Step 1- Install the Ring Insulator
Step 2- Install the Ring for Universal Tip Holder
Step 3- Install the Nozzle Insulator

Step 4- Install the Gas Lens by hand, then tighten slightly with pliers as shown.
Step 5- Install the Gas Nozzle
Step 6- Install the Collet
Step 7- Install the Tungsten

Step 8- Install the Back Cap and tighten to secure the tungsten in place.
Assembly Holder Block
Adjustment Shaft

42 (RED) Deg Tip Holder for PIPE Applications
Also Available in 39 (BLUE) Deg Tip Holder for PLATE Applications

Tip / Liner Assembly

Includes:
Contact Tip
.035, .045
Liner
Fiberglass silicone
Sleeve

7.5” Liner Assembly will work on Regular and Large Nozzle Sizes
WP18 SC TORCH INSTRUCTIONS

Loosen the Set Screw inside the Tip Holder

Install the weld repellant tape as shown.

Install the Tip Assembly into the Tip Holder and tighten.

Install the Tip Assembly Shaft.
Step 9- Install the Assembly Holder Block to the Ring and secure with screw.
Step 10- Attach Hotwire Cable to Assembly Holder Block with screw.

Radius of Tip Assembly needs to have a uniformed radius as shown for best wire feeding results.

Step 11- Push in Liner Assembly to Hull Adapter on torch
Step 12- Connect Adjustment Shaft to Assembly Holder Block and tighten screws