This kit contains the following parts:

1. 18-tooth insulating gear Part No. 04N85
2. Gear Guard Part No. 04N31
3. 3/8-in.-16 by 3/4-in. long hex-socket type flat-head steel machine screw.

The feed roll shaft on the SWM-2 welding machine, as shipped, is equipped with a 30-tooth gear. A 14-tooth pinion is mounted on the motor gear-head output shaft. This provides a rod-feed speed range of 20 - 200 ipm, recommended for operation with 1/16-in. and 3/32-in. welding rod.

When using 1/32-in. and 3/64-in. rod, higher speeds are required. The parts in this kit should be substituted for those on the machine, as follows, to provide a speed range of 50 - 550 ipm:

1. Remove Rod Drive Assembly from machine frame (withdraw two screws from underneath, and remove two cap screws and nuts). It is not necessary to detach the motor leads.
2. Remove feed roll assembly and spacer from insulating base plate (withdraw two machine screws).
4. Remove the 14-tooth steel pinion from the motor gear-head output shaft. Replace it with the 18-tooth gear 04N85.
5. Replace the 30-tooth gear on the feed roll shaft with 14-tooth gear removed in step 4.
6. Using the 3/4-in. screws supplied, reinstall the feed roll assembly without its spacer, on the insulating base plate.
7. Replace the Rod Drive Assembly on the machine frame.
8. The 30-tooth gear, guard, spacer, and screws should be wrapped, conspicuously marked, and stored with the machine for subsequent use.

NOTE: Interchanging the positions of the 14-tooth pinion and 18-tooth gear will provide an intermediate speed range of 30 to 330 ipm.