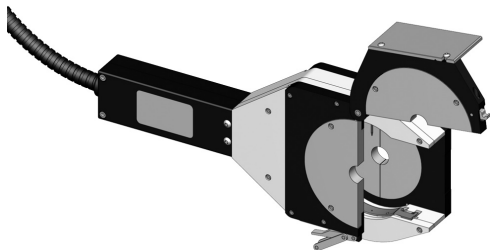


# 40H Series Weld Head Electrode Extension Installation Instructions

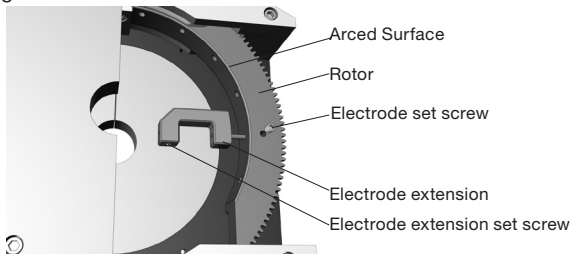


## **⚠ CAUTION**

Do not jog or move the rotor if the electrode is not clamped in place.

### **To install electrode extension:**

1. Jog the **rotor** 90° from the home position.
2. Loosen the **electrode set screw** from rotor.
3. Insert **electrode extension** so the **electrode extension set screw** is accessible through the rotor opening.



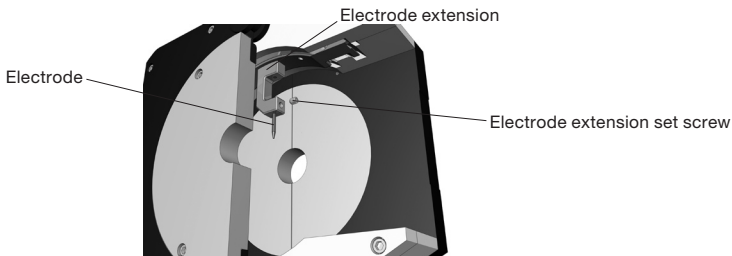
4. Align extension bottom arced surface with inside arced surface of rotor.
5. Tighten **electrode set screw**.
6. Press **HOME** on the operator front panel to return the rotor to its home position.

## **⚠ CAUTION**

Do not jog or move the rotor if the electrode extension is not clamped in place.

## To install electrode into electrode extension:

1. Loosen **electrode extension set screw**.
2. Insert **electrode** into hole at the end of the **electrode extension**.



Electrode is at default arc gap when back of electrode is even with electrode hole opening in extension.

Note: For higher arc gap accuracy, use gap gauges to improve positioning of electrode.



3. Tighten the **electrode extension set screw**.

