

INSTRUCTIONS FOR INSTALLING THE 183877 THROUGH 183883
 MODIFICATION KITS ON MODEL 32, 33, AND 38 SPROCKET FEED
 PRINTERS TO EQUIP THE FORM-OUT FOR VARIOUS LENGTHS OF
 FORMS

1. GENERAL

a. The 183877 through 183883 modification kits provide the gear set and cam lobes to equip Model 32, 33, and 38 Sprocket Feed Printers form-out for length of form desired.

b. The kits consist of:

	<u>183877</u>	<u>183878</u>	<u>183879</u>	<u>183880</u>	<u>183881</u>	<u>183882</u>	<u>183883</u>
110743 Lockwasher	2	2	2	2	1	2	
125011 Flat Washer	2	2	2	2	1	2	
162886 Screw	2	2	2	2	1	2	
187096 Cam Plate	2	2	2	2	1	2	
183391 Gear w/Gear	1						
183392 Gear w/Gear		1					
183393 Gear w/Gear			1				
183394 Gear w/Gear				1			
183395 Gear w/Gear					1		
183396 Gear w/Gear						1	
183397 Gear w/Gear							1
183398 Spur Gear	1						
183399 Spur Gear		1					
183400 Spur Gear			1				
183401 Spur Gear				1			
183402 Spur Gear					1		
183403 Spur Gear						1	
183404 Spur Gear							1

c. For parts ordering information refer to Section 574-172-800TC for Model 32, Section 574-122-800 or 574-122-800TC for Model 33, and Section 574-422-800TC for Model 38.

2. INSTALLATION

a. See Figure 1 to determine location of parts that are to be removed.

b. Remove 128357 retainer ring and pull off 183384 disc to which a spur gear is secured by (2) screws.

c. Remove 119651 ring retainer and pull off the gear w/gear.

d. See Figure 2 to determine what modification kit number to use and the appropriate number of 187096 cam plates to be used for the length of form desired.

e. The gear w/gear found in the modification kit is pushed on and the 119651 ring retainer is snapped into place.

f. Spur gear found in modification kit is put in place of spur gear mounted to 183384 disc. Install this assembly and snap the 128357 retainer ring into place.

g. Required number of 187096 cam plates put in proper places and secured as shown on Figures 4 and 5.

3. ADJUSTMENTS AND LUBRICATION

a. The standard adjustments and lubrication procedure for related equipment are to be found in the following list of sections:

<u>Model Number</u>	<u>Adjustment Section</u>	<u>Lubrication Section</u>
32	574-172-700TC	574-172-701TC
33	574-122-700 574-122-700TC	574-122-701 574-122-701TC
38	574-422-700TC	574-422-701TC

b. Make the adjustments and lubrication shown on attached Figures 3 to 6 as necessary.

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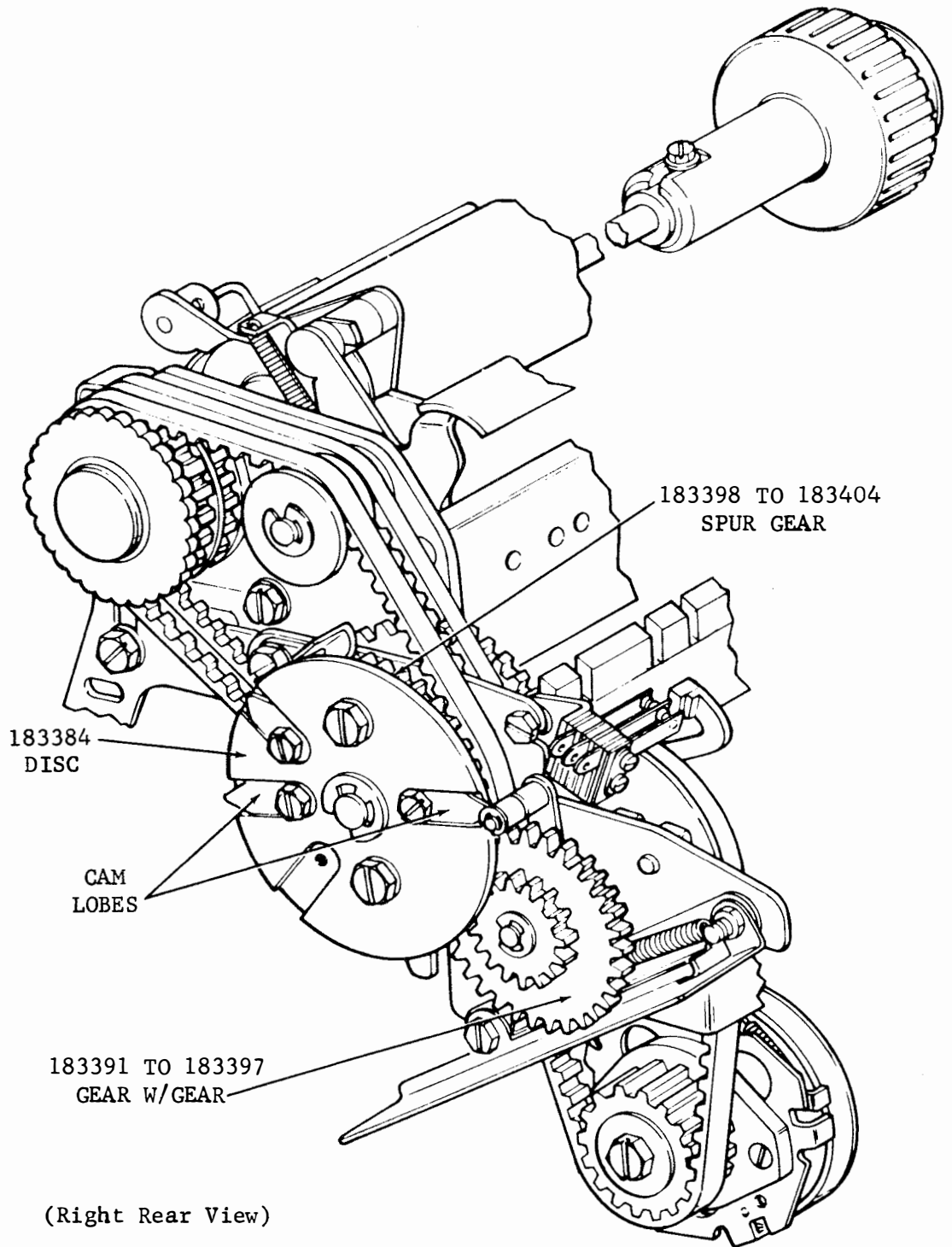
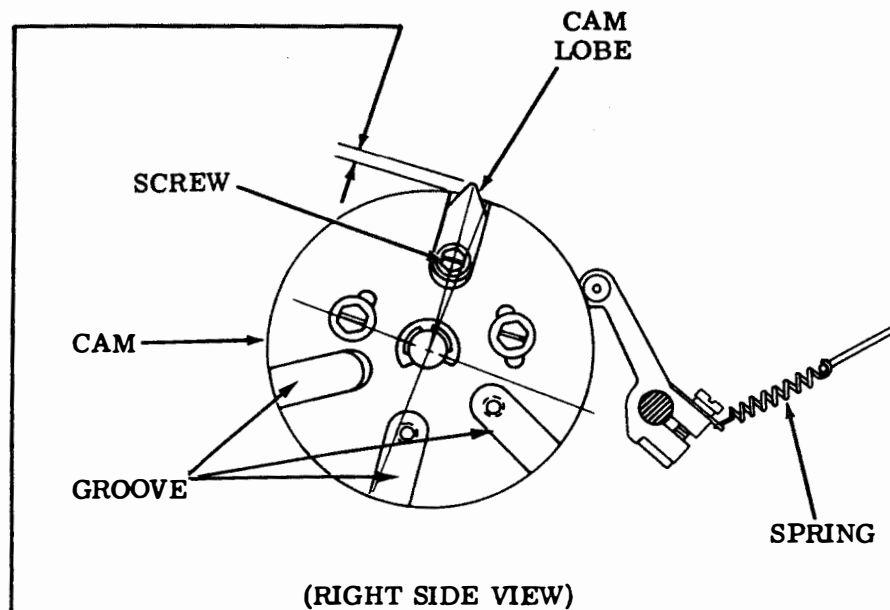


FIGURE 1 - Form Out Mechanism

FORM LENGTH IN INCHES			MOD. KIT	GEAR W/GEAR	GEAR, SPUR
QUANTITY OF CAM PLATES USED					
1	2	3			
11	5-1/2	3-2/3	183877	183391	183398
9	4-1/2	3	183878	183392	183399
7	3-1/2	2-1/3	183879	183393	183400
8	4	2-2/3	183880	183394	183401
8-1/2	NOT USED	2-5/6	183881	183395	183402
10	5	3-1/3	183882	183396	183403
6	NOT USED	NOT USED	183883	183397	183404

FIGURE 2



CAM LOBE

Note: Cam lobes, in addition to the one opposite the three closely spaced grooves, shall be adjusted according to the RESET adjustment.

Requirement

The top of the cam lobe shall be
 Min 0.050 inch---Max 0.055 inch
 above the low point of the cam.

To Adjust

With screw loosened, position the cam lobe.

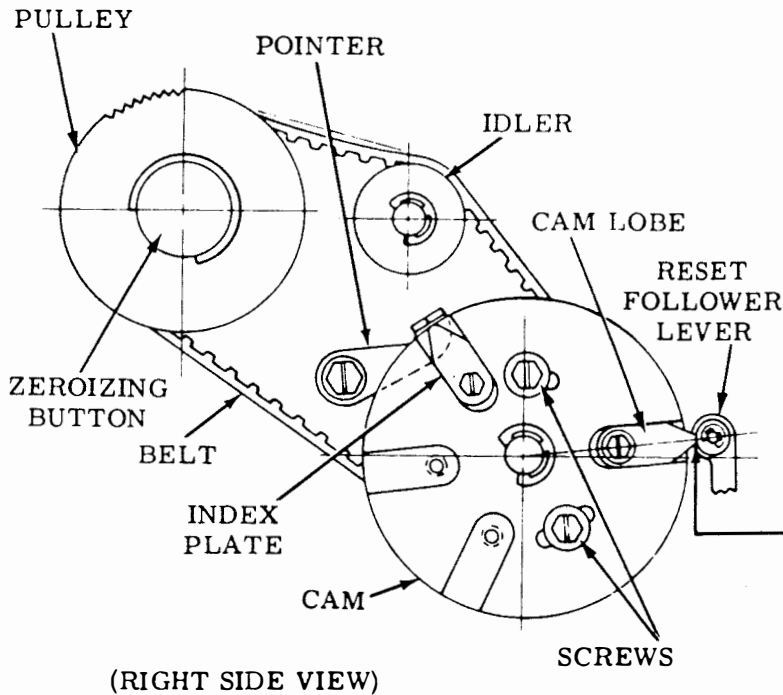
Related Adjustment

Affects

RESET (Platen Drive Area)

FIGURE 3

Platen Drive Area



RESET CAM LOBE LINE-UP

To Check

With typing unit under power, depress the form-out keytop to initiate a form-out cycle.

Requirement

At the end of a form-out cycle, the reset follower lever shall come to rest on the high point of the cam lobe.

To Adjust

With screws loosened, adjust cam.

Related Adjustments

Affects

CAM ZERO POSITION (Platen Drive Area)

Affected By

FORM-OUT BELT TENSION (Platen Drive Area)

IDLER (Platen Drive Area)

CAM ZERO POSITION

To Check

With cam lobes and index plates located on cam as shown on line drawings associated with this adjustment, place typing unit in stop condition.

Note: Reset follower lever must rest on proper cam lobe to "zero" a sprocket form. Place it in such position by depressing zeroizing button and rotating pulley until reset follower lever rests on cam lobe opposite three closely spaced grooves (on cam) facing toward the front of typing unit.

Requirement

One cam lobe:

- (1) With reset follower lever on high point of cam lobe and zeroizing button in its most right position
Min 0.025 inch---Max 0.035 inch---
between bottom surface of pointer and low part of cam.
- (2) With one's line-of-sight in line with the aluminumized surface of index plate and center of cam shaft, tip of pointer shall fall within aluminumized surface on plate.

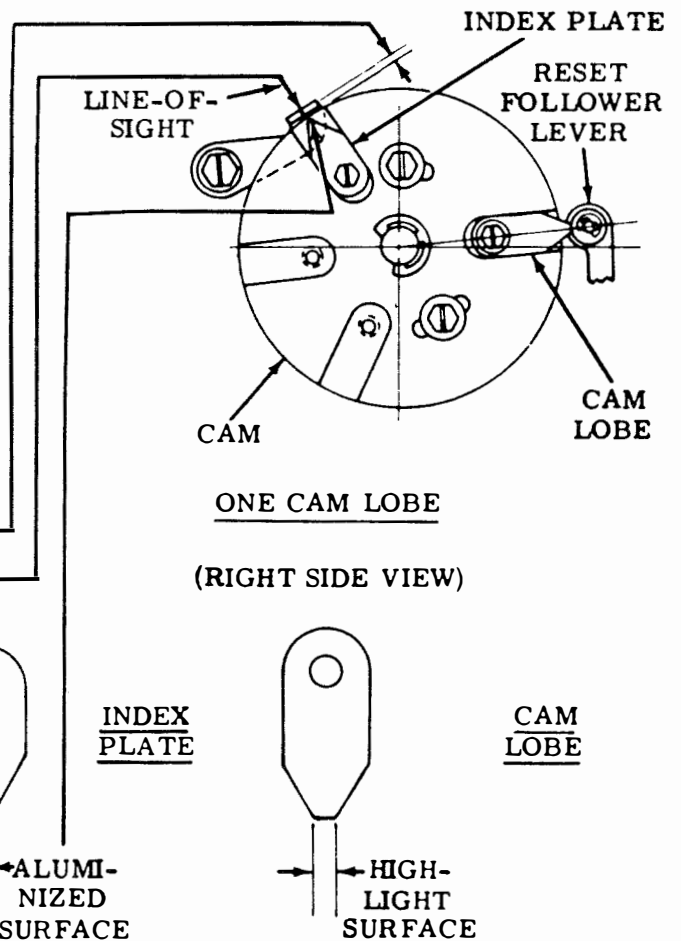


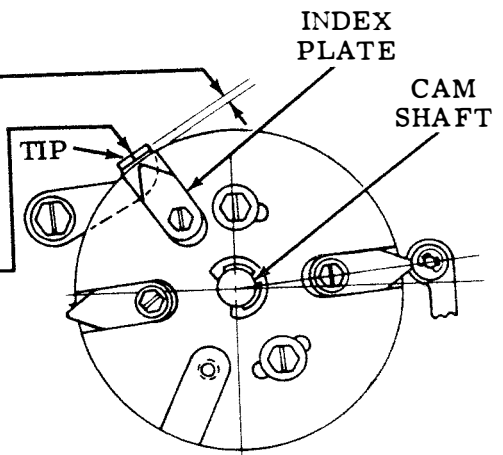
FIGURE 4

Platen Drive Area

CAM ZERO POSITION (Continued)

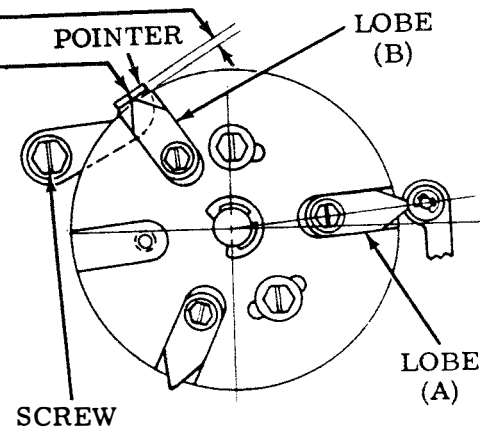
Two cam lobes:

- (1) With reset follower lever on high point of cam lobe and zeroizing button in its most right position
Min 0.025 inch---Max 0.035 inch
between bottom surface of pointer and low part of cam.
- (2) With one's line-of-sight in line with the aluminized surface of index plate and center of cam shaft, tip of pointer shall fall within aluminized surface on plate.

TWO CAM LOBES

Three cam lobes:

- (1) With reset follower lever on high point of cam lobe (A) and zeroizing button in its most right position
Min 0.025 inch---Max 0.035 inch
between bottom surface of pointer and low part of cam.
- (2) With one's line-of-sight in line with the highlight surface of cam lobe (B) and center of cam shaft, tip of pointer shall fall within highlight surface on lobe (B).

THREE CAM LOBES

(RIGHT SIDE VIEWS)

To Adjust

With screw loosened, position pointer.

Related Adjustments

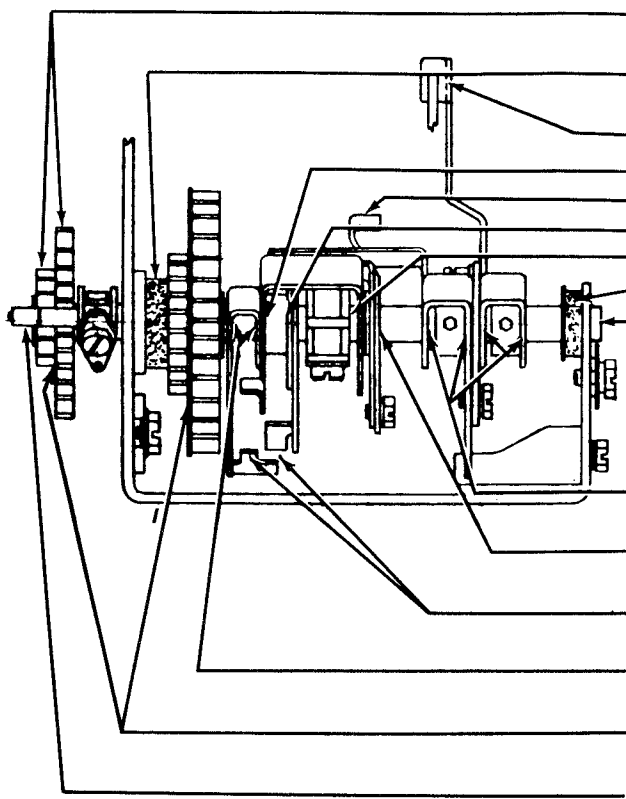
Affected By

FORM-OUT BELT TENSION (Platen Drive Area)IDLER (Platen Drive Area)PLATEN-HORIZONTAL (Paper Feed Area*)PLATEN-VERTICAL (Paper Feed Area*)RESET CAM LOBE LINE-UP (Platen Drive Area)

*Sprocket Feed Mechanisms

FIGURE 5

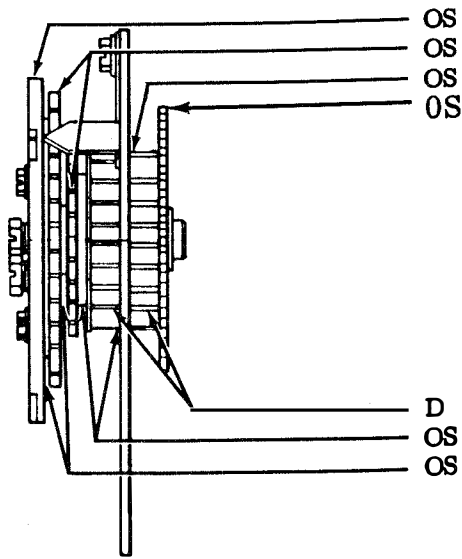
Form-Out Mechanism



- | | | |
|------|---------------------|-----------|
| OS | Surface | Gear |
| OSAT | Felt Washer | Shaft |
| OS | Engaging Surface | Bail |
| OS | Bearing | Bail |
| OS | Engaging Surface | Arm Latch |
| OS | Bearing Lever | Stop |
| OS | Bearing | Bail |
| OSAT | Felt Washer | Shaft |
| OSL | Bearing (Both Ends) | Bracket |
| OS | Bearing | Bail |
| OS | Bearing | Arm |
| OSL | Engaging Surface | Arm |
| OSL | Bearing | Bail |
| OS | Bearing | Gear |
| OS | Bearing | Lever |

(TOP VIEW)

Cam, Pulley, and Gear Combination



- | | | |
|----|--------------|-----------------|
| OS | Cam Surface | Cam Gear |
| OS | Gear Surface | Cam Gear |
| OS | Bearing | Gear and Pulley |
| OS | Gear Surface | Gear and Pulley |
| D | Surface | Pulley |
| OS | Bearing | Gear and Pulley |
| OS | Bearing | Cam Gear |

(TOP VIEW)

FIGURE 6