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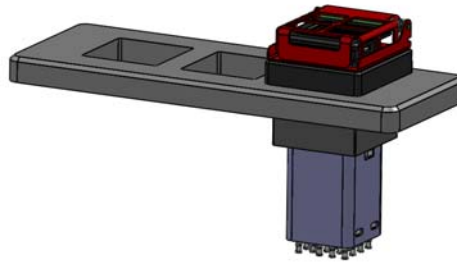
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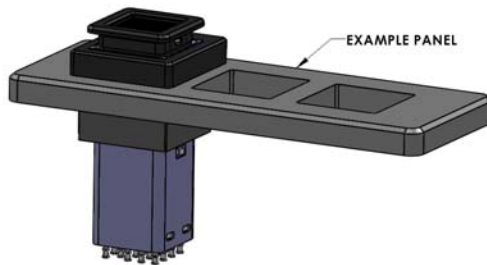
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## TECHNICAL BULLETIN – TB-203

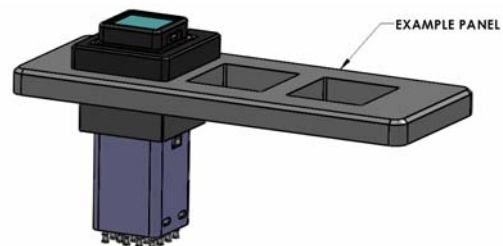
# TECHNICAL BULLETIN, SERIES 100 SWITCH, AVIONICA INSTALLATION INSTRUCTIONS FOR 730110-TAB ASSEMBLIES



MOUNTED SWITCH  
-001 CONFIGURATION



MOUNTED SWITCH  
-002 CONFIGURATION



MOUNTED SWITCH  
-003 CONFIGURATION

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**TB-203**

SHEET 1 OF 8

TB-203

1.0



**PURPOSE:**

THE PURPOSE OF THIS TECHNICAL BULLETIN IS TO PROVIDE NECESSARY INSTRUCTIONS TO THE CUSTOMER FOR PROPER INSTALLATION OF SERIES 100 SWITCHES AS DESCRIBED IN DRAWING 730110-TAB.

**CUSTOMER:** AVIONICA

**STEP BY STEP PROCEDURE for 730110-001:**

1. INSTALL PUSHBUTTON GUARD (I) ONTO SWITCH ASSEMBLY (FIGURE 1).
2. INSTALL SWITCH ADAPTOR (II) ONTO PUSHBUTTON GUARD (I) AND SWITCH ASSEMBLY (FIGURE 1).
3. INSTALL GUARD, ADAPTOR AND SWITCH INTO PANEL (III) (FIGURE 1).
4. REMOVE PUSHBUTTON (IV) FROM SWITCH. CAUTION: PUSHBUTTON IS RETAINED TO SWITCH ASSEMBLY BY UTILIZING A PUSHBUTTON LANYARD. AFTER PUSHBUTTON RELEASES FROM SWITCH, EXTEND PUSHBUTTON UNTIL LANYARD IS FULLY EXTENDED (SEE FIGURES 2 AND 3). PUSHBUTTON GUARD MUST BE HELD BY THE INSTALLER IN THE OPEN CONDITION WHEN THIS PROCEDURE IS PERFORMED.
5. AFTER INSTALLED INTO PANEL, ADD MOUNTING SLEEVE (V) ONTO BACK SIDE OF PANEL AROUND SWITCH BODY. (SEE FIGURE 1)
6. USING A FLAT HEAD SCREW DRIVER WITH TORQUE SETTINGS, TURN SCREW CLOCKWISE SO THAT MOUNTING LUGS OF SWITCH TIGHTEN AGAINST MOUNTING SLEEVE. TIGHTEN MOUNTING LUG SCREWS TO 16-18 IN-OUNCES (0.113 TO 0.127 N-m). (SEE FIGURES 2 AND 3)
7. REINSTALL PUSHBUTTON BACK ONTO SWITCH ASSEMBLY. (SEE FIGURE 4)

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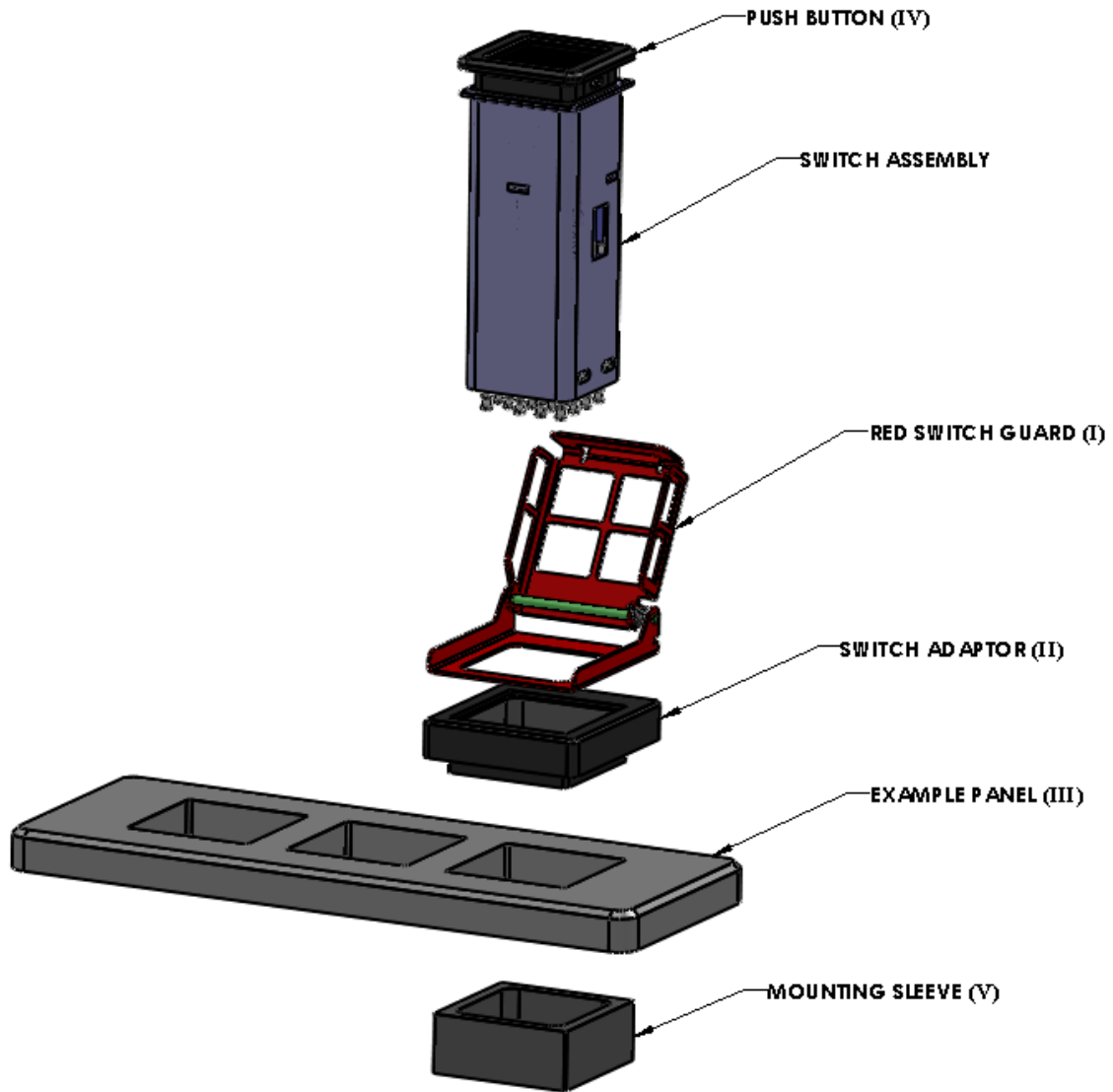


FIGURE 1 – EXPLODED VIEW FOR -001

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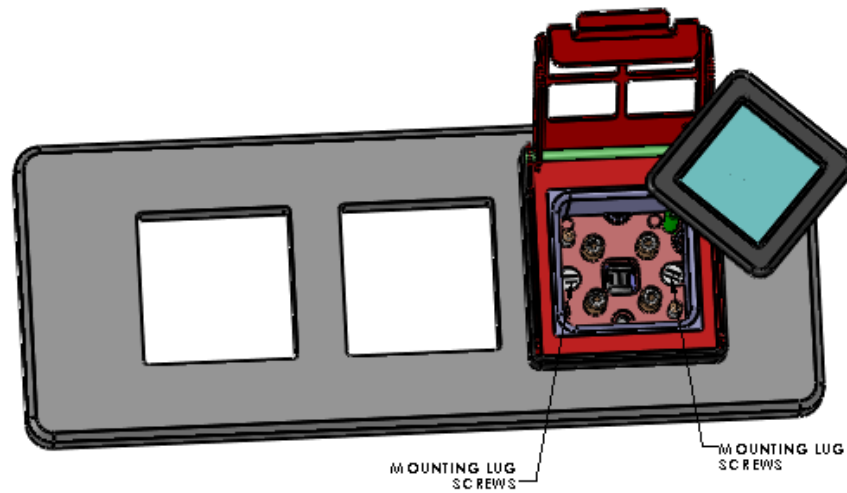
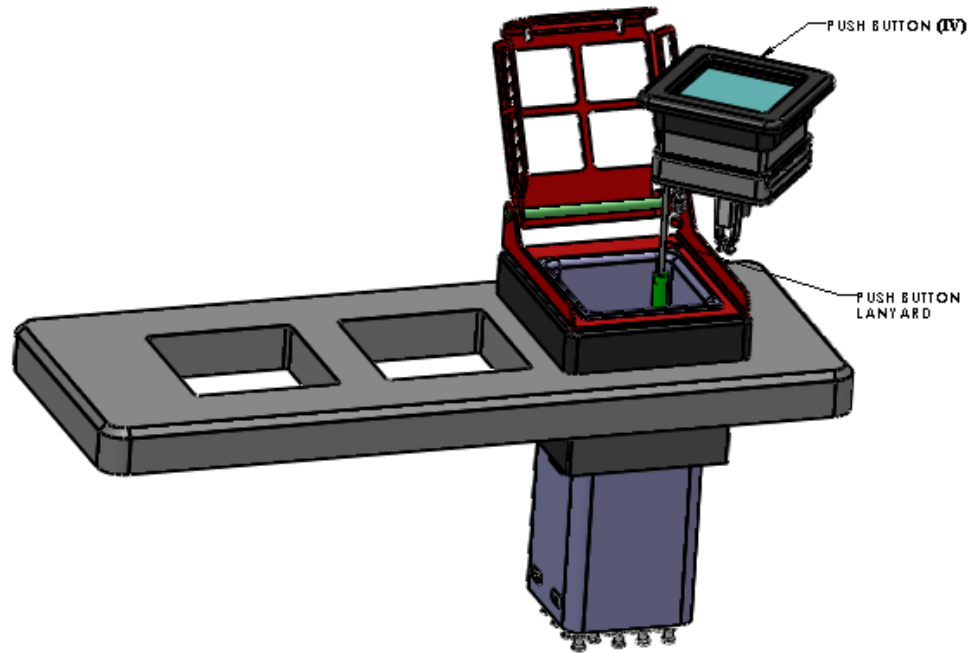
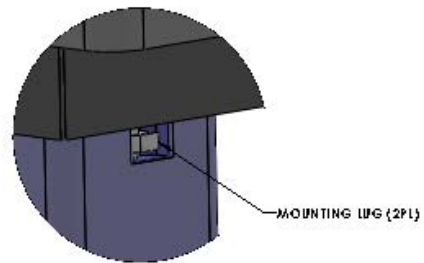
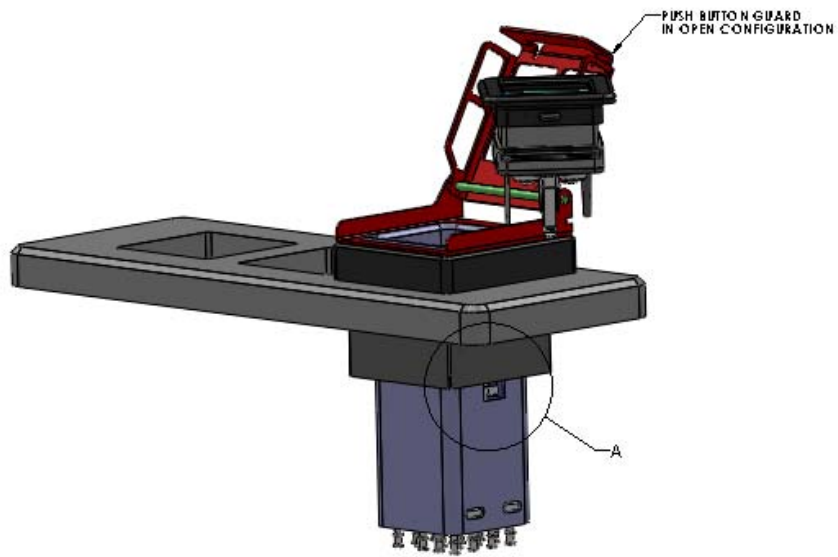


FIGURE 2 – LANYARD AND MOUNTING LUG SCREW DETAILS

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DETAIL A  
SCALE 6:1

FIGURE 3 – MOUNTING LUG DETAILS

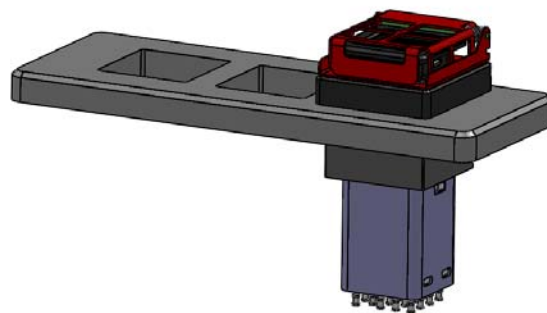


FIGURE 4 – FINISHED CONFIGURATION -001

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**PROCEDURE for 730110-002 AND -003:**

1. INSTALL SWITCH ADAPTOR (II) ONTO SWITCH ASSEMBLY (FIGURE 5).
2. INSTALL ADAPTOR AND SWITCH INTO PANEL (III) (FIGURE 5).
3. REMOVE PUSHBUTTON (IV) FROM SWITCH. CAUTION: PUSHBUTTON IS RETAINED TO SWITCH ASSEMBLY BY UTILIZING A PUSHBUTTON LANYARD. AFTER PUSHBUTTON RELEASES FROM SWITCH, EXTEND PUSHBUTTON UNTIL LANYARD IS FULLY EXTENDED (SEE FIGURES 2 AND 3). PUSHBUTTON GUARD MUST BE HELD BY THE INSTALLER IN THE OPEN CONDITION WHEN THIS PROCEDURE IS PERFORMED. FOR -003 CONFIGURATION, USE STACO PUSHBUTTON EXTRACTION TOOL P/N 15193 TO REMOVE PUSHBUTTON (FIGURE 8).
4. AFTER INSTALLED INTO PANEL, ADD MOUNTING SLEEVE (V) ONTO BACK SIDE OF PANEL AROUND SWITCH BODY. (FIGURE 5).
5. \*\*USING A FLAT HEAD SCREW DRIVER WITH TORQUE SETTINGS, TURN SCREW CLOCKWISE SO THAT MOUNTING LUGS OF SWITCH TIGHTEN AGAINST MOUNTING SLEEVE. TIGHTEN MOUNTING LUG SCREWS TO 16-18 IN-OUNCES (0.113 TO 0.127 N-m). (SEE FIGURES 2 AND 3)
6. REINSTALL PUSHBUTTON BACK ONTO SWITCH ASSEMBLY. (SEE FIGURE 6 FOR -002 AND FIGURE 7 FOR -003.)

\*\*NOTE: FOR STEPS 5, and 7, FOR THE -002 AND -003 CONFIGURATIONS, PUSHBUTTON SWITCH GUARD IS NOT USED.

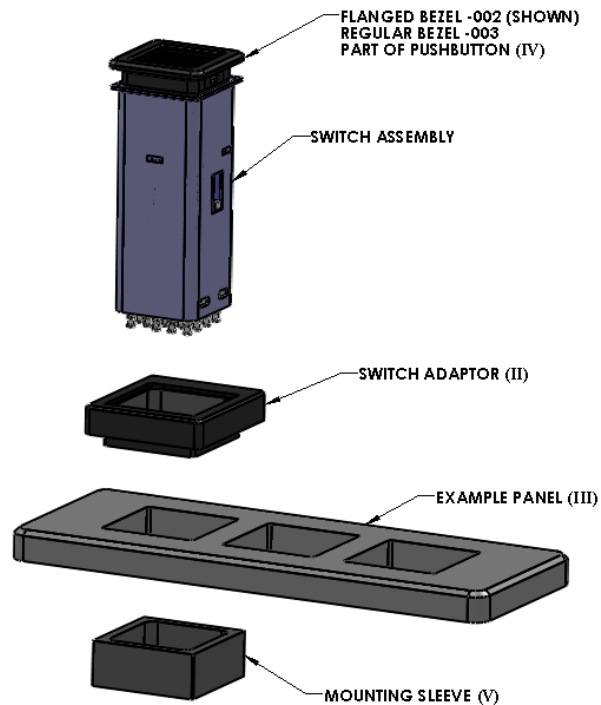
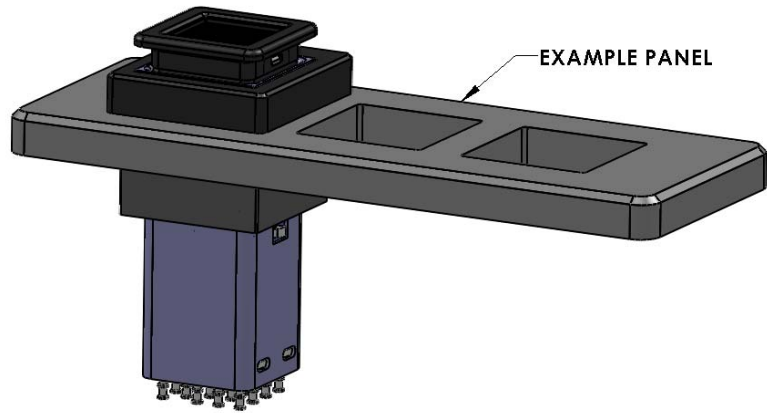


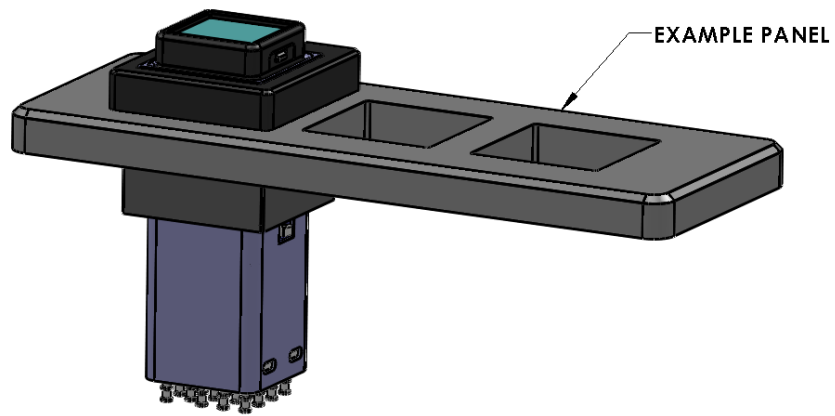
FIGURE 5 – EXPLODED VIEW, -002 AND -003 CONFIGURATIONS

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MOUNTED SWITCH  
-002 CONFIGURATION

FIGURE 6 – FINISH -002 CONFIGURATION



MOUNTED SWITCH  
-003 CONFIGURATION

FIGURE 7 – FINISHED -003 CONFIGURATION

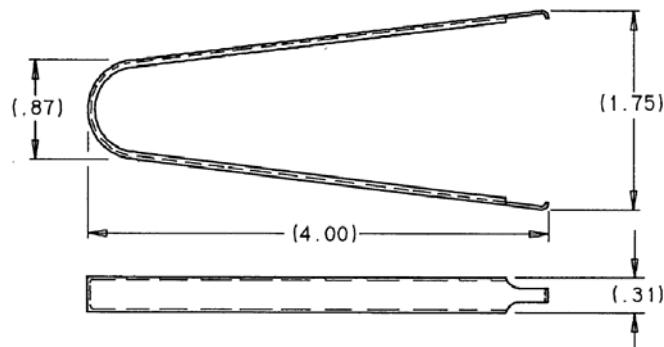


FIGURE 8 – PUSHBUTTON EXTRACTION TOOL

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