



Mounting instructions for replacement of steel liner

1 Fully extend the hose

Steel: steel - flux cored wire

Steel teflon: stainless - alu

2

I

Old liner

II

Water
Air

III

New liner

IV

Tighten up to avoid gas leaks

MIGATRONIC AIR COOLED torch ML KD

MIGATRONIC WATER COOLED torch MV KD / MV FIXED

3 Mount tip holder

← Push softly new liner backwards

3 Mount contact tip

← Push softly new liner backwards

4 Cut Liner Length (CLL)
 $X - 3mm = CLL$

Example:
 $X = 190mm - 3mm = 187mm$ CLL

Let the liner run towards the tip holder →

$X - 3mm = CLL$ ← Note! Measure X

4 Cut Liner Length (CLL)
 $X - 3mm = CLL$

Example:
 $X = 190mm - 3mm = 187mm$ CLL

Let the liner run through the tip holder →

$X - 3mm = CLL$ ← Note! Measure X

5

Expected cutting line ① Pull by hand

② Mark the calculated measurement «CLL» and cut liner

NOTE! 3 mm Push tension

5

Expected cutting line ① Pull by hand

② Mark the calculated measurement «CLL» and cut liner

NOTE! 3 mm Push tension

6

(A) Dismount liner

3 mm Push tension

(B) Grind

NOTE!

(C) Remount liner

1 2
Ensure good contact

6

(A) Dismount liner

3 mm Push tension

(B) Grind

NOTE!

(C) Remount liner

Ensure good contact

Note!

→ Ensure open outlet

45°

Wire

Note!

Wire