

## Air-Cooled Semi-Automatic MIG Torches

For Models

238CA, 347CA/PG, 354CA/PG, 407CA/PG, 454CA/PG,  
500CA/PG, 507CA/PG



**INSTALLATION, OPERATIONS AND REPLACEMENT PARTS MANUAL**

## **TABLE OF CONTENTS**

INTRODUCTION/WARRANTY .....	1
GENERAL SAFETY.....	2
TORCH SPECIFICATIONS.....	2
NOZZLE/TIP RELATIONSHIPS .....	3
INSTALLATION .....	3
LINER REPLACEMENT .....	4
GOOSENECK REPLACEMENT .....	5
TRIGGER SWITCH REPLACEMENT.....	5
UNICABLE REPLACEMENT .....	5
DAILY MAINTENANCE .....	6
OPTIONS.....	6
PARTS BREAKDOWN .....	7-8

## **INTRODUCTION**

Thank you for purchasing an American Weldquip product. The American Weldquip product you have purchased has been carefully manufactured, assembled, and fully tested. This manual contains information on the installation, operation, maintenance, and replacement part breakdown. Please read, understand, and follow all safety instructions, warnings and procedures. Keep this manual handy for referencing installation, operation, maintenance, and part ordering information. While every precaution has been taken as to the accuracy in this manual, American Weldquip, Inc. assumes no responsibility for errors or omissions. American Weldquip, Inc. assumes no liability for damages resulting from the use of the information contained in this manual. American Weldquip, Inc. shall have no liability to the buyer for consequential damages or expenses by any defect whatsoever.

## **WARRANTY**

AMERICAN WELDQUIP MIG guns and parts are warranted to be free of defects in material and/or workmanship for the period of time listed below. For any product found to be defective under normal use, AMERICAN WELDQUIP, INC. at our option, will repair, replace or issue a credit for the value of the defective product. All warranty claims must be submitted by the original purchaser. Use of non-genuine AMERICAN WELDQUIP parts and/or consumables may damage and/or severely limit the performance of the equipment which may limit or void any warranties. AMERICAN WELDQUIP, INC. will not assume responsibility for incidental damages or expenses related to any defect. This warranty does not cover damage caused by misuse or abuse, accident, alteration of product, improper installation, misapplication, lack of reasonable care and maintenance, unauthorized repairs or modifications, loss of use while at a repair facility or other conditions that are beyond the control of American Weldquip, Inc.

A Return Authorization Number (RA#) must be attained from the factory for any product being returned for Warranty Repair or Replacement. All returned product must be shipped freight prepaid by the sender. No- charge replacements, repaired products, or credit will be issued, once the returned product has been evaluated and warranty condition has been verified. If an immediate replacement is required before proper warranty evaluation, a purchase order number is required and the goods will be invoiced. A credit will be issued once it is determined that a warranty condition exists.

### **STANDARD WARRANTY**

All Semi-Automatic, Automatic, Robotic MIG TORCHES and Components	= 120 Days
MIG Torch Trigger Switches (Contacts only) -Excludes Smoke Extraction	= LIFETIME
Robotic Nozzle Cleaning Stations, Wire Cutter	= 90 Days
Robotic Peripherals, ArcSafe, Gun Mounts	= 90 Days
TIG POINT Tungsten Electrode Grinders	= 90 Days

### **LIMITED EXTENDED WARRANTY PROTECTION**

This limited extended warranty protection expands coverage to loyal customers who use all GENUINE American Weldquip consumables. Customers filing a claim under the extended warranty will need to prove, by providing past invoices, that they have been purchasing and using Genuine American Weldquip consumables.

All Semi-Automatic, Automatic, Robotic MIG TORCHES and Components	= 1 YEAR
MIG Torch Trigger Switches (Contacts only) -Excludes Smoke Extraction	= LIFETIME
MIG Torch Handles	= LIFETIME
Robotic Nozzle Cleaning Stations, Wire Cutter	= 90 Days
Robotic Peripherals, ArcSafe, Gun Mounts	= 90 Days
TIG POINT Tungsten Electrode Grinders	= 90 Days

## **ROHS COMPLIANT**

RoHS (Restriction of Hazardous Substances) is an environmental law which addresses the European Union directive 2002/95/EC known as the RoHS Directive. The RoHS directive restricts the use of hazardous substances listed below in electrical and electronic equipment. While it is not a requirement to meet the directive in the United States, at this time, American Weldquip Inc. feels this is an important part of our "Go Green initiative. We have taken all reasonable steps to try to insure the supporting evidence regarding the absence of the restricted substances to support RoHS compliance.

For reference, the maximum concentration values of the restricted substances by weight in homogenous materials are:

Lead/Lead Components	- 0.1%
Mercury	- 0.1%
Hexavalent Chromium	- 0.1%
Polybrominated Biphenyls (PBBs)	- 0.1%
Polybrominated Diphenyl Ethers (PBDEs)	- 0.1%
Cadmium	-0.01%

For RoHS Certification of Compliance Letter on a particular product please visit our website – [www.weldquip.com](http://www.weldquip.com) or email us at [technical@weldquip.com](mailto:technical@weldquip.com) or call 330-239-0317.



## GENERAL SAFETY PRECAUTIONS

Before installing, operating or performing maintenance please read the safety precautions below. Failure to observe safety precautions can result in injury or death.

**WARNING** – A welding arc emits ultraviolet (UV) and other radiation and can cause serious injury to unprotected skin and eyes.

**WARNING** – Hot metal produced by welding can cause severe burns. Heat from arcs and hot weld spatter and sparks can start fires and cause explosions of flammable gases.

**WARNING** – Fumes and gases generated from welding can cause severe injury to respiratory system and even death. **DO NOT** weld in confined spaces and make sure there is plenty of ventilation. Do not breathe fumes and gases as can cause asphyxiation.

**WARNING** – Electrical shock can kill. Do not touch live electrical parts and/or use in damp locations.

1. Always wear a welding helmet with the correct filter and cover plate.
2. Always wear safety Glasses with side shields in any work area even if a welding helmet is also required.
3. All exposed skin should be covered with flameproof protective clothing. This includes leather gloves, heavy long sleeve shirt, cuff less pants and high topped shoes. **DO NOT WEAR CLOTHING MADE FROM FLAMMABLE SYNTHETIC FIBERS.**
4. Protective screens or barriers should be used to protect others from spatter, flash and glare while welding.
5. Make sure work area is free of all combustible materials or cover with a protective non-flammable cover.
6. Remove all flammable gas cylinders as welding sparks can cause explosion in the event of a leak. Take serious precautions if welding in area of flammable gas lines and/or tanks.
7. Know where a fire extinguisher is at all times. The best practice is to have an extinguisher, water pail, fire hose and/or sand bucket available for immediate use.
8. Poorly maintained equipment can cause injury or death
9. Inspect, repair or replace worn or damaged welding cables and torch leads.
10. Insure equipment is properly grounded and installed according to code.
11. Never wrap the weld cable or torch leads around your body.
12. Make sure equipment is turned off when not in use.

### ADDITIONAL SOURCES FOR SAFETY INFORMATION

ANSI Standard Z49.1 CODE FOR SAFETY IN WELDING AND CUTTING - American National Standards Institute, 1430 Broadway, New York, NY 10018

NFPA Standard 51B, "Fire Prevention in the Use of Cutting and Welding Processes – National Fire Protection Association, Batterymarch Park, Quincy, MA 02269

CSA Standard W117.2 CODE FOR SAFETY IN WELDING AND CUTTING - Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

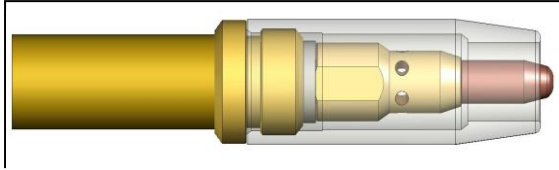
## TORCH SPECIFICATIONS

MODEL	AMPERAGE	100% Duty Cycle		60% Duty Cycle	
		CO2	Mixed Gas	CO2	Mixed Gas
238CA	250	250A	200A	300A	250A
347CA	300	325A	275A	350A	325A
354CA	350	350A	300A	375A	350A
407CA	400	400A	325A	450A	400A
454CA	400	400A	325A	450A	400A
500CA	500	500A	400A	550A	500A
507CA	500	500A	400A	575A	500A

Duty Cycle is based on a complete cycle time of 10 minutes. (60% Duty Cycle = 6 minutes weld time, 4 minutes off time).

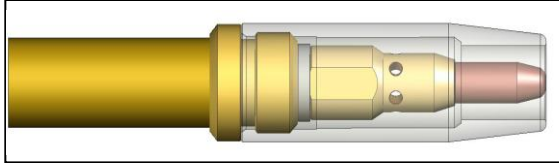
## NOZZLE/TIP RELATIONSHIPS

Shown below are typical relationship between the contact tip and nozzle in GMAW Semi-Automatic applications. Nozzles to tip relationships are usually dictated by the process and application but not necessarily the standard. Keep in mind that decreased tip life, increased spatter cleaning cycles may be required if the tip relationship is changed to achieve other objectives.



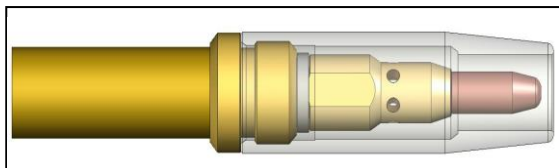
### **Extended Tip – Short Circuit (Short Arc, Dip Transfer) Welding Applications**

The tip stick out is usually 1/8" or 1/4" from the nozzle. Keep in mind that the further the stick out the more susceptible to gas porosity issues. Typically is used in short circuit, lower amperage applications, and/or where you may need to reach in to a corner.



### **Flush Tip – Higher current Short Circuit (Short Arc, Dip Transfer) Welding Applications**

The tip is flush with the end of the nozzle. Typically used in higher current and voltage short circuit applications.



### **Recessed Tip – Spray Arc, Pulsed, Flux Core Welding Applications**

The tip is usually recessed in the nozzle 1/8" or 1/4". Usually, the higher the heat and/or current the further the recess. However, this is also dependant on the wire used and the arc length requirement.

## INSTALLATION

Depending on how your torch was ordered your American Weldquip torch has been supplied with either a EURO type feeder connection or a DIRECT wire feeder connection. The American Weldquip torch can be installed to the wire feed unit in two ways.

Euro Connection – Feeder Adaptor Kit may be required

Direct Connection

### **Direct Connect**

The direct connect torch system is designed for installation to the wire feeder without the need for any adaptor system. The torch is supplied (depending on the torch configuration ordered) with a feeder connection plug at the rear of the torch, gas connection, feeder control cable.

- 1) Fully insert the torch Direct Connection into wire feeder. Tighten screw or other method on wire feeder to secure torch
- 2) Connect the gas hose to barbed fitting on the direct connect pin if required.
- 3) Connect feeder control cable/plug to torch.
- 4) Connect feeder control cable/plug to the feeder.
- 5) Feed welding wire into the torch and tighten drive rolls.

**WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.**

### **Using Feeder Adaptor Kit**

In some cases it may be desirable to use a feeder adaptor kit such as when using different manufactures wire feed units to commonize on a torch configuration.

- 1) Thread feeder adaptor plug into the adaptor block and tighten.
- 2) Insert the adaptor guide tube into the adaptor plug.

- 3) Fully insert the feeder adaptor assembly into the wire feeder. Tighten screw or other method on wire feeder to secure the adaptor assembly.
- 4) If required, connect the feeder control cable/plug to the wiring on the adaptor assembly.
- 5) Connect feeder control cable/plug to the feeder.
- 6) Connect the torch to the feeder adaptor assembly.
- 7) Feed welding wire into the torch and tighten drive rolls.

**WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.**

## **MAINTENANCE**

### ***Liner Replacement***

The standard liner requires the torch be removed from the feeder in order to be changed.

#### **Standard Liner Maintenance**

**Warnings – To avoid accidental injury ensure power supply and wire feed unit is turned off.**

- 1) Trim the end of the weld wire at contact tip.
- 2) Retract or completely remove weld wire so torch can be removed from the wire feeder.
- 3) Remove the nozzle, contact tip and diffuser.
- 4) Loosen the set screw at the torch feeder connection using a 5/64" Allen wrench.
- 5) Making sure the torch cable is straight, grasp the liner at the rear of the torch with a pair of pliers and remove.
- 6) Carefully feed the new liner into the torch using short strokes to avoid kinking. You may need to twist the liner for easier insertion.
- 7) Tighten the set screw to secure the liner in the torch.
- 8) Reinstall the torch to the wire feed unit.
- 9) **IMPORTANT:** at the front end of the torch push the liner back into the gun and hold in place.
- 10) Trim the liner to ¾" stick out from the end of the gooseneck.
- 11) Replace the Diffuser, contact tip and nozzle.
- 12) Feed welding wire into the torch and tighten drive rolls.

**WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.**

## Gooseneck Replacement

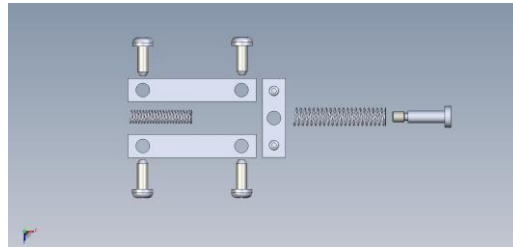
- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.
- 3) Remove the four handle screws and separate the handle assembly.
- 4) Using a wrench loosen the gooseneck / cable connection and remove from the cable assembly.
- 5) Remove the Body Insulator from the old gooseneck and install on the new one.
- 6) Thread the new gooseneck on to the cable assembly and tighten.
- 7) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit in the grooves on the sides of the body insulator. Make sure the trigger wires stay seating in the body insulator and the insulator is fully inserted into the bottom handle.
- 8) Slide the handle spring or cable support up and insert in the rear of the handle.
- 9) Install the top handle and secure with the (4) screws. **IMPORTANT:** Insure the trigger wires are not pinched between the handle.
- 10) Reinstall the diffuser, contact tip and nozzle.

## Trigger Switch Replacement

### CA SERIES TORCHES

The new Trigger Switch Assembly contains –

- 1ea. Trigger Paddle
- 2ea. Springs
- 4ea. Screws – for 2 outer contacts.
- 1ea. Shoulder Screw
- 2ea. Copper Outer Contact Plates
- 1ea. Copper Contact Plate



- 1) Secure Gooseneck in a vice.
- 2) Remove the four handle screws and separate the handle assembly.
- 3) Remove the trigger paddle shoulder screw and spring securing the center copper blade to the trigger paddle. If using the extended trigger there are two screws that secure the trigger paddle and must be removed.
- 4) Remove the (4) screws securing the copper contact assemblies and remove the trigger leads and contacts.
- 5) Using a screwdriver gently push, from the inside of the handle, the trigger paddle where it attaches to the handle and remove the trigger paddle and return spring.
- 6) Insert the return spring (the smaller diameter spring) into the seat on the bottom handle assembly.
- 7) Carefully insert the new trigger paddle into the handle assembly and tap the paddle in on the pivot point in the handle. The Trigger should snap in place.
- 8) Place the copper cross contact on the shoulder screw, then install the remaining spring over the screw, and thread into the trigger paddle until tight. **DO NOT OVER TIGHTEN.**
- 9) Using the (4) screw provided attach the (2) two outer contact plates and install the (2) two trigger leads under the front contact plate screws.
- 10) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit in the grooves on the sides of the body insulator. Make sure the trigger wires stay seating in the body insulator and the insulator is fully inserted into the bottom handle.
- 11) Slide the handle spring or cable support up and insert in the rear of the handle.
- 12) Install the top handle and secure with the (4) four screws provided. **IMPORTANT:** Insure the trigger wires are not pinched between the handle.

### PG – PISTOL GRIP SERIES TORCHES

- 1) Secure Gooseneck in a vice.
- 2) Remove the six (6) handle screws and separate the handle assembly.
- 3) Remove the trigger from the handle half and remove the trigger wires.
- 4) Reinstall the trigger wires on the new switch assembly.
- 5) Reinstall the trigger assembly inside the handle half.
- 6) Install the top handle half to the bottom handle half. **IMPORTANT:** Insure the trigger wires are not pinched between the handle.
- 7) Reinstall the six(6) handle screws and tighten.

## Unicable Replacement

- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.
- 3) Remove the four handle screws and separate the handle assembly.

- 4) Using a wrench loosen the gooseneck / cable connection and remove from the cable assembly.
- 5) Thread the gooseneck on to the new cable assembly and tighten.
- 6) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit in the grooves on the sides of the body insulator. Make sure the trigger wires stay seating in the body insulator and the insulator is fully inserted into the bottom handle.
- 7) Slide the handle spring or cable support up and insert in the rear of the handle.
- 8) Install the top handle and secure with the (4) screws. **IMPORTANT:** Insure the trigger wires are not pinched between the handle.
- 9) Reinstall the diffuser, contact tip and nozzle.
- 10) On the rear of the old cable assembly turn and remove the spring guard hand nut and slide back on the cable.
- 11) Remove the screw securing the handle to the feeder pin adaptor and separate the handle.
- 12) Unthread the power cable from the feeder adaptor block.
- 13) Slide the threaded rear handle support nut and rear spring onto the new cable assembly.
- 14) Thread the power cable to the feeder pin adaptor and tighten.
- 15) Install the trigger wire using (2) butt splices.
- 16) Install the bottom handle assembly onto the feeder adaptor assembly.
- 17) Carefully route the trigger lead thru the opening in the handle half. Make sure the trigger wires are not pinched between the handle halves.
- 18) Install the other handle half and screw the rear handle support nut and rear spring on the rear handle assembly.
- 19) Install the screw on the rear handle and feeder adaptor.
- 20) Reinstall the liner.

## **DAILY MAINTENANCE**

A few minutes per day performing a quick check of your mig torch will help to decrease weld problems, minimize downtime, and help increase consumable life.

### **At Beginning of Shift**

- Inspect the cable for cuts, nicks or tears. If you can see bare copper return for maintenance.
- Inspect the front end consumables. Clean weld spatter and inspect the nozzle insulator. If nozzle insulation is damaged is should be replaced.
- Check that the gas diffuser is tight on the gooseneck.
- Check the gas holes on the diffuser and clean if necessary.
- Check and tighten the contact tip.
- Check all electrical connections including the power cable from the power supply, torch/feeder connections, and control cables for loose connections. Tighten if necessary. Loose connections can cause overheating of cables and/or loss of electrical power.

## **OPTIONS**

<b><u>Part Number</u></b>	<b><u>Description</u></b>
75000009	Gun Hanger
75000007-ET	Extended Trigger – Includes bottom Handle Half
75000030	Heat Shield



## NOZZLE SELECTION CHART

### 300 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE ID		INSULATOR REQUIRED
				DIMENSION	O.A.L.	
75133801	NOZZLE - CONICAL	3/8" (9.5mm)	NI PLATED BRASS	.375" (9.5mm)	2.820" (71.6mm)	NONE REQ.
75133802	NOZZLE - BOTTLE NOSE	3/8" (9.5mm)	NI PLATED BRASS	.375" (9.5mm)	2.820" (71.6mm)	NONE REQ.
75135601-I	NOZZLE - CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.820" (71.6mm)	INSTALLED
75135002-I	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.820" (71.6mm)	INSTALLED
75135003-I	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.672" (67.96mm)	INSTALLED
75135602-I	NOZZLE - CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.545" (64.6mm)	INSTALLED
75135004	NOZZLE - CONICAL SHORT	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	1.937" (49.2mm)	NONE REQ.

### 400 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE		INSULATOR REQUIRED
				ID DIMENSION	O.A.L.	
75146201-I	NOZZLE - BOTTLE NOSE	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.125" (79.4mm)	INSTALLED
75145001	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.031" (77.0mm)	75001733
75146202	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.125" (79.4mm)	75001738
75146202C	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED COPPER	.625" (15.9mm)	3.125" (79.4mm)	75001738
75146202CU	NOZZLE - CONICAL	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	3.125" (79.4mm)	75001738
75145601-I	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	3.125" (79.4mm)	INSTALLED
75145002C	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED COPPER	.531" (13.5mm)	3.125" (79.4mm)	75001738
75145002CU	NOZZLE - TAPERED	1/2" (12.7mm)	BARE COPPER	.531" (13.5mm)	3.125" (79.4mm)	75001738
75145003	NOZZLE - TAPERED (LONG)	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.915" (99.4mm)	NONE REQ.
75146501S	NOZZLE - SPOT	5/8" (15.9mm)	NI PLATED BRASS	.656" (16.7mm)	3.437" (87.3mm)	75001738
75146204-I	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	2.820" (71.6mm)	INSTALLED
75146204CU	NOZZLE - CONICAL	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	2.820" (71.6mm)	75001738
75145602-I	NOZZLE - SMALL CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.820" (71.6mm)	INSTALLED
75144301-I	NOZZLE - TAPERED	7/16" (11.1mm)	NI PLATED BRASS	.438" (11.1mm)	2.820" (71.6mm)	INSTALLED
75145004	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.125" (79.4mm)	75001733
75146205-I	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.031" (77.0mm)	INSTALLED
75146205CU	NOZZLE - TAPERED	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	3.031" (77.0mm)	75001738
75146206-I	NOZZLE - SHORT CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	1.875" (47.6mm)	INSTALLED
75146207-I	NOZZLE - SHORT CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	2.187" (55.6mm)	INSTALLED
75147501	NOZZLE - CYLINDRICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.125" (79.4mm)	75001738
75147501CU	NOZZLE - CYLINDRICAL	3/4" (19.0mm)	BARE COPPER	.703" (17.9mm)	3.125" (79.4mm)	75001738
75145603-I	NOZZLE - SHORT TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.375" (60.3mm)	INSTALLED
75145005	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.820" (71.6mm)	75001733
75144302-I	NOZZLE - TAPERED	7/16" (11.1mm)	NI PLATED BRASS	.438" (11.1mm)	3.125" (79.4mm)	INSTALLED

### 500 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE		INSULATOR REQUIRED
				ID DIMENSION	O.A.L.	
75156201	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.670" (67.8mm)	175001740
75156201-I	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.670" (67.8mm)	INSTALLED
75157501	NOZZLE - CONICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.187" (81.0mm)	75001740
75157501-I	NOZZLE - CONICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.187" (81.0mm)	INSTALLED

## CONTACT TIP SELECTION CHART

### **M6 CONTACT TIPS**

PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
<b><i>COPPER (CU)</i></b>			
75023511	.023" (.6mm)	.034"	CONTACT TIP (STANDARD)
75030511	.030" (.8mm)	.038"	CONTACT TIP (STANDARD)
75035511	.035" (.9mm)	.044"	CONTACT TIP (STANDARD)
75035512	.040" (1mm)	.048"	CONTACT TIP (STANDARD)
75045511	.045" (3/64") (1.2mm)	.053"	CONTACT TIP (STANDARD)
75045512	.045" (3/64") (1.2mm)	.059"	CONTACT TIP (STANDARD)

### **M8 CONTACT TIPS**

PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
<b><i>COPPER (CU)</i></b>			
75030014	.030" (.8mm)	.038"	CONTACT TIP (STANDARD)
75035014	.035" (.9mm)	.044"	CONTACT TIP (STANDARD)
75040014	.040" (1.0mm)	.048"	CONTACT TIP (STANDARD)
75045014	.045" (3/64") (1.2mm)	.054"	CONTACT TIP (STANDARD)
75052014	.052" (1.3mm)	.061"	CONTACT TIP (STANDARD)
75062014	.062" (1/16") (1.6mm)	.073"	CONTACT TIP (STANDARD)
75062015	.062" (1/16") (1.6mm)	.076"	CONTACT TIP (STANDARD)
75078014	.078" (5/64") (2.0 mm)	.087"	CONTACT TIP (STANDARD)
75093014	.093" (3/32") (2.4mm)	.106"	CONTACT TIP (STANDARD)

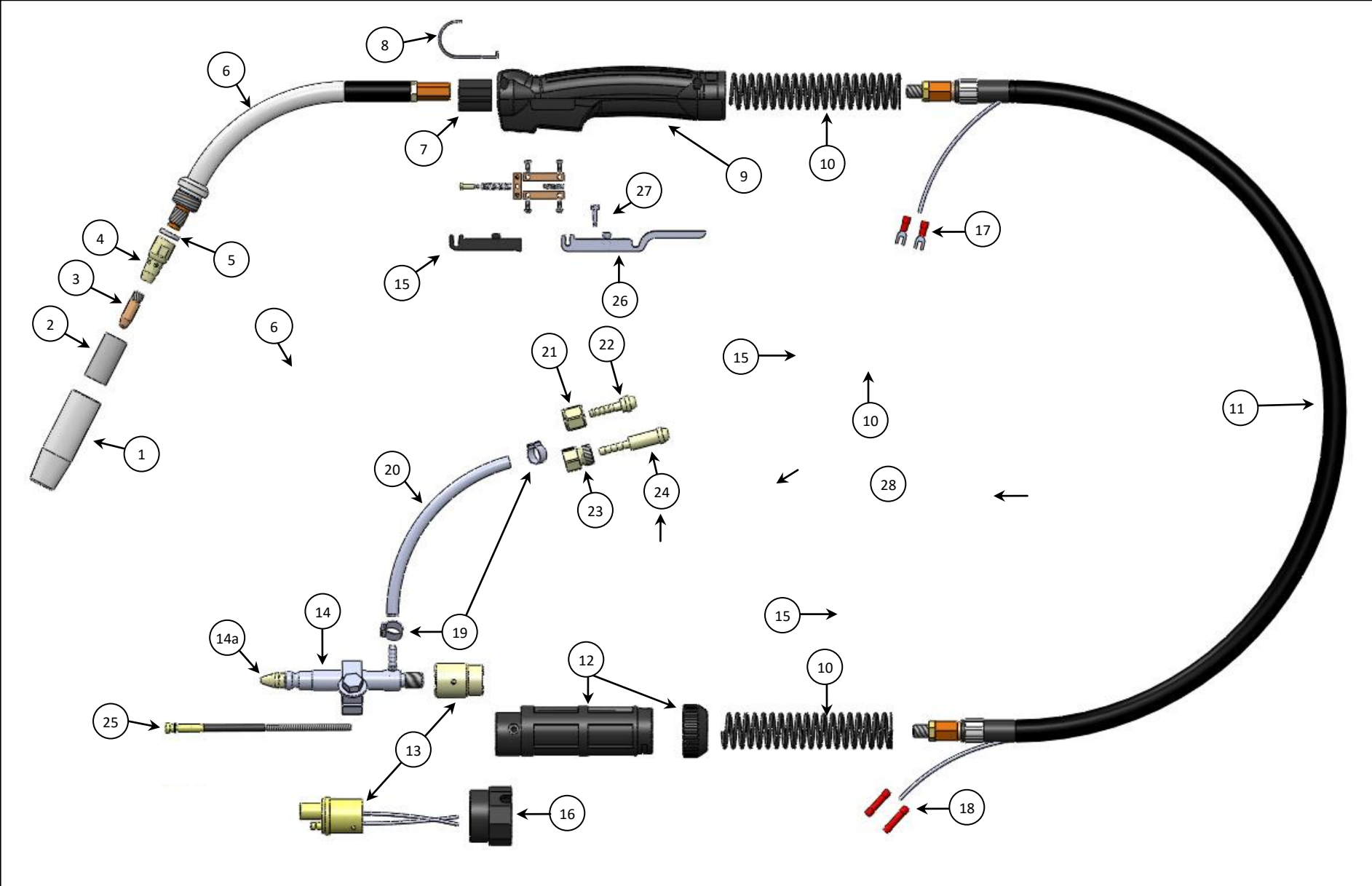
### **M8 HRT – EXTENDED LIFE CONTACT TIPS**

PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
20040400	.040" (1.0mm)	.050"	.315 OD CONTACT TIP
20045400	.045" (3/64") (1.2mm)	.054"	.315 OD CONTACT TIP
20035500	.035" (.9mm)	.044"	.395 OD CONTACT TIP
20040500	.040" (1.0mm)	.050"	.395 OD CONTACT TIP
20045500	.045" (3/64") (1.2mm)	.054"	.395 OD CONTACT TIP
20052500	.052" (1.3mm)	.061"	.395 OD CONTACT TIP
20062500	.062" (1/16") (1.6mm)	.073"	.395 OD CONTACT TIP

## LINER SELECTION CHART

PART #	DESCRIPTION
75010215T	.023-.030 LINER, 10FT – T STYLE
75015215T	.023-.030 LINER, 15FT – T STYLE
75010222T	.035-.045 LINER, 10FT – T STYLE
75015222T	.035-.045 LINER, 15FT – T STYLE
75025222T	.035-.045 LINER, 25FT – T STYLE
75010228T	.045-1/16 LINER, 10FT – T STYLE
75015228T	.045-1/16 LINER, 15FT – T STYLE
75025228T	.045-1/16 LINER, 25FT – T STYLE
75010229T	5/64-3/32 LINER, 10FT – T STYLE
75015229T	5/64-3/32 LINER, 15FT – T STYLE
75025229T	5/64-3/32 LINER, 25FT – T STYLE

# PARTS BREAKDOWN – 238, 347, 407, 507



NO.	DESCRIPTION	238	347	354	407	454	500	507
1	CONICAL NOZZLE							
	TAPERED NOZZLE							
	BOTTLENOSE NOZZLE							
2	NOZZLE INSULATOR							
3	CONTACT TIP							
4	GAS DIFFUSER, STANDARD	75002007	75002007	75004033	75004033	75004033	75004033	75004033
	GAS DIFFUSER, SHORT	75002007S	75002007S	75004033S	75004033S	75004033S	75004033S	75004033S
	GAS DIFFUSER, LONG	75002007L	75002007L	75004033L	75004033L	75004033L	75004033L	75004033L
	GAS DIFFUSER, X-LONG	75002007XL	75002007XL	75004033XL	75004033XL	75004033XL	75004033XL	75004033XL
5	INSULATING WASHER	75001003	75001005	75001004	75001004	75001004	75001004	75001006
6	GOOSENECK, 60 DEGREE – CA SERIES	75003004	75004004	75004CAS	75004036	75005038	75005038	75005036
	GOOSENECK, 45 DEGREE- CA SERIES	75003003	75004003	7500CAS-45	75004035	75005037	75005037	75005035
	GOOSENECK, 180 DEGREE- PGRIP	N/A	75003051	75003051	75004051	75004051	75004051	75007057
	GOOSENECK, 22 DEGREE- PGRIP	N/A	75003052	75003052	75004052	75004052	75004052	75007058
	GOOSENECK, 45 DEGREE- PGRIP	N/A	75003053	75003053	75004053	75004053	75004053	75007059
7	BODY INSULATOR	75003002	75003002	75003002	75003002	75003002	75003002	75003000
8	GUN HANGER <i>(Optional)</i>	75000009	75000009	75000009	75000009	75000009	75000009	75000009
9	HANDLE ASSEMBLY – STD.	75000003	75000003	75000003	75000003	75000003	75000003	75000003
	HANDLE ASSEMBLY – PISTOL GRIP	N/A	75000003P	75000003P	75000003P	75000003P	75000003P	75000003P
	HANDLE ASSEMBLY – EXT. TRIGGER	75000003-ET	75000003-ET	75000003-ET	75000003-ET	75000003-ET	75000003-ET	75000003-ET
	HANDLE TOP – STD.	75000006	75000006	75000006	75000006	75000006	75000006	75000006
	HANDLE TOP – DUAL SCHEDULE	N/A	75000006-SW	75000006-SW	75000006-SW	75000006-SW	75000006-SW	75000006-SW
	HANDLE BOTTOM – STD.	75000007	75000007	75000007	75000007	75000007	75000007	75000007
	HANDLE BOTTOM – EXT. TRIGGER	75000007-ET	75000007-ET	75000007-ET	75000007-ET	75000007-ET	75000007-ET	75000007-ET
	HANDLE SCREWS – STD (4 REQUIRED)	75000008	75000008	75000008	75000008	75000008	75000008	75000008
	HANDLE SCREW- PGRIP (6 REQUIRED)	75000008P	75000008P	75000008P	75000008P	75000008P	75000008P	75000008P
NS	SWITCH ASSY – DUAL SCHEDULE	N/A	75000017	75000017	75000017	75000017	75000017	75000017
NS	SWITCH ASSY. – MULTI-SCHEDULE	N/A	75000018	75000018	75000018	75000018	75000018	75000018
NS	DS/MS SWITCH CONNECTORS	N/A	75077018	75077018	75077018	75077018	75077018	75077018
10	CABLE SUPPORT SPRING	75002005	75002005	75002005	75002005	75002005	N/A	N/A
NS	CABLE SUPPORT BOOT	N/A	N/A	N/A	N/A	N/A	75006033	75006033
11	10' POWER CABLE	75010207	75010307	75010307	75010407	75010407	75010507	75010507
	12' POWER CABLE	75012207	75012307	75012307	75012407	75012407	75012507	75012507
	15' POWER CABLE	75015207	75015307	75015307	75015407	75015407	75015507	75015507
	20' POWER CABLE	75020207	75020307	75020307	75020407	75020407	75020507	75020507
	25' POWER CABLE	75025207	75025307	75025307	75025407	75025407	75025507	75025507
12	2 PIECE ADAPTOR SUPPORT	75077010	75077010	75077010	75077012	75077012	75077012	75077012
NS	ADAPTOR SCREW	75077011	75077011	75077011	75077011	75077011	75077011	75077011
13	DIR CON ADAPT BLK	37077000	37077000	37077000	37077000	37077000	37077000-C	37077000-C
	EURO ADAPT BLOCK	75001148	75001148	75001148	75001148	75001148	75001149	75001149
14	<b>DIR CON FEEDER PLUG</b>							
	MILLER	37577705	37577705	37577705	37577705	37577705	37577705	37577705
	OTC / DAIHEN	37577700	37577700	37577700	37577700	37577700	37577700	37577700
	OTC DP SERIES	37577701	37577701	37577701	37577701	37577701	37577701	37577701
	LINCOLN LN7	37577832	37577832	37577832	37577832	37577832	37577832	37577832
	PANASONIC	37577999	37577999	37577999	37577999	37577999	37577999	37577999

NO.	DESCRIPTION	238	347	354	407	454	500	507
	TWECO #4	37577699	37577699	37577699	37577699	37577699	37577699	37577699
	TWECO #5	37577930	37577930	37577930	37577930	37577930	37577930	37577930
14a	CAP - MILLER FEEDER PIN	37577705-N	37577705-N	37577705-N	37577705-N	37577705-N	37577705-N	37577705-N
	CAP - OTC FEEDER PIN	38277001-N078	38277001-N078	38277001-N078	38277001-N078	38277001-N078	38277001-N078	38277001-N078
	CAP - EURO	37077005	37077005	37077005	37077005	37077005	37077005	37077005
NS	O-RING- MILLER PIN	37577102	37577102	37577102	37577102	37577102	37577102	37577102
NS	O-RING- TWECO #4 PIN	37677102	37677102	37677102	37677102	37677102	37677102	37677102
NS	O-RING- TWECO #5 PIN	75000021	75000021	75000021	75000021	75000021	75000021	75000021
NS	CONTROL CABLE, MILLER	37577201	37577201	37577201	37577201	37577201	37577201	37577201
NS	CONTROL CABLE, LINCOLN	37777200	37777200	37777200	37777200	37777200	37777200	37777200
NS	CONTROL CABLE, OTC	37777250	37777250	37777250	37777250	37777250	37777250	37777250
NS	CONTROL CABLE, TWECO	37677200	37677200	37677200	37677200	37677200	37677200	37677200
15	TRIGGER SWITCH ASSY-STD.	75000004	75000004	75000004	75000004	75000004	75000004	75000004
NS	TRIGGER SWITCH ASSY- PISTOL GRIP	N/A	75000011P	75000011P	75000011P	75000011P	75000011P	75000011P
16	EURO ADAPT NUT	75077014	75077014	75077014	75077014	75077014	75077014	75077014
17	TRIGGER WIRE CONNECTOR	75077024	75077024	75077024	75077024	75077024	75077024	75077024
18	BUTT SPLICE	75077066	75077066	75077066	75077066	75077066	75077066	75077066
19	7/16 HOSE CLAMP	38577108	38577108	38577108	38577108	38577108	38577108	38577108
20	GAS HOSE PER FOOT	38577087	38577087	38577087	38577087	38577087	38577087	38577087
21	TYPE B GAS NUT	38677145	38677145	38677145	38677145	38677145	38677145	38677145
22	TYPE B GAS NIPPLE	38677144	38677144	38677144	38677144	38677144	38677144	38677144
23	INERT GAS NUT	38677141	38677141	38677141	38677141	38677141	38677141	38677141
24	INERT GAS NIPPLE	38677142	38677142	38677142	38677142	38677142	38677142	38677142
25	LINER	SEE LINER SELECTION CHART PAGE 9						
26	EXTENDED TRIGGER PADDLE	75000005-E	75000005-E	75000005-E	75000005-E	75000005-E	75000005-E	75000005-E
27	EXTENDED TRIGGER SCREW	75000013	75000013	75000013	75000013	75000013	75000013	75000013



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