Installation instructions for Castell key interlock kit (2C12891G22) Magnum® low voltage circuit breakers

⚠️ WARNING

(1) ONLY QUALIFIED ELECTRICAL PERSONNEL SHOULD BE PERMITTED TO WORK ON THE EQUIPMENT.
(2) ALWAYS DE-ENERGIZE PRIMARY AND SECONDARY CIRCUITS IF A CIRCUIT BREAKER CANNOT BE REMOVED TO A SAFE WORK LOCATION.
(3) DRAWOUT CIRCUIT BREAKERS SHOULD BE LEVERED (RACKED) OUT TO THE DISCONNECT POSITION.
(4) ALL CIRCUIT BREAKERS SHOULD BE SWITCHED TO THE OFF POSITION AND MECHANISM SPRINGS DISCHARGED.

FAILURE TO FOLLOW THESE STEPS FOR ALL PROCEDURES DESCRIBED IN THIS INSTRUCTION LEAFLET COULD RESULT IN DEATH, BODILY INJURY, OR PROPERTY DAMAGE.

General information

This key interlock provides the following safety features:

- With no key, the breaker is open and cannot close
- With the key ON (in cylinder) and rotated, the breaker is fully functional
- The key cannot be removed when the breaker is ON (closed). The key cannot turn the breaker OFF

Note: To remove the key, press the breaker OFF button, and rotate the key 90 degrees counterclockwise.

Required tools

- M10 socket with 1/4-inch drive
- 1-7/16-inch (36 mm) hole saw/drill
- #1 Phillips head screwdriver
- Flat blade screwdriver
- Needle-nose pliers

Kit parts identification

Refer to Figure 1 for visual identification of the parts listed below:

(A) Interlock arm assembly
(B) Castell lock CL1019 with key CL1062—specify unique lock lettering code when ordering (Castell keylock not supplied)
(C) Castell keylock mounting plate
(D) Interlock adapter
(E) Hold-down bracket
(F) Torsion spring
(G) Spring pin
(H) Hex standoff
(I) Extension spring
(J) Adapter screw
(K) Standoff screw (1/8-inch shoulder)
(L) Interlock cable
(M) Retaining clip (M5 x 0.7)
(N) Interlock lever
(O) Lock mounting plate screw (three)
(P) Interlock lever screw (M3.5 x 10 tapping)
**Installation of key interlock**

Proceed with the following 12 steps:

**Step 1:** Remove the front cover of the breaker by loosening four mounting bolts (six bolts if four-pole breaker), and hold the charging handle down approximately 45 degrees to simplify removal.

**Step 2:** Remove plug from keylock hole. If hole does not exist, drill a 1-7/16-inch (36 mm) hole using existing countersink on inside of cover as a pilot guide. Use a hole saw such as a Starrett #KAVH0176.

**Step 3:** If there is an operations counter and operation spring installed, remove and save these items for later re-installation. Remove existing counter/lock mounting plate and discard it.

**Step 4:** Snap the interlock arm assembly (A) into place on the shaft as shown.

**Step 5:** Remove existing screws from the back of the lock cylinder (B), and use one screw to mount the lock cylinder to the mounting plate (C). Note the orientation of the key in this step and subsequent steps, and the orientation of the slot in the lock cylinder when mounting to the lock mounting plate.

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**Figure 1. Contents of kit**

**Figure 2. Steps 1 and 2**

**Figure 3. Step 3**

**Figure 4. Step 4**

**Figure 5. Step 5**
**Step 6:** Assemble the interlock cable (L), hex standoff (H), and the interlock adapter (D) with the adapter screw (J) and standoff screw (K).

![Figure 6. Step 6](image)

**Step 7:** Mount the assembly from **Step 5** to the assembly from **Step 6** as shown. Note the key alignment orientation with the standoff.

![Figure 7. Step 7](image)

**Step 8:** Mount the torsion spring (F) and the hold-down bracket (E) to the assembly from **Step 7** using spring pin (G), and the flathead screw from the lock assembly. Note the spring winding direction as shown in the side view.

![Figure 8. Step 8](image)

**Step 9:** Mount the assembly from **Step 8** to the breaker as shown using three lock plate mounting screws (O). Connect the extension spring (I) between the interlock arm assembly and the mounting plate as shown.

![Figure 9. Step 9](image)

**Step 10:** Turn key assembly **clockwise** to create slack during this cable installation. Replace the interlock lever (N), and capture in place with the retaining clip (M). Attach the interlock cable with the interlock lever screw (P).

![Figure 10. Step 10](image)
Step 11: Rotate the key **counterclockwise** to lock out interlock as shown.

If an operations counter was previously removed in **Step 3**, re-install it to the back of the new lock mounting plate using two M3.5 x 8 mm self-tapping screws. Refer to IL2C14767 for complete operations counter installation instructions.

![Figure 11. Step 11](image)

**Step 12:** Re-install the front cover removed in **Step 1**. Key removal is required to install the front cover. The key must be in place for breaker operation.

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