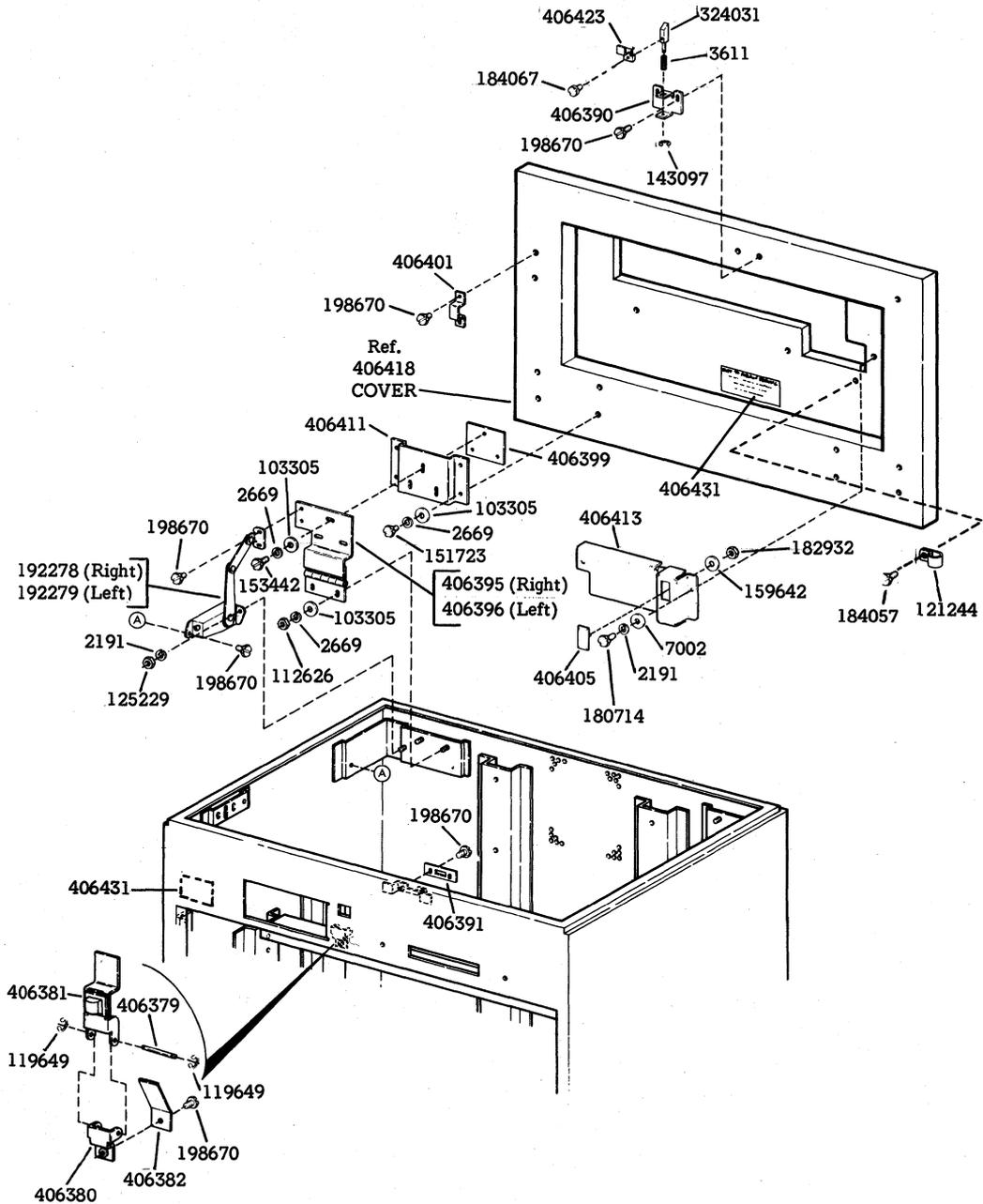


Fig. 74-40CAB302/ZZ Printer Cabinet Core for Forms Access Printer Cabinet (Cont)

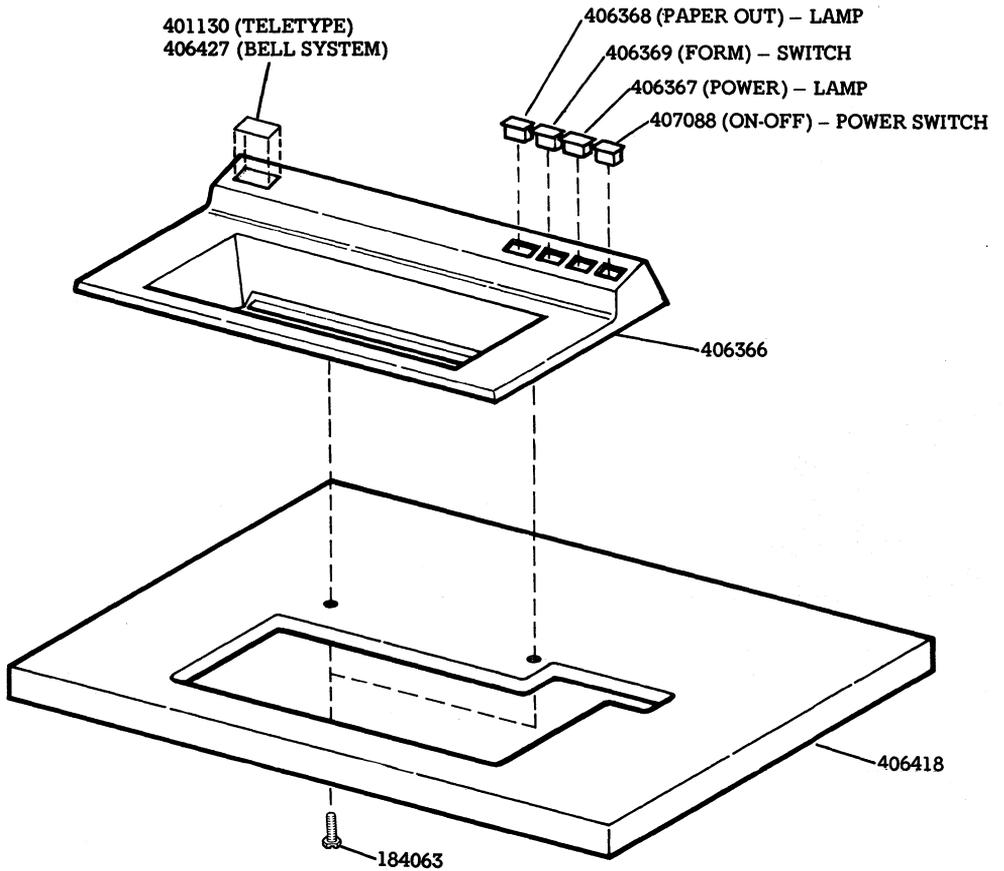


Fig. 74-40CAB302/ZZ Printer Cabinet Core for Forms Access Printer Cabinet (Cont)

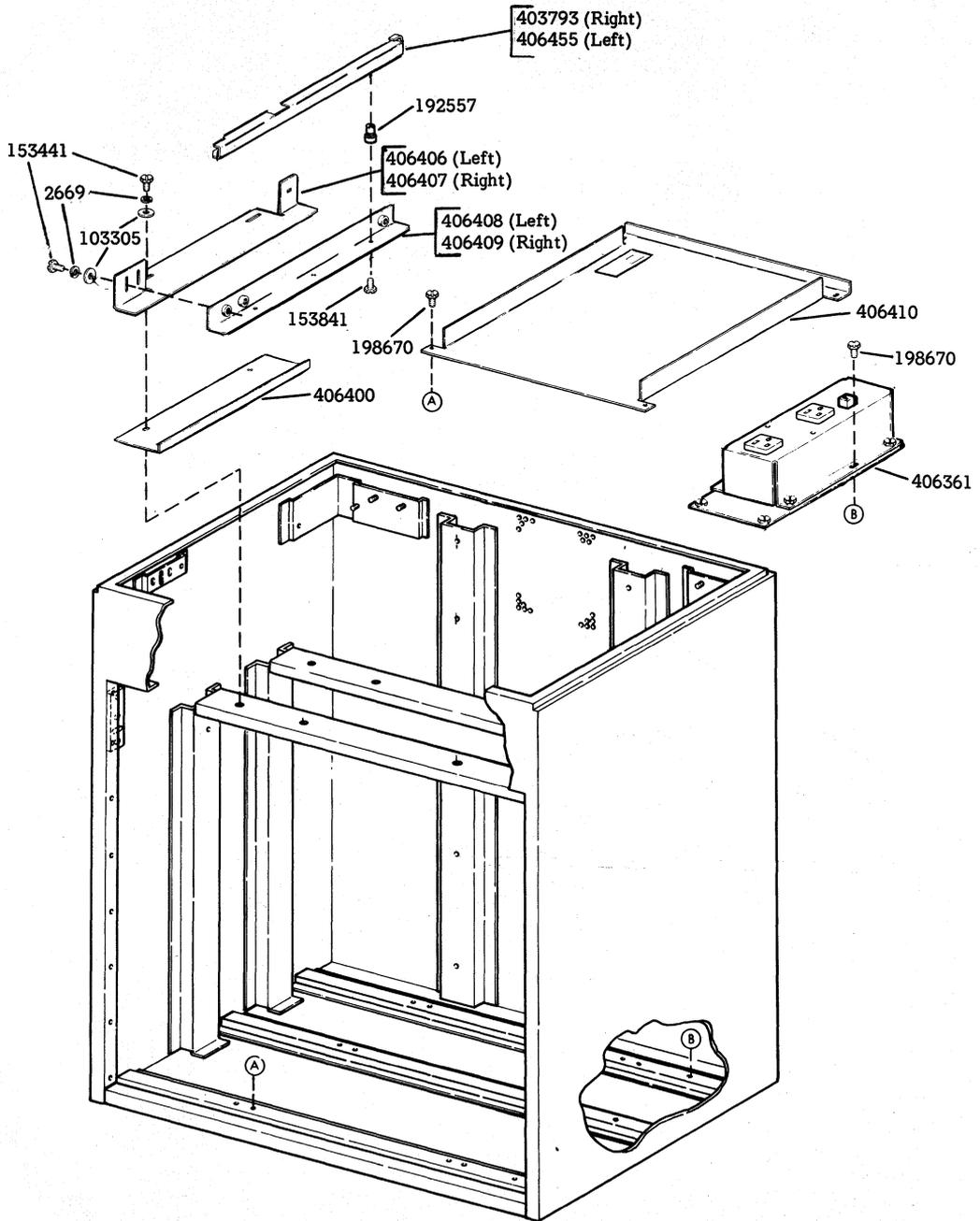
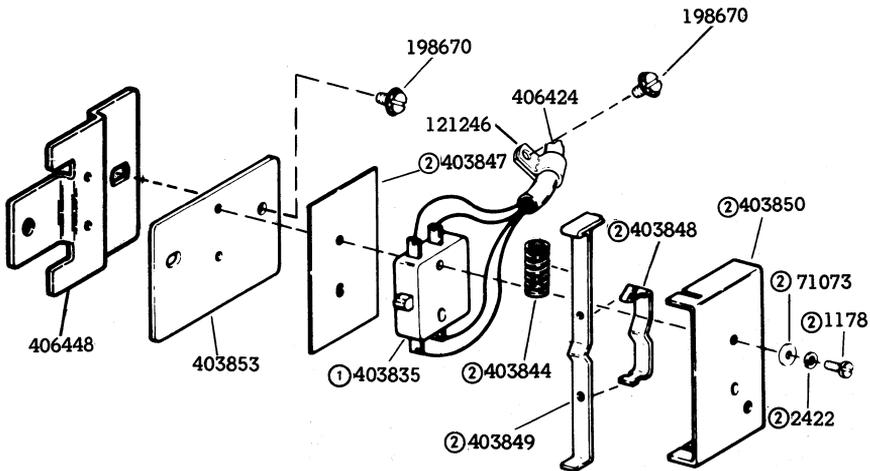
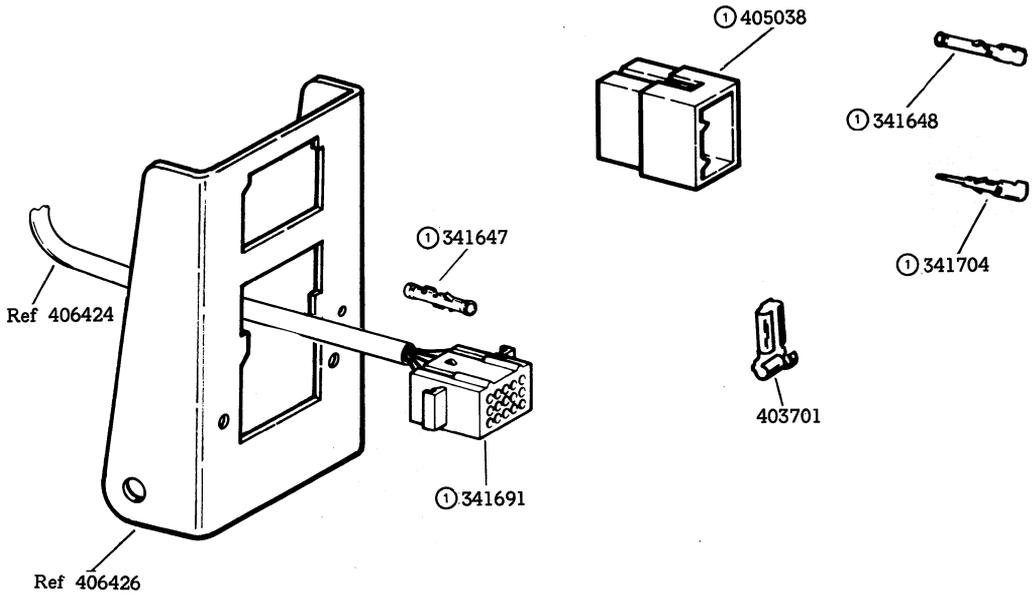
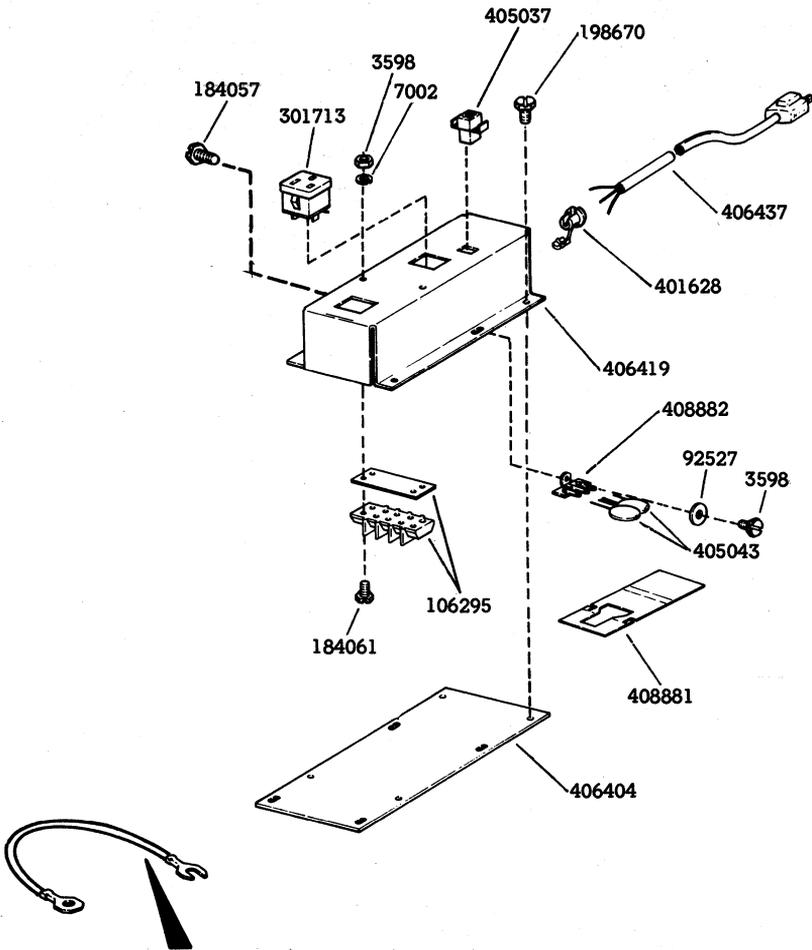


Fig. 74-40CAB302/ZZ Printer Cabinet Core for Forms Access Printer Cabinet (Cont)



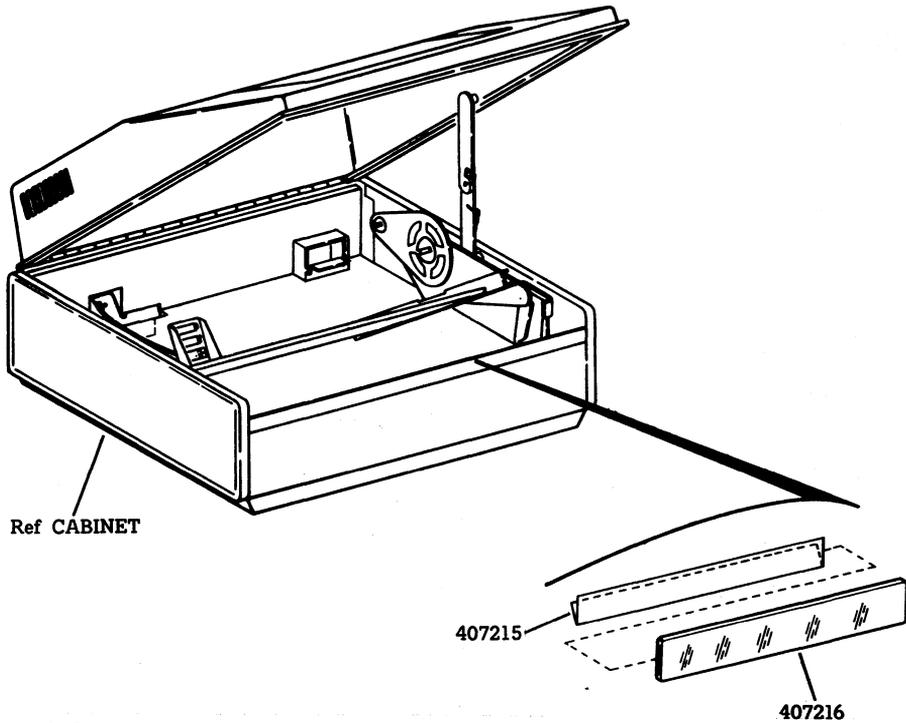
- ① Part of 406424 Cable
- ② 406442 Interlock Switch Assembly

Fig. 75-406432 Cable Assembly



STRAP NO.	COLOR	LENGTH	TERMINAL
188990	W	5"	2
188993	G	4"	2
188989	BK	5 1/2"	2
312574	BK	6"	1
318630	Braided	6"	2
325911	G	6-1/2"	1
326755	G	3-1/2"	1
406360	G	3-1/2"	2
406362	W	7"	3
406363	G	3"	1
406364	BK	5"	2
406365	W	5"	1

Fig. 76-406361 AC Distribution Assembly



Note: The following 40-type units could make use of the 407216 holder and 407215 label:

40CAB201/AA, AC
40CAB251/AA, AB, AC
40CAB351/AA, AB, AC, AD, AE
40CAB353/AA, AB, AC, AD
40CAB371/AA, AB

Fig. 77—Label and Label Holder for 40-Type Terminals

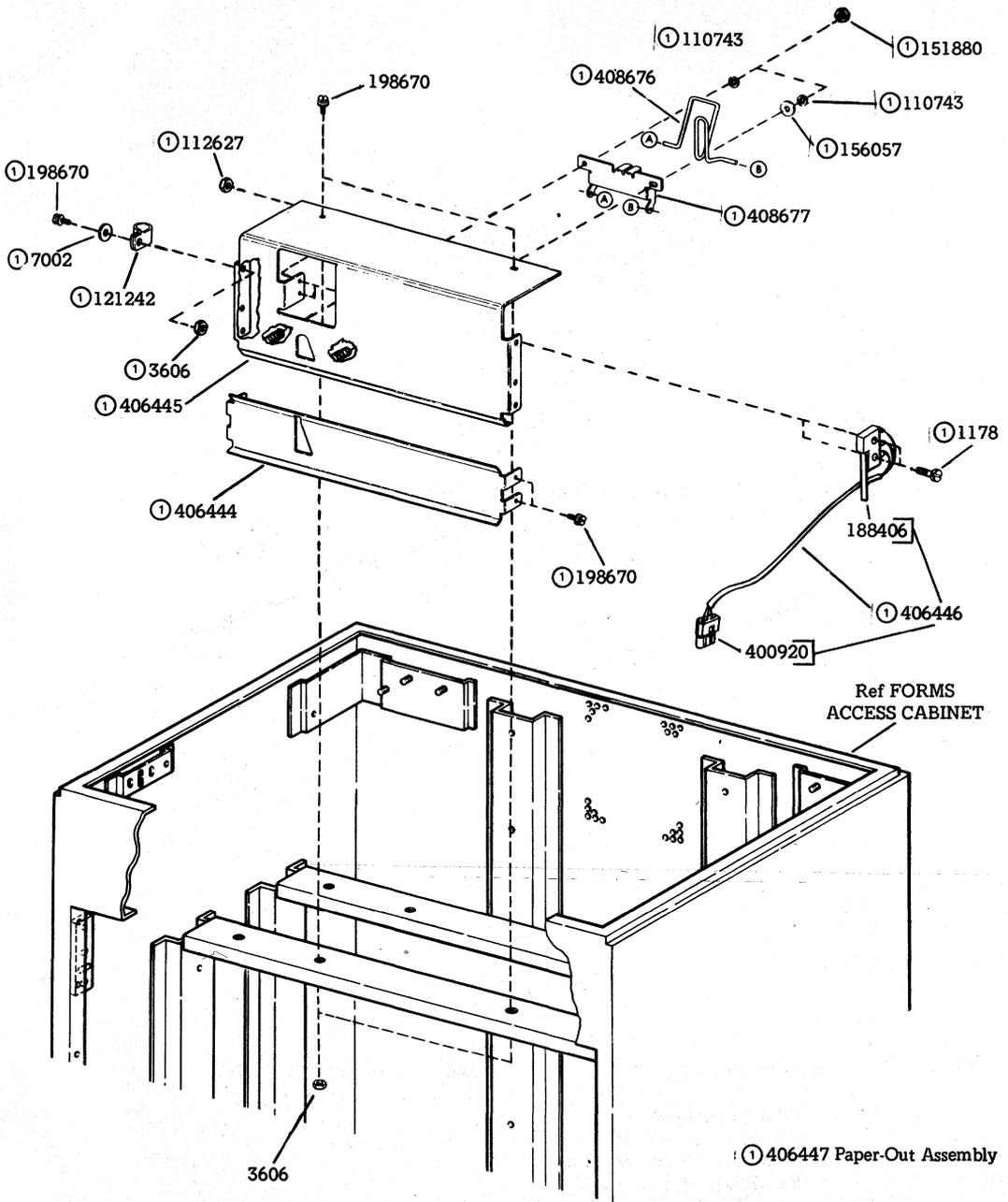
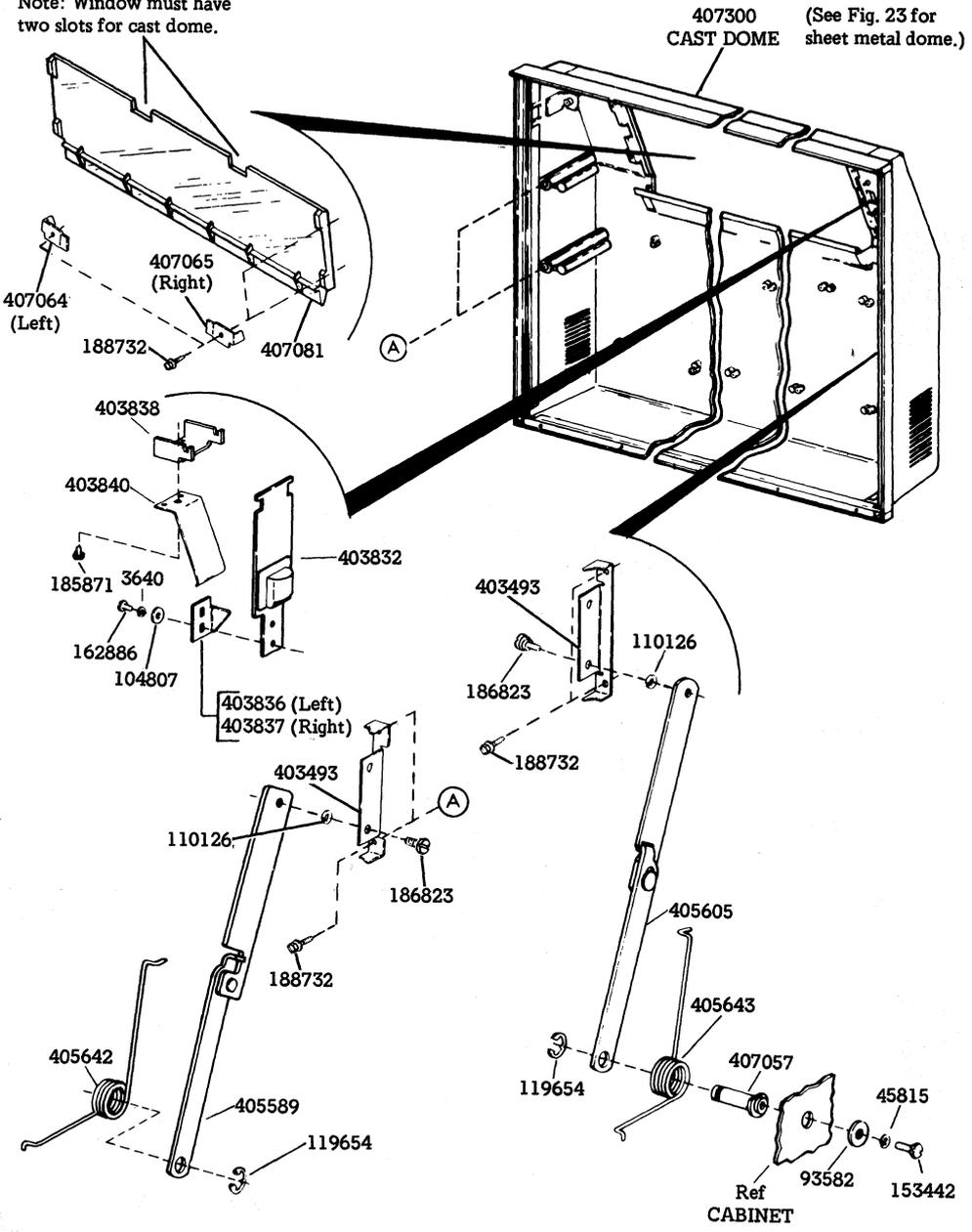


Fig. 78—406374 Modification Kit to Provide Paper-Out Contact Closure 11 Inches Below Print Line in the Forms Access Printer Cabinet

Note: Window must have two slots for cast dome.



Dome - Cast Aluminum

Fig. 79-40CAB353/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 132 Column

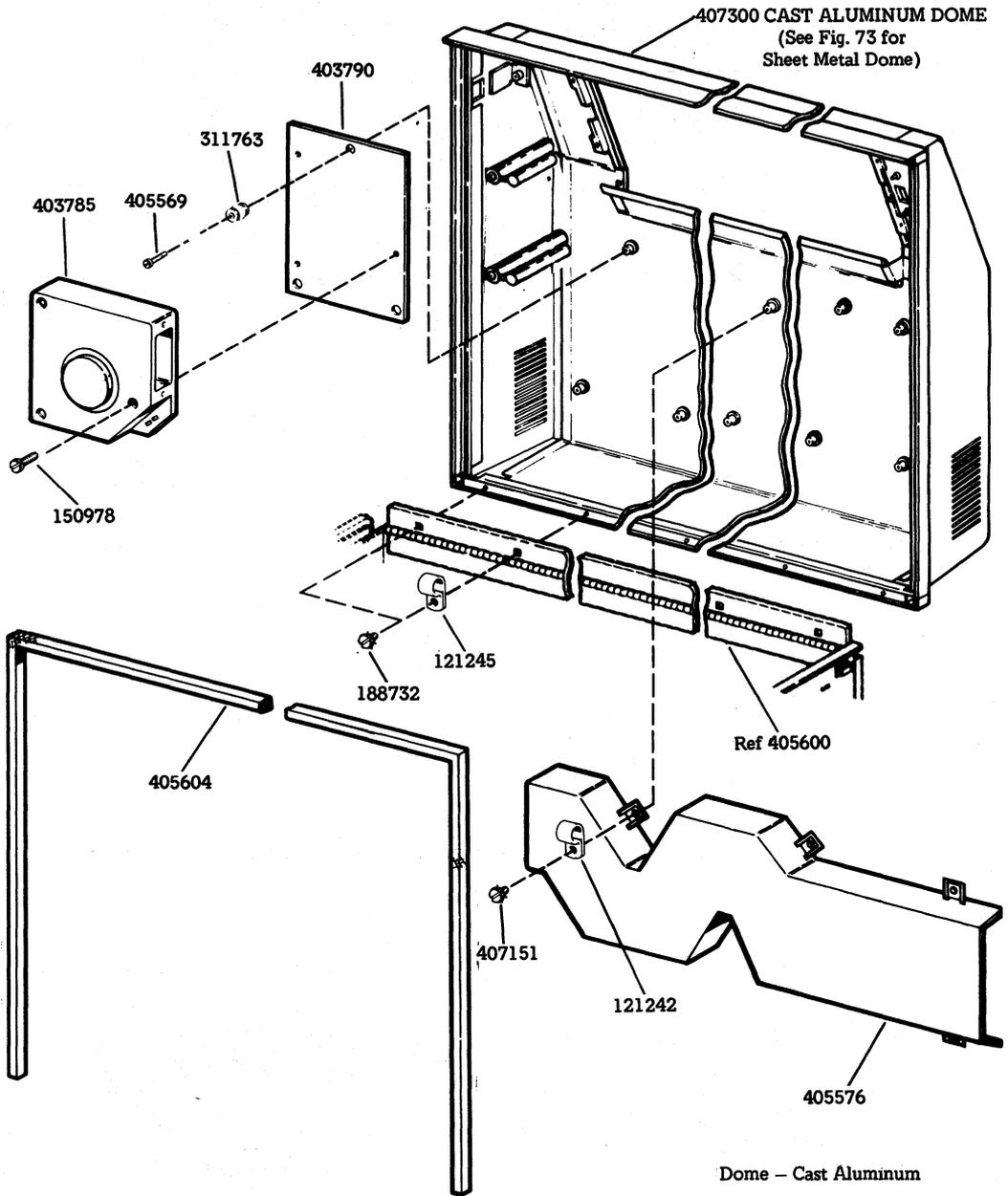
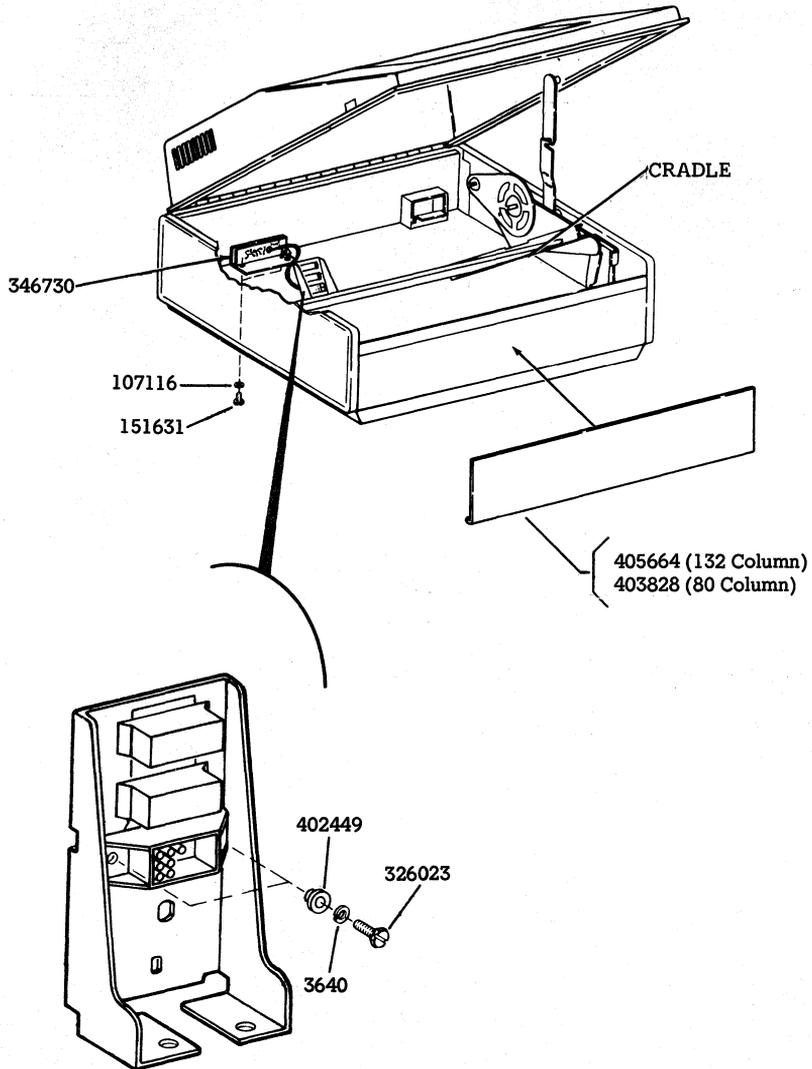


Fig. 79-40CAB353/YZ Printer Cabinet Core for Adjacent or RO Tractor Feed Printer - 132-Column (Cont)



Specification 50878S

Fig. 81 - 346731 (132) and 346731 (80) Modification Kits to Provide OEM Interface for DATASPEED 40 Tractor Feed Cabinet

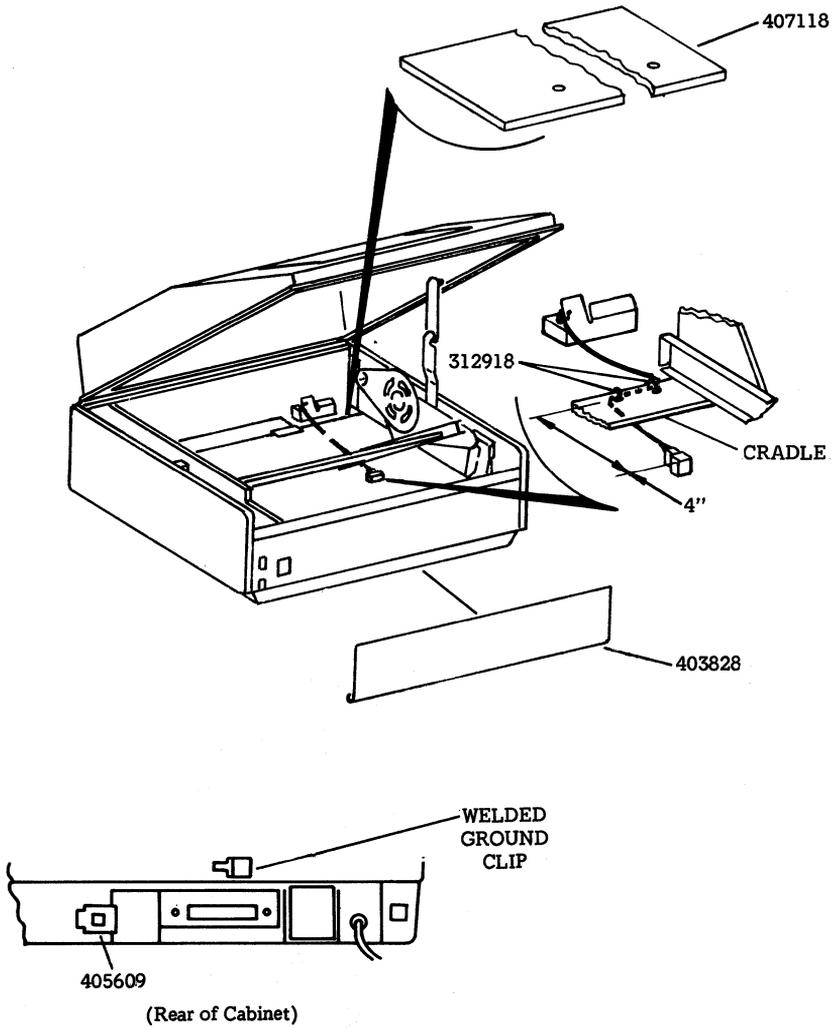
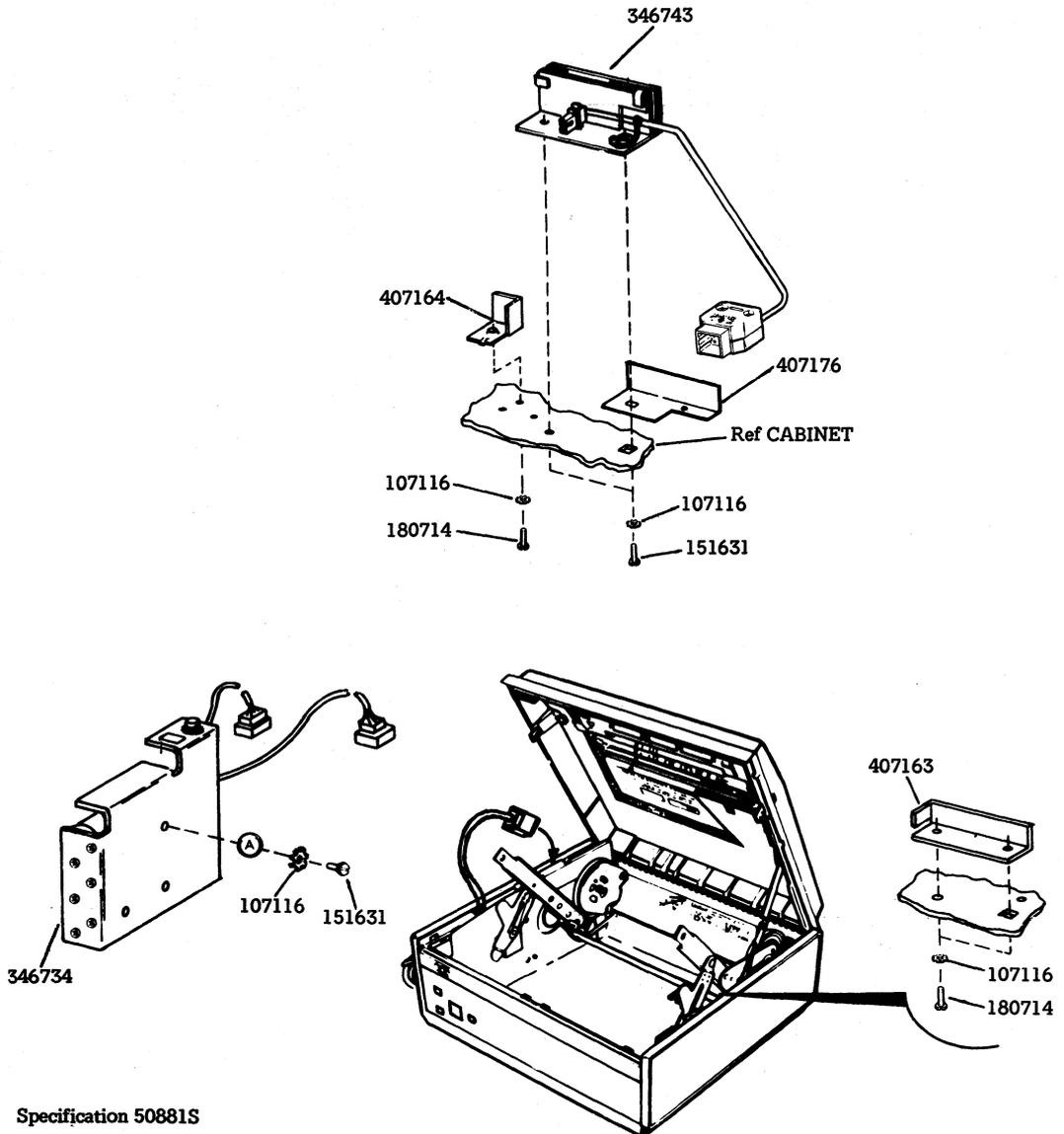
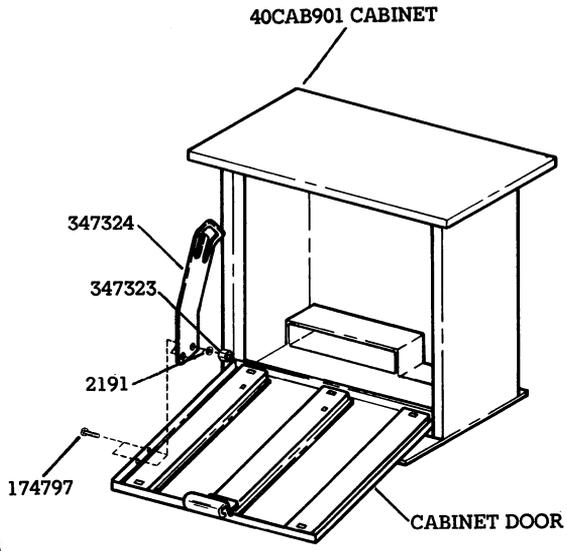


Fig. 82-346744 Modification Kit to Provide OEM Interface for Model 40CAB371/ZZ Friction Feed Cabinet



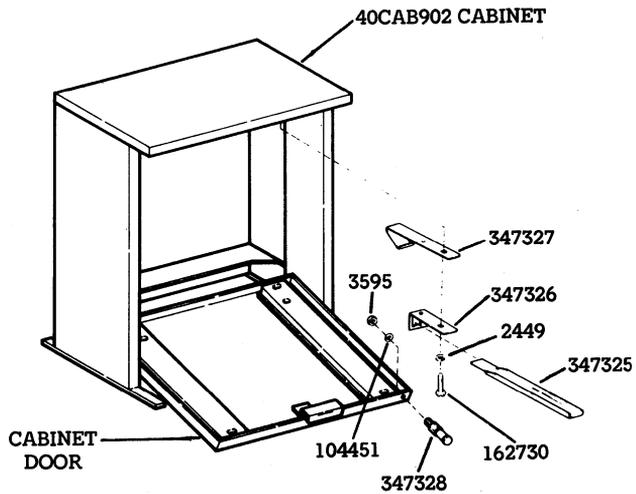
Specification 50881S

Fig. 82-346744 Modification Kit to Provide OEM Interface for Model 40CAB371/ZZ Friction Feed Cabinet (Cont)



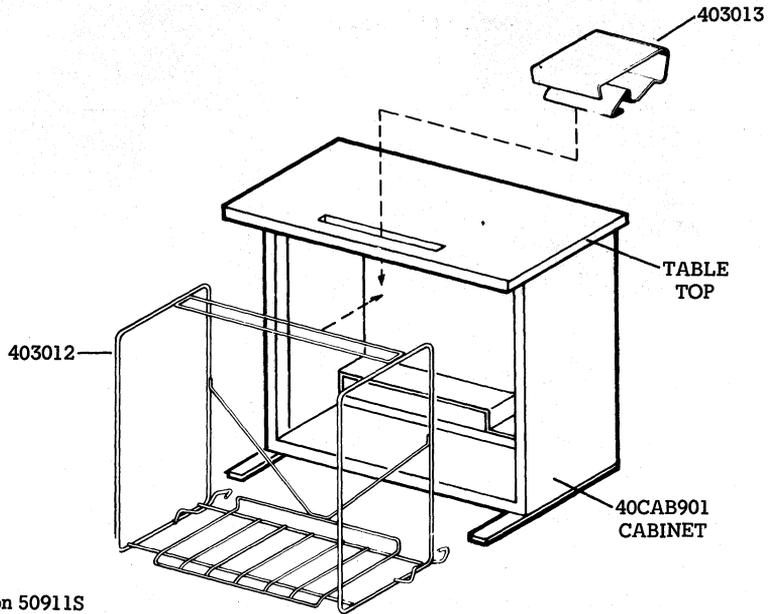
Specification 50967S

Fig. 83-347281 Modification Kit to Provide a Door Latch on 40CAB901 Cabinet



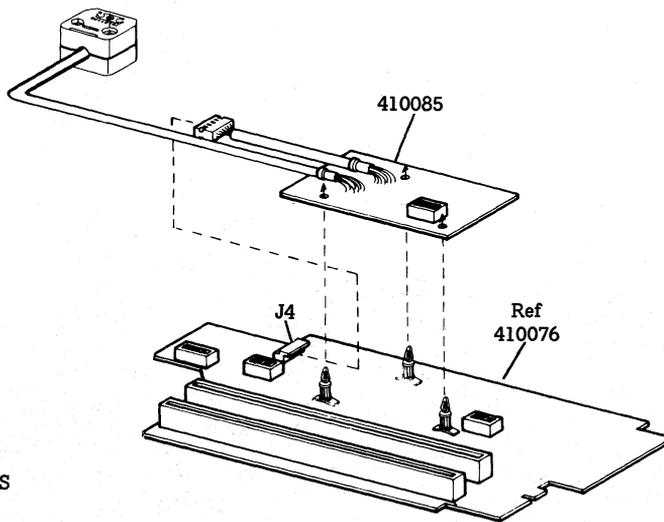
Specification 50968S

Fig. 84-347282 Modification Kit to Provide a Door Latch on 40CAB902 Cabinet



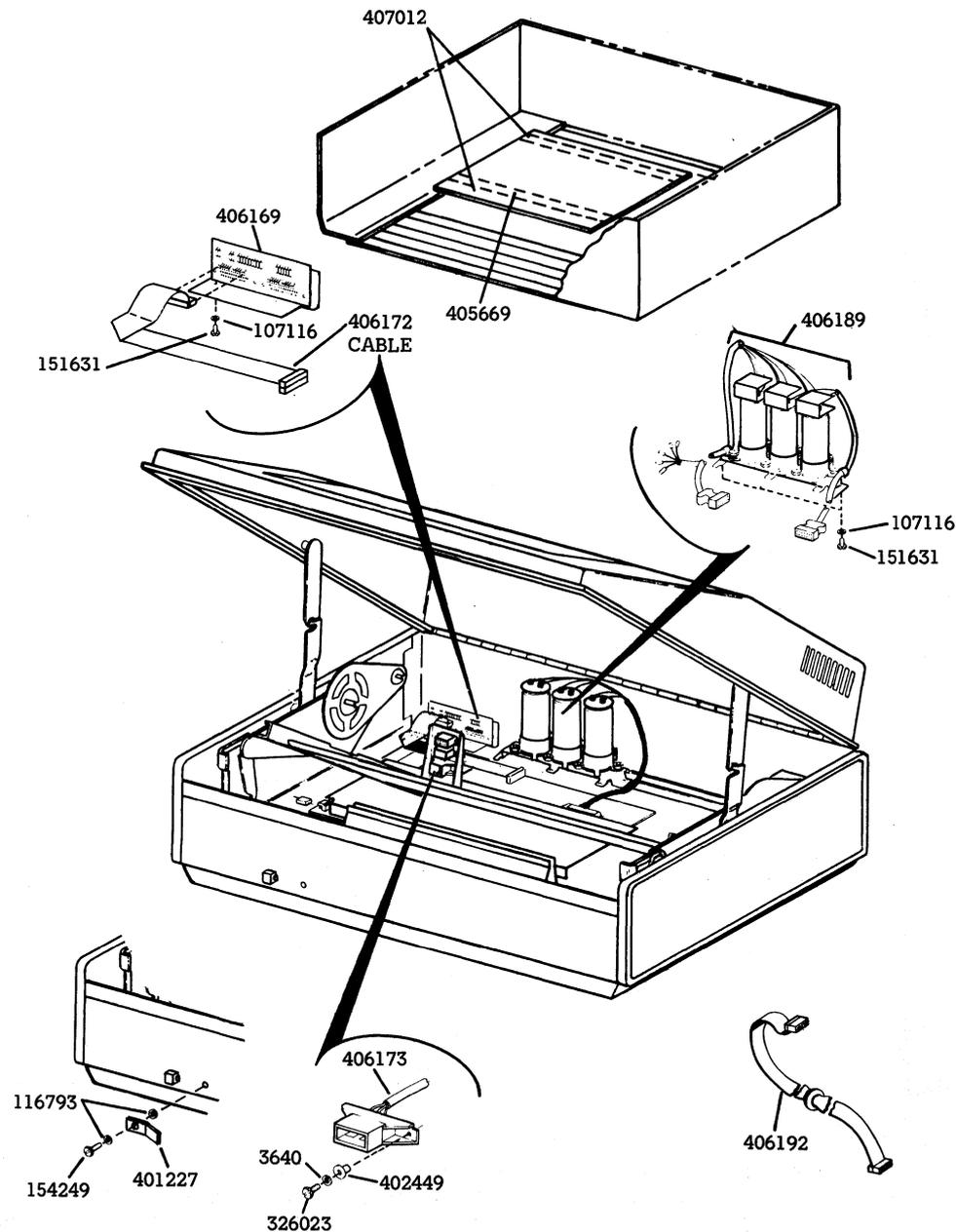
Specification 50911S

Fig. 85-403011 Modification Kit to Provide Paper Form Guide



Specification 50906S

Fig. 86-346745 Modification Kit to Provide Instructions for Optioning and Installing the 410085 OEM Card Into a Model 40P102 Friction Feed Printer



Specification 50915S

Fig. 87—406190 Modification Kit to Provide Dual EIA Interface for Printer

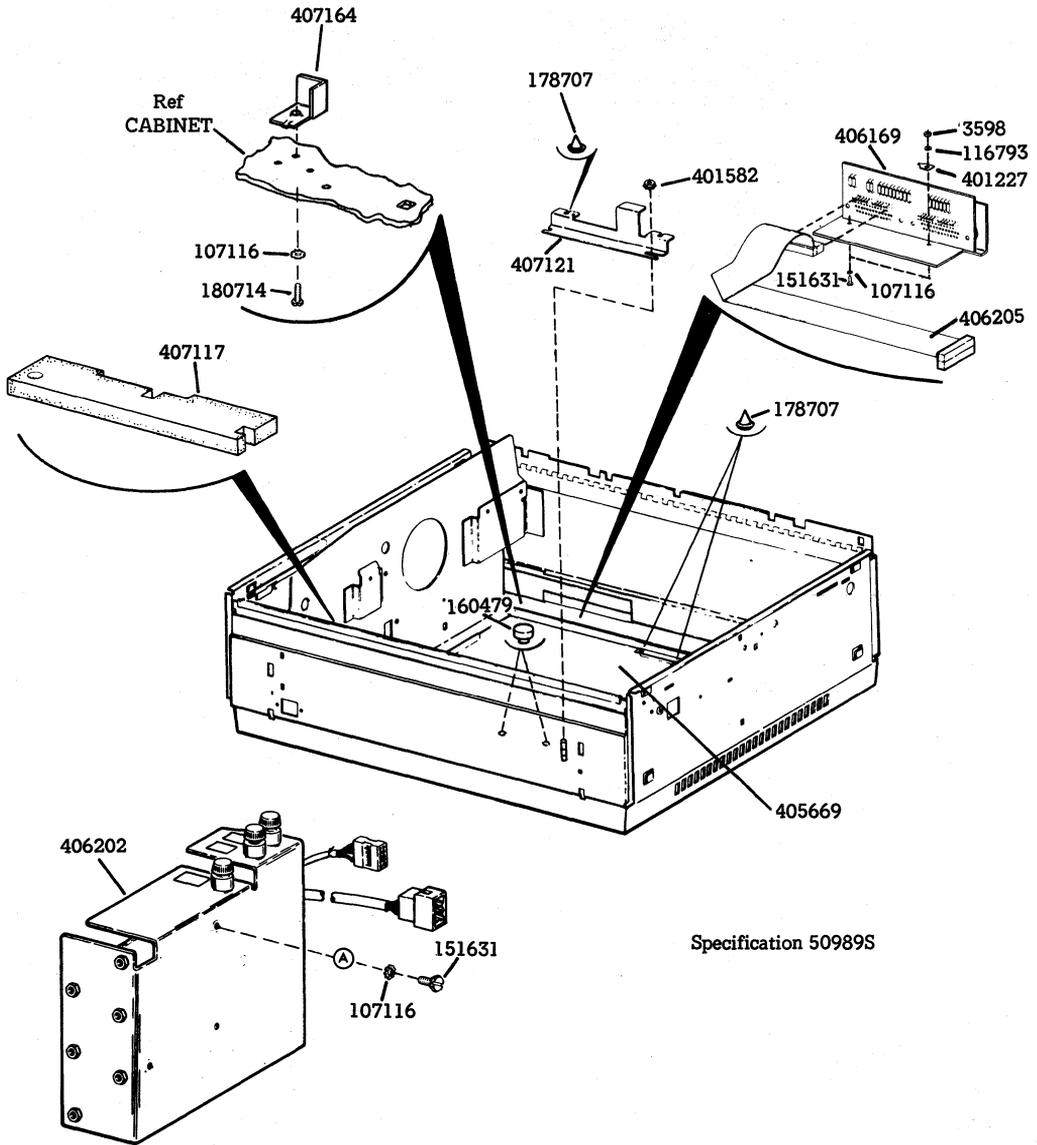


Fig. 88-406204 Modification Kit for a 40CAB371/ZZ Friction Feed Cabinet to Allow Addition of 40C303/AD Integrated Asynchronous Controller

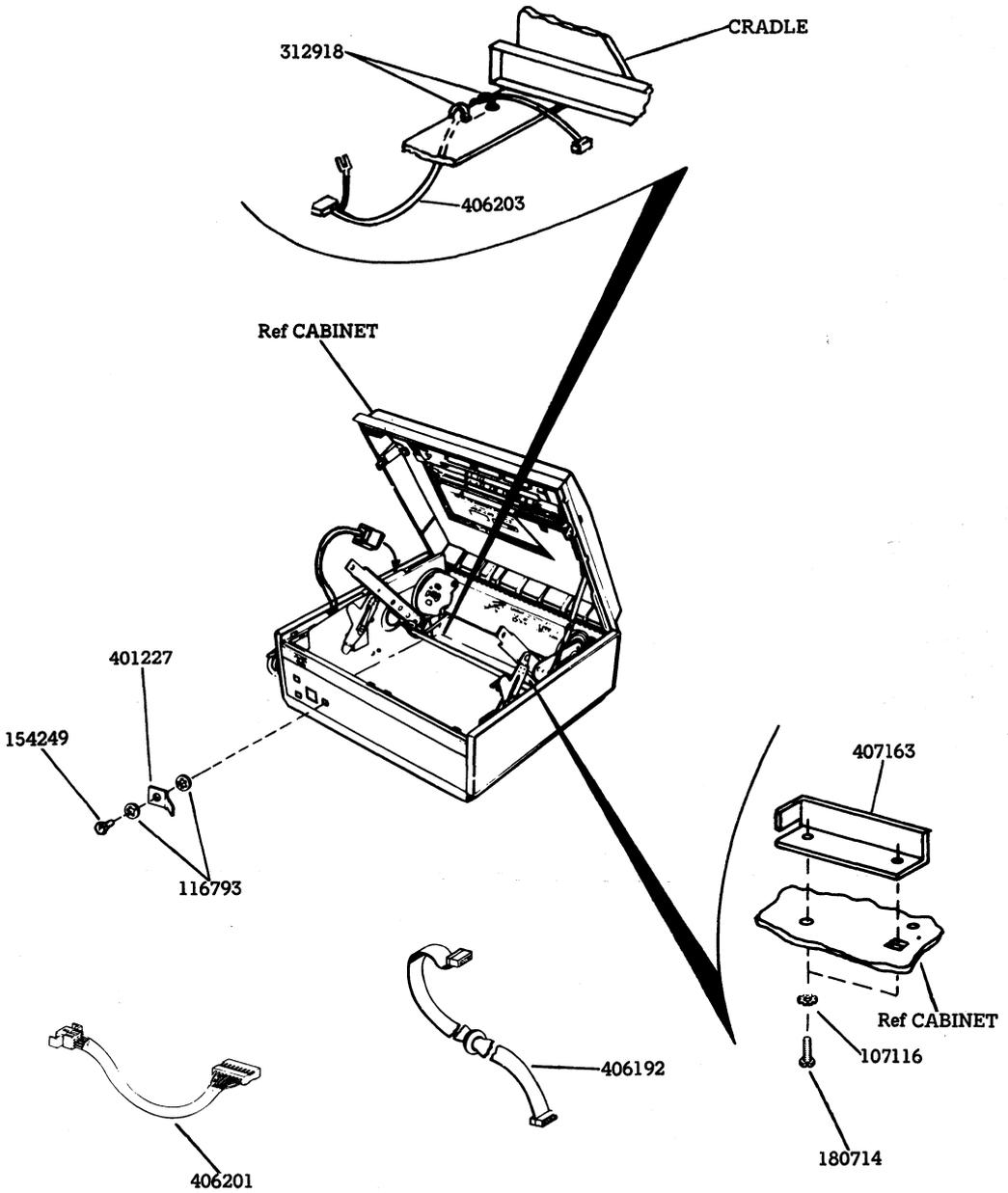
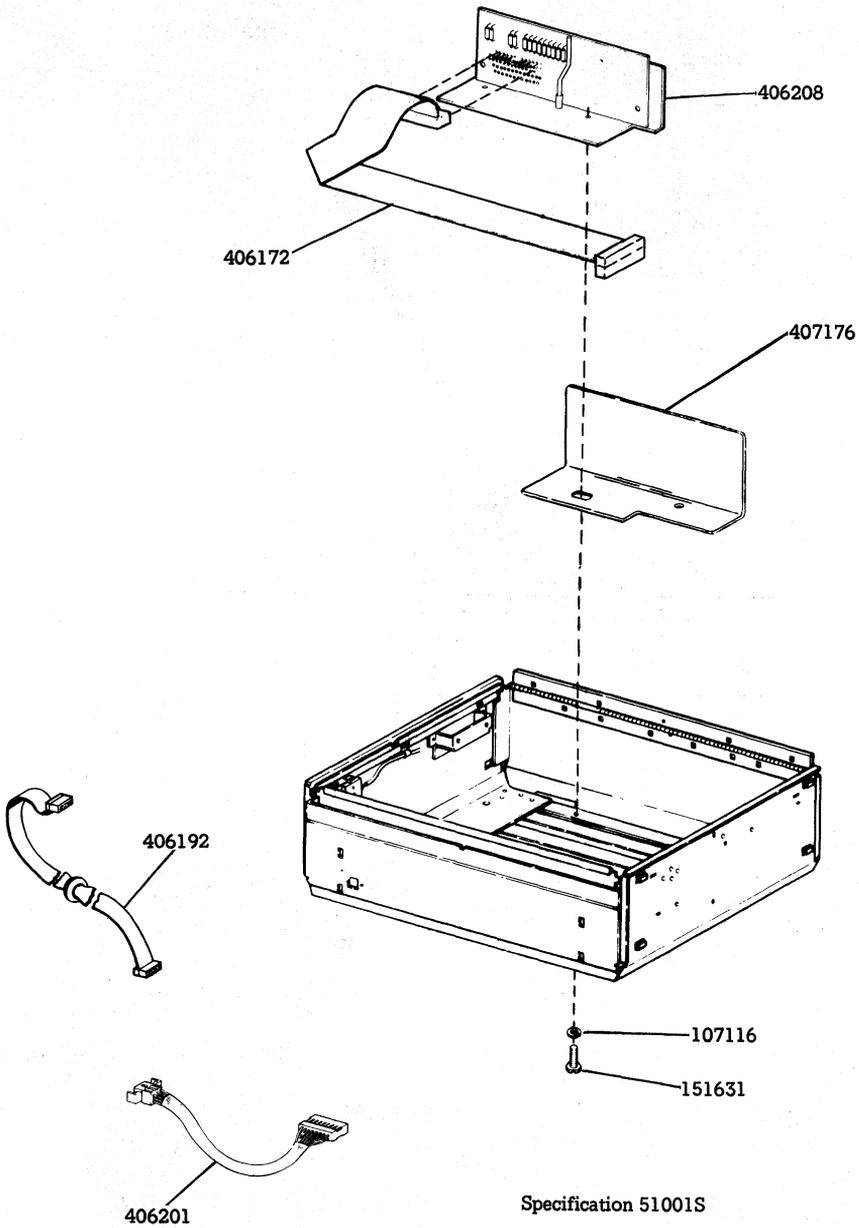


Fig. 88—406204 Modification Kit for a 40CAB371/ZZ Friction Feed Cabinet to Allow Addition of 40C303/AD Integrated Asynchronous Controller (Cont)



Specification 51001S

Fig. 89—406207 Modification Kit to Allow Replacement of 40C303/AA With a 40C303/AC or 40C303/AD Integrated Controller Used in Tractor Feed Printer Arrangements

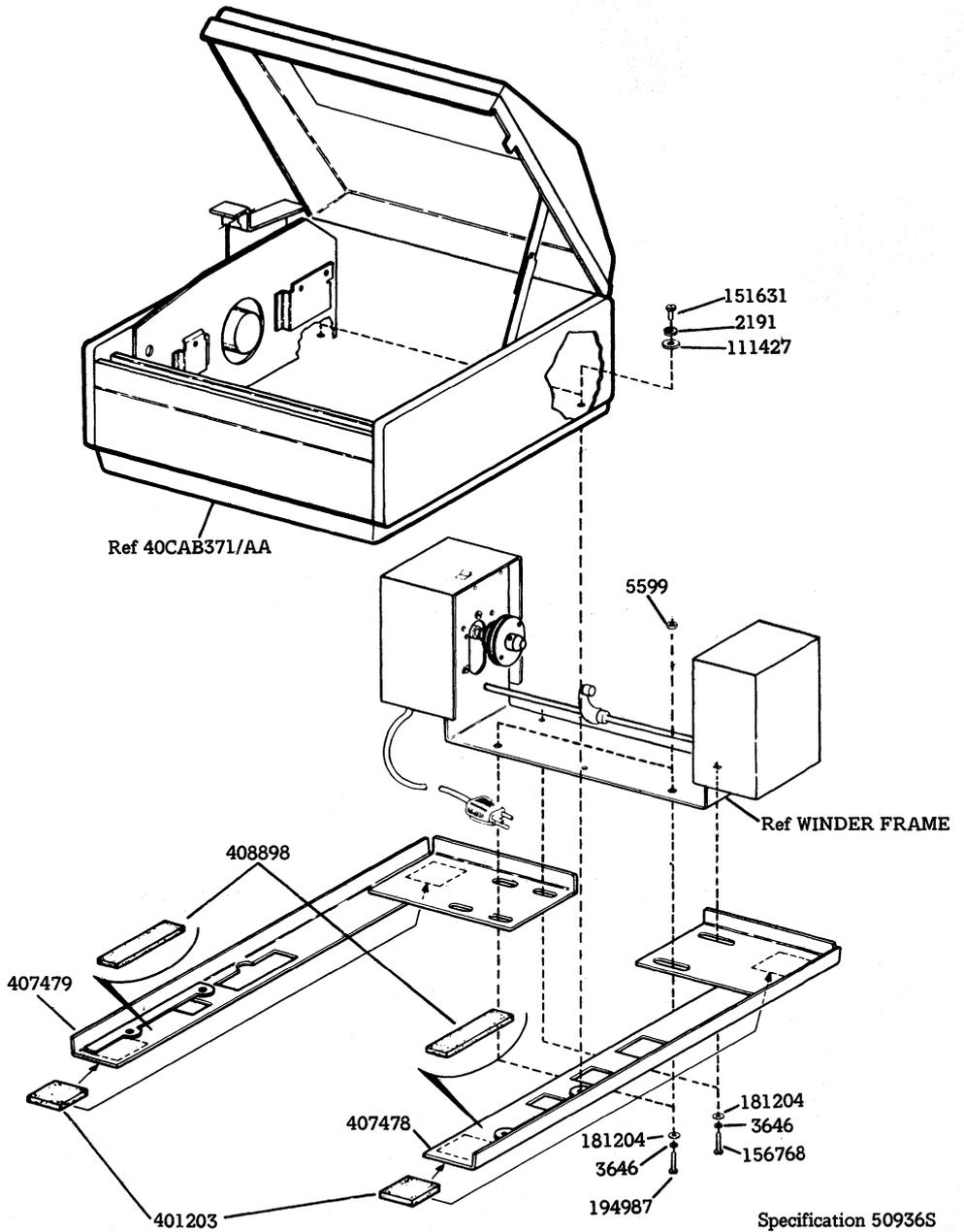
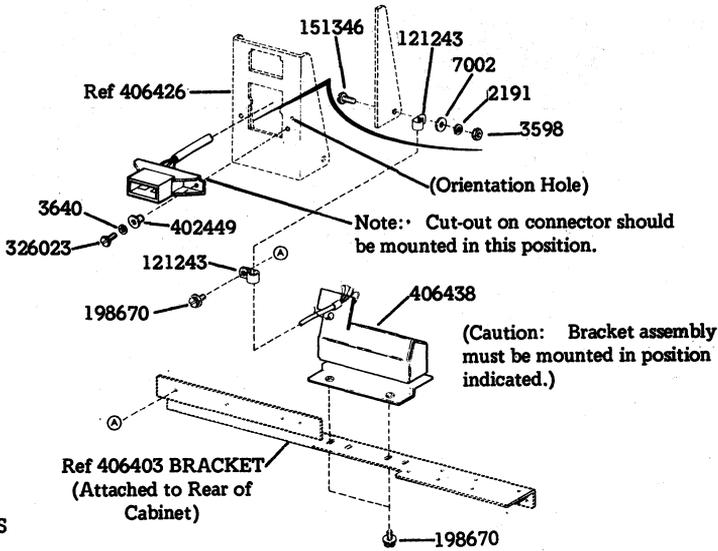
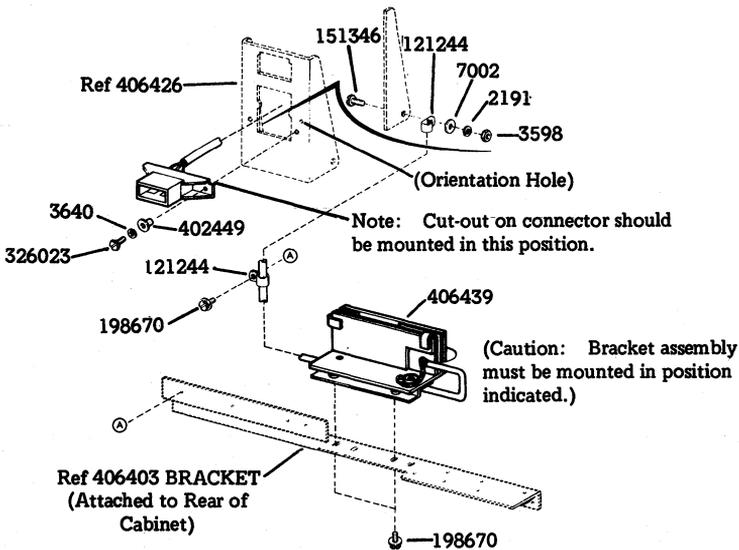


Fig. 90-406261 Modification Kit to Provide Mounting for Model 40 Paper Winder



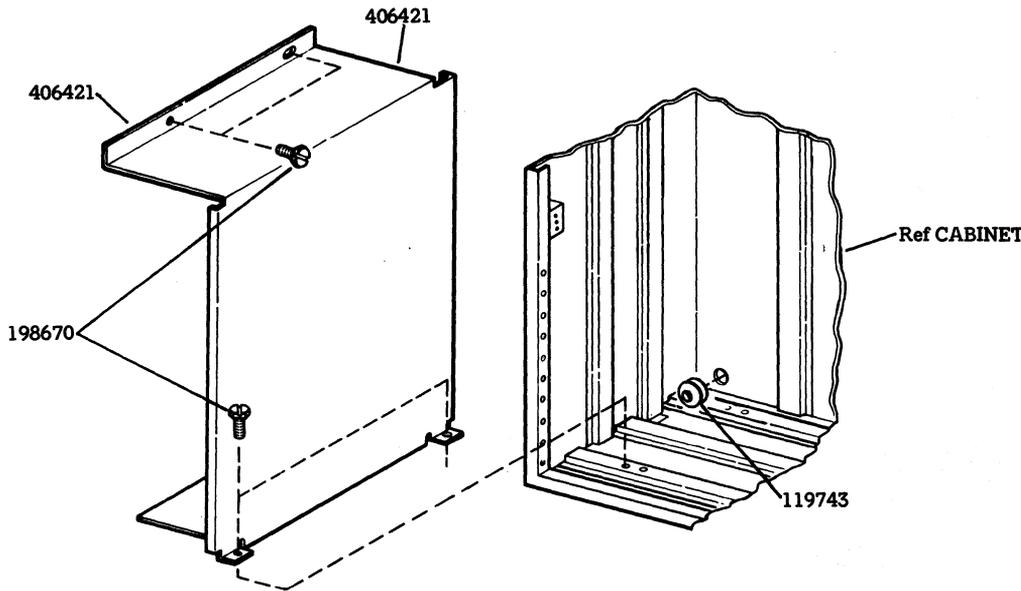
Specification 50951S

Fig. 91—406370 Modification Kit to Convert 40CAB302/ZZ to a 40CAB302/AB Cabinet to Provide SSI Interface (Forms Access Printer Cabinet)



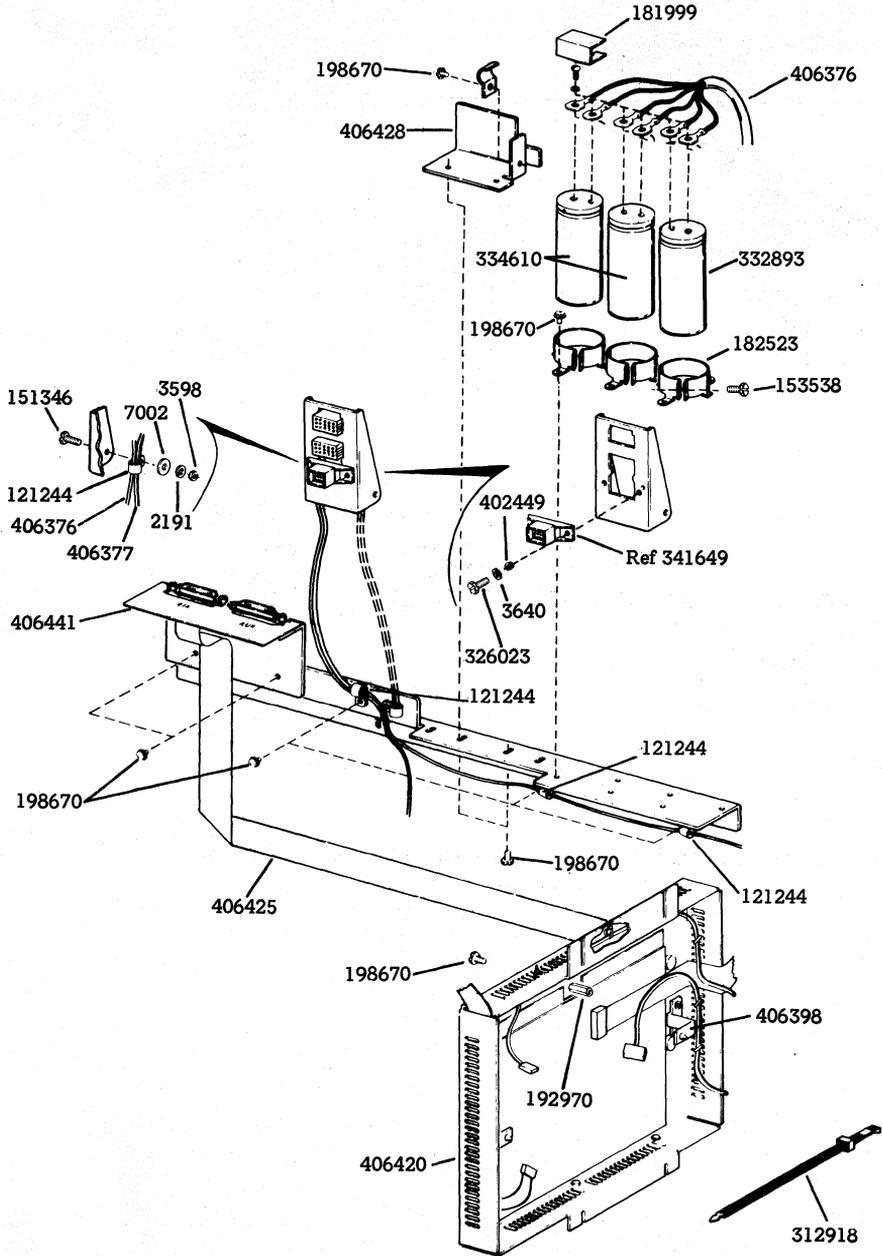
Specification 50952S

Fig. 92—406371 Modification Kit to Convert 40CAB302/ZZ to a 40CAB302/AC Cabinet to Provide OEM Interface (Forms Access Printer Cabinet)



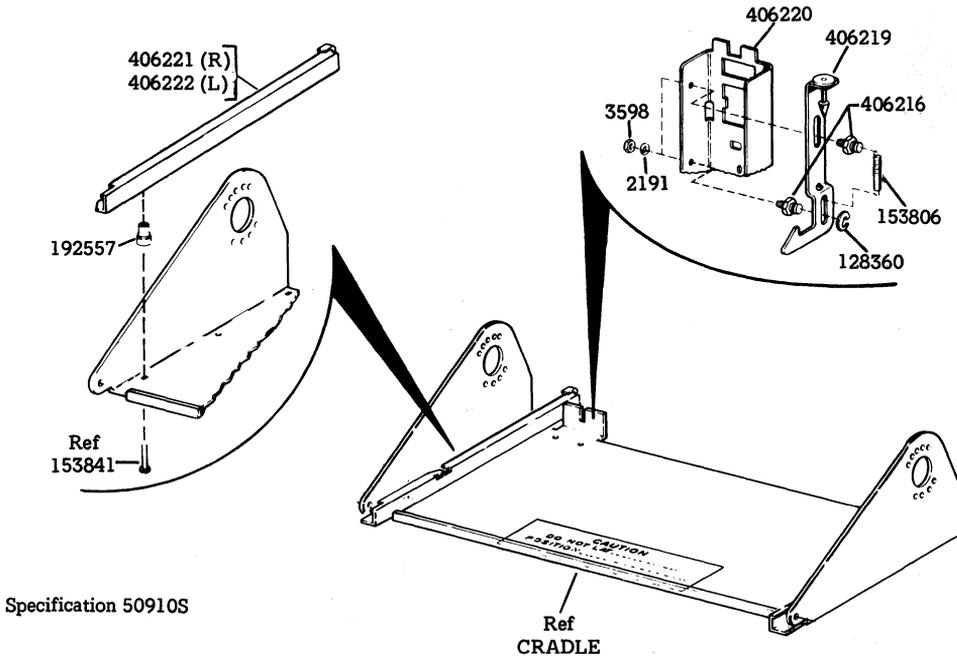
Specification 50954S

Fig. 93-406373 Modification Kit to Provide Data Set Mounting Facilities
(Forms Access Printer Cabinet)



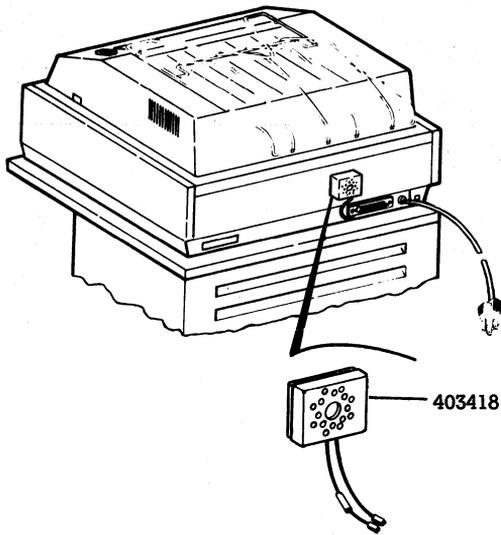
Specification 50953S

Fig. 94-406372 Modification Kit to Provide Interface and Mounting for Integrated Controller (Forms Access Printer Cabinet)



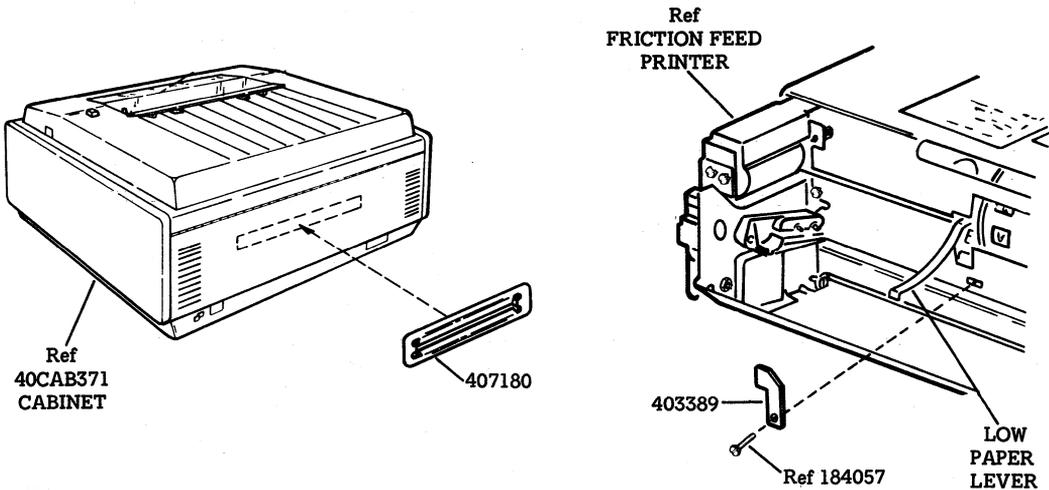
Specification 50910S

Fig. 95—406223 Modification Kit to Equip a Tractor Feed Cabinet With a Latch Mechanism



Specification 50903S

Fig. 96-403418 Modification Kit to Provide an Audible Alarm With Integrated Controller



Specification 50922S

Fig. 97-407105 Modification Kit to Provide Parts for Single-Ply Fanfold Friction Feed Paper Handling

6. ADJUSTMENTS

6.01 A complete adjustment procedure should be read before attempting to make the adjustment. After an adjustment has been completed, be sure to tighten any nuts or screws that may have been loosened to facilitate the adjustment, unless otherwise instructed.

6.02 Some adjustments require access to areas where parts have to be removed. For removal of these parts, refer to 4. DISASSEMBLY/ REASSEMBLY.

6.03 All tolerances in the adjustments in this section, unless otherwise stated, are in inches.

6.04 The instruction "friction tight" means to tighten by hand only. Tools should not be used for friction tight adjustments.

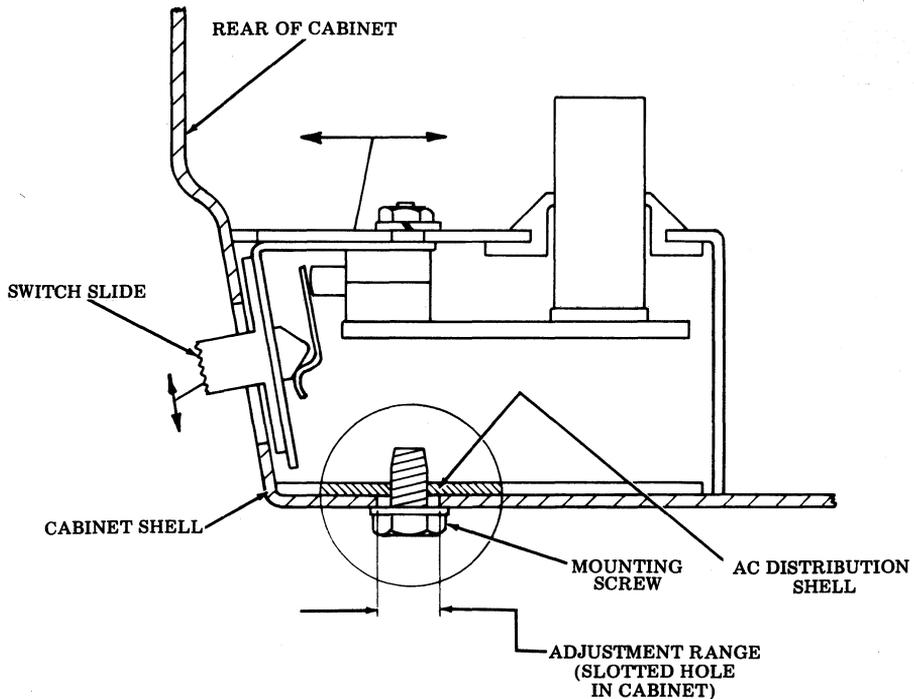
AC DISTRIBUTION ASSEMBLY (Early Design)

Requirement

Assembly should be flush to back wall of cabinet, consistent with free movement of the switch slide.

To Adjust

Loosen screw on bottom of cabinet. Meet requirement. Tighten screw.



CRADLE TORSION SPRING — FRICTION FEED

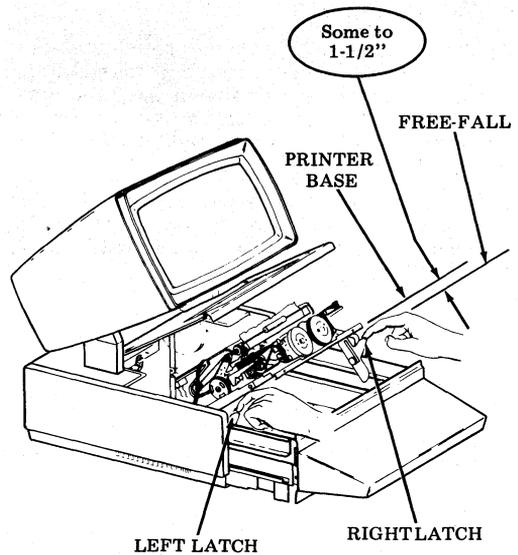
Note: This is a factory adjustment, adjusted to the optimal force. If it becomes necessary to readjust, then proceed as follows.

- Printer is installed in the cradle assembly of the cabinet and it is latched up (service position).

Requirement

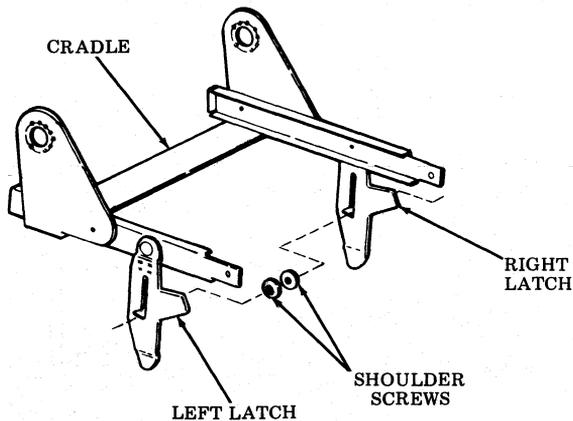
When left and right latches are released, printer should free-fall

Min Some---Max 1-1/2 inch when measured at the front of the printer base.



To Adjust

Remove printer from cradle assembly. Carefully remove shoulder screws (old design) or shoulder bushing and flat head screw that secure left and right latches to the printer cabinet.



CRADLE TORSION SPRING — FRICTION FEED (Cont)**To Adjust (Cont)**

With cradle assembly channels positioned past vertical, check outside hook portion of spring relative to hook stops. Any adjustments that are made to increase or decrease spring force should be made with the intent of keeping both springs equal in force. In essence, clearance between the hooks of left and right torsion springs and stop bushings should be approximately equal. Therefore, to increase the force, torsion spring whose hook is farther away from stop bushing should be adjusted to decrease clearance. To decrease the force, torsion spring whose hook is closer to the stop bushing should be adjusted to increase clearance. Loosen pilot screw in the hub to be adjusted until pilot is out of the locating hole in the cradle upright. Rotate torsion spring to increase or decrease force.

Note: There are five holes in each cradle upright to accept pilot portion of pilot screw.

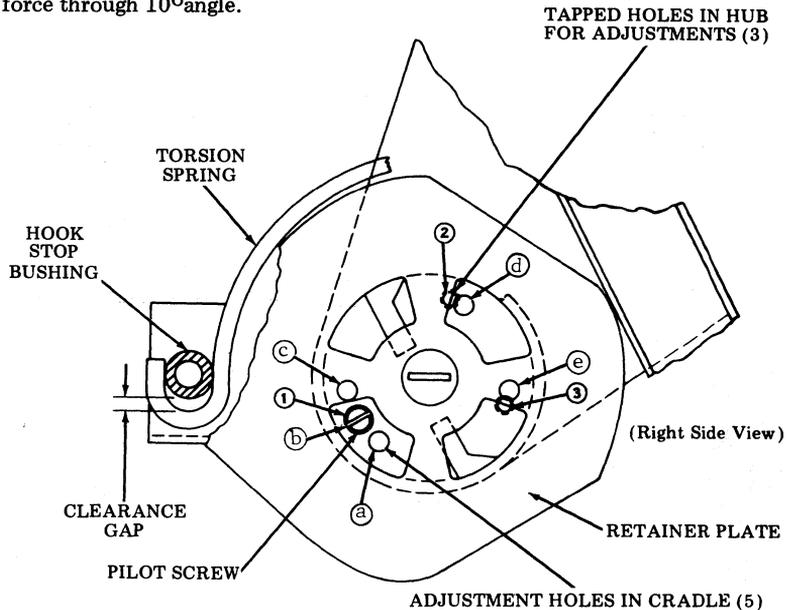
It may be necessary to reposition the pilot screw on hub if an angular adjustment of only 10 degrees is required from nominal. Reassemble with care.

LEGEND:

①, ②, and ③ are positions for pilot screw on hub.

ⓐ, ⓑ, ⓒ, ⓓ, and ⓔ are positions on cradle.

- | | | |
|---|---|-----------------------------------|
| ① | ⓑ | Nominal position. |
| ① | ⓐ | Decrease force through 20° angle. |
| ① | ⓒ | Increase force through 20° angle. |
| ② | ⓓ | Increase force through 10° angle. |
| ② | ⓔ | -- |



CRADLE TORSION SPRING — TRACTOR FEED (80-COLUMN)

Note: This is a factory adjustment, adjusted to the optimal force. If it becomes necessary to readjust, then proceed as follows.

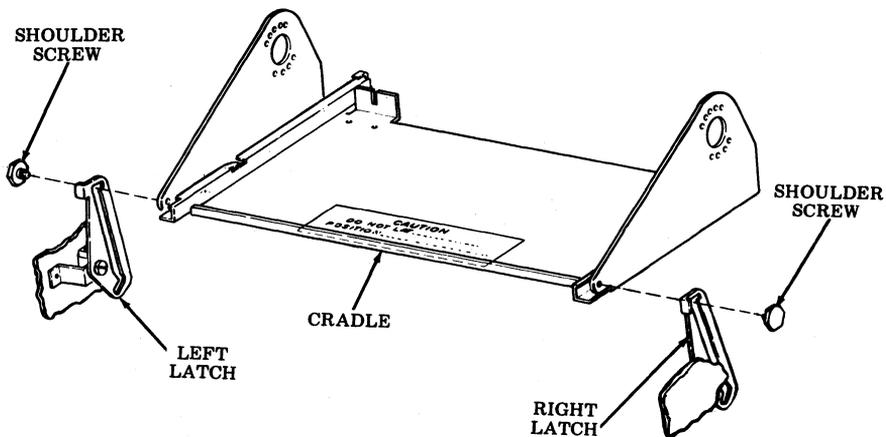
- Printer in the cabinet.
- Left and right cradle latches released (pressed inward).

Requirement

Printer should be lifted up some to halfway to the upper latched position. Latches must remain in released position.

To Adjust

Use printer to check adjustment. Remove printer from cradle assembly. If cradle assembly fails to remain in up position, raise it up until it latches. Carefully remove shoulder screws that secure left and right latches to the printer cradle.



CRADLE TORSION SPRING — TRACTOR FEED (80-COLUMN) (Cont)**To Adjust (Cont)**

With cradle assembly channels positioned past vertical, check outside hook portion of spring relative to hook stops. Any adjustments that are made to increase or decrease spring force should be made with the intent of keeping both springs equal in force. In essence, clearance between hooks of left and right torsion springs and stop bushings should be approximately equal. Therefore, to increase the force, torsion spring whose hook is farther away from stop bushing should be adjusted to decrease clearance. To decrease the force, torsion spring whose hook is closer to the stop bushing should be adjusted to increase clearance. Loosen pilot screw in the hub to be adjusted until pilot is out of the locating hole in the cradle upright. Rotate torsion spring to increase or decrease force.

Note: There are nine holes in each cradle upright to accept pilot portion of pilot screw.

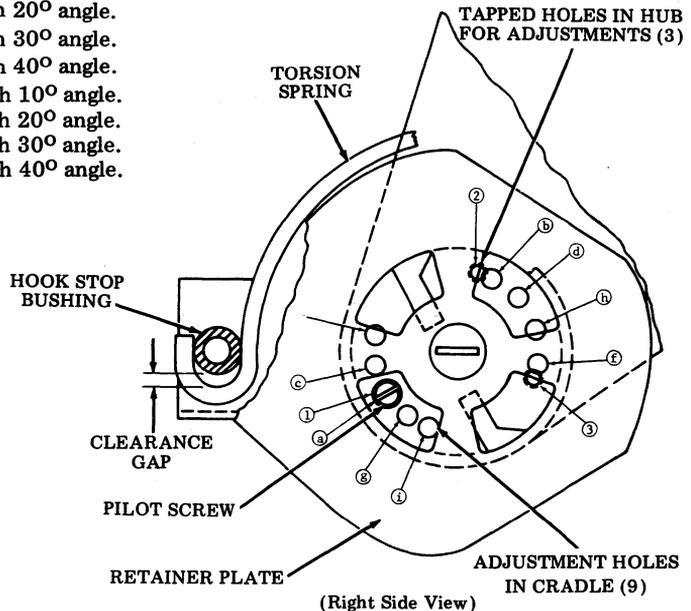
It may be necessary to reposition the pilot screw on hub if an angular adjustment of only 10 degrees or 30 degrees is required from nominal. Reassemble with care.

LEGEND:

①, ②, and ③ are positions for pilot screw on the hub.

ⓐ, ⓑ, ⓒ, ⓓ, ⓔ, ⓕ, ⓖ, ⓗ, and ⓘ are positions on the cradle.

- | | | |
|---|---|-----------------------------------|
| ① | ⓐ | Nominal position. |
| ② | ⓑ | Increase force through 10° angle. |
| ① | ⓒ | Increase force through 20° angle. |
| ② | ⓓ | Increase force through 30° angle. |
| ① | ⓔ | Increase force through 40° angle. |
| | ⓕ | Decrease force through 10° angle. |
| ① | ⓖ | Decrease force through 20° angle. |
| ③ | ⓗ | Decrease force through 30° angle. |
| ① | ⓘ | Decrease force through 40° angle. |



CRADLE TORSION SPRING – TRACTOR FEED (132-COLUMN)

- Printer in the cabinet.
- Left and right cradle latches released (pressed inward).

(1) Requirement

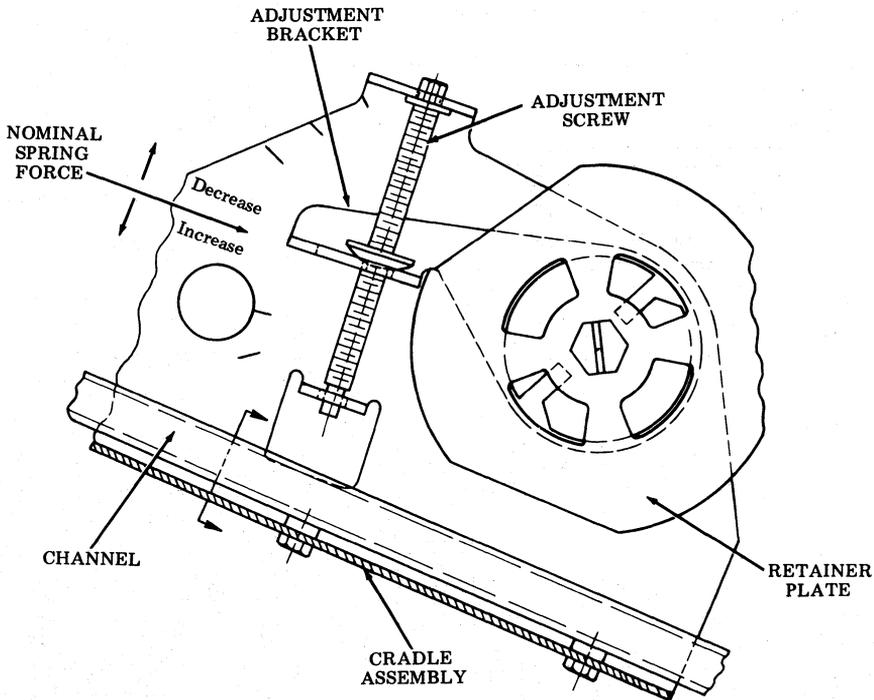
The printer and cradle should move out of the latched position and move up into an intermediate position.

(2) Requirement

With the printer in the service position, depressing the left and right latchlever should allow the printer and cradle to move out of the latched position and move down into an intermediate position.

To Adjust

Turn the adjustment screw (one on each side of the cradle) counterclockwise to increase the torsion spring force and clockwise to decrease the torsion spring force. Any adjustments to increase or decrease the spring force should be made with the intent of keeping both springs in equal tension.



PAPER EXIT GAP — NOISE REDUCING FRICTION FEED

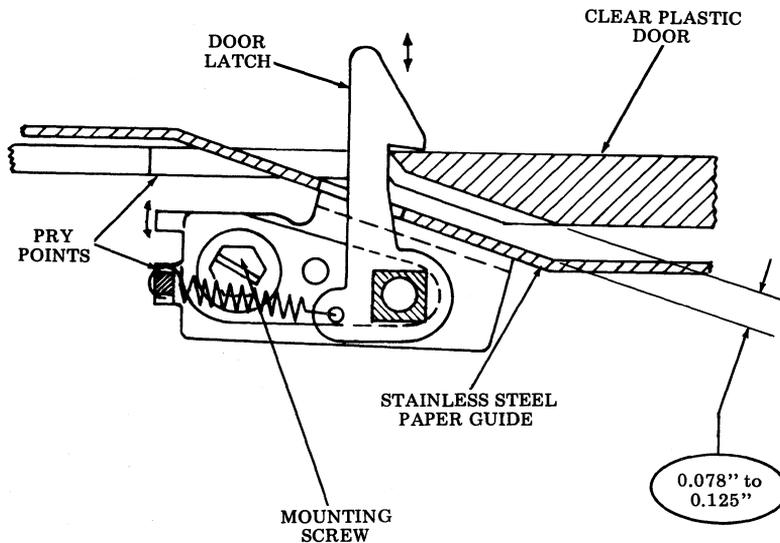
- Paper exit door closed and latched.
- Cabinet dome in the open position.

Requirement

Paper exit gap between clear plastic door and stainless steel paper guide should be
Min 0.078 inch--Max 0.125 inch
through the entire width and length of the path through which the paper travels.

To Adjust

Loosen the two mounting screws friction tight. Use pry points to raise or lower the door latches to meet requirement. Tighten the two mounting screws.



DOMES ADJUSTMENT – NOISE REDUCING FRICTION FEED

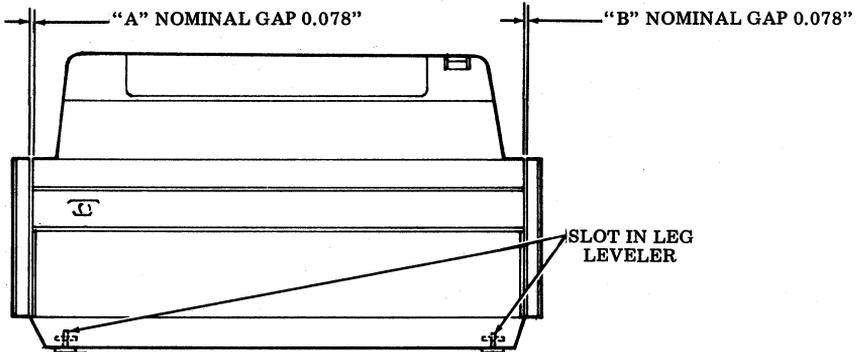
- Dome closed and latched

Requirement

Gap "A" must be equal to Gap "B" within 0.062 inch. Dome may be flush, overflush (0.030 inch) or underflush (0.030 inch) with respect to trim band. (Both Sides)

To Adjust

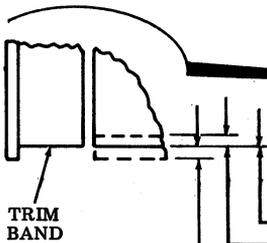
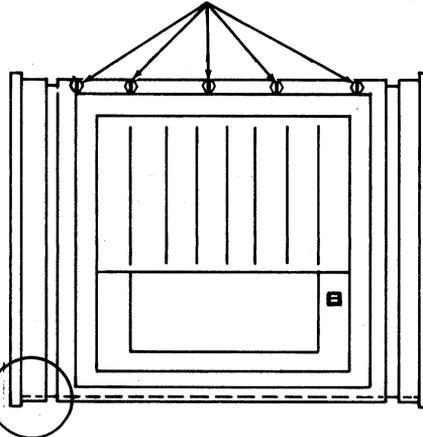
Loosen five dome mounting screws friction tight. Position dome to meet requirement. Tighten mounting screws.



Note: Adjustable feet must be fully retracted into cabinet before attempting dome adjustment.

ADJUSTABLE FEET (2)

MOUNTING SCREWS



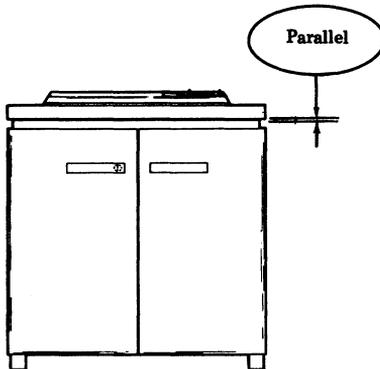
FLUSH
DOME MAY BE UP TO 0.030" UNDER FLUSH
DOME MAY BE UP TO 0.030" OVER FLUSH

TOP COVER VERTICAL ADJUSTMENT — FORMS ACCESS CABINET**Requirement**

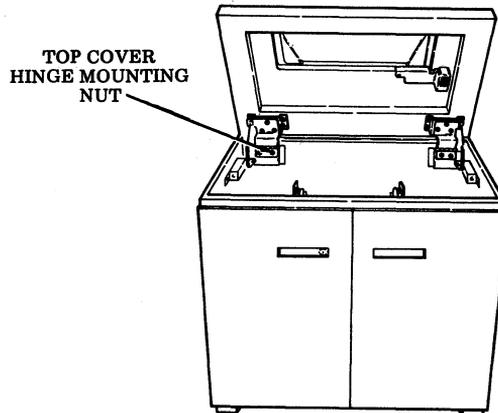
With the cabinet top cover in the closed position the cover should rest on the front gasket and be parallel to the cabinet, as gauged by eye.

To Adjust

With the four cabinet top cover hinge mounting nuts friction tight, lift or lower the rear edge of the cover until the requirement is met. Tighten the mounting nuts.



(Front View)



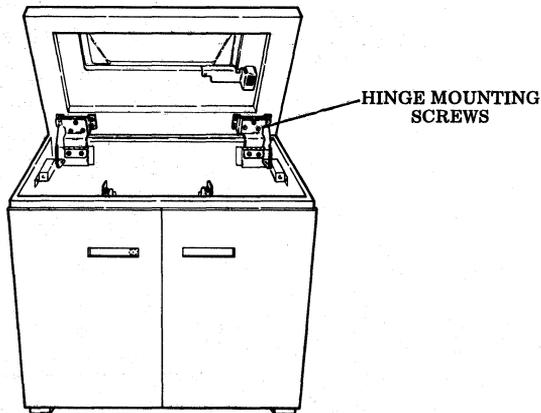
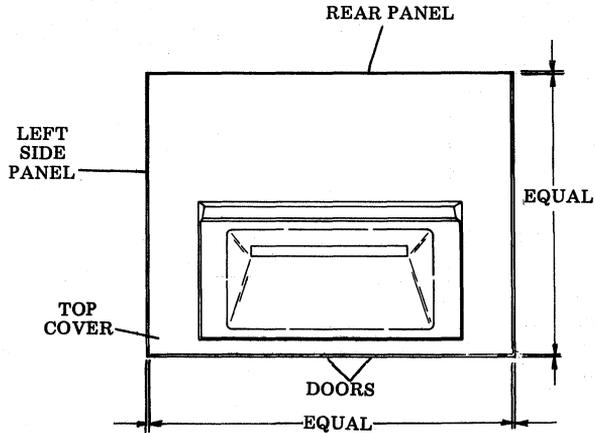
TOP COVER HORIZONTAL ADJUSTMENT – FORMS ACCESS CABINET

Requirement

With the cabinet top cover in the closed position, the cabinet doors should extend beyond the top cover equally front to rear and equally left to right as gauged by eye (approximately)

To Adjust

With the six top cover hinge mounting screws friction tight, position the top cover left to right and front to rear to meet the requirement. Tighten the six mounting screws.

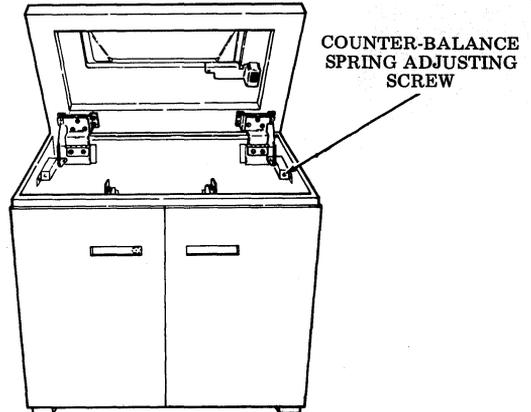


TOP COVER LEFT AND RIGHT COUNTER BALANCE SPRING ADJUSTMENT – FORMS ACCESS CABINET**Requirement**

With top cover almost closed (within 3 to 4 inches), the top will not move by gravity when released.

To Adjust

Turn each counter-balance spring adjusting screw approximately an equal number of turns until requirement is met. Do not back off screws more than four full turns from a complete clamp position.

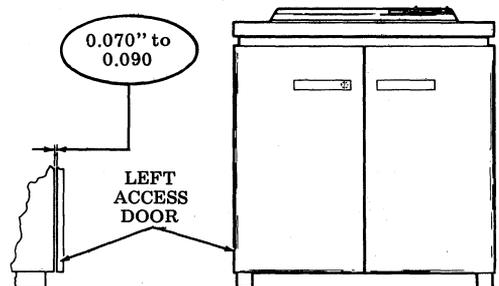
**LEFT AND RIGHT FRONT ACCESS DOOR POSITION ADJUSTMENT – FORMS ACCESS CABINET****Requirement**

The gap between cabinet side panel and respective door should be

Min 0.070 inch—Max 0.090 inch
when measured near top and bottom of door hinge ends.

To Adjust

With the door hinge mounting screws friction tight, position the door forward or rearward to meet requirement.
Tighten the hinge mounting screws.



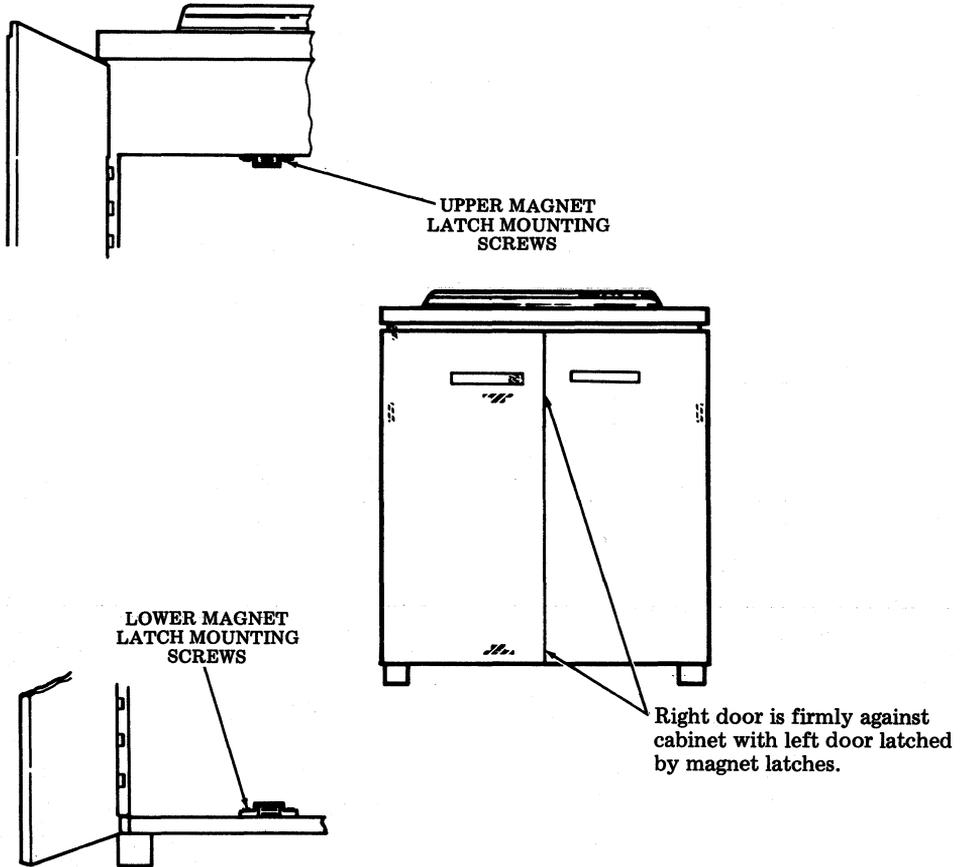
LEFT FRONT ACCESS DOOR MAGNET LATCHING ADJUSTMENT — FORMS ACCESS CABINET

Requirement

With the left door overlapping the right door and both doors in the closed position, the upper and lower magnets should be in contact with their respective strike plates while holding the right door flange firmly against the cabinet engaging surface.

To Adjust

With top and bottom magnet mounting screws (four) friction tight, close the left door overlapping the right door flange, with gentle pressure applied to left door, secure the magnets. Magnets may be secured through the top of the cabinet.



TOP COVER LATCH AND LATCH STRIKE PLATE ADJUSTMENT — FORMS ACCESS CABINET**(1) Requirement**

As the top cover latch is slowly brought into contact with the latch strike plate, contact should be approximately

Min 1/4 inch---Max 1/2 inch
of the sloped surface of the latch as gauged by eye.

To Adjust

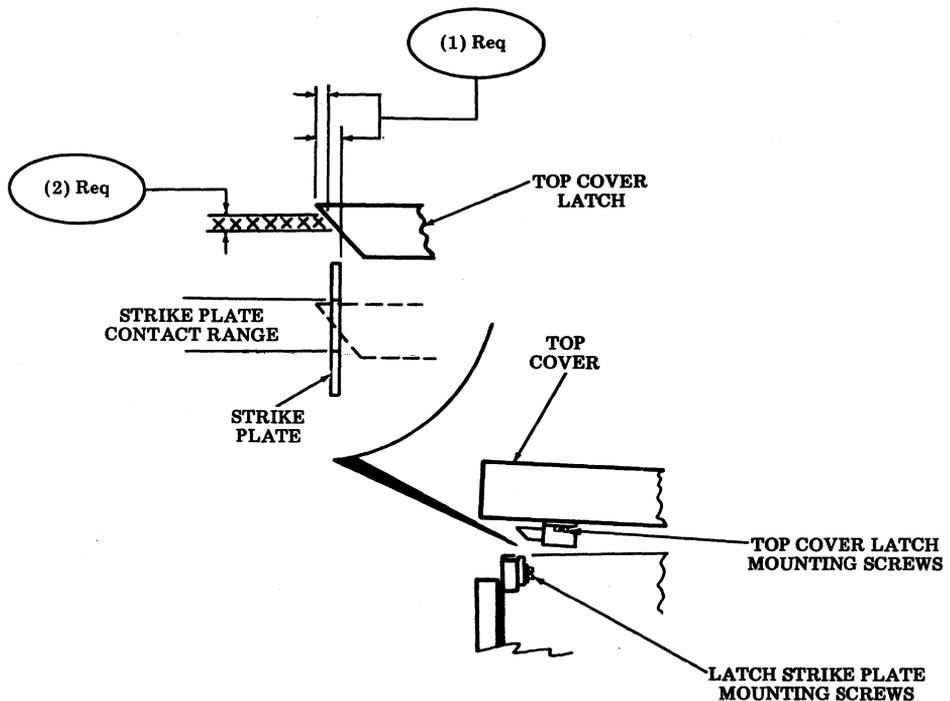
With the latch mounting bracket screws friction tight, position mounting bracket forward or rearward to meet the requirement. Tighten the mounting screws.

(2) Requirement

With the top cover gently lowered onto the cabinet gasketing, the latch should engage the strike plate with an audible sound of latching.

To Adjust

With latch strike plate mounting screws friction tight, position the strike plate up or down to meet requirement. Tighten mounting screws.



TOP COVER, LEFT AND RIGHT FRONT DOOR INTERLOCK SWITCH ADJUSTMENTS — FORMS ACCESS CABINET

Top Cover Interlock Switch

(1) Requirement

With the top cover in its latched position, the interlock switch should be in the “closed” mode and should move into its “open” mode when the top cover is raised above the latched position.

Left Front Door Interlock Switch

(2) Requirement

With the left door in the latched position, the interlock switch should be in the “closed” mode and should move into its “open” mode when the left door is opened.

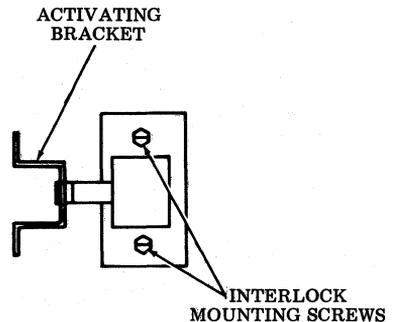
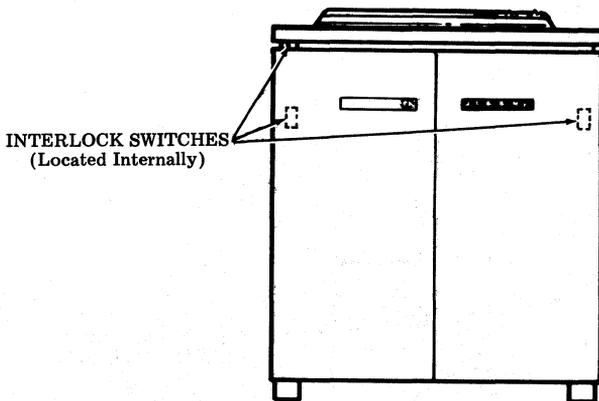
Right Front Door Interlock Switch

(3) Requirement

With the right door in the latched position, the interlock should be in the “closed” mode. When the right door is open and held overlapping the closed left door, the interlock switch should be in the “open” mode.

To Adjust

With the switch assembly mounting screws friction tight, locate the assembly closer to or farther away from the activating bracket to meet the requirement. Tighten the two mounting screws.



PRINTER VERTICAL POSITIONING ADJUSTMENT — FORMS ACCESS CABINET**Requirement**

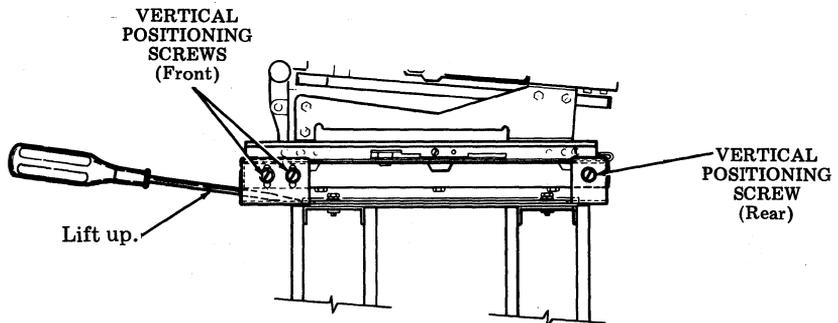
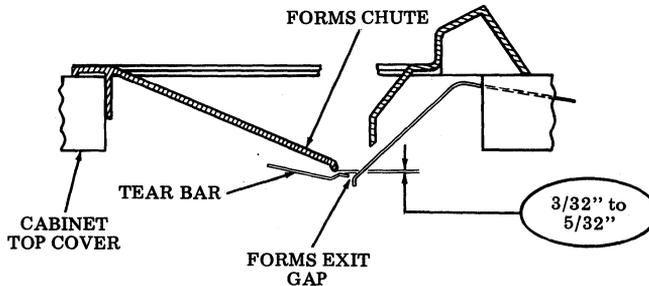
With a scale resting on the printer tear bar top surface and against the front edge of forms chute opening, the tear bar top surface should be located

Min $3/32$ inch--Max $5/32$ inch

below the form of the cabinet form chute.

To Adjust

Loosen the six intermediate rail bracket mounting screws friction tight, place the blade of a screwdriver between frame and intermediate rail, pry intermediate rail assembly up at alternate left and right front corners until adjustment is made, tightening the forward most screws. After making adjustment tighten remaining screws.



PRINTER FORWARD POSITIONING ADJUSTMENT — FORMS ACCESS CABINET

Note: The printer should be positioned and latched in its rear most location on the rail assembly frame for this adjustment.

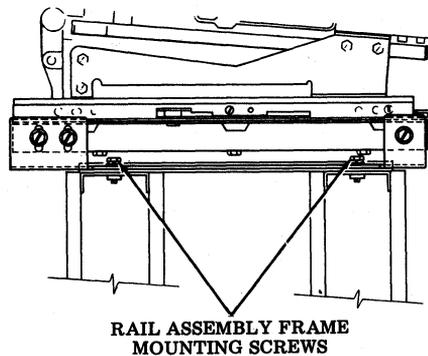
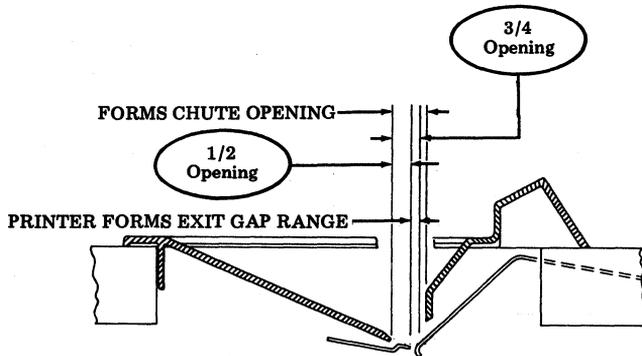
Requirement

The printer forms exit gap should be located

Min $1/2$ —Max $3/4$
of the way back in the forms chute opening as gauged by eye.

To Adjust

With the four rail assembly frame mounting screws friction tight, move printer rail assembly frame forward or rearward to meet adjustment. Tighten the four mounting screws.



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Part Number	Description and Page Number	Part Number	Description and Page Number	Part Number	Description and Page Number
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1163	Screw, 4-40 x 3/16 Fil 39	84579	Washer, Flat 33,44	121244	Clamp, 1/4 ID Cable 58, 63,72,83,110,130,132
1178	Screw, 2-56 x 7/16 Fil 66, 113,116	85471	Screw, 10-32 x 1 Hex 42,48		
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5599	Nut, 8-32 Hex 39,129	110435	Nut, 4-40 Hex 81	150710	Screw, 6-40 x 1-1/4 Hex 77
6345	Nut, 6-32 Hex 35,40,41,44	110446	Nut, 2-56 Hex 55	150711	Washer, Flat 86,96
7002	Washer, Flat 37,52,59,62, 73,81,89,91,92,103,104, 109,110,114,116,119,130, 132	110743	Lockwasher 116	150978	Screw, 6-40 x 1-1/8 Hex 58,63,118
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153441	Screw, 10-32 x 7/16 Hex 112	181247	Screw w/Lockwasher, 6-40 x 11/16 Hex 33	192557	Grommet, Rubber 59,62, 67,77,112,133
153442	Screw, 10-32 x 1/2 Hex 60,64,76,77,110,117	181249	Screw w/Lockwasher, 6-40 x 1 Hex 69	192970	Post 132
153538	Screw, 6-40 x 7/16 Hex 74,132	181392	Terminal, Tab Type 107, 108	194987	Screw, 8-32 x 3/8 Hex 129
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156875	Screw, 6-40 x 5/32 Fil 90	184067	Screw w/Lockwasher, 4-40 x 5/16 Hex 110	318630	Jumper, 6-1/8" Braided 84,95,114
158926	Screw, 4-40 x 7/32 Hex 52	185833	Plate 83	320119	Spacer, .497" Thk 60
159642	Shim, .008" Thk 110	185834	Plate 83	320410	Terminal, Spade Type 88
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161708	Latch, Magnetic 109	185871	Screw w/Lockwasher, 8-32 x 3/8 Hex 60,63,64, 85,96,117	320418	Terminal, Ring Type 56,88
162730	Screw, 1/4-20 x 7/16 Hex 84,97,99,100,123	186749	Bolt w/Cap 84,85,97,109	320420	Terminal, Ring Type 74
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163958	Washer, Flat 78	187242	Clip 98,119	324031	Latch, Front Lid 110
173974	Screw, 10-32 x 5/16 Hex 109	188406	Switch 116	325287	Nut w/Lockwasher, 10-32 Hex 72
174795	Screw, 6-40 x 1/4 Fil 45, 68,71	188483	Arm Stop 60	325911	Jumper, 6-1/2" Lg Green 114
174797	Screw, 6-40 x 3/8 Fil 123	188732	Screw, 8-32 x 3/8 Hex 58,60,117,118	326023	Screw, 4-40 x 9/32 Hex 73,74,120,125,130,132
178707	Bumper, Rubber 74,82,126	188925	Post 98,119	326588	Screw, 6-32 x 1/4 Self-Tapping 37
180714	Screw, No. 6 Self-Tapping 49,50,57,61,69,74,81,82, 106,110,122,126,127	188989	Jumper, 5-1/2" Black 114	326755	Jumper, 3-1/2" Green 114
180778	Plate 98,119	188990	Jumper, 5" White 114	327819	Terminal, Tab Type 102, 107,108
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