

BELL SYSTEM PRACTICES
Teletypewriter and Data Stations

SECTION P34.418
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AT&TCo Standard

28 MULTIPLE-MOUNTED, MULTICONTACT TRANSMITTER-DISTRIBUTOR SET DISASSEMBLY AND REASSEMBLY ROUTINES

1. GENERAL

1.01 The disassembly procedures presented in this section, together with the general instructions given in the section on general requirements for disassembly of teletypewriter apparatus, will separate the multiple-mounted, multi-contact transmitter-distributor set into its major subassemblies. Teletype Parts Bulletin 1165B shows the complete disassembly of the set and includes illustrations of the parts referred to below.

1.02 This section is reissued to remove reference to the components of the set, which are listed in another section, to revise the instructions for reassembly of the base, and to add instructions for installing speed drive parts.

1.03 For disassembly routines for the transmitter-distributor units, refer to the section on disassembly of the 28G transmitter-distributor unit.

1.04 To reassemble, reverse the disassembly procedures. Where additional information is required, a REASSEMBLY NOTE is added.

2. DISASSEMBLY

2.01 General

(1) Open the hinged front portion of the cover to provide access to each transmitter-distributor and its attached cradle. Lift the cover plate to disengage its detents. Remove the clamp screw that anchors the cradle in its slide, then lift upward and pull forward to disengage the unit.

(2) Lift the cover upward and move toward the front.

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2.02 **Transmitter-Distributor Unit:** To remove the transmitter-distributor unit from the cradle, proceed as follows:

- (1) Remove the two screws and lockwashers which secure the plug connector to the cradle.

REASSEMBLY NOTE

- (a) When the screws are replaced, make sure that the head of each screw is on the outside of the cradle.
- (2) Remove the two screws and lockwashers that secure the casting to the rear projection of the cradle. Remove the screw, lockwasher, and nut that secure the casting to the front projection of the cradle. Note that the bushing is mounted with its hex head on the top side of the casting.
- (3) Remove the screw, lockwasher, and flat washer that secure the tape deflector to the top plate and the screw, lockwasher, and flat washer that secure the right end of the tape-deflector assembly.
- (4) Remove the filler-plate mounting screws.

REASSEMBLY NOTE

- (a) Reassemble in the reverse order, taking care not to damage the cable, cable connector, or switches.

2.03 **Base:** To disassemble the transmitter-distributor base, proceed as follows:

- (1) Remove the motor mounting screws without disturbing the shaft height unnecessarily.
- (2) Disassemble the left end of the countershaft assembly by removing the screw, together with its lockwasher and flat washer, which threads through the hub collar into the side of the shaft. Then remove the screw, together with its associated lockwasher and flat washers, which threads through the hub into the end of the shaft. Remove the three screws and lockwashers in the hub, taking care not to allow the horseshoe retainer to fall off the shaft. When a speed change is to be made install the appropriate gear.

REASSEMBLY NOTE

- (a) Place the horseshoe retainer on the shaft to the right of and adjacent to the left bearing assembly. On the left side of the bearing assembly, place the flat washer. Place the nut plate in the counterbore of the 48-tooth gear. On the other side of the gear place the spacer, the appropriate driven gear, and the hub. Secure this assembly with three screws and lockwashers (fric-

tion tight) and place on the shaft so that the 48-tooth gear is to the right of the driven gear. Tighten the three screws. Next to the hub place the flat washer and secure pile-up of parts with the screw, lockwasher, and flat washer. Secure hub to shaft with screw, lockwasher, and flat washer. This assembly procedure must be followed to insure clamping the inner race of the bearing.

(b) For units that are equipped with a sprocket or gear at either end of the countershaft, loosen the screw at the end of the shaft and loosen the screw that secures the sprocket hub or gear hub to the shaft. Then tighten the screw at the end of the shaft. This will take up the play between the hub, the bearing, and the retainer ring on the shaft. Then retighten the hub mounting screw.

(c) When installing speed drive parts in the field, turn down the hub mounting screw until it is just friction tight. Then tighten the screw at the end of the shaft to take up the play between the hub, the bearing, and the retainer ring on the shaft. Retighten the hub mounting screw.

3. ASSOCIATED BELL SYSTEM PRACTICES

3.01 Other Bell System Practices that may be required in connection with this section are listed in Section P34.001, Alphabetical Index of 28-type Equipment, Bell System Practices, and Associated 28 ASR Station Drawings. ↵

