

CAPTIVE PUSHBUTTON, INSTALLATION OF TIE RETAINER, P/N: 15093

**PURPOSE OF TIE RETAINER:** TO PROVIDE A MECHANICAL CONNECTION BETWEEN THE SERIES 90 SWITCH MODULE AND THE PUSHBUTTON SO THAT WHEN PUSHBUTTON IS REMOVED FOR RELAMPING IT WILL REMAIN SECURELY ATTACHED TO ITS SWITCH MODULE AND NOT BE INSTALLED IN SOME OTHER SWITCH MODULE BY ERROR.

**SCOPE:** PROVIDES INSTRUCTIONS FOR INSTALLING TIE RETAINERS AT THE FACTORY (STACOSWITCH) OR IN THE FIELD. NO SPECIAL TOOLS ARE REQUIRED (ALTHOUGH A PAIR OF TWEEZERS COULD PROVE QUITE USEFUL).

**PROCEDURE:** THERE ARE SEVEN STEPS IN THE INSTALLATION OF A TIE RETAINER.

- A. REMOVE PUSHBUTTON FROM SWITCH MODULE.
- B. REMOVE LAMPS (OR DUMMY LAMPS) FROM LAMPBOARD ASSEMBLY.
- C. CAREFULLY SLIDE LAMPBOARD ASSEMBLY OVER ON LAMPBOX ASSEMBLY APPROXIMATELY 1/8", SUCH THAT THE COLOR FILTER CAPS REMAIN TRAPPED IN PLACE IN THE LAMPBOX. SET ASSEMBLY ASIDE.
- D. THREAD SMALLER BALL END OF TIE RETAINER (P/N 15093) THROUGH HOLE IN SWITCH HEADER PLATE ALL THE WAY TO THE BOTTOM SUCH THAT OPPOSITE END PROJECTS ABOVE TOP OF SWITCH HOUSING. A STRAIGHTENED PAPERCLIP CAN HELP IN THIS OPERATION. SEE FIGURE I.

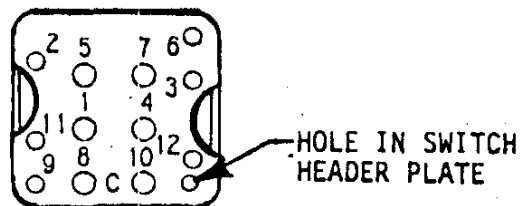


FIG. I

- E. THREAD THE SMALLER BALL, ON THE PROJECTING END OF THE TIE RETAINER, THROUGH THE KEYHOLE SLOT IN THE LAMPBOARD ASSEMBLY, MOVING IT UP, OVER THE BOSS, AND THEN LOWERING IT BACK DOWN INTO THE RELIEF OVER THE KEYSLOT. SEE FIGURE II.

INSTALLATION OF TIE RETAINER

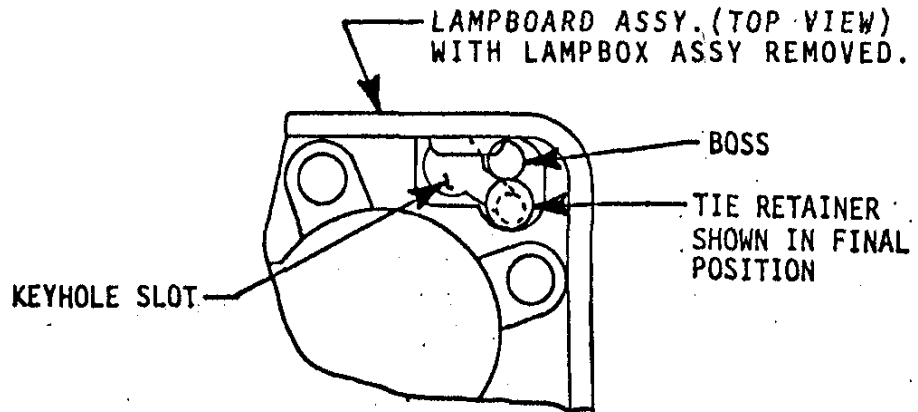


FIG II

- F. SLIDE THE LAMPBOX BACK INTO LAMP BOARD ASSEMBLY UNTIL IT SNAPS INTO POSITION. THE TIE RETAINER IS NOW INSTALLED AND SECURE.
- G. RE-INSTALL LAMPS (OR DUMMY LAMPS), ORIENT THE PUSH-BUTTON CORRECTLY AND INSERT IT BACK INTO THE SWITCH MODULE.

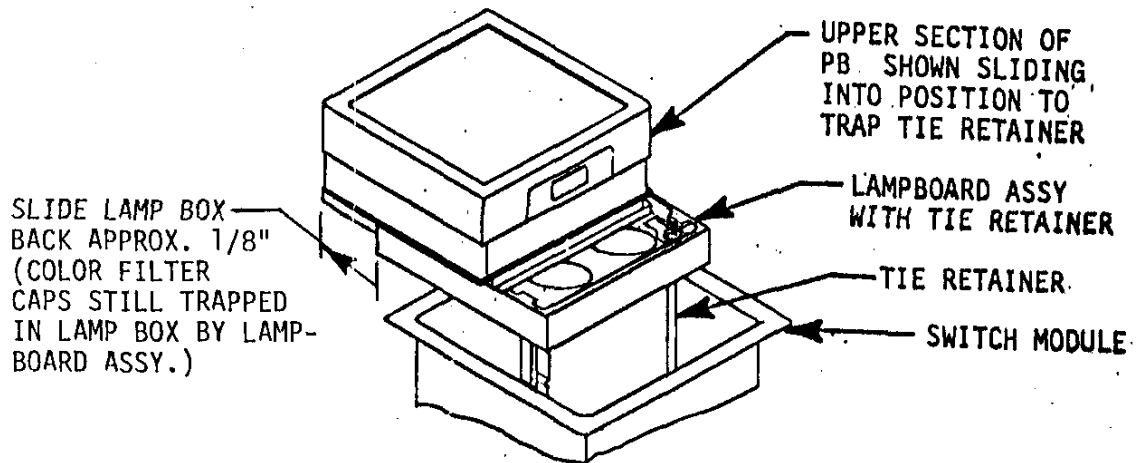


FIG III