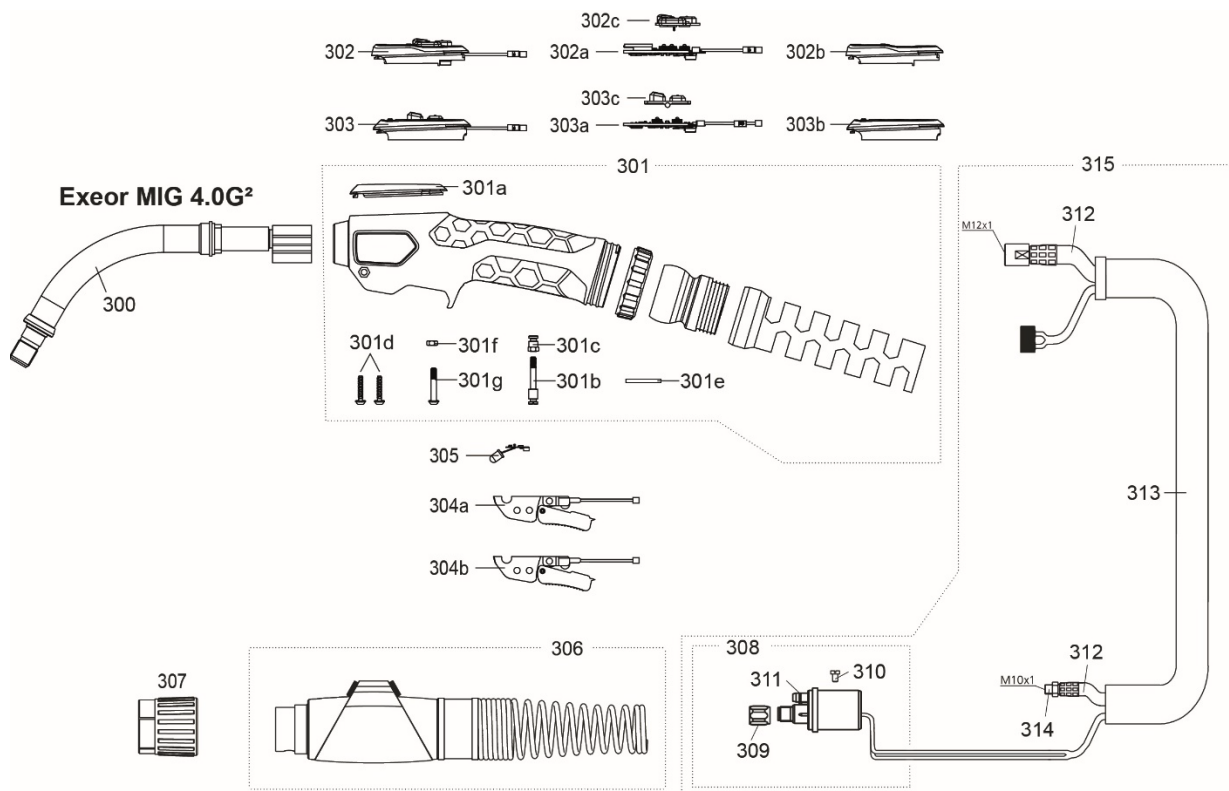




Exeor MIG CX Gaskyld



Exeor MIG 4.0G² CX, DX

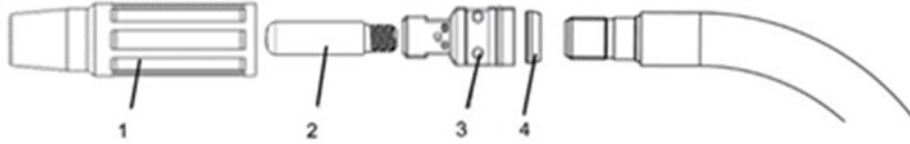



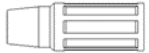

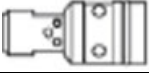

Item	Qty.	Ordering no.	Denomination	Notes
300	1	0700 026 091	Torch neck S Exeor MIG 4.0G ²	
301	1	0700 026 101	Handle w/o torch neck; remote	
301a	1	B01P600222	Blind Cover	
301b	1	B01P600230	Handle Holder Screw	
301c	1	B01P600231	Handle Holder Nut	
301d	2		Screw	EJOT Delta PT WN 5451, 3.0×16
301e	1	B01P600229	Snap-in Plate	
301f	1		Nut	M3.5 DIN EN 24032
301g	1	B01P102090	Screw	M3.5×20 T10
302	1	0700 026 142	Spare parts kit DX, gas	includes 302a, 302b, 302c, 305
302a	1		DX PCBA	with Harness
302b	1	B01P600123	Housing Kit	Exeor MIG DX
302c	1	B01P600275	Push button R/L	Exeor MIG DX
302c	1	B01P600276	Push button P/M	Exeor MIG DX
303	1	0700 026 143	Spare parts kit CX, gas	includes 303a, 303b, 303c, 305
303a	1		CX PCBA	with Harness
303b	1	B01P600114	Housing Kit	Exeor MIG CX
303c	1	B01P600116	Push button cover	Exeor MIG CX
304a	1	0700 025 793	Trigger Unit with harness; for remote System	with LED

Item	Qty.	Ordering no.	Denomination	Notes
304b	1	0700 025 794	Trigger Unit with harness; non-remote System	without LED
305	1	0700 025 082	PCBA LED f. Handle cpl.	
306	1	0700 025 971	Cable support cpl.	
307	1	0700 025 951	Adaptor nut	
308	1	0700 026 109	Control cable kit 3 m, gas with Euro connector for Exeor torches	
308	1	0700 026 110	Control cable kit 4 m, gas with Euro connector for Exeor torches	
308	1	0700 026 111	Control cable kit 5 m, gas with Euro connector for Exeor torches	
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
312	1	0700 026 034	Power cable 3 m	
312	1	0700 026 035	Power cable 4 m	
312	1	0700 026 036	Power cable 5 m	
313	1	0700 026 092	Assembly outer hose 3 m	
313	1	0700 026 093	Assembly outer hose 4 m	
313	1	0700 026 094	Assembly outer hose 5 m	
314	1	101P002005	Hex nut	M10×1
315	1	0700 026 095	Cable assembly 3 m	Includes 308
315	1	0700 026 096	Cable assembly 4 m	Includes 308
315	1	0700 026 097	Cable assembly 5 m	Includes 308


WEAR PARTS Exeor MIG 4.0G²

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

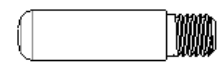


Ordering no.	Denomination	Notes	Ø	Length	
12401200	Gas nozzle, HD24L-50	Option	12,7 mm (1/2")	80 mm	
12401201	Gas nozzle HD24L-62	Standard	15,9 mm (5/8")	80 mm	
12401202	Gas nozzle, HD24L-75	Option	19,5 mm (.767")	80 mm	
15401136	Diffuser, HD54-16	Standard	-	49.6 mm	
0700025854	Insulation bushing	-	17,5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

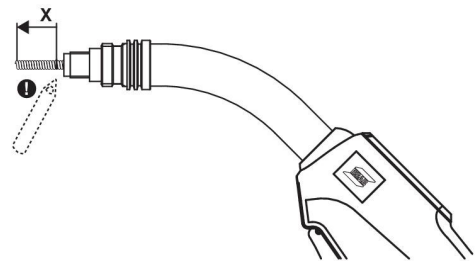
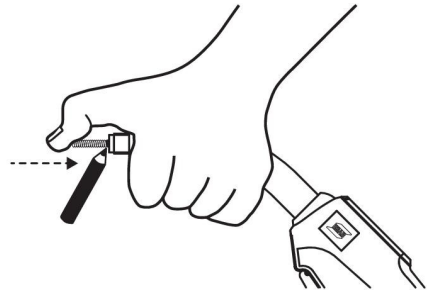
M8x1.25



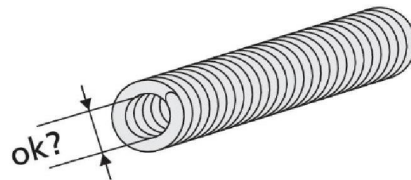
38.1 mm (1.50")

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.

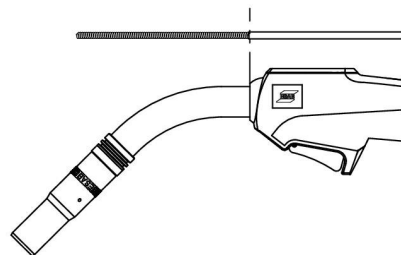


Remove the liner from the torch and carefully smoothen its front end. If needed, grind down burred edges. Make sure the inner hole is completely open.



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.

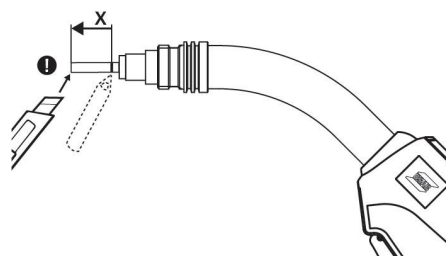
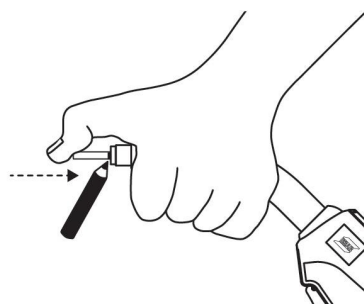


Cutting length

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).

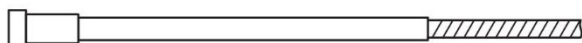


Install all equipment parts on the torch neck.

Cutting length

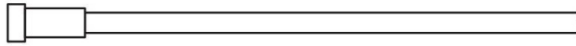
Welding torch	Projectile "X"
Exeor MIG 4.0G ²	13 mm

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