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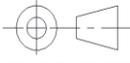
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THIRD ANGLE PROJECTION



UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES		
DECIMALS	ANGLES	FRACTIONS
X ± .03	± 1/2°	± 1/64
XX ± .010		
XXX ± .005		

~~CHECKED~~

~~PROJ ENG~~

~~MGMT~~

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TITLE TECHNICAL BULLETIN, INSTALLATION PROCEDURE FOR WATERTIGHT SEAL, S250			
SIZE A	CAGE CODE 12522	DWG NO TB-231	REV 1.0
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1.0 PURPOSE:

The purpose of this technical bulletin is to provide necessary instructions for the installation of watertight seals on S250 switches.

2.0 KEY COMPONENTS:

- 2.1. Pushbutton removal tool P/N 15193
- 2.2. Torque screw driver (capable of torquing 6-12 inch ounces)
- 2.3. S250 with watertight seal



Figure 1
Torque Screwdriver



Pushbutton Removal Tool

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SHEET

SHEET 2 OF 6

3.0 PROCEDURE

- 3.1. Remove the pushbutton from the front of the switch/indicator assembly (Figure 6). Use extractor tool PN: 15193.
- 3.2. Install watertight seal retainer PN: 11881 and panel seal PN: 12497. See Figure 2.
- 3.3. Install the switch/indicator housing into the panel with the watertight seal retainer and panel seal on the front side of panel and re-install spacer and sleeve to switch housing from back side of the panel.

Note: The number of spacers and thickness used is dependent on the application.

- 3.4. Use a torque limiting screwdriver to tighten pawl screws and secure pawls against sleeve at rear of switch housing. Tighten the pawl screws to a torque of 8 to 12 ounce/inches.
- 3.5. Install the switch/indicator wiring or crimp pin receptacle with wiring in-place.
- 3.6. The first step when installing a pushbutton with a watertight seal into a switch/indicator is to roll back the skirt portion of the watertight seal as shown in Figure 3. The watertight switch assembly is shipped with a light coating of lubricant on the lower seal rib. If the lubricant is removed through handling or cleaning, use a small brush to apply a light coating of Magna lube-G lubricant around the periphery of the three surfaces shown (Figure 3). The lubricant helps to fully seat the skirt into the groove in the retainer. Use caution that no lubricant is transferred to faceplate surfaces.
- 3.7. Install the pushbutton into the switch/indicator assembly. The next step is to roll down the skirt and seat it into the groove in the retainer. A wooden craft stick, or small plastic spatula run along the outside of the seal around the skirt will help this seating process (Figure 5). Once fully seated, the seal will be watertight.
- 3.8. If removal of the pushbutton from the switch/indicator assembly becomes necessary, careful attention is required. Pinch the skirt, with your fingers, in the area of the seal at one corner of the pushbutton and pull outward and upward to unseat the seal (Figure 5). Be careful not to tear, cut or rupture the seal material. At the same time, while pulling outward and upward, roll back the skirt portion of the watertight seal to the position as shown in Figure 3. Now, grasp the pushbutton behind the rolled back skirt and pull straight out of the switch/indicator assembly. If using the push button removal tool. Make sure to grip onto the side underneath the latches as shown in Figure 6.

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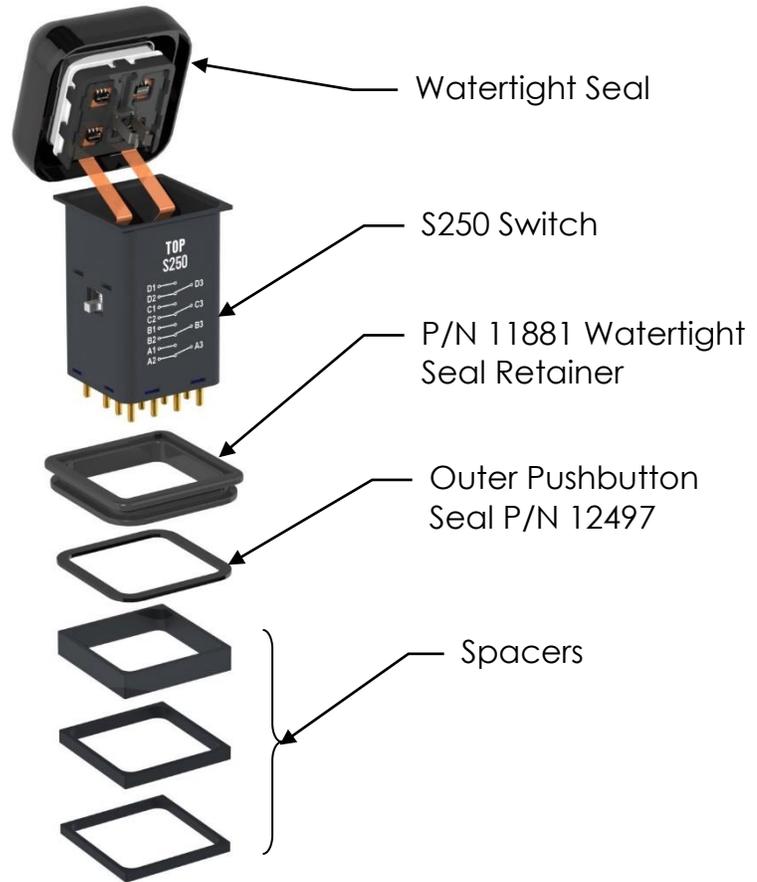


Figure 2 – Pushbutton Switch Assembly



Figure 3 - Rolled back skirt position

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TB-231

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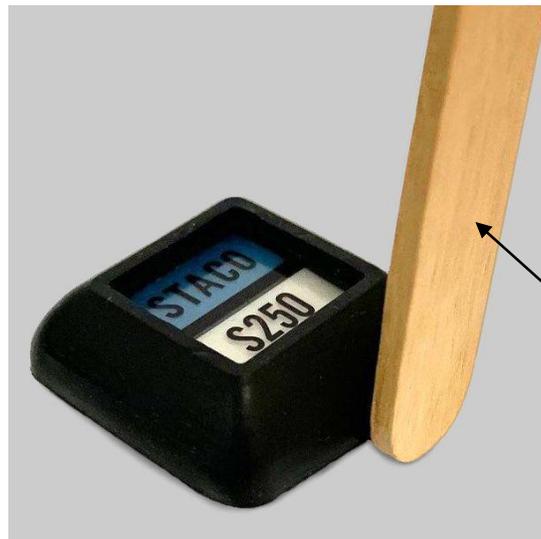
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SHEET 4 OF 6



Craft stick used to push seal in place.

Figure 4 - Switch/pushbutton with watertight seal in installed position

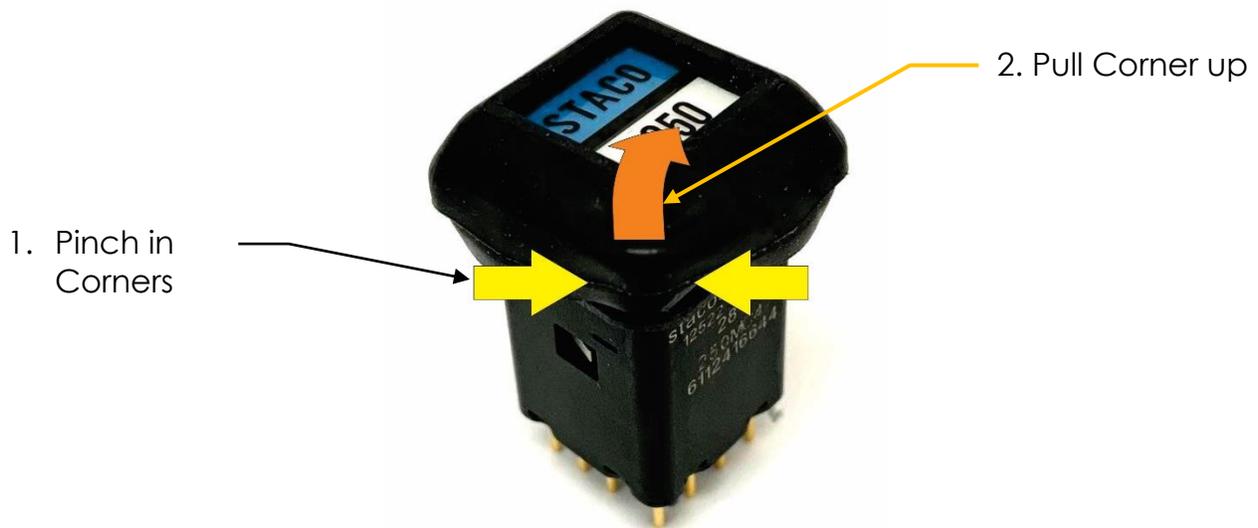


Figure 5 – Removal of Watertight Seal

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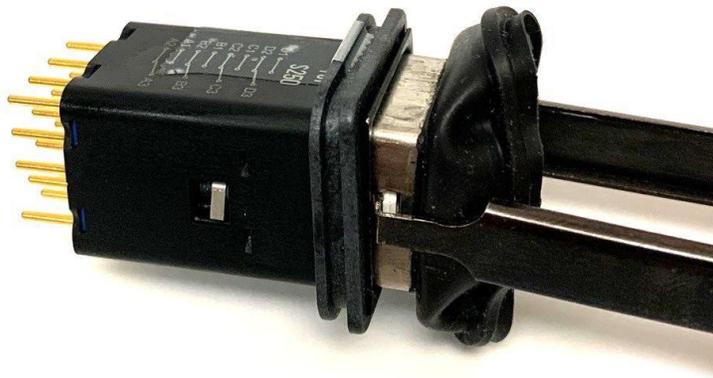


Figure 6 – Removal of Pushbutton

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SHEET 6 OF 6