

JUMP LINER INSTALLATION INSTRUCTIONS

1. Feed liner through the torch cable from the back end.
2. Secure liner collet to the feeder adapter.
3. At the front end of the gun, cut the liner flush with the end of the torch neck. Use conduit cutter or other cutting tool that leaves a clean cut without crushing the liner.
4. Completely remove the liner by pulling out from the back end of the torch cable.
5. Line the jump liner up with the front end of the torch liner (the end without the collet), and leave the jump liner overhanging the liner by 2" (51 mm) (Fig. 1).
6. Trim the liner so it is even with the base of the jump liner (Fig. 2)
7. Use welpers or pliers to crimp the jump liner to the front end of the liner. Crimp so the jump liner is secure but not crushing the torch liner (Fig. 3).
8. Feed both the jump liner and torch liner through the torch cable (Fig. 4).
9. Secure the liner collet to the feeder adapter.
10. Apply back pressure on the jump liner toward the welding gun (Fig. 5). Trim jump liner so there is approximately 3/4" (19 mm) stick-out from the neck.
11. File and deburr the ends of the jump liner so there are no sharp edges that could affect wire delivery (Fig. 6).
12. Attach gas diffuser, tip, and nozzle to the front end of the torch.

JUMP LINER REPLACEMENT

1. Remove nozzle and gas diffuser. Detach the old jump liner from the torch liner by pulling the jump liner away from the welding gun.
2. Remove the collet and torch liner from the torch cable
3. Follow jump liner installation instructions above if replacing both liners. Repeat steps 7-12 if replacing the jump liner only.

