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Product Information Sheet



Aussie Made



All TIGWARE PTFE Units are made here in Melbourne Australia

Sizes #10 - #12 - #14 - #16 - #20 - #32 (Other Sizes can be Manufactured to Order

Contact John) However the Triple Diffuser System Compensates for Intermediary Cup sizes

DC Application.

Avoid Direct contact with HOT Surfaces.

Follow Freehand Welding Technique

Colour: White

Material: PTFE

Use with Gas Lens Adapter 17GL332 (Available from TIGWARE) for

#17/#18/#26 Type Torches and or 45V44 Gas Lens for #9/#20 Type Torches. TIGWARE's TEFLON Units thread and seal directly to the Torch Head, No O-rings just a Mechanical Seal.

Welding Parameters:

DC Use Product

- 2.4mm Tungsten (3/32")
- Stick Out: **25mm.** (Greater Stick Out can be Achieved with Higher Gas Flow)
- 150 amps or Greater Increase Gas Flow as Needed
- Gas Diffuser = TIGWARE's Triple Diffuser System.

For best performance I recommend a greater than normal Tungsten Stick-out with Standard GAS Flow Rates listed below for optimal Product Endurance.

Note: Grind Each end of the TUNGSTEN Rod to a point and remove the Painted section as the Diffuser System is designed to have a Sliding Fit.

Any remaining paint will interfere with the Diffusers during TUNGSTEN insertion and or Removal.

I recommend a TWISTING Action when Inserting and or Removing the TUNGSTEN Rod

Size: #10	20 CFH / 10 > L / Min
Size: #12	24 CFH / 11 > L / Min
Size: #14	28 CFH / 14 > L / Min
Size: #16	32 CFH / 15 > L / Min
Size: #20	40 CFH / 19 > L / Min
Size: #32	64 CFH / 30 > L / Min

Diffuser Damage.

Should the primary Mesh Unit become damaged. Simply swap the First and Second diffusers. This will not affect the Gas flow performance.

Diffusers can be purchased via the TIGWARE website.

Recommended Minimum Extended Stick out Dimensions

#10 Unit = 25mm to 35mm
#12 Unit = 25mm to 35mm
#16 Unit = 25mm to 35mm
#20 Unit = 25mm to 40mm
#32 Unit = 25mm to 40mm

PTO

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Enjoy you're new product and please let me know if you have any problems.

Regards John +61 (0) 448527996 / info@tigware.com.au

**All TEFLON Units are HAND made in
Melbourne Australia
by TIGWARE.
Support the Little Guy and
Buy Australian**



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