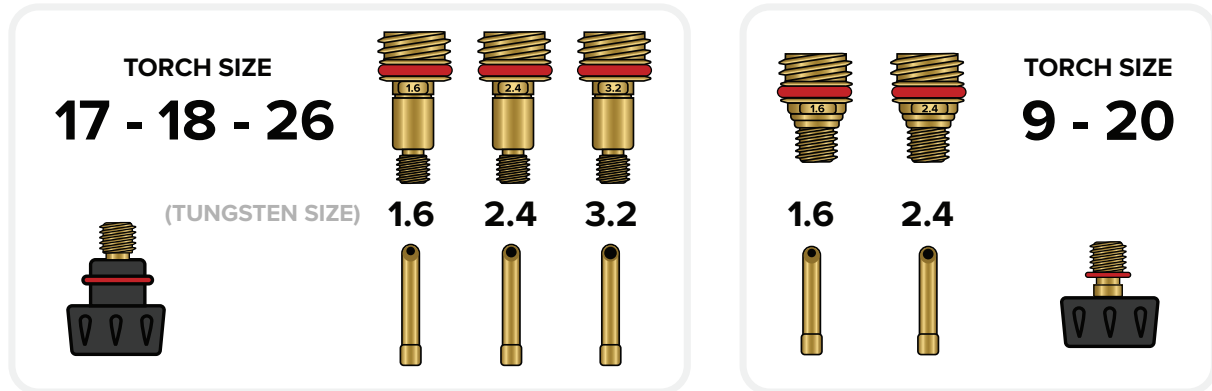


TORCH ASSEMBLY GUIDE

Before beginning assembly it is important to first identify the correct parts in the kit you will need to use.

TORCH TYPE/SIZE & TUNGSTEN SIZE

If you're using a size 17, 18, or 26 you would choose the longer gas lens. The 9 or 20 size torch uses the shorter gas lens.

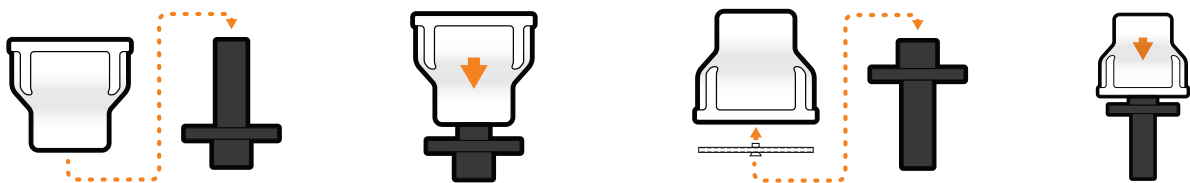


TUNGSTEN SIZE

If you're using a size 17, 18, or 26 you would choose the longer wedge collet. The 9 or 20 size torch uses the shorter wedge collet. You will need to match the tungsten size you're using to the corresponding gas lens and collet size. Each gas lens and wedge collet are marked for their tungsten size.

FILTER SIZE

You will need to match the tungsten size to the hole diameter of the filter screen located in the gas cup. Select the correct filter size to match your chosen gas cup size, and thread the filter through your chosen tungsten size to ensure it matches. All cups come ready for 2.4mm tungsten diameter.

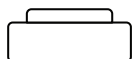


To remove a mesh filter screen from your ceramic or quartz cup, insert the longer, thinner side of the filter screen installation tool into the side of the cup that attaches to the torch and push out the filter screen.

To insert a new mesh filter screen into your ceramic or quartz cup, place the filter screen on the shorter, thicker side of the filter screen installation tool and push it into the opening of the cup until the cup is flush with the circular part of the installation tool the filter screen.

CUP TYPE

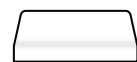
QUARTZ CUP



STUBBY INSULATOR

Select the insulator based on if you wish to use a quartz or ceramic cup. The kit supplied stubby insulator is used for quartz cups, and the insulator supplied with your torch is used for ceramic cups.

CERAMIC CUP



STANDARD INSULATOR
(NOT INCLUDED)

BACK CAP

Ensure you have selected the correct type of back cap to match your torch type based on the location of the rubber o-ring gasket. If the o-ring is located on the black plastic, it is meant for size 17, 18 & 20 type torches. If the o-ring is located on the brass portion it is meant for 9 or 20 size torches. Choose the length of back cap based on the available weld space for your torch. If you choose the shorter back caps you will need to shorten your tungsten electrodes.



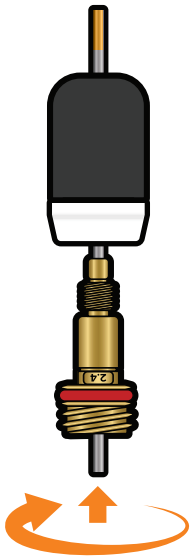
1 Press on to install the correct isolator to the torch head based on cup type.



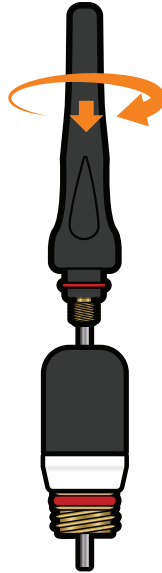
2 Insert the wedge collet into the small end of the gas lens.



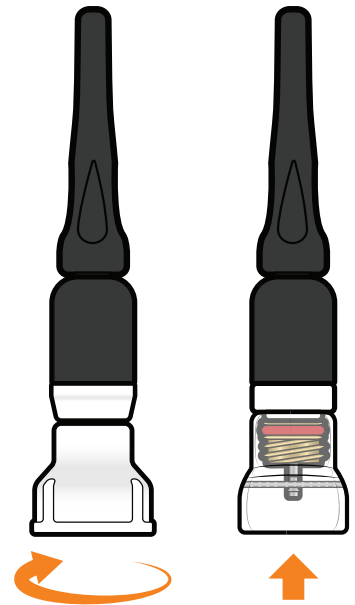
3 Insert the tungsten electrode into the collet/stubby gas lens.



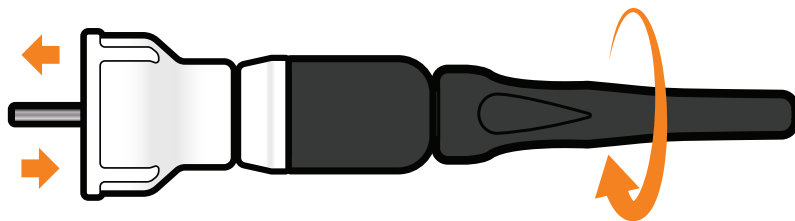
4 Screw the collet body into the torch head. Fasten securely. Ensure that the o-ring is in the correct position on the collet body.



5 Screw the back cap into the torch head, don't tighten all of the way.



6 Screw the ceramic cup or slide the quartz cup onto the stubby gas lens. ***DO NOT OVER TIGHTEN CERAMIC***



7 Adjust the tungsten to the desired length, then tighten the back cap.