

HOW TO FIT A STEEL LINER



THE FITTING OF WIRE FEED LINERS REQUIRES CARE AND ATTENTION. THE CORRECT CHOICE OF LINER IS ESSENTIAL, TO ESURE PROBLEM FREE WIRE FEEDING THROUGH THE TORCH CABLE ASSEMBLY. THE CORRECT QUALITY AND COMBINATION FOR WIRE SIZE, WIRE AND TORCH TYPE (GAS OR WATER-COOLED) MUST BE SELECTED AND PROPERLY INSTALLED.

There are four types of wire feed liners:

1. **PLASTIC COATED STEEL LINER:** used for steel or hard wire in gas cooled torches fitted with coaxial cable assemblies.
2. **PLAIN STEEL LINER:** used for steel and other hard wires in water-cooled torches including torches with the gas hose connected directly to the torch body.
3. **PTFE LINER:** used for aluminium, stainless steel, copper, bronze and other soft wires, it can be made from pure or carbon-filled PTFE.
4. **POLYAMIDE LINER:** used with MB14 AK torches, the cables of push-pull torches, and in some water-cooled torch applications.

The correct liner for your application is recommended in the relevant brochure/parts list with your Binzel Pty Ltd torch. A couple of 'rules of thumb' are, however, worth noting:

- 1/ If running mild steel wire through a water-cooled torch use a bare steel liner.
- 2/ If running the same wire through a n air-cooled torch use an insulated liner.

Remember, to get maximum performance from your Binzel Pty Ltd torch, change the liner regularly.

STEP BY STEP FITTING:

After unpacking your Binzel Pty Ltd torch and liner there are nine basic steps to follow:

1. Lay the torch and liner out straight.
2. Check that the liner has no kinks in it.
3. Remove the liner-positioning nut at the end of the torch.
4. Remove nozzle, tip and holder if applicable.
5. Gently feed the liner down through the bicox, from the machine end of the torch, taking special care not to kink it in the process.
6. Once the liner reaches the back of the swan neck it may be necessary to gently twist it through.
7. With the liner now fully home, replace the liner-positioning nut. (Do not over tension).
8. At the front end of the torch there will now be approximately 300mm (12 inches) of liner protruding from the end of the swan neck. Gently stretch the liner a further 4mm (3/16 inch) and cut at the tip of the neck with a pair of wire cutters.
9. The liner will now spring back into the swan neck by 4mm. Refit tip holder, tip and nozzle etc.

You are now ready to carry out your work.