

KS-19717 L3, L6 AND L7 TAPE PRINTERS REQUIREMENTS AND ADJUSTING PROCEDURES

1.01 This section covers requirements and adjusting procedures for the KS-19717 L3, L6, and L7 tape printers. ♦The L3 tape printer is rated "Manufacture Discontinued."♦ The L7 tape printer differs from the L6 in that it is equipped with a KS-19717 L11 Low Tape Alarm.

1.02 This section is reissued to

- Revise plunger stroke travel in 2.04
- Revise adjusting procedure in 3.04 through 3.07
- Revise Fig. 2 and 3.

This reissue affects the Equipment Test List.

1.03 Reference shall be made to Section 020-010-711, covering general requirements and definitions, for additional information necessary for the application of the requirements listed herein.

1.04 Asterisk (*): Requirements are marked with an asterisk when to check for them would necessitate dismantling or dismounting of apparatus, or would affect the adjustment involved, or other adjustments. No check should be made for these requirements unless the apparatus or part is made accessible for other reasons, or its performance indicated that such a check is advisable.

1.05 To show the location of component parts, the KS-19717 L6 tape printer with cover removed is illustrated in Fig. 1.

2. REQUIREMENTS

2.01 Cleaning: The tape printer shall be cleaned when necessary in accordance with approved procedures.

2.02 Lubrication: Do not lubricate or permit any lubricant to contact any parts of the tape printer.

2.03 Freedom of Movement: All moving parts shall be free from bind.

Gauge by feel.

***2.04 Plunger Stroke Travel:** The plunger stroke travel requirements for the solenoids are given in the following list:

SOLENOID	PLUNGER STROKE TRAVEL
1	♦0.120 inch
2	0.060 inch
3	0.240 inch
4	0.120 inch
5	0.060 inch
6	0.240 inch♦

♦Use B-27580 solenoid adjustment tool.♦

***2.05 Lateral Position Cable Adjustment:** With the plunger stroke travel requirement in 2.04 met for solenoids 3, 4, and 5, each of the characters and symbols shall be in correct horizontal alignment, centered under the print hammer.

Gauge by eye.

***2.06 Rotary Position Cable Adjustment:** With the plunger stroke travel requirement in 2.04 met for solenoids 1, 2, and 6, plus the lateral cable adjustment in 2.05 met, all of the characters and symbols shall be centered vertically on the tape.

Gauge by examining printout.

***2.07 Hammer Solenoid and Tape Advance:** The print hammer solenoid assembly shall be positioned to give proper tape advance action (character spacing) and proper intensity of printout.

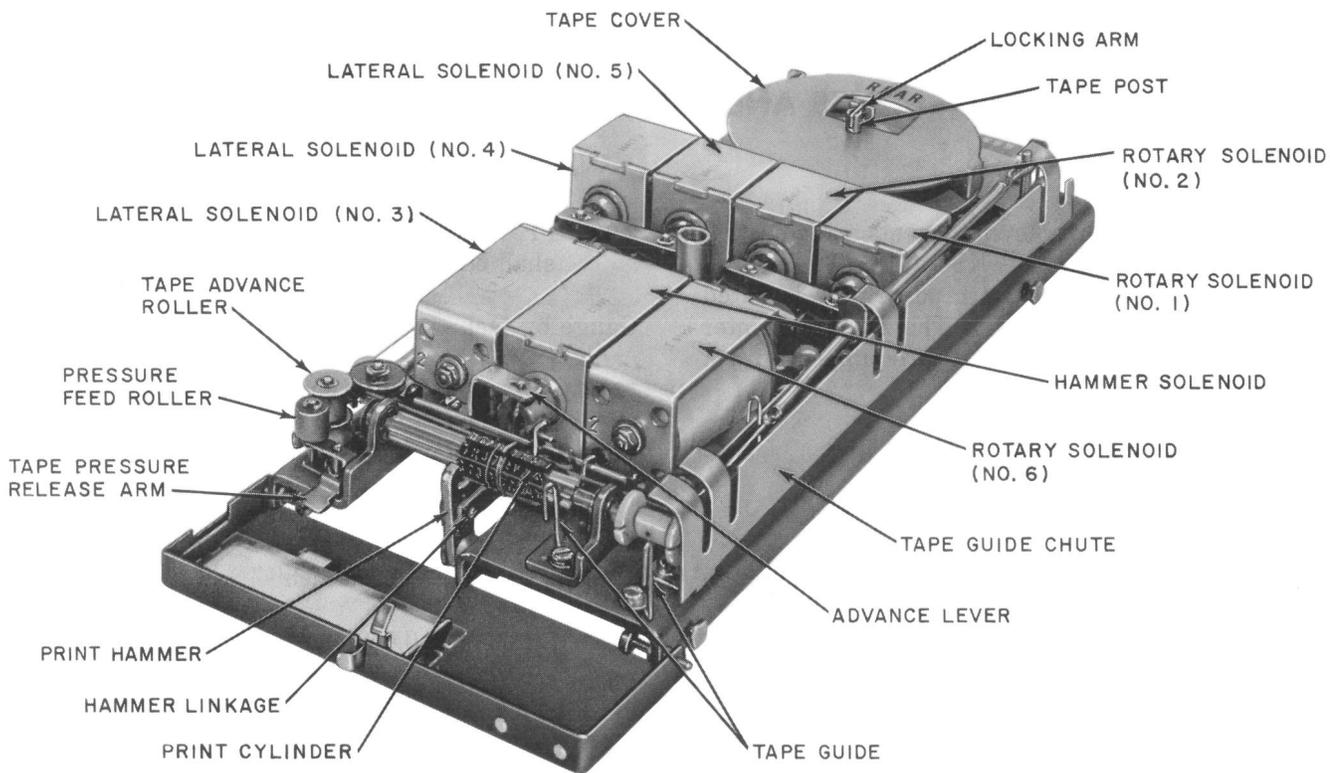


Fig. 1—KS-19717 L6 Tape Printer—Cover Removed

Gauge by examining printout.

2.08 Low Tape Alarm: The low tape alarm may be actuated at any point on the tape roll as determined by local requirements.

3. ADJUSTING PROCEDURES

3.001 List of Tools, Gauges, and Materials:

CODE OR SPEC NO.	DESCRIPTION
B27580	Solenoid adjusting tool
349	3/16- and 7/32-Inch hex closed double-end offset wrench
417A	1/4- and 3/8-Inch open flat wrench
—	3-Inch C screwdriver
R-8550	6-Inch steel scale

3.002 In order to make the adjustments covered herein, remove the tape printer from service. The equipment cover must be removed to gain access to the components. Fig. 2 illustrates the relative position of the components that may require adjustment.

3.01 Cleaning (Reqt 2.01)

- (1) Clean the external parts of the tape printer with a clean dry cloth.
- (2) To clean other parts of the tape printer, use a clean, lint-free cloth and a KS-2993 brush.

3.02 Lubrication (Reqt 2.02)

(No procedure.)

3.03 Freedom of Movement (Reqt 2.03)

- (1) If binding occurs in solenoid plungers, check for possible dirt or metallic particles. Clean

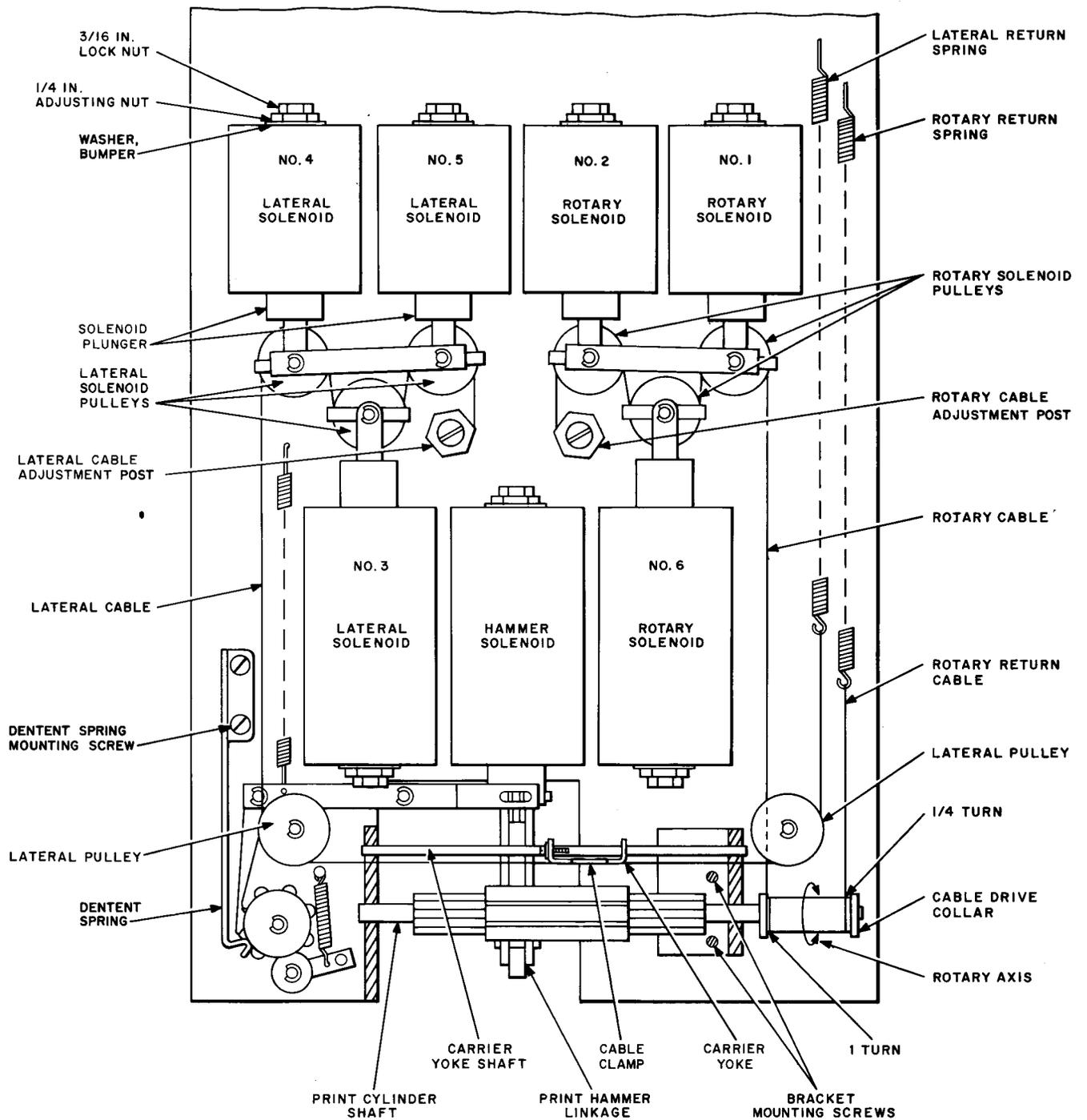


Fig. 2—Functional Diagram of KS-19717 L6 Tape Printer

the plunger and liner. Examine the liner for signs for wear and replace as required.

- (2) If binding occurs in hammer operating linkage, print cylinder movement, or any of the other mechanical functions, check for wear and replace worn parts.

3.04 *Plunger Stroke Travel* (Reqt 2.04)

- (1) Manually press the plunger against the solenoid seat and loosen the 3/16-inch hex nut at the rear of the plunger. Insert the proper size side of the B27580 adjusting tool (Fig. 3) between the rubber washer next to the 1/4-inch nut at the rear of the solenoid and the solenoid body.
- (2) Adjust the distance between the rubber washer next to the 1/4-inch nut and solenoid body to the tool size and tighten the 3/16-inch nut. Remove the tool.

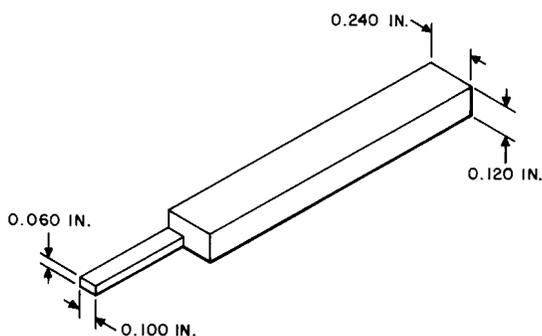


Fig. 3—A27580 Solenoid Adjusting Tool

3.05 *Lateral Position Cable Adjustment* (Reqt 2.05)

Note: To avoid overheating the solenoids, do not energize any longer than is necessary. To avoid damaging the contacts on the printed circuit board, it is recommended that the 48 volts required for test and adjustment procedures be supplied to the printer through a WE 906H connector instead of through alligator clips or other similar means.

- (1) Energize solenoids 3, 4, and 5. The character \ should be in correct alignment under

the print hammer. If the \ is correctly aligned, proceed to (4), if not, perform (2) and (3).

- (2) Loosen the screw on the lateral cable adjustment post and rotate the hex pulley either cw or ccw until the character \ is properly aligned.

- (3) Retighten the screw when the proper alignment has been achieved.

- (4) Energize solenoids 3 and 4. The character L should be in correct alignment under the print hammer. If the L is correctly aligned proceed to (7), if not, perform (5) and (6).

- (5) Loosen the 3/16-inch locknut on solenoid 5 and rotate the 1/4-inch adjustment nut cw or ccw until the character L is properly aligned.

- (6) Hold the 1/4-inch adjustment nut in place and tighten the 3/16-inch locknut.

- (7) Energize solenoids 3 and 5. The character T should be in correct alignment under the print hammer. If the T is correctly aligned, proceed to (10), if not, perform (8) and (9).

- (8) Loosen the 3/16-inch locknut on solenoid 4 and rotate the 1/4-inch adjustment nut cw or ccw until the character T is properly aligned.

- (9) Hold the 1/4-inch adjustment nut in place and tighten the 3/16-inch locknut.

- (10) Energize solenoids 4 and 5. The character X should be in correct alignment under the print hammer. If the X is correctly aligned, proceed to (13), if not, perform (11) and (12).

- (11) Loosen the 3/16-inch locknut on solenoid 3 and rotate the 1/4-inch adjustment nut cw or ccw until the character X is properly aligned.

- (12) Hold the 1/4-inch adjustment nut in place and tighten the 3/16-inch locknut.

- (13) De-energize all of the solenoids. The symbol @ should be in correct alignment under the print hammer. If the @ is not correctly aligned, repeat (1) through (13).

3.06 *Rotary Position Cable Adjustment* (Reqt 2.06)

Note: To avoid overheating the solenoids, do not energize any longer than is necessary. To avoid damaging the contacts on the printed circuit board, it is recommended that the 48 volts required for test and adjustment procedures be supplied to the printer through a WE 906H connector instead of through alligator clips or other similar means.

- (1) Energize rotary solenoids 1, 2, and 6. The symbol # should be in correct alignment under the print hammer. If the # is correctly aligned, proceed to (4); if not, perform (2) and (3).
- (2) Loosen the screw on the rotary cable adjustment post and rotate the hex pulley either cw or ccw until the symbol # is properly aligned.
- (3) Retighten the screw when the proper alignment has been achieved.
- (4) Energize solenoids 1 and 6. The character ! should be in correct alignment under the print hammer. If the ! is correctly aligned, proceed to (7); if not, perform (5) and (6).
- (5) Loosen the 3/16-inch locknut on solenoid 2 and rotate the 1/4-inch adjustment nut cw or ccw until the character ! is properly aligned.
- (6) Hold the 1/4-inch adjustment nut in place and tighten the 3/16-inch locknut.
- (7) Energize solenoids 2 and 6. The symbol " should be in correct alignment under the print hammer. If the " is correctly aligned, proceed to (10); if not, perform (8) and (9).
- (8) Loosen the 3/16-inch locknut on solenoid 1 and rotate the 1/4-inch adjustment nut cw or ccw until the symbol is properly aligned.
- (9) Hold the 1/4-inch adjustment nut in place and tighten the 3/16-inch locknut.
- (10) Energize solenoid 6. The symbol □ should be in correct alignment under the print hammer. If the □ is not correctly aligned, repeat (4) through (10).

- (11) De-energize all solenoids. The symbol @ should be correctly aligned. If the @ is not correctly aligned, repeat (1) through (11).

3.07 Hammer Solenoid and Tape Advance:

(Reqt 2.07) To correct the tape advance action and intensity of the printout, adjust the hammer solenoid assembly position.

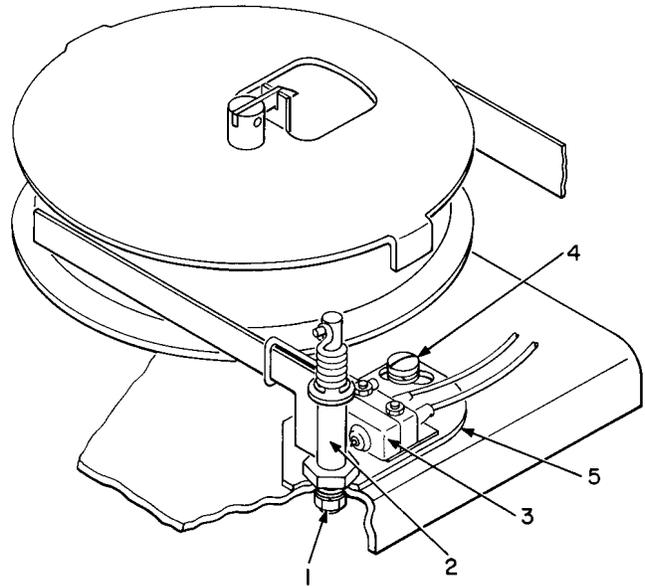
- (1) Loosen the hammer solenoid mounting nuts and manually operate the solenoid by pushing in on the solenoid plunger until the plunger has moved to the limit of its travel.
- (2) Press the solenoid body to hold the plunger securely against its seat (simulating an energized condition). With the solenoid plunger held to its most rearward position and the solenoid body held firmly to the solenoid plunger, tighten the solenoid assembly mounting screws.
- (3) Hold the solenoid plunger in the operated position and loosen the 3/16-inch locknut on the solenoid. Adjust the 1/4-inch adjustment nut to obtain a clearance of 0.100 inch between the solenoid body and the rubber washer next to the 1/4-inch nut. Hold the 1/4-inch nut in place and tighten the 3/16-inch locknut.
- (4) With the tape in the unit, loosen the solenoid mounting nuts and manually hold the print hammer against the print cylinder. Move the entire solenoid assembly to the rear until the clearance between the 1/4-inch adjustment nut and the solenoid bracket is minimum—0.085, maximum—0.090 inches.
- (5) Hold the solenoid assembly in place and tighten the solenoid mounting nuts.
- (6) Manually actuate the solenoid plunger and observe the operation of the advance pawl and the detent spring in their respective notches on the ratchet. The advance pawl should engage one tooth at a time and rotate the tape drum cw a sufficient distance to allow the detent spring to complete the rotation. This action should feed the tape an adequate distance to provide space for printing one character.
- (7) If the detent spring action is not sufficient to feed the tape properly, loosen the detent spring mounting screw and move the spring either forward or to the rear as required to

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correct the tape feed. A notch along the edge of the detent spring is provided to insert a screwdriver to bear against the screw threads and move the detent spring small controlled amounts. When the detent spring is properly adjusted, the teeth on the advance roller appear to be motionless during continuous operation.

3.08 Low Tape Alarm (Reqt. 2.08) Adjustment of the L11 low tape alarm (Fig. 4) is accomplished by using the following procedure:

- (1) Remove the tape cap and tape roll.
- (2) Loosen the hex nut (item 1) on the low tape lever pivot stud (item 2) enough to allow the pivot stud to turn with light pressure.
- (3) Turn hex on the low tape level pivot stud until switch (item 3) actuates.
- (4) Tighten the hex nut.
- (5) Loosen screw (item 4) and position the switch pivot bracket (item 5) so the switch will actuate at the desired position of the low tape lever.
- (6) Tighten screw (item 4).
- (7) Replace tape roll and tape cover.



1. HEX NUT
2. LOW TAPE LEVER PIVOT STUD
3. SWITCH
4. SCREW
5. SWITCH PIVOT BRACKET

Fig. 4—KS-19717 L11 Low Tape Alarm Adjustment