

1. General

These technical requirements deal with limited switches and also specify requirements for their manufacturing and acceptance.

II. Technical requirements

A. Requirements for micro-switches

2. Before mounting micro-switches into the limit switches, visually check them for physical damage and availability of stamps or documents to certify their acceptance at manufacturing factory and indicate that their guaranteed storage period has not expired.

6. Requirements for mounting

3. Solder by using acid-free flux prepared as per UUL-1119. Never use acid or tinol.

4. Remove the remains of flux by ^{using} ~~pin~~ up, the soldered joints with spirit.

5. To prevent overheating of elements during soldering observe the following requirements:

- a) Power of the soldering iron should not exceed ~~Power~~ 70 W.
- b) Continuous heating time during soldering should not exceed 5 seconds.

6. After soldering the micro-switch, remove protective card-board gaskets from the terminals.

7. Coat soldered joints with red varnish HU-62, OCT 6_10-391-74.

B. Requirements for electric check

B. Insulation resistance of insulated circuits with respect to ground and between themselves should be at least 2 Megohms during testing in shop conditions at a temperature of $+20^{\circ} \pm 5^{\circ}$.

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9. Check for proper electric wiring of assembled limit switch ~~by~~ by checking the circuit for continuity as per wire termination ~~the circuit for continuity as per wire termination~~ table given in the drawing.

Γ. Mechanical requirements

10. Assembled and adjusted limit switch should withstand 10,000 switchings with a frequency of 12 switchings per minute.

Jamming and failures are not permitted.

11. Rod of the push-type switch and spring-loaded plunger of the rotary switch in the limit switch should resume initial position without jamming and seizing after operation.

III. Acceptance rules

1.2. To check the limit switch for compliance with these technical requirements the following tests are performed:

- a) Acceptance test.
- b) Periodic test

Tests as per items 8, 9, 11 refer to acceptance test. Tests as per item 10 refer to periodic tests.

13. Every switch is subjected to acceptance tests.

14. One rotary switch and two push-type switches from first batch are subjected to periodic test once in 6 months.

Note: When new production is started (during first 6 months) periodic test is performed atleast once in two months.

15. Limit switches ^{are} selected for periodic test from the switches which have passed the acceptance test by the customer's representative in the presence of TID representatives.

IV. Test procedures

16. Check as per item 8 (insulation resistance) with megohmmeter M1101M for 500v according to the wire termination table given in the drawing.

Take the readings after the instrument pointer assumes a stable ~~position~~ position.

17. Check as per item 10 (reliability test) on a special stand providing for on/off switching of the limit switch with a frequency specified in item 10.

To this end, check the operation as limit switch in the NO and NC contacts as microswitch connected to the ~~passer~~ power source of 26 ⁺³_{-4v} DC. Limit switches which have failed to ~~passed~~ ~~passed~~ periodic test are rejected and are not to be further used.

In case of the limit switch failure, the manufacturer works jointly with the Chief Designing Engineer Department, TID and customer's representative to find the cause of failure and in each particular case a decision is taken whether the limit switches are to be further used.

18. Check as per item 11 by pressing the push-type switch and rotating the spring-loaded plunger as rotary switch till they operate and slowly the rod and spring-load plunger resume their initial position. This type of checking is performed atleast 50 times for each switch.