

ABIROB W Liner Instructions

SI4-XXX Series Liners

LINCOLN DIRECT TORCHES

1. Position the torch cable as straight as possible.
2. With the torch neck and consumables fitted, insert the liner into the rear of the torch until it bottoms in the tip holder/tip or wire-brake if fitted.
3. At the rear end of the torch measure the distance from the feeder plug to the end of the liner collet (Fig. 1). This is dimension "X".
4. Remove the liner from the torch and remove the dimension "X" from the front end of the liner (Fig. 2).
5. At the rear end of the liner, you must trim the excess liner which protrudes from the liner collet. Measure 4mm past the collet and cut the excess off (Fig. 3). Note: When cut properly the liner should be flush to 1mm recessed in the liner nut.
6. Apply O-ring grease. Install the liner into the torch and tighten the liner retention nut (Fig. 4).

Fig. 1

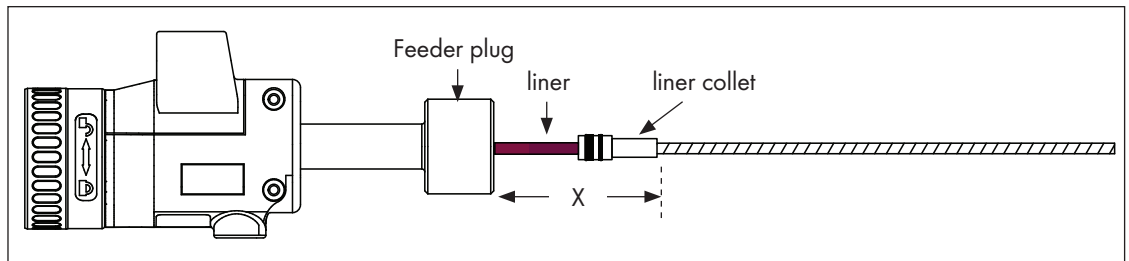


Fig. 2

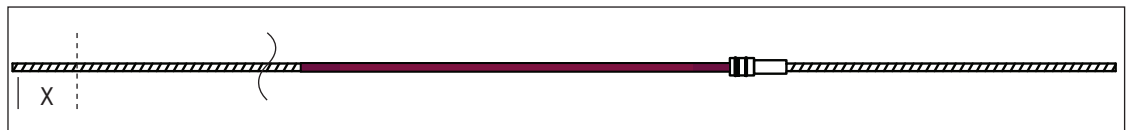


Fig. 3

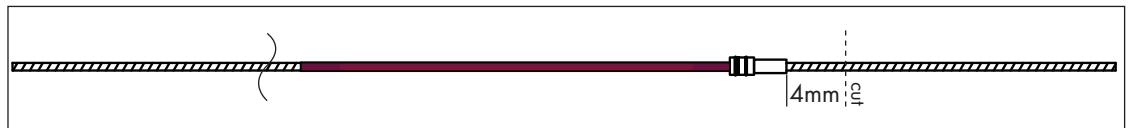
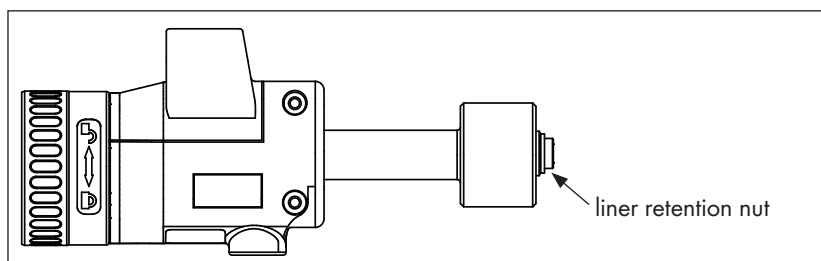


Fig. 4



**(Miller Direct Torches
on back...)**

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MILLER DIRECT TORCHES

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2. With the torch neck and consumables fitted, insert the liner into the rear of the torch until it bottoms in the tip holder/tip or wire-brake if fitted.
3. At the rear end of the torch measure the distance from the feeder plug to the end of the liner collet (Fig. 1) and subtract 5mm. This is dimension "X".
4. Remove the liner from the torch and remove the dimension "X" from the front end of the liner (Fig. 2).
5. At the rear end of the liner, you must trim the excess liner which protrudes from the liner collet. Measure 7mm past the collet and cut the excess off (Fig. 3). Note: When cut properly the liner should protrude from the liner collet by approximately 2mm or two coils.
6. Apply O-ring grease. Install the liner into the torch and tighten the liner retention nut (Fig. 4).

Fig. 1

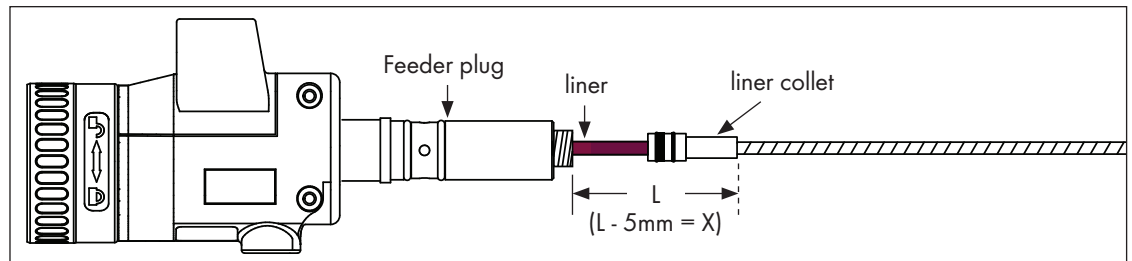


Fig. 2

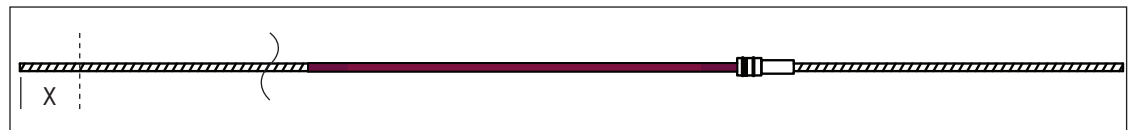


Fig. 3

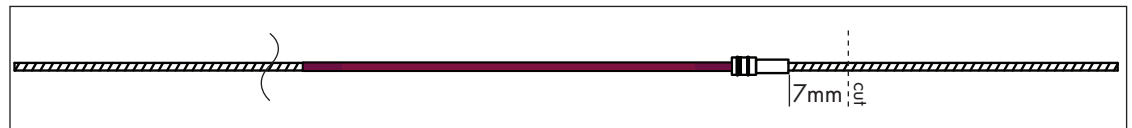
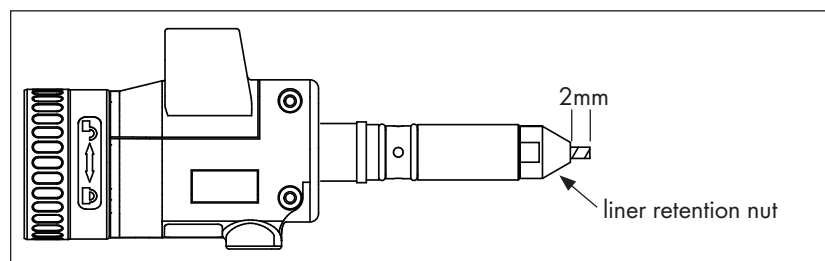


Fig. 4



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