

**INSTRUCTIONS FOR INSTALLING THE 182056 MODIFICATION
KIT TO CONVERT MODEL 33 TYPING UNIT TO 12 SPACES
PER INCH**

1. GENERAL

a. The 182056 modification kit converts a Model 33 Typing Unit to twelve characters per inch horizontal spacing.

b. A typing unit equipped with this kit is capable of 83, 86, or 89 spacing characters per line.

c. The 182056 kit consists of:

2	49054	Screw	1	181956	Drum, Spacing
1	181954	Typewheel	1	181957	Belt, Spacing
1	181955	Washer, Pulley			

d. For parts ordering information, other than the parts in the kit, see Teletype Bulletin 1184B.

2. INSTALLATION (Figure 1)

NOTE

For the disassembly and reassembly of major components refer to Teletype Bulletin 273B.

a. Remove the printer cover and assembly from its subbase in accordance with standard procedure.

b. The following steps apply to the printing carriage assembly:

(1) Loosen (2) 152893 screws and lift off the ribbon feed mechanism.

NOTE

When reassembling this mechanism to the carriage, be certain that 180489 lever w/pin mounted on the carriage casting is in front of the tab on 181114 lever.

(2) Remove the typewheel and discard. Replace with the new typewheel and reassemble.

(3) With the printing carriage at the left-hand margin, unhook and remove 181323 carriage return spring.

(4) Set up the "G" combination in the selector (1, 2, 3, 7, 8 marking).

(5) Rotate the main shaft until the right rack is in its most forward position.

(6) Remove (1) right-hand 119649 retaining ring from 180528 lever w/hub and post and then slide off 180471 block and 180491 shaft.

(7) Push 180528 lever w/hub and post rearward until the tab on the right side of 180480 arm w/post pops above the right-hand rack. Release and allow 180480 arm to return to its most forward position.

(8) Remove 119649 retaining ring from 180480 arm w/post located just below the front of the left-hand rack.

(9) Pull 180480 arm w/post forward, lift upward, and rotate as far forward as possible.

(10) Line up the fronts of the right and left racks.

(11) Loosen 181243 screw from 180498 clamp bracket which fastens the spacing belt to the carriage casting.

c. At the upper right-hand side of the base casting, loosen (2) 180798 screws holding 181072 bracket w/stud. Rotate the bracket and remove.

d. At the upper left-hand side of the base casting, loosen (2) 180798 screws holding 181084 bracket. Rotate this bracket and remove.

e. Lift up on 181075 spacing belt and remove from the unit.

f. Remove 181092 bracket and 181093 extension from the spacing belt. Discard the belt.

g. Push carriage assembly to the right-hand margin.

h. Pull the left end of 181319 lever forward away from 181077 ratchet. While holding 181319 lever in this position, slip a small screwdriver between 181314 link w/post and the base casting to keep the spacing and check pawls away from the ratchet while replacing the spacing drum. (See Figure 1)

- i. Unhook 4703 spring from 181320 lever w/hub.
- j. Remove 112626 nut from 181066 shaft. Remove shaft and the 181069 spacing drum from unit.
- k. Remove 119653 retaining ring from 181066 shaft and slip off spacing drum.
- l. Remove (2) 153817 screws holding 181077 ratchet to spacing drum. Discard spacing drum.
- m. Assemble 181077 ratchet to the 181956 spacing drum with the screws and washers removed in the previous step.
- n. Assemble 181955 pulley washer to 181956 spacing drum with (2) 49054 flat head screws.
- o. Slip the spacing drum assembly onto 181066 shaft, replace 119653 retaining ring, and install into the unit.

NOTE

Be certain the 181312 latch w/hub located just below the spacing drum is hooked up to 181320 lever w/hub.

- p. Hook 4703 spring to 181320 lever w/hub.
- q. Slip 180498 clamp bracket onto 181957 spacing belt. Clamp belt to the carriage casting.

NOTE

The bars on the clamp should be in the grooves of the belt.

- r. Reverse the procedure outlined in Paragraphs 2. d. , 2. c. , 2. b. (10), 2. b. (6), 2. b. (3), and 2. b. (1).
- s. Assemble 181092 bracket and 181093 extension to the spacing belt in the approximate location.
- t. Perform the required adjustments and lubrication. (See Section 3).
- u. Reverse the procedure outlined in Paragraph 2. a.

3. ADJUSTMENTS AND LUBRICATION

a. For standard adjustments and lubrication procedure see Teletype Bulletin 273B (Bell System refer to the standardized information). Make the following adjustments.

b. Spacing Belt Tension (Spacing Area): Same as adjustment given in Bulletin 273B except change minimum requirement from "9/16" to "5/8".

c. Left Margin Spacing (Preliminary):

Place carriage at left margin, set up any printing character in the selector, and rotate main shaft until carriage drive bail is in its rearmost position.

Requirement 1

The check pawl shall overlap the ratchet as shown in Figure 2.

To Adjust

With clamp screws loosened, rotate ratchet until this condition has been met.

Requirement 2

There shall be 0.030" to 0.040" clearance between the feed pawl and ratchet tooth as shown in Figure 2.

To Adjust

Position the drive roller on the carriage drive bail with clamp nut loosened.

d. Left Margin Printing (Spacing Area) (Final): See Bulletin 273B.

e. Drive Roller (Spacing Area) (Final): See Bulletin 273B.

f. Line Length (Function and Spacing Area): Same as adjustment given in Bulletin 273B except change the character line length from "69" to "83", "71" to "85", "72" to "86", and "74" to "89" wherever these numbers appear.

NOTE

If an 89 character line is desired, it is necessary that there be no 180744 collar clamped on the right end of the 180645 shaft. If this collar is present, the only way it can be eliminated is to purchase the new style 180645 shaft and 181084 bracket. The new style parts make the use of 180744 unnecessary.

g. Typewheel (Carriage): See Bulletin 273B.

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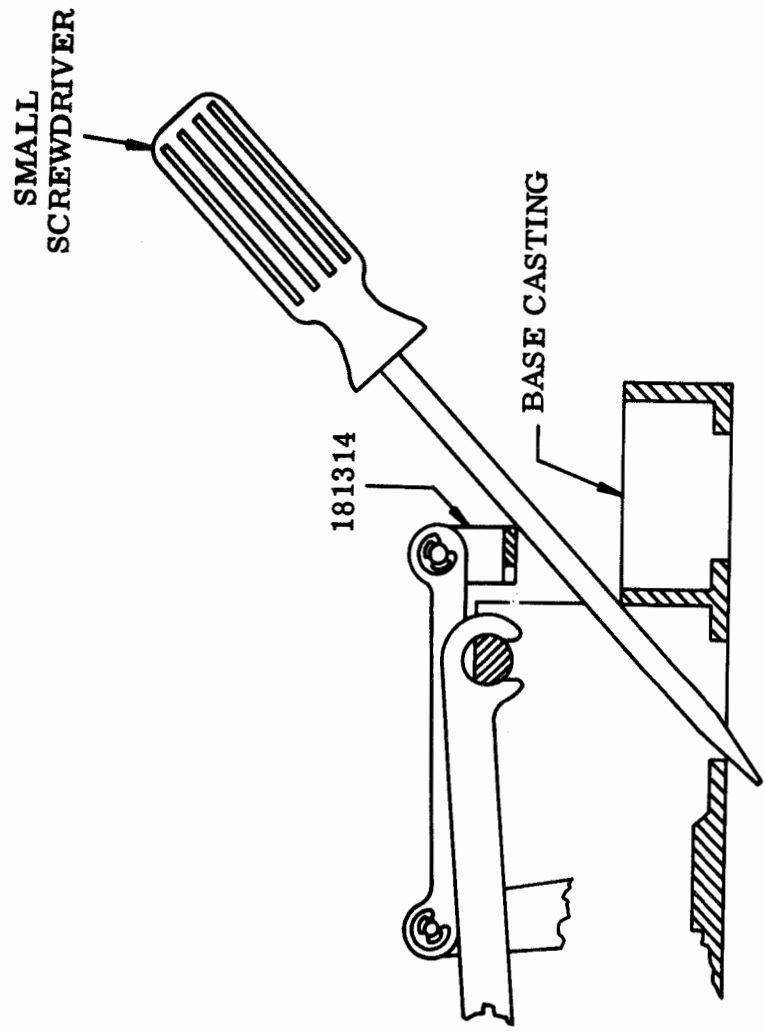
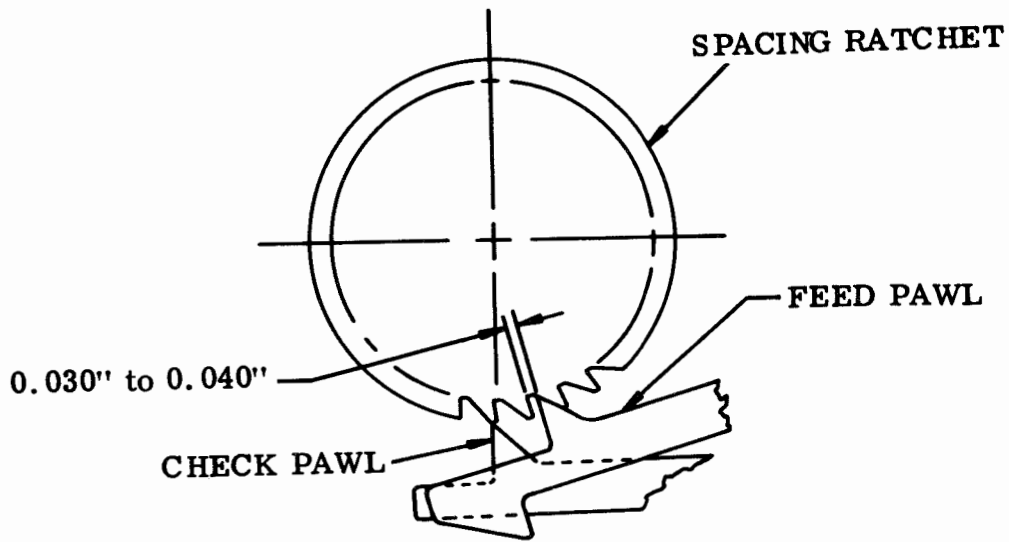


FIGURE 1

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LEFT MARGIN SPACING (PRELIMINARY)

FIGURE 2