

REVISION HISTORY				
REV.	DESCRIPTION	ER NUMBER	DATE	APPROVAL
1.1	REVISED PER ER	ER-47613	07/25/17	A.LETSO
1.0	INITIAL RELEASE PER ER	ER-41346	10/02/09	S.TRUONG



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	APPROVALS	DATE	 <p>One Step Ahead</p>		TEL: (949) 297-8700 FAX: (949) 297-8749													
	Drawn K.TAKEUCHI	09/28/09					A COMPONENTS CORPORATION OF AMERICA COMPANY											
<p>THIRD ANGLE PROJECTION</p>  <p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES</p> <table border="0"> <tr> <td>DECIMALS</td> <td>ANGLES</td> <td>FRACTIONS</td> </tr> <tr> <td>X ± .03</td> <td>± 1/2°</td> <td>± 1/64</td> </tr> <tr> <td>.XX ± .010</td> <td></td> <td></td> </tr> <tr> <td>.XXX ± .005</td> <td></td> <td></td> </tr> </table>	DECIMALS	ANGLES	FRACTIONS	X ± .03	± 1/2°	± 1/64	.XX ± .010			.XXX ± .005			CHECKED	SEE ER	TITLE			
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	.XX ± .010																	
.XXX ± .005																		
PROJ ENG	TECHNICAL BULLETIN, SERIES 100 SWITCH, AVIONICA INSTALLATION INSTRUCTIONS FOR 7301 10-TAB ASSEMBLIES																	
MGMT	SIZE	CAGE CODE	DWG NO	REV														
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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.

2.0 CUSTOMER:

Avionica

3.0 Step by step procedure for 730110-001:

- 3.1. Install pushbutton guard (I) onto switch assembly (Figure 1).
- 3.2. Install switch adaptor (II) onto pushbutton guard (I) and switch assembly (Figure 1).
- 3.3. Install guard, adaptor and switch into panel (III) (Figure 1).
- 3.4. 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 (Figures 2, 3 and 4). Pushbutton guard must be held by the installer in the open condition when this procedure is performed.
- 3.5. After installed into panel, add mounting sleeve (V) onto back side of panel around switch body (Figure 1).
- 3.6. 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 10 ± 2 in-ounces (0.0703 ± 0.014 Nm). (Figures 2, 3 and 4)
- 3.7. Re-install pushbutton back onto switch assembly (Figure 4).

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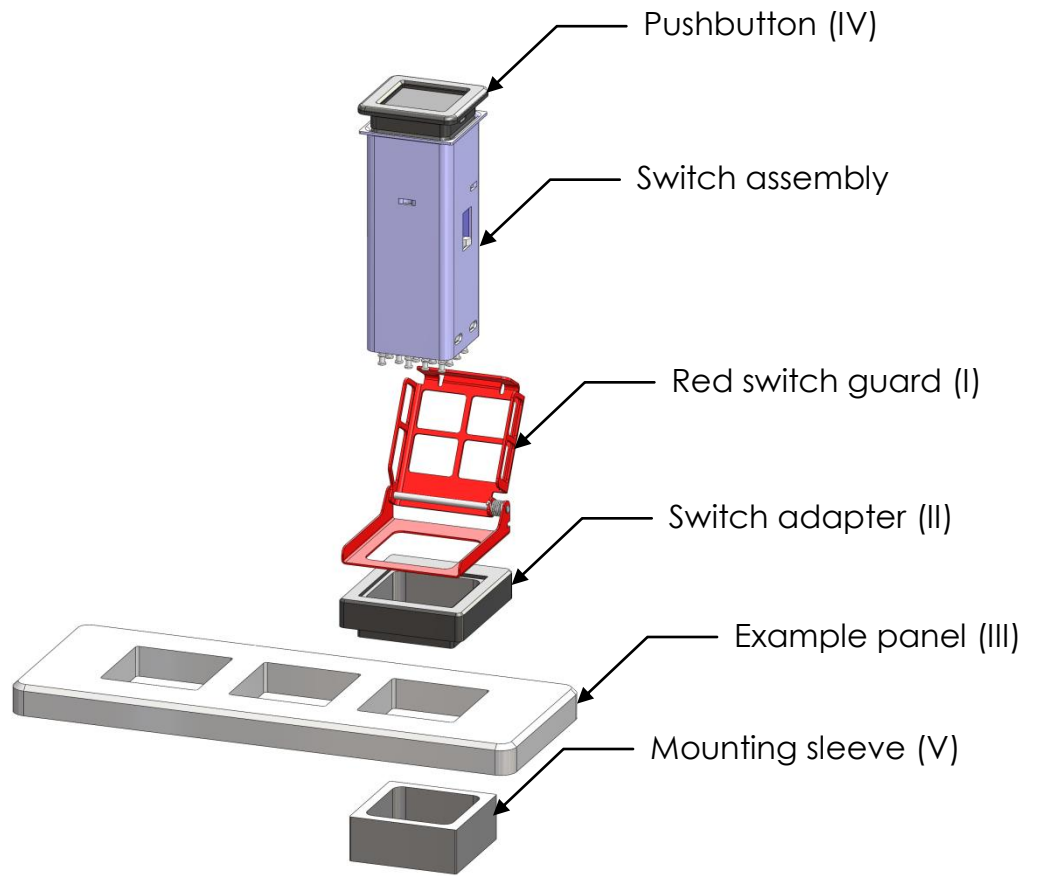


Figure 1: Exploded view for -001

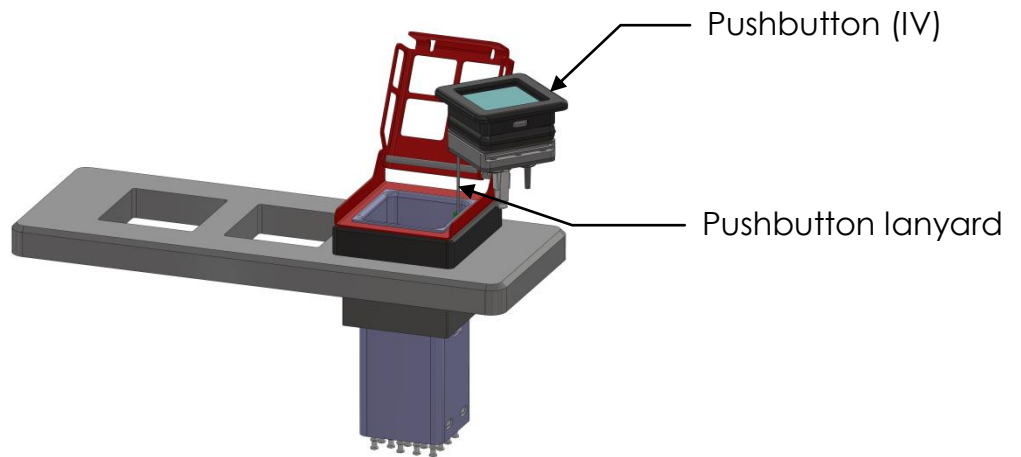


Figure 2: Lanyard

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Figure 3: Mounting lug screw details

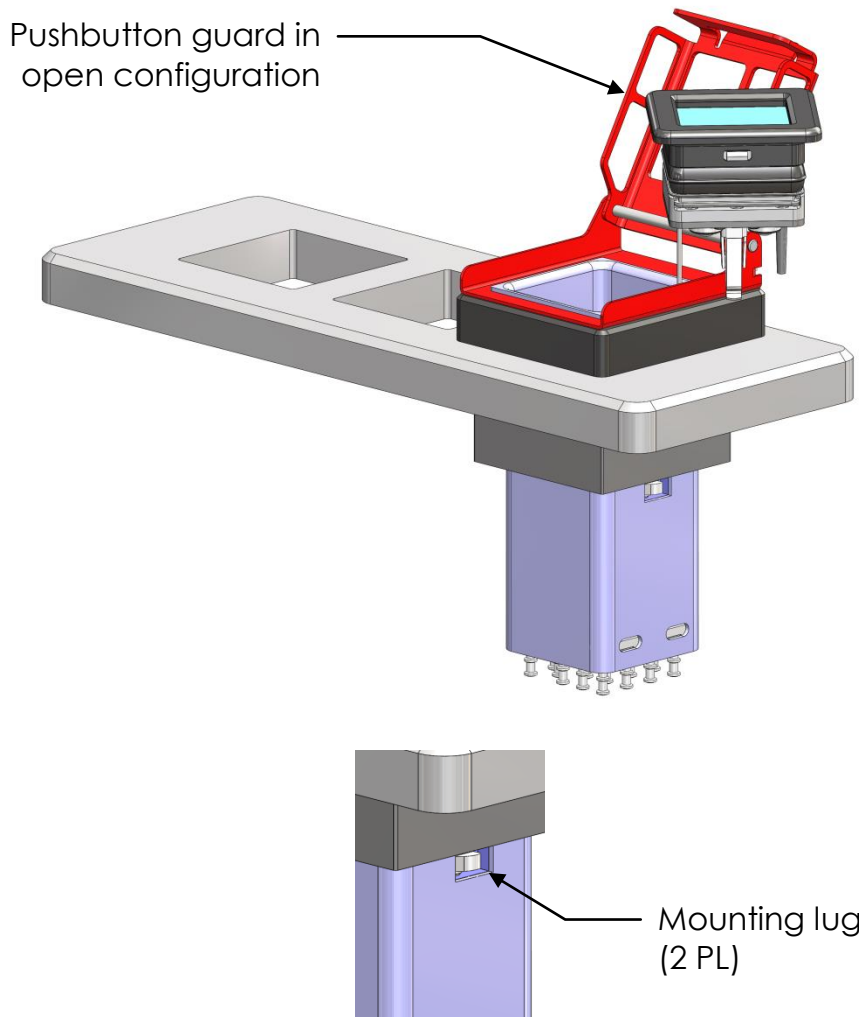


Figure 4: Mounting lug details

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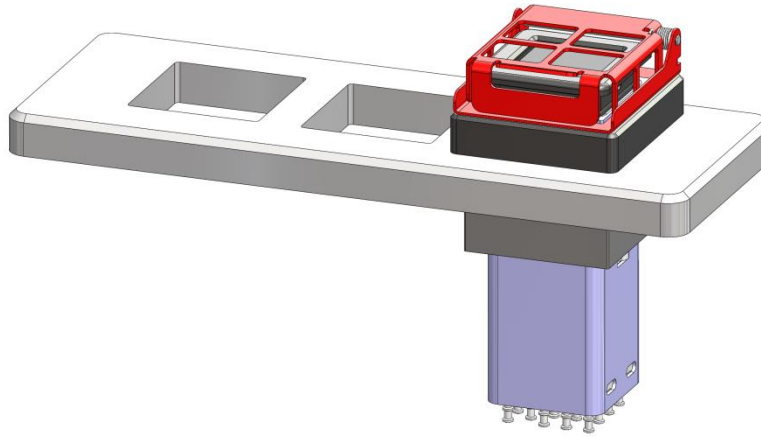


Figure 5: Finished configuration -001

4.0 **Step by step procedure for 730110-002 and -003:**

- 4.1. Install switch adaptor (II) onto switch assembly (Figure 6).
- 4.2. Install adaptor and switch into panel (III) (Figure 6).
- 4.3. 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 (Figures 2, 3 and 4). 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 9).
- 4.4. After installed into panel, add mounting sleeve (V) onto back side of panel around switch body. (Figure 6).
- 4.5. 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 10 ± 2 in-ounces (0.0703 ± 0.014 Nm). (Figures 2, 3 and 4)
- 4.6. Re-install pushbutton back onto switch assembly. (Figure 7 for -002 and Figure 8 for -003.)

Note: For steps 5, and 7, for the -002 and -003 configurations, pushbutton switch guard is not used.

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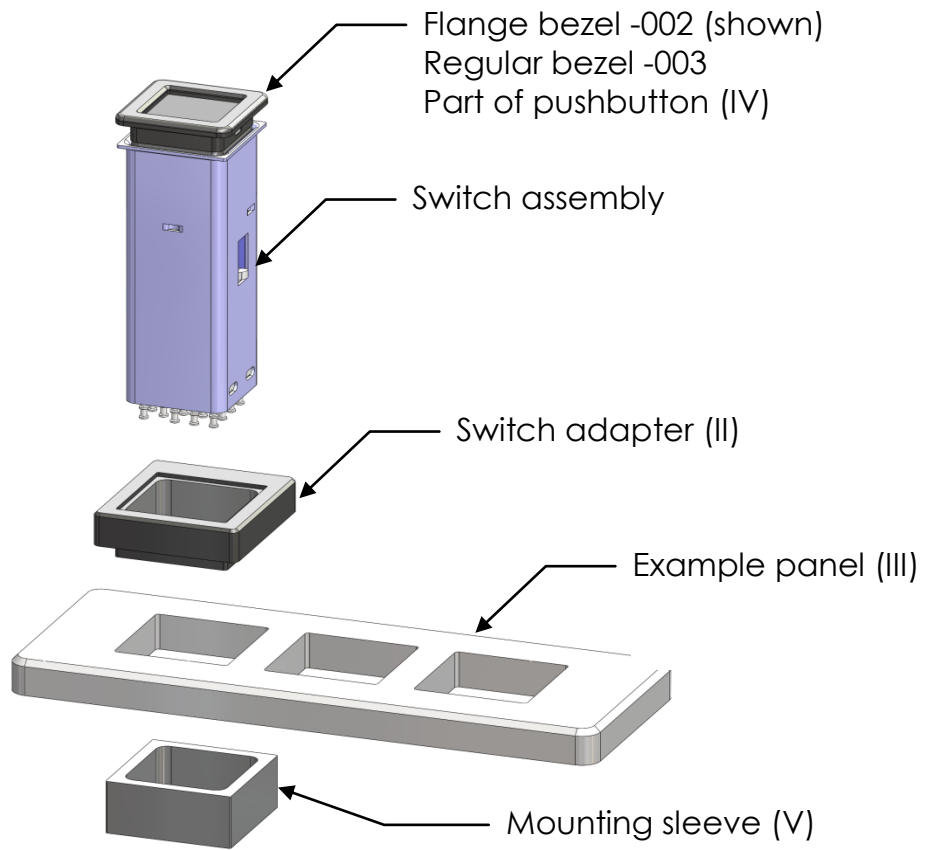


Figure 6: Exploded view, -002 and -003 configurations

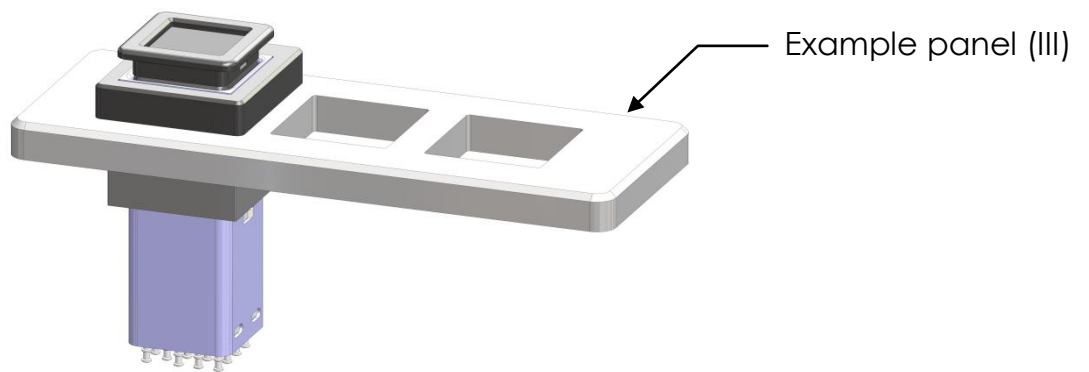


Figure 7: Finish -002 Configuration

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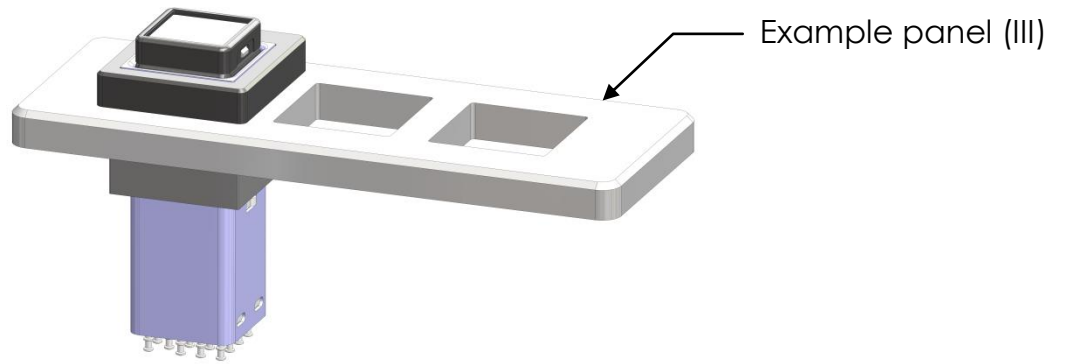


Figure 8: Finish -003 configuration

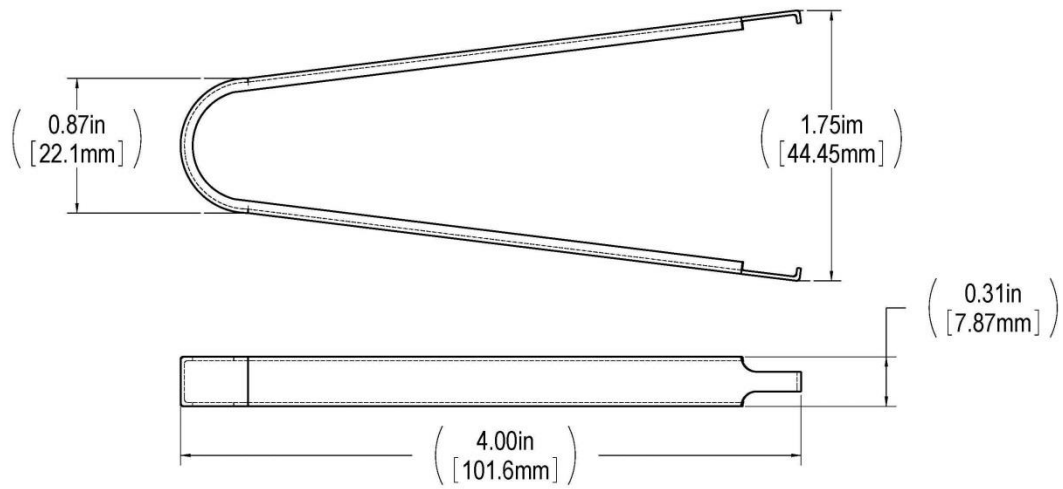


Figure 9: Pushbutton extraction tool

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