
3 Installation and start-up

3.1 Description

The wire cutter is an add-on module for the TC 96 torch cleaner. The tool tip is connected mechanically to the clamping cylinder of the torch cleaner and does not need any additional control elements.

You can also retrofit the wire cutter to your torch cleaner.

With this add-on device you can cut the welding wire electrode to the length you require.

You can improve the ignition behaviour and the serviceability of your welding unit by :

- cutting off bent or an excessively long wire
- cutting off the wire end each time before torch cleaning and prior to every TCP measurement
- cutting off the slag formation on the end of the wire.

3.2 Retrofitment of the 'wire cutter'

3.2.1 Preparations for alteration



Before you start the alteration :

1. Make sure that the air supply and power supply have been disconnected.
2. Clean the torch cleaner.

3.2.2 Removing the cylinder cover

Before you can fit the wire cutter you must remove the cylinder cover :

1. Unscrew the **connection nut** of the right-angle plug (33) to the initiator (miniature sensor) and pull out the right-angle plug.
2. Unscrew the **elbow** (73) of the pneumatic connection.
3. Unscrew the **4 cheese-head bolts** M6x90 (25) in the cylinder cover.

Installation and start-up

4. The cylinder tube (17) is only retained by the friction of the o-ring seals. For this reason keep a grip on the cylinder tube of the clamping cylinder as you carefully unscrew and pull away the **cylinder cover** (21) together with the o-ring and the initiator from the cylinder tube without separating the cylinder tube from the torch cleaner unit!
5. Remove the **damping washer** (22).
6. Pull out the piston rod (19) together with the piston (18) and the gasket (27).
7. With the piston rod removed you will be able to unscrew the **hexagonal bolt** M6x16 (23) together with the **washer** (24) from the piston rod.

Parts (21), (23), (24) and (25) are not required for fitting the wire cutter.

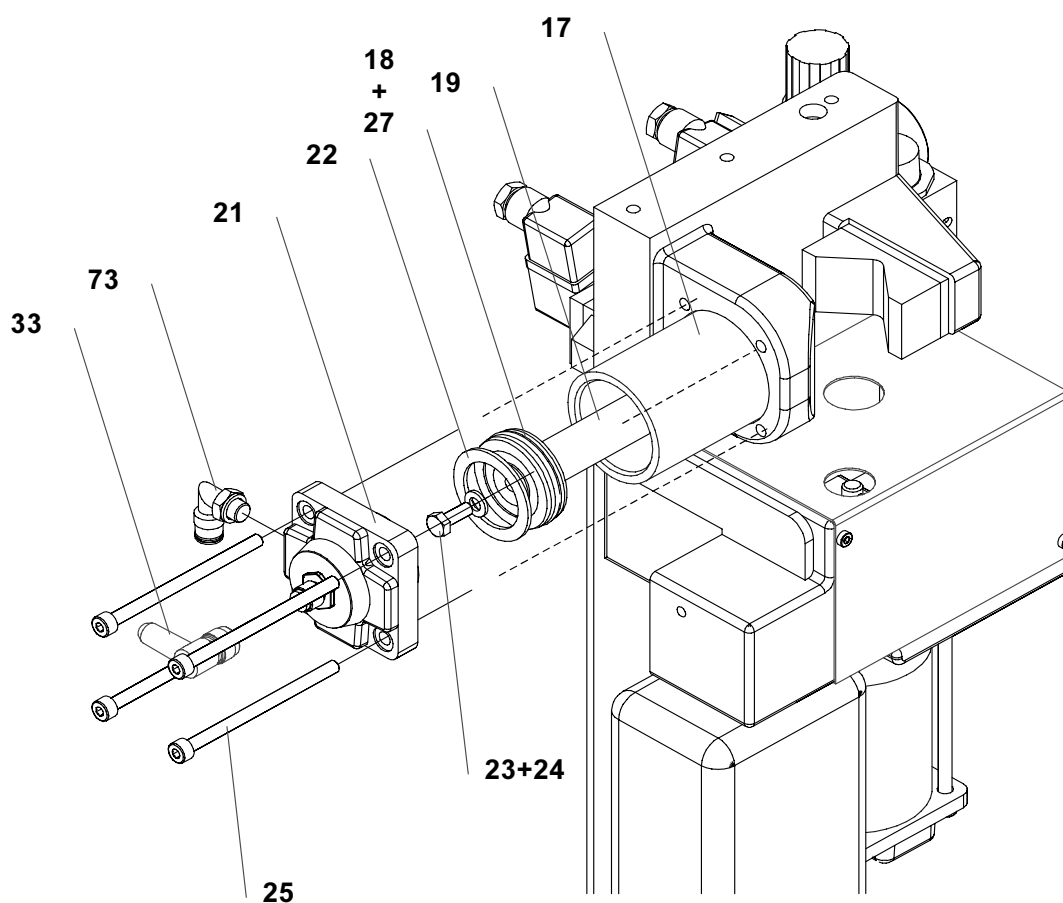


Figure 1. Removal of the cylinder cover.