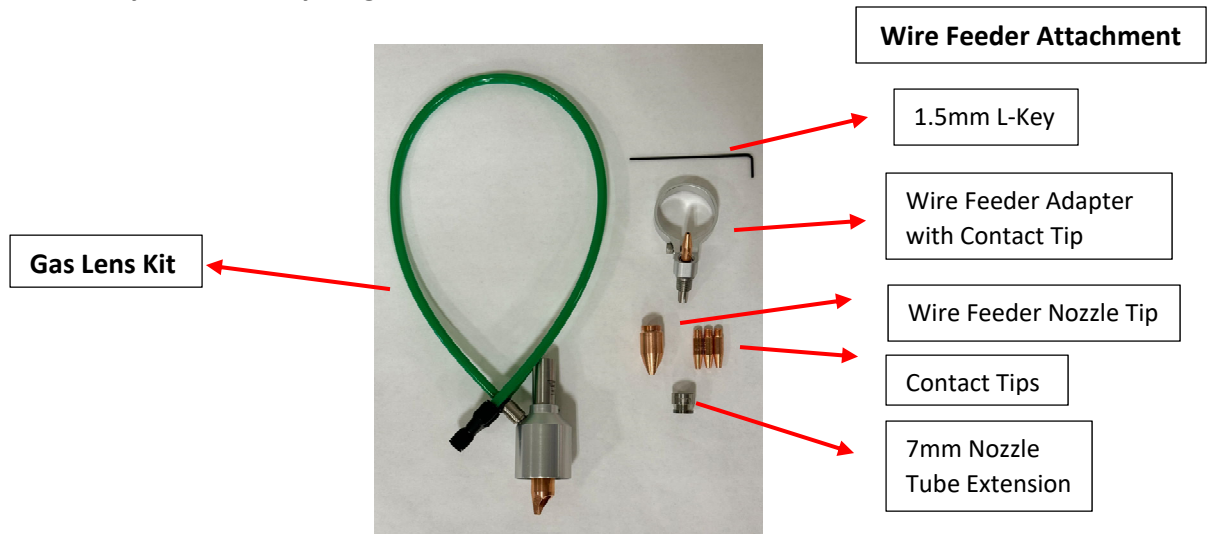


LightWELD GAS LENS DIFFUSER MANUAL

Part Number: CFMUGMPS0001ENUS

1. Make Sure you have everything:



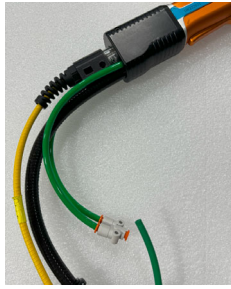
2. Installation

Before starting the installation be sure that the nozzle tip notch is aligned with the green hose fitting on the diffuser body.

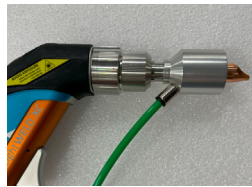
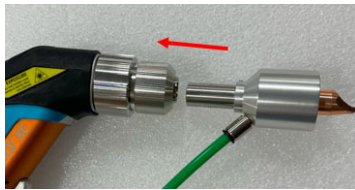
To align the notch on the nozzle tip to green hose fitting on the diffuser body to be in the same line and tighten the setscrew after that.



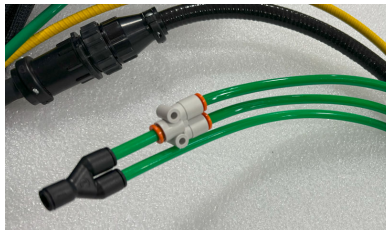
- a. Take the single side of the external gas hose out from Wye fitting.



- b. Insert nozzle tube to torch with loosening the retainer nut on the torch. After installation, be sure the nut is tightened back.



- c. Install shorter green hose on the gas diffuser to single side of Wye fitting.



- d. Insert the external gas hose to the single side of Wye fitting on the gas diffuser.

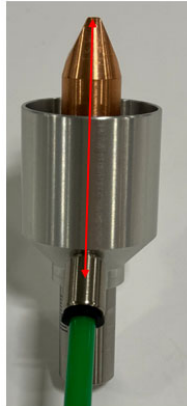


3. Wire Feeder Attachment Kit

3.1. Hard Wire Configuration

Replace the current nozzle tip with the wire feeder nozzle tip which can be found in the wire feeder attachment kit. Be sure that the nozzle tip notch is aligned with the green hose fitting on the diffuser body.

To align the notch on the nozzle tip to green hose fitting on the diffuser body to be in the same line and tighten the setscrew after that.



See Mode Chart for details.

3.2. Soft Wire Configuration

- a. Remove the tube assembly from the diffuser body to replace it with the wire feeder parts. Loosen the set screw on the body and take the whole assembly out.



- b. Unscrew the nozzle tip and 10mm tube extension.



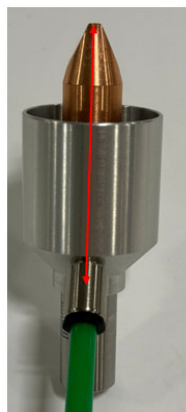
- c. First, screw the 7mm tube extension into the nozzle tube and then place the gas diffuser lens to the wire feeder nozzle tip as shown below. Lastly, screw the nozzle tip which has a gas diffuser lens to the nozzle extension.



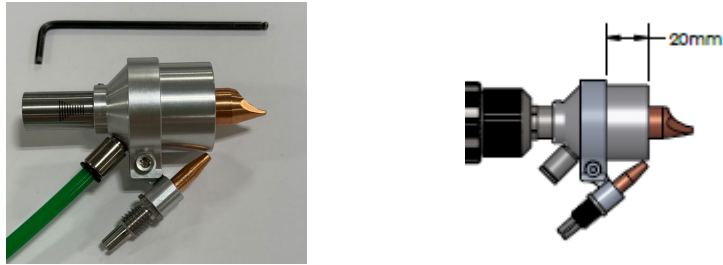
- d. Place the whole wire feeder assembly to the diffuser body.



- e. Align the notch on the nozzle tip to green hose fitting on the diffuser body to be in the same line and tighten the setscrew after that.



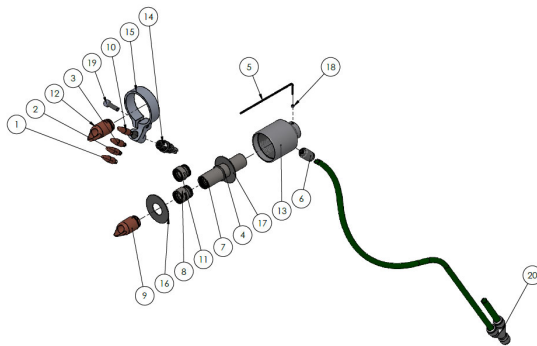
- f. Place the wire feeder adapter clamp to the diffuser body and adjust the location shown in the below. Tighten the screw with using 4mm L- Key.



See Wire Feeder Manual or Mode Chart for details.

4. Gas Lens Diffuser Assembly Part List

The following table shows the parts in the Gas Lens Diffuser Assembly.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	CMMIXX0002648PX	CONTACT TIP, WIRE FEEDER, 0.9MM, LIGHTWELD	1
2	CMMIXX0002649PX	CONTACT TIP, WIRE FEEDER, 1.2MM, LIGHTWELD	1
3	CMMIXX0002864PX	CONTACT TIP, WIRE FEEDER, 0.8MM, LIGHTWELD	1
4	CMMIXX0005010PX	O-RING, POLYU, 11/16 OD X 9/16 ID	1
5	CMMIXX0005037PX	L KEY, HEX, 1.5MM, 3.2" LONG	1
6	CMMIXX0005373PX	FITTING, STR, 1/4" PTC X M5 M	1
7	CMUS0008259XXXU	HH Nozzle Extension, 120mm	1
8	CMUS0008377XXXU	HW Nozzle Extension, 10mm	1
9	CMUS0008398002XU	Nozzle Tip, 1 point, Wire Feed	1
10	CMUS0010319XXXU	CONTACT TIP, WIRE FEEDER, 1.6MM, LIGHTWELD	1
11	CMUS0010359XXXU	HW Nozzle Extension, 7mm	1
12	CMUS0011276001XU	Nozzle Tip, 1 point, Wire Feed, Ver 2	1
13	CMUS0012106XXXU	ADAPTER, NOZZLE, GAS, SHIELDING	1
14	CMUS0015298XXXU	ADAPTER, LINER COLLET, WF, LW	1
15	CMUS0015299XXXU	CLAMP, WF ADPTR, GAS LENS, LW	1
16	CMUS0015300XXXU	DIFFUSER, GAS LENS ADAPTER, LW	1
17	CMUS0016223XXXU	DIFFUSER, INNER, GAS LENS, LW	1
18	P40-009360	SCREW, SET, CUP PT, SH, SS, M3 X 3	1
19	P40-009628	SCREW, SHCS 18-8SS, M4x14	1
20	P40-018983	FITTING, PTC, WYE, 1/4"	1