Bernard™ BTB MIG Guns use aluminum armored necks that withstand abuse and offer outstanding heat dissipation for longer life. Available in fixed or rotatable styles in a wide variety of lengths and bends, necks can be selected during gun configuration to optimize weld puddle access and visibility. Rotatable necks are interchangeable which allows the gun to be adapted to changing weld access needs for increased welder comfort and productivity.

Necks for BTB Guns are also designed to maximize consumables compatibility. A dual thread on the front of the neck allows installation of your choice of Centerfire™, Quik Tip™ or TOUGH LOCK™ Consumables. A common neck diameter means that the same consumables can also be used across BTB Guns of all amperages.

- Compatible with BTB MIG Guns and Centerfire, Quik Tip and TOUGH LOCK Consumables
- Wide selection of fixed or rotatable necks
- Available in multiple lengths and bends for limited access welds and improved operator comfort
- Rotatable necks changeover and rotate without tools
- Rotatable necks are easily removable for jump liner changeover

Select your neck online in the BTB MIG Gun Configurator

Choose from up to 22 necks per handle

Configure your MIG gun online

Select your neck online in the BTB MIG Gun Configurator
Rotatable Necks for B, O, T and C Series Handles

Fixed Necks for B and O Series Handles

Available through configurator

Rotatable Neck

QT2-30 30° Short

QT2-45 45° Short

QT2-60 60° Short

QT2-80 80° Short

Fixed Neck

QT3-30 30° Medium

QT3-45 45° Medium

QT3-60 60° Medium

QT3-80 80° Medium

QT5-30 30° Long

QT5-45 45° Long

QT5-60 60° Long

Fixed Necks on T and C Series Handles

Available through configurator

Fixed Neck on T Series

T Series Large Straight Handle

305-45 45° Short

305-60 60° Short

405-45 45° Medium

405-60 60° Medium

405-45LL 45° Longest

405-60LL 60° Longest
C Series Large Straight Handle

305-45CT 45° Short

305-60CT 60° Short

405-45CT 45° Medium

405-60CT 60° Medium

505-45CT 45° Long

505-60CT 60° Long

T Series Small Straight Handle

205-45 45° Short

205-60 60° Short

315-45 45° Medium

315-60 60° Medium

405-45NB 45° Long

405-60NB 60° Long
Neck Insulators

Users should be aware that neck insulator replacement for BTB (Best of the Best) MIG Guns (BernardWelds.com/BTB) will be based on several variables including:

- Your gun’s amperage;
- Your gun’s neck/handle combination;
- The consumable series that you are using.

Please use the following chart when selecting the appropriate replacement neck insulator:

<table>
<thead>
<tr>
<th>Necks</th>
<th>Handle</th>
<th>Consumables</th>
<th>200A</th>
<th>300A</th>
<th>400A</th>
<th>500A</th>
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<td></td>
<td>10012</td>
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</tbody>
</table>

Q-Nut Cover and Insulators

Q-Nut Cover Installation Instructions for rotatable necks

With gas diffuser/retaining head removed, install insulating ring over the front of the neck and into the space between the aluminum armor and the front face of the Q-Nut.

Line up the hex shape on the Q-Nut cover with the hex on the Q-Nut and slide the Q-Nut forward until the part bottoms out. When installed properly, there should be an approximate 1/16” gap between the rear face of the Q-Nut cover and the threads on the Q-Nut.

Slide the silicone insulator over the threads of the Q-Nut and press flush up against the rear face of the Q-Nut cover. Ensure that the silicone insulator is orientated in the position shown in the image below.

Q-Nut on Rotatable Neck

Nut Insulator on Fixed Neck for B and O Series Handles

Silicone Insulator

Q-Nut Cover with insulating ring

Nut Insulator

Q-Nut

Insulating Ring

Q-Nut Cover

Silicone Insulator

10012 Neck Insulator

402-11 Neck Insulator

Insulating Ring

Silicone Insulator
Neck Replacement Instructions

A. Changing the Neck - Rotatable
1. To remove neck, grasp brass nut and rotate counterclockwise. Rotation will free neck from end fitting. To install the neck, perform the above instructions in reverse order and torque to 38 in-lbs.
2. Liner may need to be changed if switching to a neck of a different bend angle or length.

B. Changing the Neck - Fixed with Curved Handle
1. To remove neck, remove the nut insulator.
2. Using a wrench, rotate brass nut counterclockwise, rotation will free neck from end fitting.
3. To install the neck, perform the above instructions in reverse order and tighten lock nut to 16 ft-lbs (21.7 Nm). Be sure nut insulator is in place.
4. Liner may need to be changed if switching to a neck of a different bend angle or length.

C. Changing the Neck - Fixed with T Series Large Straight Handle
1. Place neck in vise. Remove both switch mounting housing screws with an 8 mm nut driver.
2. Slide handle back exposing the cable connection. Loosen the cable/neck connection using a 7/8” wrench.
3. Remove from vise and unthread neck by hand.
4. Thread the neck into the cable connection (hand tighten). Place neck in vise and tighten with a wrench to within 1/8” (3.2 mm) spacing between the cable connection and neck.
5. Install the switch and reposition handle and switch housing.
6. Reinstall switch housing mounting screws.
7. Liner may need to be changed if switching to a neck of a different bend angle or length.
D. Changing the Neck - Fixed with T Series Small Straight Handle

1. Loosen and remove locking collar.
2. Place neck in vise, twist handle lock nut counterclockwise and pull away from handle.
3. Remove screw from handle. Separate handle halves exposing jam nut and front of unicable.
4. Loosen jam nut using two 19 mm wrenches and unthread neck. Remove from vise and unthread neck by hand.
5. Thread jam nut onto new neck. Thread neck into unicable to desired orientation. Place neck in vise, tighten unicable and jam nut.
6. Reposition switch and handle. Reinstall handle lock nut, locking collar and screw.
7. Liner may need to be changed if switching to a neck of a different bend angle or length.

E. Changing the Neck - Fixed with C Series Large Straight Handle

1. Place neck in vise. Remove both switch housing mounting screws with a Phillips screwdriver.
2. Remove both the top and bottom pods from handle.
3. Slide handle back, exposing the cable connection. Loosen the cable/neck connection using a 7/8" wrench.
4. Remove from vise and unthread neck by hand.
5. Thread the new neck into the cable connection (hand tighten). Place neck in vise and tighten with a wrench to within 1/8" (3.2mm) spacing between the cable connection and neck.
6. Install the switch and reposition handle and switch housing.
7. Reinstall switch housing mounting screws.
8. Liner may need to be changed if switching to a neck of a different bend angle or length.

Accessories

Not configurable, please order separately

Neck Grips

For Curved Handle MIG Guns
This high temperature rubber sleeve for curved handle MIG guns provides the operator with improved accuracy and reduced heat exposure. The Q-Neck Grip is designed to help users hold the neck in a steady position, improve overall weld quality and reduce operator fatigue.

For T Series Handles
This neck grip features a heavy duty metal spring for straight handle MIG guns configured with fixed necks. Designed to reduce heat exposure and help users hold the neck in a steady position in order to improve weld quality and reduce operator fatigue.

<table>
<thead>
<tr>
<th>Neck Grip</th>
<th>Code</th>
<th>Application</th>
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<td>For Curved Handle MIG Guns</td>
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<tr>
<td>Q-Neck Grip</td>
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<td>use with 405-60 Neck</td>
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<td>use with 405-45 Neck</td>
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<tr>
<td>Q-Neck Grip</td>
<td>506-1</td>
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</tbody>
</table>

Q-Neck Coupler

The Q-Neck Coupler is designed to connect any two Q-Necks for flexibility and to minimize the need for special-order necks. Compatible with any rotatable necks.
Additional Options

Flex Necks

For B Series and O Series Handles

Save labor and time — change, rotate or bend the Flex Neck to your desired angle without tools. Available in 6" and 8" lengths and is easily removable for jump liner changeover. Compatible with Bernard Centerfire™ and Quik Tip™ consumables.

- **QT-F-6**: 6" length
- **QT-F-8**: 8" length

For T Series Handles

The Flex Neck for T Series handles features a braided copper conductor tube with a bend radius of up to 80° allowing you to reach your weld joints comfortably. The flex neck can be replaced without disturbing cable connections and is compatible with select Tregaskiss TOUGH LOCK™ and TOUGH ACCESS™ consumables.

**405-FL**

See Flex Neck Spec Sheet (SP-FN) for more information

Rotatable Neck Adaptor for Straight Handle Fixed Necks

The 1680085 and 1680085C adapter is used to convert straight handle BTB Guns from fixed to rotatable necks. Compatible with T Series Large Straight Handles and C Series Straight Handles only.

**1680085** Rotatable Neck Adaptor

(required for use with T Series handles only)

**1680085C** Rotatable Neck Adaptor

(required for use with C Series handles only)

Specialty Necks

Not configurable, please order separately

There are additional standard necks available for order separately in multiple lengths and bends that will help ensure a high quality weld and to improve operator comfort.

- **QT2-45-12**: 45°, 12 in.
- **QT2-45-18**: 45°, 18 in.
- **QT2-45-24**: 45°, 24 in.

See Flex Neck Spec Sheet (SP-FN) for more information
QT-180-3 0°, 3 in.  
4.2” [106.7 mm]

QT-180-5 0°, 5 in.  
5.9” [149.9 mm]

QT-180-7 0°, 7 in.  
8.0” [203.2 mm]

QT-180-12 0°, 12 in.  
12.6” [320 mm]

QT-180-18 0°, 18 in.  
18.6” [472.4 mm]

QT-180-24 0°, 24 in.  
24.6” [624.8 mm]

Subject to Change – The information presented in this spec sheet is accurate to the best of our knowledge at the time of printing. Please visit BernardWelds.com for the most up-to-date information.