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TIGWARE QUARTZ Units



Aussie Inovation

Product Information Sheet

TIGWARE Quartz TIG Units Melbourne Australia

Sizes #10 - #12 - #14 - #16 - #20

TIGWARE'S Triple Diffuser System Compensates for Intermediary Cup sizes

DC Application.

Colour: Clear

Material: QUARTZ

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 Quartz Units are connected to the Torch Head with TIGWARE'S Quartz 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: **20mm**. (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 Quartz Adapters with TIGWARE'S 17GL332 GAS LENS'S**

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

Standard GAS Flow Rates listed below for optimal Product 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.

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 Pyrex Adapter from excessive HEAT...!

Quartz Unit use and Installation.

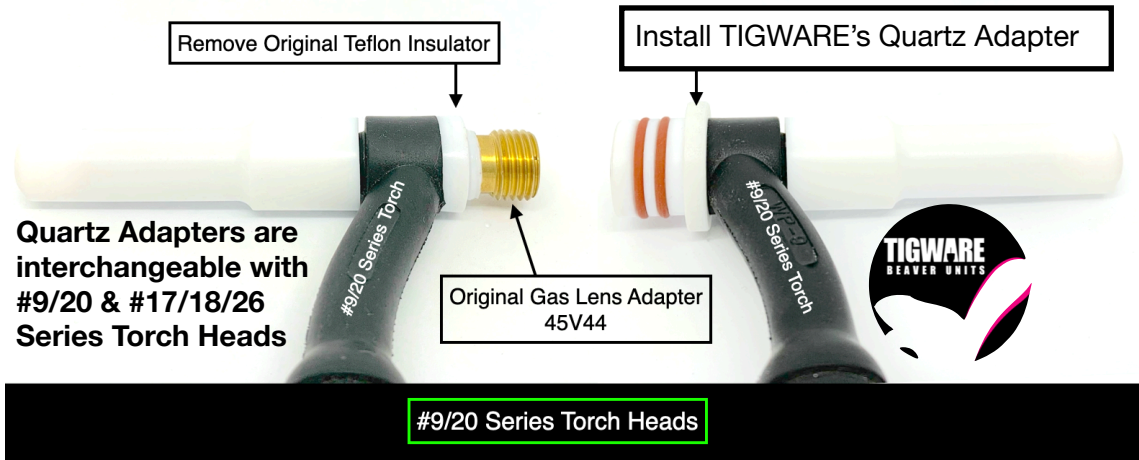
It's very important to **REMOVE** the original Torch Insulator before installing TIGWARE'S Quartz Adapter. Always **EXCHANGE** the Original Teflon Insulator from the Torch head and install TIGWARE'S Quartz Adapter so it's **FIRMLY** in contact with the BLACK Rubber of the Torch head. This allows for **FULL Thread Mating** of the Quartz 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.



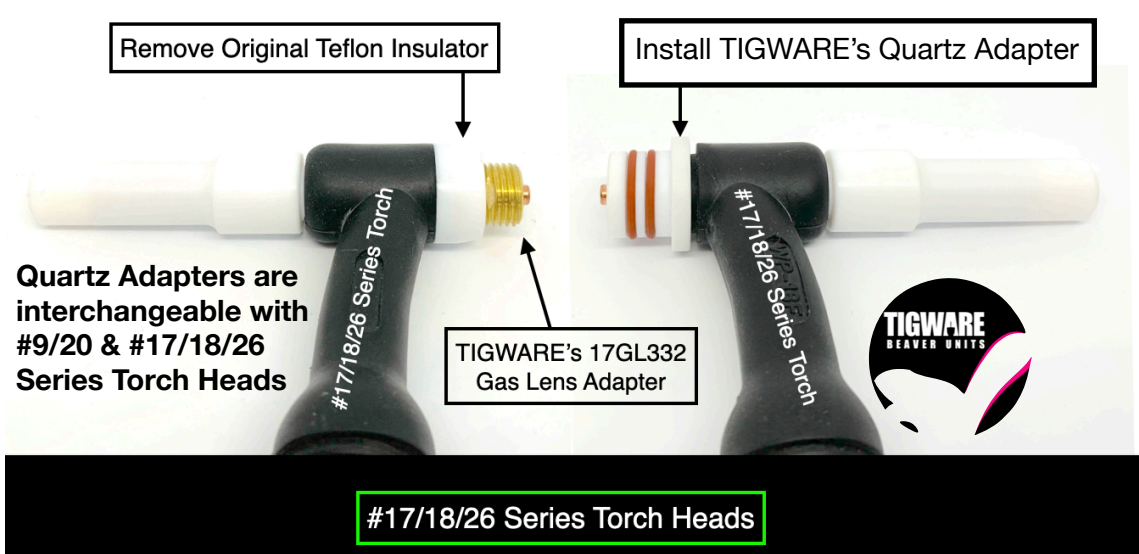
PTO

Always Protect the BEAVER

For #9/20 Series Torch Heads
Exchange Original Insulator with TIGWARE's Quartz Adapter



For #17/18/26 Series Torch Heads
Exchange Original Insulator with TIGWARE's Quartz Adapter



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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