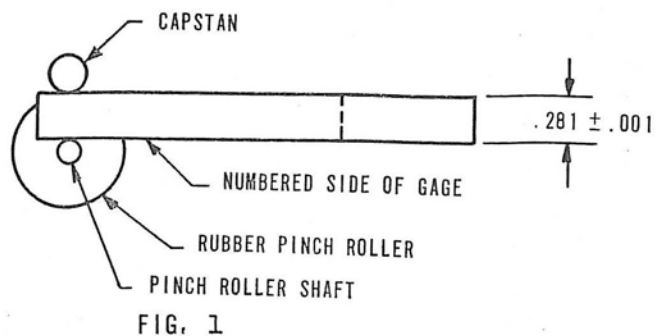


SOLENOID SHELL REPLACEMENT ON CRITERION 80 DECKS

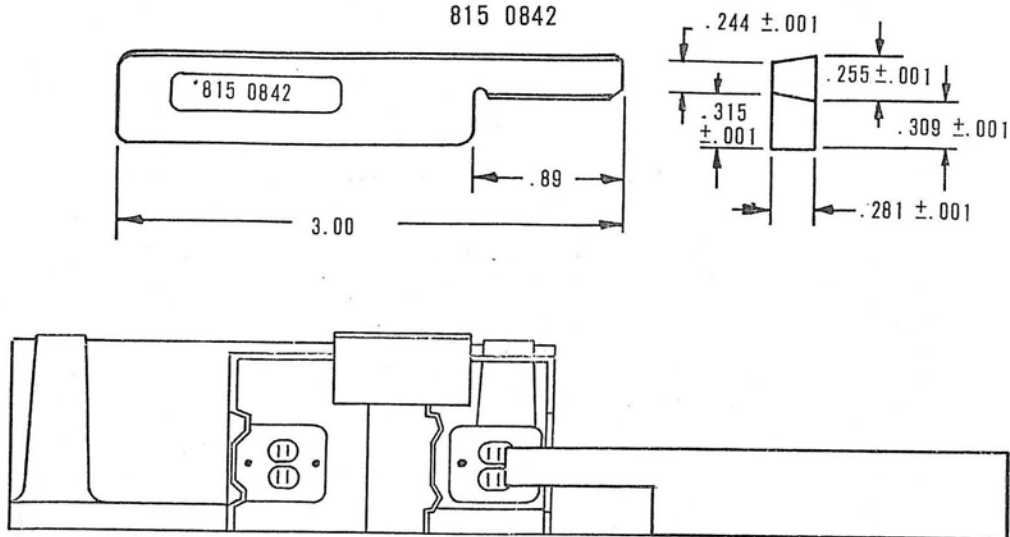
With Pentagonal Deck Opening for Pinch Roller

1. Check deck opening for pinch roller to be sure it is the type with a pentagonal, rather than a rectangular opening. Contact the Gates Radio Company for information on decks with rectangular pinch roller openings, without "LOT C" stamped on top of solenoid.
2. Use the universal Allen Wrench supplied with this kit to remove the two cap-screws used to fasten the solenoid shell to the deck.
3. Rotate the solenoid shell to expose the terminals on the side of the coil, and note the wire polarity so they can be replaced the same way on the new shell. Remove the wires.
4. Remove the old solenoid shell and lay the new one in its place; connect the wires to the new coil.
5. Mount the solenoid shell securely to the deck per Dwg. 823-1041-401 (attached) with the two cap-screws removed from the old one.
6. Remove the large set-screw, locking nut, spring and plunger cushion from the old solenoid shell and install in the same manner in the new one, with the set-screw barely started into the threaded stop on the solenoid.
7. Unlock the locking nut on the set-screw on the plate in front of the solenoid; turn the set-screw CW, if necessary, until the solenoid plunger does not "bottom" in the housing while energizing solenoid.
8. Turn this small set-screw CCW until it barely permits the plunger to "bottom" in the housing while energizing solenoid; lock the set-screw with the locking nut.
9. Adjust the large set-screw on the rear of the solenoid CW until the correct amount of pressure is obtained on the pinch roller per Fig. 1 of the attached sheet, by measurement with the 0.281" dimension of the gage supplied with this kit. Start, and measure the dimension between the top of the pinch roller shaft and the motor capstan with the 0.281" gage, and stop several times to average the readings. Allow about 5 seconds rest between stopping and restarting. When the gage is a slip fit between the shafts about half of the start times, the correct adjustment is achieved.
10. Lock the set-screw with the locking nut on the rear of the solenoid.
11. Manually push the solenoid plunger all the way into the housing to bottom it as in Step 8, above. With the solenoid plunger unpowered, it should release and the plunger return to the disengaged position. If it does not, repeat the Steps (6 thru 10) before contacting the factory.

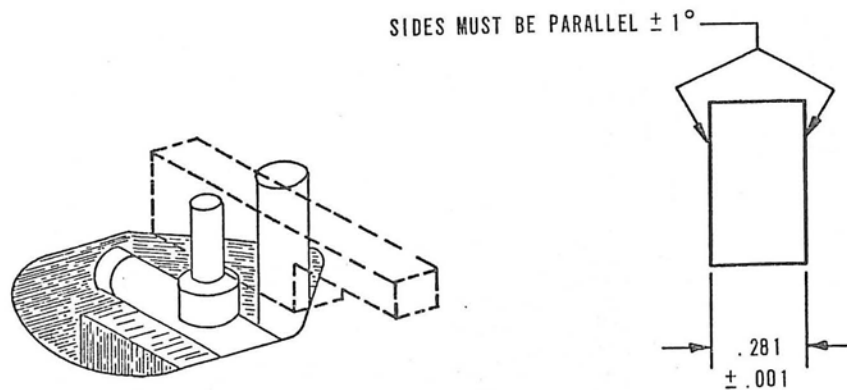
PINCH ROLLER ADJUSTMENT GAGE
LARGER PORTION OF GAGE 815 0842



HEAD/GUIDE HEIGHT GAGE
815 0842

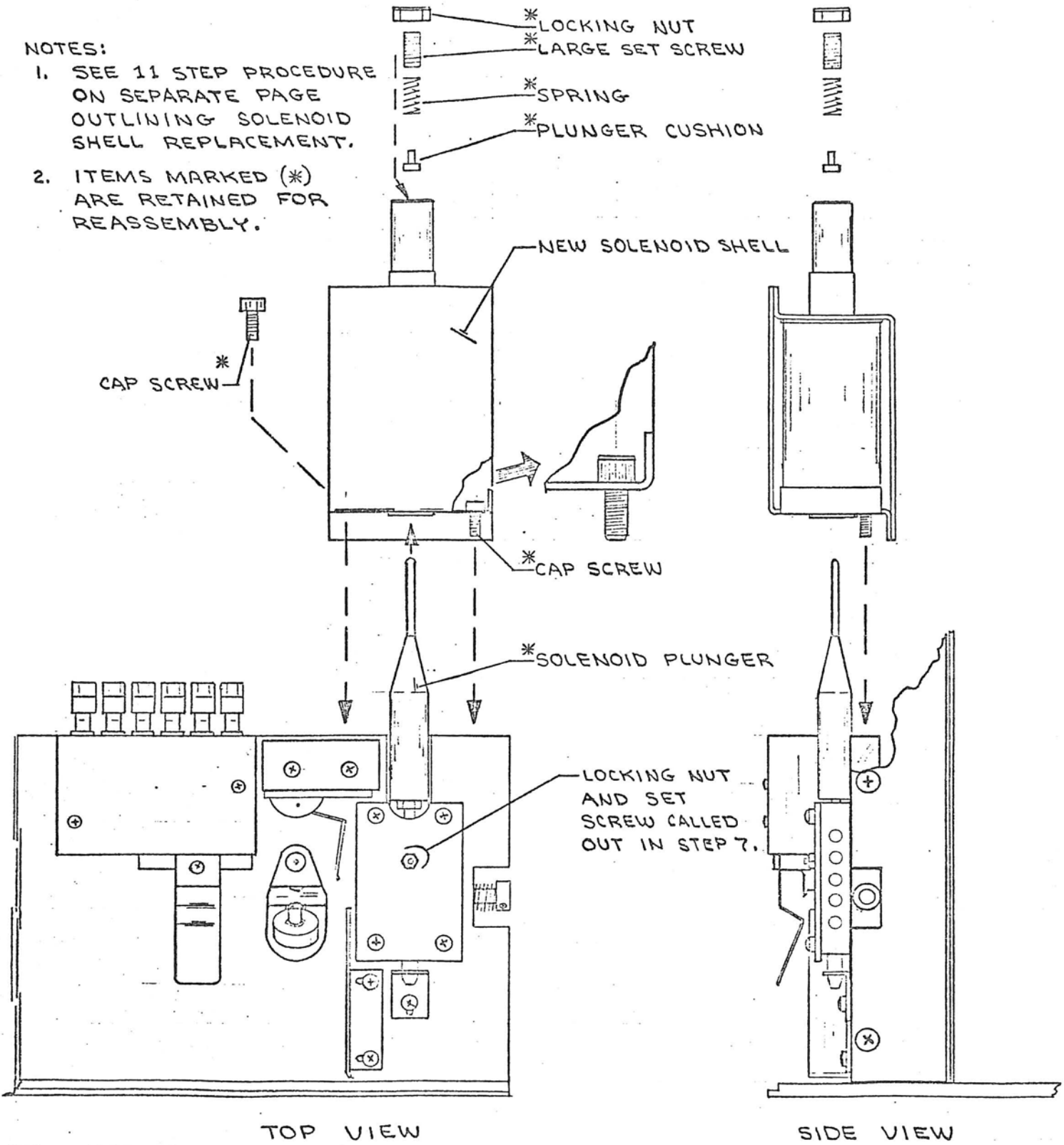


CAPSTAN ADJUSTMENT GAGE
LARGER PORTION OF GAGE 815 0842



NOTES:

1. SEE 11 STEP PROCEDURE ON SEPARATE PAGE OUTLINING SOLENOID SHELL REPLACEMENT.
2. ITEMS MARKED (*) ARE RETAINED FOR REASSEMBLY.



* LOCKING NUT
 * LARGE SET SCREW
 * SPRING
 * PLUNGER CUSHION

* CAP SCREW

NEW SOLENOID SHELL

* CAP SCREW

* SOLENOID PLUNGER

LOCKING NUT AND SET SCREW CALLED OUT IN STEP 7.

TOP VIEW

SIDE VIEW

GATES RADIO COMPANY
 DWG. NO. 823-1041-401