






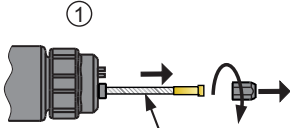
Mounting instructions for replacement of Carbon/PET liner with neck MIGATRONIC air-cooled torch (ML KD) and water-cooled torch (MV KD / MV FIXED)

1 Fully extend the hose

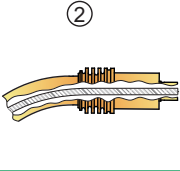


Carbon  300mm
PET  150mm

2 Remove old liner

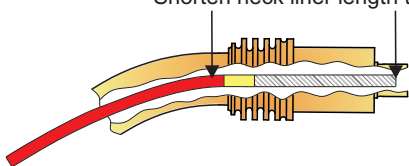




Remove old liner



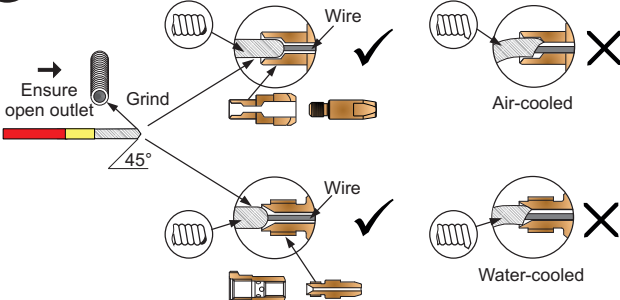
Tip - water-cooled
Holder and tip - air-cooled

3 Adjust bronze liner



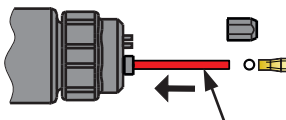
Carbon  300mm
*PET  150mm
* Alu: Higher performance and lower friction:
Shorten neck liner length to approx. 50mm

3 Note! for better performance



Ensure open outlet
Grind 45°
Wire
Air-cooled
Water-cooled

4 Mount liner

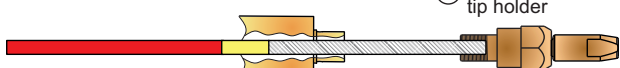


Mount new liner

4 Note!
More easy to install if the torch is fully extended

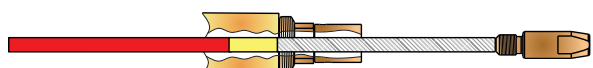


5 Air-cooled

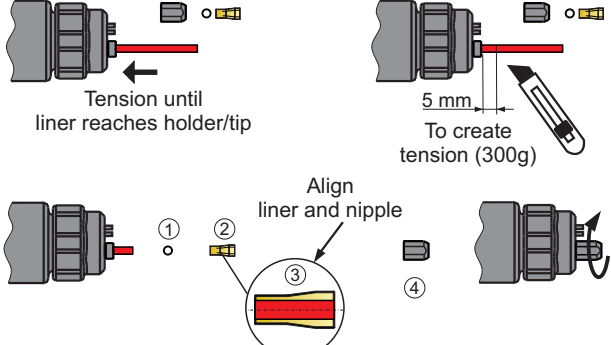


① ← Push softly new liner backwards
② Mount tip and tip holder

5 Water-cooled

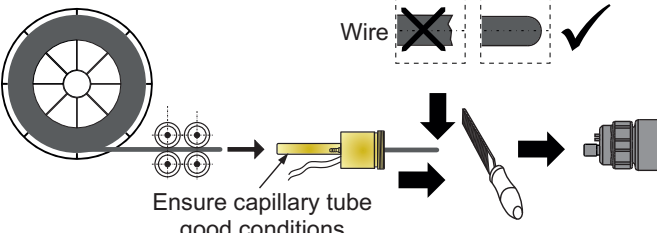




① ← Push softly new liner backwards
② Mount contact tip



Tension until liner reaches holder/tip
5 mm
To create tension (300g)
Align liner and nipple
① ② ③ ④

Note!



Wire  
Ensure capillary tube good conditions