

INSTRUCTIONS FOR USE OF THE 116749
TYPE-PALLET SOLDERING JIG
FOR MODEL 15 PRINTER

1. GENERAL

The Teletype 116749 type pallet soldering jig is designed to aid in the aligning of type pallets when they are being replaced in Model 15 printer typing units. The body of the jig clamps to the type bar guide by means of a thumb screw and presents an adjustable matrix to the type pallet when raised to the printing position. A pressure arm holds the type pallet in contact with the matrix. The 116749 jig includes a 116751 matrix for use with standard (.098" high) type. A 116750 matrix for type .120" high may be ordered separately.

2. PROCEDURE

- a. Remove the type bar carriage from the typing unit and remove the ribbon carrier from the carriage.
- b. Select the "N" type bar to serve as a master type bar. (If the "N" pallet or its associated type bar is damaged or otherwise unsuitable, some other type bar in close proximity to the "N" type bar may be used as a master.)
- c. Position the matrix (116750 for type .120" high or 116751 for type .098" high) of the type soldering jig approximately midway in its vertical travel and place the type soldering jig on the type bar guide. Clamp the jig in place by means of the thumb screw in a position such that the lower case character of the selected master type bar when raised engages the lower cut-out in the matrix.
- d. Secure the master type bar to the jig by means of the spring clamp.
- e. Adjust the matrix to meet the following conditions:
 - (1) The top and bottom sloping surfaces of the lower case character should touch the sloping sides of the lower cut-out of the matrix. This adjustment may be secured readily if the lower thumb screw for the matrix is loosened and the matrix made friction-tight by means of the upper thumb screw and then shifted upward or downward. Since all type faces may not be of equal height, it is essential that the type pallet on the selected master type bar touch as specified for good alignment. The cut-out has been made somewhat smaller than the height of the smallest type face.
 - (2) The upper case type face should just touch the upper surface of the matrix. This adjustment is made with the lower thumb screw. After making this adjustment, recheck adjustment outlined in Paragraph (1), refine if necessary, and tighten the upper thumb screw. Release the spring clamp and remove the master type bar from the jig.
- f. Remove the unwanted type pallets from the type bars and remove excess solder to facilitate positioning the new pallets on the type bars.

g. Place the new type pallet on the type bar and clamp the type bar in the jig by means of the spring clamp. Hold the pallet securely against the matrix so that the new pallet meets the conditions given under Paragraph e. Solder the type pallet to the type bar and remove excess solder. After the solder has hardened, remove the type bar with pallet from the jig and repeat the process on other type bars as required.

h. Replace the ribbon carrier on the type bar carriage and replace the type bar carriage on the typing unit.

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