

*Eastwood*

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Part #20284

# TIG 200 GAS LENS KIT

## INSTRUCTIONS

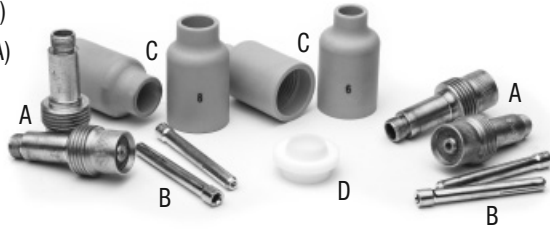


The **Eastwood Gas Lens Kit** contains all the common consumable parts in both 1/16" [1.6mm] and 3/32" [2.4mm] sizes. These parts will also fit other brand size WP-17 torches.

Gas lens improves shielding gas coverage by distributing shielding gas around the tungsten more efficiently with less turbulence than a conventional design. A gas lens also allows the tungsten to protrude further out of the torch for more maneuverability and better visibility of the area you're welding and the arc itself.

## INCLUDES

- (2) Gas Lens Body, 1/16" [1.6mm] (A)
- (2) Gas Lens Body, 3/32" [2.4mm] (A)
- (2) Collet, 1/16" [1.6mm] (B)
- (2) Collet, 3/32" [2.4mm] (B)
- (2) Gas Nozzle, 3/8" [#6] (C)
- (2) Gas Nozzle, 1/2" [#8] (C)
- (1) Gas Nozzle Reduction Collar (D)



## SAFETY INFORMATION



### READ INSTRUCTIONS!

- Read this entire manual before set up and use.
- Keep this manual in a safe location as it will be necessary to refer to it often.



### CAUTION!

- Welding fumes and gasses can be hazardous to your health, **Do Not** inhale welding fumes.
- Arc Rays can injure your eyes and burn your skin.
- Electric shock from welding can cause injury and possible death, **Do Not** touch live electrical components.
- Wear correct eye, ear, and body protection.
- Improper gas flow or improper post flow can cause the nozzle to fracture from the heat.



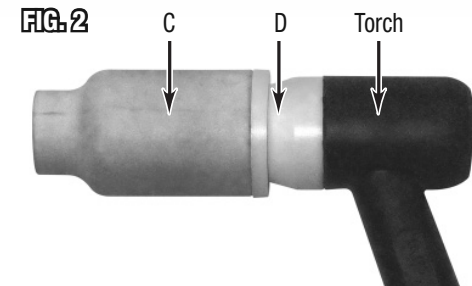
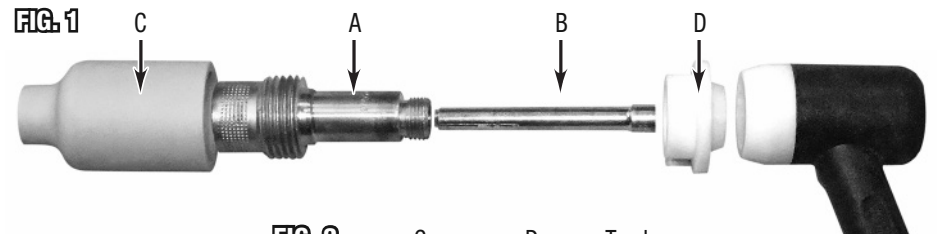
## TORCH DISASSEMBLY

1. Be sure the welder is turned off and unplugged before beginning.
2. Remove the Rear Cap from the Torch.
3. If a tungsten is in place, pull it out from the front of the Torch.
4. Slide the Collet out of the Torch.
5. Unscrew the Gas Nozzle.
6. Unscrew the Collet Body.

## TORCH ASSEMBLY

### REFERENCE FIG 1 & 2

1. Choose the size Gas Lens (**FIG. 1-A**) that fits your desired tungsten diameter.
2. Place the white plastic Nozzle Reduction Collar (**FIG. 1-D**) with the beveled side facing towards the Torch onto the Gas Lens Body (**FIG. 1-A**), then thread the Gas Lens into the Torch making sure that the new Gas Nozzle Reduction Collar seats itself correctly against the original Gas Nozzle Reduction Collar.
3. Choose the desired Gas Nozzle (**FIG. 1-C**) and install it on the front of the Gas Lens (**FIG. 1-A**) making sure that it seats correctly against the Gas Nozzle Reduction Collar (**FIG. 1-D**).  
**NOTE:** The Gas Nozzles are made of ceramic material and may shatter if dropped or broken.
4. Choose the correct size Collet (**FIG. 1-B**) that fits your tungsten diameter, slide the tungsten into the Collet and then place the assembled piece into the Torch from the rear.
5. Install the Rear Cap but leave the Cap slightly loose so you can adjust the tungsten rod stick out of the Gas Nozzle (**FIG. 1-C**).
6. When you have the desired tungsten stick out, tighten the Rear Cap so the tungsten rod is secured tightly. You have now completed the assembly.



# ADDITIONAL ITEMS

- #20262 1/16" Gas Lens Body
- #20263 3/32" Gas Lens Body
- #12822 1/16" Collet
- #12824 3/32" Collet
- #20264 #6 Gas Lens Nozzle (3/8")
- #20265 #8 Gas Lens Nozzle (1/2")
- #20266 Gas Nozzle Reduction Collar

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**If you have any questions about the use of this product, please contact**

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: [techhelp@eastwood.com](mailto:techhelp@eastwood.com)

PDF version of this manual is available online >> [eastwood.com/20284manual](http://eastwood.com/20284manual)

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA

US and Canada: 800.345.1178 Outside US: 610.718.8335

Fax: 610.323.6268 [eastwood.com](http://eastwood.com)