

**CAUTION** Disconnect gun from equipment, allow to cool and remove electrode from liner before servicing

## Diffuser Removal

Using the appropriate wrench remove the gas diffuser with a counterclockwise rotation.

## Conventional Liner Installation

Re-insert liner into power pin with cable laying straight. Continue until liner lock is fully seated into power pin. A twisting motion may be necessary to seat o-ring (some direct plugs may require installation of additional components to secure liner). Making sure cable is straight, push liner back into gun (back load) and trim per diffuser part number on the chart. Remove any burr that may obstruct wire feed.

## Diffuser Installation

Secure gas diffuser with appropriate wrench and torque in a clockwise rotation to 70 in-lbs.

**For additional maintenance and repair information, please visit the Technical Support area of our website at [BernardWelds.com/technicalsupport](http://BernardWelds.com/technicalsupport)**

New Liner Trim Lengths		
Centerfire™ Diffuser Part Number	Liner Trim Length	
	D-1	9/16"
D-1T	13/16"	20.6 mm
D-1T-5	13/16"	20.6 mm
DS-1	9/16"	14.3 mm
DS-1T	5/8"	15.9 mm
DW-1	1/4"	6.4 mm
Quik Tip™ Diffuser Part Number	Liner Trim Length	
	D114	5/8"
D114Q	9/16"	14.3 mm
D118	3/4"	19.1 mm
D118Q	3/4"	19.1 mm
D118QLL	1-5/16"	33.3 mm
D1FQ	7/8"	22.2 mm
D218	7/8"	22.2 mm

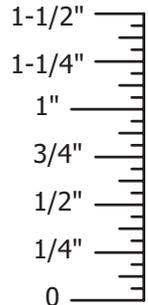
Please see helpful measurement guide provided below.



Quik Tip™ Diffuser  
without internal stop



Quik Tip™ Diffuser  
with internal stop



## Bernard

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