

**HIGH FREQUENCY CAM SWITCH REPAIR KIT**

Part No. 003-0708-00

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## HIGH FREQUENCY CAM SWITCH REPAIR KIT

Repair Kit, PN 003-0708-00, provides parts and instructions for replacing one to ten High Frequency contacts used in High Frequency Cam Switches.

## PARTS INCLUDED IN REPAIR KIT:

<u>Quantity</u>	<u>Part Number</u>	<u>Description</u>
1 ea	003-0713-00	.125 drill (1/8")
1 ea	003-0714-00	.059 drill (#53)
1 ea	003-0715-00	Pin Vise (.025 - .075 DIA)
1 ea	003-0716-00	Pin Vise (.045 - .135 DIA)
1 ea	003-0717-00	3/32" Hex spin-tight
1 ea	062-1568-00	Data Sheet for 003-0708-00
10 ea	131-1030-00*	Contact, switch
10 ea	131-1031-00	Contact, cam
10 ea	211-0160-00	Screw, Fil. Hd, 0-80 X .188
10 ea	220-0691-00	Nut, Hex, 0-80

\* Extra contacts and hardware can be ordered as required.

## CAUTION: OBSERVE THE FOLLOWING!!

- A) Make certain all of the metal chips resulting from drilling are removed from the circuit board surface and all other areas of instrument.
- B) After installing the new contact(s), CHECK CONTACT ALIGNMENT.

## INSTRUCTIONS:

- ( ) 1. Remove the cam actuator from the circuit board (refer to your Instruction Manual for removal and installation procedure). Remove only sliding actuator from slide switches.
- ( ) 2. Using the .125 drill, clamped in the pin vise, remove rolled flange of rivet. A #6 or #8 pan-head or truss-head screw inserted into the end of the pin-vise will make rotation easier on the palm of the hand. If rivet rotates in the circuit board, hold the pin-vise at a slight angle and continue drilling until the rivet flange is removed. Be careful not to drill into the circuit board.
- ( ) 3. Using needle-nosed pliers remove the cam-contact by gripping the tin plated spring beam and peel back towards riveted end. Do not remove solder at the riveted end by heating. Heat may cause solder to spread onto area that should be flat for proper mounting of replacement contact.

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- ( ) 4. Remove the switch-contact on the opposite side of the board by gripping the tin plated spring beam with needle-nosed pliers and work the contact loose from the solder joint and pull the rivet through the board. If the switch-contact is not used or if rivet cannot be pulled through the board, remove by tapping the rivet through the board with a punch or scribe.
- ( ) 5. Using the .059 drill clamped in the pin-vise, carefully ream out the contact mounting hole.
- ( ) 6. Install the new contact(S) using the screw and nut supplied.
  - a. In general, the screw head can be installed on either side of the circuit board unless there is a clearance problem with the height of the nut.
  - b. On some attenuator switches it may be necessary because of electrical shields to place the screw head on the switch-contact side of board.
  - c. On most slide switches the screw head must be placed on the cam-contact side of board.
- ( ) 7. Using the 3/32" Hex spin-tight, tighten the nut until the contacts are held snugly against the circuit board but not tight. Align the contacts with the appropriate circuit board pads and then continue to tighten using the spin-tight and a small screw-driver until the contacts are firmly held down and properly aligned. Tightening torque will be from 12 to 18 in-oz. Overtightening can cause the screw or nut to imbed in the board, damaging the contact.
- ( ) 8. Check the switch-contact for noticeable wiping action against the circuit board pad. Check the cam-contact for proper lobe height of .125" to .150" from circuit board surface. Resoldering of tin plated spring beam at rivet is not necessary.

