CONVERSION INSTRUCTIONS

DRAG BRAKE ASSEMBLY

FOR OM-48 SIDE-BEAM CARRIAGE

(Series 1 and 2)

The Drag Brake Assembly (29V09) is designed to prevent uneven carriage movements due to backlash in the gearing. Assembling the drag brake to the OM-48 (Series 1 and 2) is a simple operation. Proceed as follows:

1. Drill and countersink mounting holes in the carriage frame as shown in Fig. 1.

2. Run the adjusting nut (20N02) home against the arm (20N01). Slide the spring (29Z03) over the adjusting screw.

3. Mount the drag brake assembly on the carriage frame as shown in Fig. 2, using the 1/4-in. screws and lock washers supplied. The brake pad (19W99) will extend approximately 3/8 in. beyond the end of the carriage.

4. Set brake pad load as desired. To increase braking friction, turn the adjusting nut (20N02) to compress the spring (29Z03). Brake friction should be just enough to eliminate jerky carriage travel. Excessive braking should be avoided.

FIG. 1 – INSTALLING DRAG BRAKE ASSEMBLY ON OM-48 SIDE BEAM CARRIAGE
FIG. 2 - REPLACEMENT PARTS PICTURE, DRAG BRAKE ASSEMBLY 29V09

HARDWARE LIST

DRAG BRAKE ASSEMBLY — PART NO. 29V09

<table>
<thead>
<tr>
<th>SYMBOL</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>S-C-64</td>
<td>1/4-in.-20 Socket-Head Steel Cap Screw 1/2-in. Lg. (2 used)</td>
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<tr>
<td>S-FL-250</td>
<td>1/4-in.-20 Flat-Head Steel Machine Screw 3/4-in. Lg. (2 used)</td>
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<tr>
<td>W-SH-L-22</td>
<td>1/4-in. &quot;Shakeproof&quot; #1214-00 Internal Type Steel Lock Washer</td>
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<tr>
<td>W-SH-L-C-48-1</td>
<td>1/4-in. &quot;Shakeproof&quot; #1516-00 Countersunk Type Steel Lock Washer</td>
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