

LINER REPLACEMENT PROCEDURE

Warnings – To avoid accidental injury ensure power supply and wire feed unit is turned off.

1. Trim the end of the weld wire at contact tip.
2. Retract or completely remove weld wire
3. Remove torch from the wire feeder.
4. Remove the nozzle, contact tip, and diffuser. Inspect and replace if necessary.
 - a. Inspect insulating washer (between diffuser and gooseneck) and replace if necessary.
5. Loosen the set screw, DO NOT REMOVE, on the feeder pin using a 5/64” Allen wrench. If retaining nut, remove and set aside.
6. Making sure the torch cable is straight, grasp the liner at the rear of the torch with a pair of pliers and remove.
7. Carefully feed the new liner into the torch using short strokes to avoid kinking. You may need to twist the liner for easier insertion. Ensure liner collet is all the way against the power pin.
8. Tighten the set screw or retaining nut to secure the liner in the feeder pin.
9. IMPORTANT: at the front end of the torch push the liner back into the gun and hold.
10. While holding the liner in, trim the liner so that 13/32” (2007 series diffusers) or 11/16” (4033 series diffusers) sticks out from the end of the gooseneck. Check the torch diffuser to determine if AW 02007 or AW 04033 is engraved on it.
11. Gently twist the power cable 180°. Which end you twist from depends on direction of rotation.

Warning - It is important to keep one end of the power cable stationary while twisting the opposite end.

- a. Holding the neck, twist the cable **counterclockwise**.
 - b. Holding from the power pin, twist the **cable clockwise**.
12. Replace the diffuser, contact tip, and nozzle.
 13. Untwist the torch.
 14. Attach torch to the wire feeder.
 15. Feed welding wire into the torch and tighten drive rolls.

WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.

