

# TORCH INSTALLATION GUIDE

Mig160i, Mig185i, Mig200i, Mig225Ai

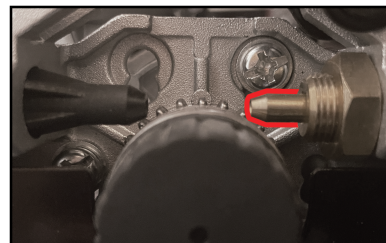
Please reference the user manual for more detailed instructions.

## STEEL TORCHES

### REQUIRES a Chamfered Brass Liner Guide Tube

Push the brass tube into the wire channel of the torch mount.  
The tip should be close to, but not touching, the drive roller.

Chamfered Brass Liner Guide Tube - reference to scale



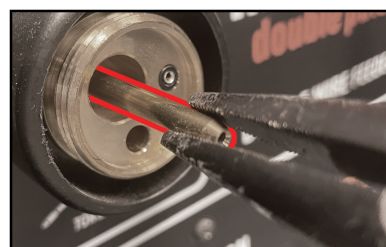
## ALUMINUM TORCHES

### MUST REMOVE the Brass Liner Guide Tube

Using narrow pliers, carefully grip the guide tube inside the torch mount and pull the brass tube out. Keep tube for Steel Torches.

\*There is an optional brass support tube for the nylon liner

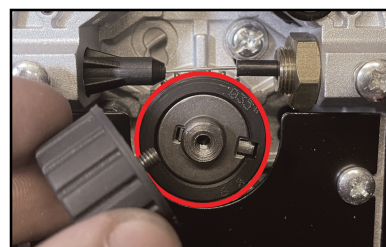
Optional Brass Support Tube - reference to scale



## CHANGING DRIVE ROLLERS

Insert the drive roller with your wire groove away from you.  
The text for the desired groove size should be hidden.  
Ensure the roller is fully inserted and locked in place.

\*For MIG160i/ Mig185i - Manually turn the drive roller to access the set screw.



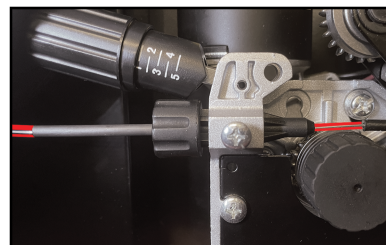
## WIRE REMOVAL

Cut the beaded tip of the welding wire at the torch nozzle.  
Release the wire tensioner inside the machine.  
Carefully return the wire back onto the wire spool.  
Remove the spool holder cap to remove the spool.



## WIRE INSTALLATION

Insert New wire once all other steps are complete.  
Lock the wire spool onto the spool holder with the spool cap.  
Straighten the first 6" of the wire and remove the torch tip  
Push the wire through the wire guide and into the torch  
Close the drive roller tension arm (standard tension is 2)  
Pull the torch trigger to feed the wire, then replace the tip



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