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### 1. GENERAL

1.01 This section is issued to provide adjustment information for the 32 typing unit, tape punch, and reader covers. The requirements apply to covers for both Keyboard Send-Receive (KSR) and Automatic Send-Receive (ASR) Sets (Figures 1 and 2).

1.02 After completing an adjustment, replace cover and/or any parts that were removed. Check any adjustments affected by the removal of the cover and/or parts.

CAUTION: ELECTRICAL POWER MUST BE REMOVED FROM UNIT BEFORE ANY ADJUSTMENTS ARE MADE.

1.03 In the adjustments covered in this section, location of clearances and position of parts are illustrated by line drawings. Requirements and procedures are set forth in the texts that accompany the line drawings.

1.04 Reference to left, right, front, or rear, etc., consider the cover to be viewed from a position where the lid is up and the nameplate position is facing the viewer.

1.05 Unless specifically stated otherwise, position screws or nuts friction tight to make an adjustment, and tighten them securely once the adjustment has been made.

1.06 Tools needed to perform adjustments are included in TP185830 maintenance tool kit and are listed in Section 570-005-800.

1.07 Check appropriate disassembly and re-assembly section for approved procedure of cover and parts removal.
SECTION 574-176-700TC

Figure 1 - Cover (Keyboard Send-Receive Set)

Figure 2 - Cover (Automatic Keyboard Send-Receive Set)
2. BASIC UNIT

2.01 Call Control Area

(Detail View)

DIAL TO COVER

Requirement
The numbered dial face should be flush to outside surface of cover or bezel, within
1/16 inch below---3/32 inch above and parallel to outside surface of cover or bezel, within
1/16 inch as gauged by eye.

To Adjust
Loosen dial mounting bracket screws and position dial face. Tighten screws.

KNOB TO BEZEL

To Check
Fully seat the TP181824 knob on the power switch.

Requirement
Min some---Max 1/8 inch between the bottom of the knob and the face of the bezel.

To Adjust
Remove the TP181824 knob and the cover (refer to appropriate disassembly and reassembly section). Loosen screws and position bracket. Tighten screws and replace cover and knob. Recheck Requirement.
2.02 Paper Area

Note 1: The following adjustment applies only to typing units with TP181441 switch mounted on the base casting next to the left function shaft clamp.

LOW-PAPER CONTACT OPERATING ARM

(1) Requirement (Preliminary)
   With paper spindle in place
   Min 1/16 inch --- Max 3/16 inch
   between operating arm and spindle.

   To Adjust
   Bend the wire operating arm.

(2) Requirement (Final)
   Switch will operate when predetermined low paper supply is reached.

   To Adjust
   If switch operates when diameter of paper supply roll is too large, bend arm closer to roll. If switch operates when paper supply is too low, bend arm away from roll.

Note 2: The operating arm should pass through the cover slot, free from any contact with the cover.

(Top View)
2.03 Tape Reader Area

Note: The following adjustment applies to tape readers with early design bases.

**READER MOUNTING BRACKET** (Early Design)

Requirement
There should be equal clearance on three sides between top plate and tape reader cover.

To Adjust
With three mounting screws friction tight, position tape reader base. Tighten screws.
2.04 Tape Reader Area (continued)

Note: The following adjustment applies to tape readers with late design bases.

READER MOUNTING BRACKET (Late Design)

(1) Requirement
Top plate to be
   Min flush---Max 0.030 inch
   below cover.

(2) Requirement
   Equal clearance between top plate and tape reader cover on three sides.

To Adjust
With four adjusting screws and locking screw (L) loosened and mounting bracket
lying flat on tape reader base, position tape reader. Run two adjusting screws
(X) up until requirement is approximately met. Tighten locking screw friction
tight. Run two adjusting screws (Y) up until requirement is approximately met.
Refine all four adjusting screws, loosen locking screw if necessary. Tighten
locking screw.

(Top View)

(Left Side View)
2.05 Tape Punch Area

CONTROL PUSHBUTTONS

Requirement
Min 1/2 oz---Max 1-1/2 oz
to push each control pushbutton
down 1/8 inch
as gauged by eye, while
remaining control pushbuttons
remain in their normal upward
positions.

(Left Side View)