



SECTION 1025B:

TYPE B NEMA 4 HEAVY DUTY TREADLE OPERATED FOOT SWITCH SERVICE BULLETIN

DESCRIPTION:

This is a one-direction treadle-operated foot switch. The switch is supplied as a factory-built option with either one or two precision unit switches and with or without a half or full down treadle latch. Each precision unit switch has a normally open and a normally closed circuit. The contacts are designed to open and close either alternating current or direct current pilot circuits.

INSTALLATION:

This foot switch may be mounted in any convenient position. When installed, it will give a long-life service with a minimum amount of service/maintenance.

ADJUSTMENT:

FOOT SWITCHES WITHOUT SECOND STAGE FEEL SPRINGS

The foot switch is adjusted at the factory to operate the contacts at approximately one-fourth of the total motion of the treadle lever. No field adjustments should be necessary. The adjustment of the range of contact operation is made with the socket head screw (item 17). To make the switch operate later (longer travel of the treadle), turn the screw a fraction of a turn counterclockwise.

LATCH:

The foot switches equipped with a half down latch are devised so as to engage and hold the treadle lever when the treadle is depressed approximately one-fourth of the total travel of the treadle lever. The contacts are set at the factory to operate when the latch is engaged. Depress the latch to release the treadle lever.

The foot switches equipped with a full down latch, are arranged to engage and hold the treadle lever when the treadle is depressed to the end of its travel.

The latch may be made inoperative as follows:

Face the treadle end, depress the latch lever, and move the latch toward the treadle end. This locks the latch in the latch free position. To restore the latch to the normal position, push the latch lever toward the switch enclosure.

The latch lever may be installed on the left-hand side if desired; to do so, remove the hex screw, washer, and spring (see item 11). Reassemble the items on the left-hand side.

FEEL SPRING (WHEN SUPPLIED) HALF DOWN TREADLE POSITION

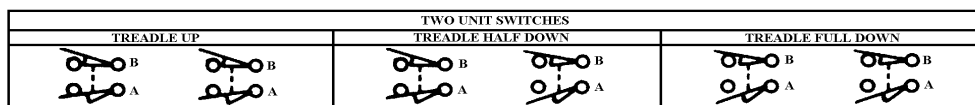
The foot switches equipped with a feel spring are normally assembled at the factory with a "light" feel spring. A medium and a heavy spring are available if required. A rectangular plate on the bottom of the limit switch retains the feel spring.

PRECISION UNIT SWITCH

The precision unit switches assume the contact positions shown below when installed in the foot switch. Connections to the terminals in each unit switch must be of the same polarity.



FOOT SWITCHES WITH OR WITHOUT HALF DOWN LATCH



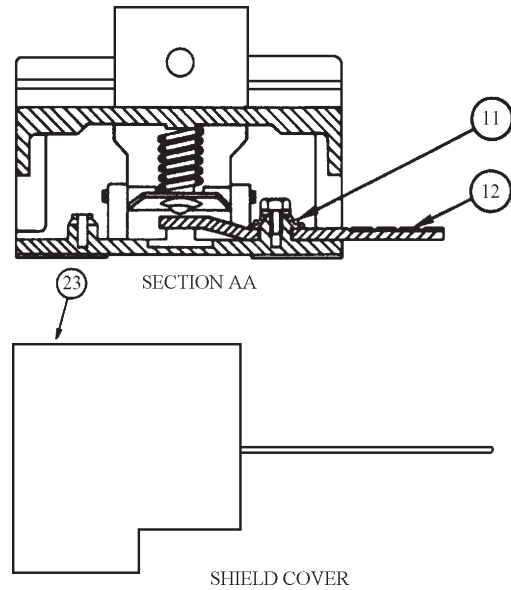
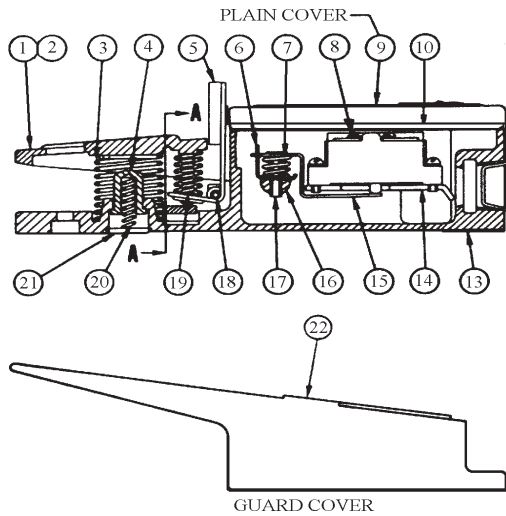
FOOT SWITCHES WITH OR WITHOUT LATCH AND WITH SECOND STAGE FEEL SPRINGS

LUBRICATION

The limit switch was lubricated at the factory and should not require lubrication for the life of the switch.

WARNING: THIS FOOT SWITCH SHOULD ONLY BE USED WHERE POINT OF OPERATION GUARDING DEVICES HAVE BEEN PROPERLY INSTALLED SO THAT IT IS IMPOSSIBLE FOR THE OPERATOR'S HANDS OR FINGERS TO REMAIN WITHIN THE POINT OF OPERATION DURING THE ACTUAL MACHINE CYCLE.

SECTION 1025B:



Item No.	Description of Part	Number Required		Part No.
		Without Latch Lever	With Latch Lever	
1	Treadle	1	1	A0054300
2	Spring pin (not shown) used with items 1 and 16	2	2	04564032
3	Spring	1	1	04581008
4	Plunger (use with item 20)	When Used	When Used	M0651900
5	Latch - half down	...	1	SD0317400
	Latch - Full down	...	1	SD0317401
6	Bracket	As Req'd	As Req'd	S0070200
7	Spring	As Req'd	As Req'd	04581004
8A	Precision unit switch S.P.D.T.	As Req'd	As Req'd	1950-1-B-A-D0
8B	Precision unit switch D.P.D.T.	As Req'd	As Req'd	1950-4-B-A-D0
8C	Air switch	As Req'd	As Req'd	04537014
9	Cover, plain (includes gasket item 10 and cover screws)	1	1	SD0317200
10	Gasket	1	1	S0068800
11	Spring	...	2	04581007
	Screw #8-32 x 5/16" long	...	1	04560066
	No. 8 lockwasher	...	1	04563026
	No. 8 washer	...	1	04563032
12	Latch lever	1	1	S0069700
13	Case	1	1	A0054100
14	Mounting Plate	1	1	S0069400
15	Lever	As Req'd	As Req'd	C0743500
16	Shaft	1	1	M0651300
	"O" ring	2	2	04582005
17	Flat head screw #10-32 x 7/8" long	As Req'd	As Req'd	04560062
18	Spring pin	...	As Req'd	04564035
19	Spring - Inner	...	1	04581011
	Spring - Outer	...	1	04581012
20	Spring - Light	As Req'd	As Req'd	04581009
	Spring - Medium			
	Spring - Heavy			
21	Feel spring retaining plate	When Used	When Used	C0743200
22	Guard cover (includes gasket item 10 and cover screws)	1	1	SD0317300
23	Shield cover, stamped (incl. gasket item 10 & cover screws)	1	1	SD0317700
24	Safety gate for shield cover *Ultra guard only.	As Req'd	As Req'd	C0743701



1080 N. Crooks Road • Clawson, MI 48017
 800-635-0289 • 248-435-0700 • Fax 248-435-8120
 www.ametekapt.com • www.ametek.com

530A
 1025B.I2R
 4/02.Z73
 1M