

DATE <u>8-15-58</u>	<b>TMC SPECIFICATION NO. S -388</b>	
SH. <u>1</u> OF <u>2</u>		
COMPILED BY <i>file</i>	TITLE: ASSEMBLING AND CLEANING-INSTRUCTION FOR TRL-1	JOB
APPROVED <i>AM</i>		

STEP A:

Assemble the magnet PO-153 to the body of the relay on the side opposite to the transmitter connector which came assembled to the PO-153. Use the 4-40X1 machine screws supplied.

STEP B:

Remove hole plug from end of block. Turn the PO-155 connector into the 5/8 threaded hole of the PO-152 body. This connector will move the reed or tongue of the relay towards the transmitter connector contact. This can be seen through the hole in the end of the body.

When you have turned the connector in so that there is a space of 1/16 between the contact on the reed and the transmitter connector, hold the connector from turning any further and set the 3/4 hex jam nut securely. PO-152 is factory assembled for correct contact pressure. Your relay is ready for installation in your transmitter but should be bench tested to see that the magnet is operating satisfactorily.

After step B is complete check to see that there is sufficient spacing between the receiver contacts and the reed. This should be approximately 1/32 to 1/16 in the energized position.

STEP C:

Mount the PO-154 using the two 4-40X5/8" machine screws supplied. After you have one screw in the switch, place the 1/8" fibre piece in the 1/8" hole. Place the other screw in the switch and tighten. Minor adjustments may be required to assure proper contact of the leaves of the external switch. By bench checking you can check these in the energized and de-energized position.

NOTE

Under no circumstances should you remove the antenna connector from the PO-152 body.

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Internal contacts of P0-155 special receiving connector can be cleaned by removing connector from relay body and submerging in carbon-tetrachloride.

A. C. Magnet Assemblies P0-153 are guaranteed free from any A. C. hum or chatter which can be caused only by foreign matter between armature and pole face or overloading.

If hum or chatter develops, clean as follows:

1. Remove lock ring holding dust cover. Dust cover can then be removed by actuating relay and armature action will lift cover out of cage. If magnet is removed from relay, remove lock ring and gently tap plunger insulator protruding from magnet.
2. Clean armature face and pole piece with light oil and wipe clean making sure armature is firm on brass plunger.
3. Clean inside of cage and assemble.

If transmit connector is removed for any reason--- readjust for responsive operation. Buzzing indicates overload (excessive tongue pressure) and any tendency toward lagging or sticking in transmit position indicates insufficient contact pressure on tongue. Screw in transmitter connector one half turn.