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TIGWARE AC Units



Aussie Innovation

Product Information Sheet

TIGWARE AC-250 #6 Ceramic TIG Units are made in Melbourne Australia
Size #6

AC/DC Application.

Colour: White

Material: High Density 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 Aluminium Adapters, threads and seals directly to the Torch Head by way of a Mechanical Seal.

Welding Parameters: AC/DC Use Product

Tungsten $\varnothing = 2.4\text{mm}$ (3/32") or Greater

Stick Out: **2mm**. (Greater Stick Out can be Achieved with Higher Gas Flow)

MAX 250 amps rated **Non Continuous**

For #17/18/26 Style Torch Heads use TIGWARE's 17GL332 Gas Lens Adapter

TIGWARE recommends a 10 second POST-Flow

The Ceramic Unit Remains in Position with a Single Titanium Clip

When threading the unit onto the torch head apply lateral force to assist removal

This will help remove and install the AC unit from the torch head.

GAS Flow Rate

Size: #6 12 CFH / 6 > L / Min Variable

TIGWARE AC-250 #6 Unit use and Installation.

It's very important to **REMOVE** the original Torch Teflon Insulator before installing TIGWARE's Aluminium ADAPTER. Always **EXCHANGE** the Original Teflon Insulator from the Torch head and install TIGWARE's Teflon Double Adapter so it's **FIRMLY** in contact with the Torch head. This allows for **FULL Thread Mating** of the Adapter and for Electrical Isolation. 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 #9/20 & #17/18/26 Series Torch Heads

For # 17/18/26 Torches
Use TIGWARE's 17GL332
Gas Lens Adapter

For #9/20 Torches
Use the original 45V44
Gas Lens Adapter

Install TIGWARE's Teflon Double
Insulator

AC-250 #6 Nozzle Double Insulator



Remove the original Insulator & Install TIGWARE's Teflon Insulator

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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