

Bernard® Technical Insert

How to Install AccuLock™ S Series Liner Using Power Pin Cap with Set Screw

STEP 1:

A. Remove the nozzle.



B. Loosen the gas diffuser.



C. Remove the gas diffuser.



D. Loosen the set screw in the power pin cap and remove the cap from the rear of the gun.



STEP 2:

A. Remove the old liner.



B. Replace the new liner through the neck.



C. With the gun laying straight, push the liner through until the brass liner lock bottoms on the neck.



How to Install AccuLock™ S Series Liners with Set Screw (Continued)

STEP 3

A. To lock and center the liner, reinstall and tighten the gas diffuser.



B. Reinstall the nozzle.



C. Place the power pin cap over the liner and thread onto power pin.



D. Tighten the cap snug against the power pin shoulder with welding pliers or appropriate wrench.



E. Holding the hex wrench as shown, tighten the set screw "finger tight" against the liner.



F. Next, hold the hex wrench by the handle and tighten the set screw an additional one-half turn to fully secure the liner.



STEP 4

A. Trim the liner flush with the power pin.



B. Insert a piece of welding wire into the liner to check for burrs or obstructions. If needed, loosen screw slightly until wire slides freely.

