Instruction Manual 373
NCCE-A Curved Robotic Torches
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D/F MACHINE SPECIALTIES, INC.

MIG & TIG Welding Products, Consumables & Accessories

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WATER-COOLED CURVED MIG GUN
MODEL NCCE-A

INSTRUCTIONS, PARTS & SPECIFICATIONS MANUAL

D/F MACHINE SPECIALTIES is a world leader in the design, development, and manufacture of “MIG” (GMAW) & “TIG” (GTAW) welding products, consumables and accessories. D/F offers several types of manual Air or Water-Cooled “MIG” welding tools, and with the increased use of automated and robotic welding systems, a demand has been created for welding tools of the highest quality, durability and interchangeability. For over forty years, D/F welding products have been used extensively on “MIG” and “TIG” welding applications. This experience, coupled with patented design features, unavailable on any other competitive equipment, has made D/F welding tools the most advanced “MIG” and “TIG” welding guns and barrels for semi-automatic, automatic or robotic welding applications.

This Catalog is a guide to helping you select the proper tool for a given semi-automatic, automatic or robotic welding application. The following is only a partial listing of available semi-automatic, automatic and robotic guns. For further information on special “MIG” and “TIG” requirements, please consult the factory.

Customer satisfaction and customer benefits are the center points of all strategic contents

The spirit of the D/F Machine Specialties personnel is to listen to and to integrate the customer throughout the process, to develop and design marketable products, to present prototypes, to carry out pilot tests and to prepare for and be open to new technology and tasks. We attract and carefully select talented individuals who share our values. Together we will nurture and sustain a work environment with two-way communication, training, mentoring, and rewarding career opportunities.

Commitment to excellence

At D/F Machine Specialties we commit to design, build and deliver premium products and superior customer support to quality driven welding professionals. Customers still to this day choose D/F over competitors because of our responsiveness and flexibility. Customers will continue to choose D/F tomorrow for our superior hand-made products and service. To ensure this, we need creative and competent personnel in all business divisions, an intensive exchange of thoughts and ideas with all users, participation in working and study groups within the field of welding technology and intensive cooperation with institutes and universities.

Innovation and quality

Innovation and quality come from being receptive and willing to learn from others. We encourage our people to be creative and take risks in the pursuit of excellence. Innovative practices are deeply rooted in every one of our employees, a philosophy that leads to continuous product development and industry firsts.

Teamwork

Striving for excellence is a commitment that is an integral component of the D/F Culture. Our team of skilled and dedicated employees takes pride in the excellence products they produce. Each of us willingly accepts personal responsibility for meeting our commitments and we hold each other to a high standard of accountability.

Progress

By remaining confident, focused, and persistent in challenging times, we will discover opportunity. Commitment to quality and the pursuit on innovation ensure that D/F Machine Specialties will remain an industry leader for years to come.

Responsibility

We will continually strive to be environmentally responsible and to support the health and safety of our employees, customers, and neighbors. We continue to support the communities in which we operate and the industries in which we participate.

Thank You for Choosing D/F Machine Specialties

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SAFETY MEASURES - **PLEASE READ!**

Welding is not particularly hazardous when certain safety practices are followed. Anyone using this equipment should be thoroughly trained in safe welding practices. Failure to observe safe practices may cause serious injury. Handling welding torches presents no danger if the appropriate safety regulations are strictly adhered to. For example:

• Starting-up procedures must be reserved for those fully conversant with processes relating to arc welding equipment.
• Arc welding can prove damaging to eyes, skin, and hearing! It is therefore imperative that the Accident Prevention Regulations UVV 26.0 and VGB 15 are fully observed and that all protective clothing, eye and ear protectors specified are worn.
• The load data given are maximum limit figures. Overloading will inevitably damage the torch!
• Before changing wear parts, disconnect for the power supply.
• The operating instructions for the individual welding components - e.g. power source, wire feed and cooling unit must be followed.
• Never pull the cable assembly across sharp edges or set down close to weld spatter or on a hot workpiece.
• Those not involved in the welding process should be protected by curtains or partitions from radiation and the danger of being dazzled.
• When handling gas cylinders, consult the instructions issued by the manufacturers and the suppliers of the pressurized gas.
• Workpieces which have been degreased using chlorinated solvents must be sprayed down with clean water before welding starts to avoid the risk of phosgene forming. For the same reason, no degreasing baths containing chlorine must be placed close to the welding point.
• All vapors given off by metals can cause harm and a special warning is attached to lead, cadmium, copper, zinc, and beryllium. If necessary, take appropriate precautions (by providing adequate ventilation or an extraction system) to ensure that the legal maximum levels of toxic concentrations are not exceeded.

For more information, refer to the following standards in their latest revisions and comply as applicable.

• ANSI Standard Z49.1, SAFETY IN WELDING AND CUTTING obtainable from the American Welding Society, 2501 N.W. 7th St., Miami, FL 33125.
• ANSI Standard Z41.1, STANDARD FOR MEN'S SAFETY - TOE FOOTWEAR obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018.
• ANSI Standard Z49.2, FIRE PREVENTION IN THE USE OF CUTTING AND WELDING PROCESSES obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018.
• OSHA, SAFETY AND HEALTH STANDARDS, 29CRF 1910, obtainable from the U.S. Government Printing Office, Washington, D.C. 20402.
• AWS Standard A6.0, WELDING AND CUTTING CONTAINERS WHICH HAVE HELD COMBUSTABLES obtainable from the American Welding Society, 2501 N.W. 7th St., Miami, FL 33125.
• NFPA Standard 70-1978, NATIONAL ELECTRICAL CODE obtainable from the National Fire Protection Association, 470 Atlantic Avenue, Boston, MA 02210.
• ANSI Standard Z88.2, "Practice for Respiratory Protection" obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018.
• ANSI Standard Z87.1, SAFE PRACTICES FOR OCCUPATION AND EDUCATIONAL EYE AND FACE PROTECTION obtainable from the American National Standards Institute, 1430 Broadway, New York, NY, 10018.
• NIOSH, SAFETY AND HEALTH IN ARC WELDING AND GAS WELDING AND CUTTING obtainable from the Superintendent of Documents, U.S. Printing Office, Washington, D.C. 20402.
• American Welding Society Standard AWSF4.1 "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", obtainable from the American Welding Society, 2501 N.W. 7th St., Miami, FL 33125.

IMPORTANT

The D/F torch is famous for the fact that if it is chilled properly, the welder can grab the front of the torch with their bare hand and it will be cold to the touch seconds after welding. With the proper chiller, this can be done even after a 4 hour arc time.

Make certain the cooling water supply is **Deionized water (DI Water) and** at least the minimum flow rate of 3 quarts per minute (for each inner body), at 40 psi (80 psi maximum) with a 5 gallon reservoir and 15,000 BTU/hr cooling capacity. Gun ratings are affected by shielding gas used, arc time, cooling time and inlet water temperature. Water outlet temperature should not exceed 27°C (80°F). The torch's water out & power cable is not cooled until the coolant has gone through the torch and out the water out & power cable. If water is not flowing through the D/F torch for at least 1 minute prior to striking an arc, when you apply the power and water hits the "hot" water/out & power cable, you will generate steam. Steam can damage the torches internals in seconds causing a leak. It can also blow out the torches water/out & power cable. A flow switch can be installed after the return line ensuring that coolant is present at the return line prior to striking an arc.

When High-Deposition GMAW or extended periods of arc time are used, it is recommended that a liquid chiller be considered with a larger reservoir and a minimum of 30,000 BTU/hr cooling capacity. Precise temperature control maintains the cooling at a constant 13°C (55°F) temperature, thus prolonging the life of the welding equipment and more specifically extending the service life of the gas nozzle and current tip.

A refrigerated liquid chiller for GMAW may be obtained from: For single torch chillers: Dynaflux - 800-334-4420 - www.dynaflux.com

**For extreme duty cycles or multiple torch cooling systems: MTA Refrigerated Chillers - 716-693-8651 - https://www.mta-it.com/eng/

INTRODUCTION

The D/F Water-Cooled Curved Gun Model NCCE-A offers a rugged design for accommodating a hard and cored wire diameter range of .030”-1/8”.

The Model NCCE-A accommodates several types of threaded current tips. The current tips are accepted by the gun assembly through the use of interchangeable adapters fastened to the front end of the inner body assembly. In addition, gun lengths may be extended by the selection of two (2) different Water-Cooled Nozzles.

The Curved Gun has a current capacity of 500-600 amperes contingent on which combination of current tip and shielding gas is used. It will accommodate .030”-1/8” hard/cored wire, and 3/64”-3/32” AL wire, and is recommended for all robotic applications.

A unique feature of these Water-Cooled Machine Barrels is that the nozzle assembly water chamber and inner body water chamber are serially connected to each other with removable connectors making it a relatively simple matter to detach the nozzle assembly, thus completely eliminating the need for gaskets or O-rings in the water passage system.

CAUTION:
Make certain that periodic inspection is made of the nylon casing insulating sleeve at the forward end of the gun elbow. A deteriorated nylon insulating sleeve could allow the welding potential to appear at the Water-Cooled Nozzle and gas nozzle, thus arcing could occur at the gas nozzle should the gun be accidentally touched to the ground during the welding operation.

For further information or help with D/F Machine Specialties products, please visit our web site at www.dfmachinespecialties.com, or consult the factory at 1-507-625-6200.

TABLE 1 - SPECIFICATIONS & ORDERING INFORMATION

Model NCCE-A Threaded Tip - 7/16” Diameter
Standard Body Tube

CODE NO.	DESCRIPTION	W/C NOZZLE ASSEMBLY	RECOMMENDED WIRE DIAMETER RANGE	CO_2
17224-NCC	10 Ft. Assy.	Short 3” (11142)	.030”-1/8” Hard/Cored 3/64”-3/32” AL	600 amp
17225-NCC	12 Ft. Assy.	Short 3” (11142)		600 amp
17226-NCC	15 Ft. Assy.	Short 3” (11142)		600 amp
17227-NCC	10 Ft. Assy.	Inter 4” (11138)		600 amp
17228-NCC	12 Ft. Assy.	Inter 4” (11138)		600 amp
17229-NCC	15 Ft. Assy.	Inter 4” (11138)		600 amp
17230-NCC	10 Ft. Assy.	Long 5” (45127)		600 amp
17231-NCC	12 Ft. Assy.	Long 5” (45127)		600 amp
17232-NCC	15 Ft. Assy.	Long 5” (45127)		600 amp

Model NCCE-A Threaded Tip - 7/16” Diameter
20” Body Tube

Code No.	Description	W/ Nozzle Assembly	RECOMMENDED WIRE DIAMETER RANGE	CO_2
17217-NCC	10 Ft. Assy.	Short 3” (11142)	.030”-1/8” Hard/Cored 3/64”-3/32” AL	600 amp
17218-NCC	12 Ft. Assy.	Short 3” (11142)		600 amp
17219-NCC	15 Ft. Assy.	Short 3” (11142)		600 amp
17220-NCC	10 Ft. Assy.	Inter. 4” (11138)		600 amp
17221-NCC	12 Ft. Assy.	Inter. 4” (11138)		600 amp
17222-NCC	15 Ft. Assy.	Inter. 4” (11138)		600 amp
17223-NCC	10 Ft. Assy.	Long 5” (45127)		600 amp
17223-12-NCC	12 Ft. Assy.	Long 5” (45127)		600 amp
17223-15-NCC	15 Ft. Assy.	Long 5” (45127)		600 amp

REQUIRED TOOLS LIST FOR DISASSEMBLY & ASSEMBLY

1. **D/F 12111 Collet/Tip Wrench** - This is the only tool that should ever be used to tighten the collet nut or the tip. Pressure should be 30 lbs., or as snug as hand tightened. Never use another wrench to apply more torque to this wrench.

2. **D/F Nozzle Thread Chaser Tap** - This is used to re-tap damaged threads that have been improperly cleaned or cross threaded. Always blow out the nozzle and gas nozzle after changing gas cup or re-tapping. For more information on how to use the nozzle thread chaser tap, use the following link: www.dfmachine.com/taps

3. **Long 5/16" Open Ended Wrench**
   A. A short wrench will work, however we prefer the feel and comfort of the long 5/16" open ended wrench. This is used to loosen or tighten interconnection hose (10974) to the 7mm fitting on the inner body, and to connect the pipe assembly (10957) to the water in hose.
   B. Also use this wrench to connect the torch's water-cooled nozzle assembly to the interconnection hoses.

4. **3/8" Open Ended Wrench** - This is used on the inner body's gas hose fitting to secure the gas hose to the torch's inner body. A crescent wrench could be used instead, but due to the large size of crescent wrenches, we prefer the smaller size of the open ended wrenches. You never want to use excessive force by using too large of a wrench. You will use the Long 7/16" Open Ended Wrench for the fitting on the gas hose itself while using the 3/8" wrench to steady the inner body at the fitting. (see #5)

5. **Long 7/16" Open Ended Wrench** - This is used to secure the gas hose to the torch's inner body. (see #4)

6. **9/16" & 1/2" Open Ended Wrench**
   A. This is used on the inner body's water out & power cable fitting to secure the water out and power cable to the torch's inner body. A crescent wrench could be used instead, but due to the large size of crescent wrenches, we prefer the smaller size of the open ended wrenches. We prefer the use of the larger wrenches on the power cable fitting to ensure that there are no water leaks, and that it has been seated correctly. You will use the #7 (Long 9/16" Open Ended Wrench) for the fitting on the water out & power cable hose. (see #7 A)
   B. This wrench is also used to secure the adapter and jam nut that hold the current tip to the inner body. In your left hand hold the inner body, and with your right hand thread up the adapter using the 1/2" Open Ended Wrench until it is tight. Now place the same wrench on the jam nut and snug it up against the inner body. Keeping that wrench on the jam nut and placing it on the table for force, take #7 (Long 1/2" Open Ended Wrench), place it on the adapter and push it down (counter-clockwise) securing the adapter to the inner body. (see #7 B)

7. **Long 1/2" & 9/16" Open Ended Wrench**
   A. This is used to secure the water out & power cable to the torch's inner body. A medium size adjustable crescent wrench could be used as well. We prefer the use of the larger wrenches on the power cable fitting to ensure that there are no water leaks, and that it has been seated correctly. (see #6 A)
   B. This wrench is also used to secure the adapter and jam nut to the inner body. (see #6 B)

8. **Adjustable Crescent Wrench** - A medium size adjustable crescent wrench could be used as well. We prefer the use of the larger wrenches on the power cable fitting to ensure that there are no water leaks, and that it has been seated correctly. **CAUTION:** Never use excessive force with large wrenches, for you could twist or break parts.

9. **Standard Flat Head Screwdriver** - This is used to tighten or secure the torch's body screw. Also, the screwdriver can be used to straighten the contact tip if it is not aligned in the center of the gas cup or water-cooled nozzle **CAUTION:** This cannot be done unless the spatter disc has been removed from the torch.

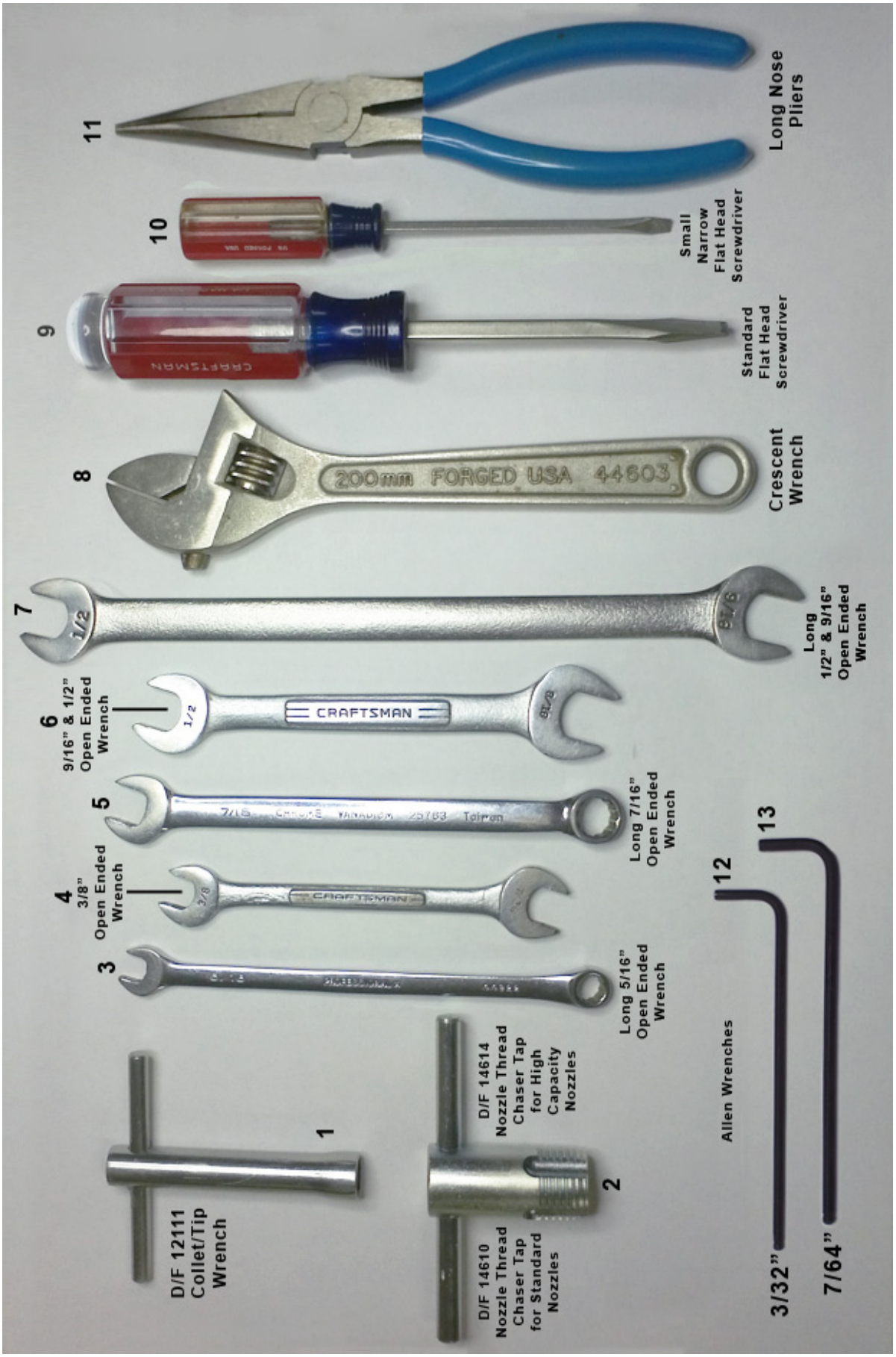
10. **Small Narrow Flat Head Screwdriver** - This is required to insert into the curved body elbow hole so you can access the casing/conduit set screw.

11. **Long Nose Pliers** - These are used to grab the small white insulation tubes (10723) and get them into the correct position when working on the interconnection hose fittings inside the torch. Also they are very handy when changing a slip-in contact tip.

12. **3/32" Allen Wrench** - This is used to secure the socket set screw that holds the casing/conduit in the inner body.

13. **7/64" Allen Wrench** - This is used to secure the 2 socket screws that hold the elbow on the body housing.

REQUIRED TOOLS LIST FOR DISASSEMBLY & ASSEMBLY



HOW DO I CUT, FIT, AND INSTALL A NEW LINER?

1. Be sure the MIG Gun cable is arranged in a straight line, free from twists, when installing or removing a wire liner.

2. Remove the old liner by first removing the MIG gun's contact tip.

3. Pull the old wire liner out of the conduit/casing assembly from the feeder connector or feeder adapter plug end. If you are using a feeder adapter that has an inlet, the inlet must be removed first. If you have any problems removing the liner you may un-thread the feeder adapter first this will also back the liner out of the conduit/casing.

4. If you know that the old liner is the correct length or is still the original liner that was cut at the factory you may hold the new liner up against the old liner and cut off the new liner to the same size as the old liner.

5. Make sure you have a good sharp cut off with no material sticking out!

6. To get the correct length of the new liner, insert the liner into the feeder adapter and feed it through the conduit/casing.

7. Once again be sure the MIG Gun cable is arranged in a straight line, free from twists, when installing a new wire liner.

8. Sometimes on longer conduits/casings and liners it may take 2 people together; one on each end to rotate and twist the conduit/casing to get the liner trough the torch.

9. If you have any troubles getting a liner through a torch make sure you have a good sharp cut off, and if you have to you can gently sand the end of the liner on a belt sander. You can remove the cast in the aluminum liner by pre-bending and straightening the liner before loading.

10. After the new liner comes out the end of the torch you want to cut the new liner off flush with the end of the copper gas nozzle or Cu gas cup.

11. Now you have the overall length of the liner, you still have to take out the length of the contact tip.

12. Carefully remove the liner one more time.

13. After removing the liner hold the gun end of the liner up against the tip.

14. Cut off the length off the tip plus the set back of the tip (1/8" or 3/8" tip setbacks)

15. Now that you have cut off the length of the tip plus the setback you may install the new liner and it will back up into the back of the tip chamfer.

16. We always recommend checking the condition of the insulation tube in the front of the torch and collet nut that holds the slip-in tip.

17. We always recommend replacing the spatter disc/gas diffuser, contact tip, and nozzle, after installing a new liner.

18. Tighten the flat head set screw in the inner body, or the Allen set screw in the docking spool onto the conduit/casing to prevent backward movement or an unwanted pumping action.

WHAT IS THE PROPER USE OF THE NOZZLE THREAD CHASER TAP?

All D/F Nozzles are hand checked for fit before and after plating, and checked again before shipping. If a nozzle has been installed on a new complete torch, they have also been hand checked while being assembled.

The only reason to ever take a gas cup out a nozzle is to clean it. The nozzle and the gas cup must be blown out, and all of the threads have to be wire brushed and blown out again before hand-tightening the gas cup back into the nozzle. If you can't thread it in by hand then something is wrong. Never force a gas cup into a nozzle.

When using the D/F Machine Specialties nozzle thread chaser taps, be sure to always follow the steps below:

1. Make sure that the nozzle is properly supported when tapping so it does not twist in the front of the torch body and cause damage.
   - Improper support can cause the spigots to twist off the top of the rear nozzle collar, or damage the torch internal body parts.
   - Note where the water ports go down the sides of the water-cooled nozzle (following down in line with the spigots). Too much direct pressure on these water ports could cause them to cave in and block of the flow of water.
   - Best practice is to hold the water-cooled nozzle in a vice with soft jaws, perpendicular to the spigots.
   - Over-tightening of the vice can cause damage in general.

2. Remove the tip from the front of the torch before tapping.

3. Lightly lubricate the nozzle and nozzle thread chaser tap before tapping.

4. Be sure to start the tap very carefully. Do not cross thread the nozzle.

5. Be very careful to start threads correctly. Only tap 1/2 turn at a time, always backing up and removing chips 1/2 cycle at a time before moving forward. Do not try to tap further into the water-cooled nozzle than needed or past the factory thread depth.

6. Blow out the nozzle after tapping. Wire brush and blow off the gas cup before threading it back into the nozzle.

7. If nozzle is badly deformed or damaged please return to the factory for a repair estimate before disposing of product (damaged parts can often be repaired).

ORDERING INFORMATION - NOZZLE THREAD CHASER TAPS

CODE NO.	DESCRIPTION	USED WITH NOZZLE ASSEMBLY	USED FOR GAS NOZZLE
14610	Nozzle Thread Chaser Tap for Standard A/C & W/C Nozzle Assembly Front	13197 16184 11117, 45101 11118, 45102 11119, 45103 45114 45107 NCC-N/HTC-N NCC-LRN, HTC-LRN	10340 10359 10362 10374
14611	Nozzle Thread Chaser Tap for BIG MIG & BIG TIG Nozzle Assembly Front	11123	10382 10387 10389 10390 10392
14612	Nozzle Thread Chaser Tap for Nozzle Body Assembly Rear	13196 13197 13198 16184	
14614	Nozzle Thread Chaser Tap for Series A High-Capacity Nozzle Assembly Front	11142, 45120 11138, 45121 45127 11132, 45129 45125	16748 16749 16750 16751 18030 18031 18032
14615	Nozzle Thread Chaser Tap for Nozzle Body Assembly Front	13198	10379
14617	Nozzle Thread Chaser Tap for Tandem Nozzle Assembly Front	41641	41667 41668

DISASSEMBLY

1) All repairs and adjustments to barrel assemblies are made with the power source and feeder turned off.

2) Remove the forward gas nozzle, collet nut, current tip, support tube and spatter disc.

3) Remove the wire casing via the screw through the hole in the elbow. Then turn the screw back down until it bottoms. This provides the clearance to remove the inner body from the elbow.

4) Unscrew the cone nut to allow the Water-Cooled Nozzle Assembly to be pulled forward approximately 3/4”. This will expose the water connection fittings. Make certain that the Water In hose is not under tension while pulling the nozzle forward. The nylon insulators at the water-cooled nozzle rear collar are now exposed. Push these insulators into the body housing concaves which will then expose the inter-connection water hose fittings. With a 5/16” open end wrench, disconnect these fittings and remove the Nozzle Assembly from the elbow. The water-cooled nozzle can now be pulled from the barrel assembly. If replacement of the inner body is required, remove the adapter with jam nut at this time using two (2) 1/2” open end wrenches.

5) Loosen the two (2) socket screws in the elbow and pull the fiber tube back far enough to expose the inner body and hose fittings. Remove the screw and insulating washer on top of the metal elbow. This will permit the inner body to move forward slightly.

6) Remove the two (2) insulators from the concaves, then remove the black fiber insulator from the elbow. The inner body can now be removed from the rear of the elbow, and the service lines disconnected if necessary.

ASSEMBLY

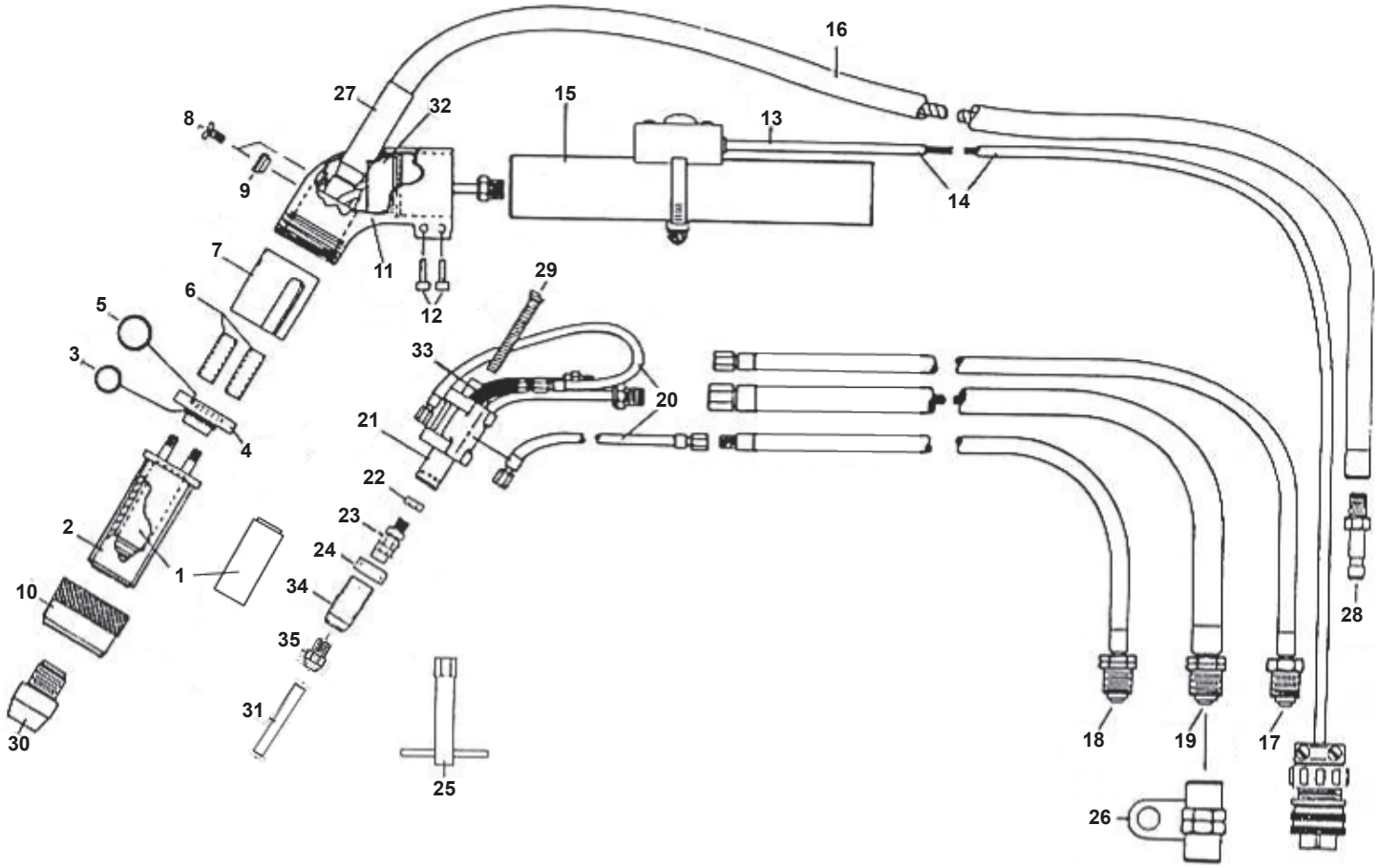
1) Load fiber handle with service lines and connect all service lines to the inner body assembly if necessary.

2) Reassembly in reverse order of steps outlined under disassembly.

TABLE 2 - RECOMMENDED SPARE PARTS

ITEM	CODE NO.	MIN QTY.
Gas Nozzle	To Be Selected	2
Current Tip	To Be Selected	25
Spatter Disc	18253	2
Body Liner	To Be Selected	2
Insulation Tube	To Be Selected	1
Support Tube	To Be Selected	1

MODEL NCCE-A
Curved Gun with External Casing



REF.	CODE NO.	DESCRIPTION
1	18451	Insulation Tube - For 3” Nozzle
	18452	Insulation Tube - For 4” Nozzle
	18383	Insulation Tube - For 5” Nozzle
2	11142	Water-Cooled Nozzle - Short 3”
	11138	Water-Cooled Nozzle - Inter. 4”
	45127	Water-Cooled Nozzle - Long 5”
3	12516	O-ring - External
4	10739	Insulating Collar w/ O-rings
5	13912	O-ring - Internal
6	10723	Insulating Tube (2 req’d)
7	12893	Elbow Insulator
8	12613	Flat Head Screw (SS)
9	12880	Washer
10	16812	Cone Nut
11	12886	Body Elbow
12	12521	Socket Head Cap Screw (2 req’d)
13	12151	Slide Switch Assembly - 12” Leads
14		Switch & Cable Assembly (see p. 13)
15	12870	Body Tube - Standard
	16965	Body Tube - 20”
16		Casing (see p. 12, Table 5)
17	11846	Gas Hose 10 Ft.
	11852	Gas Hose 12 Ft.
	11847	Gas Hose 15 Ft.
18	12944	Water In Hose 10 Ft.
	12946	Water In Hose 12 Ft.
	12945	Water In Hose 15 Ft.

REF.	CODE NO.	DESCRIPTION
19	11906	Water Out & Cable Assembly 10 Ft.
	11910	Water Out & Cable Assembly 12 Ft.
	11908	Water Out & Cable Assembly 15 Ft.
20	10974	Hose Assembly (2 req’d)
21	11039	Inner Body
22	11960	Jam Nut
23	18312	Adapter Assembly - Short 3” Nozzle
	18263	Adapter Assembly - Inter. 4” Nozzle
	18313	Adapter Assembly - Long 5” Nozzle
24	18253	Spatter Disc
25	12111	Wrench
26	14430	Cable/Water Out Hose Power Coupling
27	12894	Insulator Tube - For 5/64”-3/32” Casing
	12895	Insulator Tube - For 7/64”-1/8” Casing
28		Wire Feeder Adapter (see p. 15)
29		Inner Body Liners (see p. 12, Table 6)
30		Gas Nozzle (see p. 12, Table 4)
31		Current Tip 5/16” Slip-in see p. 12, Table 3)
32	12896	Elbow Insulator
33	12644	Heat Shrink
34	18251	Support Tube - For 3” Nozzle
	18252	Support Tube - For 4” & 5” Nozzle
35	18262	Collet Nut

TABLE 3 - CURRENT TIPS

CURRENT TIPS - 5/16" DIAMETER SLIP-IN

Gun/Barrel Model	Wire Size	Wire Type	Code No.
All NC, NCC, NCM (Tip provides 1/8" set back)	.030" .035" .045" .052" 1/16" 5/64" 3/32"	Hard Hard Hard Hard Hard Hard Hard	10883 10884 10885 10886 10887 10888 10889
All NC, NCC, NCM (Tip provides 3/8" set back)	,035" .045" .052" 1/16" 5/64" 3/32" 7/64"	Cored Cored Cored Cored Cored Cored Cored	10893 10894 10895 10896 10897 10898 10899
All NC, NCC, NCM (Tip provides 1/8" set back)	3/64" 1/16" 3/32"	Soft Soft Soft	10902 10935 10936

TABLE 4 - GAS NOZZLES

REF.	CODE NO.	TYPE	I.D.
1	16749	Copper Short Taper	11/16"
	16750	Copper Short Taper	13/16"
	16751	Copper Short Taper	15/16"
2	18030	Copper Full Taper	11/16"
	18031	Copper Full Taper	13/16"
	18032	Copper Full Taper	15/16"

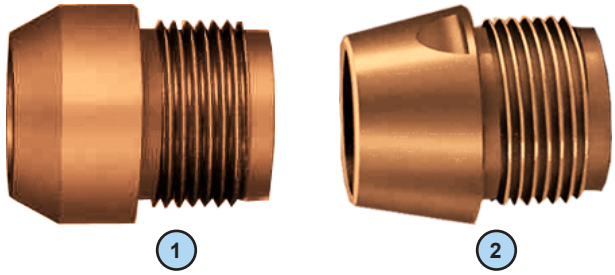


TABLE 5 - CASINGS

DESCRIPTION	10 FT.	12 FT.	15 FT.
5/64"-3/32" Dia. Single Piece Casing - Cored Wire (Insulation Tube 12894)	15701	15702	15703
7/64"-1/8" Dia. Single Piece Casing - Cored Wire (Insulation Tube 12895)	15704	15705	15706

TABLE 6 - INNER BODY LINERS

CODE NO.	WIRE SIZE	W/C NOZZLE
14667	.045"-.052"-1/16"	Short 3"
14668	.045"-.052"-1/16"	Inter. 4"
14669	.045"-.052"-1/16"	Long 5"
14670	5/64"-3/32"	Short 3"
14671	5/64"-3/32"	Inter. 4"
14672	5/64"-3/32"	Long 5"
14673	7/64"-1/8"	Short 3"
14674	7/64"-1/8"	Inter. 4"
14675	7/64"-1/8"	Long 5"

TABLE 7 - SWITCH & CABLE ASSEMBLIES

Code No.	Feeder Manufacturer - Model No.	Type Of Connector	Length
18000	Miller “50” Series	AMP	10 Ft.
18001	OTC CMRE-741 & 742	Amphenol - 2 Pin	-
18004	Lincoln LN-7, LN-8, LN-9, Power Feed 10, LF-72, LF-74, PF-84	Amphenol - 5 Pin	-
18005	Linde/ESAB31/35-Miller “30” Series	Hubbell - 2 Blade	-
18007	Miller “50” Series	AMP	12 Ft.
18008	OTC CMRE-741 & 742	Amphenol - 2 Pin	-
18011	Lincoln LN-7, LN-8, LN-9, Power Feed 10, LF-72, LF-74, PF-84	Amphenol - 5 Pin	-
18012	Linde/ESAB31/35-Miller “30” Series	Hubbell - 2 Blade	-
18014	Miller “50” Series	AMP	15 Ft.
18015	OTC CMRE-741 & 742	Amphenol - 2 Pin	-
18018	Lincoln LN-7, LN-8, LN-9, Power Feed 10, LF-72, LF-74, PF-84	Amphenol - 5 Pin	-
18019	Linde/ESAB31/35-Miller “30” Series	Hubbell - 2 Blade	-
Code No.	**DESCRIPTION (PLUG ONLY)**	**Type Of Connector**	
12162	Miller “50” Series	AMP	
13850	OTC CMRE-741 & 742	Amphenol - 2 Pin	
12160	Hobart-Airco-Westinghouse	Amphenol - 3 Pin	
14731	Oxo All-Auto Arc	Amphenol - 4 Pin	
14734	Lincoln LN-7, LN-8, LN-9, Power Feed 10, LF-72, LF-74, PF-84	Amphenol - 5 Pin	
13317	Miller “30” Series-Linde/ESAB31/35	Hubbell - 2 Blade	
13431	Hobart 27	Phone Jack	

UTILITY STATION - STANDARD

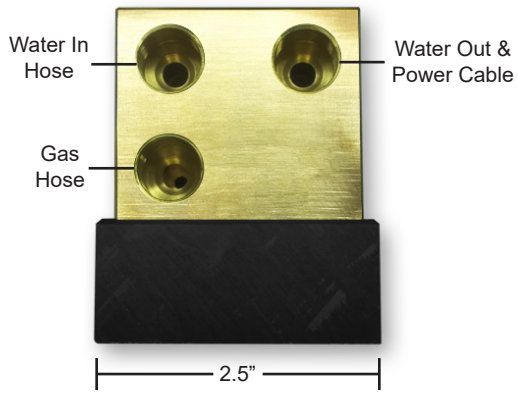
ORDERING INFORMATION

Description	Code No.
Utility Station	45196
Utility Station - Dual Power Cable	45188

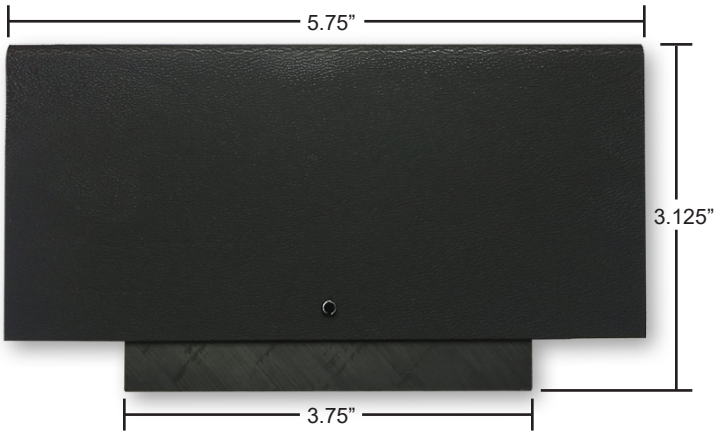
DIMENSION SPECIFICATIONS

Base Length	3.75”
Overall Length	5.75”
Base Width	2.25”
Overall Width	2.5”
Overall Height	3.125”
Mounting Hole Center Distance	2.75”
Overall Weight	3.5 lbs.

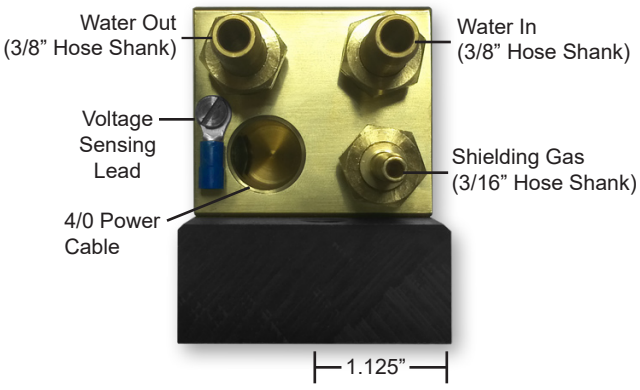
D/F TORCH CONNECTION



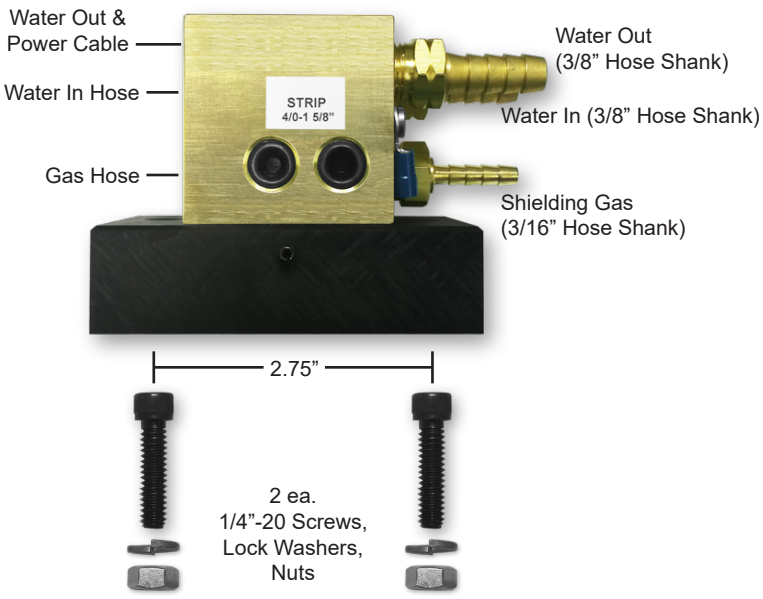
UTILITY STATION SIDE VIEW WITH COVER



CUSTOMER UTILITIES CONNECTION



FROM LEFT: D/F TORCH CONNECTION
FROM RIGHT: CUSTOMER UTILITIES CONNECTION



WIRE FEEDER ADAPTERS & INLETS

Manufacturer	Models	Wire Diameter	Remote Mount Adapter			Direct Mount Adapter	
			Hard or AL	Cored	Stub* Liner	Hard or AL	Cored
ESAB®	D20 (20mm)	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13098	13099	* *	13096	13097
ESAB®			18246	18247		18248	18249
EURO			18493	18493		18540	18540
Hobart®	All Models	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13067	16087	* *	13068	16225
Lincoln®	LN-7, LN-8, NA5-R	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13110	13112	* *	13113	13116
	LN-9	.030”-3/32” H/C/AL 5/64”-1/8” H/C	16581	16582	* *	16528	16529
	NA3, NA5	.030”-3/32” H/C/AL 5/64”-1/8” H/C	16879	16878	* *	16880	16881
“BIG MIG”	NA3, NA5	.030”-3/32” H/C/AL 5/64”-1/8” H/C	16879	16878	* *	16888	16888
Lincoln®	Power-Feed 10, LF-72, LF-74	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13479	13469	* *	13480	13468
Linde®	SWM31 SWM34 SWM37 SWM38 EH8	Casing to Feeder (Accepts Linde® Outlet Guide)	13046			13046	
		D/F Insert .035”-.045” Hard .045”-1/16” Hard 5/64”-3/32” Cored 3/64”-1/16” AL	13047 13048 13050	13049		13047 13048 13050	13049
	EH10	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13043	13052	* *	13080	13079
Mavrix®	PA-10	.030”-3/32” H/C/AL 5/64”-1/8” H/C	16556	16568	Requires Inlet		
Miller® (50 Series)		.030”-3/32” H/C/AL 5/64”-1/8” H/C	16557	16559	* *	16558	16560
OTC®	Requires Insert	.030”-1/8” .030”-1/8”	18268		* *	18275	
	CMRE-741		18282			18282	
Panasonic®	PME-12X YW50AKW1	.030”-1/16” .030”-1/16”	13090 13466	Requires Inlet			
TWECO®	#4	.030”-3/32” H/C/AL 5/64”-1/8” H/C	13479	13469	* *	13480	13468
Welding Alloys®		.030”-3/32” H/C/AL 5/64”-1/8” H/C		Requires Liner Requires Inlet		13486	13486

***Stub liners only required in feeder adapter when single-piece casing is used.**

ORDERING INFORMATION

Each D/F gun is fully assembled and ready to install. In order to make the installation complete, the code number, wire size & type, make/model of wire feeder, and inlet as needed must be specified when ordering. If special welding tools or accessories other than those listed previously are required, please consult with the factory.

FEEDER ADAPTER INLETS

Wire Size	Steel Code No.	Brass Code No.	Nylon Code No.
.030”	13801	16417	
.035”	13803	16418	
.045”	13806	16419	
.052”	13844	16420	
1/16”	13809	16421	
5/64”	13812	16422	
3/32”	13814	16422	
7/64”	13816		
1/8”	13842		
3/64” AL			13807
1/16” AL			13810
3/32” AL			13815

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TROUBLESHOOTING: POROSITY (SUMMARY)

NOTE: Most POROSITY is caused by gas problems, followed by base metal contamination.

Causes of Porosity	Possible Solutions
BASE METAL CONTAMINATION	
Impurities on base metal	a. Remove contamination; clean surfaces b. Use of specific wire/gas mix for specific types of impurities
FILLER METAL CONTAMINATION	
Impurities on filler metal (wire)	a. Replace wire b. Install wire-cleaning system c. Prevent industrial dust/dirt/grit from contaminating wire during storage or use d. Prevent build-up of aluminum oxide on exposed aluminum wire surface by using up quickly e. Remove wire from wire drive unit and store in a sealed plastic bag when not in use for long periods
ATMOSPHERIC CONTAMINATION	
Drafts, wind, fans, etc.	a. Protect weld from drafts (curtains/screens) b. Use tapered or bottleneck gas nozzles when drafts cannot be avoided
GAS MIXING APPARATUS	
1. Too high a gas flow, causing turbulence, and/or sucking air at hose connections; creating the venturi effect at end of gas nozzle	1a. Reduce gas flow 1b. Tighten all hose connection points
2. Too low a gas flow, causing insufficient gas coverage	2. Increase gas flow
3. Damaged or kinked gas lines	3. Repair or replace
4. Too high an oxygen content	4. Adjust mixer
5. Leaks in gas distribution system	5. Repair leaks
6. Other impurities in gas - moisture, etc.	6. Overhaul system; fit filters and/or dryers
7. Inconsistent gas flow (cfh) at the torch connection	7. Regulate pressure into flow meter for consistent cfh delivery of gas
GAS TURBULENCE	
1. Excessive spatter build-up in gas nozzle and on current tip	1. Clean nozzle and tip regularly; spray with anti-spatter fluid
2. Nozzle damage, causing uneven gas coverage	2. Replace nozzle
3. Torch gas ports clogged or deformed	3. Clean or replace
4. Super-heated nozzle, causing shielding gas to expand rapidly and create return effect at end of nozzle	4. Check duty cycle rating of torch
5.Gas diffuser/nozzle insulator missing	5. Replace
6. Too high a gas flow causing the venturi effect	6. Reduce gas flow
WELDING PARAMETERS, ETC.	
1. Too long a wire stick-out; gas nozzle too far from weld puddle	1. Use longer nozzle or adjust stick-out (3/8” minimum or 15 times wire diameter)
2. Bad torch position - too sharp a torch incline causing the venturi effect at the end of the nozzle leading to atmospheric contamination	2. Correct torch angle
3. Excessively wide weld pool for nozzle I.D.	3. Width of the weld pool should be 1.3 times the nozzle I.D.; use suitable wider gas nozzle
4. Arc voltage too high	4. Reduce voltage
5. Too high a travel speed	5. Reduce speed

TROUBLESHOOTING: SPATTER

Problems/Causes	Possible Solutions
SPATTER	
Too fast or too slow wire feed for the arc voltage	Set the wire feed rate and voltage in accordance with good welding practices as recommended by a qualified welding engineer.
Too long an arc	Adjust the wire feed and voltage so that the arc is in accordance with good welding practice for the joint to be welded. The distance from the current tip to the workpiece should be 15 times the welding wire diameter. If the arc is too long there will be spatter, usually in the direction of the weld.
Damaged current tip	If the current tip becomes worn the welding wire will not be in constant contact with the tip and the arc will become unstable. A current tip contaminated with spatter will cause uneven wire feed resulting in further spatter.
Inclination of welding gun too great	The angle of the gas nozzle relative to the workpiece should be between 45 and 90 degrees. If the angle is too small, the wire runs parallel to the weld pool, resulting in spatter in the direction of the welding.
Faulty power source	Have the power source checked for faulty conditions such as broken wires and faulty contacts.
Incorrect start	A great deal of spatter occurs if the stick-out is too great and if the welding gun is held too far from the workpiece when striking the arc. Try to start with as short a stick-out as possible and with the welding gun as close to the starting point as possible. If a large ball end is formed on the end of the welding wire, remove it by cutting the wire with sharp wire cutters. It is helpful if the wire is cut to a point. Always remove the ball end before striking an aluminum arc. Check the welding ground connection.
Incorrect pulse parameters	Check the user manual for your power supply or consult a qualified welding engineer.
Uneven wire feed	Uneven wire feed gives rise to heavy spatter. Find the cause of the disturbance and correct the condition before proceeding.
Impurities on the base metal	Paint, mill scale, rust and other contamination on the base metal form an insulating layer causing an unstable arc that results in heavy spatter. Clean the surfaces to be welded.
Poor ground contact	Inspect ground cable for loose connections, fraying and cuts. Correct any problem areas found and attach the ground cable directly to the workpiece after having cleaned the contact surface first. POOR GROUND CONTACT IS THE MOST COMMON CAUSE OF UNSTABLE MIG WELDING CONDITIONS.
Too long stick-out (short-arc welding)	The stick-out should be 15 times the diameter of the wire electrode being used. With increasing stick-out, the current is reduced and the arc voltage rises, giving a longer unstable arc and increased spatter.
Incorrect polarity	Check for correct polarity. Follow the electrode manufacturer's recommendations.

TROUBLESHOOTING: GENERAL GUIDE

Problems/Causes	Possible Solutions
ERRATIC WIRE FEED	
Slipping feed rolls	Check that the feed roll size is correct for the wire size being used. Increase the drive roll pressure until the wire feed is even. Do not apply excessive pressure as this can damage the wire surface, causing copper coating to loosen from steel wires or metal shavings to be formed from soft wires like aluminum. These metal fragments or shavings can be drawn into the wire feed conduit and will rapidly clog the liner. When welding with flux-cored wires, excessive drive roll pressure may open the wire seam and allow flux or metal powders to escape.
Clogged or worn gun liner	a. Dust, particles of copper, drawing lubricants, metal or flux and other forms of contamination can all clog the liner so that the wire feed is slowed or impeded. A liner that has been in use for an extended period of time becomes worn and filled with dirt and must be replaced. b. When changing the welding wire, remove the tip from the front end of the gun and blow out the body liner with clean, dry compressed air from the back of the gun. Repeat with the casing and liner assembly. Note: Wear safety goggles when using compressed air to clean the liners. Make sure proper safety procedures are followed in order to avoid possible serious eye injury.
Liners too long or too short	Check the lengths of the liners and trim or replace if too long or too short. The efficient feeding of the welding wire is dependent on the liners fitting correctly.
Spatter on the wire	An unprotected coil of wire quickly collects dust and other airborne contamination. If grinding is being performed in the vicinity, particles can become attached to the wire, severely interfering with the wire feed. Replace with clean wire and keep it protected with a cover. Make sure spare wire rolls are stored in a clean, dry place.
Coil brake incorrectly adjusted	Set the brake so that the coil immediately stops rotating as soon as welding is interrupted. If the brake is applied too hard it will cause the feed rolls to slip, resulting in uneven wire feed. If it is too loose, overrun of the wire will occur, causing wire tangles, inconsistent tension on the feed mechanism and irregular arc characteristics.
UNSTABLE ARC	
Incorrect setting of voltage and/or current	Set the wire feed in relation to the arc voltage in such a way that the arc is stable and burns evenly. In spray arc welding, set the wire feed so that there are no short circuits and the filler metal is transferred in a spray across the arc. Find the cause of the interference and correct it. (See ERRATIC WIRE FEED above)
Problems in wire feeding: worn current tip	When the internal diameter of the current tip becomes worn from the passage of wire through it, the wire may no longer stay in continuous electrical contact with the tip. This results in an unstable arc and an increase in spatter. Paint, mill scale, silicon scale, rust or flux deposits from previous weld runs may form an insulating layer causing an unstable arc. Clean the surfaces to be welded.
Impurities on the base metal	Securely attach the ground cable as close to the point of welding as possible on the workpiece. Clean the surfaces thoroughly to ensure good contact.
Poor contact between ground cable and workpiece or loose power connection	Check to insure the welding power connection on the power source is tight, the and workpiece. Connection on the wire feeder is tight, the connection to the adaptor block is tight, Loose power connection and the connection of the gun to the adaptor block is tight.
Stick-out too long	Adjust the current tip to work distance to a minimum of 3/8” for short arc welding. A more precise distance is 15 times the wire diameter.

TROUBLESHOOTING: GENERAL GUIDE

Problems/Causes	Possible Solutions
AIR-COOLED GUN RUNNING TOO HOT	
Poor ground	Inspect ground cable for loose connections, fraying and cuts. Correct any problem areas found. Clean clamping area to insure good contact. Securely attach the ground cable to the workpiece, as close as possible to the point of welding. Make sure there is a good connection to the welding power source.
Loose power connection	Check to make sure the power connection on the power source is tight, the connection on the wire feeder is tight, the connection to the adaptor block is tight, and the connection of the gun to the adaptor block is tight.
Consumable items loose or worn	Remove nozzle from gun and inspect current tip, collet nut (tip holder) and spatter disc (gas diffuser) for wear and tightness; replace or tighten as necessary.
Capacity of gun being exceeded	Note complete weld parameters, including welding current (Amps), welding voltage, wire feed speed, type and size of wire, type of gas and flow rate of gas and consult your local Authorized D/F Machine Specialties Distributor or contact the factory.
Dirty connection	Remove torch and inspect parts for dirt build-up. Periodic cleaning is necessary.

D/F MACHINE SPECIALTIES, INC.

MIG & TIG Welding Products, Consumables & Accessories

WARRANTY

This Equipment is sold by D/F MACHINE SPECIALTIES, Incorporated, under the warranty set forth in the following paragraph. Such warranty is extended only to the buyer who purchases the equipment directly from D/F or its authorized distributor as new merchandise.

The barrel and cable assemblies are warranted by D/F to be free from manufacturing defects for 90 days after delivery by D/F, provided that the equipment is properly operated under conditions of normal use and that regular periodic maintenance and service is performed. Expendable parts are not warranted for any specific time. Expendable parts referred to herein would be the nozzles, current tips, spatter discs, insulators, casing liners, and wire inlets. D/F's sole obligation under this warranty is limited to making replacement at its manufacturing facility for barrel assemblies which are returned to it with transportation charges prepaid, and upon D/F's examination have been found to be so defective.

Genuine D/F MACHINE SPECIALTIES, Inc. Parts, Accessories, and Consumables must be used for safety and performance reasons. The use of anything other than genuine D/F MACHINE SPECIALTIES, Inc. Parts, Accessories, or Consumables will void this Warranty. All units returned for warranty repair are subject to Warranty Inspection. Warranty and repair work shall not apply to goods that have been altered or repaired, have been subject to misuse or used while any parts are loose, broken, or damaged, or used with other than original D/F® parts, consumables, or accessories which may affect performance and safety.

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