

How to Install or Replace TOUGH LOCK™ Consumables



IMPORTANT:

- Neck insulator **MUST** be in place before welding to properly insulate neck armor.
- Check all parts to ensure that connections are tight before welding.
- The heavy duty retaining head **MUST** be tightened with a 5/8" (16 mm) wrench to prevent the contact tip from overheating.
- **DO NOT** use pliers to remove or tighten the retaining head or scoring may result.

TOUGH LOCK Consumables



NOZZLE



CONTACT
TIP



RETAINING
HEAD



NECK
INSULATOR

Removal and Replacement

Nozzle

- Pull slip-on nozzles off with a twisting motion.
- When installing the nozzle, ensure that it is fully seated.

Contact Tip

- Thread the contact tip into the retaining head.
- Torque to 30 in.-lbs. (3.5 Nm).
- The Tregaskiss Tip Tool (Part # 450-18 – for heavy-duty tips) or a pair of weld pliers are the optimal tools for contact tip installation.

Retaining Head

- Thread retaining head onto gooseneck with a 5/8" (16 mm) wrench.
- Torque to 80 in.-lbs. (9 Nm).
- **DO NOT** use pliers to remove or tighten the heavy duty retaining head or scoring may result.

Neck Insulator

- The neck insulator is pressed onto the neck by hand with the aluminum side towards the neck and the black insulation towards the nozzle.