INSTALLING THE DUPLEX
DOUBLE-THROW INCHING BUTTON
ON THE
UNIONMELT
Trade-Mark
"US" AND "DS" (A.C.) SERIES
VOLTAGE CONTROLS

1. Disconnect the old inching button and remove it from the cabinet.

2. Enlarge the one inch hole in the panel by drilling as shown in Fig. 1. If appearance is important, fill the two old mounting holes with black sealing wax. This wax is the type used for sealing documents and letters and may be obtained in most stationery stores. It melts at a low temperature and can be easily deposited in the holes a drop at a time. When the wax cools, finish the surface with a knife blade or a file. Drill the locating pin hole in the back of the panel.

3. Remove the collar from the neck of the inching button. Insert the button from the back of the panel, locating it by means of the pin on the body.

4. Place the washer (Part No. 94W45) over the neck of the pushbutton and secure the button with the collar.

5. Connect to terminals 21, 22, 23, and 24, the wires that were connected to these terminals on the old button (refer to the wiring diagram on Form 9180).

6. Remove the one wire, and install the two wires shown in Figure 2.

(Figures 1 and 2 on reverse side.)

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FIG. 1 - ALTERATIONS TO FRONT PANEL

- INSIDE SURFACE OF PANEL
- DRILL NEW HOLE WITH #29 DRILL 1/8" DEEP
- ENLARGE 1" HOLE USING 1-7/32" DRILL
- SEAL PRESENT MOUNTING HOLES

FIG. 2 - CHANGES IN WIRING

Linde Air Products Company
A Division of Union Carbide and Carbon Corporation

In Canada: Dominion Oxygen Company, Limited, Toronto