

INSTRUCTIONS

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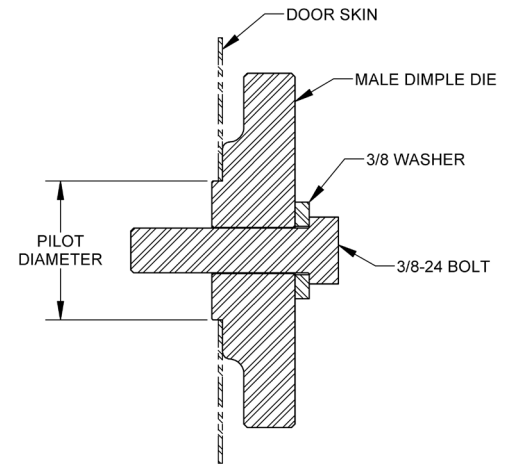
916-032662 - Lincoln Button

| Kit Contents | | |
|--------------|--------------|-------------------------------|
| Qty | Part # | Description |
| 2 | 916-032661.1 | Lincoln Button Dimple Die Set |

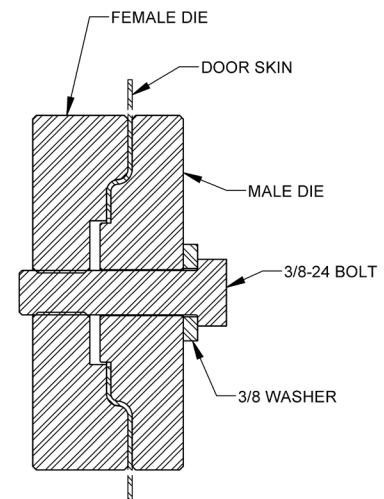
| Hardware | | | |
|----------|------------------------------|-----------|-------------|
| Qty | Description | Tool Size | Thread Lock |
| 1 | 3/8-24 x 1-1/2 Hex Cap Screw | 9/16 Hex | No |

| Tools | | |
|-------|--------------|-----------------------|
| Qty | Sku # | Description |
| 1 | 910-89-1.125 | 1-1/8" Hole Saw Blade |
| 1 | 910-89458 | Deburring Tool |

1. Determine the location you would like to install the door button. Mark the center point and create a hole that's 1.170". Cut a hole using a 1-1/8" hole saw then open the hole up to 1.170" diameter using a barrel sander. Remove any burrs before inserting the die. The pilot diameter of the male die should fit the hole with minimal clearance.



2. Insert the 3/8 hardware through the male die. Insert the pilot diameter of the male die into the hole on the outside of the door skin. Place the female die inside of the door skin. Screw in the 3/8 bolt until the female die is snug up against the inside of the door skin. Ensure the male die pilot diameter is still inserted into the hole. Tighten the bolt until the sheet metal is formed.



3. Remove the die set. The hole size will have increased during the forming operation. Test fit the door button or measure the hole after forming. The hole will need to measure 1-1/4" diameter. Increase the hole size with a barrel sander if it is still undersized.

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