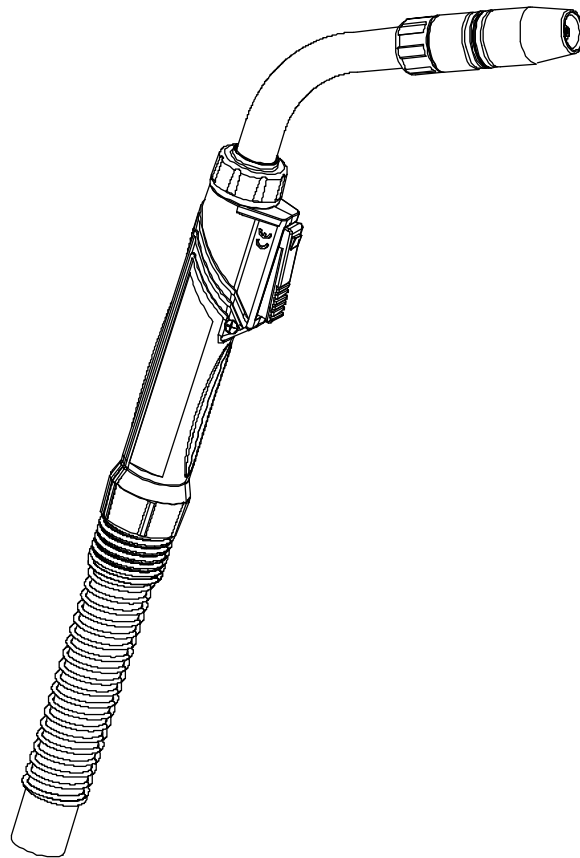




# SPEC SHEET

For 400 amp  
**T-Gun™ Semi-Automatic Compact  
Series Water-Cooled MIG Guns**



## AMPERAGE RATINGS

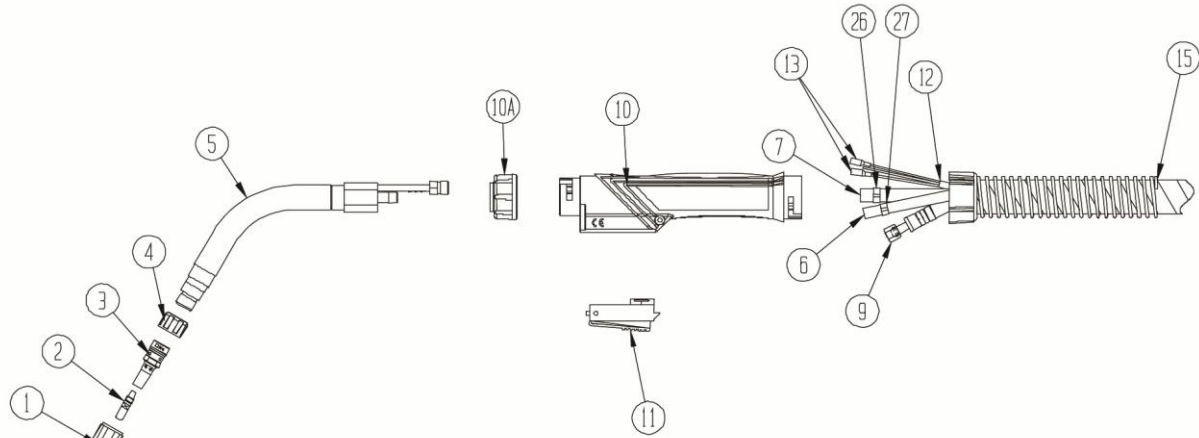
GUN MODEL	60% DUTY CYCLE - MIXED GASES OR 100% DUTY CYCLE - CO <sub>2</sub>
400 amp	425 amp

NOTE: Ratings are based on tests that comply with IEC 60974-4 standards.

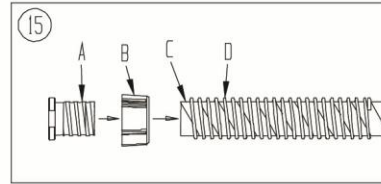
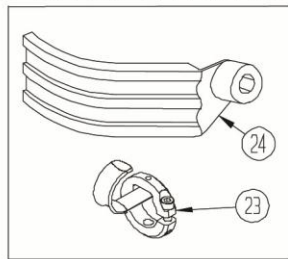
## STANDARD PARTS

GUN MODEL	NECK	NOZZLE	RETAINING HEAD	NECK INSULATOR	CONTACT TIPS
400 amp	455-60	401-6-62	404-20	402-7	403-20-xx

# EXPLODED VIEW AND PARTS LIST



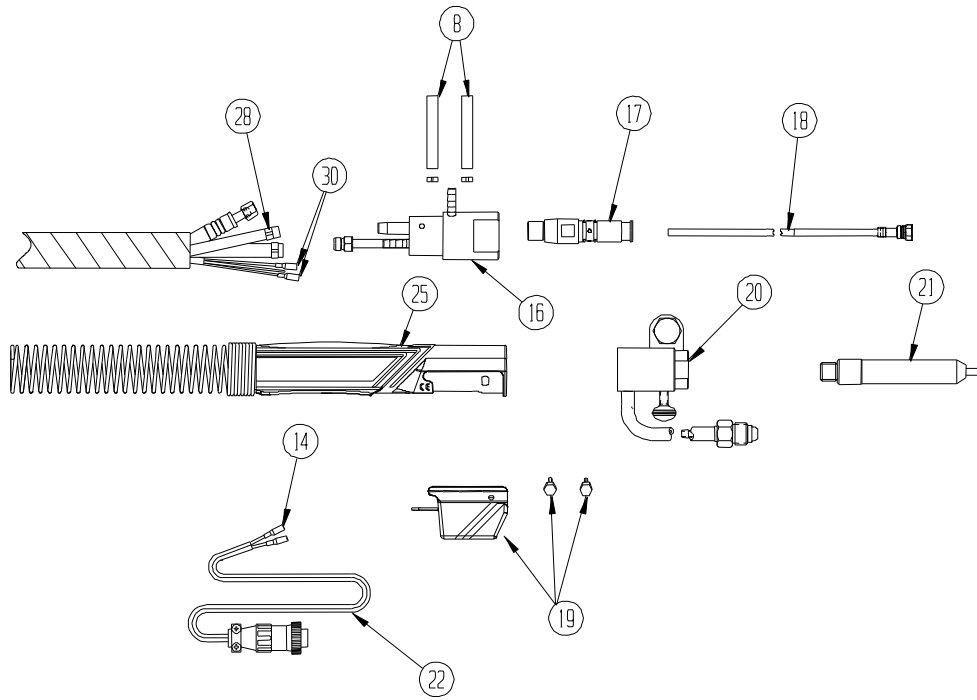
## OPTIONAL ACCESSORIES



Numbers in this column correspond to the exploded view images above.

ITEM	PART #	DESCRIPTION	
1	401-40-38	<b>STANDARD NOZZLES (SELF-INSULATED)</b>	
	401-4-38	SUPER TAPERED NOZZLE - 3/8" BORE (BRASS)	
	401-4-50	3/8" (10 mm) BORE - FLUSH TIP	
	401-4-62	1/2" (13 mm) BORE - 1/8" (3 mm) TIP RECESS	
	401-4-75	5/8" (16 mm) BORE - 1/8" (3 mm) TIP RECESS	
	401-8-62	3/4" (19 mm) BORE - 1/8" (3 mm) TIP RECESS	
	SHORT ARC NOZZLE	401-8-62	5/8" (16 mm) BORE - 1/8" (3 mm) TIP STICKOUT
		401-5-62	<b>HEAVY DUTY NOZZLES (SELF-INSULATED)</b>
		401-5-62	5/8" (16 mm) BORE - 1/4" (6 mm) TIP RECESS
		401-5-75	3/4" (19 mm) BORE - 1/4" (6 mm) TIP RECESS
		401-6-50	1/2" (13 mm) BORE - 1/8" (3 mm) TIP RECESS
		401-6-62	5/8" (16 mm) BORE - 1/8" (3 mm) TIP RECESS
		401-6-75	3/4" (19 mm) BORE - 1/8" (3 mm) TIP RECESS
	401-7-62	5/8" (16 mm) BORE - 1/4" (6 mm) TIP RECESS (BRASS)	
401-7-87	7/8" (22 mm) BORE - 1/4" (6 mm) TIP RECESS (BRASS)		
2		<b>HEAVY DUTY TREGASKISS™ TOUGH LOCK™ CONTACT TIPS - 5/16" (7.9 mm) O.D.</b>	
	403-20-30	FOR .030" (0.8 mm) WIRE	
	403-20-35	FOR .035" (0.9 mm) WIRE	
	403-20-1.0	FOR 1 mm WIRE	
	403-20-45	FOR .045" (1.2 mm) WIRE	
	403-20-364	FOR 3/64" (1.2 mm) WIRE	
	403-20-1.4	FOR 1.4 mm WIRE	
	403-20-52	FOR .052" (1.3 mm) WIRE	
	403-20-116	FOR 1/16" (1.6 mm) WIRE	
	403-20-564	FOR 5/64" (2.0 mm) WIRE	
	403-20-332	FOR 3/32" (2.4 mm) WIRE	
		<b>HEAVY DUTY TAPERED TREGASKISS TOUGH LOCK CONTACT TIP - 5/16" (7.9 mm) O.D.</b>	
	403-21-30	FOR .030" (0.8 mm) WIRE	
	403-21-35	FOR .035" (0.9 mm) WIRE	
	403-21-1.0	FOR 1 mm WIRE	
	403-21-45	FOR .045" (1.2 mm) WIRE	

ITEM	PART #	DESCRIPTION
3	404-20	TREGASKISS TOUGH LOCK RETAINING HEAD - FOR HD TIPS
	454-1-2	RETAINING RING
	402-6	O-RING
4	402-7	NECK INSULATOR
5		NECKS (INCL. C/W (1) 357-2 AND (1) 413-5 CLAMP)
	445-45	NECK - 45°
	445-60	NECK - 60°
6	656-15	INTERNAL WATER LINE (INCL. C/W (1) 357-2 CLAMP FOR FRONT & (1) 656-1 CLAMP FOR REAR) 15' SERVICE (CUT FOR OTHER LENGTHS)
7	657-15	CONDUIT (INCL. C/W (2) 657-1 CLAMPS) 15' SERVICE (CUT FOR OTHER LENGTHS)
8	658	RED WATER LINE - OUT (C/W (1) 656-1 CLAMP)
	658-1	BLUE WATER LINE - IN (C/W(1) 656-1 CLAMP) (LOCATED AT QUICK CONNECT POWER BLOCK ASSEMBLY)
9		POWER CABLE ASSEMBLY
	659-10	10' SERVICE (ACTUAL LENGTH - 9.5')
	659-12	12' SERVICE (ACTUAL LENGTH - 11.5')
	659-15	15' SERVICE (ACTUAL LENGTH - 14.5')
10	320	HANDLE - FRONT
10A	320-2	HANDLE LOCK NUT (FOR FRONT)
11	211-5	SWITCH ASSEMBLY
	211-5-8	SWITCH WITH EXTENDED LEVER
12		CONTROL WIRE
	662-10	10' SERVICE
	662-15	12' SERVICE
	662-15	15' SERVICE



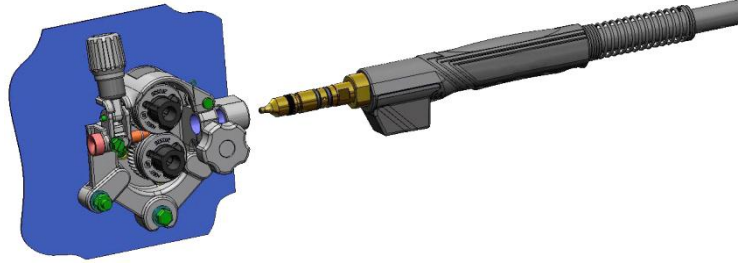
PART #	DESCRIPTION
13	412-8 SWITCH LEAD CONNECTOR
15	642-XX OUTER JACKET ASSEMBLY
15A	320-5 JACKET BUSHING
15B	320-4 REAR HANDLE CAP
15C	663-1-XX OUTER JACKET
15D	663-1 STRAIN RELIEF
16	664-400 POWER PIN BLOCK
17	214 TWECO®
	214-2 LINCOLN®
	214-6-116 MILLER®
	214-12 TWECO #5
	214-13 PANASONIC®
	414-1 O-RING FOR TWECO
	414-2 LINER SET SCREW
	414-11-2 O-RING FOR MILLER POWER PIN
	214-6-9 MILLER (FOR ALUMINUM)
18	<b>CONVENTIONAL LINERS</b>
	415-23-15 FOR .023" (0.6 mm) WIRE - 15' (5 m)
	415-30-15 FOR .030" (0.8 mm) WIRE - 15' (5 m)
	415-35-10 FOR .035" - .045" (0.9 mm - 1.2 mm) WIRE - 10' (3 m)
	415-35-15 FOR .035" - .045" (0.9 mm - 1.2 mm) WIRE - 15' (5 m)
	415-35-25 FOR .035" - .045" (0.9 mm - 1.2 mm) WIRE - 25' (8 m)
	415-35-2 FOR .035" (0.9 mm) ALUMINUM WIRE - 15' (5 m)
	415-116-10 FOR .045" - 1/16" (1.2 mm - 1.6 mm) WIRE - 10' (3 m)
	415-116-15 FOR .045" - 1/16" (1.2 mm - 1.6 mm) WIRE - 15' (5 m)
	415-116-25 FOR .045" - 1/16" (1.2 mm - 1.6 mm) WIRE - 25' (8 m)
	415-116-2 FOR 3/64" - 1/16" (1.2 mm - 1.6 mm) ALUM. WIRE - 15' (5 m)
	415-332-15 FOR 5/64" - 3/32" (2.0 mm - 2.4 mm) WIRE - 15' (5 m) FLAT WOUND
	415-332-153 FOR 5/64" - 3/32" (2.0 mm - 2.4 mm) WIRE - 15' (5 m) ROUND WOUND
	415-332-251 FOR 5/64" - 3/32" (2.0 mm - 2.4 mm) WIRE - 15' (5 m) ROUND WOUND
	415-332-25 FOR 5/64" - 3/32" (2.0 mm - 2.4 mm) WIRE - 25' (8 m) FLAT WOUND
	415-564-15 FOR ALL 5/64" (2.0 mm) WIRE & 1/16" (1.6 mm) FLUX CORE WIRE
	415-332-15 FOR .078" - 3/32" (2.24 mm) WIRE - 15' (5 m) FLAT WOUND
	415-1M LINER O-RING
	415-25 JUMP LINER
	415-45-01 FOR .035" - 3/64" WIRE - 6'
	415-45-02 FOR .035" - 3/64" WIRE - 10'
	415-45-03 FOR .035" - 3/64" WIRE - 15'
	415-116-21 FOR 3/64" - 1/16" WIRE - 6'
	415-116-22 FOR 3/64" - 1/16" WIRE - 10'
	415-116-23 FOR 3/64" - 1/16" WIRE - 15'

PART #	DESCRIPTION
19	416-15 EURO HOUSING BLANK (C/W SCREWS)
	416-5 CONTROL HOUSING (C/W SCREWS)
	411-3M MOUNTING SCREWS (METRIC)
20	<b>FEEDER ADAPTOR REQUIREMENTS (SOLD SEPARATELY)</b>
	417 QUICK CONNECT BLOCK ASSEMBLY TWECO® #4
	417-50 QUICK CONNECT BLOCK ASSEMBLY EURO
	417-60 QUICK CONNECT BLOCK ASSEMBLY TWECO #5
21	FEEDER ADAPTORS (TO BE USED WITH QUICK CONNECT BLOCK)
22	CONTROL PLUGS (C/W PLUGS LEAD & FEMALE CONNECTORS)
	<b>OPTIONAL ACCESSORIES</b>
23	422 GUN HANGER
24	421 HEAT SHIELD
25	610 HANDLE (REAR W/STRAIN RELIEF)
	<b>REPLACEMENT CABLE BUNDLES</b>
	661-10 10 FT. CABLE BUNDLE
	661-12 12 FT. CABLE BUNDLE
	661-15 15 FT. CABLE BUNDLE
26	413-5 OETIKER CLAMP - 11.3 mm
27	357-2 OETIKER CLAMP - 8.7 mm
28	656-1 OETIKER CLAMP - 9.5 mm
30	412-1 SWITCH LEAD CONNECTOR

# INSTALLING MIG GUN INTO A FEEDER

## For most power pins

1. Insert power pin to shoulder and secure.
2. Insert control plug to control housing of gun.
3. Insert control plug into feeder.
4. Feed welding wire into power pin by hand and tighten drive rolls.
5. If using a water-cooled gun, securely clamp blue hose on rear housing to water-out on water cooler and red hose on rear housing to water-in on water cooler.



Note: On Lincoln® feeders it is necessary to connect the gas hose to the barbed fitting on the power pin.

## GENERAL SAFETY

Before installation or operation of T-Gun MIG Guns, please read the safety precautions listed below.

1. Always wear a properly fitted welding helmet with the proper grade of filter plate and suitable welding gloves.
2. All exposed skin should be covered with flame resistant, protective clothing. **DO NOT WEAR CLOTHING MADE FROM FLAMMABLE SYNTHETIC FIBERS.**
3. Protective screens or barriers should be used to protect others from spatter, flash and glare while welding.
4. Prevent fires by ensuring that hot slag or sparks do not contact combustible solids, liquids or gases.
5. Ensure that operator's head is not too close to the arc and that adequate ventilation is available.
6. Constant repetitive motion may lead to cumulative trauma disorders.
7. Do not touch live electrical parts. The following should be checked to prevent electrical shock:
  - Equipment is adequate for the job, properly grounded and installed according to code.
  - Faulty or damaged equipment is repaired or replaced.
  - Proper operator maintenance is performed to prevent excess spatter accumulation in the nozzle, or the contact tip or other areas of the gun.
  - Electrical insulating components are in place and not damaged. Repair or replace if necessary.
  - Operator and his surroundings are not wet.
  - Cables are not wrapped around operator's body.
  - Equipment is off when not in use.
8. CSA Standard W117.2 CODE FOR SAFETY IN WELDING AND CUTTING obtainable from the Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.
9. ANSI Standard Z49.1 CODE FOR SAFETY IN WELDING AND CUTTING obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018.

### CALIFORNIA PROPOSITION 65 WARNING

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer.

This product contains chemicals, including lead, known to the State of California to cause cancer, and birth defects or other reproductive harm. *Wash hands after use.*

(California Health & Safety Code Section 25249.5 at seq.)



## FOR ADDITIONAL TECHNICAL DATA:

For additional Technical Data, including installation, maintenance, neck dimensions, options, accessories and troubleshooting, please visit the Technical Support section of the Bernard website at BernardWelds.com.



### For Customer Support:

U.S.A                      800-946-2281  
International            708-946-2281  
BernardWelds.com