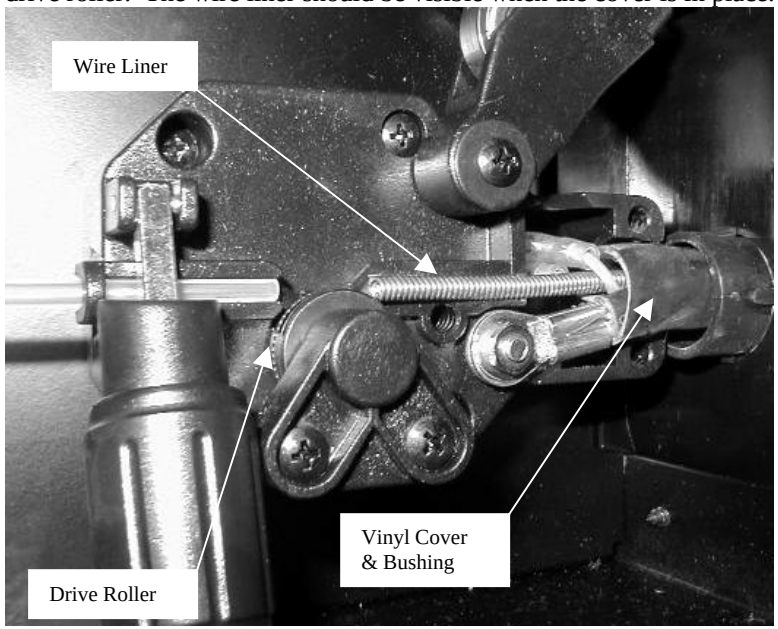
23. Align the wire liner in the drive deck so that it is almost touching the drive roller. The wire liner should be visible when the cover is in place.



24. Slide bushing and rubber jacket back enough to be gripped by the cover, when it is reinstalled.

25. Replace the cover and reinstall the three screws.

Instructions For Replacing Wire Liner

Components included in kit:

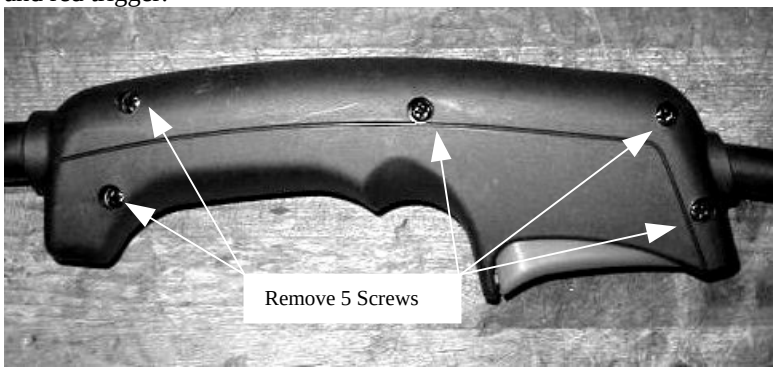
1. Wire liner
2. O-rings (x2)
3. Instructions

Tools required:

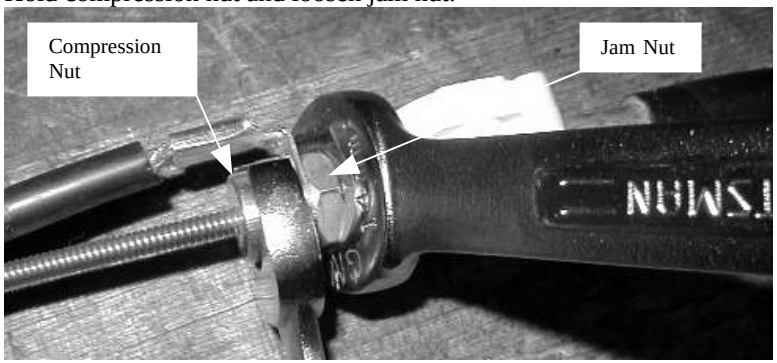
1. #2 Phillips screwdriver
2. 14-mm open end wrench (x2)

Procedure

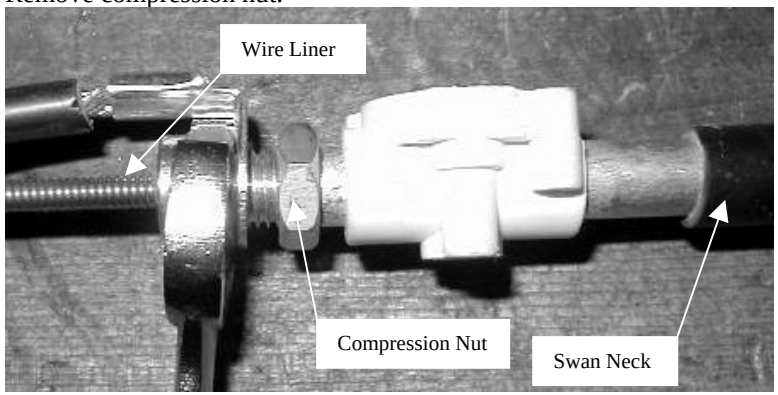
1. Remove five screws from torch handle and set aside two handle halves and red trigger.



2. Hold compression nut and loosen jam nut.

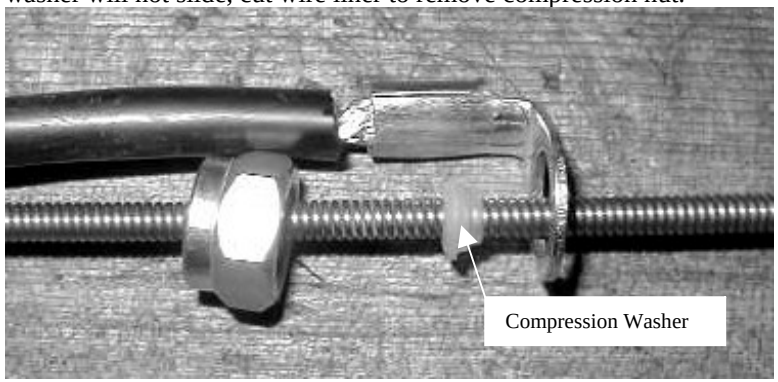


3. Remove compression nut.



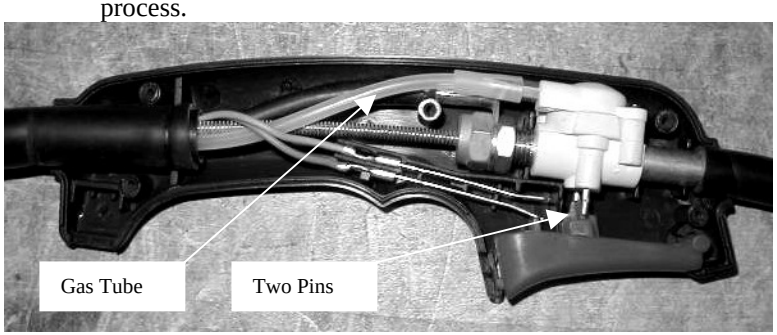
4. Pull wire liner out of swan neck.

5. If compression washer will slide off of the old wire liner, remove it and the compression nut and set compression nut aside. If the compression washer will not slide, cut wire liner to remove compression nut.

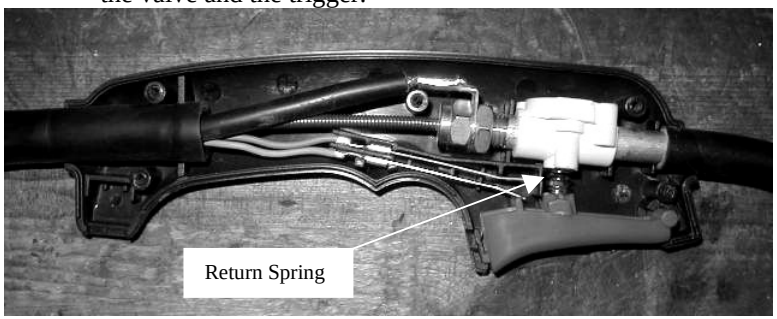


6. Lay torch cable assembly out on floor as straight as possible.

21. The flux torch and MIG torches are similar, but there are some differences.
    a. The MIG torch has two pins in the bottom of the valve and a gas tube. Make sure the pins did not fall out during this process.

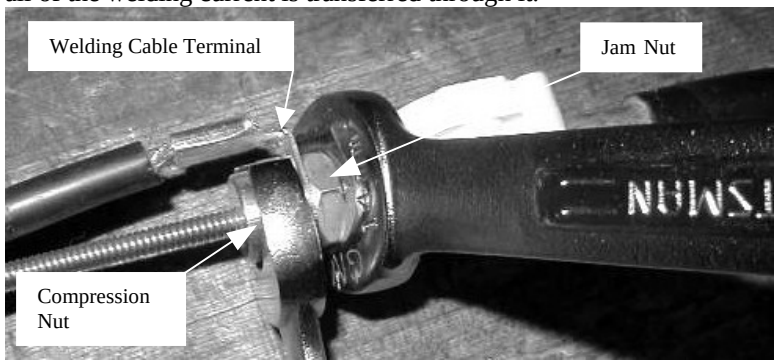


    b. The flux torch has a return spring that must be inserted between the valve and the trigger.

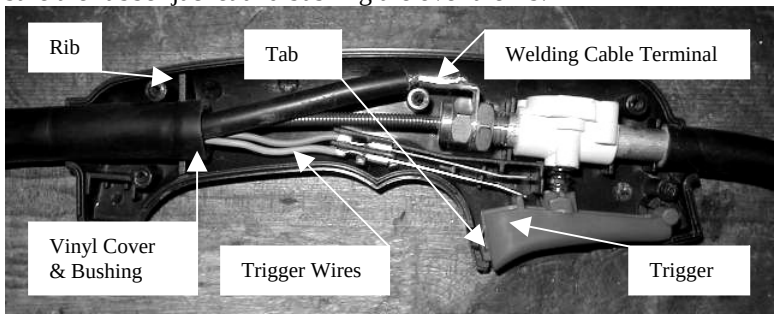


22. Replace the other torch half and reinstall the five screws.

17. While holding the compression nut with one wrench, tighten jam nut against compression nut very tightly with the second wrench. The welding cable terminal should be at the top in order for the assembly to fit back into the handle halves. This connection must be tight, because all of the welding current is transferred through it.



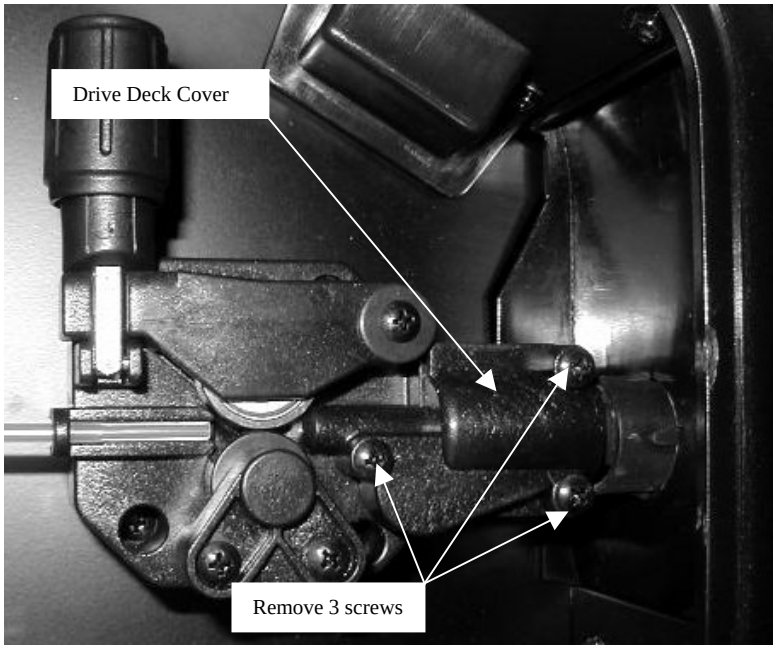
18. Place the swan neck back into the left half of the torch handle. Make sure the rubber jacket and bushing are over the rib.



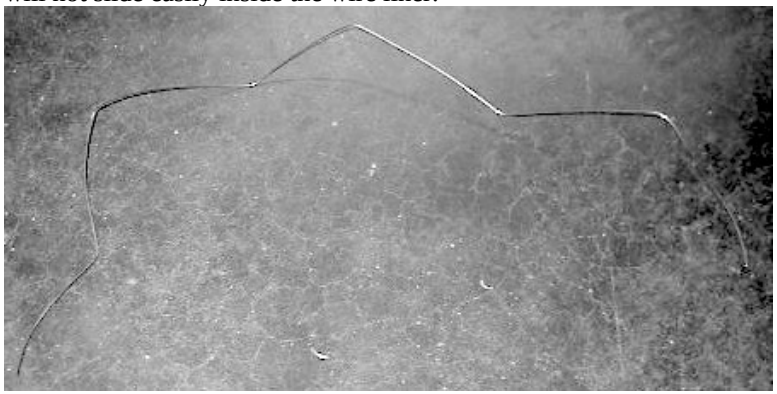
19. Insert the two trigger wires into the handle. Make sure they are aligned properly and behind the correct ribs.

20. Place the red trigger into the handle. Make sure the tab at the back of the trigger is inside the handle.

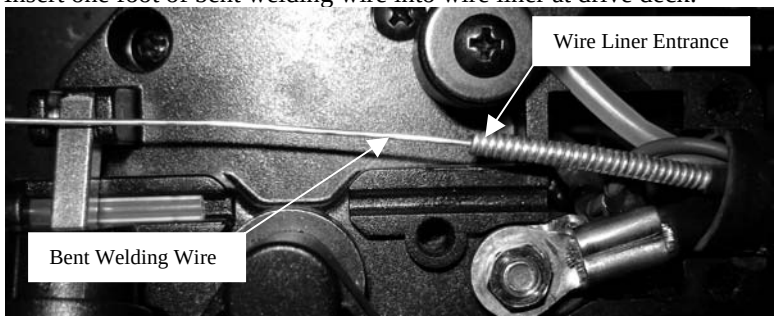
7. Remove three screws and drive deck cover.



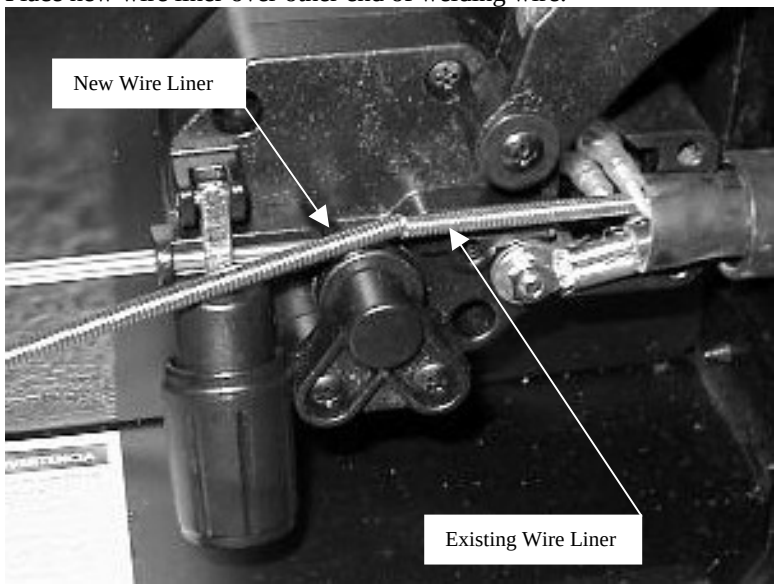
8. Take a two-foot section of welding wire and bend back and forth so it will not slide easily inside the wire liner.



9. Insert one foot of bent welding wire into wire liner at drive deck.



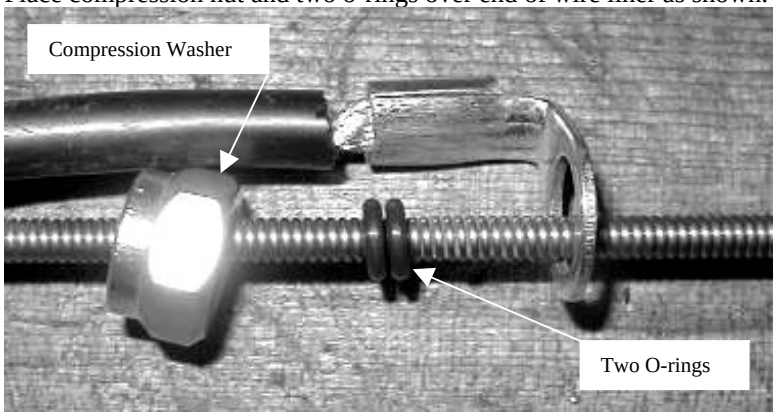
10. Place new wire liner over other end of welding wire.



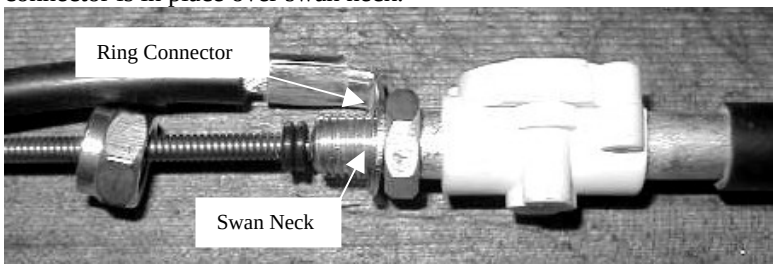
11. Push new wire liner through vinyl cover following original path of old wire liner.

12. When new wire liner appears at handle end of vinyl cover, dispose of old wire liner and bent welding wire.

13. Place compression nut and two o-rings over end of wire liner as shown.



14. Insert wire liner into swan neck, making sure welding cable ring connector is in place over swan neck.



15. Push wire liner into swan neck until it contacts the back of the contact tip (approximately 7.5 inches).
16. Tighten compression nut until wire liner is locked in place.