

### CONVERSION INSTRUCTIONS for the

# Linde SWM-2 (SERIES 2) ARC-CUTOFF CONTROL

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## INTRODUCTION

Under some operating conditions in sigma welding, the arc is abnormally long. In the past, this condition led to burnbacks which froze the welding wire to the guide tube and presented a major problem. However, it was found that a simple relay and rheostat combination, properly connected across the arc and tied in with the controls, made a very satisfactory arc-cutoff control. This is the basis of the SWM-2, (Series 2) Arc-Cutoff Conversion Kit.

In addition to eliminating burnbacks during welding, the arc-cutoff control performs several other useful functions:

1. It automatically stops the machine at the end of a coil, a break in a coil or a tangle in a coil.
2. If the wire feed becomes erratic for any reason, it will usually stop the machine and cause the operator to correct the cause of the erratic feed.
3. When it is permissible to run off the end of the work at the completion of a weld, this control will automatically stop the machine.

Field installation of SWM-2, (Series 2) machines can be adapted to include the arc-cutoff feature simply by following the instructions outlined below.

## INSTALLATION

### A. Equipment Required

All parts required for arc-cutoff conversion are provided in the SWM-2, (Series 2) Arc-Cutoff Conversion Kit. (This includes leads of the correct lengths.) The circuit and control cabinet assembly diagrams, Figures 5 and 6, show the relationship of these parts to the rest of the SWM-2 setup. Replacement parts for the arc-cutoff circuit are shown in Figure 6.

### B. Mounting the Relay and Rheostat

1. Lay out the centers of the six holes to be drilled, as indicated in Figure 1.
2. Drill all holes. If a "W" drill is not available, a 3/8-in. drill may be used for this hole only.
3. Countersink the four 5/32-in. holes and remove the burrs from all six holes.
4. Mount the relay (93W55) with the stationary contacts down, using the four 6-32 x 3/8-in. flat-head screws provided. The relay is mounted behind the front panel, on the four countersunk holes (see Figs. 2 and 4).

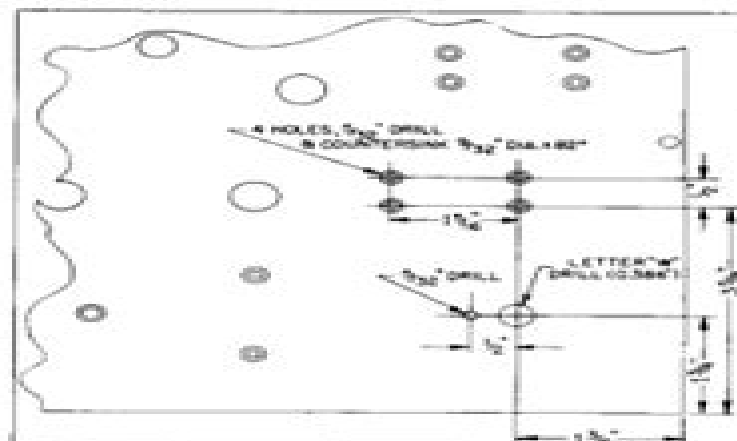


FIG. 1 - Lower Right-Hand Corner of Upper Panel, Showing Mounting Holes for Arc-Cutoff Control Components

# Linde Manual Arc Machine Type 65

**Ying Liu**



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