

20 TYPING UNIT
REQUIREMENTS AND ADJUSTMENTS

1. GENERAL

1.01 This section is limited to requirements and adjustments peculiar to the 20 typing unit, and to modifications of the section covering the 15 typing unit requirements and adjustments to make that section applicable to the 20 typing unit. This section, sections referred to in this section, and the section covering teletypewriter general requirements and adjustments provide the information for the maintenance of the 20 typing unit.

1.02 This section is reissued to:

- (a) Change paragraph numbers to coordinate with the section covering the 15 typing unit requirements and adjustments.
- (b) Refer to the section covering 15 teletypewriter (auxiliary features) requirements and adjustments and remove information on the two-color printing mechanism from this section.

1.03 Table A shows the relationships of the selecting cam, levers, vanes, etc for the 20 typing unit, as viewed from the front of the unit in its normal position.

1.04 Where LTRS and FIGS are mentioned in 572-202-700 they should be read as UN-SHIFT and SHIFT, respectively.

1.05 Wherever the letters R or RY are referred to, 4 or 4y (y lower case), respectively, should be used.

2. REQUIREMENTS AND ADJUSTMENTS

Note 1: The following paragraphs, numbered to fit into the outline of 572-202-700, give additions and changes for 572-202-700 which are required to make the requirements and adjustments of that section applicable to the 20 typing unit.

TABLE A

Sequence of Code Selection	Cam Peaks	Selector Levers	Swords	T Levers	Vanes	Bell Cranks	Code Bars
1	1 (Second from left)	1 (Second from left)	1 (Second from left)	1 (Second from left)	1 (Top)	1 (Short-est)	1 (Front)
2	2	2	2	2	2	2	2
3	3	3	3	3	3	3	3
4	4	4	4	4	4	4	4
5	5	5	5	5	5	5	5
	(Extreme right)	(Extreme right)	(Extreme right)	(Extreme right)			
0	0	0	0	0	6	6	6
	(Extreme left - first in pile-up)	(Extreme left - first in pile-up)	(Extreme left - first in pile-up)	(Extreme left - first in pile-up)	(Bottom)	(Long-est)	(Rear)

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Note 2: For the requirements and adjustments of the two-color printing mechanism, refer to the section covering 15 teletypewriter (auxiliary features) requirements and adjustments.

*2.31 (Replaces) Right and Left Pullbar Spring-Bracket: With the pullbar bail in its extreme rear position the end pullbar and the eighth pullbar should have a slight amount of play, not more than 0.004 inch, between the typebar and the bracket when the typebar is in the guide. See Figure 19.

To Adjust: Position the right and left pullbar spring-brackets.

Note: If the second, third, fourth, fifth, sixth, or seventh pullbar binds against the bracket when its respective typebar is moved to the typebar guide by hand, readjust the bracket so that all eight pullbars are free and so that the end pullbar and at least one of the other seven pullbars have not more than 0.004 inch of play between the typebars and the bracket when their respective typebars are in the typebar guide.

*2.45 (Omit) Sixth-vane extension spring.

*2.47 (Omit) Sixth-vane.

*2.56 (Replaces) Printing and Spacing Cut-out Function-lever Spring: Rotate the main-shaft until the printing bail is in its extreme rear position. Then unhook the function-lever spring from the spring-plate. Hook the scale in the spring eye. It should require minimum 22 ounces, maximum 30 ounces to stretch the spring to its position length.

Note: The above spring tension applies to all function levers, regardless of their location in the typing unit, which block printing and spacing but perform no other function.

*2.58 (Omit) Unshift-on-space cut-out lever.

*2.63 (Omit) Sixth-vane extension.

*2.71 (Replaces) Line-feed Detent-lever Spring: With the typing unit resting in its normal upright position, hook the scale over the end of the detent-lever and pull in line with the spring. It should require minimum 2-1/2 pounds, maximum 3-1/2 pounds to start the detent-lever moving.

*2.73 (Replaces) Line-feed Check-screw Head should enter the 15th notch ahead of the one in which the detent-roller rests and the top of the screw-head should clear the face of the tooth by not more than 0.020 inch, when the check screw is held in the bottom of the notch. Check the adjustment on at least four ratchet teeth located 90 degrees apart. See Figure 34.

To Adjust: Reposition line-feed check-screw. On old-style line-feed check-screws with a slotted head and flat sides, the flat sides should be vertical and the adjustment made by turning the screw in or out 1/2 turn at a time. If necessary, the line-feed check-post stop-screw may be backed off when making this adjustment.

*2.117 (Omit) Sixth-vane-detent spring.

*2.134 [Replaces last two lines in(a)] last character desired on the line is partially over-printed by the next character.

*2.135 (Omit) Ribbon-oscillator lever.

*2.139 (Replaces) Margin Bell: Loosen the margin-bell-cam thumb-screw and adjust the cam so that it is approximately 1/16 inch from the right side-frame. Tighten the thumb-screw. See Figure 41.

*Refers to paragraphs in Plant Series Section 572-202-700.