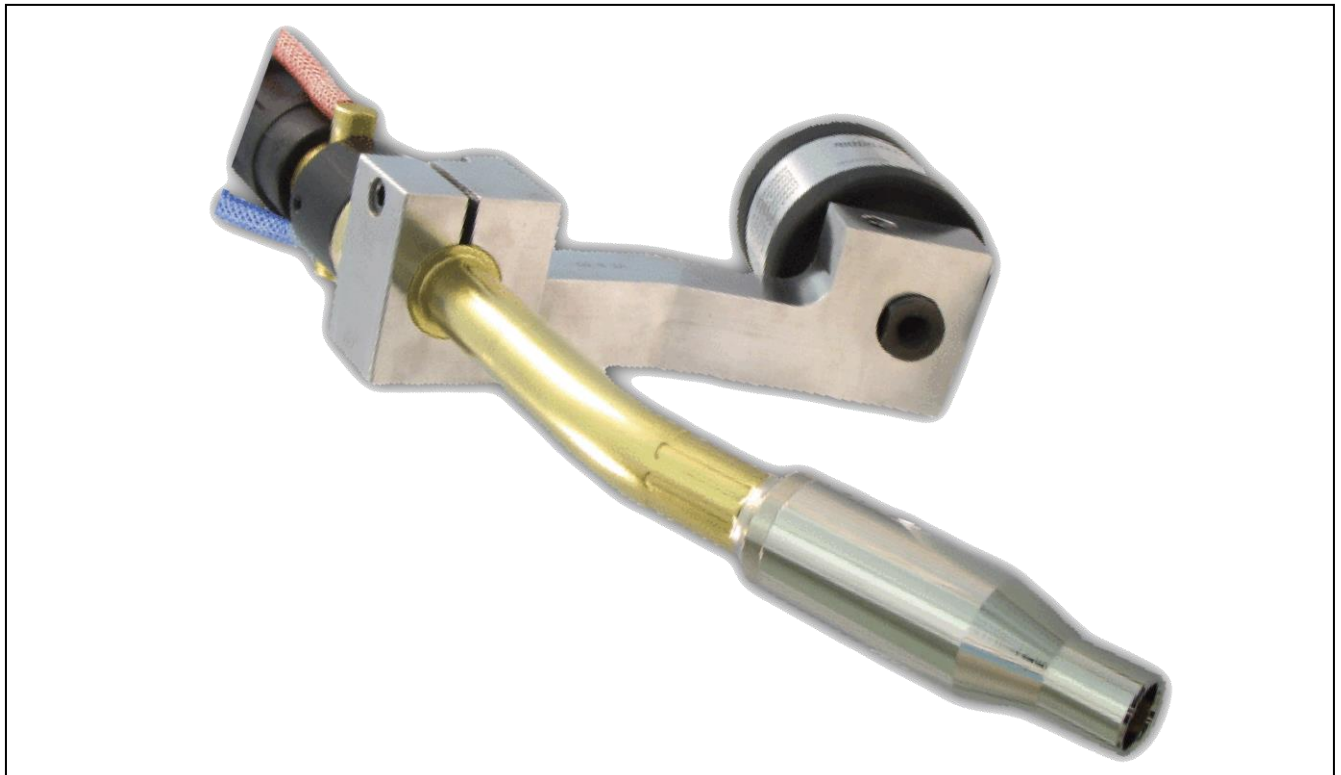


Water-Cooled Robotic MIG Torches

For Models
450R,550R,600R



INSTALLATION, OPERATIONS AND REPLACEMENT PARTS MANUAL

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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 or email us at 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.

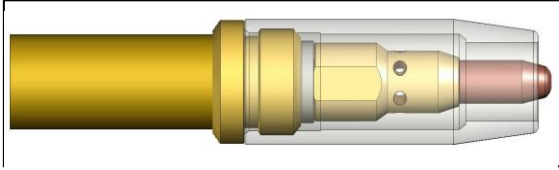
TORCH SPECIFICATIONS

MODEL	AMPERAGE	100% Duty Cycle		60% Duty Cycle	
		CO2	Mixed Gas	CO2	Mixed Gas
450R	450	400A	350A	450A	400A
550R	550	500A	450A	550A	500A
600R	600	550A	500A	600A	550A

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

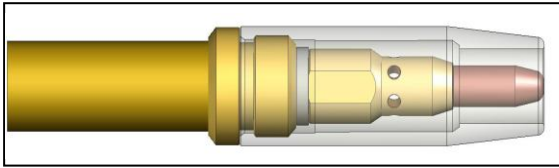
NOZZLE/TIP RELATIONSHIPS

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.



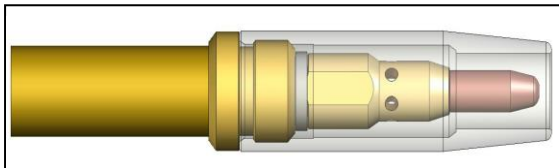
Extended Tip – Short Circuit (Short Arc, Dip Transfer) Welding Applications

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.

Torch Mount Installation

The robotic torch has a precious locating flat for accurate locating in the mating torch mount.

- 1) Loosen the cap screw in the torch mount.
- 2) Insert the torch through the top of the mount lining the locating flat on the torch with the mating flat on the torch mount.
- 3) Fully insert the torch into the torch mount.
- 4) Tighten the cap screw to secure the torch into the torch mounting arm.

MAINTENANCE

Liner Replacement

There are two types of liners offered – standard and the EASY front loading liner system. The standard liner requires the torch be removed from the feeder in order to be changed. The EASY front load system only requires the removal of the front end consumables.

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 3/4" 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.

Hybrid Air-Cooled Unicable Replacement

- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.
- 3) Remove the 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 bottom handle assembly onto the feeder adaptor assembly.
- 16) Install the other handle half and screw the rear handle support nut and rear spring on the rear handle assembly.
- 17) Install the screw on the rear handle and feeder adaptor.
- 18) Reinstall the liner.

Water-Cooled Cable Assembly Replacement

- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.
- 3) Remove the handle screws and separate the handle assembly.
- 4) Unthread the power cable from the gooseneck.
- 5) Cut off the clamps from the water line and conduit and pull off neck assembly. You may have to slit with knife.
- 6) Slide new clamps on the water line and conduit of the new cable assembly.
- 7) Thread the power cable to the gooseneck and tighten.

- 8) Push the water line and conduit on the gooseneck assembly and crimp the clamps.
- 9) Install two open end terminals to the trigger wire assembly and attached to the screws on the trigger assembly in the bottom handle.
- 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) screws. **IMPORTANT:** Insure the trigger wires are not pinched between the handle.
- 13) Reinstall the diffuser, contact tip and nozzle.
- 14) On the rear of the old cable assembly turn and remove the spring guard hand nut and rear support spring and slide back on the cable assembly.
- 15) Remove the screw securing the handle to the feeder pin adaptor and separate the handle.
- 16) Unthread the power cable from the feeder adaptor block.
- 17) Cut off the clamps from the short red water line (do not discard as reusable) and conduit and pull off. You may have to slit with knife.
- 18) Slide the threaded rear handle support nut and rear support spring onto the new cable assembly.
- 19) Slide new clamps on the short red water line and conduit of the new cable assembly.
- 20) Thread the power cable to the feeder pin adaptor and tighten.
- 21) Push the red water line and conduit on the feeder pin adaptor and crimp the clamps.
- 22) Install the trigger wire using (2) butt splices.
- 23) Install the bottom handle assembly onto the feeder adaptor assembly.
- 24) Carefully route the red and blue water lines and the trigger lead thru the opening in the handle half. Make sure the water lines are not pinched between the handle halves.
- 25) Install the other handle half and screw the rear handle support nut and spring on the rear handle assembly.
- 26) Install the screw on the rear handle and feeder adaptor.
- 27) 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.

NOZZLE SELECTION CHART

300 SERIES NOZZLES

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

400R/500 SERIES NOZZLES

PART #	DESCRIPTION	TYPE	BORE SIZE	MATERIAL	BORE ID DIMENSION	O.A.L.	INSULATOR REQUIRED
75146201-I	NOZZLE - BOTTLE NOSE	E	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	3.125" (79.4mm)	INSTALLED
75145001	NOZZLE - BOTTLE NOSE	C	1/2" (12.7mm)	NI PLATED BRASS	.500"(12.7mm)	3.031" (77.0mm)	75001733
75146202	NOZZLE - CONICAL	A	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	3.125" (79.4mm)	75001738
75146202C	NOZZLE - CONICAL	A	5/8" (15.9mm)	NI PLATED COPPER	.625"(15.9mm)	3.125" (79.4mm)	75001738
75146202CU	NOZZLE - CONICAL	A	5/8" (15.9mm)	BARE COPPER	.625"(15.9mm)	3.125" (79.4mm)	75001738
75145601-I	NOZZLE - TAPERED	B	9/16" (14.2mm)	NI PLATED BRASS	.563"(14.2mm)	3.125" (79.4mm)	INSTALLED
75145002C	NOZZLE - TAPERED	B	1/2" (12.7mm)	NI PLATED COPPER	.531"(13.5mm)	3.125" (79.4mm)	75001738
75145002CU	NOZZLE - TAPERED	B	1/2" (12.7mm)	BARE COPPER	.531"(13.5mm)	3.125" (79.4mm)	75001738
75145003	NOZZLE - TAPERED (LONG)	B	1/2" (12.7mm)	NI PLATED BRASS	.500"(12.7mm)	3.915" (99.4mm)	NONE REQ.
75146501S	NOZZLE - SPOT	H	5/8" (15.9mm)	NI PLATED BRASS	.656"(16.7mm)	3.437" (87.3mm)	75001738
75146204-I	NOZZLE - CONICAL	A	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	2.820" (71.6mm)	INSTALLED
75146204CU	NOZZLE - CONICAL	A	5/8" (15.9mm)	BARE COPPER	.625"(15.9mm)	2.820" (71.6mm)	75001738
75145602-I	NOZZLE - SMALL CONICAL	D	9/16" (14.2mm)	NI PLATED BRASS	.593"(15.1mm)	2.820" (71.6mm)	INSTALLED
75144301-I	NOZZLE - TAPERED	D	7/16" (11.1mm)	NI PLATED BRASS	.438"(11.1mm)	2.820" (71.6mm)	INSTALLED
75145004	NOZZLE - BOTTLE NOSE	C	1/2" (12.7mm)	NI PLATED BRASS	.500"(12.7mm)	3.125" (79.4mm)	75001733
75146205-I	NOZZLE - CONICAL	A	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	3.031" (77.0mm)	INSTALLED
75146205CU	NOZZLE - TAPERED	B	5/8" (15.9mm)	BARE COPPER	.625"(15.9mm)	3.031" (77.0mm)	75001738
75146206-I	NOZZLE - SHORT CONICAL	G	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	1.875" (47.6mm)	INSTALLED
75146207-I	NOZZLE - SHORT CONICAL	G	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	2.187" (55.6mm)	INSTALLED
75146209-I	NOZZLE - BOTTLE NOSE	E	5/8" (15.9mm)	NI PLATED BRASS	.625"(15.9mm)	3.125" (79.4mm)	INSTALLED
75147501	NOZZLE - CYLINDRICAL	F	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.125" (79.4mm)	75001738
75147501CU	NOZZLE - CYLINDRICAL	F	3/4" (19.0mm)	BARE COPPER	.703" (17.9mm)	3.125" (79.4mm)	75001738
75145603-I	NOZZLE - SHORT TAPERED	G	9/16" (14.2mm)	NI PLATED BRASS	.563"(14.2mm)	2.375" (60.3mm)	INSTALLED
75145005	NOZZLE - BOTTLE NOSE	C	1/2" (12.7mm)	NI PLATED BRASS	.500"(12.7mm)	2.820" (71.6mm)	75001733
75144302-I	NOZZLE - TAPERED	D	7/16" (11.1mm)	NI PLATED BRASS	.438"(11.1mm)	3.125" (79.4mm)	INSTALLED

CONTACT TIP SELECTION CHART

M6 CONTACT TIPS

<u>PART #</u>	<u>WIRE SIZE</u>	<u>NOMINAL I.D.</u>	<u>DESCRIPTION</u>
<i>COPPER (CU)</i>			
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

<u>PART #</u>	<u>WIRE SIZE</u>	<u>NOMINAL I.D.</u>	<u>DESCRIPTION</u>
<i>COPPER (CU)</i>			
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)

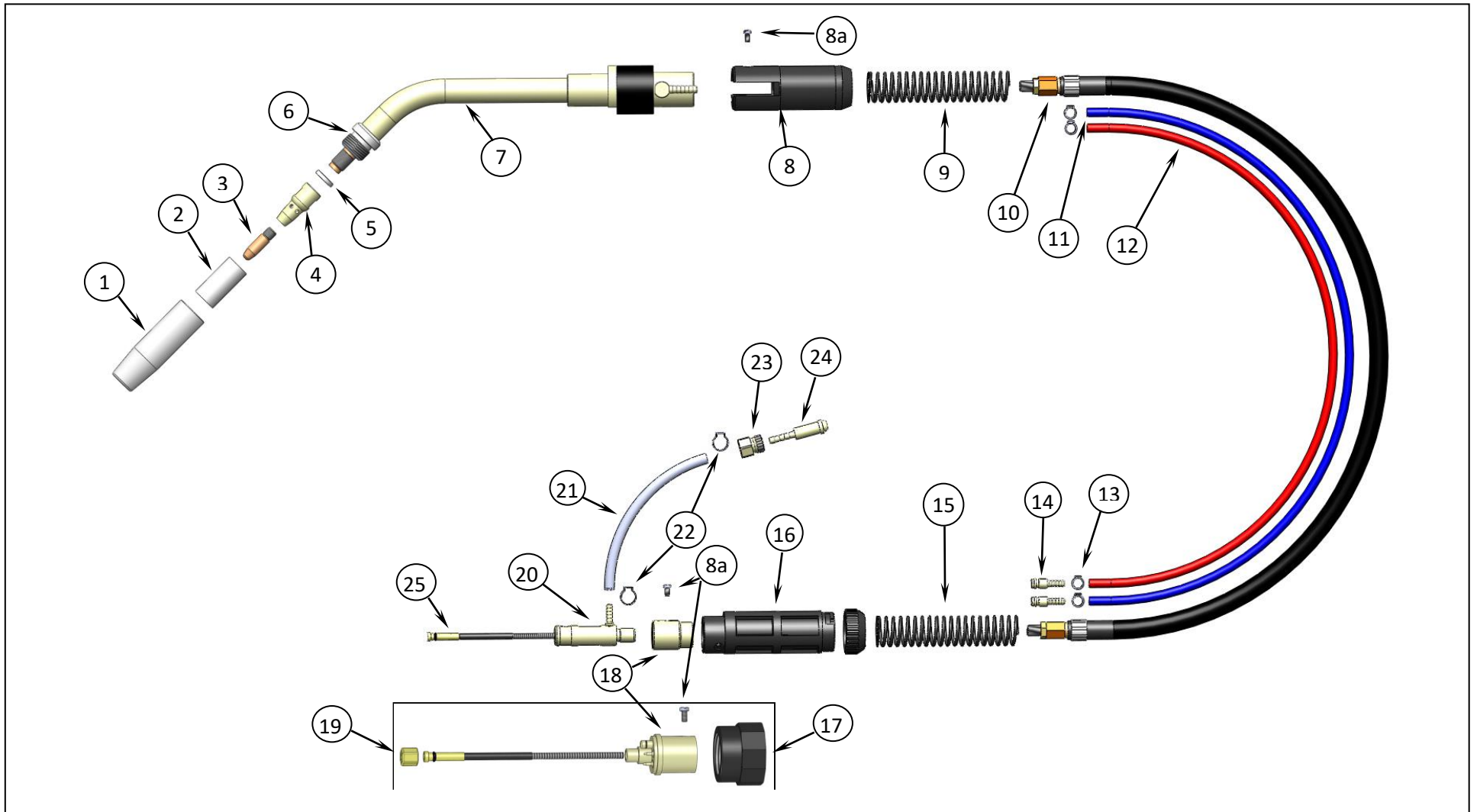
M8 HRT – EXTENDED LIFE CONTACT TIPS

<u>PART #</u>	<u>WIRE SIZE</u>	<u>NOMINAL I.D.</u>	<u>DESCRIPTION</u>
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

ROBOTIC TEACH TIPS

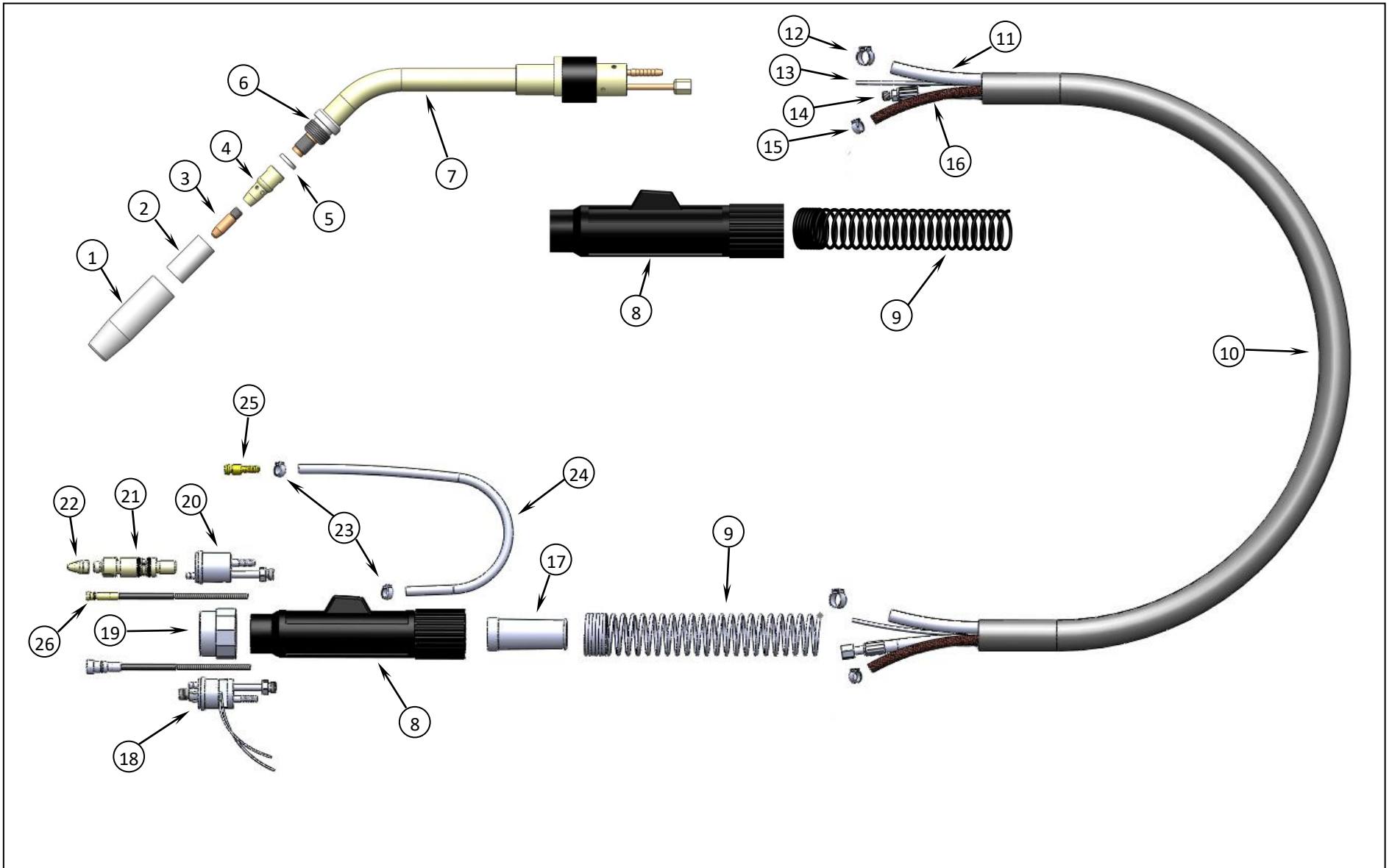
750TT014-.500	ROBOTIC TEACH TIP (014 SERIES TIP WITH .500" WIRE STICKOUT)
750TT014-.625	ROBOTIC TEACH TIP (014 SERIES TIP WITH .625" WIRE STICKOUT)
750TT014-.750	ROBOTIC TEACH TIP (014 SERIES TIP WITH .750" WIRE STICKOUT)
750TT230-.625	ROBOTIC TEACH TIP (230 SERIES TIP WITH .625" WIRE STICKOUT)
750TT511-.625	ROBOTIC TEACH TIP (511 SERIES TIP WITH .625" WIRE STICKOUT)

PARTS BREAKDOWN – 450R/550R



450R/550R PARTS LIST

NO.	DESCRIPTION	450R	550R	NO.	DESCRIPTION	450R	550R
1	NOZZLE	SEE NOZZLE SELECTION TABLE PAGE 9		NS	ORING – EURO ADAPTOR BLOCK	28500002	28500002
2	NOZZLE INSULATOR	SEE NOZZLE SELECTION TABLE PAGE 9		19	CAP - MILLER FEEDER PIN	37577705-N	37577705-N
3	CONTACT TIP	SEE CONTACT TIP SELECTION TABLE PAGE 10			CAP - OTC FEEDER PIN	38277001-N078	38277001-N078
4	GAS DIFFUSER, STANDARD	75004033	75004033		CAP - EURO	37077005	37077005
	GAS DIFFUSER, SHORT	75004033S	75004033S	20	MILLER FEEDER PIN	37577705	37577705
	GAS DIFFUSER, LONG	75004033L	75004033L		OTC / DAIHEN FEEDER PIN	37577700	37577700
	GAS DIFFUSER, X-LONG	75004033XL	75004033XL		OTC DP SERIES FEEDER PIN	37577701	37577701
5	INSULATING WASHER	75001004	75001004		LINCOLN LN7 FEEDER PIN	37577832	37577832
6	REPLACEABLE NOZZLE SEAT - OPTION	75077850	75077850		PANASONIC FEEDER PIN	37577999	37577999
7	GOOSENECK, 180 DEGREE	450R-180-H	550R-180-H		TWECO #4 FEEDER PIN	37577699	37577699
	GOOSENECK, 22 DEGREE	450R-22-H	550R-22-H		TWECO #5 FEEDER PIN	37577930	37577930
	GOOSENECK, 45 DEGREE-	450R-45-H	550R-45-H	NS	O-RING- MILLER PIN	37577102	37577102
8	FRONT HANDLE SUPPORT	75077017W	75077017W	NS	O-RING- TWECO #4 PIN	37677102	37677102
8a	SUPPORT SCREW	75077011	75077011	NS	O-RING- TWECO #5 PIN	75000021	75000021
NS	INSULATING CAPS	75099755	75099755	21	GAS HOSE PER FOOT	38577087	38577087
9	CABLE SUPPORT SPRING	75002009	75002009	22	7/16 HOSE CLAMP	38577108	38577108
10	3' POWER CABLE	75003400R	75003500R	23	INERT GAS NUT	38677141	38677141
	4' POWER CABLE	75004400R	75004500R	24	INERT GAS NIPPLE	38677142	38677142
	5' POWER CABLE	75005400R	75005500R	25	.023-.030 LINER, 5FT – T STYLE	75005215T	75005215T
	6' POWER CABLE	75006400R	75006500R		.023-.030 LINER, 10FT – T STYLE	75010215T	75010215T
	8' POWER CABLE	75008400R	75008500R		.035-.045 LINER, 5FT – T STYLE	75005222T	75005222T
	10' POWER CABLE	75010400R	75010500R		.035-.045 LINER, 10FT – T STYLE	75010222T	75010222T
11	BLUE WATER HOSE – ORDER PER FOOT	75099025	75099025		.045-1/16 LINER, 5FT – T STYLE	75005228T	75005228T
12	RED WATER HOSE – ORDER PER FOOT	75099026	75099026		.045-1/16 LINER, 10FT – T STYLE	75010228T	75010228T
11	REAR ADAPTOR SUPPORT SPRING	75002005	75002009		5/64-3/32 LINER, 5FT – T STYLE	75005229T	75005229T
	EURO REAR ADAPTOR SUPPORT SPRING	75002005	75006033S		5/64-3/32 LINER, 10FT – T STYLE	75010229T	75010229T
12	REAR ADAPTOR SUPPORT	75077010	75077017	NS	LINER ORING	75000001	75000001
	EURO REAR ADAPTOR SUPPORT	75077010	75077012				
13	HOSE CLAMPS	38577105	38577105				
14	MALE QUICK DISCONNECTS	38660000	38660000				
15	REAR ADAPTOR SUPPORT SPRING	75002005	75006033				
16	REAR ADAPTOR SUPPORT	75077012	75077012				
17	EURO HAND NUT	75077014	75077014				
18	DIR CONNECT ADAPT BLOCK	37077000	37077000-C				
	EURO ADAPTOR BLOCK	75001148	75001148				



PARTS LISTING

NO.	DESCRIPTION	600R
1	NOZZLE	SEE NOZZLE SELECTION TABLE PAGE 8
2	NOZZLE INSULATOR	SEE NOZZLE SELECTION TABLE PAGE 8
3	CONTACT TIP	SEE CONTACT TIP SELECTION TABLE PAGE 9
4	GAS DIFFUSER, STANDARD	75004033
	GAS DIFFUSER, SHORT	75004033S
	GAS DIFFUSER, LONG	75004033L
	GAS DIFFUSER, X-LONG	75004033XL
5	INSULATING WASHER	75001004
6	REPLACEABLE NOZZLE SEAT - OPTION	75077580
7	GOOSENECK, 180 DEGREE	600R-180-H
	GOOSENECK, 22 DEGREE	600R-22-H
	GOOSENECK, 45 DEGREE-	600R-45-H
8	FRONT/REAR HANDLE SUPPORT	75077012
NS	SUPPORT SCREW	75077011
9	CABLE SUPPORT SPRING	75006033S
10	3' POWER CABLE ASSY.	75003600R
	4' POWER CABLE ASSY.	75004600R
	5' POWER CABLE ASSY.	75005600R
	6' POWER CABLE ASSY.	75006600R
	8' POWER CABLE ASSY.	75008600R
	10' POWER CABLE ASSY.	75010600R
11	WIRE/GAS CONDUIT – ORDER PER FOOT	75099600
12	CONDUIT CLAMP	38577108
13	ANTI-STRETCH CORD	75099001
14	WATER-COOLED POWER CABLE – 3'	75006003
	WATER-COOLED POWER CABLE – 4'	75006004
	WATER-COOLED POWER CABLE – 5'	75006005
	WATER-COOLED POWER CABLE – 6'	75006006
	WATER-COOLED POWER CABLE – 8'	75006008
	WATER-COOLED POWER CABLE – 10'	75006010
15	7/16" HOSE CLAMP	38777108
16	WATER-IN BLUE – ORDER PER FOOT	75099025
17	CABLE SUPPORT BOOT	75006033
18	EURO ADAPTOR BLOCK	75006148
NS	O-RING - EURO ADAPTOR BLOCK	28500002

NO.	DESCRIPTION	600R
19	EURO HAND NUT	75077014
20	DIR CONN ADAPTOR BLOCK	775006148-DC
21	MILLER FEEDER PIN	37577705
	OTC / DAIHEN FEEDER PIN	37577700
	OTC DP SERIES FEEDER PIN	37577701
	LINCOLN LN7 FEEDER PIN	37577832
	PANASONIC FEEDER PIN	37577999
	TWECO #4 FEEDER PIN	37577699
	TWECO #5 FEEDER PIN	37577930
NS	O-RING- MILLER PIN	37577102
NS	O-RING- TWECO #4 PIN	37677102
NS	O-RING- TWECO #5 PIN	75000021
22	CAP - MILLER FEEDER PIN	37577705-N
	CAP - OTC FEEDER PIN	38277001-N078
	CAP - EURO	37077005
23	7/16 HOSE CLAMP	38577108
24	GAS HOSE PER FOOT	38577087
25	QUICK DISCONNECT - MALE	38660000
NS	QUICK DISCONNECT – FEMALE	38660001
21	.023-.030 LINER, 5FT – T STYLE	75005215T
	.023-.030 LINER, 10FT – T STYLE	75010215T
	.035-.045 LINER, 5FT – T STYLE	75005222T
	.035-.045 LINER, 10FT – T STYLE	75010222T
	.045-1/16 LINER, 5FT – T STYLE	75005228T
	.045-1/16 LINER, 10FT – T STYLE	75010228T
	5/64-3/32 LINER, 5FT – T STYLE	75005229T
	5/64-3/32 LINER, 10FT – T STYLE	75010229T
NS	LINER ORING	75000001

NOTES:



AMERICAN WELDQUIP

1375 Wolf Creek Trail – P.O. Box 397
Sharon Center, Ohio 44274
330-239-0317 Telephone / 800-949-9353 Fax

