

## SW60 SWITCH REPLACEMENT

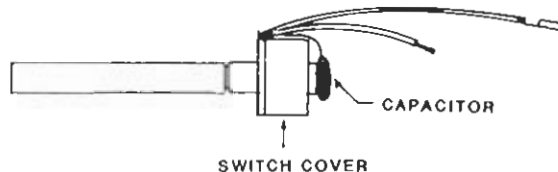
### Kit Includes:

- 1 - SW60 Switch W/Capacitor
- 1 - Long Conical Spring

- 2 - Long Screws #2 x 1"
- 1 - Wire Connector

### THE FOLLOWING PROCEDURE SHOULD BE FOLLOWED FOR SWITCH REPLACEMENT.

1. Remove two Phillips head screws (#1) from flange.
2. Grasp heating element (#2) in one hand while holding black insulator (#3) and handle (#4) in other hand and pull heating element out.
3. Locate flat on strain relief (#5) where cord enters handle. This flat is aligned with the Weller logo. Press downward and forward with a flat screw driver until cord moves forward into handle. DO NOT PRY ON HANDLE.
4. Pull insulator (#3), switch (#6) and cord (#8) out of handle.
5. Remove white switch lead (#7) from the black insulator (#3) by pulling connector pin out with the needle nose pliers or remove terminal using special pin removal tool.\*
6. Remove wire connector (#9) from other switch lead and wires attached to it.
7. Grasp switch insulator and force switch rearward approximately  $\frac{1}{4}$ " until spring (#10) is disengaged from groove in switch barrel.
8. Slide spring forward over end of switch barrel and remove spring.
9. On new switch, gently bend the capacitor down and over boss on switch cover. See below



10. Insert new switch through insulator (#3) and insert white lead (#7) with crimp terminal into insulator until it snaps and cannot be pulled back.  
(Note: The crimp pin anti-rotation tabs must be turned toward the center of the tool, against the protruding insulator extension. The terminal will not insert otherwise.)
11. Slide the long conical spring (#10) over the switch barrel (large opening end of spring toward insulator) and slide it rearward until it snaps into groove in the switch barrel.
12. With wire connector (#9), reconnect the other switch lead and wires that were connected to it from Step 6.
13. Assuming the strain relief did not come off the cord, pull the cord through the handle so that the insulator with switch can be worked into place. Align the switch and insulator as shown in Figure 2 so that capacitor leads are facing towards you. Rotate the handle so that the Weller logo is also toward you in the same plane. Guide the switch and insulator into the handle, wiggling slightly to properly seat insulator. The switch terminals should straddle the screw boss in the handle if positioning is correct.
14. With the handle in one hand and the cord in the other, rotate the cord until the flat on the strain relief aligns with the handle stop bar under the Weller logo. Pull firmly until the strain relief snaps into place. (If this cannot be done, check for strain relief alignment or insulator alignment.) Replace heating element and flange screws. Check switch for free movement with tip. There should be approximately  $\frac{1}{16}$ " movement of the tip from spring action.

\*Note: If crimped wire receptacles are removed by force they will be rendered non-reusable. When replacing defective parts this is not detrimental because line cords and magnastat switches are supplied with new receptacles crimped in place. For removing receptacles without damage, a special tool is required. This tool may be easily made from a common lady's "bobby pin" which has .020" x .050" spring wire material. The open end of the pin is inserted into the grooves in the insulator around the receptacle hole. The receptacle may then be removed without damage by pulling from the wire side.

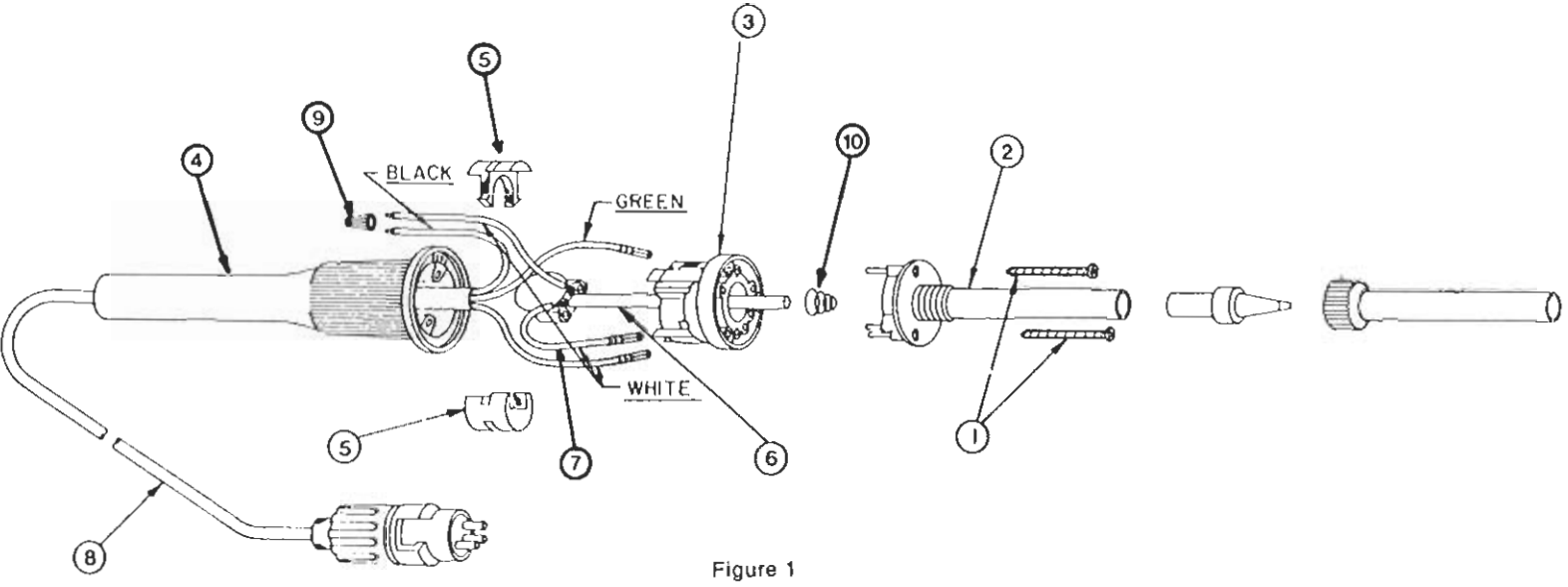
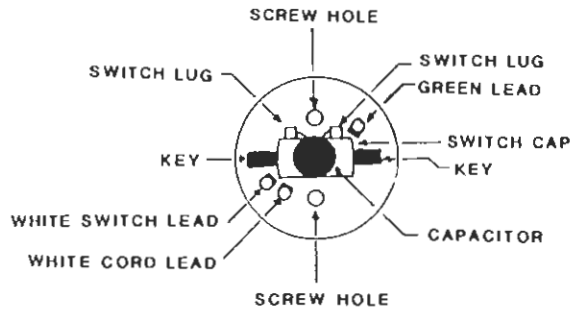


Figure 1



Switch alignment in insulator as viewed from handle side of insulator. (Lead wires not shown.)

Figure 2