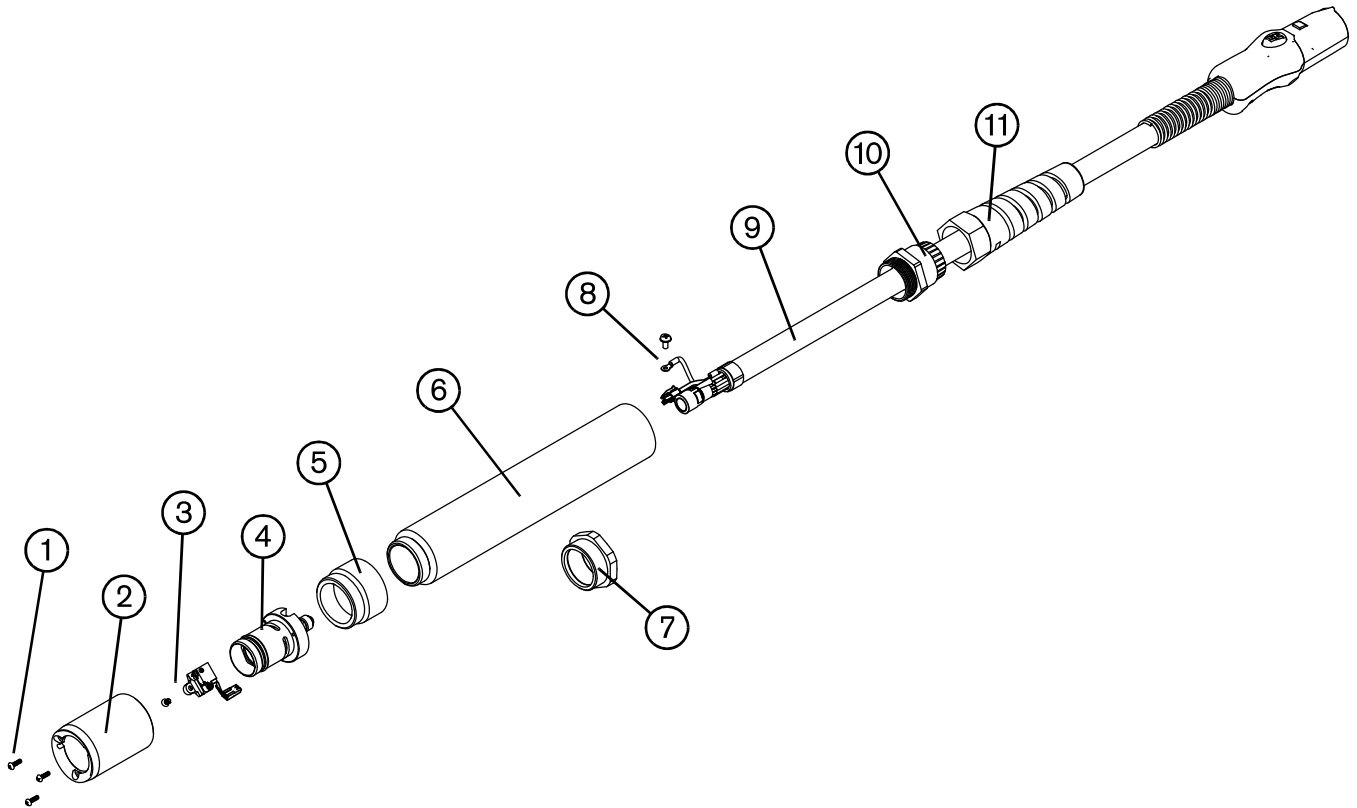


Disassemble the machine torch

You may need to disassemble the machine torch in order to mount it on a cutting table (see *Mount the torch* on page 72). Another reason to disassemble the machine torch is to convert it from the full-length machine torch to a mini machine torch (see *Convert a full-length machine torch to a mini machine torch* on page 71).



- | | |
|---|-------------------------------------|
| 1 Mounting sleeve screws | 7 Adapter (mini machine torch only) |
| 2 Mounting sleeve | 8 Pilot arc wire and screw |
| 3 Cap-sensor switch and screw | 9 Torch lead |
| 4 Torch body | 10 Strain relief |
| 5 Coupler | 11 Strain relief nut |
| 6 Positioning sleeve (full-length machine torch only) | |

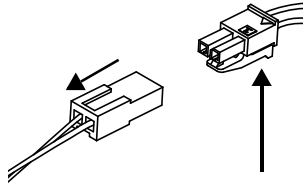


While disconnecting and reconnecting the torch parts, maintain the same orientation between the torch head and torch lead. Twisting the torch head in relation to the torch lead can cause damage to the torch wires.

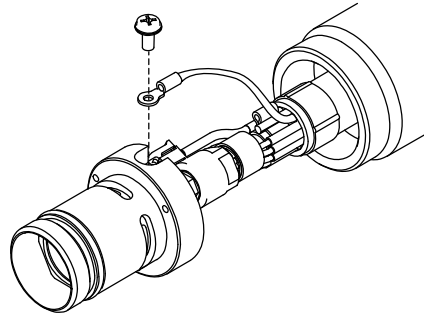
1. Disconnect the torch lead from the power supply, and remove the consumables from the torch.
2. Unscrew the strain relief nut from the strain relief, and slide the nut back along the torch lead.
3. If you are disassembling the full-length machine torch, unscrew the strain relief from the positioning sleeve. If you are disassembling the mini machine torch, unscrew the strain relief from the adapter. Slide the strain relief back along the torch lead.

6 – Machine Torch Setup

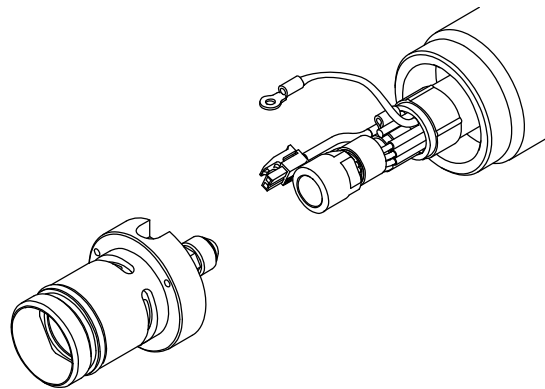
4. If you are disassembling the full-length machine torch, unscrew the positioning sleeve from the coupler. If you are disassembling the mini machine torch, unscrew the adapter from the coupler.
5. Unscrew the coupler from the mounting sleeve.
6. Remove the three screws from the consumables end of the mounting sleeve, and slide the mounting sleeve off the front of the torch body.
7. Disconnect the wire connector for the cap-sensor switch.



8. Remove the screw that secures the torch's pilot wire to the torch body.



9. Use 5/16-inch and 1/2-inch wrenches, or adjustable wrenches, to loosen the nut that secures the gas supply line to the torch lead. Set the torch body aside.



10. Slide the coupler off the front of the torch lead.
11. If you are disassembling a full-length machine torch, slide the positioning sleeve off the front of the torch lead. If you are disassembling a mini machine torch, slide the adapter off the front of the torch lead.