



LINER INSTALLATION INSTRUCTIONS WH WELDING GUN WITHOUT CUTTING MECHANISM WH35, WH45, WH455, WH500, WH505

1. Remove the neckliner, nozzle, tip and tip holder if installed from the WH swanneck.
NOTE: On WH455D remove the tip holder.
2. Lay the WH cable assembly out straight.
3. Install the WH swanneck (see step 1) onto the WH cable assembly.
4. Remove the liner-retaining nut from the adapter block at the back of the WH cable assembly.
5. Gently feed the correct liner for your current welding process through the cable assembly from the machine end of the torch. (A plastic insulated liner needs to be installed in the welding gun where WH500, WH505, WH35, and WH45 swannecks are used). Push the liner through the gun until it exits from the swanneck.
NOTE: There is normally some resistance felt when pushing the liner into the welding gun especially at the frontend and swanneck areas. Gently twisting the liner will aid in installation. Use care not to kink the liner.
6. With the liner now fully inserted, install and lightly tighten the liner-retaining nut.
7. At the front end of the end of the torch, there will now be liner protruding from the swanneck. Mark the liner where it protrudes from the swanneck then loop the cable assembly so the liner moves forward. Mark and cut off the liner 3mm or 2 rings back from the previous mark with a pair of sharp cutters. Ensure there are no burrs or obstructions to the inner diameter of the liner.
8. Remove the loop from the cable assembly and install the required tip holder, tip gas diffuser and nozzle.

