NO. 52A AND 52B HEAD TELEPHONE SETS
MODIFICATION TO PROVIDE A ROTATION STOP BAR

1. GENERAL

1.01 This section covers the procedures for modifying the No. 52A and 52B head telephone sets to provide a rotation stop bar.

1.02 The modification consists of mounting a rotation stop bar on the transmitter arm of the No. 52A or 52B head telephone set. The stop bar limits the rotation of the transmitter arm in the receiver case and prevents undue strain on the cord connections.

1.03 The rotation stop bar can be added,without replacing the transmitter arm assembly, only to the No. 52A and 52B head telephone sets manufactured after the second quarter of 1947. On the earlier type sets, the distance between the free end of the transmitter arm and the terminal block mounting hole is shorter than that required for mounting the stop bar and in order to use the stop bar, it will be necessary to order a complete No. 55A transmitter arm (equipped with the stop bar) and to replace the transmitter arm in accordance with Section 028-360-811.

1.04 Names of parts shown in parentheses on the figure should not be used for ordering information. The stop bar, terminal block shells, and clamping screw are the only parts which should be ordered to make this modification.

2. LIST OF TOOLS AND MATERIALS

CODE OR SPEC NO.	DESCRIPTION
TOOLS	
KS-6854	3-1/2 Inch Screwdriver
R-1005	Jeweler's Screwdriver
—	Hand Drill, North Bros. Mfg. Co. No. 1446 (or equivalent)
—	No. 44 (0.086-inch diameter) Twist Drill
MATERIALS	
P-294004	Screw
P-11E207	Stop Bar
P-12E915	Shell (without code marking)
P-12E916	Shell (with code marking)

3. PROCEDURE FOR MOUNTING THE ROTATION STOP BAR

3.01 Loosen the end cap assembly screw with the KS-6854 screwdriver and remove the end cap assembly from the free end of the trans-

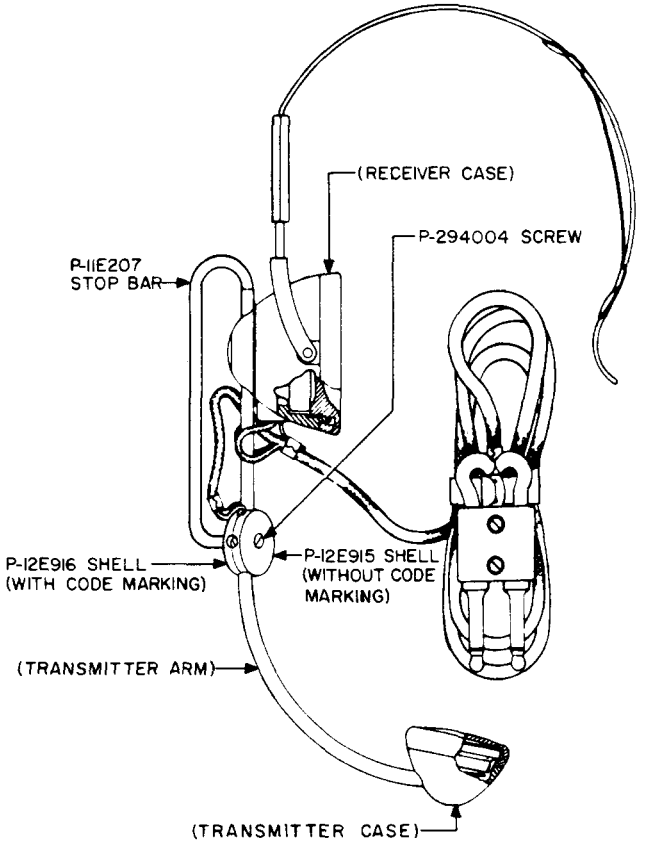

Fig. 1 – No. 52A or 52B Head Telephone Set Equipped With a Stop Bar

mitter arm. Remove the terminal block clamping screw and nut, using the R-1005 screwdriver, and remove the shells. Discard the end cap assembly, the shells, the screw, and the nut.

3.02 At this time attempt to insert the new P-294004 screw into the hole in the transmitter arm tube. If it will not easily go through the hole, proceed as follows. Disconnect the cord from the binding posts by backing off the cord clamping screws with the KS-6854 screwdriver and remove the cord terminals. Place the transmitter tube in a vise, taking care not to damage the tube and the cord. If necessary, remove the receiver case assembly. Drill out the hole in the transmitter tube, using the No. 44 twist drill. Again try the screw, this time it should enter easily.

3.03 Remount the receiver case assembly if removed. Insert the cord terminals from the outside of the transmitter arm into the holes in the binding posts so that the smooth surface of the metal tip is in contact with the screw. Take care that the cord tips are seated on the bottom of the binding post holes, then tighten the screws securely.

3.04 Place the new shell halves on the binding posts. Make sure that the shell without the code marking is on the side toward the transmitter case. Position the shell halves so that the holes in the shell halves and the hole in the transmitter arm tube are in alignment. Insert the P-294004 screw into the hole in the shell half without the code marking, through the hole in the transmitter arm tube and partially into the other shell half.

3.05 Insert the solid end of the rotation stop bar into the free end of the transmitter arm tube and the threaded end of the stop bar into the hole in the terminal block shell with the code marking. Insert the P-294004 screw into the threaded end of the stop bar. Tighten the screw securely, using the KS-6854 screwdriver.