



M077-A TECHNICAL GUIDE ADDENDUM Gooseneck Replacement on TOUGH GUN™ Tandem Robotic MIG Gun

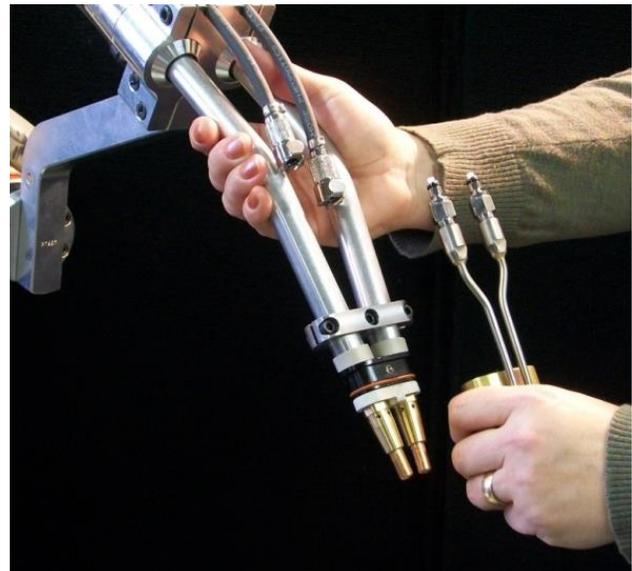
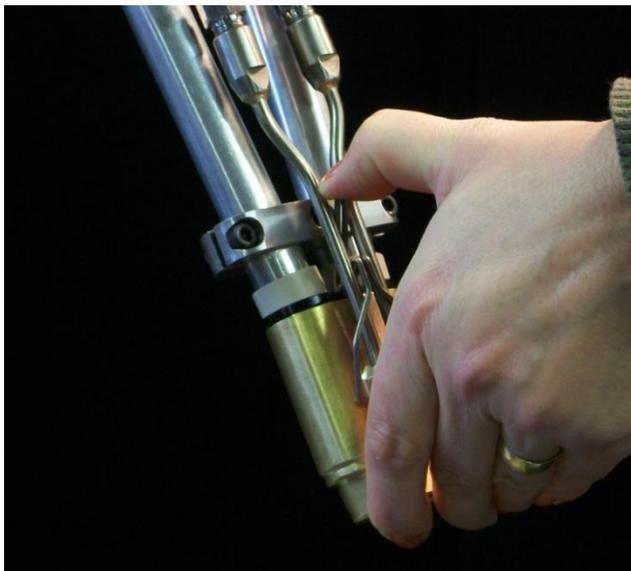
STEP 1: Disconnect Nozzle

1. Before nozzle removal ensure water supply is turned off.
2. Disconnect nozzle water lines from quick connect couplers.



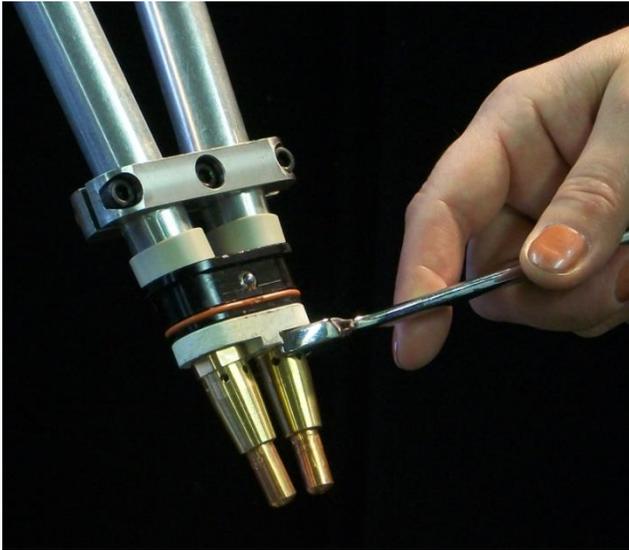
STEP 2: Remove Nozzle

1. Flip nozzle clasp
2. Slide off nozzle



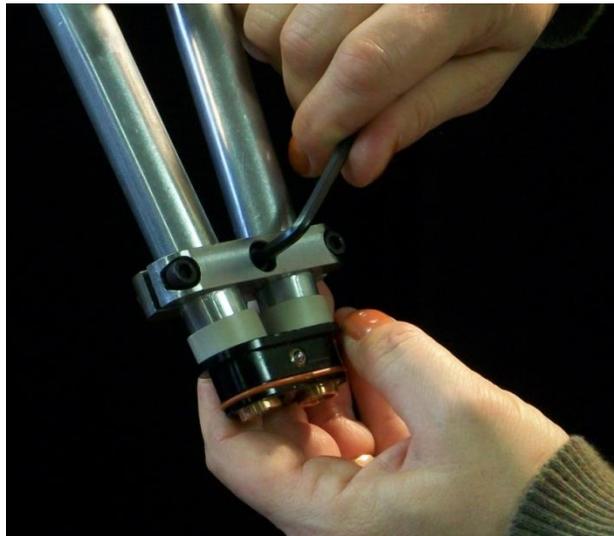
STEP 3: Remove Gas Diffusers And Nozzle Retainer Insulator

1. Remove first gas diffuser using 9/16"(14 mm) wrench
2. Hold nozzle retainer insulator in place when removing second gas diffuser



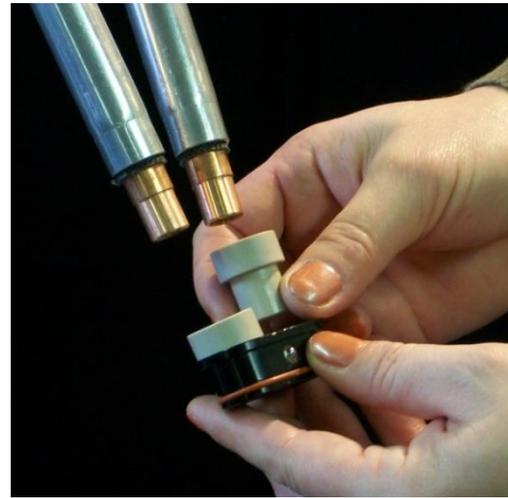
STEP 4: Remove Gooseneck Clamp

1. Remove two outside screws before removing center screw.



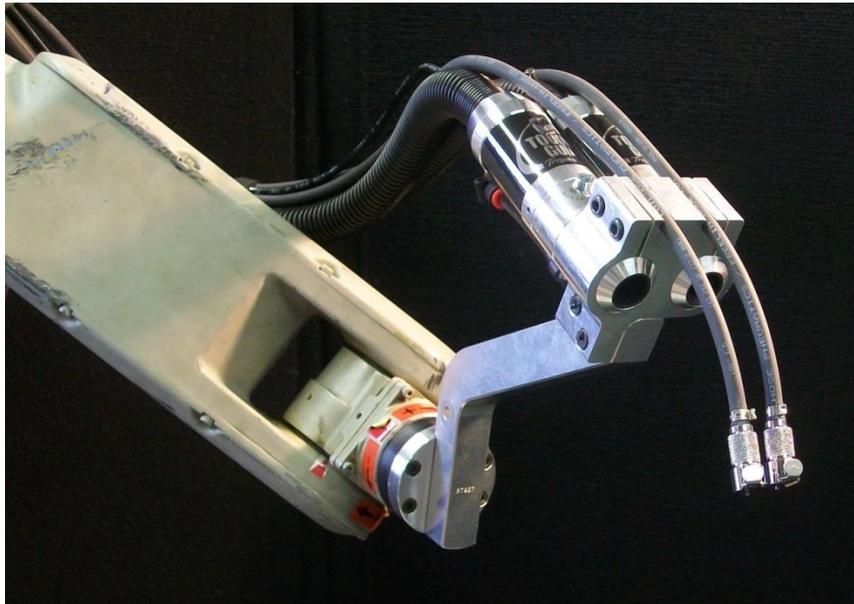
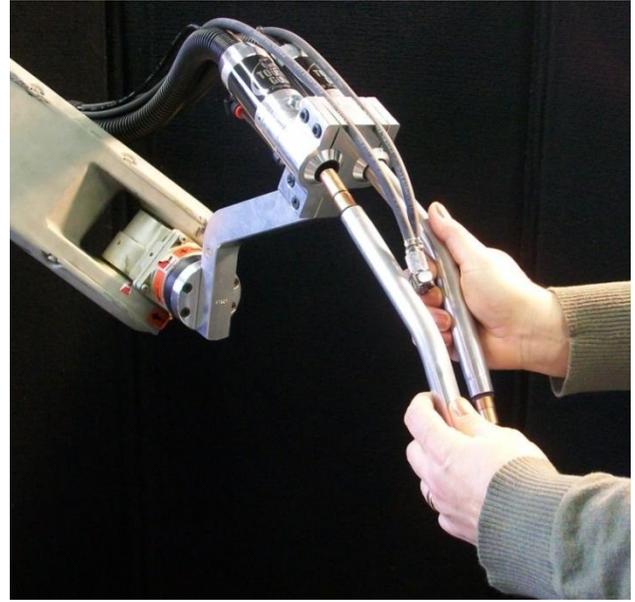
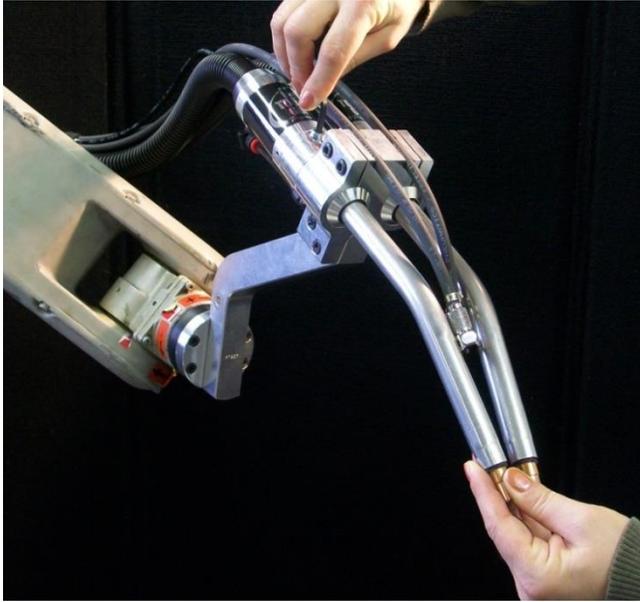
STEP 5: Remove Nozzle Retainer And Gooseneck Insulators

1. Loosen gooseneck locking screws by $\frac{1}{4}$ turn
2. Slide off gooseneck insulators and nozzle retainer



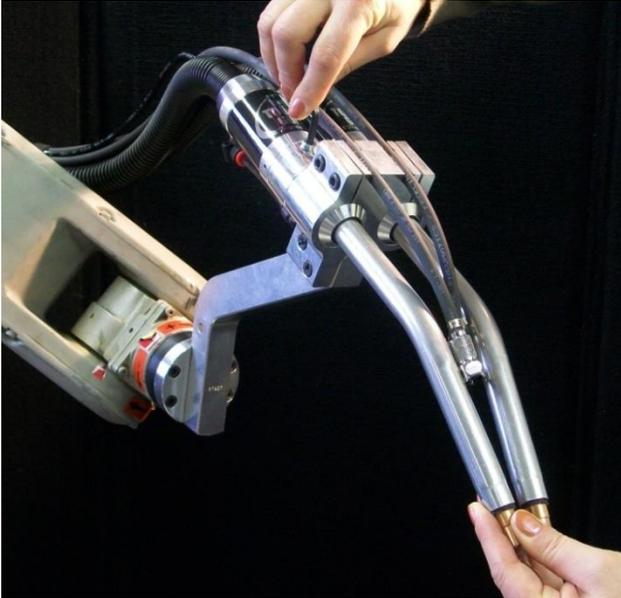
STEP 6: Remove Goosenecks

1. Using 5 mm Allen wrench, loosen M6 screw 1/2 turn to remove neck
2. Pull gooseneck directly out of gun housing
3. Repeat steps for second gooseneck



STEP 7: Install Goosenecks, Neck Insulators & Nozzle Retainer

1. Insert replacement gooseneck into gun housing. Ensure key on gooseneck aligns with key way
NOTE: Make sure marks on goosenecks completely disappear within gun housing (see orange arrow and text box below).
2. Tighten set screw (max. 60 in-lb. or 7 Nm)
3. Install gooseneck insulators and nozzle retainer

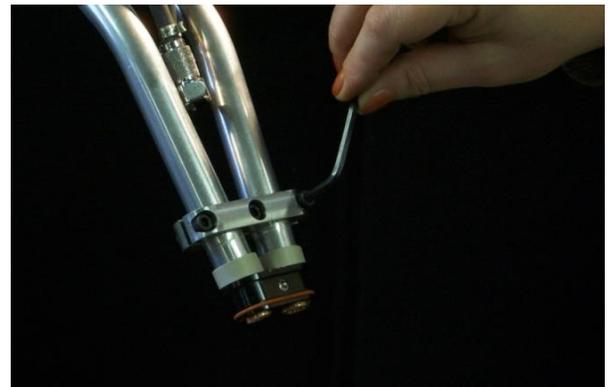
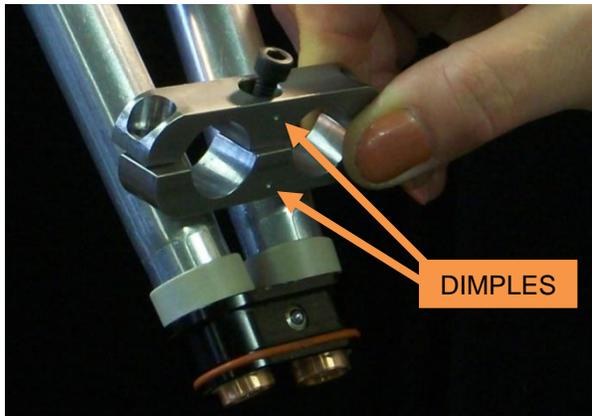


THIS LINE SHOULD COMPLETELY DISAPPEAR WITHIN THE GUN HOUSING WHEN THE GOOSENECK IS FULLY INSERTED.



STEP 8: Install Gooseneck Clamps

1. First make sure the dimples on clamp are orientated toward front of neck.
2. Place the clamps on goosenecks.
3. First tighten middle screw and then left and right screws.



Step 9: Install Nozzle Retainer Insulator and Gas Diffusers

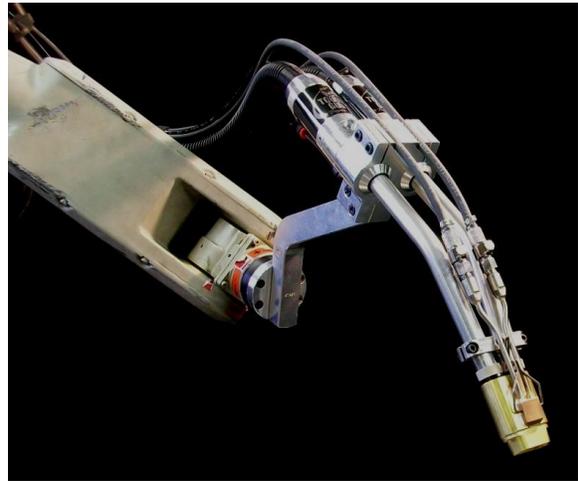
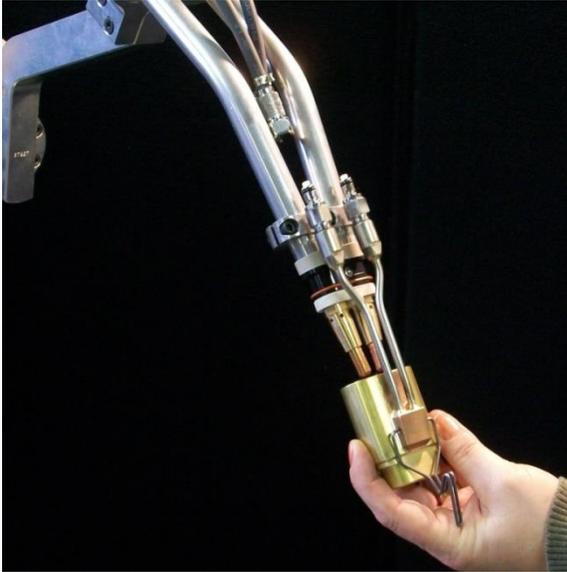
NOTE: Ensure that QUICK LOAD™ Liners are installed before proceeding with this step (see QUICK LOAD Liner Replacement section in M077 Technical Guide).

1. Slide nozzle retainer insulator in place. Hold while threading gas diffusers in place. Tighten securely.



STEP 10: Install Nozzle

1. Slide nozzle in place
2. Lock nozzle with the clasp
3. Reconnect water lines to quick connect couplers



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Canada & U.S.A. Phone: 1-877-737-3111
Fax: 1-877-737-2111

International Phone: +1-519-737-3000
Fax: +1-519-737-2111

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