

	NAME	DATE
ORIGINATOR	P. SCOTT	5/19/15

TECHNICAL BULLETIN TB-223

INSTALLATION PROCEDURE

FOR

SERIES 30 PUSHBUTTON SWITCHES

TB-223

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PART NO.

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PART NO.

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1.0 **PURPOSE**

The purpose of this technical bulletin is to provide necessary instructions for proper installation of Series 30 switches.

2.0 **APPLICABLE DOCUMENTS**

The following documents form a part of this document to the extent specified herein. Where specific paragraphs are called out, all subordinate paragraphs also apply. Where individual paragraphs are not specified, the document is applicable in its entirety.

2.1. Staco Systems Documents

Series 30 SCD Specification Control Document, Series 30, Switch, Pushbutton, Environmentally Sealed

3.0 **KEY COMPONENTS**

3.1. S30 switch

3.2. Torque wrench (capable of 15 inch pounds)

4.0 **PROCEDURE**

4.1. Mounting Procedure

4.1.1. Remove dress ring and washer gasket by unscrewing the dress ring.

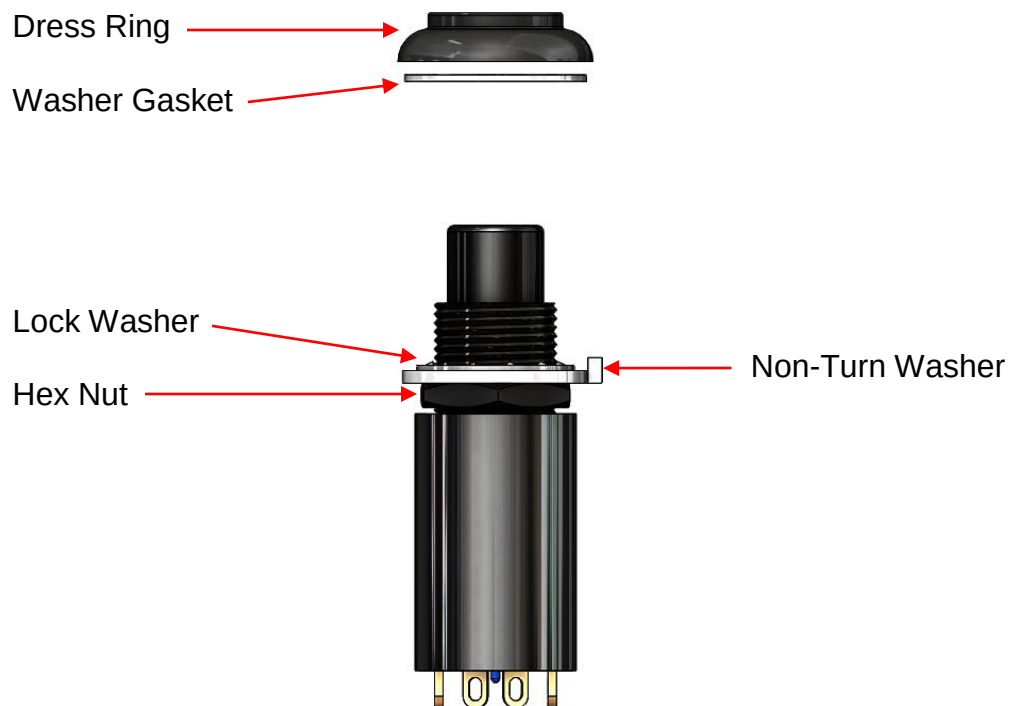


Figure 1: Dress Ring and Washer Gasket Removal

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PART NO.

TB-223

REV.

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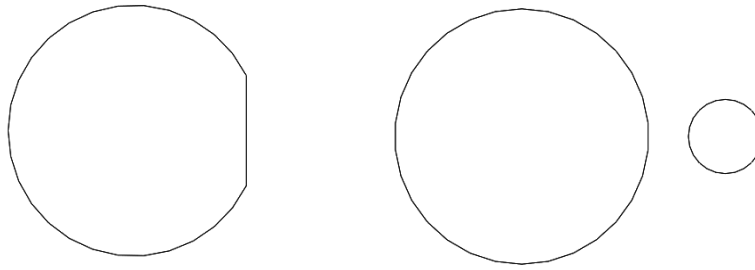


Figure 2: Mounting Hole Layouts, D Hole (Left), Non-Turn Hole (Right)

The non-turn washer orientation depends upon the mounting hole design chosen. If using the D hole the non-turn washer will need to be facing down. If using the non-turn hole the non-turn washer will need to be facing up.

Before installation the hex nut should be screwed all the way down.

- 4.1.2. The switch is inserted from the back side of the panel. The switch and/ or washer needs to be lined up with the mounting holes.

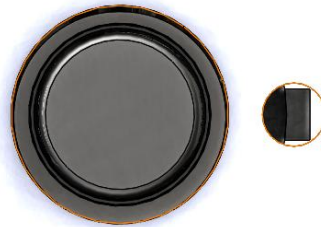


Figure 3: Switch Installation and Alignment for Non-Turn Mounting



Figure 4: Switch Inserted in Panel

CAGE CODE
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PART NO.

TB-223

REV.
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6

- 4.1.3. The washer gasket is installed on the front of the panel and the dress ring is screwed down on top till finger tight.
- 4.1.4. Once the switch is installed and everything is fingertight, a torque wrench is needed to tighten the hex nut up to the panel with a force between 10 in lbs and 15 in lbs.



Figure 5: Completed Installation

CAGE CODE
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PART NO.

TB-223

REV.
1.0

SHT.
7