TITLE
ASSEMBLY AND TEST INSTRUCTIONS
FIRST MADE FOR J FRAME BRIDGE

REVISIONS
6 REDRAWN, ECNRP02-005 JOHN CANNON, Aug. 12, 2002

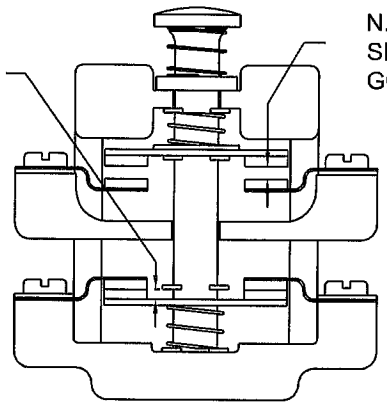
SPECIAL PURPOSE INTERRUPTERS PER 246B2323AA G1, G2 and G4 ALSO

SPECIAL PURPOSE CONTACTORS PER DS304M07GF032DXT (246B2323 G3), AND 246B2323AAG5 and G6.

1. General instructions for all configurations

1.1 Verify that the universal interlocks have been adjusted prior to installation per SI214501E0009 for the IC2956A200 silver faced interlock or SI214501E0009A for the IC2956A205 gold faced interlock. Reference figure 1.

N.C. WIPE
SILVER: 0.046 MIN., 0.085 MAX.
GOLD: 0.055 MIN., 0.085 MAX



N.O. GAP
SILVER 0.078 MIN., 0.125 MAX.
GOLD: 0.078 MIN., 0.110 MAX.

FIGURE 1

1.2. Verify that the main contact tips align within .06 inch side to side and lengthwise. Bend the stationary contact assembly or shift in mounting holes as required while making sure that the attached arc runner is kept parallel to the base and the terminal is square to the base. Reference figure 2.

1.3. Silver solder is used to join the main contact tips. Excess may flow onto the mating surface. The movable contact must not mate with solder anywhere or else it may stick closed in service. Verify that the contact tips have no solder on the mating faces.

1.4. Verify that the movable contact tips pivot freely with the arc chute installed. The minimum clearance to the arc chute walls is .09 inch.

1.5. With the base in a vertical plane, remove the opening springs and verify that the armature will still open by gravity to its stop. The armature may rebound and retain a maximum gap of .13 inch to its stop. If necessary form the shunt or replace if too short.

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1.6 Torque hardware per SI214501E0003, SECTION 3, SH 1:

#8 screws (in plastic)	15-30 in-lb
1/4-20	55-90 in-lb
5/16-18	100-200 in-lb
3/8-16	200-300 in-lb
1/2-13	50-125 ft-lb

The insulated interlock operator must be held with a tool to tighten; do not hold by hand. There is not a torque value. Confirm by attempting to unscrew the insulated operator by hand.

2. High Speed, 2500 ADC interrupters per 246B2323AA G1 and G4, and high speed contactors per G5 and G6.

2.1. With the coil energized, main contact wipe must be between .16 and .23 inch. Shim to adjust. Use no more than 6 shims. Reference figure 2.

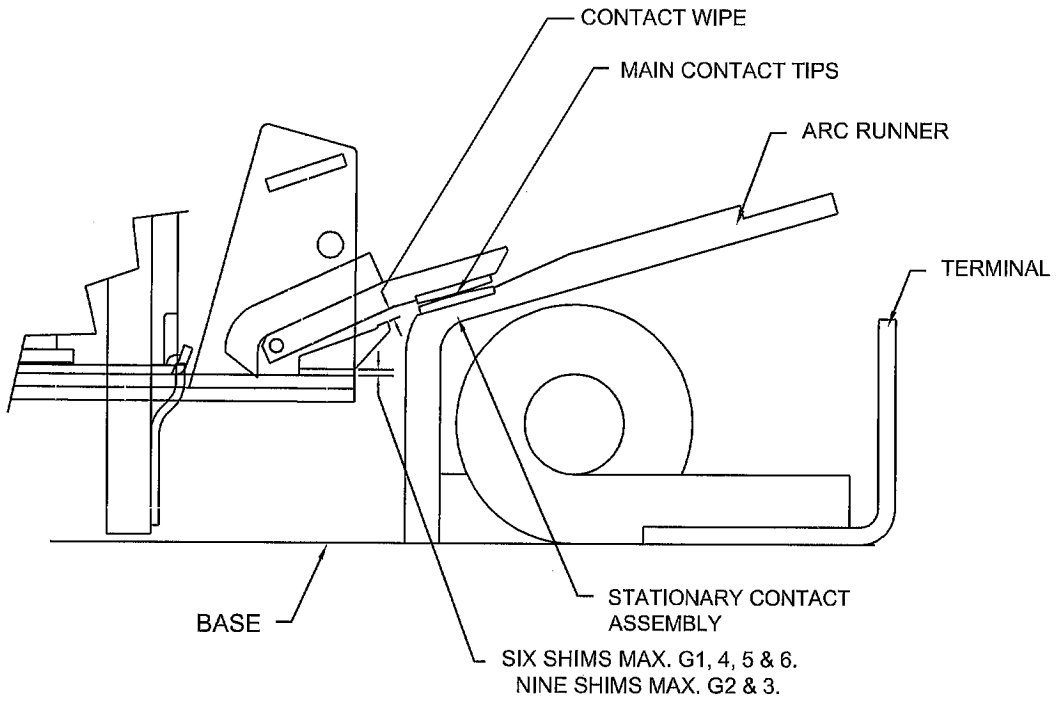

FIGURE 2

2.2. With main contact wipe adjusted, hold the interrupter/contactor in the kiss position by pulling the armature toward the coil. Adjust the interlock operator so that it touches the interlock plunger within +/- 0.010 inch. Energize the coil and verify minimum N.O. contact wipe at .047 and minimum N.C. gap at .078. If necessary, adjust the operator to obtain the minimum gap and wipe. Finally verify that there is at least .063 interlock stroke remaining with the coil energized by inserting a .063 spacer between the interlock operator and interlock plunger. Reference figure 3.

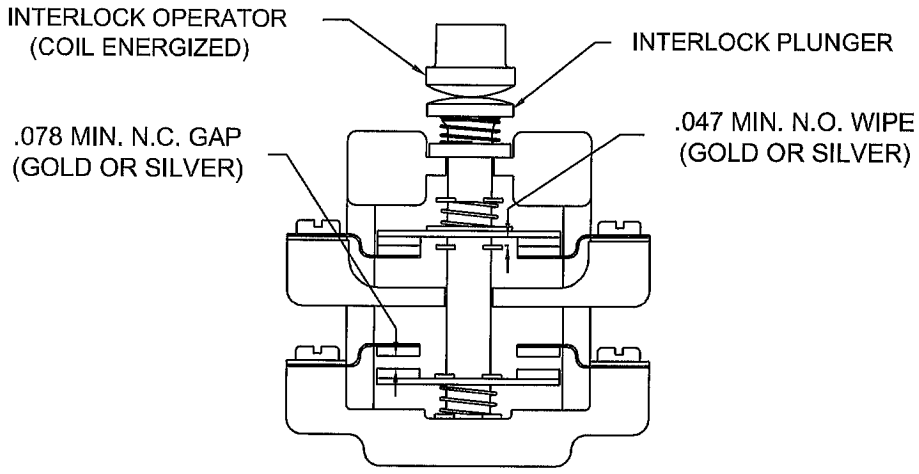

FIGURE 3

2.3. Test pick up from the full open position at 63 % of 105 VDC or 66 VDC maximum with the coil at room temperature. To avoid the effect of coil heating, measured cold coil resistance and pick up current can be multiplied by resistance to obtain pick up voltage. The coil is not continuously rated; do not leave power on for more than 30 sec.

Note: In the event that pick up is high and cannot be corrected by eliminating binding or reducing wipe, the armature stop may be shimmed to reduce contact gap and pick up voltage. Although not a routine setting, the armature stop may be shimmed to reduce this gap to .70 inch. This method cannot be used to correct a interrupter/contactor that stalls at the kiss position.

2.4. Test drop out from the sealed position by slowly reducing the current to .90 amps DC. Drop out must not occur above .90 amps DC.

Note: The sealed contact force at the contact center line is 27 pounds (22 pounds at the contact edge) or about twice the standard size 7 contactor. The G5 contact force will be less since its shunt is thinner (standard size 7). Audit as required if pick up or drop out values are too high.

2.5. HiPot between the shorted coil leads and the interrupter frame for 60 seconds. Do not allow coil leads to touch the frame.

G1, G5 and G6: Hi Pot at 2200 VAC
G4: Hi Pot at 5000 VAC

3. Standard speed, 2500 ADC Interrupter per 246B2323AA G2 and the special purpose contactor per DS304M07GF032DXT (same as 246B2323AA G3):

3.1. With the coil energized, contact wipe must be between .09 and .15 inch. Use no more than 9 shims. This interrupter/contactor may not pick up if the wipe is grater than .15 inch. Reference figure 2.

3.2. Energize the coil and adjust interlock gap and wipe. Reference figure 4.

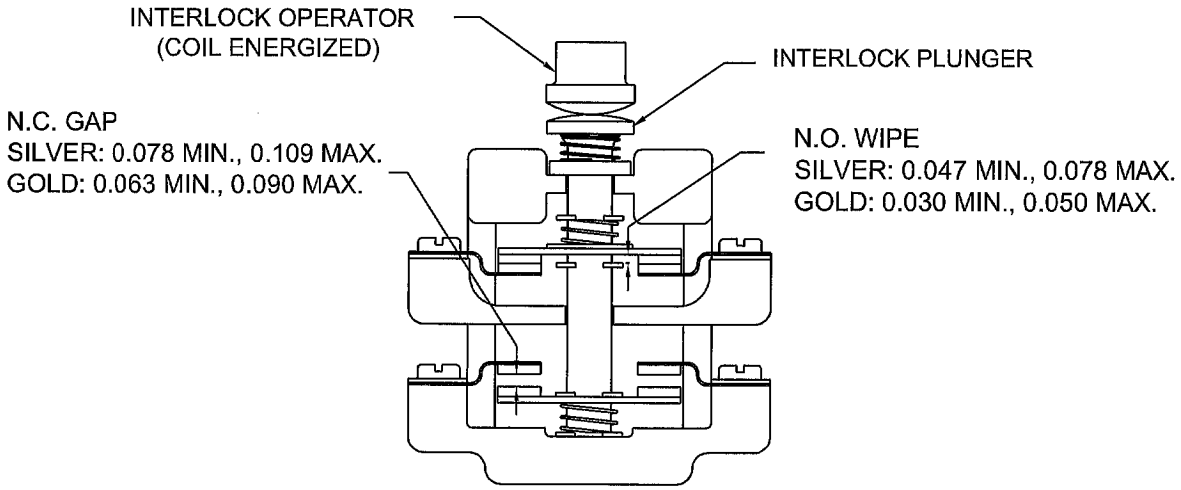

FIGURE 4

3.4. Test pick up from the full open position at 63 % of 105 VDC or 66 VDC maximum with the coil at room temperature.

Note: The sealed contact force at the contact center line is 13 pounds or about the same as the standard size 7 contactor. Audit spring function as required if the contactor fails to pick up.

3.6. HiPot between the shorted coil leads and the interrupter frame at 2200 VAC for 60 seconds. Do not allow coil leads to touch the frame.