

INSTRUCTIONS FOR INSTALLING THE 325967  
MODIFICATION KIT TO CONVERT MODEL 35  
PRINTER LINE FEED CLUTCH FROM 6-STOP TO  
3-STOP

1. GENERAL

- 1.01 The 325967 modification kit converts a Model 35 sprocket feed typing unit from a 6:1 line feed ratio to a 3:1 ratio.
- 1.02 The modification consists mainly of removing 6:1 ratio parts from the stunt box, line feed clutch, and line feed mechanism, and replacing them with 3:1 ratio parts.
- 1.03 The 325967 kit consists of:
- |   |        |                         |   |        |                       |
|---|--------|-------------------------|---|--------|-----------------------|
| 2 | 119651 | Retainer ring           | 2 | 150652 | Screw                 |
| 1 | 119653 | Retainer ring           | 1 | 151658 | Screw                 |
| 1 | 150014 | Adjusting disc assembly | 1 | 151736 | Spring                |
| 1 | 150033 | 3-stop disc assembly    | 1 | 152871 | Spring                |
| 1 | 150035 | 3-stop disc             | 1 | 153236 | Gear                  |
| 1 | 150318 | Stud                    | 1 | 160576 | Stripper slide        |
| 1 | 150650 | Bushing                 | 1 | 160577 | Bail blade with studs |
| 1 | 150651 | Driven gear             |   |        |                       |
- 1.04 For parts ordering information other than those listed in the modification kit, see Teletype Bulletin 1187B.

2. INSTALLATION

- 2.01 Remove the stunt box from the typing unit following disassembly instructions in Bulletin 280B.
- 2.02 Modify the stunt box as follows:
- (a) Remove the 151637 screw and 110743 lockwasher which fasten the 153294 cam to the shaft and retain. Remove and retain the 119653 retainer ring. Push the cam and felt washers to the right and lift out the shaft.
  - (b) From the left side of the stunt box remove and discard the 151721 screw, 151629 nut, 8330 flat washer, and 2191 lockwasher which fasten the 192311 arm to the 153295 shaft. Remove the arm and discard.
  - (c) Remove and retain the 155099 screw and 3606 nut which fasten the 153301 arm to the left bracket. Remove and retain the arm. Remove the 70466 spring and discard.
  - (d) Remove and discard the 192304 blade assembly. Also discard the 192307 slide, 192308 stripper bail, 192309 pin, 192310 spring, and (2) 119648 retainer ring.

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- (e) Place the 160576 stripper slide (furnished with kit) on the studs of the 160577 bail assembly (furnished with kit), securing with the 119651 retainer rings (furnished with kit).
  - (f) Fit the assembled bail on the 153301 right-hand arm and replace the left-hand arm, securing with the previously removed 155099 screw and 3606 nut.
  - (g) Replace cam and felt washers on shaft. Replace the shaft and re-fasten the cam on the left-hand side, using the previously retained 151637 screw and 110743 lockwasher. Move the 90504 felt washers back against the cam and fasten with the 119653 retainer ring.
- 2.03 Remove the main shaft from the typing unit per Bulletin 280B.
- 2.04 Remove the line feed clutch from the main shaft and modify as follows. Disassemble line feed clutch as shown in Figure 1.
- (a) Replace 194871 disc with 150035 disc.
  - (b) Replace 194956 spring with 151736 spring.
  - (c) Replace 194873 disc assembly with 150014 disc assembly.
  - (d) Replace 194872 disc assembly with 150033 disc assembly.
  - (e) Replace 194868 gear with 153236 gear.
  - (f) Reassemble the line feed clutch as shown in Figure 1.
- 2.05 Remove the 150654 line feed pawl guide, the 309692 bracket with post, and the 309690 bumper from the typing unit. Retain the guide and discard the bracket and bumper.
- 2.06 Remove and discard the 80848 spring from the 150642 bellcrank.
- 2.07 Remove the 3606 nut (discard) and the 2191 lockwasher (retain) which mount the line feed pawl assembly to the left side frame.
- 2.08 Modify the line feed pawl assembly as follows. Disassemble line feed pawl assembly as shown in Figure 1.
- (a) Replace 119649 retaining ring and 125015 washer with 119653 retaining ring.
  - (b) Replace 194870 gear with 150651 gear and 150650 bushing.
  - (c) Replace two 151685 screws with two 150652 screws.
  - (d) Replace 192312 stud with 150318 stud.
  - (e) Reassemble line feed pawl assembly as shown in Figure 1.

2.09 Replace the line feed pawl on the printer using the 151658 screw (furnished) and 2191 lockwasher (previously retained). Make sure the slots in the 150585 line feed pawls fit around the post of the 150642 bellcrank.

2.10 Place the 152871 spring (furnished) on the bellcrank.

2.11 Replace the 150654 line feed pawl guide on the left side frame.

2.12 Reassemble and replace the main shaft per Teletype Bulletin 280B.

2.13 Replace the stunt box per Teletype Bulletin 280B.

### 3. ADJUSTMENTS AND LUBRICATION

3.01 For adjusting procedure, refer to Teletype Bulletin 280B. Check the following standard adjustments.

(a) LINE FEED CLUTCH TRIP LEVER ECCENTRIC POST

(b) LINE FEED CLUTCH TRIP LEVER ADJUSTING SCREW

(c) LINE FEED CLUTCH GEAR PHASING

(d) LINE FEED SPUR GEAR DETENT ECCENTRIC

(e) STRIPPER BLADE DRIVE CAM POSITION

(f) LINE FEED CLUTCH SHOE LEVER

(g) LINE FEED CLUTCH TRIP LEVER SPRING TENSION

3.02 Lubricate per Teletype Bulletin 280B.

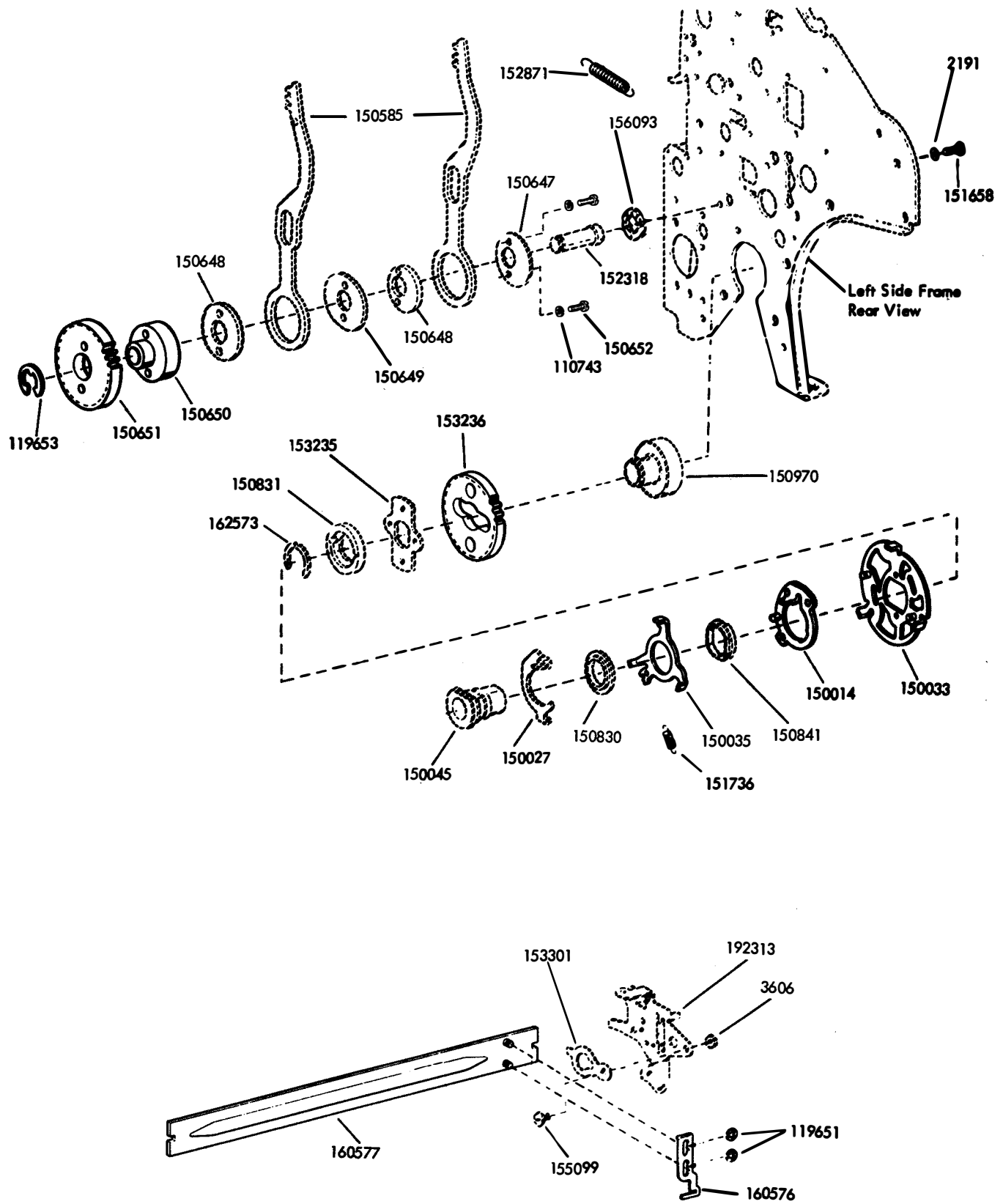


Figure 1 - 325967 Modification Kit