INSTRUCTIONS FOR INSTALLING THE
Linde
Trade-Mark

ROD DRIVE ASSEMBLY
PART NUMBER 38V01
ON THE FSM-2 (SERIES 1, 2, AND 3) MACHINES

Any FSM-2 welding machine can be modernized by replacing the rod drive assembly with a new rod drive assembly (Part No. 38V01). The rod guides and feed roll of the new assembly are mounted in a one-piece casting. This unit type construction does away with the adjustments needed to align the feed roll and rod guides. These adjustments have been troublesome on some FSM-2 installations, and use of the new assembly will result in an increase in production time.
Material Required

The following materials are required for the mounting of the new assembly:

a. Motor, Gear Head and Feed Roll Assembly, Part No. 38V01.
b. Spacers—Two required. (See ‘‘C. Rod Reel Support’’ in the opposite column.)
c. 3/8-in.-16 x 2-1/2-in. long hex socket head cap screw, steel—Four required.
d. 5/16-in.-18 x 5/8-in. long hex socket head cap screw, steel—Two required.
e. 5/16-in.-18 x 1-1/4-in. long hex head cap screw, steel—Two required.
f. 5/16-in.-18 hex nut, steel—Two required.
g. 5/16-in. standard lock washer—Four required.

Installation

Remove the welding cable connector block, the rod feed assembly, and the rod reel support bracket from the FSM-2 frame by removing the fastening screws. These parts must be removed and relocated to accommodate the new feed assembly. Drill new holes in the frame as shown in Figure 1. Mount the parts on the frame as follows:

A. ROD DRIVE ASSEMBLY

The new rod drive assembly is furnished mounted on a plastic base plate.

1. Place the assembly on the FSM-2 frame so that the holes in the base plate line up with the holes in the frame.
2. From the bottom of the frame, screw in the two 5/16-in. hex socket head cap screws through the holes in the frame and into the base plate. Use 5/16-in. lock washers under the heads of the screws.
3. Put the 5/16-in. hex head cap screws through the two holes located 5/8-in. in from the edge of the plate. Tighten down with 5/16-in. nuts and lock washers.
4. Note that two 3/4-in. holes are in the plate. These were drilled to give access to the screws holding the feed roll assembly to the base plate. It is sometimes necessary to remove the feed roll assembly for changing gears. With the 3/4-in. holes, you can take off the feed roll assembly without taking off the entire rod feed assembly and base plate.

B. WELDING CABLE CONNECTOR BLOCK

Remount the connector block over the new holes. Use the screws that were previously removed. Be sure to include the insulating block and plate to isolate the connector from the frame.

C. ROD REEL SUPPORT

The base of the rod reel support must be raised about 1-3/8 in. above the frame, and located over the new holes, to clear the new feed assembly. The support may be raised by using spacers under it. Figure 2 shows a simple spacer that can be made from 1-1/2-in. channel iron. Two of these spacers are required.

When the spacers have been prepared, secure the spacers and the support to the frame. Use the 3/8-in. screws shown on the materials list above, and the nuts and washers that were removed from the old screws.

Instructions and Parts Data

Operating and maintenance instructions for the rod drive assembly 38V01 are in the booklet: "Instructions and Parts Data for the SWM-2 Portable Sigma Welder," Form 9172D. If you do not have a copy of this booklet, you can get one through any LINDE office.

As the title indicates, Form 9172D covers the SWM-2 machine and not the FSM-2. However, when you have installed the new drive assembly, your FSM-2 will be the same as the SWM-2 so far as the drive assembly is concerned, since Part No. 38V01 is used on the SWM-2. Your machine will be similar in other respects depending on its series number and the other modernization kits that have been used on it.

Rod Guides and Feed Rolls

Rod guides and feed rolls are not supplied with drive assembly 38V01. The rod guides that were supplied with the FSM-2 can be used on the new assembly. Feed rolls are not supplied since different size rolls are needed for the various rod sizes used. For information on feed rolls and related parts, see Form 9172D. The complete title of this booklet is mentioned above.
FIG. 1 - FSM-2 FRAME REvised FOR ROD DRIVE ASSEMBLY - 38VO1

FIG. 2 - SPACER - TWO REQUIRED

MATERIAL: $\frac{11}{16}'' \times \frac{1}{2}'' \times \frac{3}{8}'' \quad 0.155 \#\text{FT. STL CHANNEL} - 8\frac{3}{8}'' \text{LG}$
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