

Cutting Dual Shafts

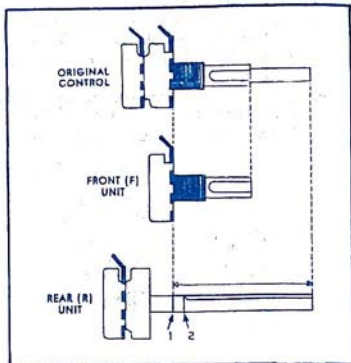
Cut off shafts of Fastatch units to same length as original control and remove all burrs.

Front Unit:

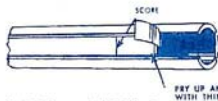
Measure shaft length from mounting surface not from end of bushing.

Rear Unit:

1. Use this groove to measure from in determining correct inner shaft length when assembling with carbon front units. (F-1, or F-3.)
2. Use this groove in measuring inner shaft length with wirewound front unit (F-7.)



Fitting All Knob Types



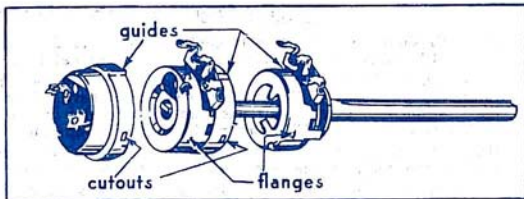
Front "F1" and "F3" brass sleeve shafts will fit all knobs designed for flatted shafts and many popular double and single slotted knobs. For

difficult-to-fit metal knobs, use a small "rat-tail" file to reduce the projections on inside of knob to allow knob assembly. A thin-nose pliers may be used to carefully rip or peel metal to the scored line on the shaft for use with double or single slot knobs. Burred edges must be filed smooth before assembly of front and rear controls.

Rear "R2" and "R4" brass shaft controls and blue shaft controls will fit all push-on and setscrew knobs without adjustment. For slotted and split knurl knobs, drill out hole with size "A" drill and use adapter spring included in the Series R (rear) Fastatch controls.

Assembling F and R Fastatch[®] Units . . . "It's a Snap!"

F and R controls can be assembled with terminals "in line," as illustrated, or 180° apart. To assemble dual concentric controls insert shaft of the "R" (rear) unit into the hollow shaft of the "F" (front) unit. Line up guides (see illustration). Ignore the alignment "pimple" and "slot" behind the terminals if the controls are to be assembled with the terminals 180° apart. Push both front and rear units together until they snap and are locked. Apply pressure to the bushing-plate assembly only, NOT to the phenolic terminal plate.



Attaching new RED LABEL* "KR" Fastatch® Switches to Red Label* Fastatch® Radiohms® B, AB, R, SR and STR

- Remove the Red and White label from the rear of the control.
- Looking at Control from the shaft end with terminals down, rotate shaft to extreme clockwise end of rotation.
- Insert enclosed rubber ring into KR switch before assembly to assure snug fit between control and switch cover. Be sure ring is completely down to flange for best results.
- Place the switch cover over the rear end of the control, keeping guides in line with each other.
- Push switch cover and control together until the small cutouts in the cover click into the corresponding flanges of the control.

*Red label switches attach only to red label controls.

Wiring Fastatch® Switch Covers



Note: All switch contact symbol views are with switch assembled to control and shaft in extreme counter-clockwise position.

Switching Arrangements for KR2/KR7 and B60S/B70S

Follow Directions Below in Wiring Red Label KR Fastatch Switches

SPST — Connect terminals 1 and 2 or 3 and 4.

DPST — Connect terminals 1 and 2 (Pole One) 3 and 4 (Pole Two).

3 Point — Connect terminals 1 and 4 for one point, terminals 2 and 3 become other two points.

KR3 — With Jumper between terminals 1 and 4 or 1 and 3 SPDT Switching is obtained.

KR6 — Terminals 1 and 2 are switch lugs, terminal 4 is a dummy lug, terminal 3 is omitted.

**Adashaft®
Assembly**



Adashaft® Assembly Instructions

The stub shaft on the Adashaft control can be used as is, or extended by using any of the "AK" Shafts shown in the current Centralab catalog.

Select an "AK" Shaft of the same type and adequate length as the original control. Insert the pilot end of the shaft into the stub shaft hole of the Adashaft control, keeping the straddle mill of the shaft lined up with the slot in the stub shaft. Lightly tap the end of the shaft until the "C" ring on the control snaps into the mating groove of the shaft.

Using the measurement of the original control from mounting surface to end of shaft, cut off new shaft to the same length as original control.

Use Centralab SK-2 Shaft Cut tool for accurate shaft cutting to 1/64 of an inch.

Form 42-470R 8-61

Litho in U.S.A.