

PIECE-PART DATA AND REPLACEMENT PROCEDURES

547-, 552-, 576-, 579-, 582-, 583-, AND 585-TYPE KEYS

1. GENERAL

1.01 This section covers the information necessary for ordering parts to be used in the maintenance of the keys enumerated above. It also covers the approved procedures for replacing these parts.

1.02 This section is reissued to cover the 579- and 585-type keys and to add a procedure for 547-type keys. Detailed reasons for reissue will be found at the end of the section.

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

1.04 Part 3 of this section covers the approved procedures for the replacement of the parts covered in Part 2. This information is called Replacement Procedures.

2. PIECE-PART DATA

2.01 The figures included in this part show the various piece parts in their proper relation to other parts of the apparatus. The piece-part numbers of the various parts are given together with the names of the parts as listed by the Western Electric Company Merchandise Department. When these names differ from those in general use in the field, the latter names, in some cases, are shown in parentheses.

2.02 When ordering piece parts for replacement purposes give both the number and the name of the piece part. For example, P-44A621 Plunger Rod. Do not refer to the section number or to any information shown in parentheses following the piece-part number.

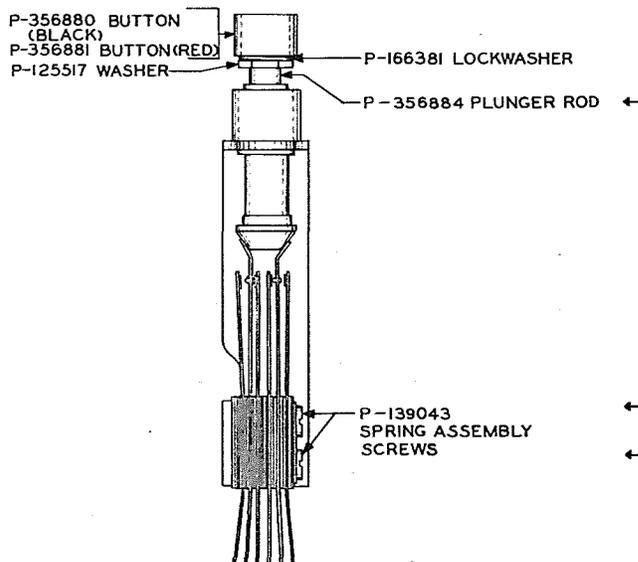


Fig. 1 - 547-type Key (No. 547B Illustrated)

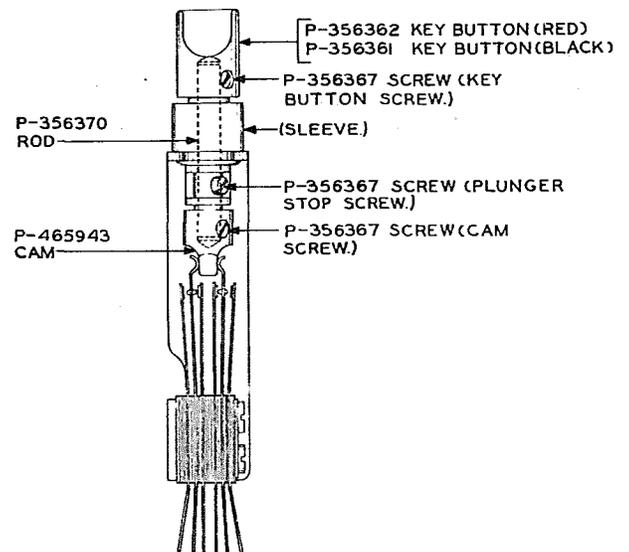


Fig. 2 - Nos. 552A, B, C, D, G, and H Keys Equipped With 3-piece Plunger (No. 552A Illustrated)

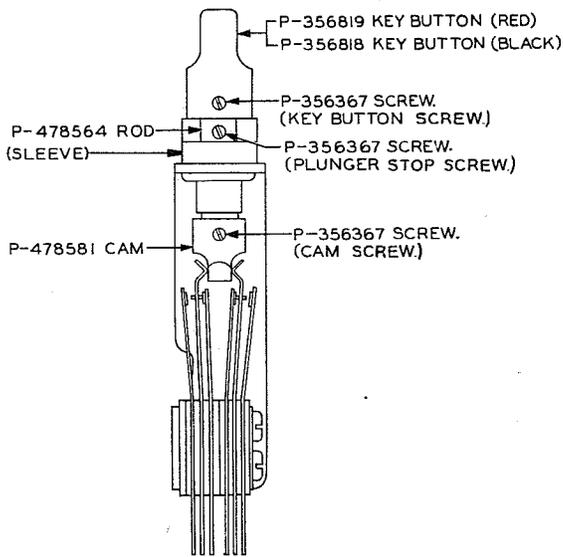


Fig. 3 - No. 552E Key Equipped With 3-piece Plunger

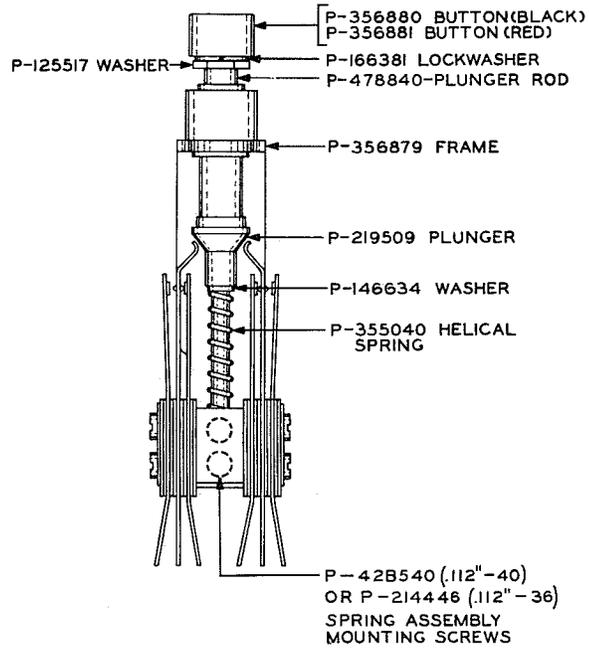


Fig. 5 - 576-type Key

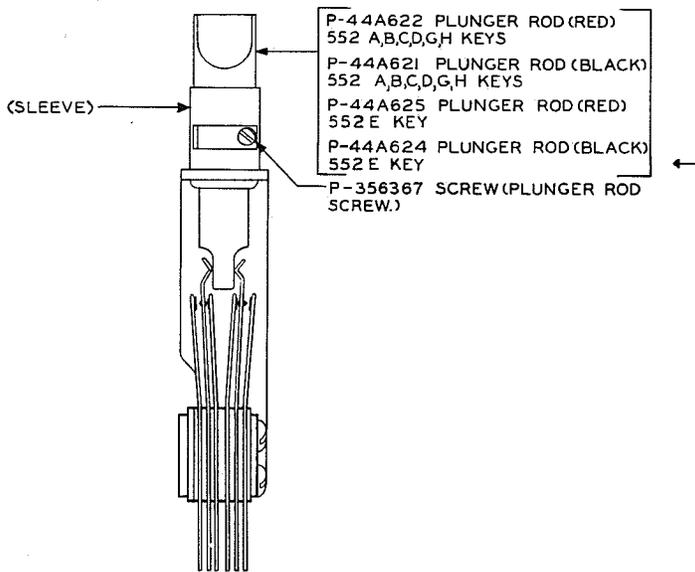


Fig. 4 - 552-type Keys Equipped With One-piece Plunger (No. 552A Illustrated)

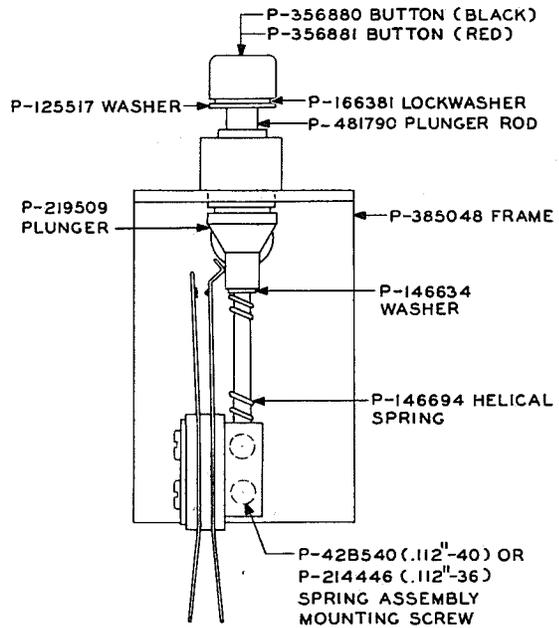


Fig. 6 - 579-type Key

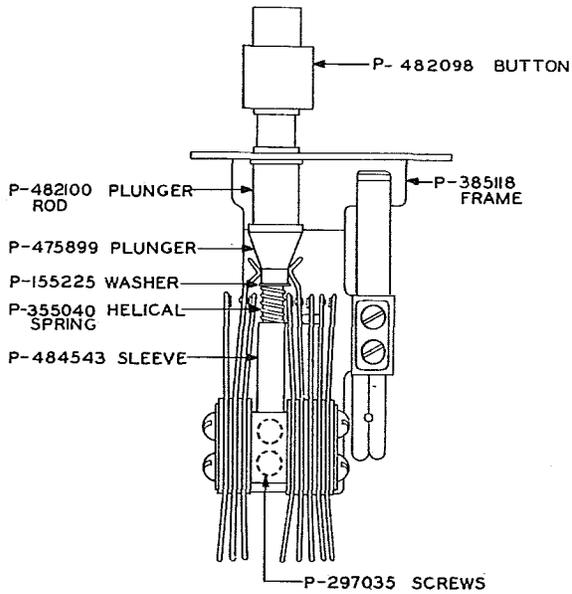


Fig. 7 - 582-type Key

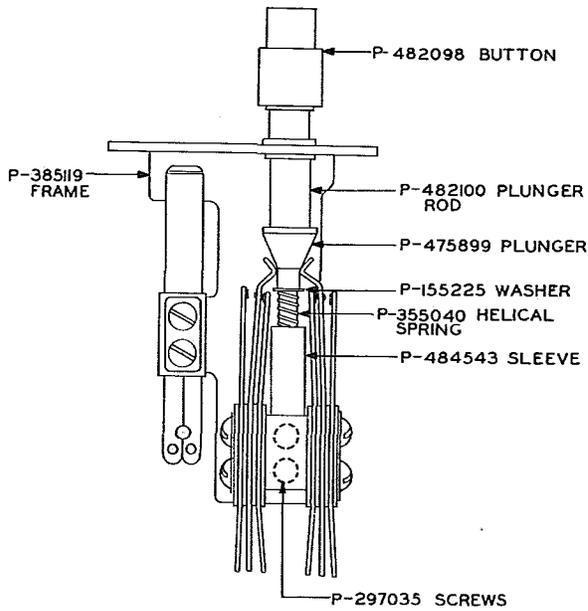


Fig. 8 - 583-type Key

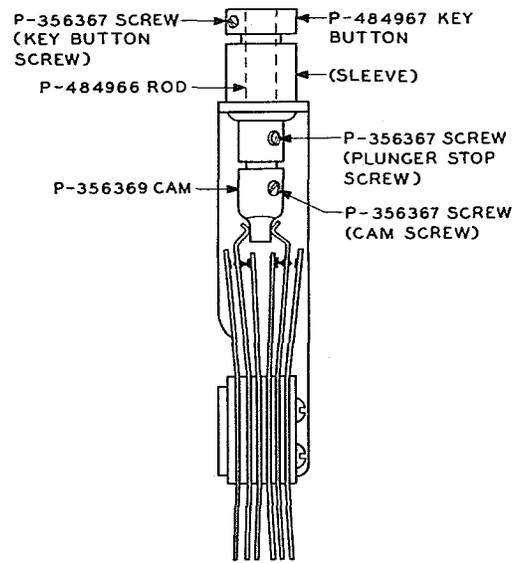


Fig. 9 - No. 585A Key Equipped With 3-piece Plunger

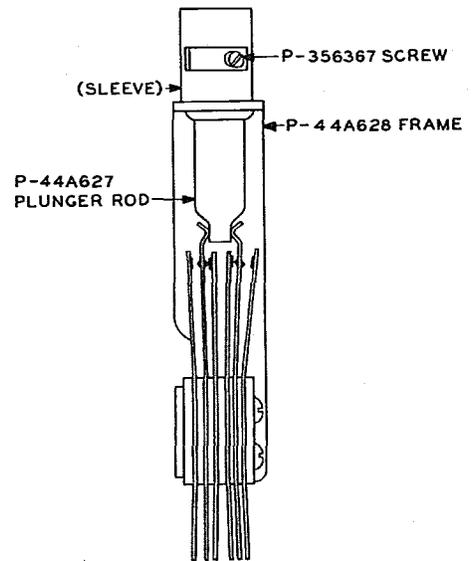


Fig. 10 - 585-type Key Equipped With One-piece Plunger

3. REPLACEMENT PROCEDURES3.01 List of Tools and Materials

<u>Code or Spec No.</u>	<u>Description</u>
<u>Tools</u>	
209	5/16-inch Hex. Open Single-end Offset Wrench
211	Key Button Pliers
→ 417A →	1/4- and 3/8-inch Open Double-end Flat Wrench
R-1005	Jeweler's Screwdriver
R-2959	Allen Socket Screw Wrench
-	3-inch Cabinet Screwdriver
-	4-inch Regular Screwdriver
-	6-1/2-inch P-long-nose Pliers

Material

1A or 2A Cushion (or equivalent tubing)

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

3.03 After making any replacement of parts, check the key and where necessary, readjust it to meet the requirements covered in Section A432.052 for the 547-, 552-, → 576-, 579-, and 585-type keys or Section B432.052 for the 582- and 583-type keys.

3.04 If necessary to remove a 547-, 552-, → 576-, 579-, or 585-type key from its mounting, unsolder the leads to the terminals and tag the leads to facilitate reconnecting them. Remove the key mounting screw using the 4-inch regular screwdriver.

3.05 If necessary to replace a 582- or 583-type key when it is mounted in a 555-, 556-, or 557-type PBX switchboard cord unit, remove the No. 348A plug from the connector. Loosen the two cowl fasteners at the top and bottom of the cord unit, by turning them toward the left (counterclockwise) with the 4-inch regular screwdriver and remove the cord unit. Loosen the plunger block setscrews that secure the plunger block on the push turn rod of the No. 580A key with the R-2959 Allen Wrench. Remove the cotter pin that connects the push turn rod to the No. 580A key with the P-long-nose pliers and while supporting the plunger block, withdraw the push turn rod. Remove the two screws that secure the keyshelf to the cord unit frame with the 3-inch cabinet

screwdriver, and remove the push turn rod bushing with the 4-inch regular screwdriver. Lift the keyshelf from the cord unit frame. Tag and unsolder the wires from the terminals of the 582- or 583-type key. Remove the key mounting screws with the 3-inch cabinet screwdriver. Mount the replaced 582- or 583-type key with the key mounting screws using the 3-inch cabinet screwdriver, resolder the leads, place the keyshelf on the frame, and remount the push turn rod bushing with the 4-inch regular screwdriver. Remount the keyshelf mounting screws with the 3-inch cabinet screwdriver. Slide the push turn rod through the bushing and through the hole in the plunger block. During this operation, the finger portion of the knob should be in the upward position and the key mechanism of the No. 580A key should be in the unoperated position but with the push turn rod pulled out. Insert a new cotter pin as shown in Fig. 11 with the P-long-nose pliers. The two setscrews in the plunger block should then be tightened securely on the push turn rod with the R-2959 Allen wrench so that the position of the plunger block is in accordance with the requirements for plunger block position for the No. 581A key as outlined in Section B432.055. Remount the cord unit, tighten the cowl fasteners with the 4-inch regular screwdriver, and insert the No. 348A plug in the connector.

Key Buttons

→ 3.06 547-, 576-, and 579-type Keys: Hold the locknut with the No. 209 wrench and with the No. 211 pliers, equipped with a No. 1A or 2A cushion or equivalent slid over each jaw, remove the key button by turning in a counterclockwise direction. Screw the new key button on, tightening it securely. Care should be taken to insure that the locknut is seated properly on the shoulder of the plunger rod.

3.07 582- and 583-type Keys: To replace the button, remove the key as covered in 3.05, replace the button on the plunger rod, and remount the key as covered in 3.05.

→ 3.08 552-type and No. 585A Keys Equipped With a 3-piece Plunger: Remove the key button screw with the R-1005 jeweler's

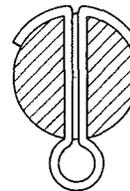


Fig. 11 - Method of Clinching Cotter Pin to Clear Wiring

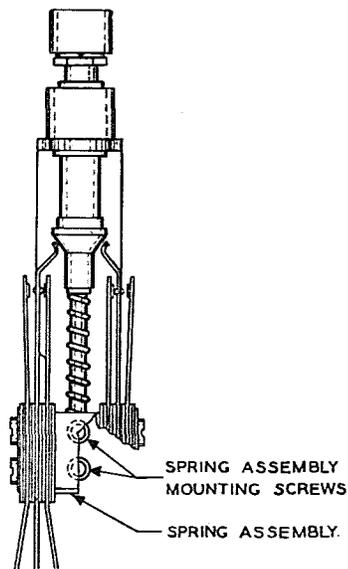


Fig. 12 - Position of Spring Assembly Mounting Screws for the 576-, 579-, 582-, and 583-type Keys (No. 576A Illustrated)

screwdriver and remove the key button. Position the new key button and reassemble the key button screw, tightening it securely.

Plunger Rod

3.09 547-type Key: To replace the plunger rod, remove the spring assembly screw nearest the front of the key using the 3-inch cabinet screwdriver and slightly loosen the spring assembly screw at the rear of the key. Lift the spring assembly sufficiently to clear the plunger. Hold the plunger nut with the No. 417A wrench and remove the key button with the fingers. Then withdraw the plunger rod from its bearing.

Plunger Rod, Sleeve, Helical Spring, Plunger, and Cam

3.10 576- and 579-type Keys: To replace the plunger rod, helical spring, washer, or plunger, remove the button as outlined in 3.06. Remove the spring assembly mounting screws as shown in Fig. 12 with the 3-inch cabinet screwdriver and remove the spring assembly, helical spring,

washer, or plunger, as necessary. Replace the defective part or parts and reassemble them in the reverse order. Tighten the spring assembly mounting screws securely

3.11 582- and 583-type Keys: To replace the plunger rod, sleeve, helical spring, washer, or plunger, remove the key from its mounting as covered in 3.05. Remove the spring assembly mounting screws as shown in Fig. 12 with the 3-inch cabinet screwdriver and remove the spring assembly, sleeve, helical spring, washer, or plunger as necessary. Replace the defective part or parts and reassemble them in the reverse order. Tighten the spring assembly mounting screws securely. Remount the key as covered in 3.05.

3.12 552-type and No. 585A Keys Equipped With a 3-piece Plunger: To replace the cam or rod, remove the plunger stop screw and the cam screw with the R-1005 Jeweler's screwdriver. Withdraw the key button and rod from the sleeve. If the cam requires replacement, remove it. If necessary to replace the rod, remove and assemble the button on the new rod as outlined in 3.08. To reassemble the parts, place the cam between the plunger springs and insert the rod of the button and rod assembly through the sleeve and into the cam. Replace the cam screw and plunger stop screw and tighten them securely.

3.13 552- and 585-type Keys Equipped With a One-piece Plunger: To replace the plunger, remove the plunger rod screw with the R-1005 Jeweler's screwdriver and withdraw the plunger from the sleeve. Position the new plunger rod and tighten the screw securely.

REASONS FOR REISSUE

1. To include the 579- and 585-type keys.
2. To add Figs. 6, 9, and 10.
3. To revise Fig. 1 to add piece-part numbers for the plunger rod and spring assembly screws.
4. To revise Fig. 5 to add a piece-part number for the mounting block screws (information to Western Electric Company covered by C0-513663).
5. To add the No. 417A wrench in the list of tools (3.01).
6. To add a procedure for 547-type keys (3.09).