

# CENTRALAB, INC.

A NORTH AMERICAN PHILIPS COMPANY

## ASSEMBLY INSTRUCTIONS FOR 1400 AND 2500 SERIES ROTARY SWITCHES

Ceramic or Phenolic switches with 1 to 10 sections can be assembled with Centralab 30° index assemblies and switch sections. See current catalog for full complement of parts. Index assemblies are furnished with appropriate hardware. Maximum number of sections per index assembly is based on recommended spacings of 1/2" between front plate and first section and 1/2" between all remaining sections. 1/4" spacing is possible with section clips bent out flat.

**PRE-ASSEMBLY NOTE:** Index assemblies are pre-set with knob end of shaft in extreme CW rotation. Switch sections are pre-set with rotor in corresponding extreme CW rotation. Confirm this before assembly of switch.

## ASSEMBLY INSTRUCTIONS

1. Remove all hardware from plastic bag and sort according to size. Follow Fig. 1 for assembly sequence.
2. Insert two bolts into holes on each end of front plate. Bolts will extend beyond end of rotor shaft.
3. Hold index assembly with shaft end down, tie bolts up right. Finger pressure on bolt heads will prevent their dropping out during following steps.
4. Ceramic Switch Assembly:
  - A. Place spacer washer on each tie bolt.
  - B. Place ceramic spacer on each tie bolt.
  - C. Place spacer washer on each tie bolt.
  - D. Read Pre-assembly note. Place first section on tie bolts.
  - E. Repeat steps A thru D as required.
  - F. Place spacer washer on each tie bolt.
  - G. Place lockwasher on each tie bolt.
  - H. Thread tie bolt nut snugly on each tie bolt.
  - I. Index wheel stop, may rub against ceramic spacers. During step J hold first spacers to outer edge of front plate.
  - J. Tighten tie bolt nuts with 3/16" hex-nut driver. **"DO NOT tighten by rotating bolts with screwdriver."** Alternate between nuts to avoid section damage.
  - K. Cut off excess tie bolt length.
5. Phenolic Switch Assembly:
  - A. Follow all above except step C is not necessary.

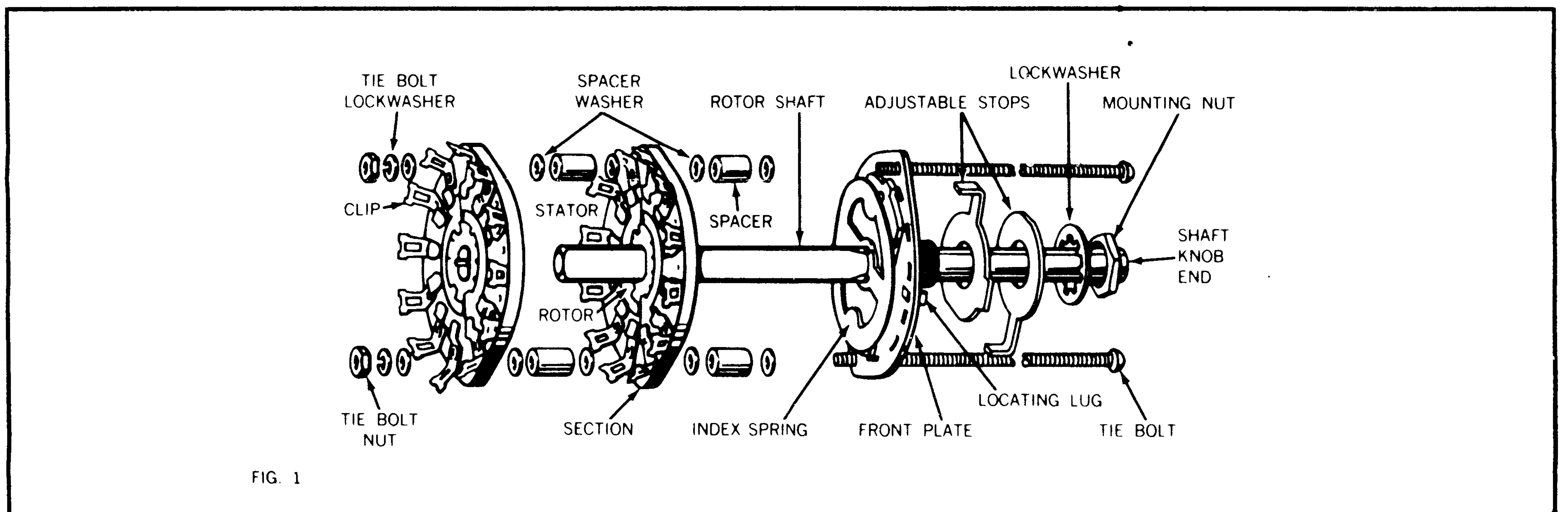


FIG. 1

### ADJUSTABLE STOPS (See Fig. 1 and Fig. 2)

Index assemblies are furnished with (2) adjustable stop plates in position shown in Fig. 2 and moveable to many combinations of stop positions.

"A" in Fig. 2 is locating lug on 17/32" radius and is a non-turn device. Remove or bend out of way if not desired. Use lockwasher furnished as non-turn device.

"B" in Fig. 2 is adjustable stop plate next to front plate and shown as furnished in position for full CW rotation.

"C" in Fig. 2 is adjustable stop plate next to lockwasher and shown as furnished in position for full CCW rotation.

### ADJUSTING STOPS:

Remove Mtg. nut and lockwasher from mounting bushing.

Rotate stop "C" to required stop position for lesser number of positions. ie: move stop "C" to position No. 4 for 4 position switch, to position No. 8 for 8 position switch, to position No. 6 for 6 position switch, etc. Remove both stops for continuous rotation.

**NOTE:** When one or both stops are not required use adjusting stop plate(s), with finger(s) removed, as spacer washers between switch and chassis.

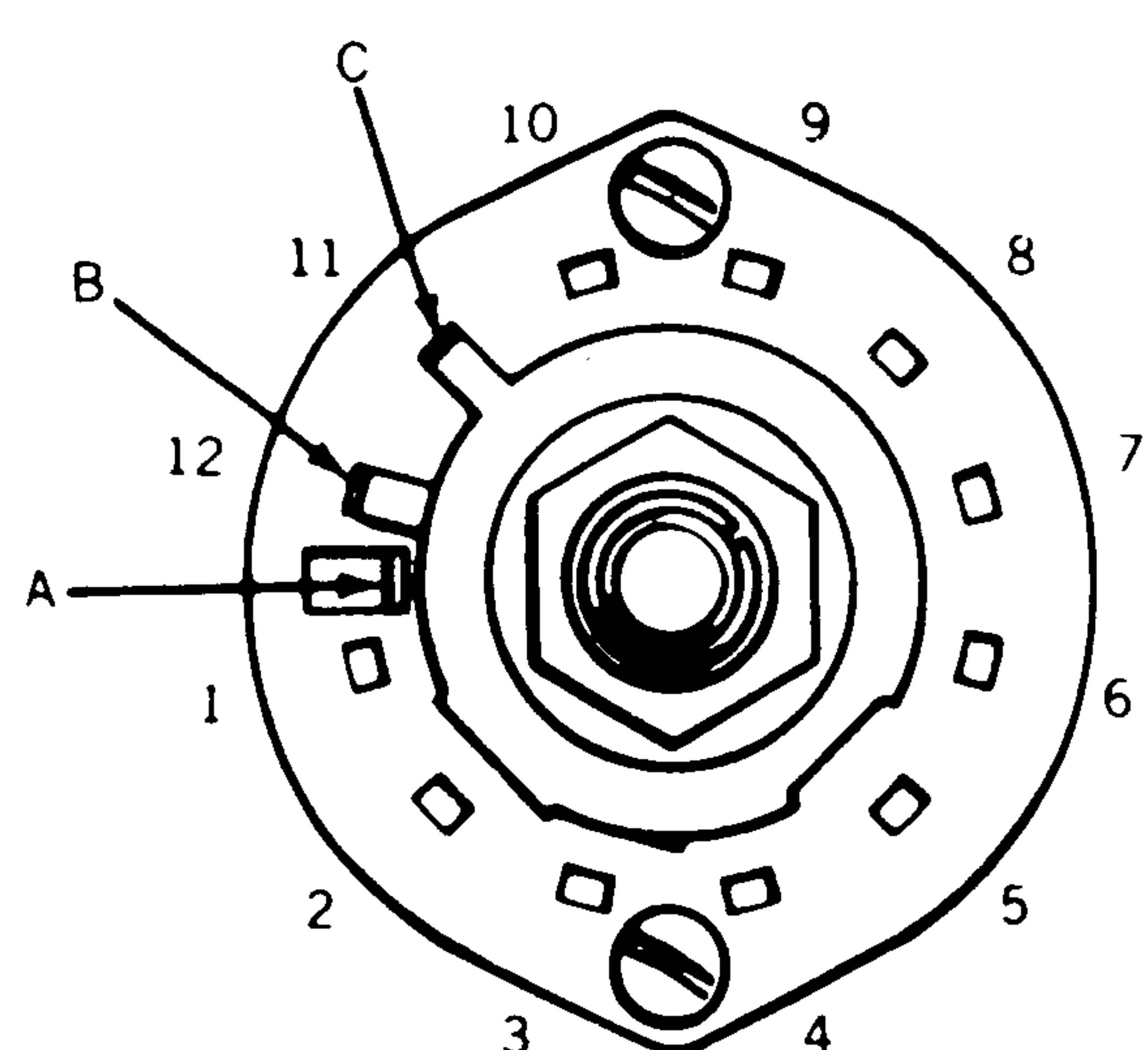


FIG. 2

### ADJUSTING STOPS FOR "OFF" POSITION

CRL SECTION & SWITCHING	"OFF" POSITION AT END OF ROTATION	REMOVE FINGER OF STOP	MOVE STOP	TO POS.
BD, JD, UD, YD (1 Pole, 11 Pos.)	CCW CW	B B	C C	12 11
AD, HD, TD, XD (1 Pole, 6 Pos.)	CCW CW	— —	C B	6 6
CD, KD, RD, RRD (2 Pole, 5 Pos.)	CCW	—	C	6
DD, LD, SD, SSD (3 Pole, 3 Pos.)	CCW	—	C	4