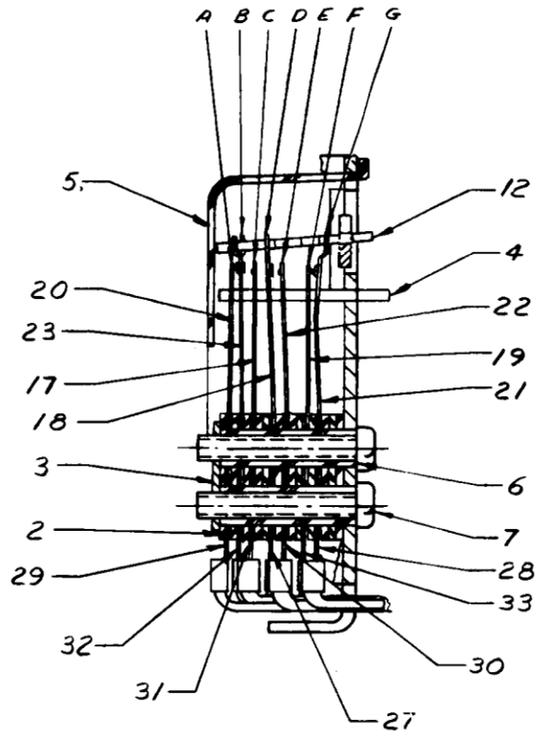


REQUIREMENTS:

- 1.0 ALL MOVING PARTS SHALL MOVE FREELY IN THEIR BEARINGS.
- 2.0 THE INSULATION BETWEEN ALL METAL PARTS SHALL BE CAPABLE OF WITHSTANDING A 500 VOLT A.C. BREAKDOWN TEST PER SPEC. KS 38 SUPPLEMENT C.
- * 3.0 WHEN THE HOOK IS IN ITS UPPER POSITION AGAINST THE STOP:
 - 3.1 THE FORCE BETWEEN EACH PAIR OF CONTACTS ON SPRINGS BC AND ED SHALL NOT BE LESS THAN 15 GRAMS, MEASURED AS NEAR TO THE LINE OF CONTACT AS PRACTICAL.
 - 3.2 THERE SHALL BE A SEPARATION BETWEEN EACH PAIR OF CONTACTS ON SPRINGS AB & GF OF NOT LESS THAN .015 IN.
- * 4.0 WHEN THE HOOK IS FULLY DEPRESSED (AS SHOWN):
 - 4.1 THE FORCE BETWEEN EACH PAIR OF CONTACTS ON THE SPRINGS AB & GF SHALL NOT BE LESS THAN 15 GRAMS, MEASURED AS NEAR TO THE LINE OF CONTACT AS PRACTICAL.
 - 4.2 THERE SHALL BE A SEPARATION BETWEEN EACH PAIR OF CONTACTS ON SPRINGS BC AND ED OF NOT LESS THAN .015 IN.
- * 5.0 WHEN THE HOOK IS RELEASED FROM ITS LOWEST POSITION, THE CONTACT SEQUENCE SHALL BE AS FOLLOWS:
 - 5.1 ONE PAIR OF CONTACTS ON SPRINGS C & B SHALL CLOSE PERCEPTIBLY BEFORE EITHER PAIR OF CONTACTS ON SPRINGS D & E CLOSE.
 - ~~5.2 BOTH PAIRS OF CONTACTS ON SPRINGS F & G SHALL OPEN PERCEPTIBLY AFTER BOTH PAIRS OF CONTACTS ON SPRINGS B & C CLOSE.~~
 - 5.2 ONE PAIR OF CONTACTS ON SPRINGS D & E SHALL CLOSE PERCEPTIBLY BEFORE BOTH PAIRS OF CONTACTS ON SPRINGS A & B OPEN AND BOTH PAIRS OF CONTACTS ON SPRINGS F & G OPEN.
 - 5.3 BOTH PAIRS OF CONTACTS ON SPRINGS A & B SHALL OPEN PERCEPTIBLY BEFORE BOTH PAIRS OF CONTACTS ON SPRINGS F & G OPEN.
- * 6.0 CONTACT SPRING ASSEMBLIES, P-10E233 AND P-339709 SHALL REMAIN VISUALLY OPEN WHEN A LOAD OF 100 GRAMS IS APPLIED TO SWITCH HOOK AT A LINE LOCATED MIDWAY BETWEEN THE HANDSET SEATING SURFACE.

REQUIREMENTS CONTINUED BELOW.



SECT. A-A

REQUIREMENTS CONTINUED

- * 7.0 WHEN THE ARM IS DEPRESSED FROM ITS UPPER POSITION, THE CONTACT SEQUENCE SHALL BE AS FOLLOWS.
 - ~~7.1 ONE PAIR OF CONTACTS ON SPRINGS A AND B SHALL CLOSE BEFORE BOTH PAIRS OF CONTACTS C AND D OPEN.~~
 - 7.1 ONE PAIR OF CONTACTS ON SPRINGS A & B SHALL CLOSE PERCEPTIBLY AND BOTH PAIRS OF CONTACTS ON SPRINGS D & E SHALL OPEN PERCEPTIBLY BEFORE BOTH PAIRS OF CONTACTS ON SPRINGS B & C OPEN.
 - ~~7.2 ONE PAIR OF CONTACTS ON SPRINGS A & B SHALL MAKE AND BOTH PAIR OF CONTACTS ON B & C SHALL OPEN BEFORE BOTH PAIR ON CONTACTS C & D OPEN.~~

* - SEE ASSEMBLY NOTE 4

ASSEMBLY NOTES:

1. LUBRICANT KS 8559 SHALL BE APPLIED TO THE BEARING SURFACES OF BRACKET (ITEM 10), HOOK AND SHAFT. A PRECEPTIBLE FILM OF LUBRICANT SHALL BE OBSERVABLE AT THE POINTS OF APPLICATION.
2. INSULATORS (ITEM 2) SHALL BE BAKED, STORED AND ASSEMBLED AS SPECIFIED ON A-552789.
3. (S) AT ANY TIME UP TO 30 DAYS AFTER ASSEMBLY, THE TORQUE REQUIRED TO TURN THE SPRING PILE-UP SCREWS IN A TIGHTENING DIRECTION SHALL NOT BE LESS THAN 10 LB.-IN.
4. (S) REQUIREMENTS 3.0, 4.0, 5.0, 6.0 AND 7.0 APPLY AFTER SWITCH HOOK ASSEMBLY, P-24E277 SHAFT, P-13E124 AND COIL SPRING, P-339687, ARE ASSEMBLED. THESE PARTS ARE SHOWN IN TELEPHONE SET STOCKLIST. THE SWITCH AFTER ASSEMBLY SHALL BE CAPABLE OF MEETING REQUIREMENTS 3.0, 4.0, 5.0, 6.0 AND 7.0 AFTER ASSEMBLY IN THE TELEPHONE SET.

P-24E273

DATE	ISSUE	BY	CHKD
11-16-62	1	REO	REO
11-16-62	2	REO	REO
11-16-62	3	REO	REO
11-16-62	4	REO	REO
11-16-62	5	REO	REO

CHANGED: ITEMS 27, 31 & 32 WERE P-13E124, P-13E173 & P-13E174 RESP

LE. REO | 590932AC

CHANGED: P-13E124 TO AGREE WITH P-24E276. ISSUE 2

LE. REO | 590929AC

6-26-62

CHANGED: P-13E124 TO AGREE WITH ISS-3, P-24E276.

REO | 442725-A1

8-30-62

CHANGED: P-13E124 TO AGREE WITH ISS-2, P-13E417

REO | 591319-B1C-1

4-11-63

CHANGED: IN REGT 5.3, PORTION BOTH PARTS WAS EITHER AD. REGTS 5.2 & 7.1 WERE AS IN CROSSHATCHED REGTS 5.2 & 7.1. CANCELED: REGT 7.2

REO | 591495-B1L-1

8-7-63

ITEM	QUANTITY	DESCRIPTION	REMARKS	REQ
33	1	P-13E175	SLATE-RED	1
32	1	P-25E004	SLATE-WHITE	1
31	1	P-25E003	SLATE-GREEN	1
30	1	P-13E172	SLATE-BROWN	1
29	1	P-13E171	SLATE	1
28	1	P-43A830	SLATE-BLACK	1
27	1	P-43A999	SLATE-YELLOW	1
26				
25				
24				
23	1	P-18A867		1
22	1	P-18A261		1
21	1	P-10E233	CONTACT SPRING ASSEMBLY	1
20	1	P-339710		1
19	1	P-339709		1
18	1	P-339673		1
17	1	P-339672		1
16				
15				
14				
13				
12	1	P-13E125	CARD OPERATING	1
11	1	P-24E272	SUPPORT & BRACKET ASSEM.	1
10				
9				
8				
7	2	P-43A433	SCREW, RHM SPL. HEAD	2
6	2	P-335678	BUSHING	2
5	1	P-13E417	COVER	1
4	1	P-339686	CARD STATIONARY	1
3	1	P-339683	PLATE	1
2	12	P-339681	INSULATOR	12
1				

FOR CHARGES REFER TO DRAFTING ORG. CARD INDEX

SWITCH ASSEMBLY

SCALE 2/1
WESTERN ELECTRIC CO. INC.
ENGINEER OF MANUFACTURE

ITEM	PIECE	NAME	REQ
STOCK LIST			
DIMENSIONS UP TO AND INCLUDING 7/8 INCHES EXPRESSED IN INCHES. NON-LIMITED DIMENSIONS OTHER THAN SIZE OF RAW MATERIAL SHALL BE HELD WITHIN FRACTIONAL DECIMAL.			
			6S