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APPROVED

TECHNICAL BULLETIN TB-206

INSTALLATION PROCEDURE FOR PUSHBUTTON SWITCH ASSEMBLY.

TB-206

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TB-206

1.1

SHEET 1 OF 5

PURPOSE:

THE PURPOSE OF THIS TECHNICAL BULLETIN IS TO PROVIDE NECESSARY INSTRUCTIONS TO THE CUSTOMER FOR PROPER INSTALLATION OF SERIES 100 AND SERIES 90 PUSHBUTTON SWITCH ASSEMBLIES.

MOUNTING PROCEDURE

1. REMOVE PUSHBUTTON FROM SWITCH/INDICATOR ASSEMBLY.

USING PUSHBUTTON EXTRACTION TOOL, SEE FIGURE 1, POSITION THE TOOL'S GRIPPING TABS UNDER THE PUSHBUTTON'S BEZEL RETENTION TABS (SEE FIGURE 2 & DETAIL A). CLAMP/SQUEEZE THE TOOL GENTLY, BUT FIRMLY, AND PULL THE PUSHBUTTON AWAY FROM THE SWITCH ASSEMBLY. THE REMOVAL FORCE SHOULD BE IN THE RANGE OF TWO (2) TO FIVE (5) POUNDS.

THIS GIVES ACCESS TO THE HEADS OF THE LOCKING SCREWS LOCATED INSIDE THE FRONT PORTION OF THE SWITCH / INDICATOR. SEE FIGURE 5 & DETAIL B.

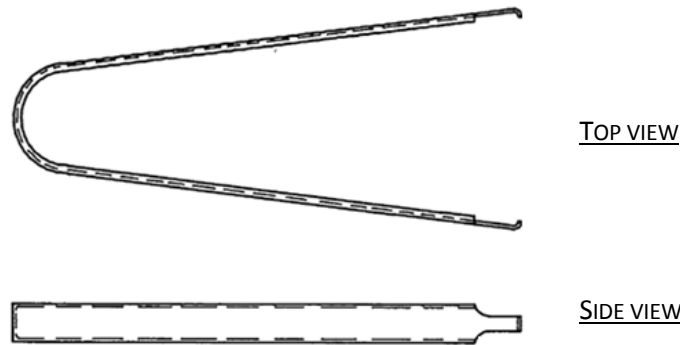


Fig. 1 - pushbutton extraction tool (PN-15193)

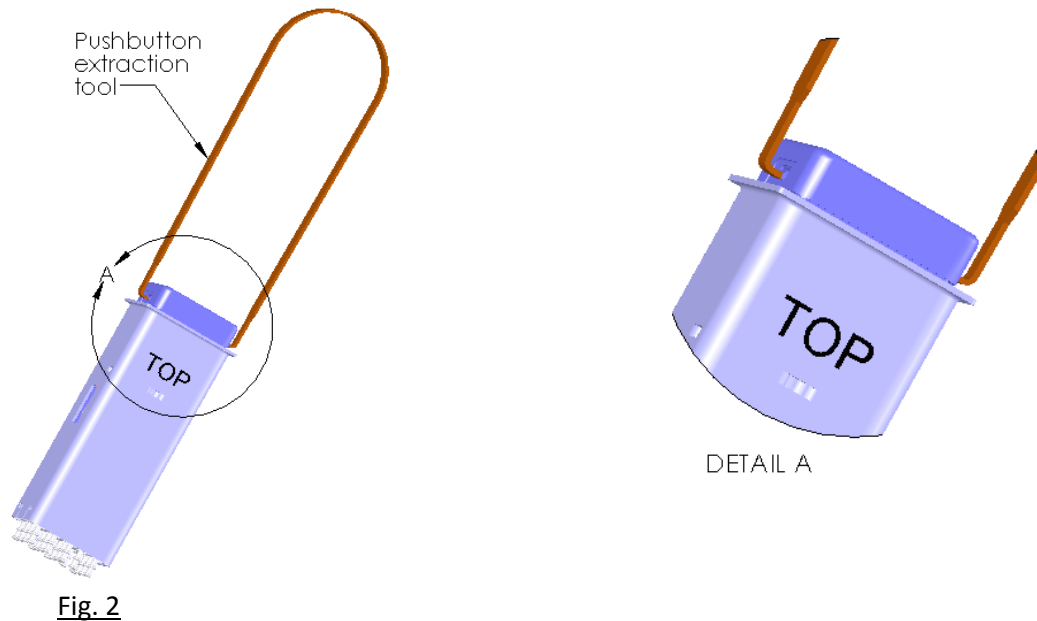


Fig. 2

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12522	TB-206	1.1	3

NOTES:

A. **ALTERNATE ACTION SWITCHES:**

ALTERNATE ACTION SWITCHES, WHEN ACTIVATED, THE PUSHBUTTON RETAINED IN THE LATCH-DOWN / COMPRESSED POSITION UNTIL PUSHBUTTON IS DEACTIVATED. SEE FIGURES 3 & 4 FOR PUSHBUTTON PROTRUSION FOR NON-COMPRESSED AND COMPRESSED STATES.

TO PREVENT THE PUSHBUTTON SEALS AND BEZELS FROM BEING DAMAGED DURING THE REMOVAL PROCESS. ALTERNATE ACTION SWITCHES SHALL BE IN THE NON-COMPRESSED STATE BEFORE ATTEMPTING THE PUSHBUTTON REMOVAL PROCESS.

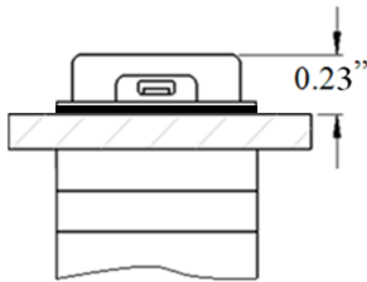


Fig. 3 Non-compressed

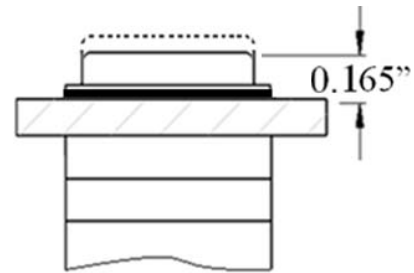


Fig. 4 Compressed / latch-down

B. **SERIES 100 CODED MODEL 'A' AND SERIES 90 PUSHBUTTON SWITCH ASSEMBLIES WITH RETAINER TIE.**

TO PREVENT DAMAGE TO THE PUSHBUTTON RETAINER TIE AND PUSHBUTTON ASSEMBLY DURING THE REMOVAL PROCESS. PUSHBUTTON ASSEMBLY SHALL NOT BE PULLED AWAY FROM THE SWITCH HOUSING EDGE GREATER THAN 0.25". SEE FIGURE 5.

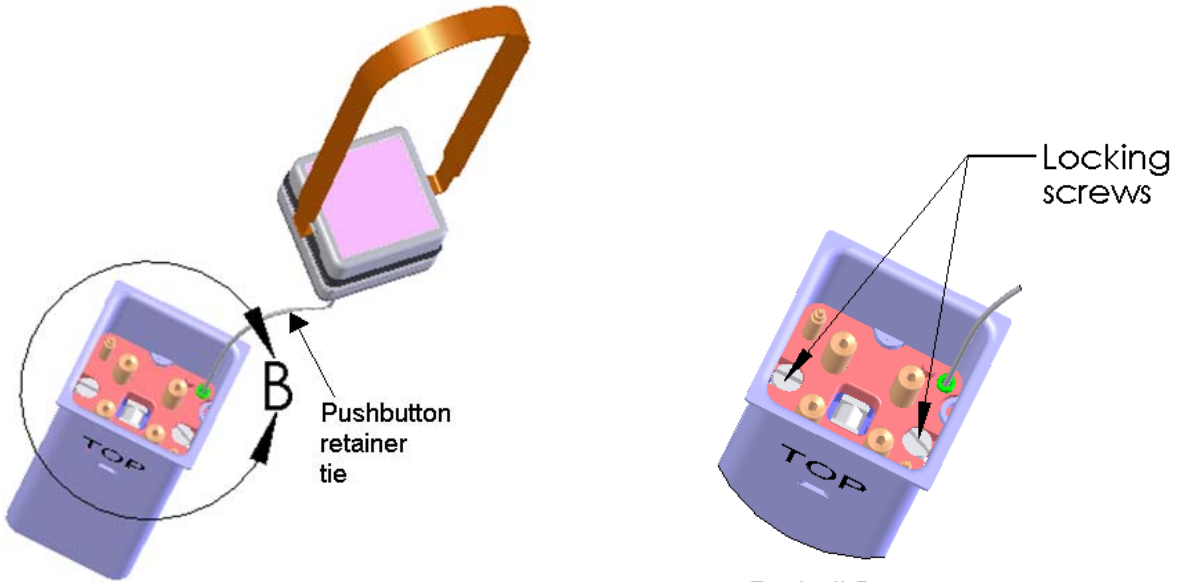


Fig. 5

Detail B

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12522	TB-206	1.1	4

2. ROTATE THE TWO LOCKING SCREWS COUNTER-CLOCKWISE WITH A SMALL SCREWDRIVER. THIS WILL RELEASE MOUNTING CAMS.
3. SLIDE MOUNTING SLEEVE AND PANEL SPACER OFF OF THE SWITCH/INDICATOR ASSEMBLY.
4. INSTALL SWITCH/INDICATOR ASSEMBLY THROUGH PANEL CUT-OUT FROM FRONT OF PANEL. ASSEMBLY IS MARKED WITH WORD "TOP" TO HELP PROPERLY ORIENT POSITION OF THE ASSEMBLY IN THE PANEL.
5. REPLACE PANEL SPACERS AND MOUNTING SLEEVE AS APPROPRIATE FOR THE PANEL THICKNESS.

THE TWO PANEL SPACERS, TOGETHER WITH THE MOUNTING SLEEVE, PROVIDE VARIOUS OPTIONS FOR FITTING THE SWITCH/INDICATOR ASSEMBLY TO MOUNTING PANELS WITH THICKNESSES RANGING FROM ESSENTIALLY ZERO TO A MAXIMUM OF 0.88".

6. ROTATE LOCKING SCREWS CLOCKWISE TO BRING MOUNTING CAMS TO LOCK POSITION. RECOMMENDED MOUNTING TORQUE IS 10 ± 2 OUNCE INCHES (0.071 ± 0.014 NM).
7. TO INSERT THE PUSHBUTTON PROPERLY, ALIGN THE INDEX PIN, AT THE REAR OF THE PUSHBUTTON, WITH THE INDEX HOLE IN THE SWITCH HOUSING AND PUSH GENTLY UNTIL THE PUSHBUTTON IS PROPERLY SEATED.
 - 7.1 FOR INCANDESCENT PUSHBUTTON, BE CERTAIN THAT INCANDESCENT TYPE PUSHBUTTONS HAVE LAMPS AND/OR DUMMY LAMPS INSTALLED IN ALL FOUR POSITIONS BEFORE INSERTING INTO MATING SWITCH/INDICATOR ASSEMBLY.
 - 7.2 BEFORE REINSTALLING THE PUSHBUTTON, APPLY A SMALL BEAD OF TEFLON GREASE, MAGNALUBE-G, AROUND THE THROAT OF THE SWITCH HOUSING WITH A COTTON-BASE SWAB.
8. FOR EXTENDED MOUNTING OF THE ASSEMBLY, AS IN CONJUNCTION WITH EDGE-LIT PANELS, THE BLACK PANEL SPACER IS LEFT INSTALLED ON THE ASSEMBLY BEFORE IT IS INSERTED IN THE PANEL CUT-OUT SO AS TO BE IN FRONT OF THE PANEL WHEN INSTALLATION IS COMPLETE.

CAGE CODE:	DRAWING NO.	REV.	SHT.
12522	TB-206	1.1	5