

INSTRUCTIONS FOR INSTALLING THE 312994 MODIFICATION
KIT TO PROVIDE A UNIVERSAL KEYBOARD SWITCH ON
MODEL 35 KEYBOARDS

1. GENERAL

1.01 The 312994 modification kit provides an electrical switch under any or all keys in the keyboard. It may be wired normally open or closed. The keyboard switch mounts directly under the lobe of the codebar lever in the keyboard. As the key is pressed, it performs its standard function and opens or closes the keyboard switch.

1.02 The contacts of the kit are capable of passing one ampere of ac or 1/2 ampere of dc current at 120 volts.

1.03 The 312994 kit consists of:

1	1178	Screw	2	121473	Stud
2	2191	Washer	2	153817	Screw
2	3599	Nut	2	156740	Screw
2	7002	Washer	1	309507	Contact Assembly
1	71073	Washer	1	309508	Bracket, Left
2	85976	Washer	1	309509	Bracket, Right
1	93117	Washer	1	312727	Guide
2	110743	Washer	2	312995	Bar, Retainer
1	112627	Nut			

1.04 For parts ordering information, other than the parts in the kit, and for standard adjustments and lubrication procedure, refer to the standardized information.

2. INSTALLATION (Figures 1, 2, and Bulletin 1187B)

2.01 Install the 312995 retainer bars on the 309508 and 309509 brackets. Fasten the bar to the brackets friction tight using two 153817 screws, 110743 lockwashers, and 3599 nuts.

Note: Sight down the length of the 312995 retainer bars and check for straightness. Bend, if necessary, prior to assembly.

2.02 Install the 309507 switch in its approximate location on the 312995 retainer bars. Fasten friction tight in place with the 1178 screw, 321727 guide, 71073 flat washer, 93117 lockwasher, and 112627 nut.

- 2.03 Remove the 309506 spring from the 309507 switch to prevent molten solder from running into it. Solder the wires carefully to prevent shorting and/or interference with the swinger, spring, and 112627 mounting nut. Replace the 309506 spring.
- 2.04 Remove the two 151631 screws, 2191 lockwashers, and two 125015 flat washers holding the 192552 ball channel. Install two 121473 studs along with the same lockwashers and two 85976 flat washers. Discard the two 125015 flat washers. Be careful not to disturb the adjustment of the ball channel. Install the 309508 and 309509 brackets with attached 312995 retainer bars on top of the studs friction tight with two 2191 lockwashers, two 7002 flat washers, and two 156740 screws.

Note: Arc suppression should be provided as necessary.

3. ADJUSTMENTS (Figures 1 and 2) - Make the following adjustments.

3.01 Keyboard Switch Horizontal Adjustment

Requirement

With the contact assembly guide and code lever assembly lined up, as per Figure 2, there should be some to 0.020" clearance (gauge by eye) between the right edge of the contact swinger insulator and the extension of the code lever assembly in the unoperated position.

To Adjust

Loosen the 1178 screw holding the contact assembly to the 312995 retainer bars and adjust. Tighten the screw.

Note: When the horizontal adjustment is completed, check for 0.050" to 0.075" clearance between the contact assembly spring and the keyboard wedge retainer. Bend the 312995 retainer bars if necessary.

3.02 Keylever Switch Vertical Adjustment

Requirement

With the unit in the stop position and the keylever depressed to a point where the clutch engages or the intended function selected, the center and lower contact should just close.

To Adjust

Loosen the two 156740 screws which fasten the 309508 and 309509 brackets on the two 121473 studs and position the complete mounting assembly.

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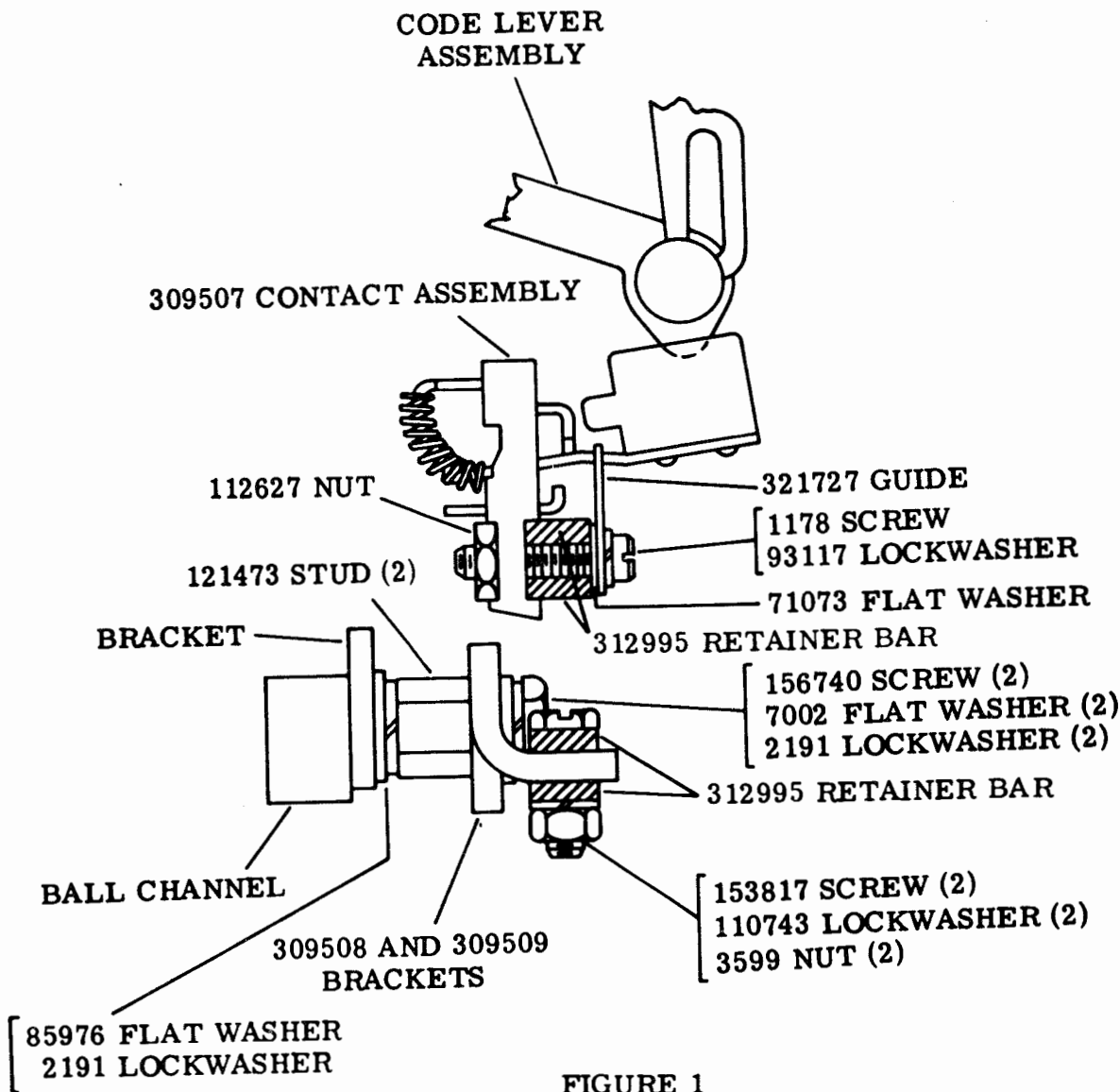


FIGURE 1

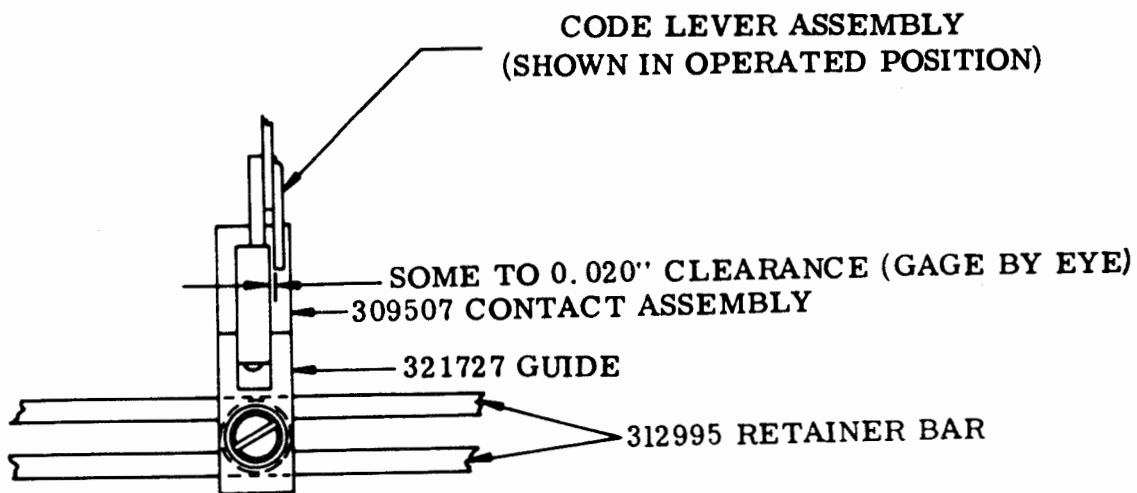


FIGURE 2