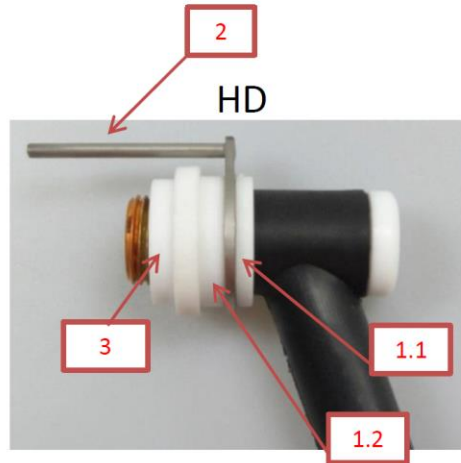
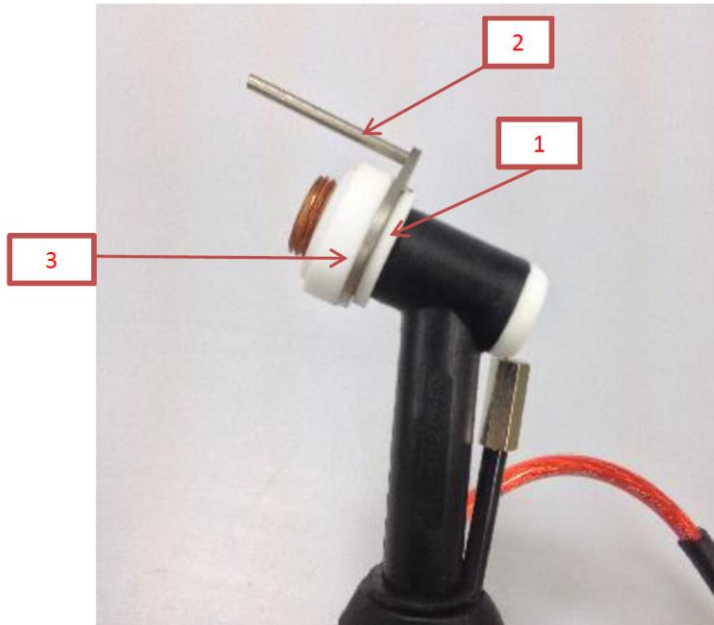
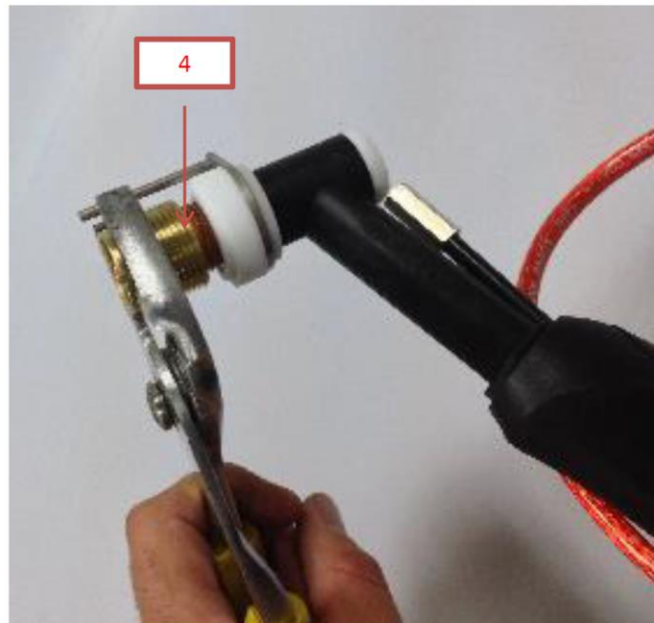


WP18 SC TORCH INSTRUCTIONS

Standard

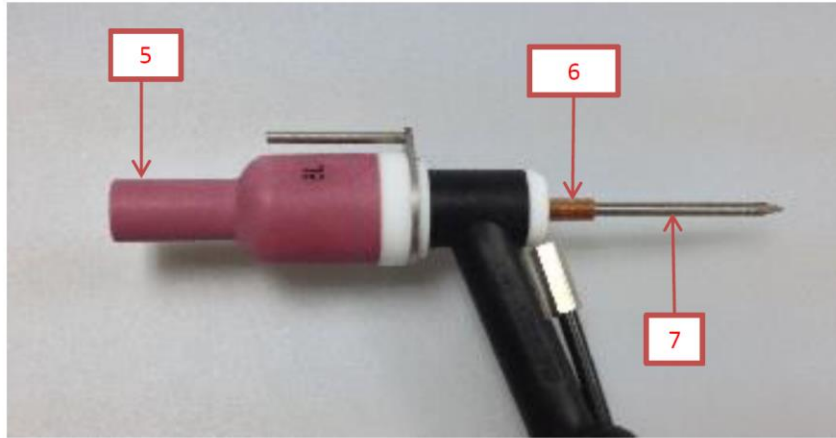


- Step 1- Install the Ring Insulator
- Step 2- Install the Ring for Universal Tip Holder
- Step 3- Install the Nozzle Insulator



- Step 4- Install the Gas Lens by hand, then tighten slightly with pliers as shown.

WP18 SC TORCH INSTRUCTIONS



Step 5- Install the Gas Nozzle

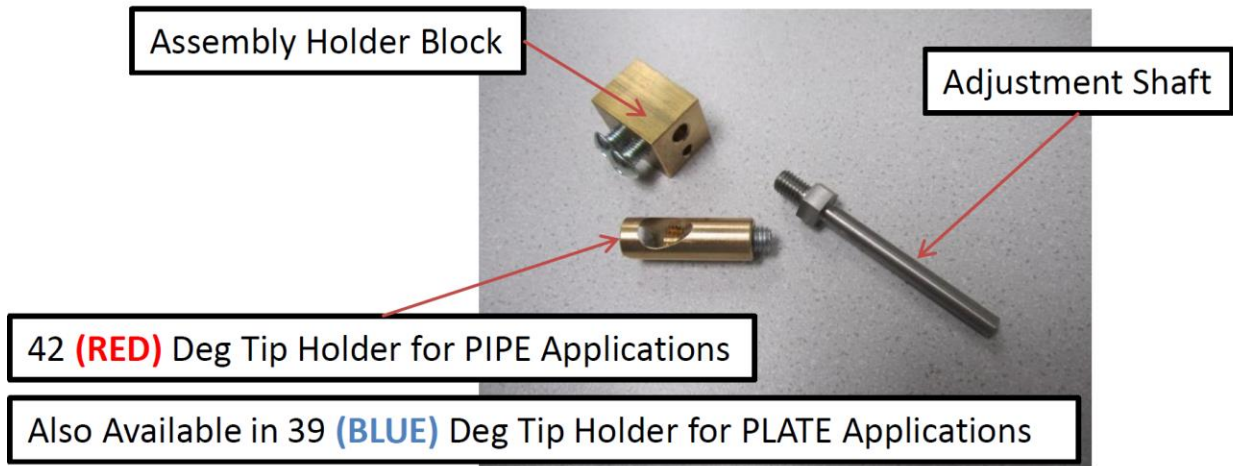
Step 6- Install the Collet

Step 7- Install the Tungsten



Step 8- Install the Back Cap and tighten to secure the tungsten in place.

WP18 SC TORCH INSTRUCTIONS



Tip / Liner Assembly



7.5" Liner Assembly will work on Regular and Large Nozzle Sizes

WP18 SC TORCH INSTRUCTIONS



Loosen the Set Screw inside the Tip Holder



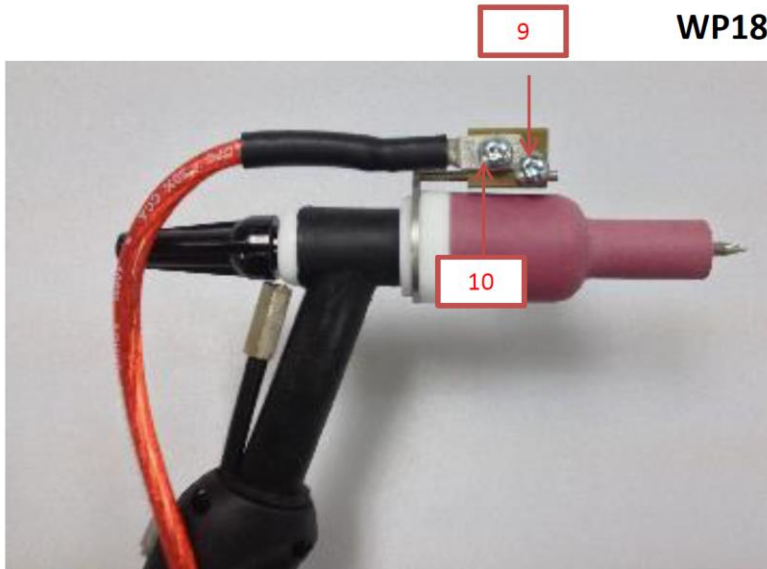
Install the weld repellent tape as shown.

Install the Tip Assembly into the Tip Holder and tighten.



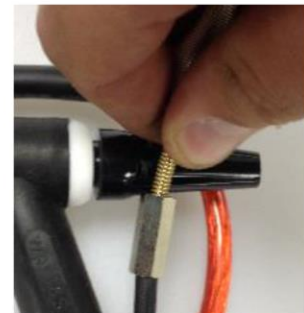
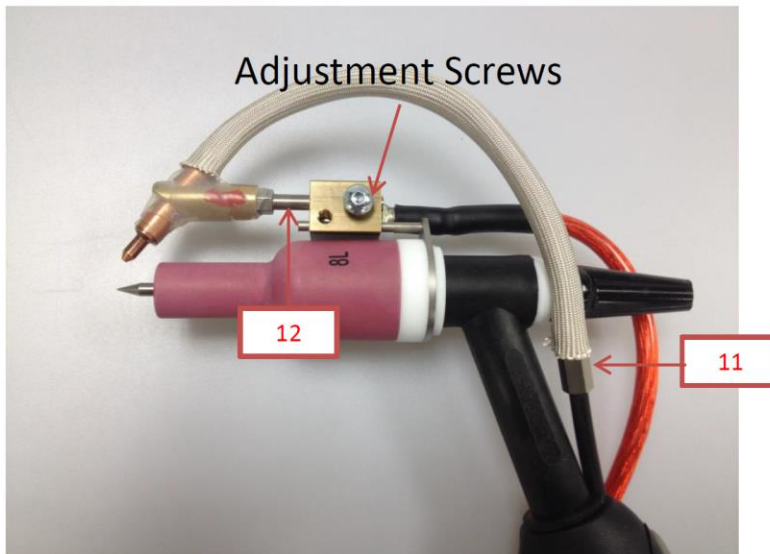
Install the Tip Assembly Shaft.

WP18 SC TORCH INSTRUCTIONS



- 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



Push in liner and twist counter clockwise to seat in place.

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