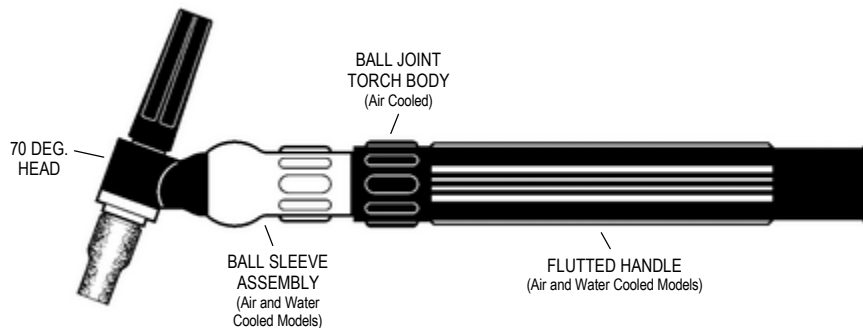


# *i* - HEAD INSTRUCTION SHEET

TEC Torch's new i-head interchangeable head TIG torches are the newest and most innovative tools for TIG welding on the market today. Please take a few moments to review these instructions and familiarize yourself with these unique welding torches before you put them into service.

## **CAUTION**

*Read your welding machine operation manual. Electricity can injure or kill. Turn off your machine before installing or changing TIG torches or making adjustments to the torch that exposes electrically conductive parts of the torch.*



## **BALL JOINT – LOCKING HEAD MODELS (WTB)**

### **Lock-up of head position**

Locking the head in the desired position requires only a slight twist of the torch body/handle in a clockwise rotation. Set the head in the desired position and by holding the torch head in the palm of your hand and the ribs of the orange bulb section with your thumb and forefinger twist the black rubber torch body/handle clockwise firmly. A slight twist in the opposite direction will unlock the head.

**BEFORE CHANGE HEAD STYLES, LOCK-UP THE TORCH HEAD.**

### **Changing heads**

Each WTB ball joint torch package includes a 70° angle head (installed by factory on the torch body). There are optional heads including; a 90° head, a pencil style 180° head and a flat 50° head.

### **IMPORTANT:**

The head must be screwed onto the ball stem and seated snugly using the 3/8" side of the wrench provided. **DO NOT OVERTIGHTEN.** If the head is not seated snugly it will turn even if the ball stem is locked in place. Arcing could take place in the thread area if the torch is operated with the head loose.

### **Exposing head – ball stem connection**

The threaded head connection and wrench flats on the ball stem can be exposed by pulling back the orange rubber bulb sleeve where it meets the black rubber torch head. Again, it's much easier to do if the head is locked firmly. Pull back the orange rubber sleeve at the bulb end towards the handle. As it bunches up you will see the wrench flats on the copper ball stem. Place the 3/8" side of the wrench on the flats and while holding the wrench firmly unscrew the torch head by turning the head in a counter clockwise rotation. Do not turn the wrench; use the wrench only to hold the copper ball stem. The connection should only be snug, not tight. The head should unscrew easily. If the head and ball stem start to turn lock-up the ball joint again and then unscrew the head.

### **Head note**

Only the angle heads are snugly attached using the wrench. The 180° pencil head is left loose so it can rotate. It's used to push the back of the collet to grip the tungsten electrode. When the pencil head is tightened and pushing the collet the threaded connection will be snug and eliminate any possible arcing across the threads of the ball stem. Simply screw the pencil head onto the ball stem until it stops. Do not tighten with the wrench. Note: the pencil heads use only short lengths of tungsten electrodes so as not to inhibit the swivel of the ball joint (920P = 3" max., 1718P = 3 3/4" max.).

### **Replacing rubber sleeve onto head**

LOCK-UP THE HEAD BEFORE STARTING THIS PROCEDURE. Pinch the bulb end edge of the orange sleeve with your thumb and forefinger until it puckers up. Push the puckered edge section up and over the lip on the edge of the black rubber head. Hold it in place with your thumb while you roll the edge with your finger around the head. Repeat several times as you work around the head. Using your fingers to pinch and work the sleeve into the head groove. It's similar to installing a bicycle tire on a rim. Note, the orange sleeve edge is not to be rolled over onto the head groove. It is important that the orange sleeve be completely rolled into the head groove. The orange bulb may collapse or flatten, this is normal and will resume its bulb shape when the swivel head is unlocked.

The proper insertion of the bulb lip into the head groove creates an electrical and gas seal and must be completed properly. It may take several tries to get it into place. Once you feel you have the edge of the orange sleeve rolled into the head groove, unlock the head and swivel it around to check the seal.