

## INSTRUCTIONS FOR FITTING REPLACEMENT CONTACTS, PART No. 255912, TO LUCAS STARTER SWITCHES MODELS ST900 (SOLENOID OPERATED) AND ST10 (MANUALLY OPERATED).

The contacts are supplied only in complete sets. These include two fixed contacts for fitting to the starter end bracket, the moving contact disc, a rocking washer and the necessary packing shims, etc.

The contacts must be replaced as a complete set, and they must be accurately fitted. The replacement must not be made unless the contacts can be set to the dimensional limits shown in the illustration overleaf. Before removing the starter switch, disconnect the earthing cable from the battery terminal to avoid any danger of causing short circuits.

The switch can be removed from the starter end bracket when the cables are disconnected and the four securing screws are removed.

To remove the old fixed contacts from the starter end bracket, remove the nut securing the connection from the starter, and withdraw the three securing screws. Fit the replacement contacts in position, taking care to place the insulating plate beneath the contacts and to place the insulating bushes over the securing bolts before screwing them home.

After fitting the two fixed contacts, the faces of the contacts must be machined in order to obtain a flat surface. The diameter of the machined portion must be 1 inch, and the depth of the machined surface must be  $\cdot 245$  in.  $\pm$   $\cdot 005$  in. from the edge of the starter end bracket.

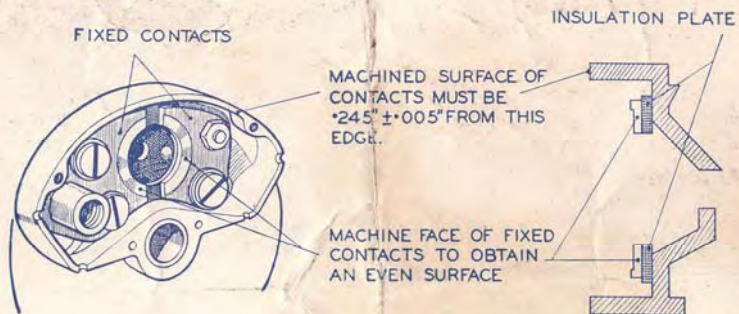
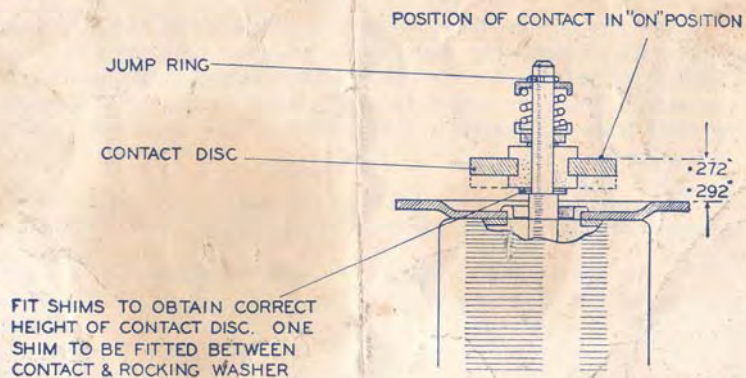
To remove the original contact disc, withdraw the jump ring from the end of the spindle. The correct position of the contact disc relative to the switch fixing plate, as shown in the illustration, must be obtained by fitting shims behind the disc. The rocking washer, which is a steel washer having four indentations, must not be fitted immediately behind the contact disc; a shim must be fitted between the washer and the disc. Replace the spring with its end caps on the spindle and secure by means of the jump ring.

**JOSEPH LUCAS LIMITED, BIRMINGHAM, ENGLAND.**

Finally, fit the switch to the starter end bracket and reconnect the leads to the switch.

With ST900 switches do not attempt to adjust the switch by means of the locking nut under the rubber cap at the end of the starter switch, as this may impair its action.

If any difficulty is experienced, the switch, together with the starter end bracket, should be returned to the nearest Lucas Service Depot.



CROSS SECTION OF BRACKET SHOWING POSITION OF CONTACTS.