I. Purpose

The Complete Spindle Assembly (Part No. 38V66) and the Conversion Spindle Assembly (Part No. 38V68) are designed for use on LINDE sigma welding machines. They permit the use of nine and twelve-inch disposable spools of welding rod. The Complete Spindle Assembly (Part No. 38V66) entirely replaces the rod reel. The Conversion Spindle Assembly (Part No. 38V68) is used to convert a rod reel to a complete spindle assembly.

II. Installation Procedure for Conversion Spindle Assembly (Part No. 38V68)

1. Remove the rod reel from its shaft. To do this, first unscrew the cap screw at the reel hub, and remove the spring guide and brake spring. Then remove the keyed washer from the shaft and pull off the reel.

2. Install the new spindle on the shaft assembly. (The attached drawing shows the proper relationship of the parts.)

3. A keyed washer, Part No. 66N18, is supplied with the conversion kit. Place this washer on the shaft, and seat it in the spindle socket so that its key enters the slot in the shaft.

4. Assemble the original cap screw and brake spring (removed in Step 1) and guide 66N16 (supplied with the conversion kit) as shown in the attached drawing. Place the guide on the screw, with the smaller diameter of the guide toward the threaded end of the screw, and seat the spring on the smaller diameter of the guide.

5. Insert the cap screw into the threaded hole in the shaft, and screw it in until the brake spring applies pressure to the keyed washer. Make sure that the washer key is not displaced from the shaft slot during this step.

III. How to Mount a Welding Rod Spool on the Spindle

To install a spool of welding rod, simply slip the spool onto the spindle and engage the spindle lug in the hole in the spool. When the spool is fully seated, the spindle spring will engage the lip of the spool bore, to hold the spool in position.

Note: The spool should be placed on the spindle so that the rod will feed to the rod drive unit from the bottom of the spool.

Adjustment of brake tension is the same as for the spoke-type rod reel. The cap screw should be tightened until brake spring pressure is sufficient to prevent coating of the reel, but not enough to cause binding of the rod coil.
**HARDWARE FOR**

**COMPLETE SPINDLE ASSEMBLY - 38V66**

**AND CONVERSION SPINDLE ASSEMBLY - 38V68**

<table>
<thead>
<tr>
<th>SYMBOL</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>P-R-72</td>
<td>Roll Pin - Elastic Stop Nut Corp. #250 - .250 x 2&quot; Lg.</td>
</tr>
<tr>
<td>P-R-36</td>
<td>Roll Pin - Elastic Stop Nut Corp. #59-.040-187-.500 (2 used)</td>
</tr>
<tr>
<td>S-B-B-43</td>
<td>#4-40 x 1/4&quot; Straightside Bind. Hd. Brass Mach. Screw (2 used)</td>
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<tr>
<td>*S-C-232</td>
<td>1/2&quot;-20 x 2&quot; Lg. Hex Head Steel Cap Screw</td>
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*Parts with this symbol not included in Conversion Spindle Assembly (Part No. 38V68)