

**251-TYPE KEYS**  
**REQUIREMENTS**  
**(CONDENSED SECTION FOR 032-708-701)**

**1. REQUIREMENTS (Also See Section 020-012-711)**

**1.01 *Lever and Plunger Segment Movement:***  
No bind.

**1.02 *Contact Separation:*** .010" (Readj. .012").

unit with plunger of the paired unit resting against its plunger springs.

**1.05 *Contact Pressure***

(a) 150 grams (Readj. .170 grams) between normally closed contacts. 62B gauge.

(b) 50 grams (Readj. 55 grams) between normally open contacts when closed. 68B gauge.

**1.06 *Contact Follow:*** .008" (Readj. .010") for normally open contacts.

**1.07 *Flexible Spring Position***—Fig. 1(B):  
Rest on stop spring, at least on end nearest contact, when spring is unoperated.

**1.08 *Contact Sequence Requirements***

(a) ***Normal Contact Sequence Break-Make Combinations:*** Closed contacts shall break before associated open contacts make by —.005" (Readj. .006").

(b) ***Cross Sequence — Break-Make Spring Combinations on Ringing Spring Assemblies:*** All closed contacts operated by a plunger shall break before any open contacts make by .005" (Readj. .006").

**1.09 *Lever Operate Pressure:*** 420 grams, max. 1590 grams (Readj. 450 grams, max. 1360 grams). 79B and 79F gauges.

**1.10 *Lever Release:*** 75 grams (Readj. 85 grams). 62B gauge.

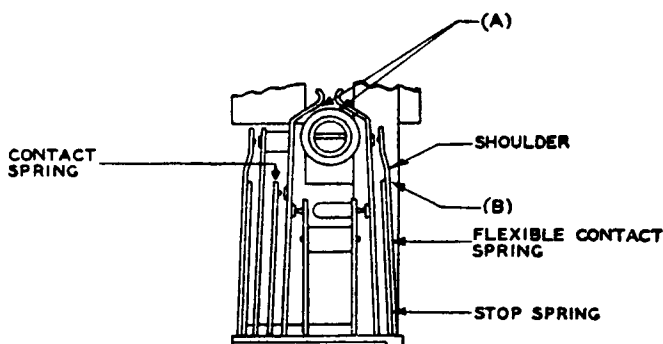


Fig. 1

**1.03 *Spring Clearance:*** Between springs designed never to make contact and between spring and frame .014" (Readj. .016").

**1.04 *Plunger Spring Clearance***

(a) Fig. 1(A): .005" between plunger springs and rubber plunger.

(b) Max. .025" (Readj. Max. .020") between plunger springs and rubber plunger of one