

BELL SYSTEM PRACTICES
Teletypewriter Stations

SECTION P36.474
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AT&T Co Standard

INSTALLATION OF THE TP95380 SET OF PARTS ON 15 TYPING UNIT TO CONVERT PULLING-MAGNET TYPE TO HOLDING-MAGNET TYPE

1. GENERAL

1.01 This section furnishes information for installing the TP95380 set of parts on a pulling-magnet 15 typing unit to convert it to a holding-magnet typing unit.

1.02 This section is reissued to show the substitution of a terminal block for a series-parallel switch to permit series or parallel connection of the selector-magnet windings. The changes are indicated by marginal arrows.

2. LIST OF PARTS

2.01 The TP95380 set of parts consists of the following:

- 1—TP95379 Holding-magnet selector assembly
- 1—TP91265 Cam-sleeve assembly
- 1—TP91266 Retaining disc
- 1—TP113703 Series-parallel terminal block assembly
(includes TP123540 cable assembly,
TP82440 screws and TP2191 lock-
washers)
- 1—TP90760 Range-finder assembly
- 1—TP91278 Patent plate
- 4—TP75646 Drive-screws
- 1—TP124591 Cable assembly
- 1—TP95218 Lacing twine

3. INSTALLATION

- 3.01 Remove the typebar carriage from the typing unit.
- 3.02 Remove and discard the range-finder assembly.
- 3.03 Remove and discard the TP72516 retaining disc and the TP8507 selector cam sleeve from the main-shaft.
- 3.04 If the typing unit is equipped with a mechanical motor-stop mechanism remove and discard all parts of the mechanism as this type of motor stop cannot be used with the holding-magnet selector.
- 3.05 Remove the TP8884 terminal block from the underside of the typing unit and unsolder the leads of the selector-magnet cable from the terminal block.
- 3.06 Remove the three TP6746 screws and TP2191 lock-washers which secure the selector assembly to the typing unit and remove the selector assembly. Discard this assembly except for the clutch throw-out lever, the clutch throw-out-lever bracket and the screws and washers mounting this bracket.
- 3.07 Assemble the clutch-throw-out lever and bracket on the selector assembly furnished with the set of parts.
- 3.08 Mount the holding-magnet-selector assembly on the typing unit using the three TP6746 mounting-screws previously removed and three TP2191 lock-washers. Before tightening the mounting-screws, make sure that the T levers properly engage the arms of their respective selector vanes.
Note: In some of the older typing units there may be interference between the selector-arm pivot-screw and the raised portion of the left-side frame casting that mounts the main-shaft bearing. If this interference exists, a small amount of this raised portion will have to be filed away until no interference exists. The portion filed should be coated with lacquer or touch-up paint to prevent rusting.
- 3.09 Install the TP91265 selector cam sleeve and the TP91266 retaining disc on the main-shaft.
- 3.10 Remove the TP74200 upper carriage track and drill two holes in it as shown in Fig. 1. Remount the track so that these two holes in the end will be at the left side of the typing unit; i.e. above the selector assembly. **Fig. 1**
- 3.11 Mount the TP113703 series-parallel terminal block⁷ assembly on the rear side of the upper carriage track, using the TP82440 screws and the TP2191 lock-washers. Wire the TP124591 cable assembly from the selector magnets to the

TP8884 terminal block as shown in Fig. 2. Wire the TP123540 cable assembly from the selector magnets to the TP113703 series-parallel terminal block assembly as shown in **Fig. 2**.

3.12 Remount the TP8884 terminal block on the underside of the typing unit with the mounting-screws, lock-washers and insulator originally used for this purpose.

3.13 With lacing twine, tie the TP124591 selector magnet cable to the teletypewriter frame at the left end (as viewed from the front) of the TP8884 terminal block. ↙

3.14 Mount the new range-finder mechanism on the typing unit.

3.15 Remove the "U. S. Patent" nameplate on the right-side frame by taking out its drive-screws and mount the TP91278 "U. S. Patent" nameplate furnished with the set of parts in this location, using the TP75646 drive-screws also furnished.

Note: The drive-screws may be removed by tapping the ends of the screws on the underside of the casting using a drift punch and hammer.

3.16 Remove the typing-unit code-designation plate and replace it with the proper code-designation plate for the converted unit if such a plate is available.

3.17 Replace the typebar carriage on the typing unit.

3.18 Adjust the selector mechanism in accordance with ←
B.S.P. Section P32.001. ←

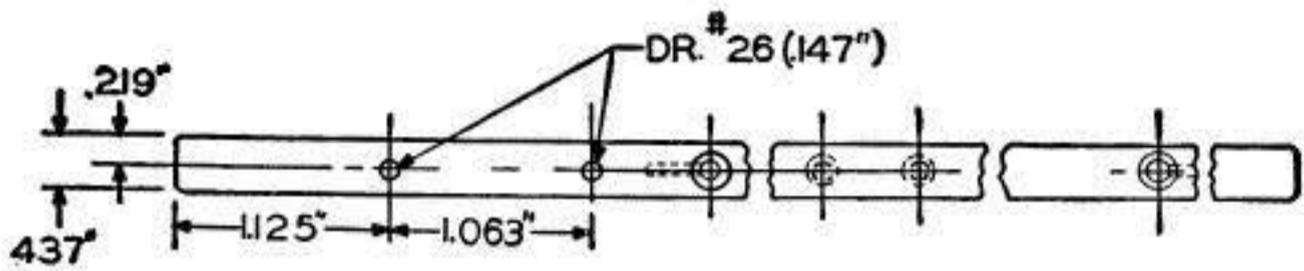


Fig. 1

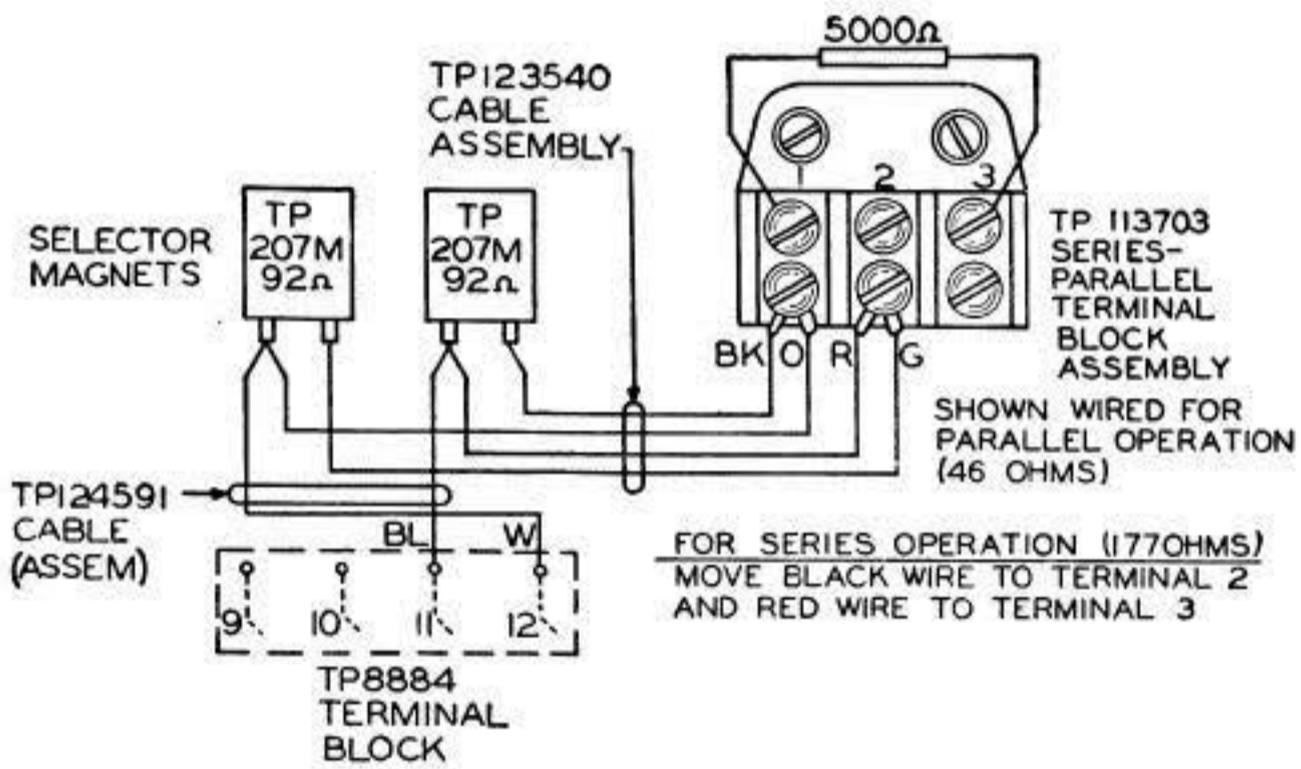


Fig. 2