



ALUMINUM LINER INSTALLATION INSTRUCTIONS

1. Feed liner through the torch cable from the back end.
2. Secure liner collet to the feeder adapter.
3. Line base of the distance sleeve up with the front end of the neck on the welding gun.
4. Cut the liner near the center of the distance sleeve where it tapers down, so there is approximately 3/8" (9.5 mm) liner stick-out from the end of the neck (Fig. 1). Use conduit cutter or other cutting tool that leaves a clean cut without crushing the liner.
5. Fully thread the distance sleeve onto the liner (Fig. 2).
6. Attach gas diffuser, tip, and nozzle to the end of the welding gun, over the sleeve (Fig. 3).

Note: If liner experiences excess wear at the torch neck due to the bend of the neck or damage due to high heat, a phosphorous bronze jump liner (part # WTP-ELJL-45116A) is available to improve liner life and wire delivery.

Figure 1: Cut liner to approx. 3/8" stick-out



Figure 2: Thread sleeve onto liner



Figure 3: Reinstall diffuser tip and nozzle

