

Without vacuum

with vacuum

## Ø Manifold for welding torch and welding robot

**Type:** Welding torch or welding robot

**Applications:** Welding

**Suction requirement:** 200m<sup>3</sup>/h

**Vacuum hose:** ø 32-38mm

**Attachment kit Art. No:** 40403330

**Parts in attachment kit:** 40307860 Manifold  
 40912570 Screw PTKA40x12 (1442) 2pcs  
 40912580 Screw PTKA40x20 fzb (1442) 2pcs  
 40278300 Adapter universal without holes  
 xxxxxxxx 40160740 Hose H-50 length 0,1m  
 40151020 F40-50P hose coupler

**Accessories:**

**Hose kit Art. No:** 40273250 hose 32mm length 1,8m  
 40273260 hose 38mm length 1,8m

## Torch Attachment

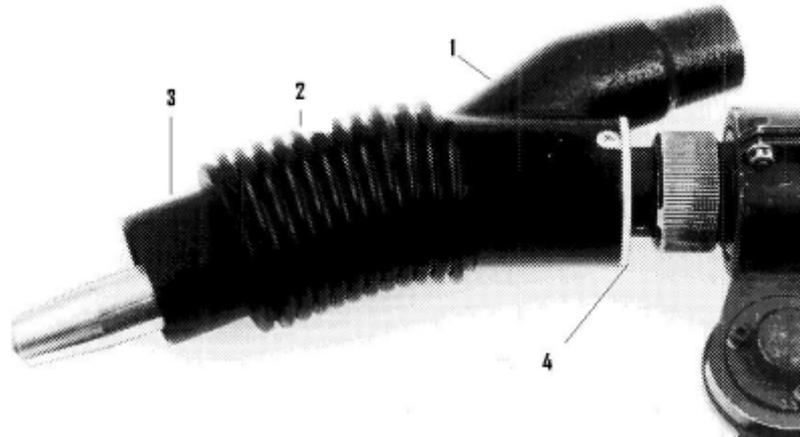


Figure 1

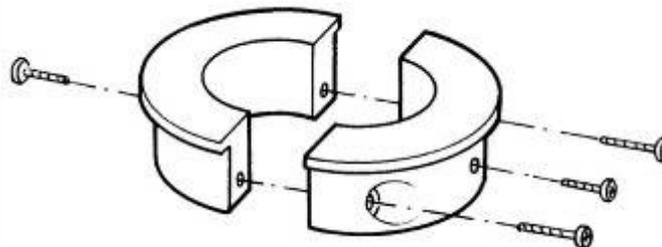


Figure 2

### Mounting instruction torch attachment kit

## Mounting

Figure 1 show the kit fitted to a torch. The diameter of the torch neck is different from torch to torch.

Therefore, the retainer centre hole has not been machined in advance, but has to be machined individually to fit the torch.

For certain torches it is necessary to

Fit the retainer to the torch neck at another angle than 90 degrees.

Before drilling the centre hole, determine where on the neck to fit the retainer. Note that the plastic hose and the plastic nozzle can be trimmed in length. Measure the diameter of the neck and determine if the hole can be drilled at 90 degrees angle or if another angle is desired.

Drill to same diameter as the neck diameter. Then saw the retainer in two halves along the slot as per figure 2.

Fasten the two halves to the neck using two 20 mm screws.

Fit the manifold to the retainer and secure with two 12 mm screws.

Fit the hose and the nozzle and trim if necessary.

Vacuum hose  $\varnothing$  32 mm fits directly to the manifold.  $\varnothing$  38 mm hose can be fitted after trimming off the  $\varnothing$  32 mm stud.

If necessary, fit a valve to the vacuum hose to regulate the air flow.