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TIGWARE Ceramic Units



Aussie Inovation

Product Information Sheet

TIGWARE Ceramic TIG Units Melbourne Australia

Sizes #12 - #14 - #16 - #20

TIGWARE'S Triple Diffuser System Compensates for Intermediary Cup sizes

DC Application.

Colour: White

Material: Ceramic

Use with Gas Lens Adapter 17GL332 (Available from TIGWARE) for #17/#18/#26 Series Torches and or 45V44 Gas Lens for #9/#20 Series Torches. TIGWARE Ceramic Units are connected to the Torch Head with TIGWARE'S Ceramic TEFLON Adapters, threads and seals directly to the Torch Head by way of a Mechanical Seal.

Always Treat your BEAVER with Great Care

Welding Parameters: DC Use Product

Tungsten $\varnothing = 1.6\text{mm}$ (1/16") / 2.4mm (3/32")

Stick Out: **15/25mm**. (Greater Stick Out can be Achieved with Higher Gas Flow)

MAX 180 amps rated **Non Continuous**

Gas Diffuser = TIGWARE'S Triple Diffuser System

For #17/18/26 style Torch Heads **Always use TIGWARE TEFLON Ceramic Adapters with TIGWARE'S 17GL332 GAS LENS'S**

TIGWARE Ceramic Units will have some internal markings. This is from the Assembly process and will not effect the overall performance.

Note: Grind Each end of the TUNGSTEN Rod to a point and remove the Painted section as the Diffuser System is designed to have a Sliding Fit.

Any remaining paint will interfere with the Diffusers during TUNGSTEN insertion and or Removal.

Standard GAS Flow Rates listed below for optimal Product Performance.

GAS Flow Rates

Size: #12 24 CFH / 11 > L / Min

Size: #14 28 CFH / 14 > L / Min

Size: #16 32 CFH / 15 > L / Min

Size: #20 40 CFH / 19 > L / Min

TIGWARE recommends a 10 second POST-Flow to protect the O-rings and Ceramic Adapter from excessive HEAT...!

Ceramic Unit use and Installation.

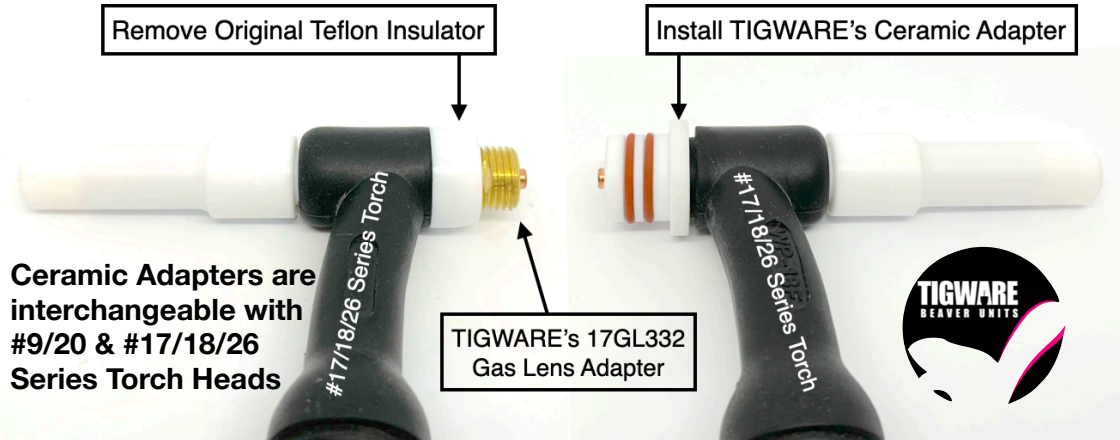
It's very important to **REMOVE** the original Torch Insulator before installing TIGWARE'S Ceramic ADAPTER. Always **EXCHANGE** the Original Teflon Insulator from the Torch head and install TIGWARE'S Ceramic Adapter so it's **FIRMLY** in contact with the BLACK Rubber of the Torch head. This allows for **FULL Thread Mating** of the Ceramic Adapter reducing potential heat distortion of the Adapter. This design also reduces the total length of the Nozzle from the Torch Head by 12mm for a 17/18/26 Head and 8mm for a 9/20 Style Heads offering more comfortable handling of the torch head during the weld process.



PTO

For #17/18/26 Series Torch Heads

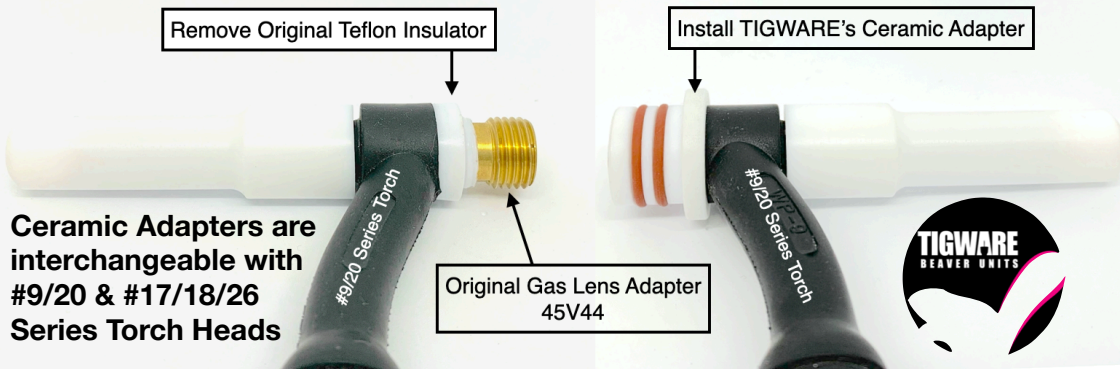
Exchange Original Insulator with TIGWARE's Ceramic Adapter



#17/18/26 Series Torch Heads

For #9/20 Series Torch Heads

Exchange Original Insulator with TIGWARE's Ceramic Adapter



#9/20 Series Torch Heads

Always Protect the BEAVER

Enjoy your new product and please let me know if you have any problems.

Regards John +61 (0) 448527996 / info@tigware.com.au

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