

15 PERFORATOR TRANSMITTER OPERATION AT 100 SPEED REQUIREMENTS AND PROCEDURES

1. GENERAL

1.01 This section outlines special requirements and procedures for 15 perforator transmitters operating at 100 speed. It supplements the following sections, to which reference should be made for complete maintenance of the machine:

P30.002 Distortion Tests

P36.101 List of Units and Auxiliary Features

P36.602 Lubrication

P36.660 Requirements and Procedures

1.02 This section is reissued to:

(a) Add references to related BSP sections.

(b) Make minor editorial changes.

(c) Change the rating from provisional to standard.

1.03 Changes and additions are indicated by marginal arrows.

1.04 Teletype Corporation specification 5510S gives instructions for installing and adjusting the sets of parts to convert a 15 Perforator Transmitter for 100-speed operation. Section P36.101 indicates the codes for the units already equipped with these parts.

2. LUBRICATION

2.01 In addition to the normal lubrication of the 15 perforator transmitter, the following special lubrication should be done for 100-speed operation:

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

(b) Cam-follower hinge (one drop).

3. REQUIREMENTS AND PROCEDURES

3.01 **Short transmitting contact springs** should require a horizontal pressure of Min 4 oz, Max 8 oz, applied directly behind their contacts to move them away from their stiffeners when associated contact levers are on the high part of their cams.

(a) To adjust, bend short contact springs and their stiffeners using the TP72003 tool. If this adjustment is made, check sending contact pressure as specified in P36.660.

3.02 **Lock loop roller** should 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.

3.03 **Cam-Pulsing Contact Assembly TP112570:**

(a) The cam-pulsing contact bracket should be in contact with the head of the lock-loop front pilot screw.

(1) To adjust, reposition bracket. If this adjustment is made check 3.02.

(b) Cam follower should ride centrally (approx.) on the No. 3 transmitting cam throughout a complete revolution of the cam and contacts should be in approximate vertical alignment.

(1) To adjust, loosen contact pile-up mounting-screws and position the assembly.

(c) Short contact springs should clear their stiffener but by not more than .010" measured at the end of the stiffener when the cam follower is on the high part of its cam.

(1) To adjust, bend short contact stiffener.

(d) Contact gaps should be Min .010", Max .020", when cam follower is on the low part of its cam. The long-contact-spring stiffener should clear the cam follower by at least .010" when the cam follower is on the high part of its cam.

(1) To adjust, bend long-contact-spring stiffener. ←

(e) Long contact spring should press against its stiffener by not more than 2 oz, measured by pulling vertically upward at the contacts with the cam follower on the low part of its cam.

(1) To adjust, bend long contact spring.

(f) Contacts should separate when a force of Min 2 oz, Max. 4 oz., is applied vertically upward at the tips of the short contact springs with the cam follower on the high part of its cam. Contacts shall make and break approximately simultaneously when transmitting cam cylinder is rotated.

(1) To adjust, bend short contact springs.