BELL SYSTEM PRACTICES
Teletypewriter and Manual Telegraph Station and P.B.X. Installation and Maintenance

SECTION P35.652
Issue 1, November, 1945
AT&T Co Provisional

TYPING REPERFORATOR UNITS AND BASES 14 TYPE

REQUIREMENTS AND PROCEDURES OPERATION AT 100 SPEED

1. GENERAL

1.01 This section outlines special apparatus requirements and adjusting procedures for the maintenance of No. 14 typing reperforator units and bases for wpm operation.

1.02 The information contained herein will be included in the standard P sections when it has been fully tested in the field.

1.03 For requirements and procedures not covered herein reference should be made to standard P sections covering No. 14 typing reperforator units and bases.

2. LUBRICATION

2.01 The following typing reperforator unit and base parts shall be lubricated with oil in addition to those listed in other sections:

Typing Reperforator Units

(a) Felt washer on selector cam assembly located between the armature lever cam and stop arm (saturate).

(b) Felt wick in selector arm spring (saturate).

(c) Felt wick in locking lever spring (saturate).

(d) Felt wick in armature lever spring (saturate).

Note: Above felt wicks were not included in early 100 wpm sets of parts.

Bases (Sending and Receiving)

(e) Felt washers between cams on the transmitting cam sleeve assembly (saturate).

3. REQUIREMENTS AND PROCEDURES—TYPING REPERFORATOR UNITS

3.01 **Main shaft clutch spring (110878M):** A pull of 64 ozs. shall separate the clutch teeth and a pull of 52 ozs. shall not separate the clutch teeth under conditions outlined for measuring the regular spring.

3.02 **Sword separator plate leaf springs,** except on front and rear plates, shall be bent min. .050", max. .060", away from plane of plates.

3.03 **Locking lever spring (2605M)** tension shall be min. 7 ozs., max. 10 ozs., measured in the same manner as the regular spring.

Note: 2605M spring was not furnished in early 100 wpm sets of parts. This spring with a 74553M wick should be used to obtain a more stable locking action.

3.04 **Selector arm stop detent spring (110880M)** shall be min. 6-3/4 ozs., max. 7-3/4 ozs., measured in the same manner as the regular spring.

3.05 **Armature lever spring** tension shall be min. 22 ozs., max. 26 ozs., measured and adjusted as outlined for normal operation.

Note: Early 100 wpm sets of parts did not include a 73611M wick for this spring. The wick should be used to stabilize the spring action.

3.06 **Selector arm spring (114107M)** tension shall be min. 1-3/4 ozs., max. 2-1/4 ozs. measured in the same manner as the regular spring.

Note: 110879M spring was furnished in early 100 wpm sets of parts. This heavier spring which gives a tension between 2-3/4 and 3-1/4 ozs. should be replaced by the later 114107M spring and its 93729M wick to obtain more satisfactory operation.

3.07 **Trip latch spring (110872M)** pressure shall be min. 3 ozs., max. 3-1/2 ozs., measured in the same manner as the regular spring.

3.08 **Selector clutch torque:** A pull of 22 ozs. shall hold the cam sleeve from rotating and a pull of 18 ozs. shall not hold the cam sleeve from rotating under conditions outlined for normal operation.

4. REQUIREMENTS AND PROCEDURES — TYPING REPERFORATOR BASES (SENDING AND RECEIVING)

4.01 **Short contact springs:**

(a) Sending contact gaps shall be min. .020", max. .025", (with exception of start-stop contact gap which may be min. .015", max. .025") when associated contact levers are on the high part of their cams.

(b) Short contact springs shall require a horizontal pressure of min. 4 ozs., max. 8 ozs., applied directly behind their contacts to move them away from their stiffeners when associated contact levers are on the high part of their cams.

(1) To adjust, bend short contact springs and their stiffeners using the 72003M tool. If this adjustment is made check sending contact pressure as specified in P35.620.

4.02 **Lock loop roller** shall clear the highest part of its cam by min. .020", max. .060", when lock loop is held against its backstop screw.

(a) To adjust, reposition backstop screw.