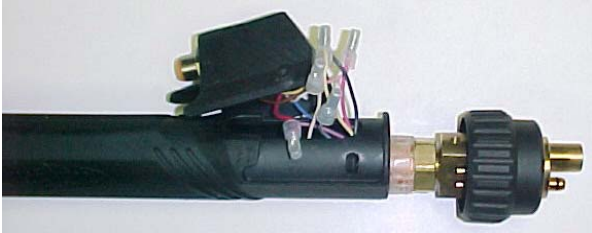




Euro Repair Guide For AC Robotic

Unicable repair kit part# 513-7

1. Remove the liner from the gun
2. Remove screws from base of terminal housing



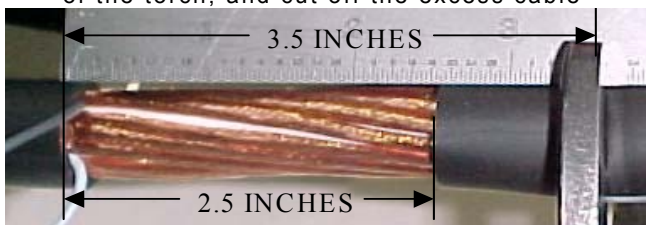
3. Remove terminal housing, move handle back
4. Disconnect cable leads from euro butt connectors
5. Move euro hand nut and spacer out of way (be careful not to strip lead wires)
6. Place euro body in vice



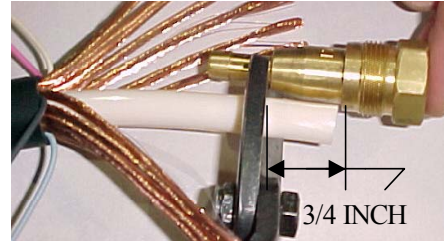
7. Bend unicable behind connector cone, cut unicable at bend
8. Remove old euro hand nut, spacer and handle
9. Add new euro spring, rear handle nut and front hand nut onto cable
10. Slide two large "oetiker" clamps 1.5ft down the unicable (required for crimping later)
11. From your cut, (end of cable) measure 4" back, and cut away the outer jacket of the cable. ****Be careful not to cut the copper wiring or switch leads****



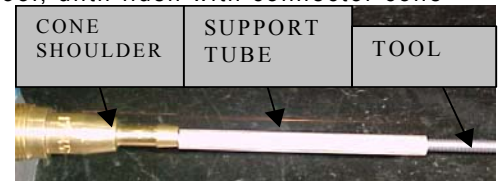
12. Slide outer jacket toward cut to expose the copper wiring and leads
13. Pull out the lead wires
14. From the 4" cut, measure 3 1/2 towards the front of the torch, and cut off the excess cable



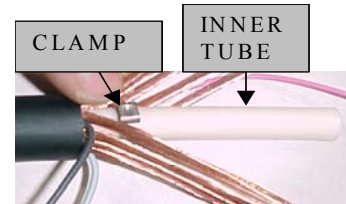
15. Fan back copper, and remove 3/4" of the inner gas tube



16. Place unicable repair tool in vice
17. Place connector cone on unicable repair tool
18. Slide the support tube over unicable repair tool, until flush with connector cone



19. Slide small oetiker clamp over top of inner gas tube (Hytrell).

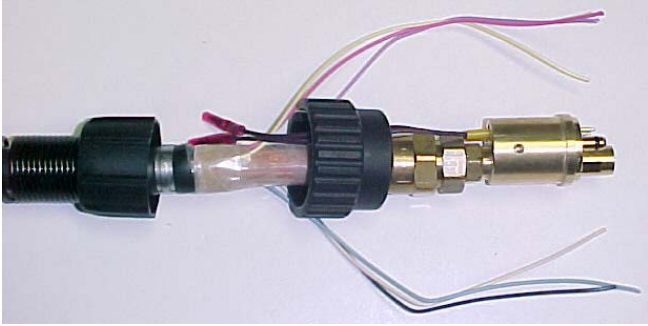


20. Using unicable repair tool as a guide, slide the inner gas tube over the support tube and up to the cone shoulder
21. Crimp the support tube clamp. Crimp between the black and white switch leads.
22. Position copper wires between roll marked numbers on cone and first step before threads. Crimp the large oetiker clamps 1/4" and 1" behind the outer jacket at the front of the torch
23. Remove the inner gas tube (Hytrell) from the cone.
24. Fan out the copper and bring the copper around the inner gas tube (Hytrell) evenly, and slide the Cone Nut over the copper.

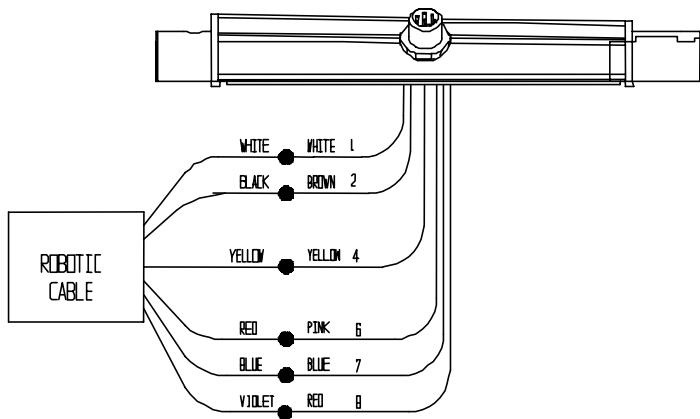


25. Slide the inner gas tube on the Cone up to the shoulder

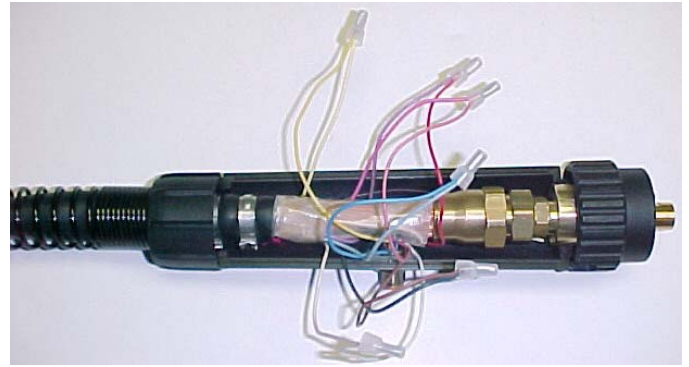
26. Fan the copper evenly around the inner gas tube, up to the shoulder of the Cone Connector. Thread on the Cone Nut onto Connector Cone. Torque the Cone Nut to 30ft lbs
27. Using 3/4" Teflon electrical tape, wrap up the copper and spare switch leads (Green, Gray) neatly.
28. Place cone and cone nut connection in vice and thread on euro body.



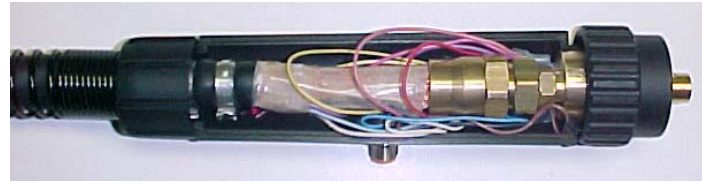
29. Move euro hand nut onto euro body (be sure not to strip lead wires)
30. Strip leads about 1/8" back and crimp appropriate wires together using butt connectors (part# 510-200-3-2).



31. Place one side of handle against inner wall of hand nut



32. Insert spring into spring groove at the rear of the handle and tuck connected switch leads into handle.



33. Place second piece of handle flush against first piece
34. Slide rear handle nut onto handle pieces, turning clockwise until locked
35. Turn handle assembly until drilled holes align with those of euro body
36. Insert screws provided



37. Insert liner (check liner length *refer to liner installation guide)