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Item #21322, 21323, 21324

MIG TORCH REPLACEMENT LINER

INSTRUCTIONS

The **EASTWOOD MIG TORCH REPLACEMENT LINER** is designed to fit most popular Eastwood MIG Torches as well as some aftermarket units with the popular Tweco style Torch.

CONTENTS

(1) Torch MIG Wire Liner

SAFETY INFORMATION

Welding can be dangerous to you and other persons in the work area. Read and understand this instruction manual before using your Eastwood welding machine. Injury or death can occur if safe welding practices are not followed. Safety information is set forth below and throughout this manual.

To learn more about welding safety, read OSHA Title 29 CFR 1910, available at **www.osha.gov**; ANSI Z49.1, "Safety in Welding, Cutting and Allied Processes," available at www.aws.org; and the consumable manufacturer's Safety Data Sheet.

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

⚠ READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.

⚠ DANGER ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

- Improper use of an electric Welder can cause electric shock, injury and death! Read all precautions described in the Welder Manual to reduce the possibility of electric shock.
- Disconnect Welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.
- Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.
- Always operate the Welder in a clean, dry, well ventilated area. Do not operate the Welder in humid, wet, rainy or poorly ventilated areas.
- The electrode and work (or ground) circuits are electrically “hot” when the Welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing.
- Separate yourself from the welding circuit by using insulating mats to prevent contact from the work surface.
- Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.
- Always attach the ground clamp to the piece to be welded and as close to the weld area as possible. This will give the least resistance and best weld.

⚠ DANGER WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

- Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.
  DO NOT operate electric arc Welder in areas where flammable or explosive vapors are present.
  DO NOT use near combustible surfaces. Remove all flammable items from the work area where welding sparks can reach (min. of 35 feet).
- Always keep a fire extinguisher nearby while welding.
- Use welding blankets to protect painted and or flammable surfaces; rubber weather-stripping, dash boards, engines, etc.
- Ensure power supply has properly rated wiring to handle power usage.

⚠ WARNING ELECTROMAGNETIC FIELDS CAN BE A HEALTH HAZARD!

- The electromagnetic field that is generated during arc welding may interfere with various electrical and electronic devices such as cardiac pacemakers. Anyone using such devices should consult with their physician prior to performing any electric welding operations.
- Exposure to electromagnetic fields while welding may have other health effects which are not known.

⚠ WARNING ARC RAYS CAN INJURE EYES AND BURN!

- Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).
- Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.

⚠ WARNING **FUMES & WELDING GASES CAN BE A HEALTH HAZARD!**

- Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation.
- Prolonged inhalation of welding fumes above safety exposure limits can injure the lungs and other organs.
- Use enough ventilation and/or exhaust at the arc to keep fumes and gases from your breathing area.
- Use an OSHA approved respirator when welding in confined spaces or where there is inadequate ventilation.
- Never weld coated materials including but not limited to: cadmium plated, galvanized, lead based paints.

⚠ CAUTION **HOT METAL & TOOLS WILL BURN!**

- Electric welding heats metal and tools to temperatures that will cause severe burns!
- Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, torch tip or nozzle until they have completely cooled.

⚠ CAUTION **FLYING METAL CHIPS CAN CAUSE INJURY!**

- Grinding and sanding will eject metal chips, dust, debris and sparks at high velocity. To prevent eye injury wear approved safety glasses.
- Wear an OSHA-approved respirator when grinding or sanding.
- Read all manuals included with specific grinders, sanders or other power tools used before and after the welding process. Be aware of all power tool safety warnings.

⚠ NOTICE **FIRST AID**

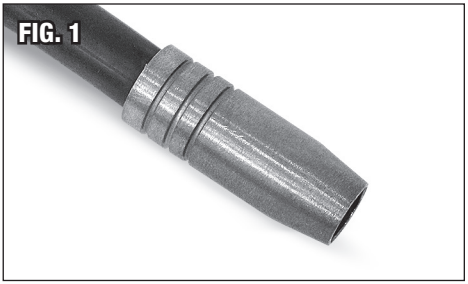
- If exposed to excessive fumes move to an area with fresh air. Follow safety information on manufacturer's Safety Data Sheet.
- For other injuries follow basic first aid techniques and call a physician or emergency medical personnel.

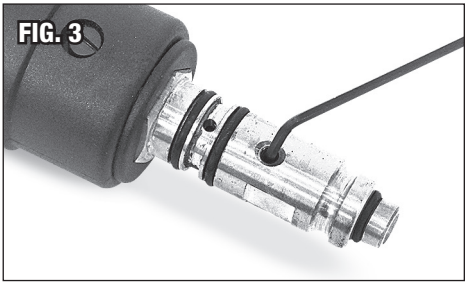
LINER REMOVAL

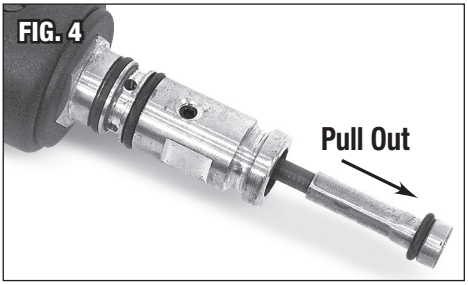
- Be sure the welder is turned off and unplugged before beginning.
- Disconnect the Torch assembly from the Welder.
- Remove the Nozzle from the Torch **(FIG 1)**.
- Remove the Contact Tip from the Torch **(FIG 2)**.
- On models where a set screw is used to retain the Liner in place, loosen it using a hex key (not included) before removing Liner **(FIG 3)**.
- Grip the Brass Ferrule and pull the entire Liner out through the brass fitting at the welder connection end of the Torch Cable **(FIG 4)**.

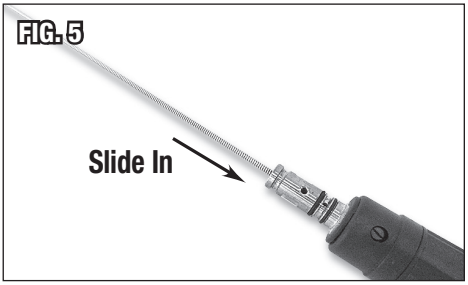
LINER INSTALLATION

- Be sure the welder is turned off and unplugged before beginning.
- Lay out the Torch Cable so that it is as straight as possible.
- Insert the end of the replacement Liner into the welder connection end of the Torch Cable **(FIG 5)**.
- If a set screw is used, tighten it firmly but do not overtighten which could crush the liner.
- On most models, the Liner length is an exact fit and the Torch Cable may be reconnected to the welder.

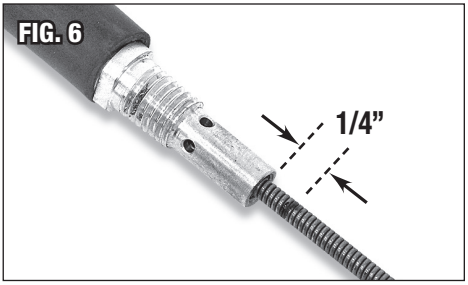


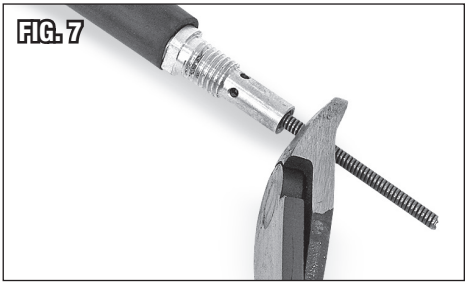






- On some models, the excess length must be trimmed. To do so:
  - Mark the end of the Liner at 1/4" beyond the end of the Torch **(FIG 6)**.
  - Using sharp diagonal cutters or welding pliers, cut the metal Liner squarely and evenly **(FIGS 7-8)**. A file may be used to remove any sharp barbs **(FIG 9)**.
- Re-install the Nozzle and Contact Tip on the Torch.
- Reconnect the Torch Cable to the welder.





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

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: techelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/21325manual
The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA
US and Canada: 800.343.9353 Outside US: 610.718.8335
Fax: 610.323.6268 eastwood.com

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