

X-10: Prepare Cabinet for Entry (Induction Holding)

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- A key and locking mechanism is built into the induction holding furnace control panels.

EQUIPMENT

- radio for communicating with the control tower

RESOURCES

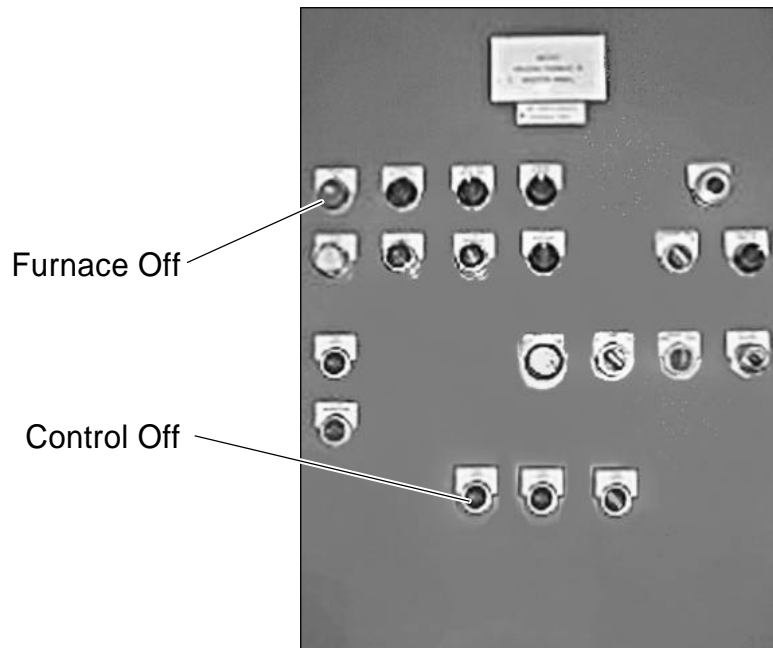
- none



Prepare Cabinet for Entry (Induction Holding)

Part A: Disconnect Power

1. Disconnect the electrical power to the induction holding furnace.
 - Contact the melt tower by radio and request electrical power be turned off to the appropriate furnace.
 - Confirm that the furnace off light is illuminated on the induction holding furnace control panel. Each furnace has its own control panel. See the figure below.

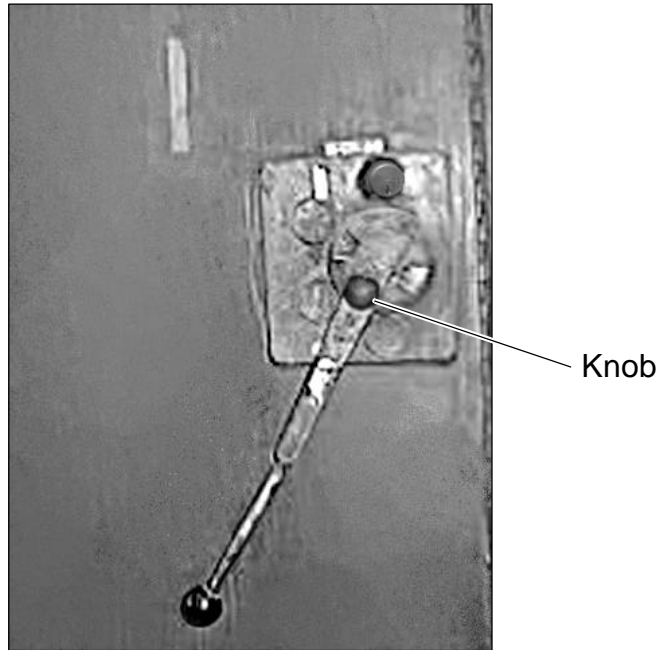


Note: A red light indicates that the power is off to the panel. A horn also sounds and, depending on which furnace, a blue light will flash.

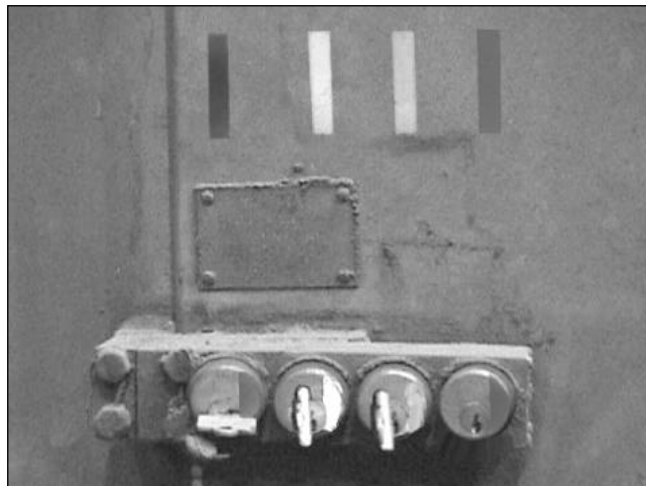
- Push the Control Off or Master Stop button, depending on the panel, to remove all control power to the master relay. This action allows for safe entry to any part of the cabinet.
2. Open the 4160 volt interrupter.

Note: The color markings on the keys and locks must match.

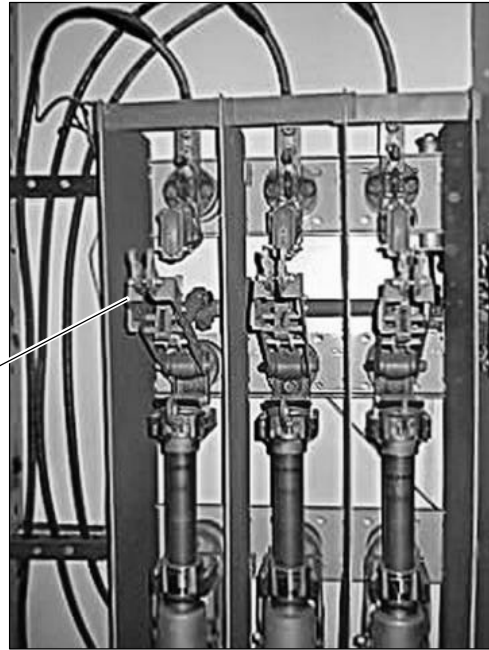
- Pull out the knob, then pull down on the handle. See the figure below.



- Remove the cover over the key.
- Turn the red key to lock the handle in the down position.
- Remove the key from the lock.
- Insert the red key into the four key block and unlock the block.
- Remove the orange key from the key block and insert it into the lock on the interrupter door. See the figure below.



- Open the interrupter door and confirm that the knife switches are in the open position. See the figure below.



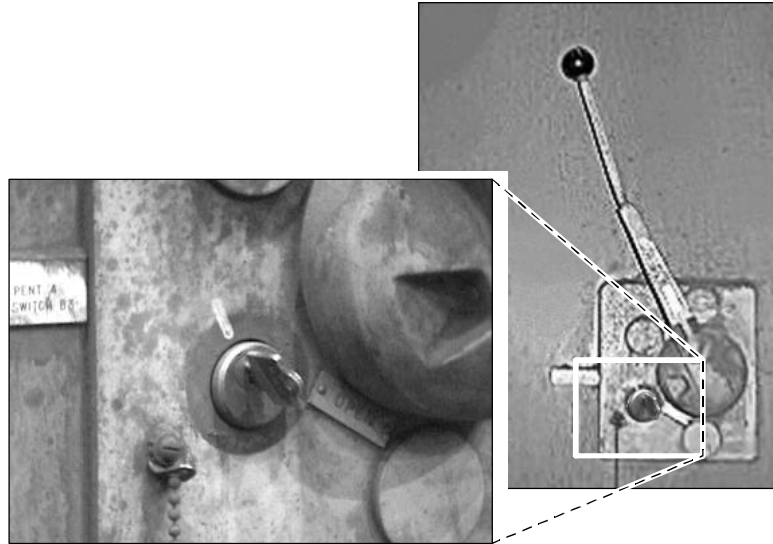
Knife Switches in
Open Position

- Close the interrupter door and lock it.
- Remove the orange key and return it to the four key block.

Part B: Restore Power

1. Close the interrupter.
 - Remove the red key from the key block.
 - Unlock the interrupter handle with the red key.
 - Pull out the knob.

- Push up on the handle, closing the knife switches. The handle will lock automatically in the up position and the red key stays the interrupter lock. See the figure below.



2. Restore the electrical power to the induction holding furnace.
 - Press the green Master Start button to turn the control power on.
 - Contact the melt tower by radio and request electrical power be restored to the holding furnace.