

AUG 31 1956

Teletype Corporation
Chicago, Illinois, U. S. A. (NOT FOR PUBLICATION)

Specification 5026S
Issue 8, Page 1
January, 1956

INSTRUCTIONS FOR INSTALLING THE 80483 SET OF PARTS
WHICH CONSIST OF THE 115872 AND 87154 SET OF PARTS
TO CONVERT A MODEL 15 FRICTION FEED PRINTER
TO A SPROCKET FEED PRINTER

1. GENERAL

a. The 80483 set of parts consists of the 115872 set of parts to convert the typing unit from friction feed to sprocket feed and the 87154 set of parts to modify the cover. All necessary parts are supplied in the set of parts with the exception of the sprocket feed platen with rings which should be ordered separately in accordance with parts numbers listed in the Teletype Model 15 Printer Parts Bulletin.

*b. If the unit to be converted is equipped with the old style 74371 ribbon guide, one of the following two guides should be ordered separately:

- 1 - 126955 ribbon guide - new style
- 1 - 74875 ribbon guide - if unit is intended for stencil cutting.

c. The 80483 set of parts consists of:

1-87154 set of parts which consists of:

✓8	2191	Lock Washer	✓1	80395	Paper Guide
✓6	3598	Nut 6-40 Hex.	✓1	80420	Paper Guide
✓2	6746	Screw 6-40 x 5/16 Hex.	✓4	80421	Spacer
✓4	7002	Flat Washer	✓4	80481	Post
✓2	74986	Screw 6-40 x 13/32 Hex.			

*1-115872 set of parts which consists of:

✓6	1163	Screw 4-40 x 3/16 Fil.	✓1	80407	Shaft
✓4	1269	Screw 6-40 x 1/2 Fil.	✓1	80412	Clamp
✓11	2191	Lock Washer	✓2	80413	Pressure Roller
✓4	3598	Nut 6-40 x 5/16 Hex.	✓1	80478	Post
✓2	6746	Screw 6-40 x 5/16 Hex.	✓1	80479	Collar
✓5	7002	Flat Washer	✓2	80488	Post
✓1	74855	Cross Bar	✓1	82012	Spring
✓2	80396	Bracket	✓1	84079	Pressure Lever
✓3	80397	Retarding Rod			Roller - Left
✓1	80400	Bracket	✓1	84081	Pressure Roller
✓1	80401	Spring			Lever - Right
✓1	80402	Screw 4-40 x 15/32 Special	✓1	107137	Shield
✓2	80403	Screw 6-40 Shoulder	✓2	107174	Paper Stripper
✓1	80405	Baffle Plate	✓1	128673	Loading Plate Assembly

d. For part numbers referred to in the following text, see Teletype Model 15 Printer Parts Bulletin.

*Indicates change

Printed in U. S. A.

2. REMOVAL OF FRICTION FEED PARTS

a. Remove the 80466 platen crank from the platen shaft, the cover from the printer, and the type bar carriage from the typing unit.

b. Remove and retain the 74706 or 49345 platen balance spring, the 74704 shift detent spring, the 74361 shift vertical link upper screw, the 74011 line feed vertical link upper shoulder screw, and the 2191 lock washers and 3598 nuts.

c. Remove and discard the 74878 spindle drag spring, two 6746 screws, 2191 lock washers, 7002 washers and the two 74056 retaining plates, four 6800 screws 74283 washers and 34432 washers.

d. Back off the 74252 pilot screws (one on each side) and remove the platen assembly from the typing unit.

e. Remove and discard the left and right 74709 paper straightener lever springs, the two 80724 paper rod levers, the 74476 straightener rod, the two 74732 posts and 2191 lock washers, 74733 studs, and 72509 lock washers.

f. Remove and discard the 74519 paper finger shaft but retain the 3599 nut, 125011 washer and 3640 lock washer. Discard the 74469 and 74770 paper fingers, the two 74613 set screws and 55063 spring.

g. Loosen the 74059 and 74536 screws of the 74454 release cams and 7036 collars respectively. Remove and discard the 74452 release shaft, the two 74454 release cams, and 74059 screws. Remove and retain the 74710 detent lever spring, 7036 collars and two 74536 screws.

h. Remove the 82463 line feed check lever spring and loosen the 6811 screw of the 74561 line feed check post and the 1026 screw of the 74563 line feed check lever and remove the 74559 line feed check shaft. Retain all check mechanism parts.

i. Back off the 74517 or 112699 platen set screws and remove the 74264 platen shaft. Then remove the platen roll and 80945 line feed pawl spring. Remove the 74446 line feed ratchet and the 74447 detent ratchet from the old friction feed platen roll and install them on the new sprocket feed platen roll being used. (Sprocket feed platen roll with rings not included with the 80843 set of parts).

j. Remove and retain the three 8539 screws in each end of the platen assembly and discard the 74339 cross bar and attached parts. Remove and discard the two 74554 spring posts and the two 74473 straightener rod stops and four 1162 screws, 3640 lock washers and 41675 washers. Mount the sprocket feed platen roll in place in the platen assembly and insert the 74264 platen shaft. Remove the 74517 or 112699 set screws from the old platen roll and install them in the new platen, making sure that they are seated in the locating indents in the platen shaft. Discard the old platen roll but retain the 80945 line feed pawl spring.

3. INSTALLATION OF THE 115872 SET OF PARTS ON THE TYPING UNIT (See Parts Bulletin for parts illustration.)

a. Using the 8539 screws, previously removed in paragraph 2j, install the 74855 cross bar in the platen unit assembly. While inserting the 8539 screws, install the 80400 bracket under the rear right-hand screw with the spring eye forward.

b. With the 74855 cross bar installed, remove and discard the 74437 slide bar and in its place install the 128673 loading plate (with slide bar) assembly using the 8543 screws and 2191 lock washers previously mounting the 74437 slide bar.

c. Mount the two 80488 posts in the slots in the 128673 loading plate assembly using two 7002 washers, 2191 lock washers and 3598 nuts.

NOTE: If the platen shaft does not turn freely, loosen the 74448 bushing and the 6970 lock nuts and adjust the bushings by rotating them. Tighten the lock nuts.

d. Replace the 80945 line feed pawl spring and 74710 line feed detent lever spring.

e. Secure the 84079 left pressure roller lever to the 80412 clamp, using the 6746 screw and 2191 lock washer, in such a way that the enlarged portion of the small front end is toward the top when the assembly is on the typing unit. Insert a 6746 screw and 2191 lock washer in the clamping end of the 80412 clamp.

f. Mount the two 80413 pressure rollers against the inner surface of the 84079 left pressure roller lever and the 84081 right pressure roller lever so that the knurled edge is toward the lever, using the two 80403 shoulder screws, 2191 lock washers, and 3598 nuts.

g. Insert the 80407 shaft through its mounting hole, which is the uppermost hole, in the 74031 right platen bracket, and assemble the following parts on the shaft in the order given - the right pressure roller lever assembly (with the hub to the right), the 80479 collar (with the flange to the right), the 80401 spring (with long formed end to the right), the right 107174 paper stripper (in such a position that it will fit into the right hand platen groove) the two 7036 collars and 74536 screws previously removed in paragraph 2g, the left 107174 paper stripper (in such a position that it will fit into the left hand platen groove), the left pressure roller lever assembly (with the tapering end pointing downward and to the front), and insert the shaft in the 74435 left platen bracket. Install the 80402 screw in the 80407 pressure roller shaft with the head of the screw forward. Position the 80407 shaft so that the end of the arm, in which the spring post is mounted, is above and to the front of the stop post in the right platen bracket. The two 7036 collars are used to help locate the paper strippers with relation to the grooves in the platen, and are placed beside each paper stripper, temporarily until the final adjustment of the mechanism locates them permanently.

h. Lock the 80407 shaft in place using the 125011 washer, 3640 lock washer, and 3599 nut previously removed from the 74519 shaft.

i. Position the parts on the 80407 shaft, as shown in the parts bulletin. Install the 80478 spring post in the 80479 collar. Hook the short end of the 80401 spring over the spring post in the 80479 collar and the long end over the stud on the right side of the 84081 right pressure roller lever.

j. Hook the 82012 spring in place between the 80407 shaft arm and the 80400 bracket.

k. Replace the platen assembly on the typing unit and adjust the 74252 pilot screws, previously loosened in paragraph 2c, in accordance with Model 15 printer adjustment bulletin.

l. Connect the line feed and shift vertical links, using the screws, nuts and lock washers previously removed in paragraph 2b. Replace the 74706 or 49345 platen balance spring and 74704 shift detent spring.

m. Replace the line feed check mechanism previously removed in paragraph 2h and recheck the complete line feed adjustments in accordance with Model 15 printer adjustment bulletin.

n. On units equipped with the old style 74371 ribbon guide, replace it with the 126955 guide on the type bar carriage; replace the carriage on the typing unit.

NOTE: If stencils are to be cut on the typing unit, a 74875 ribbon guide is used in place of the 126955 guide.

o. Mount the two 80396 side brackets on top of the rear extensions of the typing unit side frames by using four 1269 screws and four 2191 lock washers. (Do not tighten the screws).

p. Assemble the two outer 80397 retarding rods in place. Make sure that the side brackets are parallel to the side frames and to each other and that the front end of the left bracket does not interfere with the 74058 platen shift detent lever. Tighten the four 1269 bracket mounting screws.

q. Snap the 80405 baffle plate into place over the front and rear 80397 retarding rods. Then install the center 80397 retarding rod. Before tightening the six 1163 set screws, make sure that the ends of the rods do not extend beyond the left side bracket.

r. Remove the two 1161 screws and two 2191 lock washers which mount the 74414 type bar guide. Place the 107137 shield in front of the type bar guide and replace the two screws and two lock washers.

4. INSTALLATION OF THE 87154 SET OF PARTS ON THE COVER (See Parts Bulletin for Parts Illustration).

a. Install the 87154 set of parts on the rear of the cover as follows:

(1) Remove and discard 74825** slot covering strip, the two 80985 mounting screws, 110435 nuts and 80986 lock washers from the rear of the cover.

NOTE: The double Asterisk (**) designates a paint finish part.

(2) Mount the 80420 paper guide to the cover by means of the two 6746 screws and 2191 lock washers, the screws being threaded into the two tapped holes in the pad retainer channel located on the rear of the cover just below the form slot. Use two 80421 spacers between the 80420 paper guide and the pad retainer channel.

(3) Install the four 80481 paper guide posts in the four slots in the 80420 paper guide, using the 7002 washers, 2191 lock washers and 3598 nuts.

(4) The 80395 paper guide strip should be then installed at the bottom of the 80420 paper guide, using two 74986 screws, 2191 lock washers and 3598 nuts. Two 80421 spacers are used between the 80395 paper guide strip and the 80420 paper guide.

(5) Place the cover on the printer. If multiple copy forms are to be used, align the sprocket holes in the first of a length of the forms and place a paper clip over the leading edge to hold the forms in alignment. Insert the forms in the machine by threading the leading edge between the surface of the paper guide and the guide strip, thence through the slot in the cover under the center retarding rod on the typing unit and over the surface of the loading plate under the platen. With the leading edge of the forms resting against the ribbon guide and with the pressure roller in their extreme raised position, press the forms to the platen near the ribbon guide and turn the platen crank to carry the edge of the forms past the ribbon guide. Set the forms on the sprocket pins, being sure that the pins are in their proper holes so that the paper is straight, and lower the pressure rollers to hold the forms in place. Then take up the slack in the forms by grasping them just below the paper guide and pulling them straight down. The two guide posts on the loading plate to the rear of the platen should be adjusted so that they just clear the sides of the paper when it is straight and taut. The four guide posts on the paper guide should be similarly adjusted.

5. ADJUSTMENTS

a. After the foregoing installations have been completed, adjust in accordance with Teletype Model 15 Printer adjustment bulletin.

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