

BELL SYSTEM PRACTICES
Teletypewriter and Manual
Telegraph Station and PBX
Installation and Maintenance

SECTION P31.450
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AT&T Co Standard

USE AND MAINTENANCE OF 1A TAPE SPLICER

1. GENERAL

1.01 This section furnishes information concerning the 1A Tape Splicer for splicing chadless tape such as is used with certain teletypewriter automatic sending equipment. Instructions on the use and maintenance of the splicer are included in this section.

1.02 This section is reissued to make some minor corrections, to include adjusting information and to make reference to the Parts Bulletin 1134. ←

1.03 The 1A Tape Splicer provides for joining the ends of two pieces of chadless tape by pushing the partial perforations of one tape through the openings in the other so that transmission from the tapes may take place in automatic transmitters without interruption. The splicer consists primarily of a platform (tape guide plate) on which the ends of the tapes to be spliced are placed and a moving arm and pin arrangement for interlocking the partial perforations of the two ends. ←

1.04 The splicer is provided with cushion feet so that it may be rested on a teletypewriter table or other surface without marring the finish. Where the splicer is to be permanently used in one location, it may be fastened to the surface by means of screws. Where the splicer is to be used at more than one location or where it is not desired to permanently fasten it, a cast iron base with a black wrinkle finish is available to which the splicer may be attached in order to provide greater stability. This base has been given the catalog designation "103074M Base" and it includes machine screws for attaching the splicer to it. ←

1.05 The over-all dimensions of the splicer are 6-1/2" deep by 3-1/2" wide by 4" high without the base. When the base is attached the dimensions become 7-1/4" by 4" by 4-1/2". ←

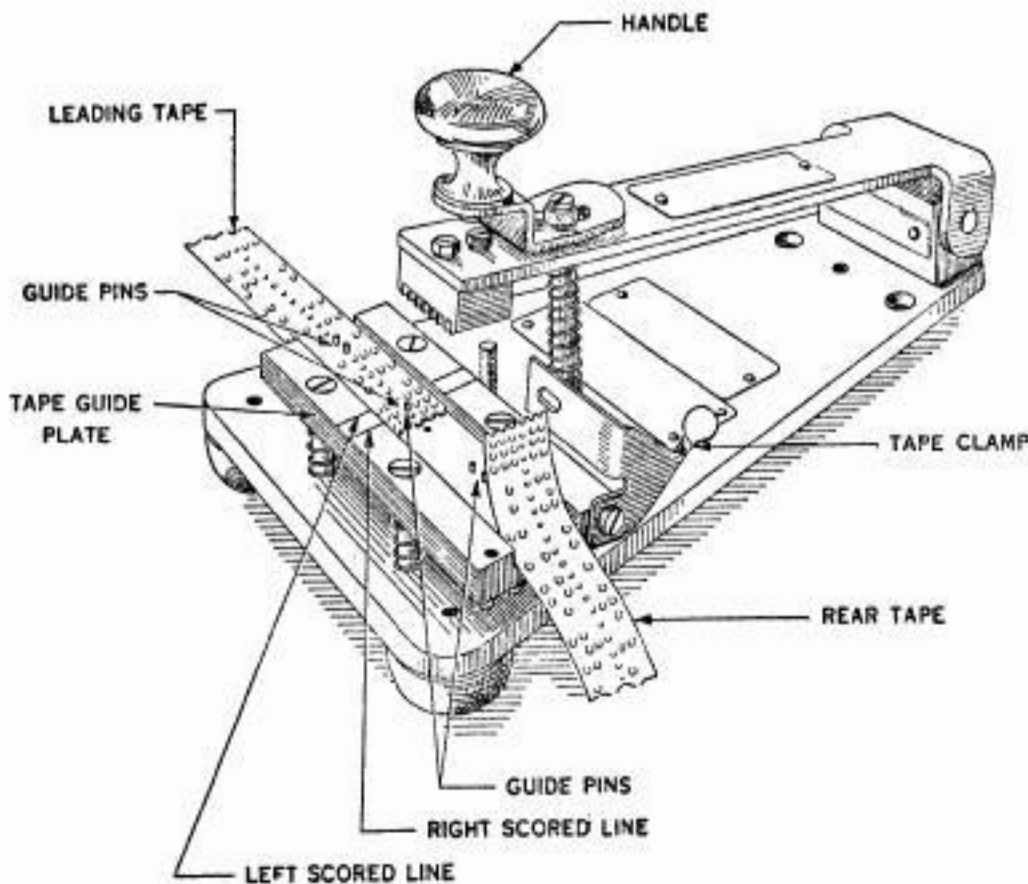
2. METHOD OF OPERATION OF SPLICER

2.01 The end of the tape to which a splice is to be made should be perforated with at least three "letters" signals and the tape to be attached should begin with at least three

“letters” signals. Splicing is accomplished by pushing three rows of partial perforations (chad lids) of one piece of tape through the openings in the other piece. Splicing should only be done on “letters” signals in the tape in order to avoid errors in transmitting and to obtain maximum interlocking of the tapes and greater strength. The tapes to be spliced should have square ends which may be obtained by creasing the tape through a row of “letters” perforations and tearing along the crease.

2.02 To splice the tape proceed as follows:

- (a) Place the rear end of the LEADING TAPE in the left side of the GUIDE so that the last LETTERS code is in alignment with the right SCORED LINE. The tape should be placed in the SPLICER so that its feed holes engage the GUIDE PINS. Press the tape down.
- (b) Place the front end of the REAR TAPE in the right side of the GUIDE so that the first LETTERS code is in alignment with the left SCORED LINE. The tape should be placed in the splicer so that its feed holes engage the GUIDE PINS. Press the tape down. After the tapes have been properly placed, the REAR TAPE will overlap the LEADING TAPE by three LETTERS codes. Lower the TAPE CLAMP to hold the tape in place while splicing.
- (c) Press down the operating handle until it hits the stop.
- (d) Raise the TAPE CLAMP and lift the tape from the SPLICER.



3. LUBRICATION

- 3.01 Apply a single drop of KS-7470 oil at the following bearing points and pivots:
- Ends of operating handle shaft.
 - Four tape guide plate shoulder screws.
 - Tape splicing pins.
 - Ends of all coil springs.
 - Shoulder screw pivot for tape clamp.
 - Detent spring surface contacting tape clamp.
- 3.02 After the parts are lubricated remove any excess oil, especially any oil on the tape guide plate.

4. MAINTENANCE

4.01 The end of the **stop screw** shall clear the operating handle by min. .030" max. .040" with the operating handle depressed until the upper jaw just touches the tape guide plate. To adjust, reposition the stop screw.

4.02 The pivot block shall be positioned so that the operating handle does not rub or bind on the sides of the spring post. To adjust, reposition the pivot block by means of its mounting screws.

4.03 The **upper jaw** shall not bind on the rear of the tape guide channel and its fins shall clear all the punches. To adjust, reposition the upper jaw by means of its mounting screws.

Note: Further adjustment is possible by repositioning the pivot block. If this is necessary, recheck Par. 4.02.

4.04 The clamping surface of the **tape clamp** shall be parallel to and in contact with the tape guide plate. Clearance between any part of the clamping surface and the tape guide plate shall not exceed .010". Also, the edges of the clamp shall be parallel to the channel in the tape guide plate. To adjust, bend the tape clamp.

4.05 The 99221M spring post requires no adjustment.

4.06 Piece part information is given in Teletype Bulletin 1134. It should be noted that no part numbers are given for the punch pins since they form an integral part of the 99215M base into which they are inserted with a press fit. If the punches require replacement the splicer should be returned to the Western Electric Company for repair.