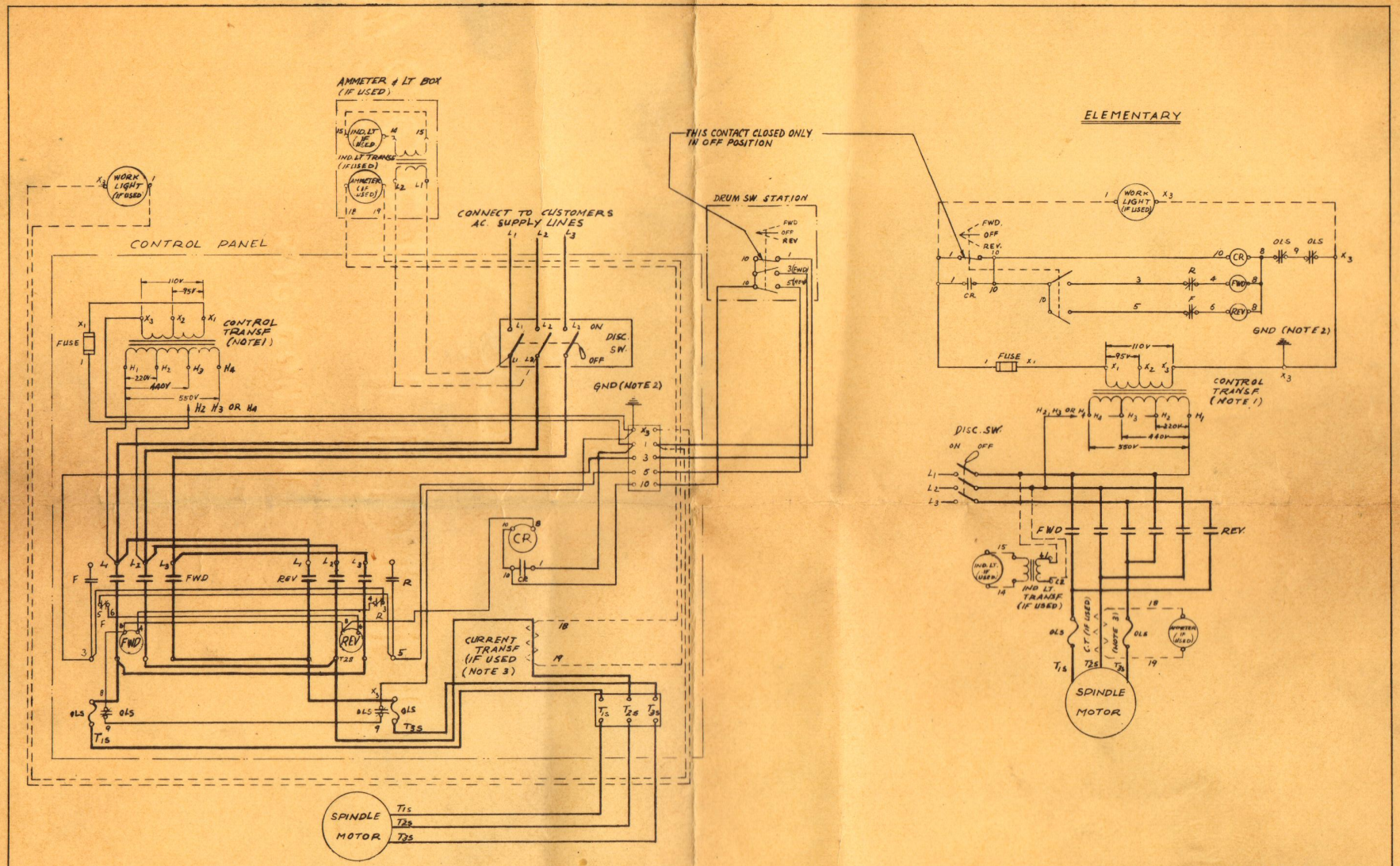


NOTE 1 - FOR TRANSFORMER WITH DUAL VOLTAGE PRIMARY CONNECT AS FOLLOWS
WITH 220 VOLT SUPPLY - CONNECT H_1 & H_3 TO L_1; H_2 & H_4 TO L_2
WITH 440 VOLT SUPPLY - CONNECT H_1 TO L_1; H_4 TO L_2; H_2 TO H_3

NOTE 2 - TO BE GROUNDED BY PURCHASER IF CONDITIONS PERMIT

NOTE 3 - CURRENT TRANSFORMER FOR MOTOR LOAD PER CENT AMMETER MUST BE CALIBRATED ACCORDING TO FULL LOAD AMPERES SHOWN ON MOTOR NAME PLATE. IF A CALIBRATED SELF CONTAINED AMMETER ONLY IS USED CONNECT IN SERIES WITH T2S

NOTE - FOR 2 PHASE 3 WIRE SERVICE L_2 & T_2 ARE THE COMMON.

LIMITS OF FRACTIONAL DIMENSIONS ARE + OR — 1/64 UNLESS OTHERWISE SPECIFIED.

DRAWING OR PART NAME	WIRING DIAGRAM — STD (DRUM) CONTROL W/O COOLANT 3 PHASE OR 2 PHASE, 3 WIRE
MACHINE	10"x12"x48" TRAY TOP LATHE MODEL "LE"
UNIT	ELECTRICAL
QUAN.	
MATERIAL	
MAT'L. SIZE	
HEAT TREAT	
DRAWN BY / DATE	
DRAW. CH. BY / DATE	
TR. BY / STDS.	
TR. CH. BY / APPROVED	
SUPERSEDES	602805
SUPERSEDED BY	
SCALE	
DRAWING NO.	603721
ASSEM. NO.	

CINCINNATI LATHE & TOOL CO.
CINCINNATI 9, OHIO, U.S.A.

LETTER	NOTICE	DATE	CHANGE
	W-944		SUPERSEDES

Bulletin 806 Style B Rotary Pilot Switches

A group of Bulletin 806 switches showing various constructions and types of handles. At left is a switch arranged for cavity mounting.

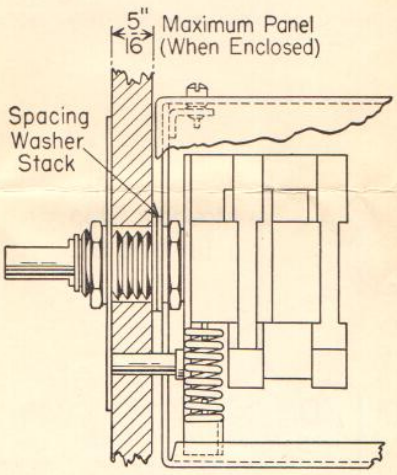
Conversion of Surface-Mounted Drum Switches to Panel or Cavity Mounting

The standard Surface-Mounted, Cam-Operated Bulletin 806, Style B is provided with a stack of spacing washers that makes it adaptable to either panel or cavity mounting. The enclosure (base frame with cover) is a standard part of all Bulletin 806's. Where the open-type construction is required, the cover and base frame can be discarded, providing the switch has 6 cam sections or less. With more than 6 cam sections, the base frame must be kept, since it supports the rear plate of the drum.

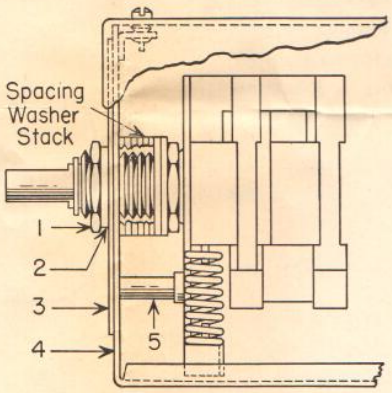
The following steps show how the standard surface-mounted enclosed drum switch can be converted to either panel or cavity mounting: Remove the handle, lock nut (1), steel washer (2), and nameplate (3). The switch may now be withdrawn from the base frame (4). With the switch out of the base frame, remove enough washers to make the total thickness of washer stack, base frame and panel equal 7/16". This means that if the switch is mounted open, the panel may be up to 7/16" thick, but with the base frame added, panel thickness may be no greater than 5/16".

If the base frame is to be used, put the switch back in it. The pilot pin (5) will now extend through a hole in the base frame, due to removal of part of the washer stack. Finally, fit the switch to the panel and replace the nameplate, steel washer, lock nut and handle.

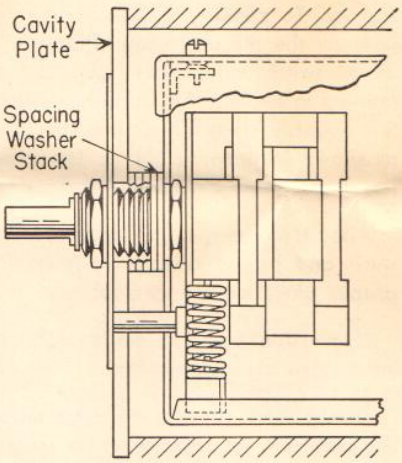
For cavity mounting, the same procedure is used, with the cavity plate substituted for the panel in the above description. The cavity plate can then be mounted by means of screws. A cavity plate can be purchased for **$4** list. Specify part No. A-22082. Dimensions for both panel and cavity mounting are shown on the reverse side of this sheet.



Panel Mounting



Surface Mounting



Cavity Mounting

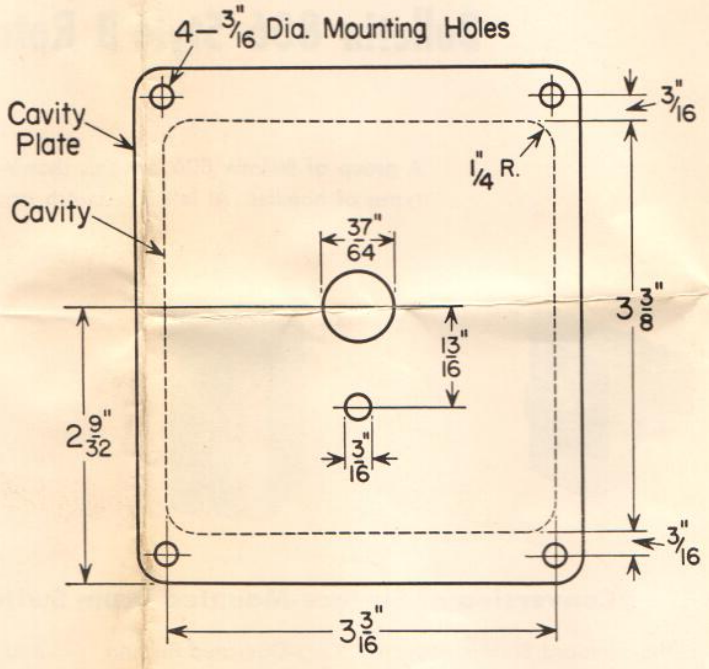
Panel Mounting Dimensions

When the drum switch is to be panel mounted, the panel must be drilled to provide the two holes shown in the center of the cavity plate. Dimensions of these holes are the same as in the cavity plate.

Cavity Mounting Dimensions

The drawing shows dimensions of the cavity plate used with Bulletin 806 Style B drum switches. Dotted lines indicate the minimum size opening for cavity mounting. When the plate is mounted with respect to the cavity as illustrated, the dimensions will assure maximum clearance on all sides of the switch.

The cavity shown here will accommodate a switch with enclosure. For an open type switch, the opening may be smaller but a clearance of at least ½" on each side must be maintained at all times.



Changing from Maintained Contact to Self-Centering (Spring Return) Operation

(Good only for single-throw or double-throw switches)

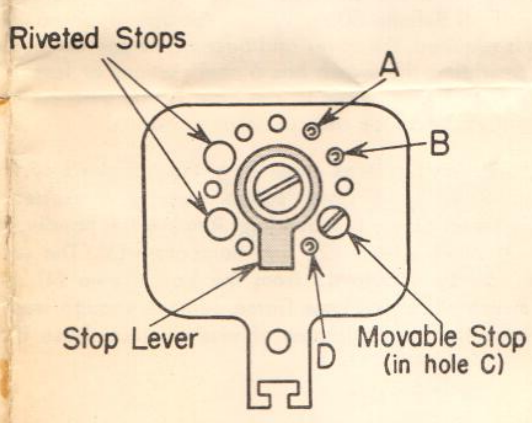
The rear support plate has 12 holes evenly spaced around the shaft opening. Two of these holes on the left side of the plate have stops riveted in them. Four holes on the right side are tapped to admit a movable stop. The location of this movable stop determines the switching arrangement with respect to single throw or double throw, maintained contact or self-centering.

Drawing No. 1 shows the switch set for maintained contact, double throw; this is how it is received from the factory. To change to spring return double throw, first unscrew the movable stop. Then, by turning the handle of the switch, rotate the shaft 180°, so the stop lever is pointed in exactly the opposite direction. Finally, replace the movable stop, this time putting it in tapped hole (B) as shown in drawing No. 2. The procedure is the same for single throw except that holes (D) and (A) are used.

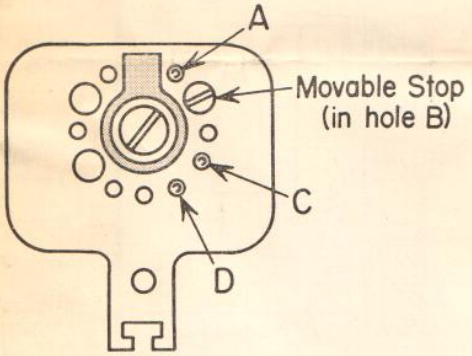
After this change, the handle must be taken off the shaft and turned around so it will again point to the proper place on the nameplate.

Conversion back to maintained contact involves the same steps as just described.

IMPORTANT: Except on large orders, switches will be shipped from the factory set for maintained contact. This means that in most cases a change to self-centering will have to be made by the user.



1. Maintained Contact—(Hole C for double throw, hole D for single throw)



2. Self-Centering—(Hole B for double throw, hole A for single throw)