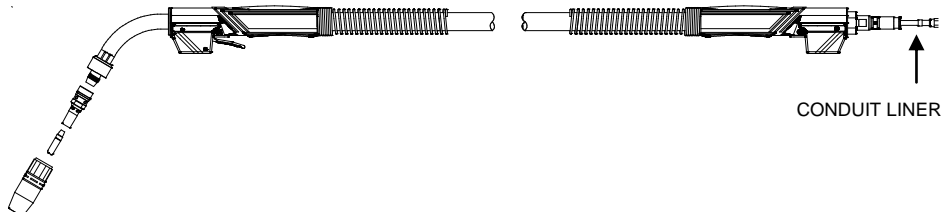


NOTE: For guns equipped with "Direct Plug-Ins", Bernard, or Euro-connector, the procedure is the same.
 On Miller style guns, liner is held captive by a guide cap which must be removed and replaced when changing liner.

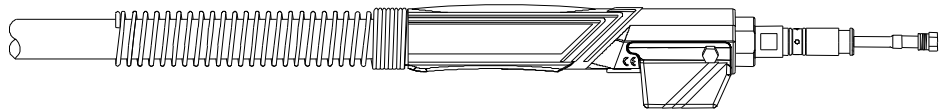
STEP #1



NOTE: Ensure power supply is off and gun is removed from feeder before proceeding.

- Remove nozzle, tip and gas diffuser.
- If power pin uses a liner set screw, loosen the set screw using a 5/64" Allen wrench.
- If power pin is thread-in liner type, using a 10 mm wrench, turn thread-in liner collet counter-clockwise until liner is free from the power pin.
- With gun straightened, grip conduit liner with pliers and remove.

STEP #2



- Feed replacement liner through gun using short strokes to avoid kinking. Twist liner clockwise if necessary.
- If power pin uses a liner set screw:
 - Seat liner retainer with o-ring to shoulder inside bore of power pin.
 - Secure by tightening liner set screw. Do not over tighten.
- If power pin is thread-in type:
 - Using a 10 mm wrench, turn thread-in liner collet in a clockwise direction and tighten in power pin.

STEP #3

- Push liner back into gun and hold in place.
- Using liner gauge, trim conduit liner with 3/4" (20 mm) stick out.
- **NOTE:** When using 154 or 454-1 retaining heads, trim conduit liner with 1/2" (13 mm) stickout.
- Remove any burr that may obstruct wire feed, especially on flat wire type conduit liner.
- Replace nozzle, tip and gas diffuser onto gooseneck.

