

DATE 12-12-61SHEET 1 OF 2TMC SPECIFICATION NO. S-675

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CHECKEDTITLE: INSPECTION PROCEDURE FOR BANDSWITCH GEARAPPROVED BPASSEMBLY NO. A-2024I FUNCTION

The function of the bandswitch gear assembly is to position and secure the rotor contacts in proper alignment for specific band operation.

II REQUIRED JIGS AND GAGES

- a) Mounting Jig for Bandswitch Assembly JG-105.
- b) Shaft Alignment Jig JG-101.
- c) Shaft Torque Adaptor JG-103.
- d) Bottom Hub Adaptor JG-104.
- e) Concentricity Check Jig JG-102.
- f) Dial Indicator (.0005 "to .090" range).
- g) Torque Indicator (0 to 30 in lbs.)

III ALIGNMENT CHECK OF BANDSWITCH SHAFT

- a) Secure Bandswitch Gear Assembly NO. A-2024 into position by clamping to mounting jig JG-105.
- b) Insert bandswitch shaft PM-676 into coupling PM-673 and tighten set screw.
- c) Attach test leads with clips, from transformer to solenoid relay.
- d) Insert alignment jig JG-101 into slot on mounting jig JG-105 and position it so as the bandswitch shaft is protruding $\frac{1}{2}$ inches through the alignment hole.
- e) Press and hold the red button in position so as not to lock the bandswitch shaft in place.
- f) By using the coupling, turn the bandswitch shaft two complete revolutions. If the shaft is aligned properly in the horizontal and vertical planes, it will not make contact with the side of the hole in the alignment jig. If contact is made, the shaft is improperly aligned and the assembly must be rejected.

IV TORQUE CHECK OF BANDSWITCH SHAFT

- a) Position Torque adaptor JG-103 in keyway on end of bandswitch shaft.
- b) Attach Torque indicator to adaptor.
- c) Press and hold the red button in position so as not to lock the bandswitch shaft in place.
- d) Turn Torque indicator handle and read gage. If the reading is between 1 in lbs. and 4 in lbs, the unit is acceptable. Any other readings, the unit must be rejected.

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SHEET 2 OF 2

TMC SPECIFICATION NO. S-675

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APPROVED

ASSEMBLY NO. A-2024

V CONCENTRICITY CHECK

- a) The concentricity check jig JG-101 is position onto mounting jig JG-105.
- b) Press and hold the red button in position so as not to lock the bandswitch shaft in place.
- c) Position dial indicator to shaft and adjust it to proper settings.
- d) Turn coupling two revolutions and read gage. The shaft must be concentric within $\pm .020$ ". If out of tolerance, the unit must be rejected.

VI CHECK "PLAY" IN BOTTON HUB

- a) Secure hub adaptor JG-104 to bottom hub PM-591.
- b) Turn coupling until shaft is securely locked into place.
- c) Place dial indicator against hub adaptor, and by turning coupling observe if any movement occurs in bottom hub. This movement is called "Play". The total amount of "Play" must not exceed .050", or the unit must be rejected.

