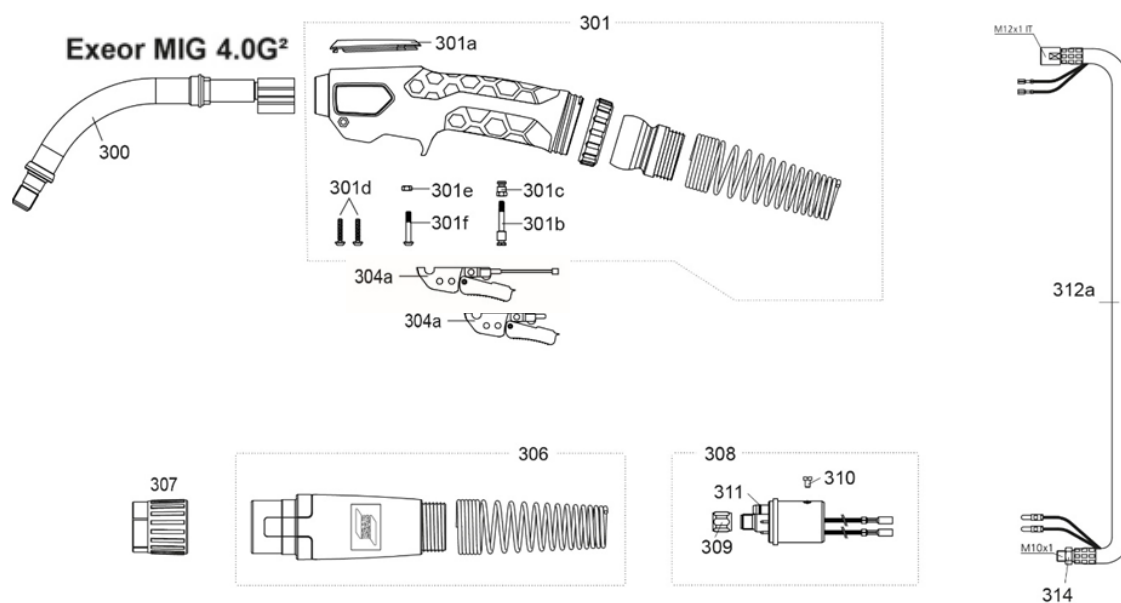




Exeor MIG Gaskyld



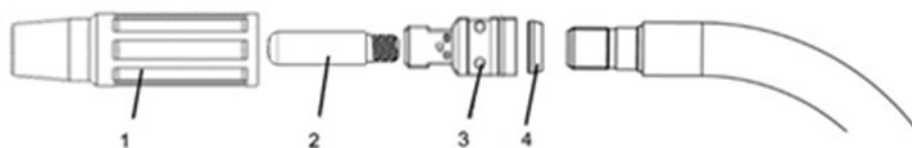
Exeor MIG 4.0G²



Item	Qty.	Ordering no.	Denomination	Notes
300	1	0700 026 091	Torch neck S Exeor MIG 4.0G ²	
301	1	0700 026 102	Handle w/o torch neck	
301a	1	B01P600222	Blind Cover	
301b	1	B01P600230	Handle Holder Screw	
301c	1	B01P600231	Handle Holder Nut	
301d	2		Screw	EJOT Delta PT WN 5451, 3.0×16
301e	1		Nut	M3.5 DIN EN 24032
301f	1	B01P102090	Screw	M3.5×20 T10
304a	1	B01P600285	Trigger Unit	2-poles without LED
306	1	0700 025 950	Cable support cpl.	
307	1	0700 025 951	Adaptor nut	
308	1	0700 200 101	Central connector G	
309	1	0700 200 098	Liner locking nut	
310	1		Screw	M4×6 ISO 7048 TYPE H, 8.8 A2K
311	1		O-ring	4.0×1.0 mm (ID×S) NBR 70 Shore A
312a	1	361P3LBB30	Power Cable 3 m, 70 ² mm	
312a	1	361P3LBB40	Power Cable 4 m, 70 ² mm	
312a	1	361P3LBB50	Power Cable 5 m, 70 ² mm	
314	1	101P002005	Hex nut	M10×1

WEAR PARTS Exeor MIG 4.0G²

1. Gas nozzle
2. Contact tip 16S-Series
3. Diffuser HD54-16
4. Insulation bushing



Ordering no.	Denomination	Notes	Ø	Length	
12401200	Gas nozzle, HD24L-50	Option	12,7 mm (1/2")	80 mm	
12401201	Gas nozzle HD24L-62	Standard	15,9 mm (5/8")	80 mm	
12401202	Gas nozzle, HD24L-75	Option	19,5 mm (.767")	80 mm	
15401136	Diffuser, HD54-16	Standard	-	49.6 mm	
0700025854	Insulation bushing	-	17,5 mm (.688")	6,0 mm (.236")	

Contact Tips; Standard 16S-Series

Exeor MIG 4.0G Stock No.		
Mix/Ar M8x1.25	Wire Size (mm / in)	Tip I.D. (mm / in)
11601102	0.90 mm (.035")	1.12 mm (.044")
11601103	1.00 mm (.040")	1.22 mm (.048")
11601104	1.20 mm (.045")	1.37 mm (.054")
11601105	1.30 mm (.052")	1.65 mm (.064")
11601106	1.60 mm (1/16")	1.85 mm (.073")
11601113	AL 1.20 mm (3/64")	1.50 mm (.059")
11601114	AL 1.60 mm (1/16")	2.08 mm (.082")

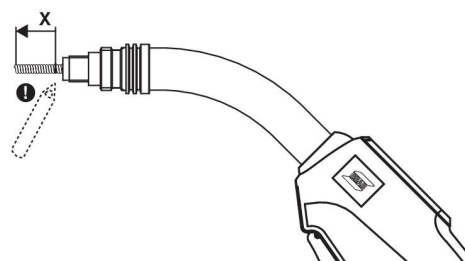
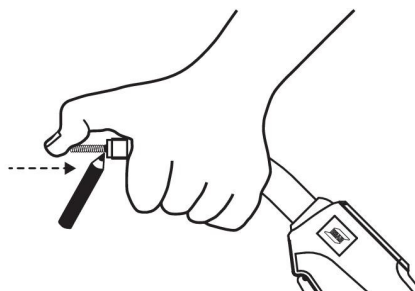
M8x1.25



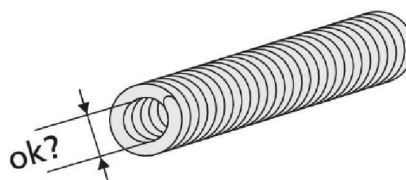
38.1 mm (1.50")

Installing a steel liner

1. Remove the sleeve nut from the central connector, remove the gas nozzle, contact tip and tip holder from the torch.
2. Insert the liner through the central connector and lock it with the sleeve nut.
3. Gently push back the front part of the liner into the torch as far as it will go, do not apply force. Mark the end of the torch neck on the liner.
4. Cut the liner to the correct length using a projectile "X" measured from the marking as shown in the figure.

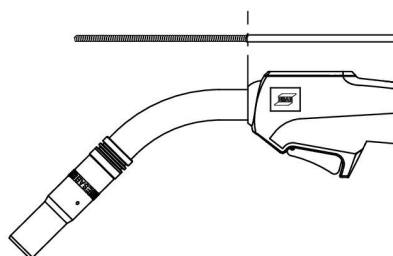


Remove the liner from the torch and carefully smoothen its front end. If needed, grind down burred edges. Make sure the inner hole is completely open.



For insulated liners, remove the insulation at the front end so that the remaining insulation ends approximately at the front end of the torch handle.

Reinstall the liner and lock it with the sleeve nut. Install all equipment parts on the torch neck.

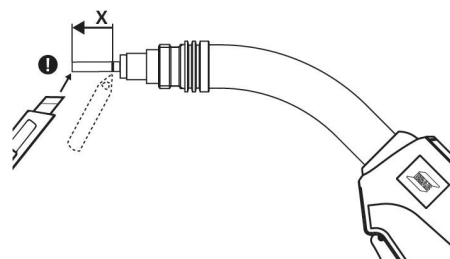
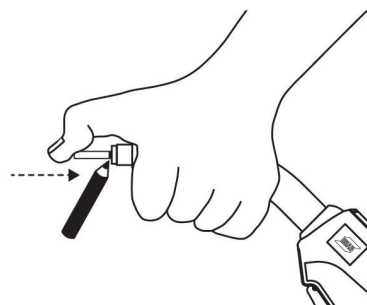


Cutting length

Welding torch	Projectile "X"
Exeor MIG 4.0G ²	13 mm

Installing a plastic liner

1. Remove the sleeve nut from the central connector, remove the gas nozzle, contact tip and tip holder from the torch.
2. Insert the liner through the central connector and lock it with the sleeve nut.
3. Gently push back the front part of the liner into the torch as far as it will go, do not apply force. Mark the end of the torch neck on the liner.
4. Cut the liner to the correct length using a projectile "X" measured from the marking as shown in the figure. Slightly chamfer the liner front end after the liner has been cut to the correct length.



NOTE!

If the liner has a bronze front end, first cut the plastic liner to a suitable length and let the bronze liner stick out approximately 40-50 mm from the torch neck. Attach the bronze liner to the front of the plastic liner and only then cut this liner assembly to the precise length.

If it is difficult to insert the liner into the torch, make a clean cut at the front end of the liner and chamfer the edges (e.g. with a pencil sharpener).

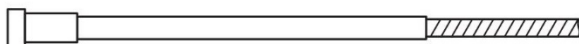


Install all equipment parts on the torch neck.

Cutting length

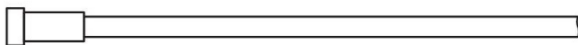
Welding torch	Projectile "X"
Exeor MIG 4.0G ²	13 mm

Steel liner



Ordering no.	Ø	Length	Notes	Exeor MIG 4.0G ²
0700 025 822	0.9 – 1.2	3 m	Red HD	X
0700 025 823	0.9 – 1.2	4 m	Red HD	X
0700 025 824	0.9 – 1.2	5 m	Red HD	X
0700 025 825	1.4 – 1.6	3 m	Grey HD	X
0700 025 826	1.4 – 1.6	4 m	Grey HD	X
0700 025 827	1.4 – 1.6	5 m	Grey HD	X

PTFE liner



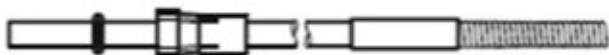
Ordering no.	Ø	Length	Notes	Exeor MIG 4.0G ²
0700 200 089	0.8 – 1.0	3 m	Blue	X
0700 200 090	0.8 – 1.0	4 m	Blue	X
0700 025 811	0.8 – 1.0	5 m	Blue	X
0700 200 091	1.0 – 1.2	3 m	Red	X
0700 200 092	1.0 – 1.2	4 m	Red	X
0700 025 812	1.0 – 1.2	5 m	Red	X
0700 025 813	1.2 – 1.6	3 m	Yellow	X
0700 025 814	1.2 – 1.6	4 m	Yellow	X
0700 025 815	1.2 – 1.6	5 m	Yellow	X

PA liner with bronze front end



Ordering no.	Ø	Length	Notes	Exeor MIG 4.0G ²
0700 025 816	0.8 – 1.0	3 m	Anthracite	X
0700 025 817	0.8 – 1.0	4 m	Anthracite	X
0700 025 818	0.8 – 1.0	5 m	Anthracite	X
0700 025 819	1.2 – 1.6	3 m	Anthracite	X
0700 025 820	1.2 – 1.6	4 m	Anthracite	X
0700 025 821	1.2 – 1.6	5 m	Anthracite	X

PTFE liner with bronze front end



Ordering no.	Ø	Length	Notes	Exeor MIG 4.0G ²
0700 026 073	0.8	3 m	blue	X
0700 026 074	0.8	4 m	blue	X
0700 026 075	0.8	5 m	blue	X
0700 026 076	1.0	3 m	red	X
0700 026 077	1.0	4 m	red	X
0700 026 078	1.0	5 m	red	X
0700 026 079	1.2 – 1.6	3 m	yellow	X
0700 026 080	1.2 – 1.6	4 m	yellow	X
0700 026 081	1.2 – 1.6	5 m	yellow	X