

ATTACHMENT a3KU1

NINETY-EM ATTACHMENT

This attachment is provided to allow for composition up to 90 ems wide, instead of the standard limit of 65 ems.

This effect is obtained by equipping the keyboard with longer unit wheel driving cylinders, driving rack and em rack, stop rack and em rack slide.

To fit the attachment, turn off the air supply and remove em rack slide x5KB, bell bracket x1KB, and unit wheel standard cap f46KB5K. How to remove these parts has already been described in this book. Then loosen the unit wheel driving cylinder heads (right—36KB2, and left—a36KB7), and release the two unit wheel driving cylinder ring pipe union nuts 36KB6. Remove unit wheel standard cap 46KB2 and unit wheel standard cap c46KB23, lift off both unit wheel driving cylinders a36KB1, together with driving rack, rider, pistons, pipe rings and pipes.

See that the ninety-em driving rack d37KB1 is quite clean and straight. Take the sixty-five em driving rack c37KB1 from within the cylinders and remove its pistons 37KB2 by unscrewing the studs 37KB4. Transfer the pistons to the long driving rack d37KB1 and make sure that the studs 37KB4 are quite tight when fitted, and that the heads of these studs are uppermost.

The pistons should be able to move freely when the studs are tightened, so that they can align themselves with the cylinders. See that the piston packings 37KB3 are quite pliable and well greased, and that their screws a37KB6 are quite tight. Take the long driving cylinders a36KB11, clean their bores and carefully enter the pistons and packings into the cylinders. Be careful not to crease or damage the packings 37KB3, and see that the threaded parts of cylinder bores are at the extreme ends when mounted together. Place unit wheel driving rack rider b37KB7 and shoe 37KB11 in position upon the driving rack d37KB1 and between inside ends of cylinders a36KB11. Place these parts in position on unit wheel standard d46KB1K and replace unit wheel standard caps (46KB2 and c46KB23). Before tightening these caps, locate the cylinders so that their inside ends are $\frac{9}{16}$ " from centre of unit wheel shaft a35KB2.