



**Miller**<sup>®</sup>

The Power of Blue<sup>®</sup>



Parts Catalog  
MillerWelds.com

**2018**

# SERIAL NUMBER REFERENCE

The letters of the serial numbers are very significant.  
Please supply the letters along with the numbers.

Yr/Month	Serial #	Style #	Yr/Month	Serial #	Style #
1968/Jan.	T-436102	T1	1993/July	KD449472	KD41
1968/July	T-452888	T6	1994/Jan.	KE550001	KE01
1969/Jan.	U-472600	U1	1994/July	KE668695	KE26
1969/July	U-493984	U6	1995/Jan.	KF780420	KF01
1970/Jan.	W-517910	W1	1995/July	KF923923	KF26
1970/July	70-539663	70-6	1996/Jan.	KG041900	KG01
1971/Jan.	71-559155	71-1	1996/July	KG173969	KG26
1971/July	71-581468	71-6	1997/Jan.	KH300251	KH01
1972/Jan.	72-604096	72-1	1997/July	KH438994	KH26
1972/July	72-626994	72-6	1998/July	KJ000100	KJ01
1973/Jan.	HD655498	HD1	1998/July	KJ165696	KH26
1973/July	HD689465	HD6	1999/Jan.	KK000100	KK01
1974/Jan.	HE730188	HE1	1999/July	KK173909	KK26
1974/July	HE778187	HE6	2000/Jan.	LA000200	LA01
1975/Jan.	HF821067	HF1	2000/July	LA210095	LA27
1975/July	HF860240	HF6	2001/Jan.	LB000200	LB01
1976/Jan.	HG000500	HG1	2001/July	LB195125	LB26
1976/July	HG044257	HG6	2002/Jan.	LC000201	LC01
1977/Jan.	HH000500	HH1	2002/July	LC230270	LC26
1977/July	HH050101	HH6	2003/Jan.	LC361720	LD01
1978/Jan.	HJ106001	HJ1	2003/July	LC5280002	LD26
1978/July	HJ169391	HJ6	2004/Jan.	LE020006	LE02
1979/Jan.	HK220001	HK1	2004/July	LE260001	LE26
1979/July	HK286000	HK27	2005/Jan.	LF010001	LF01
1980/Jan.	JA356001	JA1	2005/July	LF260001	LF26
1980/July	JA410000	JA28	2006/Jan.	LG010001	LG01
1981/Jan.	JB465001	JB1	2006/July	LG260001	LG26
1981/July	JB522459	JB26	2007/Jan.	LH010001	LH01
1982/Jan.	JC585001	JC1	2007/July	LH260001	LH26
1982/July	JC626075	JC26	2008/Jan.	LJ010001	LJ01
1983/Jan.	JD660001	JD1	2008/July	LJ260001	LJ26
1983/July	JD688500	JD26	2009/Jan.	LK010001	LK01
1984/Jan.	JE732465	JE1	2009/July	LK260001	LK26
1984/July	JE783729	JE27	2010/Jan.	MA010001	MA01
1985/Jan.	JF835606	JF1	2010/July	MA260001	MA26
1985/July	JF905000	JF26	2011/Jan.	MB010001	MB01
1986/Jan.	JG000500	JG1	2011/July	MB260001	MB26
1986/July	JG071437	JG26	2012/Jan.	MC010001	MC01
1987/Jan.	JH146311	JH16	2012/July	MC0270001	MC27
1987/July	JH229162	JH41	2013/Jan.	MD010001	MD01
1988/Jan.	JJ319663	JJ15	2013/July	MD270001	MD27
1988/July	JJ413787	JJ41	2014/Jan.	ME010001	ME01
1989/Jan.	JK529151	JK15	2014/July	ME2700001	ME27
1989/July	JK636569	JK41	2015/Jan.	MF010001	MF01
1990/Jan.	KA737051	KA15	2015/July	MF270001	MF27
1990/July	KA824820	KA41	2016/Jan.	MG010001	MG01
1991/Jan.	KB000500	KB15	2016/July	MG280001	MG28
1991/July	KB089898	KB41	2017/Jan.	MH010001	MH01
1992/Jan.	KC170500	KC15	2017/July	MH270001	MH27
1992/July	KC262180	KC41	2018/Jan.	MJ010001	MJ01
1993/Jan.	KD341750	KD15	2018/July	MJ270001	MJ27

## Letter Business

A	Advanced Technologies Prod.	N	Small Integrated MIG Systems
B	Light Industrial Products	P	Plasma Products
C	3-Phase Industrial Products	Q	Performance Engine Drive
E	Industrial Engine Driven Prod.	R	Commercial Power Products
F	ITW Cooling Systems	S	WCC/Parts Business
G	Pipe Welding Products	T	Tregaskiss
H	Portable Power Products	U	Advanced Manufacturing Sys.
K	Component Products	W	Wire Feed Systems
L	TIG Industrial Products	Y	Troy Equipment
M	Fast Switch Products	Z	Other

Some serial numbers **STARTING** in 2003 have a letter at the end of the serial number.













See chart above for business unit letter designations.

Serial number example: **LG|36|0937|P** LG = 2006, 36 = Week 36 (manufactured in week 36),

**0937** = Item 937, **P** = manufactured by Plasma Products

<sup>1</sup>Maxstar 150 models used the LD serial number prefix in 2003. Note: Style number replaces serial numbers on some models.

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## T94™ Series 4 Sensors

Item #	Description	T94™	T94i™
1	Helmet Shell, Titanium (QR)	258864	258854
2	Lens Cover, Inside 4-3/16 x 2-1/2 in (5 Per Pkg)	216327	-
3	Lens Assembly, with cable	260557	-
	Lens Assembly, without cable	-	259572
4	Tray, Battery	259574	259574
	Battery, Lithium (CR2450)	217043	217043
5	Lens Cover, Front (5 per Pkg)	265304	265304
6	Lens Holder, Front	265309	265309
7	Covers, Side Window (Pair)	260197	260197
8	Kit, Headgear Adjust Angle	265891	265891
9	Headband, Fabric	770249	770249
	Replacement O-Rings For Kit 256178 (5 Per Pkg)	079975	079975
10	Headgear, Gray	260486	260486
11	Button, Grind Mode	256179	-
12	Clip, Retaining Grinding Shield	-	245819
13	Lens, Grinding Shield (Clear)	-	258979
14	Shield, Grinding Tear Away	-	258853



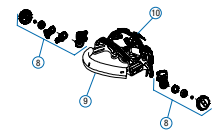
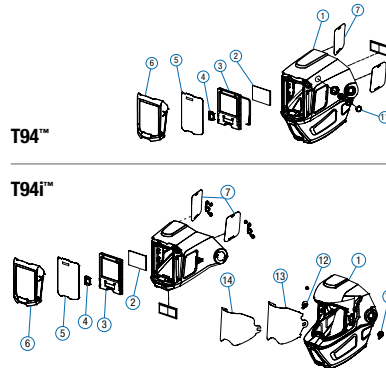
T94™  
260482  
21oz.



T94i™  
260483  
26oz.



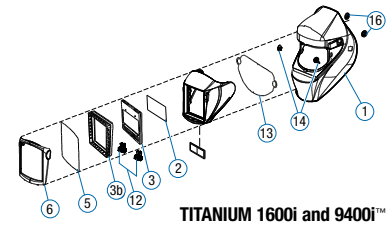
Top Helmet Cape  
279080



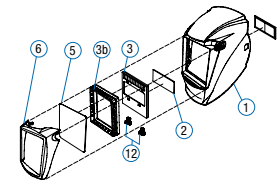
T94™ and T94i™

## Titanium Series™ 4 Sensors

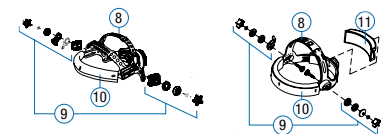
Item #	Description	TITANIUM 1600™	TITANIUM 1600i™	TITANIUM 7300™		TITANIUM 9400™		TITANIUM 9400i™	
				ANALOG	DIGITAL	ANALOG	DIGITAL	ANALOG	DIGITAL
1	Helmet Shell, Titanium (QR)	243530	245820	243530	258601	243530	258601	245820	245820
2	Inside Lens Cover (5 1/4 x 4 1/2 in) (5-Pkg)	235628	235628	-	-	-	-	-	-
	Inside Lens Cover (4 1/4 x 2 in) (5-Pkg)	-	-	770237	770237	-	-	-	-
	Inside Lens Cover (4 1/4 x 2 1/2 in) (5-Pkg)	-	-	-	-	216327	216327	216327	216327
3	Auto-Darkening Lens Assembly	-	-	245816	256358	245817	256359	245817	256360
	Filter Plate	235630	235630	-	-	-	-	-	-
3b	Gasket, Lens Assembly (QR)	245813	245813	245814	241977	241977	241977	241977	241977
5	Front Lens Cover (4 11/16 x 5 5/8 in) (5-Pkg)	216326	216326	216326	216326	216326	216326	216326	216326
6	Front Lens Holder, Titanium	243396	245815	243396	243396	243396	243396	245815	245815
8	Ratchet Headgear Assembly (Includes #9 & #10)	770246	770246	770246	256174	770246	256174	770246	256174
9	Adjustment Angle/Stop Hardware Kit	770248	770248	770248	256178	770248	256178	770248	256178
10	Fabric Headband	770249	770249	770249	770249	770249	770249	770249	770249
	Replacement O-Rings For Kits 258178 & 770248 (5 Per Pkg)	079975	079975	079975	079975	079975	079975	079975	079975
11	Comfort Cushion	216336	216336	216336	-	216336	-	216336	-
12	Battery Tray, Kit (Left/Right)	-	-	216339	216339	216339	216339	216339	216339
	Battery, Lithium CR2450 (Not Shown)	-	-	232027	217043 (2)	217043 (2)	217043 (2)	217043 (2)	217043 (2)
13	Lens, Grinding Shield (Clear)	-	245818	-	-	-	-	245818	245818
14	Clips, Retaining Grinding Shield	-	245819	-	-	-	-	245819	245819
15	Button, Replacement External Grind	-	-	-	256179	-	256179	-	-
16	Clips, Visor Hinge (I-Series Shell)	-	255070	-	-	-	-	255070	255070
17	Lens Tear-Off, Grind Shield (Clear) (Not Shown)	-	254278	-	-	-	-	254278	254278
18	Kit, Weld Shield Hinge (Pair)	-	269929	-	-	-	-	269929	269929



TITANIUM 1600i and 9400i™



TITANIUM 1600™, 7300 and 9400™



ALL TITANIUM SERIES™ MODELS

# WELDING PROTECTION

## Digital Infinity™ Series

4 Sensors

Item #	Part #	Description	Quantity
1	271340	Helmet Shell, Black Ops	1
1	271335	Helmet Shell, Black	1
1	271336	Helmet Shell, Stars & Stripes	1
1	271337	Helmet Shell, Camo	1
1	271339	Helmet Shell, Departed	1
2	271319	Lens Cover, Inside 4-3/4 in x 3-1/4 in	1
3	271321	Lens Assembly, Auto-Darkening	1
4	271320	Lens Cover, Front 6 in x 5-5/8 in	1
5	271322	Holder, Front Lens (Black)	1
5	271323	Holder, Front Lens (Silver)	1
5	271324	Holder, Front Lens (Camo)	1
6	271325	Headgear, Gray (Gen III) (Includes)	1
7	256178	Kit, Adjustment Angle/Stop Hardware	1
8	770249	Headband, Fabric	1
9	271326	Cushion, Top Headgear	1
10	271327	Tray, Battery (Left/Right) (Infinity)	2
	217043	Battery, Lithium (CR2450)	1
11	770250	Bag, Helmet (Miller Logo)	1
12	271328	Adapter, Magnification Lens (XI)	1
13	212235	Lens, 0.75 Magnification	1
13	212236	Lens, 1.00 Magnification	1
13	212237	Lens, 1.25 Magnification	1
13	212238	Lens, 1.50 Magnification	1
13	212239	Lens, 1.75 Magnification	1
13	212240	Lens, 2.00 Magnification	1
13	212241	Lens, 2.25 Magnification	1
13	212242	Lens, 2.50 Magnification	1
	222003	Adapter, Hard Hat	1
	259637	Adapter, Hard Hat, Slotted QR	1



**Black**  
280045  
23oz.



**Stars & Stripes™**  
271330  
23oz.



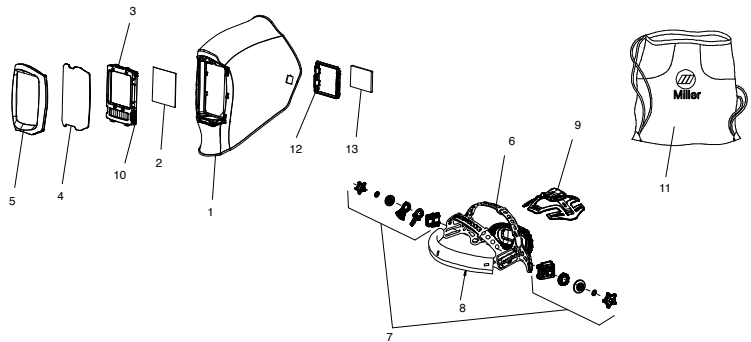
**Camouflage**  
271331  
23oz.



**Departed™**  
271332  
23oz.



**Black Ops™**  
271333  
23oz.







## Digital Elite™ Series 4 Sensors

Item #	Description	Elite Analog	Elite Digital
1	Helmet Shell, Black	216331	216331
	Helmet Shell, Black (QR)	241976	241976
	Helmet Shell, Camouflage	227190	227190
	Helmet Shell, Stars and Stripes III	265709	265709
	Helmet Shell, Inferno	223454	223454
	Helmet Shell, Lucky's Speed Shop	237872	237872
	Helmet Shell, Pink Camo	273954	273954
	Helmet Shell, Fury	256172	256172
	Helmet Shell, Vintage Roadster	260086	260086
	Helmet Shell, Not Forgotten	260128	260128
	Helmet Shell, Cat® - 1st Edition	268619	268619
	Helmet Shell, Blue Flame	269274	269274
Helmet Shell, Hot Rod Garage	269947	269947	
2	Inside Lens Cover (4 1/4 x 2 1/2 in) (5-Pkg)	216327	216327
	Lens Assembly, Digital Elite (CAT)	-	269504
3	Lens Assembly, Digital Elite	216328	256469
	Lens Assembly, Digital Elite (CAT)	-	269504
3a	Gasket, Auto-Darkening Lens Assy	234758	234758
3b	Gasket, Lens Assembly (QR)	241977	241977
4	Gasket, Front Lens	216337	216337
5	Front Lens Cover (4 11/16 x 5 5/8 in) (5-Pkg)	216326	216326
6	Front Lens Holder, Black, Flat	241978	241978
7	Lens Holding Frame	216335	234759
8	Ratchet Headgear Assembly (includes #9 & #10)	770246	256174
9	Adjustment Angle/Stop Hardware Kit	770248	256178
10	Fabric Headband	770249	770249
	Replacement O-Rings For Kits 256178 & 770248 (5-Pkg)	079975	079975
11	Comfort Cushion	216336	-
12	Battery Tray, Kit (Left/Right)	216339	216339
	Battery, Lithium Cr2450 (Not Shown)	217043 (2)	217043 (2)



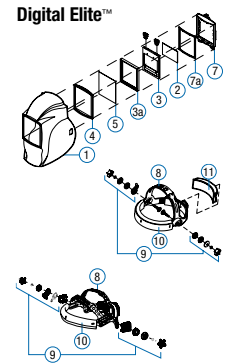
**Stars and Stripes™ III**  
264852  
16oz.



**CAT® - First Edition**  
268618  
16oz.



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**Pink Camo**  
273953  
16oz.

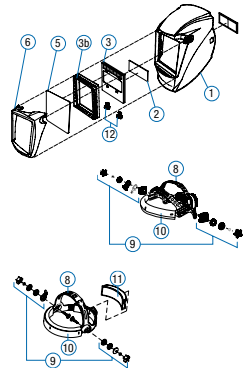


**Lucky's Speed Shop™**  
257214  
16oz.



**Vintage Roadster™**  
259485  
16oz.

### Elite Analog (QR) Series



**Camouflage**  
256173  
16oz.



**Black**  
257213  
16oz.



**Inferno™**  
257217  
16oz.

## Digital Performance™ Series

### 3 Sensors

Item #	Description	Performance Series	
		ANALOG	DIGITAL
1	Helmet Shell, Black	232020	232020
	Helmet Shell, Camouflage	241461	241461
	Helmet Shell, American Eagle II	265708	265708
	Helmet Shell, Blue Rage	241459	241459
	Helmet Shell, Illusion	256171	256171
	Helmet Shell, '64 Custom	250533	250533
	Helmet Shell, Cat® - 1st Edition	268740	268740
2	Inside Lens Cover (4 1/4 x 2 in) (5-Pkg)	770237	770237
3	Auto-Darkening Lens Assembly	232026	256468
3	Lens Assembly, Performance Series (Cat)	-	269505
4	Gasket, Front Lens	232028	232028
5	Front Lens Cover (4 1/2 x 5 1/2 in) (5-Pkg)	231921	231921
	Front Lens Holder, Black, Flat	232030	232030
	Front Lens Holder, Gloss Black	232032	232032
	Front Lens Holder, Camouflage	243395	243395
	Front Lens Holder, Light Blue	251278	251278
	Front Lens Holder, White	257041	257041
	8	Ratchet Headgear Assembly (Includes #9 & #10)	770246
9	Adjustment Angle/Stop Hardware Kit	770248	256178
10	Fabric Headband	770249	770249
	Replacement O-Rings For Kits 258178 & 770248 (5 Per Pkg)	079975	079975
11	Comfort Cushion	216336	-
12	Battery Tray, Kit (Left/Right)	232027	256730
	Battery, Lithium CR2450 (Not Shown)	217043	217043 (2)



**America's Eagle™ II**  
264851  
16oz.



**Blue Rage™**  
256164  
16oz.



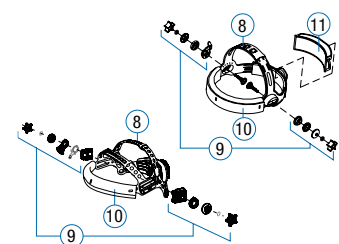
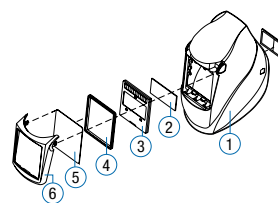
**'64 Custom™**  
256160  
16oz.



**Camouflage**  
256163  
16oz.



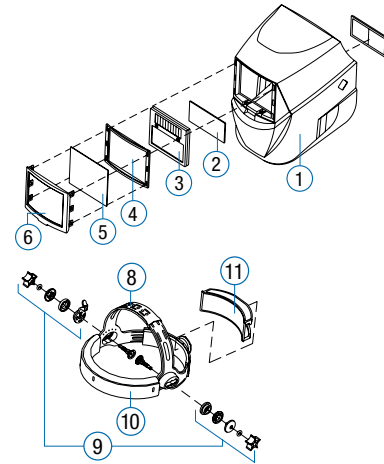
**Black**  
256159  
16oz.



# WELDING PROTECTION

## Digital Pro-Hobby™ Series 2 Sensors

Item #	Description	Pro-Hobby Series	
		ANALOG	DIGITAL
1	Helmet Shell, Black	231415	231415
	Helmet Shell, Red Flame	231419	231419
	Helmet Shell, Camouflage	231418	231418
	Helmet Shell, American Eagle II	265707	265707
	Helmet Shell, Metalworks	260087	260087
2	Inside Lens Cover (4 1/4 x 1 3/4 in) (5-Pkg)	231410	231410
3	Lens Assembly	231409	256467
4	Gasket, Front Lens	231412	231412
5	Front Lens Cover (4 1/2 x 3 3/4 in) (5-Pkg)	231411	231411
6	Front Lens Holder, Black, Flat	231572	231572
	Front Lens Holder, Gray	231573	231573
	Front Lens Holder, Red	231574	231574
	Front Lens Holder, Blue	231575	231575
	Front Lens Holder, Camouflage	231576	231576
8	Ratchet Headgear Assembly (Includes #9 & #10)	770246	256174
9	Adjustment Angle/Stop Hardware Kit	770248	256178
10	Fabric Headband	770249	770249
	Replacement O-Rings For Kits 258178 & 770248 (5 Per Pkg)	079975	079975
11	Comfort Cushion	216336	-
12	Battery Tray, Kit (Left/Right)	-	256729
	Battery, Lithium CR2450 (Not Shown)	AAA Alkaline	217043 (2)
	Battery Cover (Not Shown)	231413	-

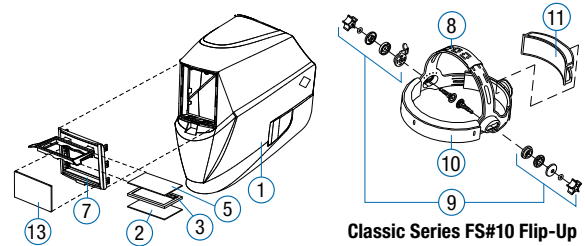


Digital/Analog Pro-Hobby™ Series  
16oz.

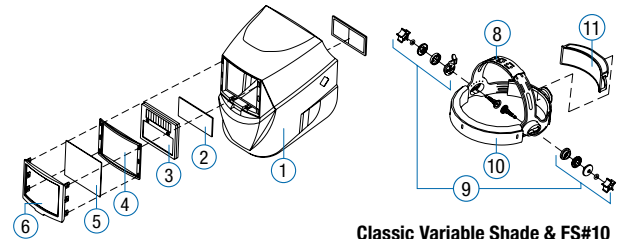
## Classic Series 2 Year Warranty

Item #	Description	Classic Series			
		FS#10	VS	VSI™	FS#10 Flip-Up*
1	Helmet Shell, Black	231415	231415	261824	231415
	Helmet Shell, Stars & Stripes	-	265707	-	-
	Helmet Shell, Red Flame	-	231419	-	-
	Helmet Shell, Metalworks	-	260087	-	-
	Helmet Shell, Camouflage	-	231418	-	-
2	Inside Lens Cover (4 1/4 x 2 in) (5-Pkg)	-	-	-	770237
	Inside Lens Cover (4 1/4 x 1 3/4 in) (5-Pkg)	231410	231410	231410	-
3	Auto-Darkening Lens Assembly	231571	251293	261826	770226
3b	Gasket, Lens Assembly (QR)	-	-	261827	-
4	Gasket, Front Lens	231412	231412	-	-
5	Front Lens Cover (4 1/4 x 2 in) (5-Pkg)	-	-	-	770237
	Front Lens Cover (4 1/2 x 3 3/4 in) (5-Pkg)	231411	231411	-	-
	Front Lens Cover (5 1/4 x 4 1/2 in) (5-Pkg)	-	-	235628	-
6	Front Lens Holder, Black, Flat	231572	231572	261828	-
7	Frame, Lens Holding	-	-	-	261829
8	Ratchet Headgear Assembly (Includes #9 & #10)	770246	770246	770246	770246
9	Adjustment Angle/Stop Hardware Kit	770248	770248	770248	770248
10	Fabric Headband	770249	770249	770249	770249
	Replacement O-Rings For Kits 258178 & 770248 (5 Per Pkg)	079975	079975	079975	079975
11	Comfort Cushion	216336	216336	216336	216336
12	Battery, Lithium CR2450 (Not Shown)	-	AAA Alkaline	217043	-
	Battery Cover (Not Shown)	-	231413	266781	-
13	Lens, Grinding Shield (Clear)	-	-	245818	261830
14	Clips, Retaining Grinding Shield	-	-	245819	-
16	Clips, Visor Hinge (I-Series Shell)	-	-	255070	-
17	Lens Tear-Off, Grind Shield (Clear) (Not Shown)	-	-	254278	-

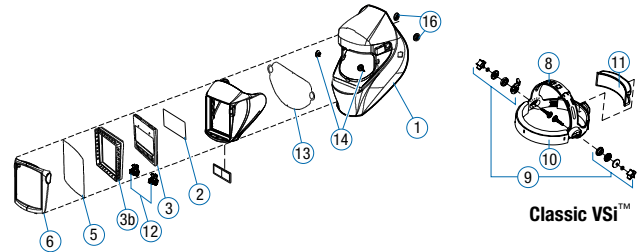
\*Order flip-up separately  
VSI Hinge Kit 269929



Classic Series FS#10 Flip-Up



Classic Variable Shade & FS#10



Classic VSI™



FS#10 Flip-Up  
263038



VSI  
260938  
23oz.



Variable Shade  
251292  
10oz.



Metalworks™  
271346



Camouflage  
271348

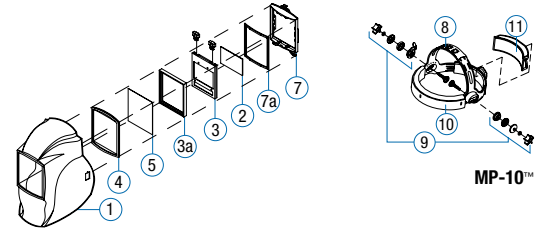


## MP-10™ Series 90 Day Warranty

Item #	Description	MP-10 Series
1	Helmet Shell, Black	216331
	Helmet Shell, Inferno	223454
2	Inside Lens Cover (5 1/4 x 4 1/2 in) (5-Pkg)	235628
3	Filter Plate	235630
4	Gasket, Front Lens	216337
5	Front Lens Cover (4 1/16 x 5 5/8 in) (5-Pkg)	216326
7	Lens Holding Frame	234759
		216335
7a	Spacer, Lens Holding (MP-10)	235629
8	Ratchet Headgear Assembly (Includes #9 & #10)	770246
9	Adjustment Angle/Stop Hardware Kit	770248
10	Fabric Headband	770249
		Replacement O-Rings For Kits 258178 & 770248 (5 Per Pkg)
11	Comfort Cushion	216336



**Black**  
238497 (Each); 235626 (6 Pk)



## Helmet Accessories and Packages



**Gen II Headgear**  
256174  
Extensive adjustability setting and a pivoting top for better fit and comfort



**Gen III Headgear**  
271325  
Oversized comfort cushion provides extensive adjustability, settings, and enhanced support



**Helmet Hook**  
251018  
• Holds welding helmets, grinding shields or other helmets with a headgear  
• Silicone strap secures the helmet in place



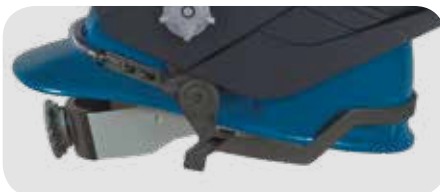
**Helmet Bib**  
253882  
Attaches to bottom of the helmet with hook-and-loop fasteners for added neck coverage



**Helmet Bag**  
770250  
• Drawstring closure  
• Ultra-soft inside liner  
• Exterior storage pouch



**Slotted Hard Hat Adapter**  
259637  
Compatible with all Miller helmets. Helmet and hat not included



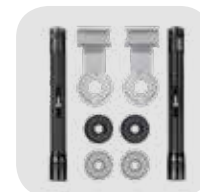
**Hard Hat Adapter**  
213110 (XI and XLI)  
265315 (T94 Series)  
222003 (Infinity, Titanium, XLix, Elite, Performance, ProHobby, Classic and MP-10 Series)  
Compatible with Fibre Metal and MSA hats. Other brands may fit depending on size and shape. Helmet and hat not included.



**Jobsite Tool Bag**  
228028  
• Over twenty separate pockets  
• Opening of 12 x 18.5 inches (305 x 470 mm)  
• 12.5 x 14 x 22 (overall dimensions)



**2x4 Auto-Darkening Lens**  
770660 Shade 8  
770659 Shade 9  
770226 Shade 10  
770961 Shade 11  
• Fits all 2x4-inch windows  
• Solar powered, two arc sensors  
• Light state shade 3  
• Two-year warranty



**Commercial Helmet Light Kit**  
282013  
Compatible with most Miller® helmets  
• Lightweight  
• Adjustable light beam



**T94™ Helmet Light Kit**  
281361  
• Lightweight  
• Adjustable light beam

## Lenses

### Bulk Cover Lenses

Part #	Description	Quantity
265304B	Front Lens Cover, T94	50 Pkg
216326B	Front: Elite, Titanium, MP-10	50 Pkg
216327B	Inside: Elite, Titanium, 9400i, T94, T94i	50 Pkg
231921B	Front: Performance	50 Pkg
770237B	Inside: Performance	50 Pkg
231411B	Front: Pro-Hobby, Classic	50 Pkg

### Magnifying Lenses for All Miller Helmets (Lens size is 4 1/2" x 2" x 5/23)

Part #	Strength
212235	0.75 Magnification
212236	1.00 Magnification
212237	1.25 Magnification
212238	1.50 Magnification
212239	1.75 Magnification
212240	2.00 Magnification
212241	2.25 Magnification
212242	2.50 Magnification

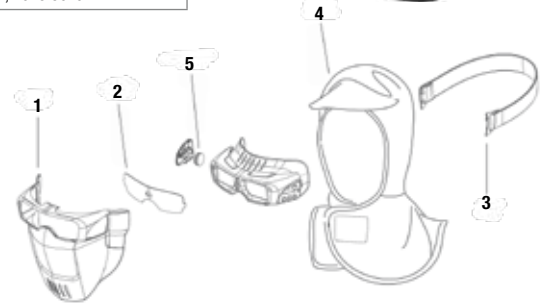
# WELDING PROTECTION

## Weld-Mask™

Item #	Part #	Description	Quantity
	<b>267370</b>	<b>Weld-Mask™ Unit</b>	
1	267422	Guard, Face	1
2	267420	Cover, Lens	1 (5 per pkg)
3	270053	Band, Head	1
4	267421	Cover, Head FR.	1
5	270055	Battery, Non-Rechargeable CR2032	2 (1 per pkg)
	272116	Lens Cover Retainer	
	272117	Cover, Battery	
	272118	Cover, Control	
	272119	Silicon Eye Skirt	
	272120	Retainer Frame, Silicon Eye Skirt	
	272131	Suction Cup, Lens Cover	
	272124	Magnifying Lens Frame	
	272137	Anti-Fog Film	

### Weld-Mask Lens Options

Part #	Description
273763	Magnifying Lenses, Diopter .75
273764	Magnifying Lenses, Diopter 1.00
273765	Magnifying Lenses, Diopter 1.25
273766	Magnifying Lenses, Diopter 1.50
273767	Magnifying Lenses, Diopter 1.75
273768	Magnifying Lenses, Diopter 2.00
273769	Magnifying Lenses, Diopter 2.25
273770	Magnifying Lenses, Diopter 2.50
272120	Retainer Frame, Silicon Eye Skirt
272116	Retainer, Lens Cover

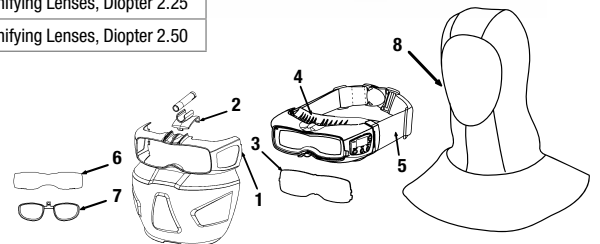


## Weld-Mask 2™

Item #	Part #	Description	Quantity
	<b>280982</b>	<b>Weld-Mask™ 2 Unit</b>	
3	280985	Cover, Lens	1 (5 per pkg)
8	280983	Cover, Head FR.	1
1	280980	Guard, Face	1
5	280981	Band, Head	1
4	280984	Silicon Eye Skirt	1
2	281188	Light Accessory Kit (optional)	
6	280986	Cover, Anti-Fog Lens	
7	280987	Magnifying Lens Frame	
	217043	Battery, CR2450	1
	280988	Cover, Battery	

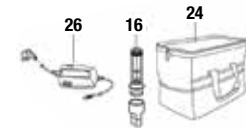
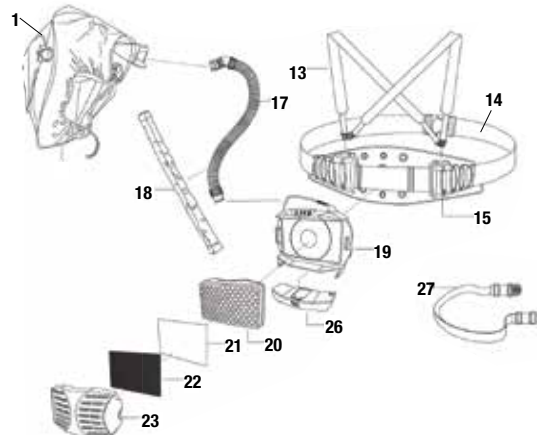
### Weld-Mask Lens Options

Part #	Description
281190	Magnifying Lenses, Diopter .75
281191	Magnifying Lenses, Diopter 1.00
281192	Magnifying Lenses, Diopter 1.25
281193	Magnifying Lenses, Diopter 1.50
281194	Magnifying Lenses, Diopter 1.75
281195	Magnifying Lenses, Diopter 2.00
281196	Magnifying Lenses, Diopter 2.25
281197	Magnifying Lenses, Diopter 2.50



## PAPR

### Service Parts/Consumables



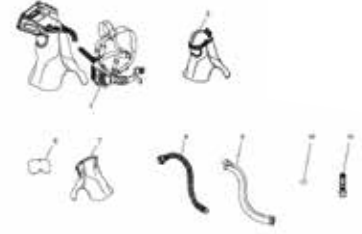




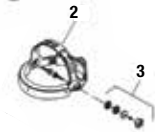
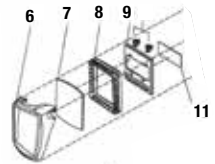
## TITANIUM PAPR Service Parts/Consumables

	Description	PAPR w/ Titanium 9400™	PAPR w/ Titanium 9400 (New Headgear)	PAPR w/ Titanium 9400i™	PAPR w/ Titanium 9400i (New Headgear)	PAPR w/ Hard Hat
	<b>PAPR (Complete System w/ Helmet)</b>	247533 (N/A) 262615* (N/A)	264879	247531 (N/A)	264877	259385 (w/9400 Helmet) 261659 (w/9400i Helmet)
	<b>PAPR (Complete System w/out Auto-Darkening Lens)</b>	247534 (N/A) 262616* (N/A)	264882	247532 (N/A)	264878	-
	<b>PAPR (Complete System w/out Helmet)</b>	-	-	-	-	259386
1	Helmet Assy. (Shell, Headgear and Headseal)	245217 (N/A) 262623*	264883	247471	264884	-
	Helmet Assy. (Hard Hat, Headgear and Headseal)	-	-	-	-	259387
2	Headgear (Includes:)	223430	256174	247472	256174	-
	Fabric Headband	770249	770249	770249	770249	-
3	Adjustment angle/stop hardware kit (w/O-rings)	770248	256178	770248	256178	-
	Replacement O-rings for kit 770248 (5 pack)	079975	-	079975	-	-
4	Headgear (Hard Hat)	-	-	-	-	259388
5	Headseal	247470	265629	247473	265628	259389 (w/goggles)
6	Lens holder, Front	243396 (N/A)	243369 (N/A)	245815	245815	243396 (9400) 245815 (9400i)
7	Outside Cover Lens (4-11/16 x 5-5/8)	216326	216326	216326	216326	216326
8	Frame/Gasket, ADF lens holding	241977	241977	241977	241977	241977
9	Auto-Darkening Lens Assembly (Titanium) (Infotrak)	256360 256359*	256359*	256360	256360	256359*
10	Battery tray kit (left/right)	216339	216339	216339	216339	216339
	Battery, Lens (Lithium CR2450)	217043 (2)	217043 (2)	217043 (2)	217043 (2)	217043 (2)
11	Inside Cover Lens (4-1/4 x 2-1/2) (5 pack)	216327	216327	216327	216327	216327
12	Lens, Grinding Shield (Titanium 9400i)	-	-	245818	245818	245818
	Tear-away, Grinding Shield	-	-	254278	254278	259391
	Clip, Retaining Grinding shield (left/right)	-	-	245819	245819	-
	Kit, Weld Shield Hinge	-	-	269929	269929	-
13	Shoulder Straps	235680	235680	235680	235680	235680
14	Belt	235679	235679	235679	235679	235679
15	Belt Pad	239636	239636	239636	239636	239636
16	Flowmeter	245219	245219	245219	245219	260890
17	Breathing Tube Assembly	245218	245218 (43")	247474 (36")	245218	259392
18	Breathing Tube Cover, Flame-resistant	245367	245367	239571	245367	239571
	O-ring, Breathing Tube	237452	237452	237452	237452	259394
19	Blower Assembly	235672	235672	235672	235672	235672
	Kit, Battery Contact	269930	269930	269930	269930	269930
20	Filter, Particulate (HEPA) (2 pack)	235673-2	235673-2	235673-2	235673-2	235673-2
	Filter, Particulate (HEPA) (6 pack)	235673-6	235673-6	235673-6	235673-6	235673-6
	Filter, Particulate (HEPA) (36 pack)	235673-36	235673-36	235673-36	235673-36	235673-36
21	Filter, Prefilter (foam) (6 pack)	235674	235674	235674	235674	235674
21	Filter, Prefilter NUIS OV	268841	268841	268841	268841	268841
22	Spark Guard	235676	235676	235676	235676	235676
23	Filter Cover	235677	235677	235677	235677	235677
24	Tool Bag	228028	228028	228028	228028	228028
25	Battery, Blower	244131	244131	244131	244131	244131
26	Charger	244132	244132	244132	244132	244132
27	Belt Extension	244151	244151	244151	244151	244151
28	Hard Hat (for PAPR)	-	-	-	-	259460
29	Slotted Hard Hat Adapter	-	-	-	-	259637
	Lens, Clear (Hard Hat Headseal)	-	-	-	-	259390
	Button, Replacement External Grind	-	256179	-	-	256179
	Kit PAPR Battery Contact Replacement	269930	269930	269930	269930	269930
	Fabric Sweatband, HH	-	-	-	-	270176

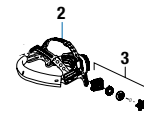
\* Indicates part number features external grind control button.



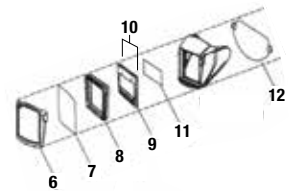
PAPR w/ Titanium 9400 Helmet



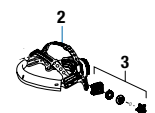
w/ New Headgear



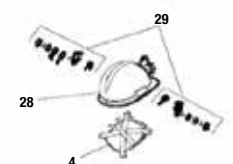
PAPR w/ Titanium 9400i Helmet



w/ New Headgear



PAPR w/Hard Hat

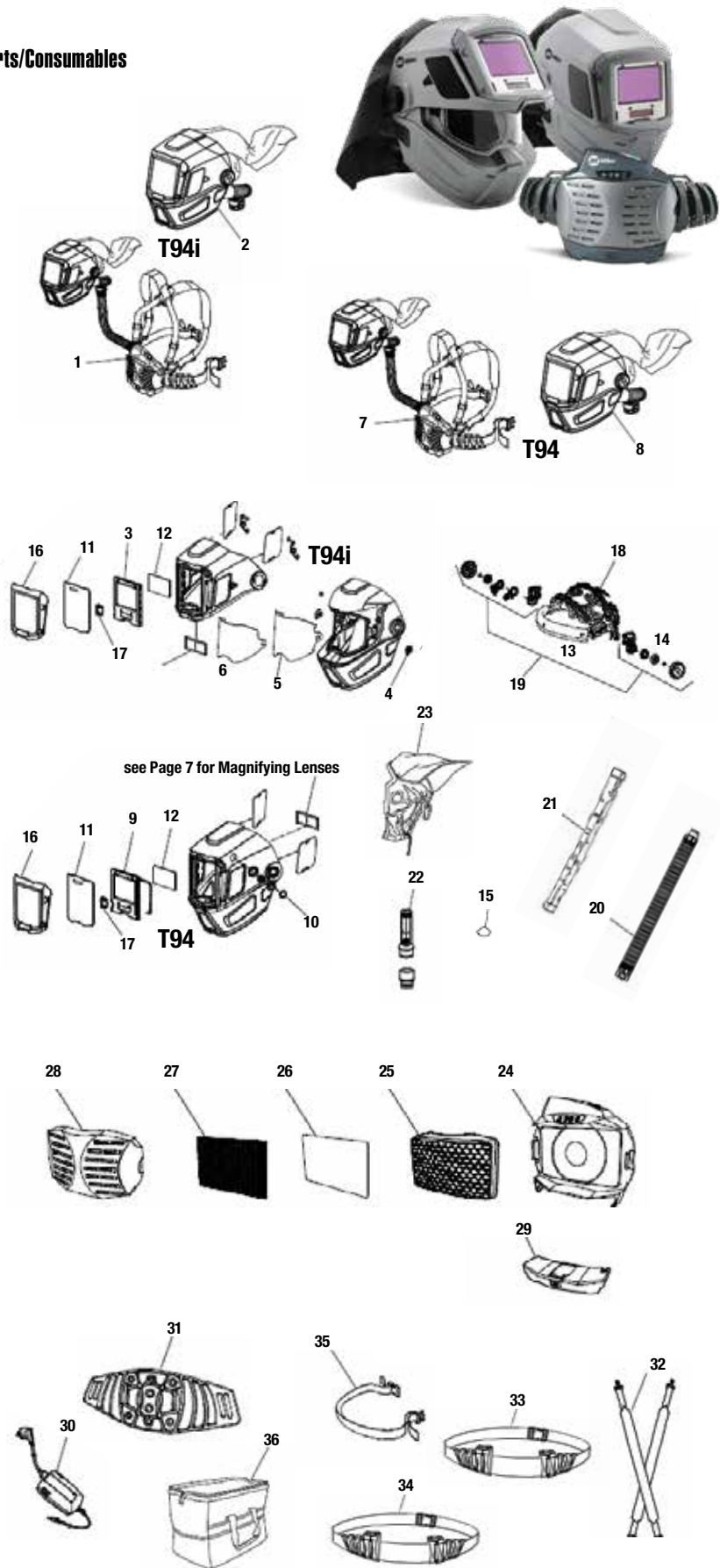


# WELDING PROTECTION

## T94-R™ & T94i-R™ PAPR

### Service Parts/Consumables

	Description	
1	<b>T94i™ PAPR (Complete System)</b>	264575
2	Head Assembly (without auto-darkening lens assembly)	265305
3	Auto-Darkening Lens	259572
4	Clip, Retaining Grinding Shield	245819
5	Lens, Grinding Shield	258979
6	Tear-Away Grinding Shield Covers	254278
7	<b>T94™ PAPR (Complete System)</b>	264573
8	Head Assembly (without auto-darkening lens assembly)	260821
9	Auto-Darkening Lens	260557
10	External Grind Button	256179
<b>Consumables</b>		
11	Lens Cover, Outside	265304
	Battery, Lithium CR2450 (not pictured)	217043
12	Lens Cover, Inside	216327
13	Headband, Fabric	770249
14	Replacement O-Rings (5-Pack)	079975
15	Breathing Tube O-Ring	237452
<b>Replacement Parts/Accessories</b>		
16	Lens Holder, Front	265309
17	Battery Tray	259574
18	Headgear Kit (Gray)	260486
19	Kit, Adjustment Angle/Stop Hardware	265891
20	Breathing Tube Assembly	261704
21	FR Breathing Tube Cover	265312
22	Flowmeter	277222
23	FR Head Seal (Hood)	260926
<b>PAPR Replacement Parts &amp; Consumables</b>		
24	Blower Assembly	235672
25	Filter, Particulate (HEPA) 2 pack	235673-2
	Filter, Particulate (HEPA) 6 pack	235673-6
	Filter, Particulate (HEPA) 36 pack	235673-36
26	Filter, Prefilter 6 pack	235674
	Filter, Prefilter, Nuisance OV Relief 6 pack (not pictured)	268841
27	Spark Guard	235676
28	Filter Cover	235677
29	Battery, Blower	244131
<b>PAPR Accessories</b>		
30	Charger	244132
31	Belt Pad	239636
32	Shoulder Straps	235680
33	Belt	235679
34	Belt, Leather	264582
35	Belt Extension	244151
36	Bag	228028





## LPR-100™ Half Mask Respirator

Description	Part #
LPR-100 Half Mask Respirator, Small/Medium	ML00894
LPR-100 Half Mask Respirator, Medium/Large	ML00895
LPR-100 Half Mask Respirator with Nuisance Level OV Filter, Small/Medium	ML00994
LPR-100 Half Mask Respirator with Nuisance Level OV Filter, Medium/Large	ML00995
<b>Consumables/Accessories</b>	
P100 Filters	SA00818
P100 Nuisance Level OV Relief Filters	SA00819
Quantitative Face-Fit Test Kit	261086



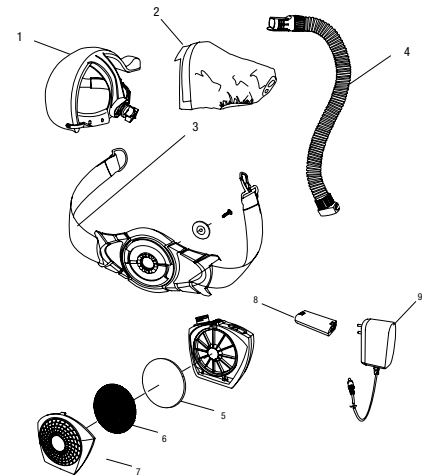
## N95 Disposable Mask Respirator

Description	Part #
Respirator (10 pack)	267334
Respirator with nuisance level OV relief (10 pack)	267335
Respirator (2 pack)	267334-2
Respirator with nuisance level OV relief (2 pack)	267335-2



## CoolBelt™ Service Parts/Consumables

Item #	Part #	Description	Quantity
	245230	CoolBelt unit (N/A)	
1	245235	Headgear (includes)	1
	079975	Replacement O-rings	1 (5 per pkg)
	770249	Fabric headband	1
2	245236	Head shroud (hood)	1
3	245232	Belt	1
4	245231	Hose assembly	1
5	245233	Filter	1 (6 per pkg)
6	247921	Spark Arrestor	1
7	245234	Filter cover	1
8	245237	Battery, blower	1
9	245238	Charger	1
	246964	Hose cover	1
	246965	Warranty Blower	



## Miller® MIG Gun History

Model Name	Serial Number Effective	Original Gun Breakdown	Recommended Replacement Gun (S)	Amperage of Gun	Wire Size	Replacement Gun Breakdown
Sidekick™ XL/ Cricket®	All Serial Numbers	GA-16C (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
Cricket®	All Serial Numbers	GA-16C1 (N/A)	M-100 W/Friction terminals part number 220606 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
Sidekick™ XL/ Cricket®/ Millermatic® 90	All Serial Numbers	GA-17C (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
			M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
			M-150 12 ft part number 249040			
Millermatic® 120/130/150	Prior to KF849783	GA-17C (N/A)	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
	Effective with KF849783	M-15 (N/A)	M-150 12 ft part number 249040			
Millermatic® 125	All Serial Numbers	M-80	M-80 part number 273618	100A at 100% Duty Cycle	.023-.045 (0.6-1.1 mm)	pg 21
Millermatic® 130 XP	Prior to KK110539	10-A (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
	Effective with KK110539	M-10	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
			M-150 12 ft part number 249040			
Millermatic® 135/140s/175/180/180 Auto Set/DVI™s/211	All Serial Numbers	M-10 (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
		pg 19	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
			M-150 12 ft part number 249040			
Millermatic® 141/190	All Serial Numbers	M-100	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
Millermatic® Challenger™	All Serial Numbers	M-15 (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
		pg 19	M-150 10 ft part number 249039	150A at 100% Duty Cycle		
			M-150 12 ft part number 249040			
Millermatic® Challenger™ 172	Prior to KK118238	10-A (N/A)	M-100 part number 248282 10 ft	100A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
	Effective with KK118238	M-10 (N/A)	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
		pg 19	M-150 12 ft part number 249040			
Millermatic® 185	All Serial Numbers	M-15 (N/A)	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
		pg 19	M-150 12 ft part number 249040			
Millermatic® 200	GA-20C	M-25	M-25 10 ft part number 169594	250A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 23
		pg 22	M-25 12 ft part number 169596			
			M-25 15 ft part number 169598			
Millermatic® 210/212/250X/251/252	All Serial Numbers	M-25	M-25 10 ft part number 169594	250A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 23
		pg 22	M-25 12 ft part number 169596			
			M-25 15 ft part number 169598			
Millermatic® 250	Prior to KF851980	GA-21C (N/A)	M-25 10 ft part number 169594	250A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 23
	Effective with KF851980	M-25 pg 23	M-25 12 ft part number 169596			
			M-25 15 ft part number 169598			
Millermatic® Vintage	All Serial Numbers	GA-20C (N/A)	M-25 10 ft part number 169594	250A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 23
		GA-21C (N/A)	M-25 12 ft part number 169596			
		M-25 pg 23	M-25 15 ft part number 169598			
Millermatic® 300	All Serial Numbers	M-40 (N/A)	Q4010TEEMC	400A at 100% Duty Cycle	.035-.045 (0.9-1.2 mm)	pg 25
			Q4010TEEMC			
			Q4010TEEMC			
Millermatic® 300 without gun		No Gun	Q4010TEEMC	400A at 100% Duty Cycle	.035-.045 (0.9-1.2 mm)	pg 25
Millermatic® 350	Prior to LE443589	Roughneck C-4012	Q4010TEEMC	400A at 100% Duty Cycle	.035-.045 (0.9-1.2 mm)	pg 25
	Effective with LE443589	Q3015AE8XM	Q3015AE8XMC		.035-.045 (0.9-1.2 mm)	pg 26
Millermatic® Passport™/ Passport™ Plus	All Serial Numbers	M-10 (N/A)	M-100 part number 248282 10 ft	150A at 100% Duty Cycle	.030-.035 (0.8-0.9 mm)	pg 21
		pg 19	M-150 10 ft part number 249039	150A at 100% Duty Cycle		pg 21
			M-150 12 ft part number 249040			
			M-150 15 ft part number 249041			
Millermatic® Pulsar	All Serial Numbers	M-15 (N/A)	M-150 10 ft part number 249039	150A at 100% Duty Cycle	.035-.045 (0.9-1.2 mm)	pg 21
		pg 19	M-150 12 ft part number 249040			
			M-150 15 ft part number 249041			

Optional Gun: M-25 Gun, Part Number 169599, 15ft. 250A at 100% Duty Cycle, Wire Size (.035-.045in)



**MIGmatic™ M-Series**  
100–250 Amp, Semi-Automatic,  
Air-Cooled MIG Welding Guns



### M-Series Consumable Kits (234607, 234608, 234609)

To better serve you, Miller® has introduced six improved, affordable MIG consumable kits that are compatible with the M-Series guns. Each kit contains consumables that are specific to your welding application, including gun type and wire size.

- 234607—M-10/15, M-100/150 Gun, .023" Wire
- 234608—M-10/15, M-100/150 Gun, .030" Wire
- 234609—M-10/15, M-100/150 Gun, .035" Wire

Consumable Kits 234607, 234608 and 234609 contain 10 contact tips, 1 nozzle and 1 contact tip adapter.

- 234610—M-25 Gun, .030" Wire
- 234611—M-25 Gun, .035" Wire
- 234612—M-25 Gun, .045" Wire

Consumable kits 234610, 234611 and 234612 contain 10 contact tips, 1 nozzle, 1 contact tip adapter and 1 nozzle adapter.

## Accessories

For a complete listing of gun consumables information, please refer to pages 13–16.



## M-10/M-15 Service Parts/Consumables

Item #	Part #	Description	Quantity	
			M-10	M-15
	195605 (N/A)	M-10 Gun, 10 ft (3 m), 100A, .030-.035 (0.8-0.9 mm)		
	169589 (N/A)	M-15 Gun, 10 ft (3 m), 150A, .030-.035 (0.8-0.9 mm)		
	169591 (N/A)	M-15 Gun, 12 ft (3.7 m), 150A, .030-.035 (0.8-0.9 mm)		
	169593 (N/A)	M-15 Gun, 15 ft (4.6 m), 150A, .030-.035 (0.8-0.9 mm)		
1	169715	Nozzle, slip type, .500 (12.7 mm) orf flush	1	1 (2 per pkg)
	226190	Nozzle, slip type, flux cored	1	1
2	087299	Tip, contact scr, .023 (0.6 mm) wire x 1.125	1	1 (10 per pkg)
	000067	Tip, contact scr, .030 (0.8 mm) wire x 1.125	1	1 (10 per pkg)
	000068	Tip, contact scr, .035 (0.9 mm) wire x 1.125	1	1 (10 per pkg)
	000069	Tip, contact scr, .045 (1.2 mm) wire x 1.125	1	1 (10 per pkg)
3	169716	Adapter, contact tip	1	1 (2 per pkg)
4	170470	Ring, retaining	1	1
5	169718	Tube, head	1	1
6	169738	Nut, locking handle	1	2
7	169719	Nut, jam (gun end)	1	1
8	169737	Handle	1	2
9	169741 (N/A)	Strain Relief, cable	—	2
10	227800	Cord Assembly with ends	1	1
11	209495	Connector, feeder—M-10 (includes) NA	1	—
11	209486 (N/A)	Connector, feeder—M-15 (includes)	—	1
12	079974	O-Ring, .500 ID x .103CS rbr	2	2
13	194010	Kit, liner monocoil .023/.025 (0.6 mm) wire x 15 ft (includes)	1	1
13	194011	Kit, liner monocoil .030-.035 (0.8-0.9 mm) wire x 15 ft (includes)	1	1
14	079975	O-Ring, .187 ID x .103CS rbr	1	1
15	227798	Switch, Red trigger	1	1
16	079878	Housing Plug and Pins	1	—
	079531	Connector, circ cpc clamp str rlf	1	—
17	169736	Terminal Block	—	1

## M-Series MIG Guns

\*For a detailed listing, please reference page 12.

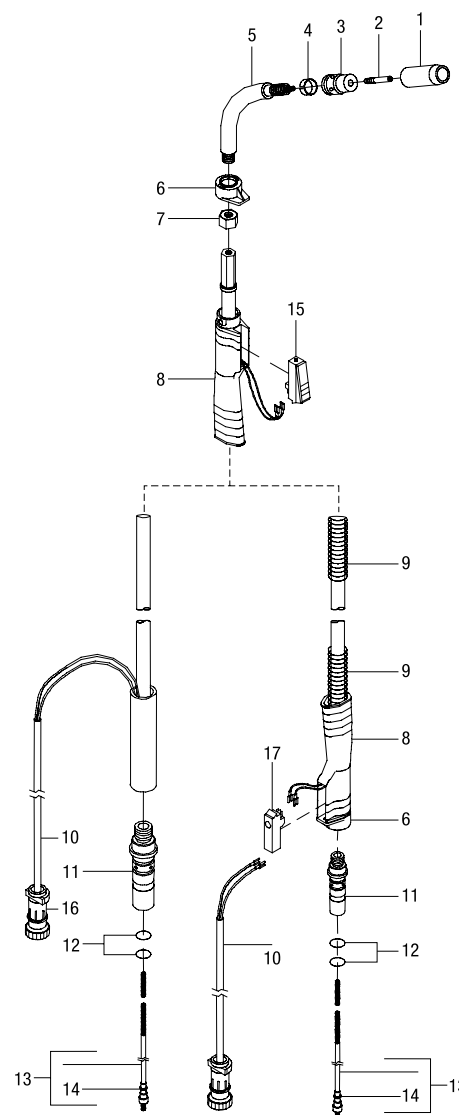
Model	Stock #	Length	Rating and Duty Cycle (C0 <sub>2</sub> ) <sup>1</sup>	Wire Size
M-80	273618 <sup>4</sup>	8 ft (2.4 m)	100 A at 100% Duty Cycle	.023-.045 in (0.6 to 1.1 mm)
M-100	248282	10 ft (3 m)	100 A at 100% Duty Cycle	.030-.035 in (0.8-0.9 mm)
	220606 <sup>2</sup>			
M-150	249039	10 ft (3 m)	150 A at 100% Duty Cycle	.030-.035 in (0.8-0.9 mm)
	249040	12 ft (3.7 m)		
	249041	15 ft (4.6 m)		
M-25	169594	10 ft (3 m)	250 A at 100% Duty Cycle	.030-.035 in (0.8-0.9 mm)
	169596	12 ft (3.7 m)		
	194805 <sup>3</sup>	12 ft (3.7 m)		
	169598	15 ft (4.6 m)		
	169599	15 ft (4.6 m)	250 A at 100% Duty Cycle	.035-.045 in (0.9-1.2 mm)

<sup>1</sup>60% with mixed gases

<sup>2</sup>220606 is an M-100 gun with friction terminals for the Miller® Cricket®

<sup>3</sup>194805 is an M-25 gun with friction lugs for the Hobart Beta-MIG 2510.

<sup>4</sup>273618 is an M-80 gun for the Millermatic® 125 Hobby.



M-10 Gun

M-15 Gun

## M-25

### Service Parts/Consumables

Item #	Part #	Description	Quantity
	169594	M-25 Gun, 10 ft (3 m), 250A, .030-.035 (0.8-0.9 mm)	
	169596	M-25 Gun, 12 ft (3.7 m), 250A, .030-.035 (0.8-0.9 mm)	
	169598	M-25 Gun, 15 ft (4.6 m), 250A, .030-.035 (0.8-0.9 mm)	
	169599	M-25 Gun, 15 ft (4.6 m), 250A, .035-.045 (0.9-1.2 mm)	
1	169724	Nozzle, slip type, .500 (12.7 mm) orf .125 recess	1
	169725 <sup>1</sup>	Nozzle, slip type, .625 (15.9 mm) orf .125 recess	1
	200258	Nozzle, slip type, .500 (12.7 mm) orf flush	1
	169726 <sup>2</sup>	Nozzle, slip type, .625 (15.9 mm) orf flush	1
	169727	Nozzle, slip type, .625 (15.9 mm) orf .125 stickout	1
2	087299	Tip, contact scr, .023 (0.6 mm) wire x 1.125	1 (10 per pkg)
	000067	Tip, contact scr, .030 (0.8 mm) wire x 1.125	1 (10 per pkg)
	000068	Tip, contact scr, .035 (0.9 mm) wire x 1.125	1 (10 per pkg)
	000069	Tip, contact scr, .045 (1.2 mm) wire x 1.125	1 (10 per pkg)
	172034 <sup>1</sup>	Tip, contact scr 3/64 (1.19 mm) wire x 1.125	1 (10 per pkg)
3	169728	Adapter, contact tip	1 (2 per pkg)
4	169729	Adapter, nozzle	1 (2 per pkg)
5	170468	O-Ring	1 (10 per pkg)
6	169730	Washer, shock	1
7	169731	Tube, head	1
8	169738	Nut, locking handle	2
9	169732	Nut, jam	1
10	169737	Handle, front	1
11	227799	Handle, rear	1
12	227800	Cord, trigger assembly	1
13	209495	Connector, feeder (includes)	1
14	079974	O-Ring, .500 ID x .103CS rbr	2
15	194010	Kit, liner monocoil	1
		.023/.025 (0.6 mm) wire x 15 ft (includes)	
15	194011	Kit, liner monocoil	1
		.030-.035 (0.8-0.9 mm) wire x 15 ft (includes)	
15	194012	Kit, liner monocoil	1
		.035-.045 (0.9-1.2 mm) wire x 15 ft (includes)	
15	194014 <sup>1</sup>	Kit, liner monocoil	1
		3/64 (1.19 mm) aluminum wire x 15 ft (includes)	
16	079975	O-Ring, .187 ID x .103CS rbr	1
17	227798	Switch, trigger	1
18	2520033	Cable strain relief 2 & 3	1
19	7000015	Screw	1
20	169746	Terminal	1

<sup>1</sup>Included with 172136 Kit, Aluminum Conversion .047 in (1.2 mm)

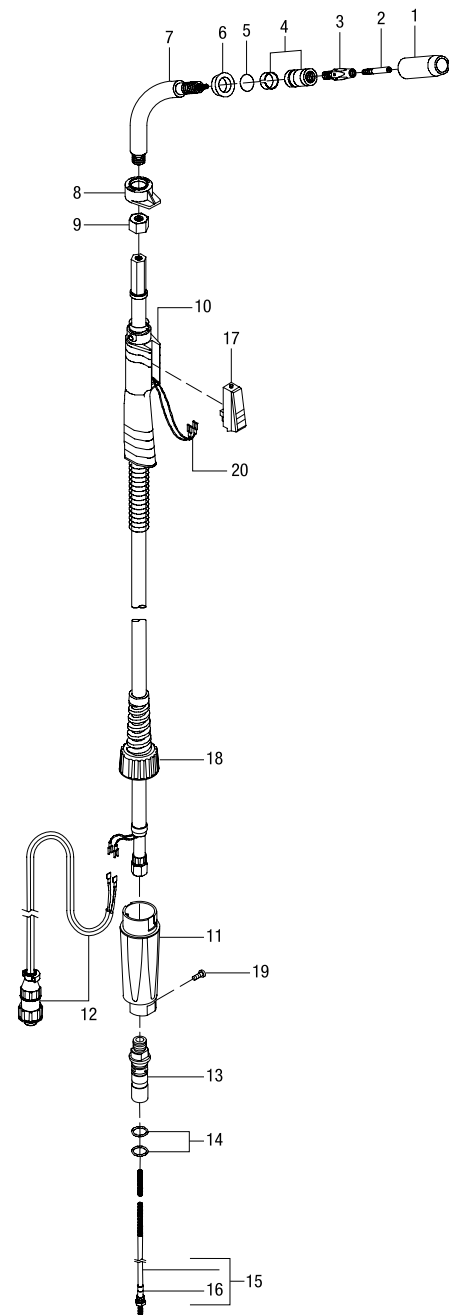
<sup>2</sup>Standard on all guns.

See page 12 for consumables kits

#### M-25 can be used on:\*

- Millermatic® 200
- Millermatic® 210/212/250x/251/252
- Millermatic® 250
- Millermatic® Vintage
- Millermatic® Reach Wire Feeder

\*For a detailed listing, please reference page 12.

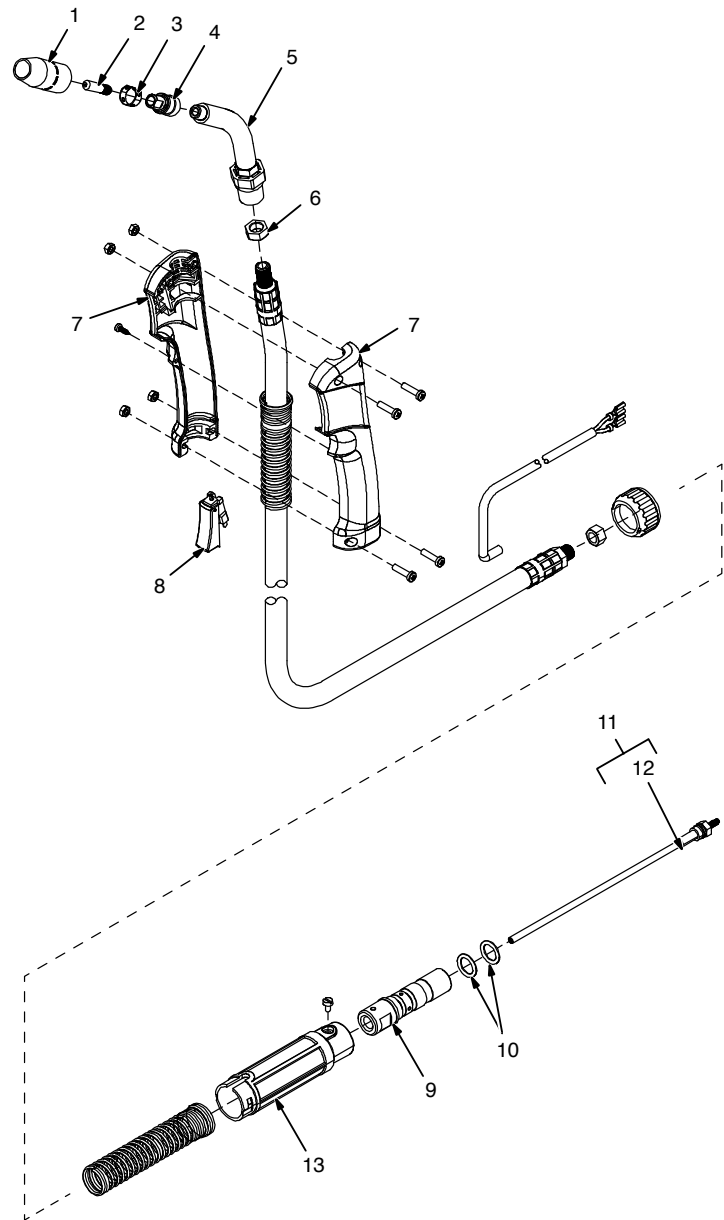


M-25 Gun

## M-80 Service Parts/Consumables

Item #	Part #	Description	Quantity
	273618	M-80 Gun, 8 ft (2.4 m), 100A, .030-.035 (0.8-0.9 mm)	
1	246372	Nozzle, slip type .500 orf flush	1
1	226190	Nozzle, flux cored slip type	1
2	087299	Tip, contact scr, .023 (0.6 mm) wire x 1.125	1
2	000067	Tip, contact scr, .030 (0.8 mm) wire x 1.125	1
2	000068	Tip, contact scr, .035 (0.9 mm) wire x 1.125	1
2	000069	Tip, contact scr, .045 (1.2 mm) wire x 1.125	1
3	170470	Ring, retaining	1
4	169716	Adapter, contact tip	1
5	246373	Tube, head	1
6	243865	Nut, jam	2
7	246082	Handle	1
8	246376	Switch, trigger	1
9	242833	Connector, feeder	1
10	079974	O-Ring, .50 ID X .103CS rbr	2
11	194010	Liner, monocoil .023/.025 (0.6 mm) wire x 15 ft (includes)	1
11	194011	Liner, monocoil .030-.035 (0.8-0.9 mm) wire x 15 ft (includes)	1
11	194012	Liner, monocoil .035-.045 (0.9-1.2 mm) wire x 15 ft (includes)	1
12	079975	O-Ring, .187 ID x .103CS rbr	1
13	246380	Housing, power pin M-100	1

See page 12 for consumables kits



## M-100/M-150

### Service Parts/Consumables

Item #	Part #	Description	Quantity	
			M-100 /	M-150
	248282	M-100 Gun, 10 ft (3 m), 100A, .030-.035 (0.8-0.9 mm)		
	249039	M-150 Gun, 10 ft (3 m), 150A, .030-.035 (0.8-0.9 mm)		
	249040	M-150 Gun, 12 ft (3.7 m), 150A, .030-.035 (0.8-0.9 mm)		
	249041	M-150 Gun, 15 ft (4.6 m), 150A, .030-.035 (0.8-0.9 mm)		
1	246372	Nozzle, slip type, .500 (12.7 mm) orf flush	1	1 (2 per pkg)
	226190	Nozzle, slip type, flux cored	1	1
2	087299	Tip, contact scr, .023 (0.6 mm) wire x 1.125	1	1 (10 per pkg)
	000067	Tip, contact scr, .030 (0.8 mm) wire x 1.125	1	1 (10 per pkg)
	000068	Tip, contact scr, .035 (0.9 mm) wire x 1.125	1	1 (10 per pkg)
	000069	Tip, contact scr, .045 (1.2 mm) wire x 1.125	1	1 (10 per pkg)
3	170470	Ring, retaining	1	1
4	169716	Adapter, contact tip	1	1 (2 per pkg)
5	246373	Tube, head	1	1
6	243865	Nut, jam	2	2
7	246082	Handle	1	1
8	246376	Switch, Blue trigger	1	1
9	079878	Housing Plug and Pins	1	1
10	242833	Connector, feeder	1	1
11	079974	O-Ring, .500 ID x .103CS rbr	2	2
12	194010	Kit, liner monocoil, .023/.025 (0.6 mm) wire x 15 ft (includes)	1	1
	194011	Kit, liner monocoil, .030-.035 (0.8-0.9 mm) wire x 15 ft (includes)	1	1
	194012	Kit, liner monocoil, .035-.045 (0.9-1.2 mm) wire x 15 ft (includes)	1	1
13	079975	O-Ring, .187 ID x .103CS rbr	1	1
14	246380	Housing, power pin	1	1

#### M-100 can be used on:\*

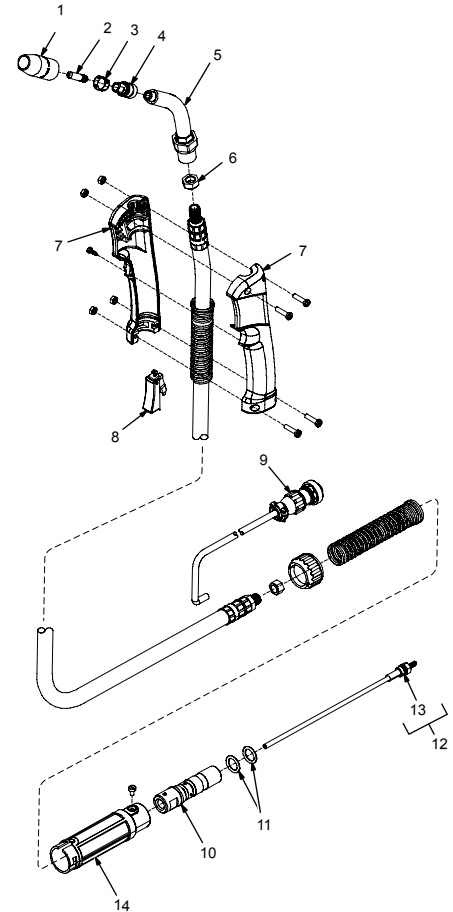
- SideKick™
- SideKick™ XL/Cricket® XL/Millermatic® 90
- Millermatic® 130
- Millermatic® 130 XP
- Millermatic® 135/140s/175/180s/DVIS®/211
- Millermatic® Challenger™
- Millermatic® Challenger™ 172
- Millermatic® Passport™/Passport™ Plus
- Millermatic® 141
- Millermatic® 190

#### M-150 can be used on:\*

- SideKick™ XL/Cricket® XL/Millermatic® 90
- Millermatic® 120/150
- Millermatic® 130
- Millermatic® 130 XP
- Millermatic® 135/140s/175/180s/DVIS®/211
- Millermatic® Challenger™
- Millermatic® Challenger™ 172
- Millermatic® 185
- Millermatic® Pulser

See page 12 for consumables kits

\*For a detailed listing, please reference page 12.



## Optional M-Series Gun Nozzles and Tips

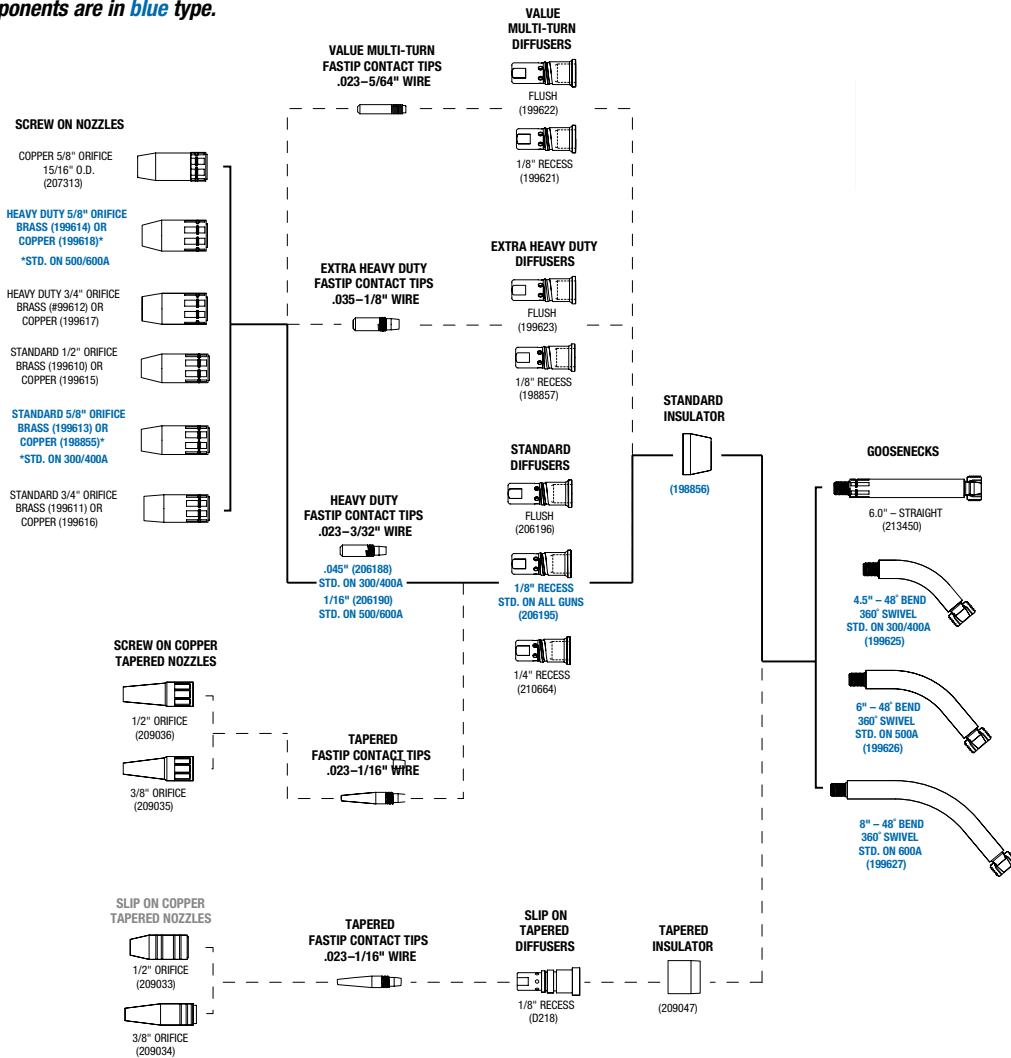
Part #	Description	Quantity
	<b>M-25 and M-40 Tapered Nozzles</b>	
176243	Nozzle, Tapered 3/8 in (9.5 mm)	1
178386	Nozzle, Tapered 11/32 in (8.7 mm)	1
	<b>M-25 and M-40 Tapered Contact Tips (1/4 in OD x 1.312 in)</b>	
176797	Contact Tip, Tapered .030 in (0.8 mm)	10
176793	Contact Tip, Tapered .035 in (0.9 mm)	10
176794	Contact Tip, Tapered .045 in (1.2 mm)	10
	<b>M-25 and M-40 Heavy-Duty Spray Contact Tips (5/16 in OD x 1.125 in)</b>	
187117	Contact Tip, Heavy Duty .035 in (0.9 mm)	25
187118	Contact Tip, Heavy Duty .045 in (1.2 mm) - N/A	25





## Roughneck® Consumables

Note: Standard gun components are in blue type.

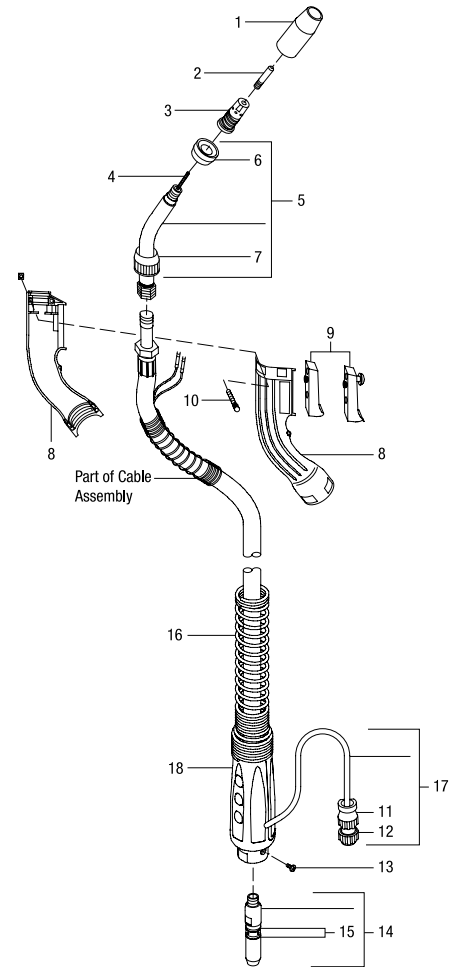


## Roughneck® Contact Tips

(10 p/pkg)	(25 p/pkg)	Description	(10 p/pkg)	(25 p/pkg)	Description
<b>Heavy-Duty FasTip™</b>			<b>Tapered FasTip™</b>		
—	206184	.023 in (0.6 mm)	—	209024	.023 in (0.6 mm)
—	206185	.030 in (0.8 mm)	—	209025	.030 in (0.8 mm)
223016	206186	.035 in (0.9 mm)	—	209026	.035 in (0.9 mm)
223017	206187	.040 in (1.0 mm)	—	209027	.045 in (1.2 mm)
223018 <sup>1</sup>	206188 <sup>1</sup>	.045 in (1.2 mm)	—	209028	3/64 in (1.2 mm)
223019	206189	.052 in (1.3 mm) or 3/64 in (1.2 mm) alum wire	—	209029	.052 in (1.3 mm)
223200 <sup>2</sup>	206190 <sup>2</sup>	1/16 in (1.6 mm)	—	209030	1/16 in (1.6 mm)
—	206191	.068 in (1.7 mm)	<b>Value Multi-Turn</b>		
—	206192	5/64 in (2.0 mm)	—	087300	.023 in (0.6 mm) - N/A
—	206193	3/32 in (2.4 mm)	—	071825	.030 in (0.8 mm)
<b>Extra Heavy-Duty FasTip™</b>			—	054202	.035 in (0.9 mm)
—	199605	.035 in (0.9 mm)	—	054201	.045 in (1.2 mm)
—	199606	.040 in (1.0 mm)	—	199593	3/64 in (1.2 mm) alum wire
—	198851	.045 in (1.2 mm)	—	047566	1/16 in (1.6 mm)
—	198852	.052 in (1.3 mm) or 3/64 in (1.2 mm) alum wire	—	199594	.068 in (1.8 mm)
—	198853	1/16 in (1.6 mm)	<sup>1</sup> Optional		
—	198854	.068 in (1.7 mm)	<sup>2</sup> For all gun lengths		
—	199609	7/64-1/8 in (2.8 mm)			

## Roughneck® C-Series Service Parts/Consumables

Item #	Part #	Description	Quantity
1	198855	Nozzle, scr type copper 5/8 in orifice	1
	199618	Nozzle, scr type copper 5/8 in orifice heavy-duty	1
2	223018	Tip, contact, .045 in (1.2 mm) heavy-duty FasTip™	1 (10 per pkg)
	206188	Tip, contact, .045 in (1.2 mm) heavy-duty FasTip™	1 (25 per pkg)
	223200	Tip, contact, 1/16 in (1.6 mm) heavy-duty FasTip™	1 (10 per pkg)
	206190	Tip, contact, 1/16 in (1.6 mm) heavy-duty FasTip™	1 (25 per pkg)
3	206195	Diffuser, gas 1/8 in tip recess – for standard and heavy-duty FasTip™	1
4	202889	Liner, monocoil .023–.030 wire x 15 ft round wound	1
	202890	Liner, monocoil .035–.045 wire x 15 ft round wound	1
	202891	Liner, monocoil .052–1/16 wire x 15 ft round wound	1
	202892	Liner, monocoil 1/16–.078 wire x 15 ft flat wound	1
	202893	Liner, monocoil 5/64–3/32 wire x 15 ft flat wound	1
	202894	Liner, monocoil 7/64–1/8 wire x 15 ft flat wound	1
	202895	Liner, monocoil 3/64–1/16 wire x 15 ft aluminum wires	1
5	199625	Gooseneck, jacketed 4.5 in/50° wrench swivel (C-30 / C-40) (includes)	1
	199626	Gooseneck, jacketed 6 in/50° wrench swivel (C-50) (includes)	1
	199627	Gooseneck, jacketed 8 in/50° wrench swivel (C-60) (includes)	1
	213450	Gooseneck, jacketed 6 in/straight (optional for C-30 / C-40 / C-50 / C-60) (includes)	1
	6	198856	Insulator, rubber
7	202292	Cover, nut	1
8	199630	Handle, small pair flared P style (C-30 / C-40 includes)	1
	199631	Handle, large pair (C-50 / C-60 includes)	1
8	199634	Screw, M3 x 11 (for 199630 C-30 / C-40 Handle only)	1
	199635	Nut, M3 Hex (for 199630 C-30 / C-40 Handle only)	1
	199632	Screw, M4 x 18	4
	199633	Nut, M4 square	4
	199647 (N/A)	Label, gun handle Miller® Roughneck	2
	9	177488	Switch, blue trigger
	MS2110 (N/A)	Switch, locking trigger (optional)	1
10	199629	Switch, contact pin	2
11	079531	Conn, circ cpc clamp str rlf size 11.453 OD	1
12	079878	Housing plug + pins (service kit)	1
13	199637	Screw, machine binding head	1
14	199640 (N/A)	Adapter, Miller® power pin (includes)	1
15	079974	O-ring, Miller® power pin	2
16	2520033	Cable Strain Relief 2 & 3 (300 Amp)	1
	2520041 (N/A)	Strain Relief Assy–Contact Bernard (400, 500, 600 Amp)	
17	GN2021	Electrical Plug–Non D/S (Includes items 11 & 12)	1
18	227650	Strain Relief, Rear (works on all Amp guns)	1



### Aluminum Adapter Kit 202895

Steel wrapped nylon liner allows 10 ft Roughneck welding guns to feed 3/64–1/16 in (1.2–1.6 mm) aluminum wire.

*Note: For a complete listing of Roughneck consumables see page 17.*

*Please see chart to the right for a complete listing of replacement Roughneck C-Series MIG Guns with Bernard BTB MIG Guns.*

### Roughneck MIG Gun Replacement

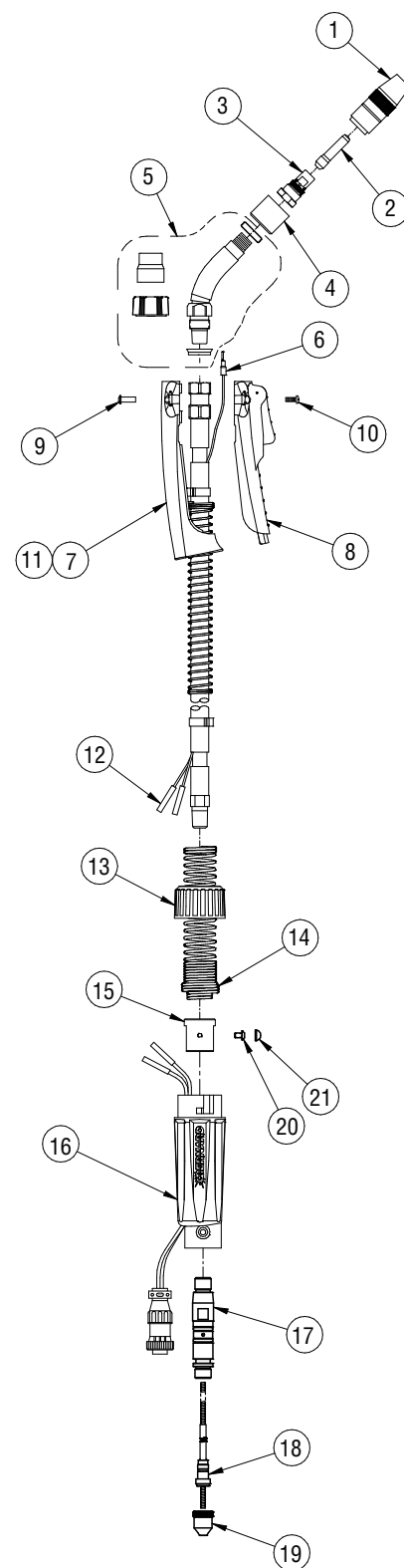
Stock No.	Model No.	Length	Replaced by Bernard BTB MIG Guns
194751	C-3010	10 ft (3m)	Q3010TE5EMC
194752	C-3012	12 ft (3.7m)	Q3015TE5EMC
194753	C-3015	15 ft (4.6m)	Q3015TE5EMC
194754	C-4010	10 ft (3m)	Q4010TE5EMC
194755	C-4012	12 ft (3.7m)	Q4015TE5EMC
194756	C-4015	15 ft (4.6m)	Q4015TE5EMC
194757	C-5010	10 ft (3m)	S5015GH5IMC
194758	C-5012	12 ft (3.7m)	S5012GH5IMC
194759	C-5015	15 ft (4.6m)	S5015GH5IMC

## Bernard™ 150 Amp MIG Gun Service Parts/Consumables

Item #	Part Q1510AB8BM	Description 150A 10 ft.
1	NS-1200B	Centerfire™ Nozzle Assy
2	T-030	Centerfire Contact Tip
3	DS-1	Centerfire Gas Diffuser
4	4523R	Cap
5	QT2-45	Neck
6	2660001	Terminal, Quick Disconnect (2 Req'd)
7	1780062	Handle Half, Lower
8	2620054	Switch Assy, Handle Half, Upper
9	4207	Post Fastener (2 Req'd)
10	4209	Handle Screw (2 Req'd)
11	1880194' (N/A)	Handle Kit - (Includes: (1) #8, (1) #9, (2) #10, (2) #11)
12	4932' (N/A)	Butt Connector (2 Req'd)
13	2520007' (N/A)	Cap, Rigid Strain Relief
14	2520048	Spring, Strain Relief
15	M1010027-1' (N/A)	Adaptor Block
16	2520047M' (N/A)	Strain Relief with Trigger Cable
17	2200137' (N/A)	Miller® Power Pin
18	194011	Kit, liner monocoil .030 – .035 (0.8 – 0.9 mm) wire x 15 ft (includes)
19	214-9' (N/A)	Miller® Power Pin Tip
20	2280065' (N/A)	Screw, Strain Relief (Not Req'd on Bernard Direct Plug)
21	1620003' (N/A)	Screw Cover, Strain Relief (1 Req'd)

<sup>1</sup>Part is only available through Bernard 1-855-MIGWELD (644-9353).

Part #	Integrated Miller® Product	Standard Configuration	Cable Length	Duty Cycle
Q1510AB8BM	Multimatic™ 200	.030 in (.8mm)	10 ft (3.05 m)	100%



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

# MIG GUNS

## Bernard™ 200 Amp BTB MIG Gun Service Parts/Consumables

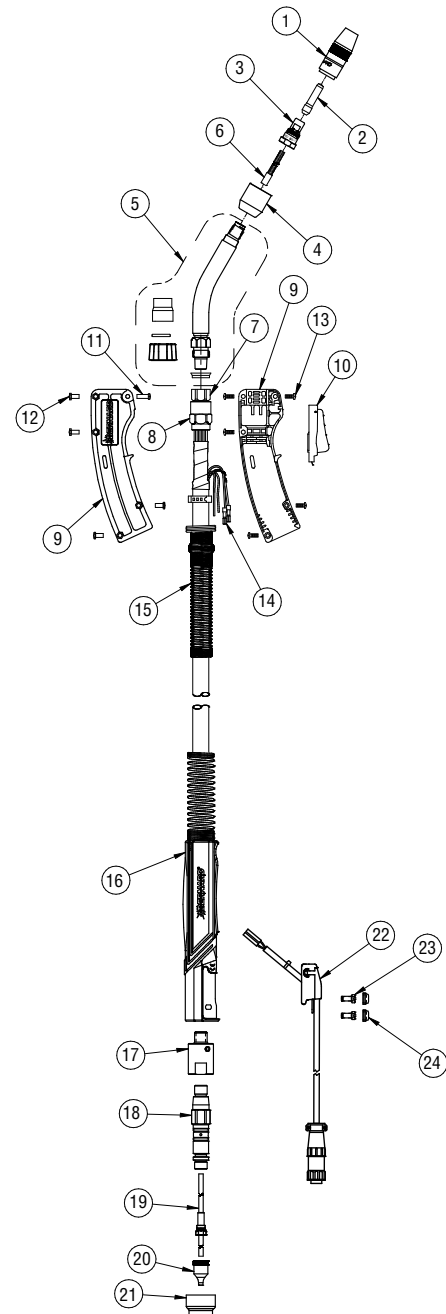
Item #	Part Q2012AD8RMC	Description
1	NS-1218B	Centerfire™ Nozzle
2	T-047AL	Centerfire Contact Tip
3	DS-1	Centerfire Gas Diffuser
4	4523R	Insulator Cap
5	QT3-30' (N/A)	Neck
6	415-25	Jump Liner
7	4213B' (N/A)	Stay-Tite™ End Fitting
8	4305' (N/A)	Stay-Tite Cone Nut
NS	4992' (N/A)	Conduit Clamp (2 Req'd)
NS	4939' (N/A)	Jacket Clamp (2 Req'd)
9	1880155	B Series Handle Kit, Standard Trigger (Includes Halves, Screws & Posts)
10	5662	Trigger, Standard
11	4207	Post Fastener (1 Req'd - Q300)
12	2030004' (N/A)	Post Fastener, Short (4 Req'd)
13	4209	Handle Screw (5 Req'd)
14	2660001	Terminal, Quick Disconnect (2 Req'd)
15	2520074' (N/A)	Handle Spring
16	410	Straight Rear Strain Relief
17	414-400' (N/A)	Adaptor Block
18	2200137' (N/A)	Miller® Power Pin Assembly
19	415-45-03	Liner, .035-3/64
20	214-9	Power Pin tip
21	414-400-20' (N/A)	Power Pin Insulator
22	1810053' (N/A)	Rear Terminal Housing/Plug
23	411-3M' (N/A)	Screw, Trigger Housing (2 Req'd)
24	1620004' (N/A)	Cover, Rear Screw (2 Req'd)

*Part is only available through Bernard 1-855-MIGWELD (644-9353).*

## 200 Amp BTB MIG Gun, Miller® Connection

Part #	Integrated Miller® Product	Standard Configuration	Cable Length	Duty Cycle
Q2012AD8RMC	Millermatic® 350P Auto Body Aluminum Package	3/64 in (1.2 mm)	12 ft (3.66 m)	100%

*Gun can be converted to run .035" (0.9 mm) wire by simply changing the contact tip.  
Duty cycle measured using CO<sub>2</sub>. Ratings with mixed gas are reduced by 10 - 50% depending on gas mixture and welding parameters.*



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit BernardWelds.com



## Bernard™ 300 Amp BTB MIG Gun Service Parts/Consumables

Item #	Part Q3015AE8XMC	Part Q3015AE8HMC	Description
1	N-5800C	NS-5818C	Centerfire™ Nozzle
2	T-045	T-052	Centerfire Contact Tip
3	D-1	DS-1	Centerfire Gas Diffuser
4	4423R	4523R	Insulator Cap
5	QT3-45		Neck
6	QJL-3545	QJL-116	Jump Liner
7	4213B		Stay-Tite™ End Fitting
8	4305		Stay-Tite™ Cone Nut
NS	4991' (N/A)		Conduit Clamp (2 Req'd)
NS	4939' (N/A)		Jacket Clamp (2 Req'd)
9	1880155		B Series Large Handle Kit, Standard
10	5662		Trigger, Standard
11	4207		Post Fastener (1 Req'd)
12	2030004' (N/A)		Post Fastener, Short (4 Req'd)
13	4209		Handle Screw (5 Req'd)
14	2660001		Terminal, Quick Disconnect (2 Req'd)
15	2520074' (N/A)		Handle Spring
16	410' (N/A)		Straight Rear Strain Relief
17	414-400' (N/A)		Adaptor Block
18	2200137' (N/A)		Miller® Power Pin Assembly
19	L3A-15 (.035-.045)	L4A-15 (.45-1/16)	Liner
20	214-116' (N/A)		Power Pin Tip <sup>2</sup>
21	414-400-20' (N/A)		Power Pin Insulator
22	1810053' (N/A)		Rear Terminal Housing/Plug
23	411-3M' (N/A)		Screw, Trigger Housing (2 Req'd)
24	1620004' (N/A)		Cover, Rear Screw (2 Req'd)

<sup>1</sup>Part is only available through Bernard 1-855-MIGWELD (644-9353).

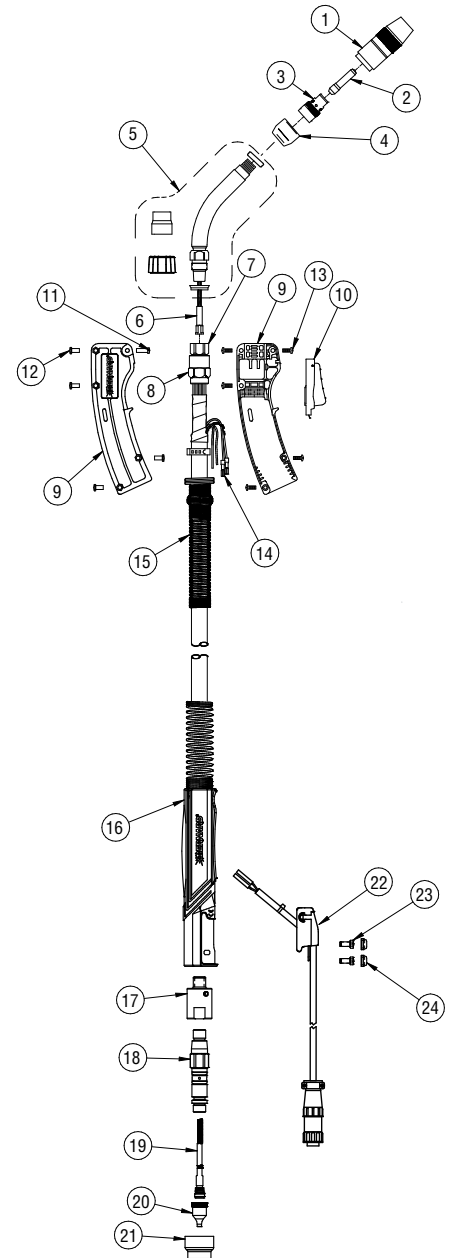
<sup>2</sup>O-Ring 079974

## 300 Amp BTB MIG Gun, Miller® Connection

Part #	Integrated Miller® Product	Standard Configuration	Cable Length	Duty Cycle
Q3015AE8XMC	22A and 24A Feeders, Millermatic® 350/350P	.045 in (1.2 mm), Flush Tip	15 ft (4.57 m)	100%
Q3015AE8HMC	Suitcase 8RC, 8VS, X-TREME 8VS, 12RC, X-TREME 12VS MIG Packages	.052 in (1.4 mm)	15 ft (4.57 m)	100%

Q3015AE8XMC can be converted to run .035" (0.9 mm) wire by simply changing the contact tip.

Q3015AE8HMC can be converted to run .045" (1.2 mm) or 1/16" (1.6 mm) wire.



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

## Bernard™ 400 Amp BTB MIG Gun with B Series Handle Service Parts/Consumables

Item #	Part Q4015AE8EMC	Description	Quantity
1	N-5818C	Centerfire™ Nozzle	
2	T-045	Centerfire Contact Tip	
3	D-1	Centerfire Gas Diffuser	
4	4423R	Insulator Cap	
5	QT3-45	Neck	
6	QJL-3545	Jump Liner	
7	4313B	Stay-Tite™ End Fitting	
8	1540003' (N/A)	Stay-Tite™ Cone Nut	
NS	4992	Conduit Clamp (2 Req'd)	
NS	4939' (N/A)	Jacket Clamp (2 Req'd)	
9	1880198	B Series Large Handle Kit, Standard	
10	5662	Trigger, Standard	
11	4207	Post Fastener (1 Req'd)	
12	4209	Handle Screw (5 Req'd)	
13	2660001	Terminal, Quick Disconnect (2 Req'd)	
14	2520042' (N/A)	Handle Spring	
15	1680088' (N/A)	End Fitting, Rear	
16	412-1' (N/A)	Switch Connector (2 Req'd)	
17	2520041' (N/A)	Spring, Strain Relief	
18	410	Straight Rear Strain Relief	
19	414-400' (N/A)	Adaptor Block	
20	2200137' (N/A)	Miller® Power Pin <sup>2</sup>	
21	414-400-20' (N/A)	Power Pin Insulator	
22	L3A-15 (.035-.045)	Liner	
23	1810053' (N/A)	Terminal Housing/Plug	
24	411-3M' (N/A)	Screw, Trigger Housing (2 Req'd)	
25	1620004' (N/A)	Screw, Cover Rear Housing (2 Req'd)	
26	214-116	Power Pin Tip	

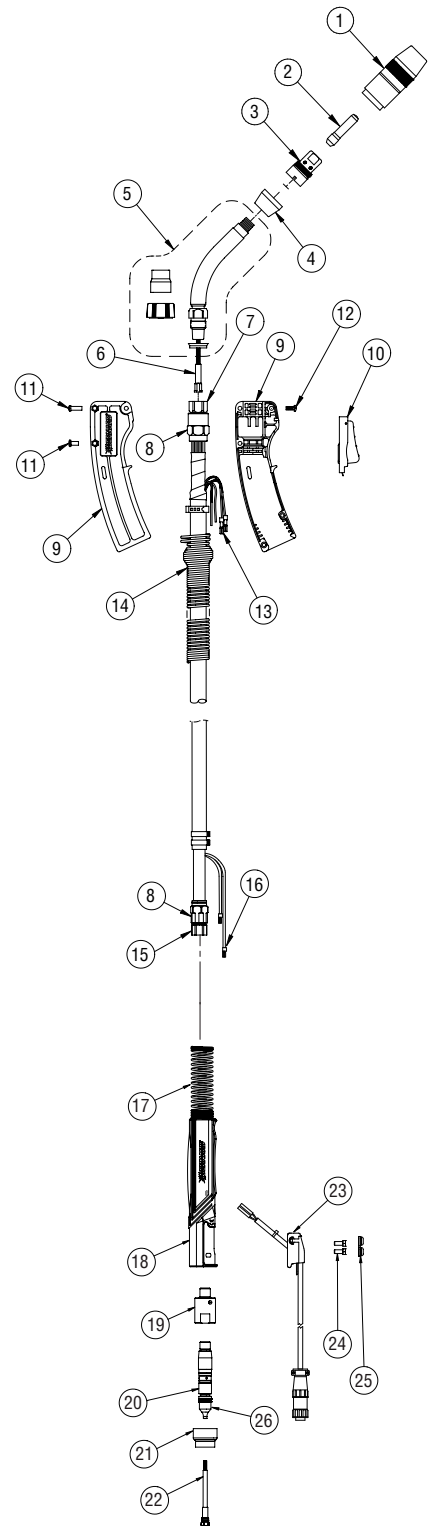
<sup>1</sup>Part is only available through Bernard 1-855-MIGWELD (644-9353).

<sup>2</sup>O-Ring 079974

## 400 Amp BTB MIG Gun, Miller® Connection

Part #	Integrated Miller® Product	Standard Configuration	Cable Length	Duty Cycle
Q4015AE8EMC	70 Series, R-115 Feeders, All Access feeders	.045 in (1.2 mm)	15 ft (4.57 m)	100%

Gun can be converted to run .035" (0.9 mm) by simply changing the contact tip.



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit BernardWelds.com



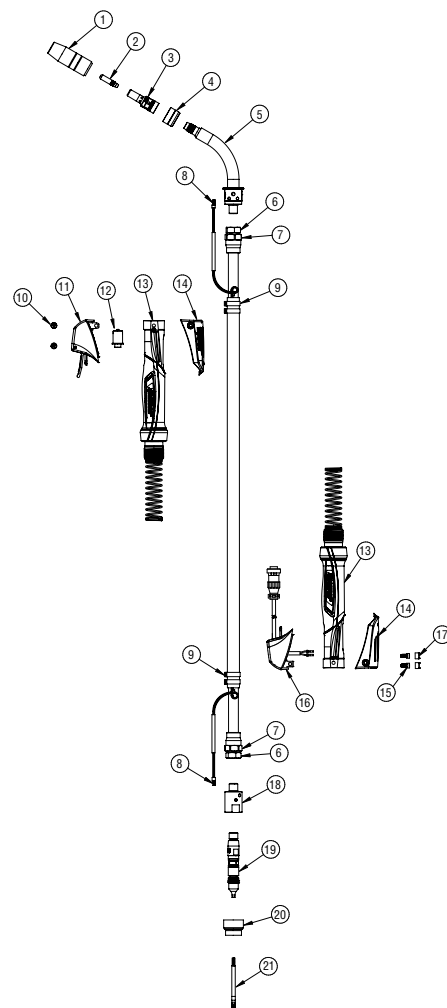
## Bernard™ 400 Amp BTB MIG Gun with C Series Handle Service Parts/Consumables

Item #	Part Q4015VS3EML	Description
1	401-6-62	Nozzle, TOUGH LOCK™ Series, Standard
2	403-20-45	Contact Tip, TOUGH LOCK, Standard Duty
3	404-26	Retaining Head, TOUGH LOCK, Standard
4	402-11	Neck Insulator, TOUGH LOCK
5	405-60CT	Neck
6	408T	End Fitting
7	409	Cone Nut
8	412-1	Switch Connector (4 Req'd)
9	4939	Jacket Clamp
NS	4992	Conduit Clamp
NS	1880263	Cable Repair Kit (Includes: (1) #6, (1) #7, (2) #8, (2) #9, (1) Conduit Clamp)
10	2280064	Screw (2 Req'd)
11	2690077	Trigger Housing, Standard
12	411-1	Switch
13	1780086	C Series Handle
14	1810046	Blank Cover
15	2280071	Screw, Rear Housing (2 Req'd)
16	1810055	Trigger Control Pod
17	1620006	Screw Cover (2 Req'd)
18	414-400C	Adaptor
19	214-81	Power Pin
20	414-400-20	Power Pin Insulator
21	415-35-15Q	QUICK LOAD™ Liner

### 400 Amp MIG Gun, Miller® Connection

Part #	Integrated Miller® Product	Standard Configuration	Cable Length	Duty Cycle
Q4015VS3EML	Continuum™ Feeders	.045 in (1.2 mm)	15 ft (4.57 m)	100%

*Gun can be converted to run .035" (0.9 mm) by simply changing the contact tip*



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

## Liners for Bernard™

200, 300, 400 & 500 Amp BTB MIG Guns  
Service Parts/Consumables

### Universal Conventional Liner Part Numbers

Wire Size	Liner Color	10' (3.05m)	15' (4.57m)
.023-.030	Yellow	--	L1A-15
.030-.035	Green	--	L2A-15' (N/A)
.035-.045	White	L3A-10** (N/A)	L3A-15*
045-1/16	Red	L4A-10*** (N/A)	L4A-15**
5/64	Blue	--	L6A-15
3/32	Grey	--	L7A-15
7/64 - 1/8	Black	--	L8A-15

\*Standard Liner for .035 & .045 Guns

\*\*Standard Liner for 1/16 Guns

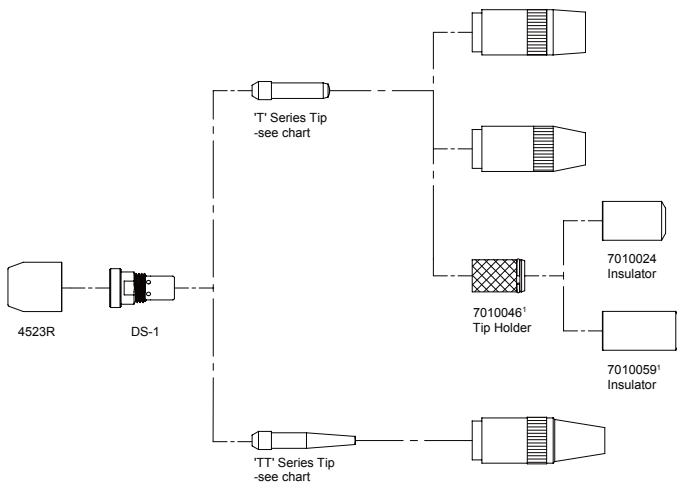
†Part is only available through Bernard 1-855-MIGWELD (644-9353).

Contact Bernard 1-855-MIGWELD (644-9353) for Optional Aluminum/Soft Wire Liners.

## Centerfire™ Consumable Series for

200, 300, 400 & 500 Amp BTB MIG Guns  
Service Parts/Consumables

### Small Centerfire™ Gas Diffusers and Nozzles

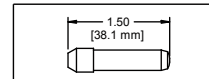


NS-5800C (5/8" I.D., Flush, Copper)  
NS-5818C (5/8" I.D., 1/8" Rec., Copper)  
NS-5800B (5/8" I.D., Flush, Brass)  
NS-5818B (5/8" I.D., 1/8" Rec., Brass)

NS-1218C (1/2" I.D., 1/8" Rec., Copper)  
NS-1200B (1/2" I.D., Flush, Brass)  
NS-1218B (1/2" I.D., 1/8" Rec., Brass)

NS-FLX Self-Shielded Conversion Kit  
(Includes tip holder and both insulators)

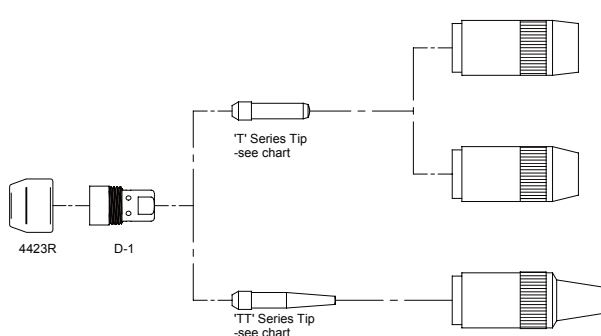
NST-3800B (3/8" I.D., Flush, Brass)  
NST-3818B (3/8" I.D., 1/8" Rec., Brass)  
NST-38XTB (3/8" I.D., 1/8" Extension, Brass)



'T' Series Tip

T-023	.023" (.6 mm)
T-030	.030" (.8 mm)
T-035	.035" (.9 mm)
T-039	.039" (1.0 mm)
T-045	.045" (1.2 mm)
T-052	.052" (1.4 mm)
T-062	1/16" (1.6 mm)
T-072	.072" (1.8 mm)
T-078	5/64" (2.0 mm)
T-094	3/32" (2.4 mm)
T-109	7/64" (2.8 mm)
T-125	1/8" (3.2 mm)

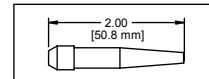
### Large Centerfire™ Gas Diffusers and Nozzles



N-3400C (3/4" I.D., Flush, Copper)  
N-3418C (3/4" I.D., 1/8" Rec., Copper)  
N-3414C (3/4" I.D., 1/4" Rec., Copper)  
N-3418B (3/4" I.D., 1/8" Rec., Brass)  
N-3414B (3/4" I.D., 1/4" Rec., Brass) - N/A

N-5800C (5/8" I.D., Flush, Copper)  
N-5818C (5/8" I.D., 1/8" Rec., Copper)  
N-5814C (5/8" I.D., 1/4" Rec., Copper)  
N-5818B (5/8" I.D., 1/8" Rec., Brass)  
N-5814B (5/8" I.D., 1/4" Rec., Brass)

NT-3800C (3/8" I.D., Flush, Copper)



'TT' Series Tip

TT-023	.023" (.6 mm)
TT-030	.030" (.8 mm)
TT-035	.035" (.9 mm)
TT-039	.039" (1.0 mm)
TT-045	.045" (1.2 mm)
TT-052	.052" (1.4 mm)
TT-062	1/16" (1.6 mm)



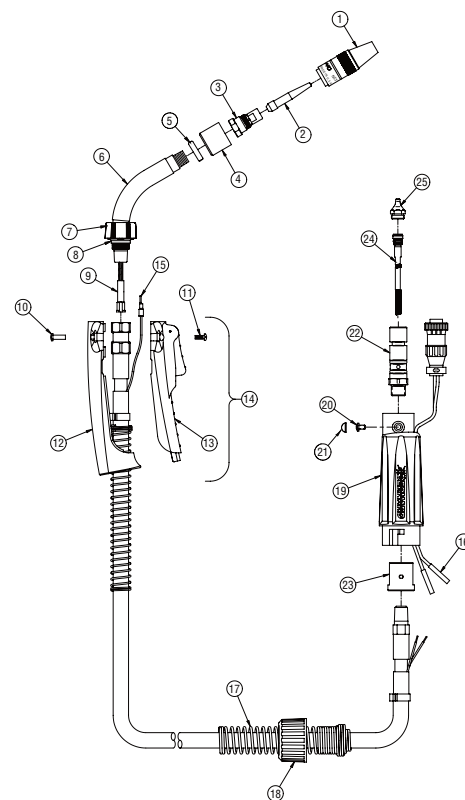
For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

## Pipeworx

### MIG Gun Part 195399 - 250 Amp 15ft Gun

Service Parts/Consumables

Item #	Part #	Description
1	NST-3800B	Centerfire™ Nozzle
2	TT-035	Centerfire Contact Tip
3	DS-1	Centerfire Gas Diffuser
4	4523R	Insulator Cap
5	1840057-2' (N/A)	Q-Nut Insulator, Front
6	QT2-60' (N/A)	Neck
7	1840057' (N/A)	Q-Neck Cover
8	1840031	Q-Neck Insulator, Rear
9	QJL-3545	Jump Liner
10	4207	Nut
11	4209	Screw
12	1780062	Handle Half, Upper
13	2620054	Lower Handle Half & Switch Assy.
14	1880194' (N/A)	Handle Kit (Includes items #10, #11, #12, #13)
15	2660001	Terminal
16	4932' (N/A)	Butt Connector
17	2520048	Spring
18	2520007' (N/A)	Strain Relief
19	2520047M' (N/A)	Strain Relief Set with plug
20	2280056'	Screw
21	1620003 (N/A)	Screw Cover
22	2200101	Cover, Rear Screw (2 Req'd)
23	1010027	Trigger Control Plug
24	L3B-15	Liner, .035-.045
25	2200135' (N/A)	Power Pin Tip

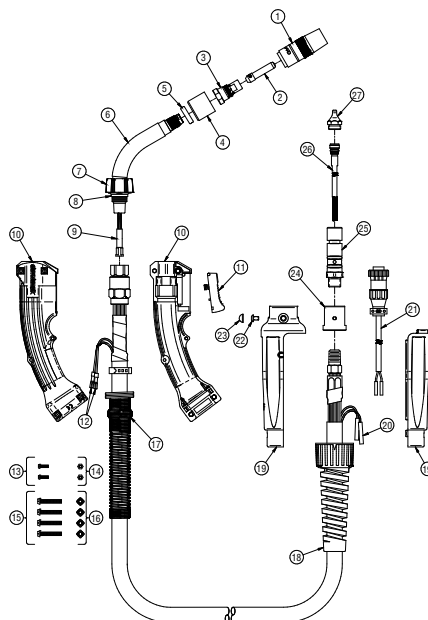


## Pipeworx

### MIG Gun Part 195400 - 300 Amp 15ft Gun

Service Parts/Consumables

Item #	Part #	Description
1	NS-5818C	Centerfire™ Nozzle
2	T-045	Centerfire Contact Tip
3	DS-1	Centerfire Gas Diffuser
4	4523R	Insulator Cap
5	1840057-2' (N/A)	Q-Nut Insulator, Front
6	QT2-60 (N/A)	Neck
7	1840057' (N/A)	Q-Neck Cover
8	1840031	Q-Neck Insulator, Rear
9	QJL-3545	Jump Liner
10	1880219' (N/A)	Handle Kit (Includes handle and items #13, #14, #15, #16)
11	177488' (N/A)	Trigger
12	177271' (N/A)	Terminal
13	2280044' (N/A)	Screw
14	2030029' (N/A)	Nut
15	203296-005	Screw
16	177272' (N/A)	Nut
17	M169700-12' (N/A)	Handle Spring
18	2520033	Strain Relief
19	2520066	Strain Relief Set
20	4932	Butt Connector
21	GN2021	Electrical Connection
22	2280056	Screw
23	1620003' (N/A)	Screw Cover
24	1010027	Adaptor Block
25	2200101	Power Pin Assy.
26	L3B-15	Liner, .035-.045
27	2200135' (N/A)	Power Pin Tip



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

<sup>1</sup>Part is only available through Bernard 1-855-MIGWELD (644-9353).



## PipePro® Dura-Flux™ XC

Service Parts/Consumables

Item #	Part 301011	Description
1	7010062	Insulator Tip
2	T1116	Contact Tip, Quik Tip™, 1/16 in (1.6 mm) (Installed On Gun)
3	1370240	Q Neck, Sleeved 6 in x 60 in deg.
4	QJL-116	Jump Liner, .045-1/16 in (Installed on Gun)
	QJL-564	Jump Liner, 5/64 in (Included with Gun)
5	1760011	Heat Shield
6	2280047' (N/A)	Screw, #8-32 x 1-1/2 (2 Req'd)
7	2030030' (N/A)	Nut, #8-32 (2 Req'd)
8	4209	Handle Screw (4 Req'd)
9	4207	Post Fastener (4 Req'd)
10	5662	Switch Assy, Trigger
11	1880256' (N/A)	Handle Kit, Dual Schedule (Includes Handle Halves)
12	2660001	Terminal, Quick Disconnect (2 Req'd)
13	2520056	Spring, Strain Relief
14	4932' (N/A)	Butt Connector, (2 Req'd)
15	1010027	Adapter Block
16	20006A	Electrical Plug - Dual Schedule
17	2520066	Rigid Strain Relief
18	2280056	Screw, Strain Relief
19	1620003' (N/A)	Screw Cover, Strain Relief
20	1880251' (N/A)	Miller® Power Pin Kit
21	2200131' (N/A)	Power Pin, Miller®
22	396' (N/A)	Set Screw, Liner
23	444710' (N/A)	Liner, .045"-1/16", 10 ft (3.05) Installed on Gun
	444815' (N/A)	Liner, 5/16", 15 ft (4.57) Included with Gun

*\*Part is only available through Bernard 1-855-MIGWELD (644-9353).  
For additional parts call Bernard at 1-855-MIGWELD (644-9353).*

## Liner Replacement Service and Instructions

### Removing Existing Liner

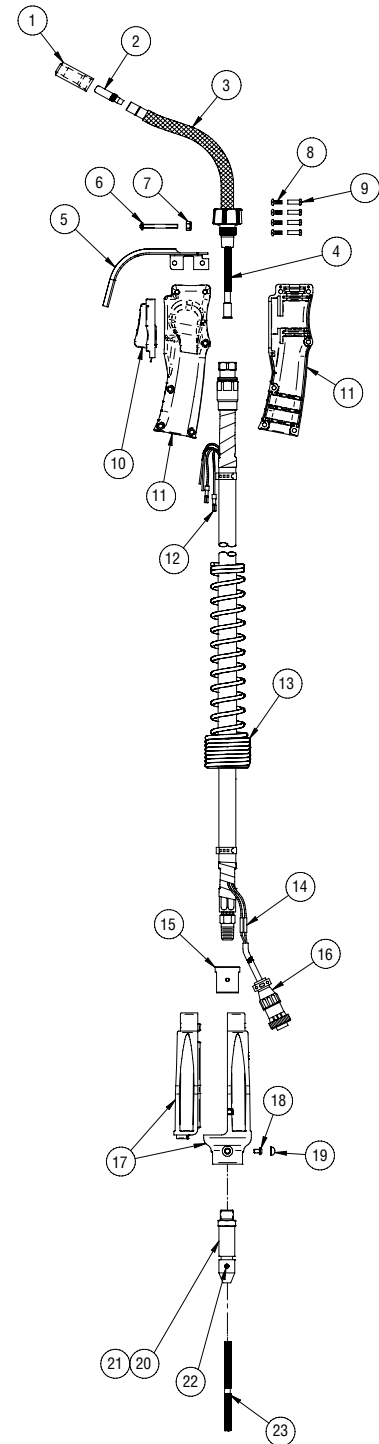
Turn off power. Remove neck from gun assembly. Lay cable straight. Loosen liner retention set screw on the power pin. Grasp liner which protrudes from power pin and remove from cable assembly.

### Install Replacement Liner

Insert liner into power pin with cable laying straight. Position the liner so that it extends approximately 1" (25.4 mm) beyond the gun handle. Tighten liner retention set screw to secure liner to cable assembly. Make sure cable is straight before trimming liner. Trim and deburr the front of the liner with 1/4" (6.4 mm) extending beyond the gun handle and reinstall neck. Trim and deburr the back end of the liner with 1/8" (3.2 mm) extending beyond the power pin.

### Service

Inspect for excessive wear and debris on the inside diameter. Do not dip liner in solvents for cleaning. Liner may be periodically blown out with shop air. Replace with new liner when excessive wear or debris produces poor electrode feed.

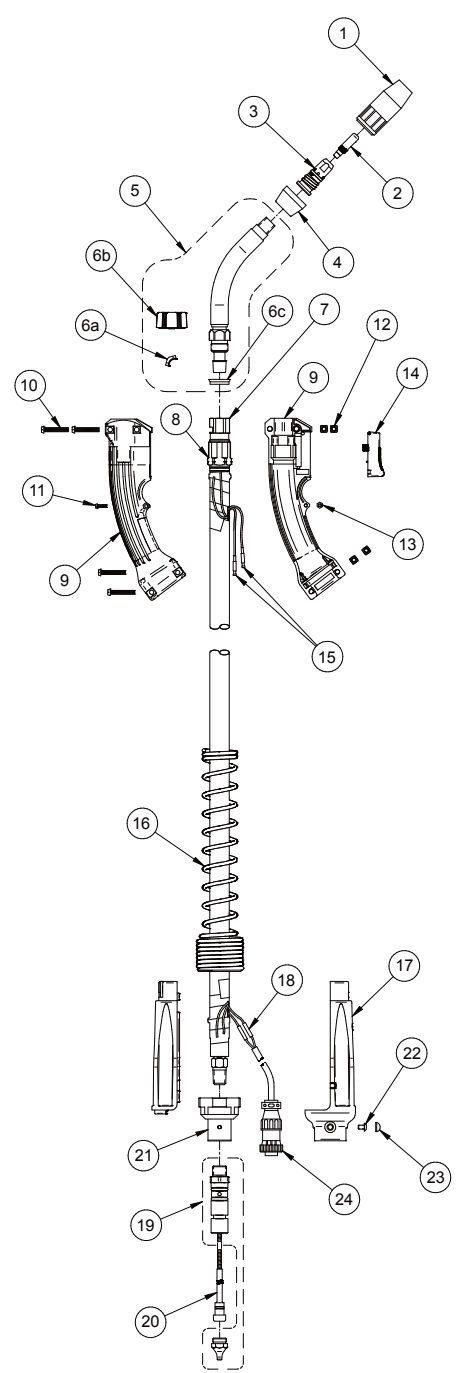


For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit BernardWelds.com



## Bernard™ S-Gun™ 250 Amp MIG Gun Service Parts/Consumables

Item #	Part S2515TE5EM	Description
1	N1C58Q' (N/A)	Nozzle Assy
2	T1045	Contact Tip, Quik Tip™, .045 in (1.2 mm) Installed on Gun
	T1052	Contact Tip, Quik Tip™, .052 in (1.4 mm) Included with gun
3	D118Q	Gas Diffuser
4	10012	Cap
5	QT3-45L' (N/A)	Neck, Rotatable/Locking, Medium
6A	1680074-2' (N/A)	End Fitting Lock (Included with Neck)
6B	1840057' (N/A)	Hand Nut (Included with Neck)
6C	1840031	Insulator (Included with Neck)
7	1680074-1' (N/A)	Stay-Tite™ End Fitting
8	1540007' (N/A)	Stay-Tite Cone Nut
NS	407709-013' (N/A)	Jacket Clamp (2 Req'd)
9	1880219' (N/A)	Handle Kit - Std. Trigger
10	203296-005	Handle Screw, Large (4 Req'd)
11	2280044' (N/A)	Handle Screw, Small
12	177272' (N/A)	Handle Nut, (4 Req'd)
13	2030029' (N/A)	Handle Nut, Small
14	177488' (N/A)	Trigger, Standard
15	177271' (N/A)	Trigger Pin (2 Req'd)
16	2520056	Spring Strain Relief
17	2520066	Strain Relief
18	4932	Butt Connector
19	1199M' (N/A)	Miller® Power Pin Assembly
20	L4A-15	Liner, .045-1/16
21	1010036' (N/A)	Adapter Block
22	2280056	Screw, Strain Relief
23	1620003' (N/A)	Screw Cover, Strain Relief
24	GN2021	Electrical Plug - Non D/S



<sup>1</sup> Part is only available through Bernard 1-855-MIGWELD (644-9353).  
 For additional parts call Bernard at 1-855-MIGWELD (644-9353).

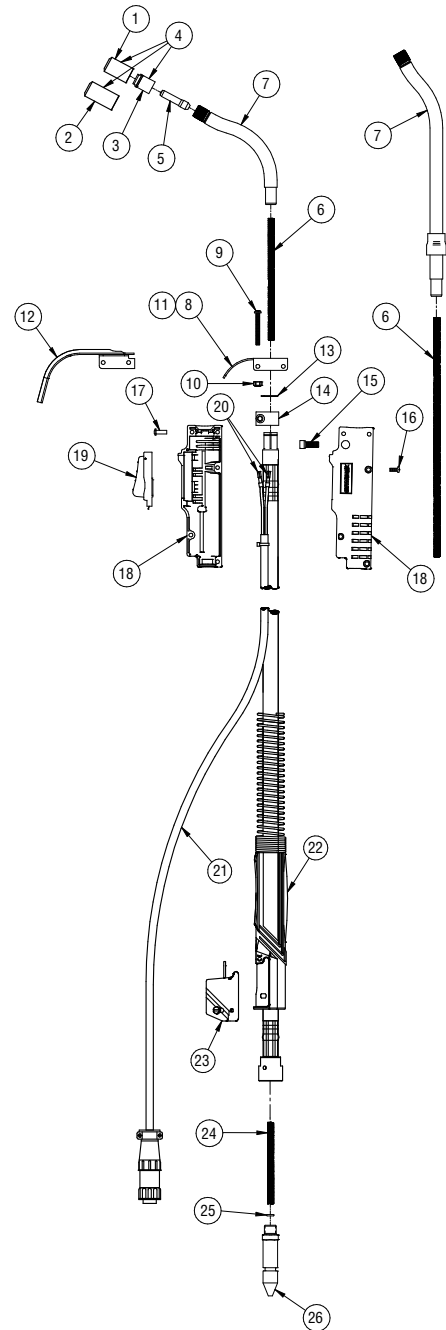


For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit [BernardWelds.com](http://BernardWelds.com)

## Bernard™ Dura-Flux™ with Fixed Power Cable Liner Service Parts/Consumables

Item #	Part # FLX3515AM	Description
1	7010024	Insulator Tip
2	7010059' (N/A)	Heavy-Duty Insulator Tip
3	7010026	Tip Holder, Slip-On
4	1880229	Tip Holder Kit (Includes: (1) #1, (1) #2, (1) #3)
5	T-062	Centerfire™ Contact Tip, 1/16" (1.6 mm) (Included w/Gun)
	T-072	Centerfire Contact Tip, .072" (1.8 mm) (Included w/Gun)
	T-078	Centerfire Contact Tip, 5/64" (2.0 mm) (Included w/Gun)
	T-094	Centerfire Contact Tip, 3/32" (2.4 mm) (Included w/Gun)
6	7010031	Neck Liner, 6" (15.2 cm)
	7010032	Neck, Liner, 12" (30.5 cm)
7		Neck Replacement Kit (Includes: (1) #6, (1) #7)
	1880232	Sleeved, 6" (15.2 cm) x 30°
	1880222	Sleeved, 6" (15.2 cm) x 60°
	1880230' (N/A)	Sleeved, 8" (20.3 cm) x 90°
	1880223	Sleeved, 12" (30.5 cm) x 30°
	1880231	Sleeved, 12" (30.5 cm) x 60°
	1880236' (N/A)	Aluminum Armored, 6" (15.2 cm) x 30°
	1880233	Aluminum Armored, 6" (15.2 cm) x 60°
	1880235	Aluminum Armored, 8" (20.3 cm) x 90°
	1880234	Aluminum Armored, 12" (30.5 cm) x 30°
	1880237' (N/A)	Aluminum Armored, 12" (30.5 cm) x 60°
8	7010034	Trigger Guard
9	2280047' (N/A)	Screw, #8-32 x 1-1/2 (2 Req'd)
10	2030030' (N/A)	Nut, #8-32 (2 Req'd)
11	1880224' (N/A)	Trigger Guard Kit (Includes: (1) #8, (2) #9, (2) #10)
12	1760002	Heat Shield (Optional)
13	2250017	Snap Ring
14	198820	Clamp
15	2280046	Screw, 1/4-20, Hex Socket
16	4209	Handle Screw (3 Req'd)
17	2030004' (N/A)	Post Fastener (3 Req'd)
18	1880225	Handle Kit (Includes: Handle Halves, (2) #9, (2) #10, (3) #16, (3) #17)
19	5662	Switch Assy, Trigger
20	2660001	Terminal, Quick Disconnect (2 Req'd)
21	7010015	Cord Assembly, 15' (4.57 m)
22	610' (N/A)	Rigid Strain Relief
23	416-15' (N/A)	Housing, Rigid Strain Relief
24	7010035	Liner, Power Pin, Miller®
25	4421' (N/A)	O-Ring
26	1880226	Miller® Power Pin Kit (Includes: Miller® Power Pin, (1) #24, (1) #25)

For additional parts call Bernard at 1-855-MIGWELD (644-9353).



For other products not listed in catalog, please contact Bernard at 1-855-MIGWELD (644-9353) or visit BernardWelds.com



# Ironmate™ Flux Cored Guns



**Ironmate™ FC-1150**  
450-Amp, Self-Shielded  
Flux Cored Welding Gun



**Ironmate™ FC-1260**  
350-Amp, Self-Shielded  
Flux Cored Welding Gun

Model	Part #	Length	Weight	Rating and Duty Cycle	Wire Size
FC-1260	195732	10 ft (3 m)	8.5 lb (3 kg)	350 A at 60% Duty Cycle	1/16–3/32 in (1.6–2.4 mm) <sup>1</sup>
	195729	15 ft (4.6 m)	11 lb (5 kg)		
FC-1260 90°	237410	10 ft (3 m)	8.5 lb (3 kg)	350 A at 60% Duty Cycle	1/16–3/32 in (1.6–2.4 mm) <sup>1</sup>
	213439	15 ft (4.6 m)	11 lb (5 kg)		
FC-1260LM	194912	10 ft (3 m)	8.5 lb (3 kg)	350 A at 60% Duty Cycle	1/16–3/32 in (1.6–2.4 mm) <sup>1</sup>
	194911	15 ft (4.6 m)	11 lb (5 kg)		
FC-1150	194864	10 ft (3 m)	9.5 lb (4.3 kg)	450 A at 60% Duty Cycle	3/32–1/8 in (2.4–3.2 mm)
	194863	15 ft (4.6 m)	12 lb (5.4 kg)		

<sup>1</sup>.035 and .045 in (0.9 and 1.2 mm) are available via optional Conversion Kit 199178.

## Consumables

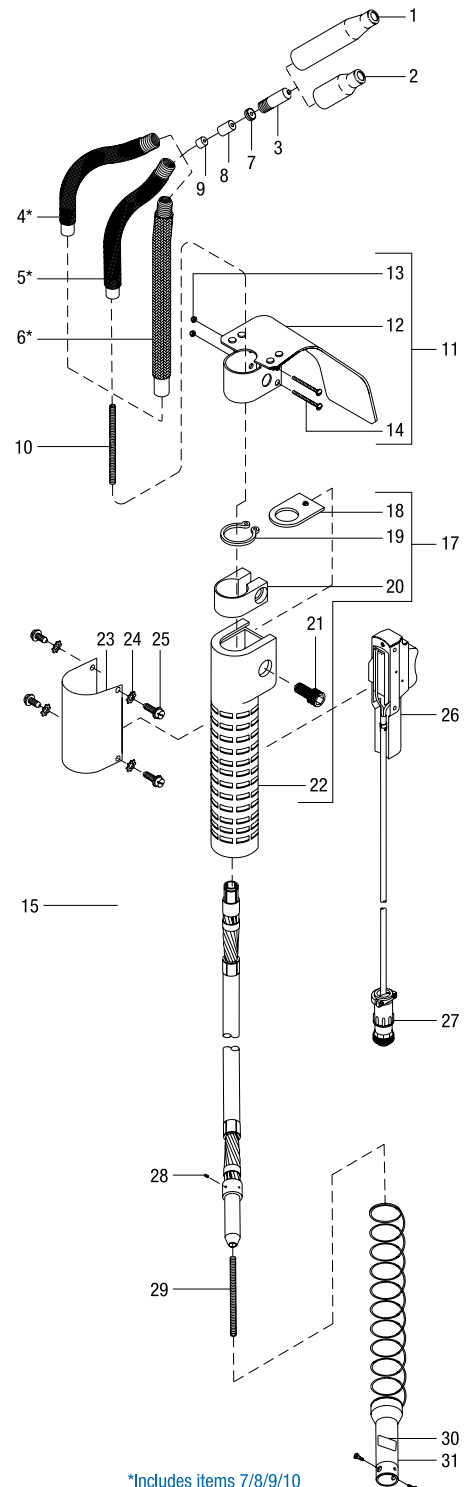
Contact Tips (25 per package)	FC-1260	FC-1150
.035 in (0.9 mm)	209248 <sup>2</sup>	—
.045 in (1.2 mm)	198784 <sup>2</sup>	—
1/16 in (1.6 mm)	198785	—
.068–.072 in (1.7–1.8 mm)	198786	—
5/64 in (2.0 mm)	198788	—
3/32 in (2.4 mm)	198790	201256
7/64 in (2.8 mm)	—	201257
.120 in (3.0 mm)	—	201258
1/8 in (3.2 mm)	—	201259
<b>Insulated Thread Protector (5 per package)</b>	198800 <sup>3</sup>	—
<b>Nozzles</b>		
Insulated Flush	198801	201261
Insulated 2 in (51 mm) Stickout	198802	—
Insulated 2-3/4 in (70 mm) Stickout	198803	201262 <sup>3</sup>
<b>Replacement Liners</b>		
1/16–3/32 in (1.6–2.4 mm) for Cable	195731	—
1/16–3/32 in (1.6–2.4 mm) for Gooseneck (Short)	198791	—
1/16–3/32 in (1.6–2.4 mm) for Gooseneck (Medium)	198792	—
1/16–3/32 in (1.6–2.4 mm) for Gooseneck (Long)	198793	—
.045 in (1.2 mm) Conversion for Cable and Gooseneck	199178	—
3/32–1/8 in (2.4–3.2 mm) for Cable	—	201246
3/32–1/8 in (2.4–3.2 mm) for Gooseneck	—	201260

<sup>2</sup>Use .045 in Conversion Kit 199178.

<sup>3</sup>Standard

Item #	Part #	Description	Quantity
1	201262	Nozzle, insulated 2-3/4 in stickout	1
2	201261	Nozzle, insulated 2 in stickout	1
3	201256	Tip, contact 3/32 in	1 (25 per pkg)
	201257	Tip, contact 7/64 in	1 (25 per pkg)
	201258	Tip, contact .120 in	1 (25 per pkg)
	201259	Tip, contact 1/8 in	1 (25 per pkg)
4	201250 <sup>1</sup>	Gooseneck, 82° bend (includes)	1
4	201251 <sup>1</sup>	Gooseneck, 82° bend, aluminum jacketed (includes)	1
5	201247	Gooseneck, 25° bend (includes)	1
5	201248 <sup>1</sup>	Gooseneck, 45° bend, (includes)	1
5	201249 <sup>1</sup>	Gooseneck, 45° bend, aluminum jacketed (includes)	1
6	201252 <sup>1</sup>	Gooseneck, straight 5° bend, (includes)	1
7	201253	Liner, locking screw 3/8 in – 16	1
8	201254	Insert, steel	1
9	201255	Insert, ceramic	1
10	201260	Liner, gooseneck replacement (short, for 6 in goose)	1
11	201245	Shield Kit, heat (consists of)	1
12	—	Shield, heat (not available separately)	1
13	198681	Nut, 008-32 .34 hex .23h stl pld elastic stop nut	2
14	135646	Screw, 008-32 x 1.50 rnd hd-phl stl pld	2
15	224083	Housing Kit with Hardware — less switch	1
16	224083	Housing assembly, trigger	1
17	194714 (N/A)	Handle Kit, assembly (consists of)	1
18	198821	Shield, spatter	1
19	081664	Ring, rtng ext .625 shaft grv x .042 thk e style	1
20	198820	Clamp	1
21	133774	Screw, cap stl sch .250-20 x .625 pld	1
22	198819	Handle	1
	000369	Switch, limit 10 amp, 125/250 VAC	1
23	198743 (N/A)	Clamp, switch housing	1
24	602202	Washer, tooth .168 id x .340 od x .023 t stl pld	4
25	070001	Screw, 008-32 x .25 hexwhd-pln stl pld	4
26	194713	Switch Kit, assembly 15 ft (consists of)	1
26	195735	Switch Kit, assembly 10 ft (consists of)	1
27	079878	Housing Plug and Pins (service kit)	1
28	198894 (N/A)	Screw, set #8-32 x .312 — liner locking	1
29	201246	Kit, replacement standard liner 15 ft (includes)	1
30	201276 (N/A)	Label, FC-1150 gun, 10 ft	1
30	201277 (N/A)	Label, FC-1150 gun, 15 ft	1
31	195733	Kit, insulator sleeve with spring and screws	1

<sup>1</sup>Optional



\*Includes items 7/8/9/10

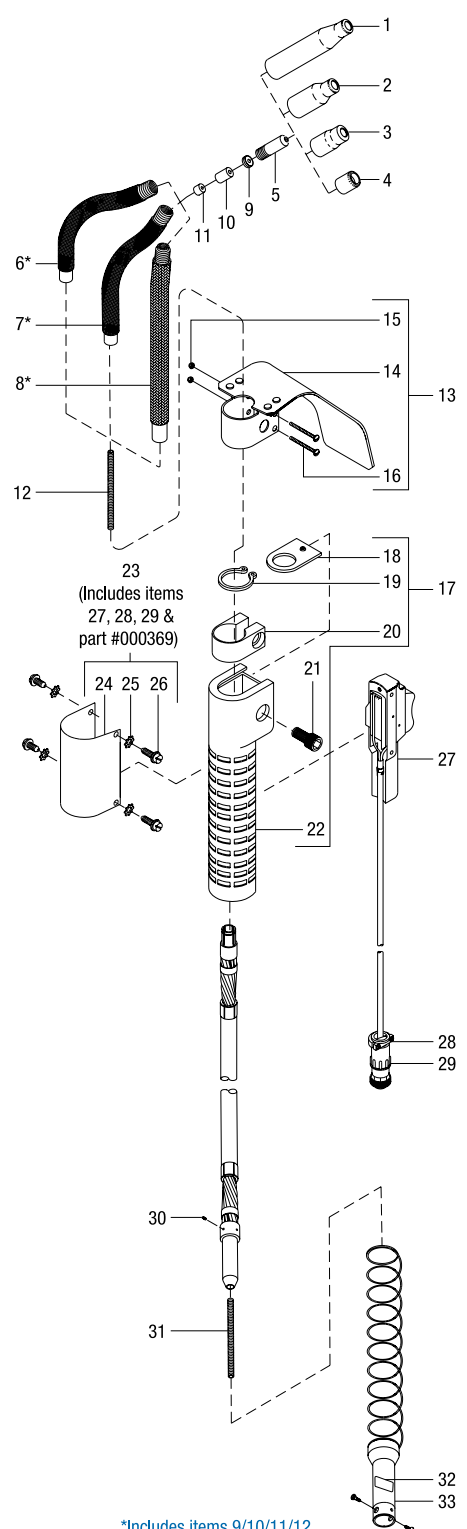
**Ironmate FC-1150 Gun**





## Ironmate™ FC-1260 and FC-1260LM Service Parts/Consumables

Item #	Part #	Description	Quantity
1	198803	Nozzle, insulated 2-3/4 in stickout	1
2	198802	Nozzle, insulated 2 in stickout	1
3	198801	Nozzle, insulated	1
4	198800 <sup>1</sup>	Protector, thread	1 (5 per pkg)
5	209248 <sup>2</sup>	Tip, contact .035 (0.9 mm)	1 (25 per pkg)
	198784 <sup>2</sup>	Tip, contact .045 (1.2 mm)	1 (25 per pkg)
	198785	Tip, contact 1/16 (1.6 mm)	1 (25 per pkg)
	198786	Tip, contact .068-.072 (1.7-1.8 mm)	1 (25 per pkg)
	198788	Tip, contact 5/64 (2.0 mm)	1 (25 per pkg)
	198790	Tip, contact 3/32 (2.4 mm)	1 (25 per pkg)
6	198794 <sup>1</sup>	Gooseneck, 6 in, 50° bend (includes)	1
	199332	Gooseneck, 6 in, 50° bend, aluminum jacketed (includes)	1
	198795	Gooseneck, 12 in, 50° bend (includes)	1
	199333	Gooseneck, 12 in, 50° bend, aluminum jacketed (includes)	1
	198798	Gooseneck, 6 in, 90° bend (includes)	1
	199334	Gooseneck, 6 in, 90° bend, aluminum jacketed (includes)	1
7	198796	Gooseneck, 6 in, 30° bend (includes)	1
	199335	Gooseneck, 6 in, 30° bend, aluminum jacketed (includes)	1
	198797	Gooseneck, 12 in, 30° bend (includes)	1
	199336	Gooseneck, 12 in, 30° bend, aluminum jacketed (includes)	1
8	198799	Gooseneck, 8 in in straight with 5° bend (includes)	1
9	198752 <sup>3</sup>	Liner, locking screw 5/16 in-18	1
10	198758 <sup>3</sup>	Insert, steel	1
11	198806 <sup>3</sup>	Insert, ceramic	1
12	198791	Liner, gooseneck replacement (short, for 6 in goose)	1
	198792	Liner, gooseneck replacement (med, for 8 in goose)	1
	198793	Liner, gooseneck replacement (long, for 12 in goose)	1
13	194712	Shield Kit, heat (consists of)	1
14	—	Shield, heat (not available separately)	1
15	198681	Nut, 008-32 .34 hex .23h stl pld elastic stop nut	2
16	135646	Screw, 008-32 x 1.50 rnd hd-phl stl pld	2
17	194714 (N/A)	Handle Kit, assembly (consists of)	1
18	198821	Shield, spatter	1
19	081664	Ring, rtng ext .625 shaft grv x .042 thk e style	1
20	198820	Clamp	1
21	133774	Screw, cap stl sch .250-20 x .625 pld	1
22	198819	Handle	1
23	194713	Switch Kit, assembly 15 ft (consists of)	1
	195735	Switch Kit, assembly 10 ft (consists of)	1
24	198743 (N/A)	Clamp, switch housing	1
25	602202	Washer, tooth .168 id x .340 od x .023 t stl pld	4
26	070001	Screw, 008-32 x .25 hexwhd-pln stl pld	4
27	224083	Aluminum Housing Kit with Hardware — less switch	1
28	079531	Conn, circ cpc clamp str rlf size 11 .453 od	1
29	079878	Housing Plug and Pins (service kit)	1
	000369	Switch, limit 10 amp, 125/250 VAC	1
30	198894 (N/A)	Screw, set #8-32 x .312 — liner locking	1
31	195731	Kit, replacement standard liner 15 ft (includes)	1
	199178	Kit, .045 conversion monocoil liner 15 ft (includes)	1
	166575	Wrench, hex .078 across flat	1
32	198759 (N/A)	Label, FC-1260 gun, 10 ft	1
	198767 (N/A)	Label, FC-1260 gun, 15 ft	1
33	195733	Kit, insulator sleeve with spring	1
	202295	Insulator, phenolic (FC-1260LM only)	1
	202294	Adapter, Miller® feeder (FC-1260LM only)	1
	202692	Adapter, Miller® to Lincoln trigger leads (FC-1260LM only)	1



\*Includes items 9/10/11/12

**Ironmate FC-1260 Gun**

<sup>1</sup>Standard  
<sup>2</sup>Use .045 in Conversion Kit  
<sup>3</sup>Items recessed in Gooseneck  
**Note: Each Gooseneck includes locking screw liner, inserts, and appropriate gooseneck liner.**

## Hobart MIG Gun History

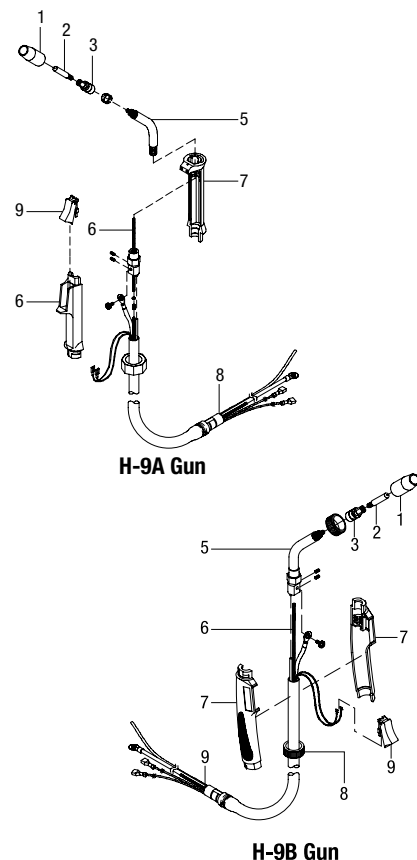
Machine	Spec # / Stock #	Original Gun	Recommended Replacement Gun
Handler®	6969-1	GAL-90	Bernard TGX Series XS1815 and 2200143 Power Pin <sup>1</sup>
	All Other 6969 Series	GAL-100	Bernard TGX Series XS1815 and 2200143 Power Pin <sup>1</sup>
Handler® 120	7144-1 and 71441A-1	GAL-100	Bernard TGX Series XS1815 and 2200143 Power Pin <sup>1</sup>
	All Other	Piecemaker® 14-A	Bernard TGX Series XS1815 and 2200143 Power Pin <sup>1</sup>
Handler® 125	All	H-9A, pg 32; H-9, pg 32	H-9 195157R, pg 32
Handler® 125EZ	All	H-9A, pg 32	H-9 195157R, pg 32
Handler® 130	All	H-9B, pg 32	H-9B 195157R,pg 32
Handler® 130XL	All	GA-16CA	H100S2-10 245924, pg 34 Plus Gun connector 193189
Handler® 135/140	All	H-10, pg 33	H100S2-10 245924, pg 34
Handler® 150	All	Piecemaker® 14-A	Bernard TGX Series XS1815 and 2200143 Power Pin <sup>1</sup>
Handler® 175/180	All	H-10, pg 33	H100S2-10 245924, pg 34
Handler® 187	All	H-10, pg 33	H100S2-10 245924, pg 34
Handler® 190	All	H100S4-10, pg 34	H100S4-10 245926, pg 34
Handler® 210	All	H-14, pg 33	H100S4-10 245926, pg 34
Handler® 210MVP	All	H100S4-10, pg 34	H100S4-10 245926, pg 34
IronMan™ 210	All	M-10, pg 13	M-100 248282 and M-150 249039, 249040, 249041, pg 16
IronMan™ 230	All	H200L4-15, pg 35	H200L4-15 239173, pg 35
IronMan™ 250/270	All	M-25, pg 14	M-25, pg 14
Trek 180	All	H100L4-10, pg 35	H100L4-10 243864, pg 35

<sup>1</sup>Part is only available through Bernard 1-855-MIGWELD (644-9353).

## H-9A/9B Service Parts/Consumables

Item #	Part H-9A*	Part H-9B	Description	Quantity
	195157R	—	H-9A Gun 8 ft (2.4 m), 100 A, .030-.035 (0.8-0.9 mm)	
	—	195157R	H-9B Gun 8 ft (2.4 m), 100 A, .030-.035 (0.8-0.9 mm)	
1	169715	169715	Nozzle, slip type .500 (12.7 mm) or flush	1 (2 per pkg)
	226190	226190	Nozzle, slip type flux cored	1 (1 per pkg)
2	087299 <sup>1</sup>	087299 <sup>1</sup>	Tip, contact scr .023 (0.6 mm) wire x 1.125	1 (10 per pkg)
	000067	000067	Tip, contact scr .030 (0.8 mm) wire x 1.125	1 (10 per pkg)
	000068	000068 <sup>1</sup>	Tip, contact scr .035 (0.9 mm) wire x 1.125	1 (10 per pkg)
3	169716	169716	Adapter, contact tip	1 (2 per pkg)
4	170470	—	Ring, retaining	1
5	210969 (N/A)	226079	Tube, head	1
6	210970	210970	Kit, liner, monocoil .023-.035 (0.6-0.9 mm) wire x 8 ft	1
7	211450 (N/A)	226080	Handle Assembly	1
8	—	226010	Nut, liner retainer	2
9	—	225410	Switch, trigger	1

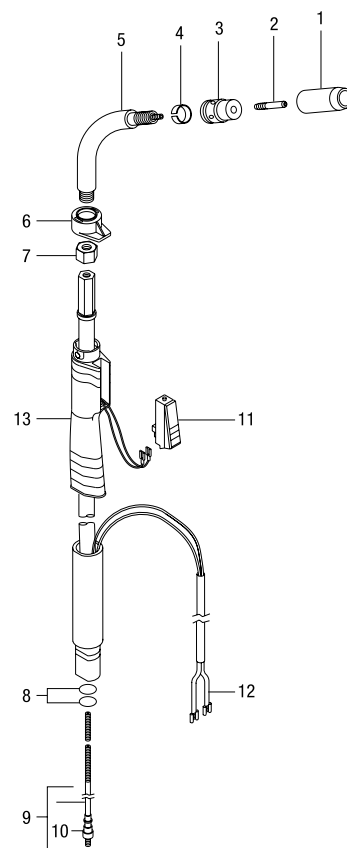
<sup>1</sup>Optional \*H9B replaces H9A



## H-10 Service Parts/Consumables

Item #	Part #	Description	Quantity
	<b>245924</b>	H-10 Gun 10 ft (3 m), 100 A, .030-.035 (0.8-0.9 mm)	
1	<b>169715</b>	Nozzle, slip type .500 (12.7 mm) orf flush	1 (2 per pkg)
	<b>226190</b>	Nozzle, slip type flux cored	1 (1 per pkg)
2	<b>087299<sup>1</sup></b>	Tip, contact scr .023 (0.6 mm) wire x 1.125	1 (10 per pkg)
	<b>000067</b>	Tip, contact scr .030 (0.8 mm) wire x 1.125	1 (10 per pkg)
	<b>000068</b>	Tip, contact scr .035 (0.9 mm) wire x 1.125	1 (10 per pkg)
	<b>000069<sup>1</sup></b>	Tip, contact scr .045 (1.2 mm) wire x 1.125	1 (10 per pkg)
3	<b>169716</b>	Adapter, contact tip	1 (2 per pkg)
4	<b>170470</b>	Ring, retaining	1
5	<b>169718</b>	Tube, head	1
6	<b>169738</b>	Nut, locking handle	1
7	<b>194524</b>	Nut, jam	1
8	<b>197123</b>	O-Ring, .312 ID x .062 70 Duro BUNA-N	2
9	<b>194010<sup>1</sup></b>	Kit, liner, monocoil .023 - .025 (0.6 mm) wire x 15 ft (includes)	1
	<b>194011</b>	Kit, liner, monocoil .030 - .035 (0.8 - 0.9 mm) wire x 15 ft (includes)	1
	<b>194012<sup>1</sup></b>	Kit, liner, monocoil .035 - .045 (0.9 - 1.2 mm) wire x 15 ft (includes)	1
10	<b>079975</b>	O-Ring, .187 ID x .103CS rbr	1
11	<b>227798</b>	Switch, trigger	1
12	<b>604464</b>	Terminals, friction	2
13	<b>169737</b>	Handle	1
	<b>209494</b>	Power Pin	1

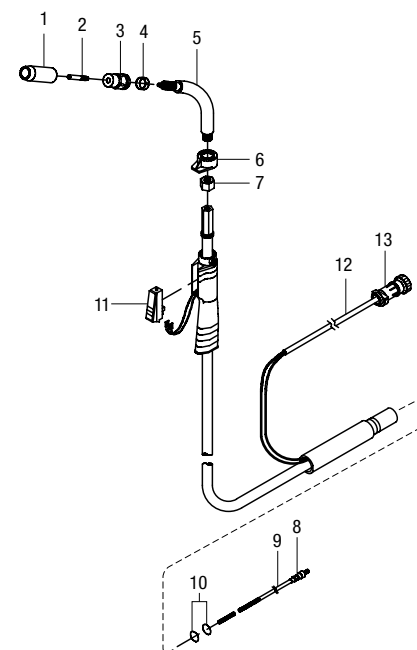
<sup>1</sup>Optional



## H-14 Service Parts/Consumables

Item #	Part #	Description	Quantity
	<b>231204</b>	H-14 Gun 10 ft (3 m), 100 A, .030-.035 (0.8-0.9 mm)	
1	<b>169715</b>	Nozzle, slip type .500 (12.7 mm) orf flush	1 (2 per pkg)
	<b>226190</b>	Nozzle, slip type flux cored	1 (1 per pkg)
2	<b>087299<sup>1</sup></b>	Tip, contact scr .023 (0.6 mm) wire x 1.125	1 (10 per pkg)
	<b>000067</b>	Tip, contact scr .030 (0.8 mm) wire x 1.125	1 (10 per pkg)
	<b>000068</b>	Tip, contact scr .035 (0.9 mm) wire x 1.125	1 (10 per pkg)
3	<b>169716</b>	Adapter, contact tip	1 (2 per pkg)
4	<b>170470</b>	Ring, retaining	1
5	<b>169718</b>	Tube, head	1
6	<b>169738</b>	Nut, locking handle	1
7	<b>169719</b>	Nut, jam	1
8	<b>079975</b>	O-Ring, .187 ID x .103CS rbr	1
9	<b>194010<sup>1</sup></b>	Kit, liner, monocoil .023 - .025 (0.6 mm) wire x 15 ft (includes)	1
	<b>194011</b>	Kit, liner, monocoil .030 - .035 (0.8 - 0.9 mm) wire x 15 ft (includes)	1
	<b>194012<sup>1</sup></b>	Kit, liner, monocoil .035 - .045 (0.9 - 1.2 mm) wire x 15 ft (includes)	1
	<b>194014<sup>1</sup></b>	Kit, liner, monocoil .023 - .035 (0.6 - 0.9 mm) wire x 15 ft (includes)	1
10	<b>079975</b>	O-Ring, .187 ID x .103CS rbr	1
11	<b>227798</b>	Switch, trigger	1
12	<b>227800</b>	Cord, trigger assembly	1
13	<b>079878</b>	Housing Plug & Pins	1
	<b>209494</b>	Power Pin	1

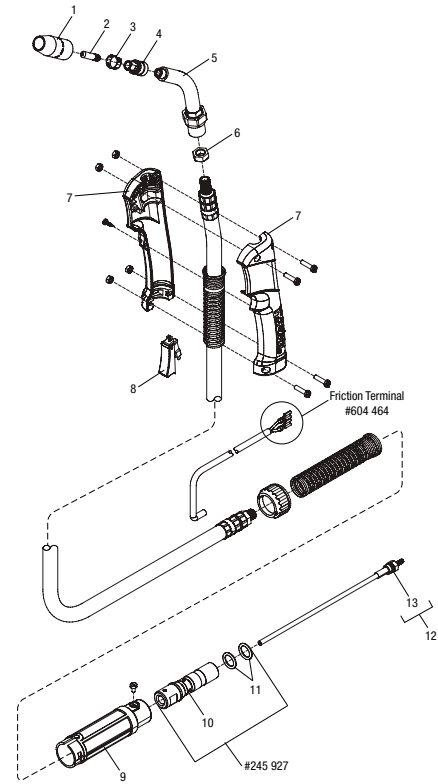
<sup>1</sup>Optional



## H100S2-10 Service Parts/Consumables

Item #	Part #	Description	Quantity
	245924	H100S2-10 Gun .30-.035 10 ft	1
1	169715	Nozzle, slip type .500 orf flush	1
	226190	Nozzle, flux cored slip type	1
2	087299 <sup>1</sup>	Tip, contact scr .023 (0.6 mm) wire x 1.125	1
	000067 <sup>1</sup>	Tip, contact scr .030 (0.8 mm) wire x 1.125	1
	000068 <sup>1</sup>	Tip, contact scr .035 (0.9 mm) wire x 1.125	1
	000069 <sup>1</sup>	Tip, contact scr .045 (1.2 mm) wire x 1.125	1
3	170470	Ring, retaining	1
4	169716	Adapter, contact tip	1
5	246373	Tube, head	1
6	243865	Nut, jam	1
7	242832	Handle	1
8	225410	Switch, trigger	1
9	246380	Housing, power pin	1
10	245927	Connector, feeder	1
11	197123	O-Ring, .312 ID x .062 70 duro buna-n	1
12	194010 <sup>1</sup>	Liner, monocoil .023 – .025 wire x 15 ft (consisting of)	1
	194011 <sup>1</sup>	Liner, monocoil .030 – .035 wire x 15 ft (consisting of)	1
	194012 <sup>1</sup>	Liner, monocoil .035 – .045 wire x 15 ft (consisting of)	1
13	079975	O-Ring, .187 ID x .103CS rbr	1

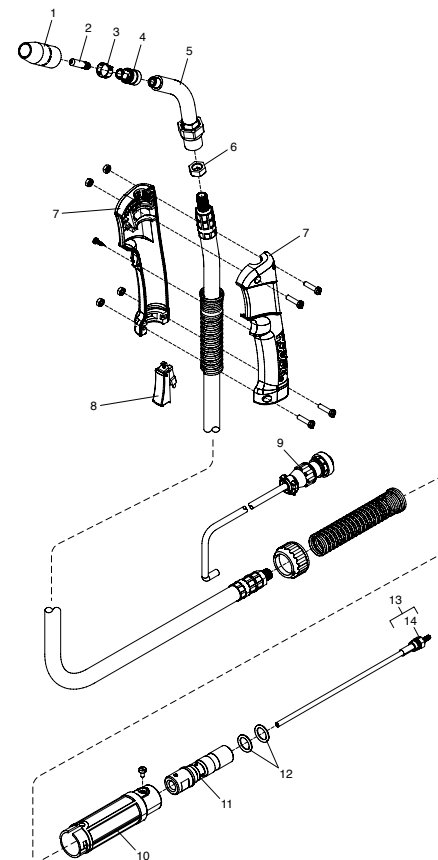
<sup>1</sup> Optional



## H100S4-10 Service Parts/Consumables

Item #	Part #	Description	Quantity
	245926	H100S4-10	
1	169715	Nozzle, slip type .500 (12.7 mm) orf flush	1 (2 per pkg)
	226190	Nozzle, slip type flux cored	1 (1 per pkg)
2	087299 <sup>1</sup>	Tip, contact scr .023 (0.6 mm) wire x 1.125	1 (10 per pkg)
	000067	Tip, contact scr .030 (0.8 mm) wire x 1.125	1 (10 per pkg)
	000068 <sup>1</sup>	Tip, contact scr .035 (0.9 mm) wire x 1.125	1 (10 per pkg)
	000069 <sup>1</sup>	Tip, contact scr .045 (1.2 mm) wire x 1.125	1 (10 per pkg)
3	170470	Ring, retaining	1
4	169716	Adapter, contact tip	1 (2 per pkg)
5	246373	Tube, head	1
6	243865	Nut, jam	1
7	242832	Handle	1
8	225410	Switch, trigger	1
9	079878	Housing plug and pins	1
10	246380	Housing, power pin	1
11	245927	Connector, feeder	1
12	197123	O-Ring, .312 ID x .062 duro buna-n	2
13	194010 <sup>1</sup>	Kit, liner, monocoil .023 – .025 (0.6 mm) wire x 15 ft	1
	194011	Kit, liner, monocoil .030 – .035 (0.8 – 0.9 mm) wire x 15 ft	1
	194012 <sup>1</sup>	Kit, liner, monocoil .035 – .045 (0.6 – 0.9 mm) wire x 15 ft	1
	079975	O-Ring, .187 ID x .103CS rbr	1

<sup>1</sup> Optional



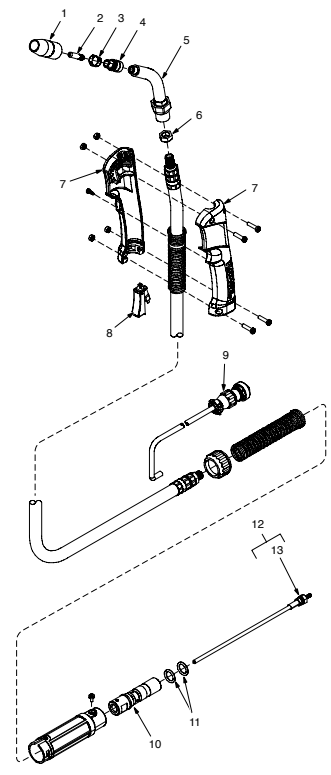


## H100L4-10

### Service Parts/Consumables

Item #	Part #	Description	Quantity
	243864	H100L4-10 Gun 10 ft (3 m), 100 A, .030-.035 (0.8-0.9 mm)	1
1	169715	Nozzle, slip type, .500 orf flush	1
	226190 <sup>1</sup>	Nozzle, flux cored slip type	1
2	087299 <sup>1</sup>	Tip, contact scr .023 wire x 1.125	1
	000067 <sup>1</sup>	Tip, contact scr .030 wire x 1.125	1
	000068 <sup>1</sup>	Tip, contact scr .035 wire x 1.125	1
	000069 <sup>1</sup>	Tip, contact scr .045 wire x 1.125	1
3	170470	Ring, retaining	1
4	169716	Adapter, contact tip	1
5	242831	Tube, head	1
6	243865	Nut, jam	1
7	242832	Handle	1
8	225410	Switch, trigger	1
9	079878	Housing plug & pins	1
10	242833	Connector, feeder	1
11	079974	O-Ring, .500 ID x .103CS rbr	2
12	194010 <sup>1</sup>	Liner, monocoil .023/.025 wire x 15 ft (consisting of)	1
	194011 <sup>1</sup>	Liner, monocoil .030/.035 wire x 15 ft (consisting of)	1
	194012 <sup>1</sup>	Liner, monocoil .035/.045 wire x 15 ft (consisting of)	1
13	079975	O-Ring, .187 ID x .103CS rbr	1

<sup>1</sup>Optional

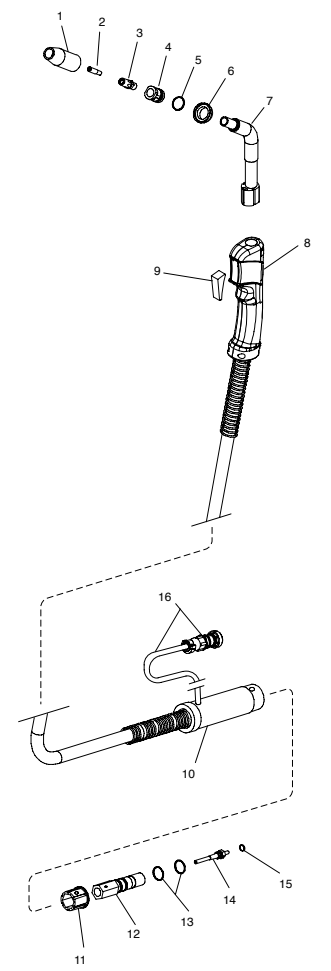


## H200L4-15

### Service Parts/Consumables

Item #	Part #	Description	Quantity
	239173	H200L4-10 Gun 15 ft (4.6 m), 200 A, .030-.035 (0.8-0.9 mm)	1
1	200258	Nozzle, slip type, .500 orf flush	1
	169724 <sup>1</sup>	Nozzle, slip type, .500 orf .125 recess	1
	169725 <sup>1</sup>	Nozzle, slip type, .625 orf .125 recess	1
	169726 <sup>1</sup>	Nozzle, slip type, .625 orf flush	1
	169727 <sup>1</sup>	Nozzle, slip type, .625 orf .125 stitch out	1
2	087299 <sup>1</sup>	Tip, contact scr .023 wire x 1.125	1
	000067 <sup>1</sup>	Tip, contact scr .030 wire x 1.125	1
	000068 <sup>1</sup>	Tip, contact scr .035 wire x 1.125	1
	000069 <sup>1</sup>	Tip, contact scr .045 wire x 1.125	1
3	169728	Adapter, contact tip	1
4	169729	Adapter, nozzle w/retaining ring	1
5	170468	O-Ring	1
6	169730	Washer, shock	1
7	242585	Tube head assembly	1
8	242635	Handle, front H-20 welding gun	1
9	225410	Switch, trigger	1
10	242597	Handle, rear H-20 welding gun	1
11	242598	Collar, adapter feeder connector	1
12	242604	Connector, feeder H-20 welding gun	1
13	079974	O-Ring, .500 ID x .103 cs rbr	1 (2 per pkg)
14	194010	Liner, monocoil .023/.025 wire x 15 ft (consisting of)	1
	194011	Liner, monocoil .030/.035 wire x 15 ft (consisting of)	1
	194012	Liner, monocoil .035/.045 wire x 15 ft (consisting of)	1
15	079975	O-Ring, .187 ID x .103CS rbr	1
16	227800	Cord, trigger assembly	1

<sup>1</sup>Optional





## Milleromatic Service Parts

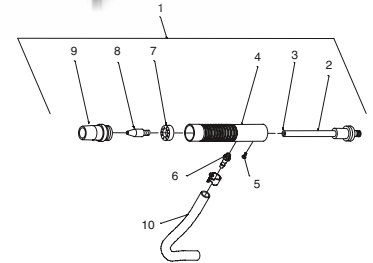
Model	Serial # Effective	On/Off Switch #	Contact #	Gas Valve #	Wire Speed Pot/Rheostat #	Wire Speed Knob #	Fan Motor #	Fan Blade #	Drive Motor #	CR-1 Relay #	Range Switch #
Challenger™	KG171523	116830	252676	218422	—	097922	495429	005656	173446	—	—
Challenger™ 172	KH511668	116830	252676	218422	See Manual	097922	495429	005656	186212	006393	250658
MM 90/130	KB102926	111997 (115 V)	252676	218421	—	097922	111931	005656	173446	006393	—
		116830 (230 V)									
MM 120/150	KB100704	116830	252676	218422	072623	097922	495429	005656	090087	072817	—
MM 130 XP	KH418495	111997	252676	218421	186207	097922	495428	005656	186212	See Manual	250658
MM 135	LB204281	196575	—	218421	See Manual	171007	196063	409953-001	202708	—	202663
MM 140/	LG320643	196575	—	218421	207415	171007	196063	409953-001	202708	—	202663
140 with Auto-Set™											
MM 175	LB204053	196574	—	218422	See Manual	207078	196064	409953-001	202708	—	202663
MM 180	LG320643	196574	—	218422	207415	207078	196064	409953-001	202708	—	202663
MM 185	KG171523	124511	See Manual	222837	035897	171007	123468	005656	See Manual	072817	153197
MM 200	HK240615	See Manual	See Manual	See Manual	030943	171007	—	—	—	See Manual	—
MM 210	LC218652	124511	196600	See Manual	See Manual	See Manual	188706	148809	202888	—	192373
MM 211	LJ330001N	196575	—	232516	207415	207078	See Manual	See Manual	202708	—	202663
MM 212	LH131786B	124511	196600	246753	228104	207077	188706	148809	233009	—	—
MM 212 w/Auto-Set™	LJ180754B	124511	—	246753	—	238122	188706	148809	233009	—	—
MM 250	KB054828	250006	—	222837	035897	171007	148808	148809	See Manual	006393	035897
MM 250MP	KB054828	250006	—	222837	—	—	148808	148809	See Manual	006393	—
MM 250X w/o meters	KJ081597	250006	—	222837	035897	171007	188706	148809	227117	006393	035897
MM 250X w/ meters	KK227730	250006	—	222837	See Manual	171007	188706	148809	227117	006393	See Manual
MM 251	LB170597	250006	—	See Manual	See Manual	See Manual	188706	148809	227117	052964	See Manual
MM 252	LG290851B	250006	—	246753	—	218764	188706	148809	225341	—	—
MM 300 w/o meters	KH457123	244920	—	222837	035897	171007	148808	148809	227117	—	035897
MM 300 w/meters	KK310628	244920	—	222837	035897	171007	148808	148809	227117	—	035897
MM 350/350P	LC447907	See Manual	248620	See Manual	—	—	225166	—	223541	106462	—
MM DVI™	LE204883	219552	196600	216396	198087	207077	188706	148809	202888	072817	153197
MM DVI-2™	LH021271B	219552	196600	246753	198087	207077	188706	148809	230496	—	192373
MM Passport	LE444123	—	—	220011	—	174992	234728	—	202708	—	—
MM Passport Plus	LH380053N	—	—	220011	—	174992	234728	—	202708	—	—
MM Pulser	LA259996	250006	196600	218494	035897	171007	188706	148809	227117	—	192373
MM Reach	LK220947N	—	—	—	—	238873	—	—	223541	—	—
Vintage	KF806591	250006	See Manual	218421	035897	171007	See Manual	See Manual	See Manual	080388	153197

## Spoolmate™ 100 Series

Item #	Part #	Description	Quantity
1	186404	Gun Tube Assembly (Includes)	1
2	234348	Head Tube Assembly	1
3	206363	Liner Kit	1
4	194633	Barrel	1
5	209080	Screw, M4 x 0.7 x 6 mm	1
6	186408	Gas Nipple	1
7	186409	Gas Diffuser	1
8	186419	Contact Tip .030	1
8	186406	Contact Tip .035	1
8	199730	Contact Tip .023	1
9	186405	Nozzle	1
10	111400	Hose, SAE .187 ID x .410 OD x 8.000	1

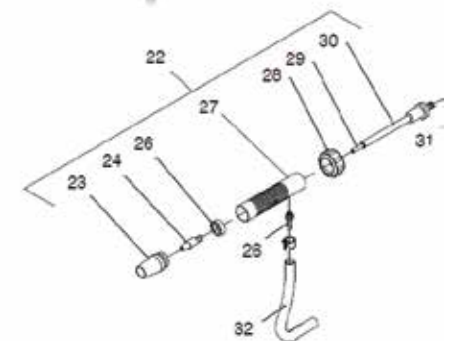


*Spoolmate 100  
Spool Gun*



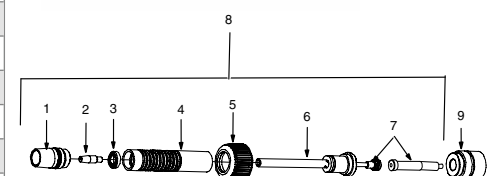
## Spoolmate™ 150 Series

Item #	Part #	Description	Quantity
22	199385	Gun Tube Assembly (Includes)	1
23	199386	Nozzle	1
24	199387	Contact Tip .030	1
24	199388	Contact Tip .035	1
24	199389	Contact Tip .047	1
25	199391	Gas Nipple	1
26	199390	Gas Diffuser	1
27	199393	Barrel	1
28	199847	Lock Nut	1
29	199392	Liner Kit	1
30	199394	Head Tube Assembly	1
31	196398	Buss Bar, Interconnecting	1
	1114000	Hose, SAE .187 ID x .410 OD x 8.000	1



## Spoolmate™ 200 Series

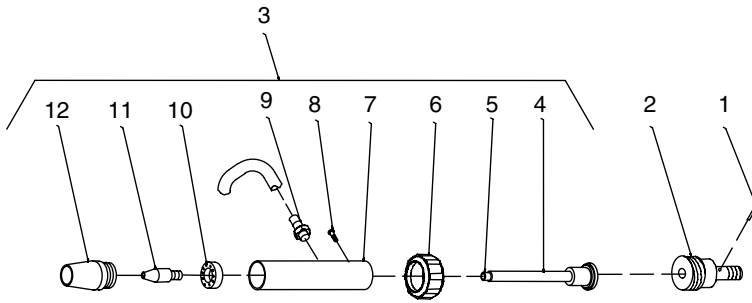
Item #	Part #	Description	Quantity
1	050622	Nozzle, Scr Type .562 Orif x 1.437 Lg	1
2	199388	Heavy Duty Tip, .035 M5 x .8 mm Thread	1
2	199387	Heavy Duty Tip, .030 M5 x .8 mm Thread	1
2	199730	Heavy Duty Tip, .023 M5 x .8 mm Thread	1
3	199390	Gas Diffuser	1
4	243294	Barrel	1
5	243383	Locking Nut	1
6	244880	Head Tube Assembly	1
7	247351	Kit, Liner w/ Outlet Guide	1
8	243385	Gun Tube Assembly	1
9	243390	Contact Adapter	1



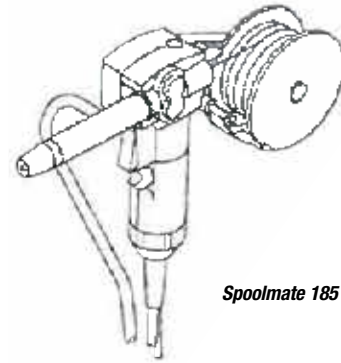
# SPOOL GUNS

## Spoolmate™ 185 & 3035 Series

Item #	Part #	Description	Quantity
1	197570	Anti-Rotation Pin	1
2	196848	Contact Adapter	1
3	196827	Gun Tube Assembly (Includes)	1
4	196849	Head Tube Assembly	1
5	206363	Liner Kit	1
6	196847	Locking Nut	1
7	194633	Barrel	1
8	209080	Screw, M4 x 0.7 x 6 mm	1
9	186408	Gas Nipple	1
10	186409	Gas Diffuser	1
11	186419	Contact Tip .030	1
11	186406	Contact Tip .035	1
11	199730	Contact Tip .023	1
12	186405	Nozzle	1



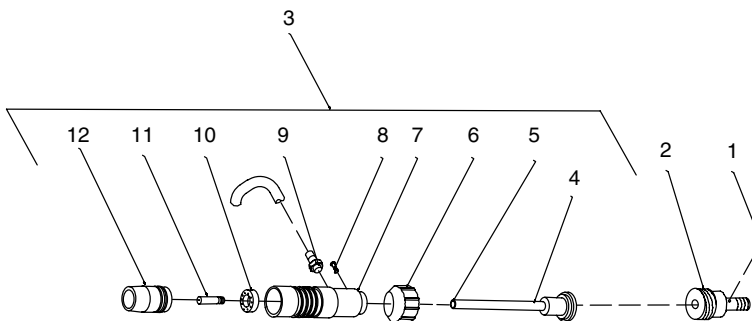
*Spoolmate 3035 Spool Gun*



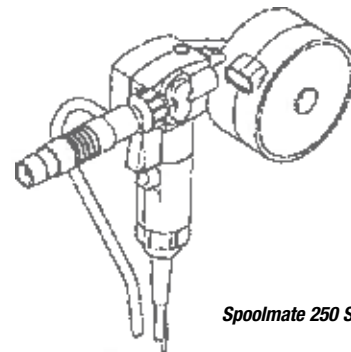
*Spoolmate 185 Spool Gun*

## Spoolmate™ 250 & 3545 Series

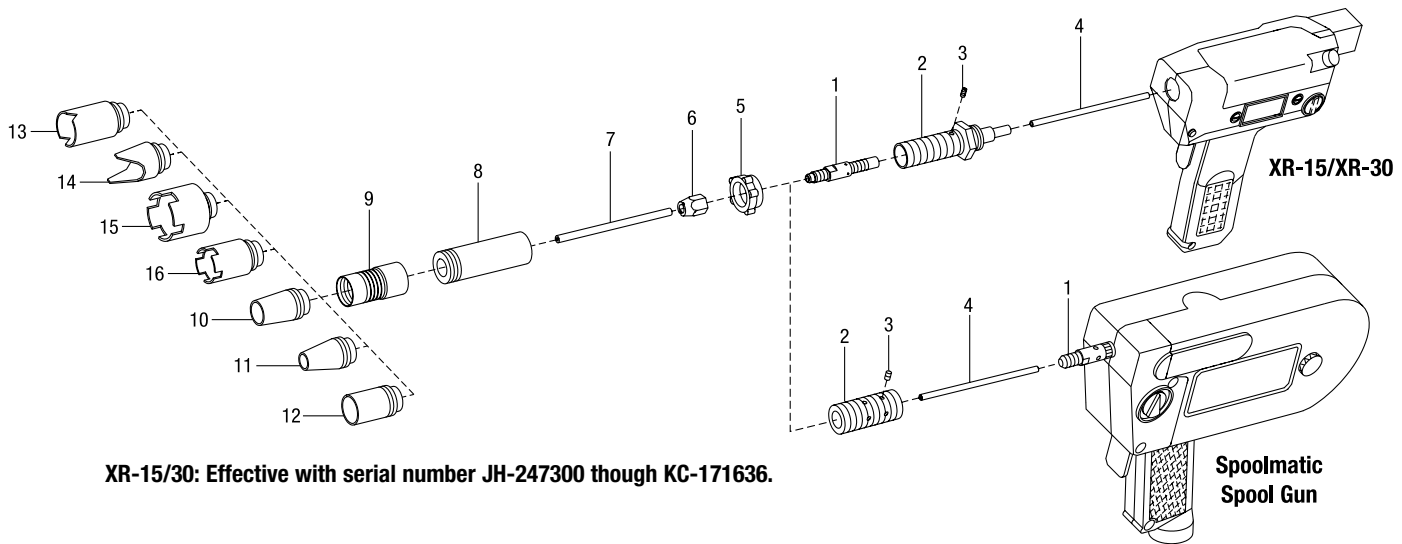
Item #	Part #	Description	Quantity
1	197570	Anti-Rotation Pin	1
2	196848	Contact Adapter	1
3	199385	Gun Tube Assembly (consisting of)	1
4	199394	Head Tube Assy	1
5	206363	Liner Kit	1
6	196847	Locking Nut	1
7	199393	Barrel	1
8	209080	Screw, M5 x 0.7 x 6 mm	1
9	199391	Gas Nipple	1
10	199390	Gas Diffuser	1
11	199387	Contact Tip .030	1
11	199388	Contact Tip .035	1
11	199389	Contact Tip .047	1
12	050622	Nozzle	1



*Spoolmate 3545 Spool Gun*



*Spoolmate 250 Spool Gun*



XR-15/30: Effective with serial number JH-247300 through KC-171636.

## XR-15™/XR-30™ and Spoolmatic® 1,2,3

Service Parts/Consumables

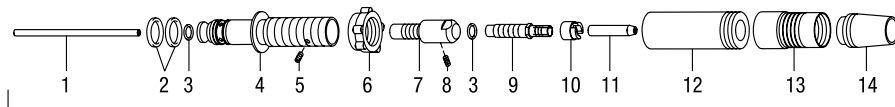
Item #	Part # XR-15/30	Part # Spoolmatic 1,2,3	Description	Quantity
1	112704	058678	Adapter, contact tube	1
2	112885 (N/A)	009541 (N/A)	Adapter, barrel	1
3	602172	—	Screw, set stl sch 10-32 x .187 cup point	1
	—	604771	Screw, set stl sch 10-32 x .125 cup point	4
4	112708	—	Liner, teflon .030–.035 (0.8–0.9 mm) wire x 4.125	1
	112707	—	Liner, teflon .047–1/16 (1.2–1.6 mm) wire x 4.125	1
	—	058681	Liner, teflon .030–.035 (0.8–0.9 mm) wire x 5.187	1
	—	058682	Liner, teflon .047–1/16 (1.2–1.6 mm) wire x 5.187	1
5	058685	058685	Nut, jam nozzle extension	1
6	058676	058676	Nut, brs cprsn .438-20	1
7	050638	050638	Tube, cont sl .030 (0.8 mm) wire x 4.000	1 (5 per pkg)
	094259	094259	Tube, cont sl .035 (0.9 mm) wire x 4.000	1 (5 per pkg)
	094260	094260	Tube, cont sl .047 (1.2 mm) wire x 4.000	1 (5 per pkg)
	050637	050637	Tube, cont sl 1/16 (1.6 mm) wire x 4.000	1 (5 per pkg)
8	156821	156821	Extension, barrel 2.875 lg	1
9	144862	144862	Extension, nozzle	1
10	050622	050622	Nozzle, 5/8 orf (15.9 mm) x 1-5/8 lg	1 (2 per pkg)
11	050115	050115	Nozzle, 1/2 orf (12.7 mm) x 1-5/8 lg	1 (2 per pkg)
12	050116	050116	Nozzle, 13/16 (20.6 mm) orf x 1-5/8 lg	1 (2 per pkg)
13	009925 (N/A)	009925 (N/A)	Nozzle, spot outside corner .937 ID x 2.375	1
14	000443 (N/A)	000443 (N/A)	Nozzle, spot inside corner	1
15	004466 (N/A)	004466 (N/A)	Nozzle, spot flat, 1-3/8 orf (35 mm)	1
16	000442 (N/A)	000442 (N/A)	Nozzle, spot flat, 15/16 orf (24 mm)	1
	050960 (N/A)	050960 (N/A)	Wrench	1
	053131	053131	Drive Roll, V-knurl .030–1/16 (0.8–1.6 mm)	1
	194405 <sup>1</sup>	—	Complete Conduit Assemblies with Liner and Fittings (replaces 112 715)	15 ft
	194410 <sup>1</sup>	—	Complete Conduit Assemblies with Liner and Fittings (replaces 112 716)	30 ft
	191065	—	Replacement Liner, gun feed cable .187 OD x .110 ID	32 ft
	191066	—	Replacement Liner, gun feed cable .187 OD x .110 ID	50 ft
	197440	—	Replacement Liner, bulk gun feed cable .187 OD x .110 ID	500 ft
	191061	—	Replacement Tubing, gun liner carrier	15 ft
	191062	—	Replacement Tubing, gun liner carrier	30 ft
	191063 (N/A)	—	Replacement Tubing, gun liner carrier	50 ft
	156486 (N/A)	—	Conversion Kit, converts XRs with 4" contact tubes to 1-7/16" tubes	1

<sup>1</sup> Updates XRs from one-piece conduit (112715 or 112716) to new style configuration that features replaceable feed cable liners and improved feedability.

# SPOOL GUNS

Spoolmatic serial numbers  
KD376404 - LC259177

XR prior to serial number LC373469



193142 Barrel Assembly



- |                                |                   |                                   |                   |
|--------------------------------|-------------------|-----------------------------------|-------------------|
| 1. Head Tube Liner             | (See chart below) | 11. Contact Tip                   | (See chart below) |
| 2. O-Ring .614 ID              | <b>134800</b>     | 12. Barrel Extension (Air-cooled) | <b>156821</b>     |
| 3. O-Ring .176 ID              | <b>164485</b>     | 13. Nozzle Extension (Air-cooled) | <b>144862</b>     |
| 4. Barrel Adapter (Air-cooled) | <b>164423</b>     | 14. Nozzle (Standard)             | <b>050622</b>     |
| 5. Set Screw                   | <b>602172</b>     | Wrench (Not shown)                | <b>136821</b>     |
| 6. Jam Nut (Air-cooled)        | <b>058685</b>     |                                   |                   |
| 7. Head Tube (Air-cooled)      | <b>164422</b>     |                                   |                   |
| 8. Set Screw (Air-cooled)      | <b>604612</b>     |                                   |                   |
| 9. Contact Tip Adapter         | <b>164421</b>     |                                   |                   |
| 10. Collet Nut                 | <b>136748</b>     |                                   |                   |

## XR™ / XR-M, Spoolmatic® 15/30A Consumables

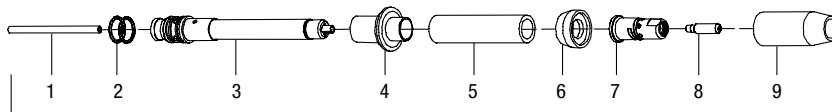
Air-cooled parts breakdown and gun shown. Consult owner's manual for water-cooled parts and consumables.

Wire Diameter	Standard Contact Tip I.D.	Optional (Smaller) Contact Tip I.D.	Gun Head Tube Liner
.030 in (0.8 mm)	.041 in (1.0 mm) <b>135428</b>	.036 in (1.0 mm) <b>135427</b>	<b>136682</b>
.035 in (0.9 mm)	.052 in (1.3 mm) <b>135430</b>	.041 in (1.0 mm) <b>147314</b>	<b>136682</b>
.047 in (1.2 mm)	.061 in (1.5 mm) <b>135424</b>	.052 in (1.0 mm) <b>135429</b>	<b>136683</b>
.062 in (1.6 mm)	.081 in (2.1 mm) <b>135425</b>	.073 in (1.0 mm) <b>135426</b>	<b>136683</b>

For guns between LC259177 and LE239243, call Miller parts for information.

Spoolmatic effective with serial number  
LE239243

XR effective with serial number LE033395



#231 523 Air-Cooled Assembly Kit (Illustrated above)  
#231 524 Water-Cooled Assembly Kit (Not shown, consult owner's manual)



- |                                 |               |                      |                   |
|---------------------------------|---------------|----------------------|-------------------|
| 1. Head Tube Liner              | <b>212156</b> | 6. Nozzle Insulator  | <b>232284</b>     |
| 2. O-Ring .614 ID               | <b>134800</b> | 7. Diffuser          | <b>227749</b>     |
| 3. Barrel Assembly (Air-cooled) | <b>221087</b> | 8. Contact Tip       | (See chart below) |
| 4. Barrel Pistol Insulator      | <b>219795</b> | 9. Nozzle (Standard) | <b>199613</b>     |
| 5. Outer Insulating Jacket      | <b>219794</b> |                      |                   |

## XR™ / XR-M, Spoolmatic® 15/30A FastTip™

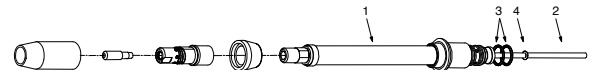
Air-cooled parts breakdown and gun shown. Consult owner's manual for water-cooled parts and consumables.

Wire Diameter Steel / Aluminum	FasTip Contact Tip I.D.	XR-Pistol Drive Rolls	XR-Pistol All-Wire Dual Groove Drive Rolls	Cable Liners
.035 in (0.9 mm) / .030 in (0.8 mm)	.041 in (1.0 mm) <b>206186</b>	<b>183357</b>	<b>136135</b>	<b>191065</b> 15 ft (4.6 m) or
.040 in (1.0 mm) / .035 in (0.9 mm)	.047 in (1.2 mm) <b>206187</b>	<b>183357</b>	<b>136135</b>	30 ft (9.1 m)
.045 in (1.2 mm) / -	.053 in (1.3 mm) <b>206188</b>	<b>183357</b>	<b>136135</b>	<b>191066</b> 50 ft (15.2 m)
.052 in (1.3 mm) / .047 in (1.2 mm)	.061 in (1.5 mm) <b>206189</b>	<b>183358</b>	<b>136135</b>	<b>197440</b> 500 ft (152 m)
.062 in (1.6 mm) / -	.071 in (1.8 mm) <b>206190</b>	<b>183358</b>	<b>136135</b>	



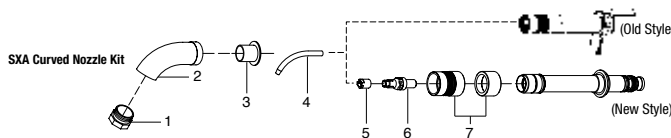


## XR™-A/Spoolmatic® 30A Options



Item #	Part #	Description	Kit Quantity
	<b>273232</b>	<b>Kit, Flex Head 10 in for XRA</b>	
1	<b>M1575</b>	Tube, Head, Flexible, XR Pistol	1
2	<b>M1507</b>	Liner, Teflon .030-.035 Wire AP (grey)	1
	<b>M1508</b>	Liner, Teflon .047-.062 Wire AP (yellow)	1
	<b>M1509</b>	Liner, Teflon .030-.035 Wire PP/SP (grey)	1
	<b>M1514</b>	Liner, Teflon .047-.062 Wire PP/SP (yellow)	1
3	<b>191191</b>	O-Ring, .312 ID x .070 CS 70 Duro Buna-N	2
4	<b>164485</b>	O-Ring, .176 ID x .070 CS 70 Duro Silicone	1
	<b>273237</b>	Instruction, Field 273232	

Item #	Part # (Old Style)	Part # (New Style)	Description	Kit Quantity
8	<b>136821</b>	—	Wrench (standard length), nut tip contact	1
9	—	<b>See page 43</b>	Nozzle	1
10	<b>144862</b>	<b>144862</b>	Extension Nozzle	1
11	<b>130632</b>	<b>130632</b>	Insulator, ring	1
12	—	<b>See page 43</b>	Contact Tip	1
13	<b>136748</b>	—	Nut, compression	1
14	<b>136431</b>	—	Adapter, contact tube	1
	—	<b>209875</b>	Diffuser, FasTip slotted	1
15	<b>153667</b>	<b>153667</b>	Clamp, Sst bundle dia 2.00 x .18 wide x 7.90 lg	1 (Old Style) / 2 (New Style)
16	<b>140665</b>	<b>212679 (N/A)</b>	Tube, head flexible (includes)	1
17	<b>134800</b>	<b>134800</b>	O-Ring, .614 ID x .070CS	2
18	<b>131171 (N/A)</b>	<b>131171 (N/A)</b>	Tubing, npm convoluted 7.100 lg x .740 ID cuffs	1
19	<b>138255</b>	<b>222853</b>	Liner, teflon .030-.035 (0.8-0.9 mm) wire x 11.625 lg, black	1
	<b>132682</b>	<b>1910031</b>	Liner, teflon .047-.062 (1.2-1.6 mm) wire x 11.625 lg, yellow	1
	—	<b>212401</b>	Liner, phos bronze .030-1/16 (0.8-1.6 mm) wire x 11.249	1
20	—	<b>134799</b>	O-Ring, .176 ID x .070CS	1
21	—	<b>212680 (N/A)</b>	Flex torch (inside tubing)	1



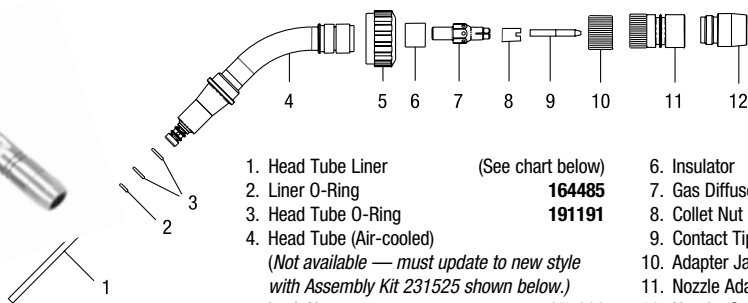
*New style Spoolmatic effective with serial number LE239243.*

*New style XR effective with serial number LE033395.*

Item #	Part # (Old Style)	Part # (New Style)	Description	Kit Quantity
	<b>147174</b>	<b>300161</b>	<b>Kit, SXA Curved Nozzle 50 Degree, Machine Sales Item</b>	
1	<b>005417</b>	<b>005417</b>	Nut, retaining ring	1
2	<b>005432</b>	<b>005432</b>	Nozzle, curve with collar	2
3	<b>148158</b>	<b>148158</b>	Insulator, nozzle	2
4	<b>148155</b>	<b>148155</b>	Tip, cont sl .030-.035 (0.8-0.9 mm) wire curved	2
	<b>148154</b>	<b>148154</b>	Tip, cont sl 3/64 (1.19 mm) wire curved	2
	<b>148156</b>	<b>148156</b>	Tip, cont sl 1/16 (1.6 mm) wire curved	2
5	<b>136748</b>	<b>136748</b>	Nut, compression	1
6	<b>185110</b>	<b>185110</b>	Adapter, quick-change contact tip	1
7	—	<b>193794</b>	Kit, nozzle adapter	1
8	<b>148151</b>	<b>148151</b>	Wrench (short length), nut retaining tip contact	1
	—	<b>222462</b>	Kit, 50 degree head tube (air-cooled), Machine Sales Item	1
	—	<b>222464</b>	Kit, 50 degree head tube (water-cooled), Machine Sales Item	1

# SPOOL GUNS

XR from serial number  
KK082113 to LC373468



- |  |                   |                       |                   |
|--|-------------------|-----------------------|-------------------|
| 1. Head Tube Liner   | (See chart below) | 6. Insulator          | 185097            |
| 2. Liner O-Ring  | 164485            | 7. Gas Diffuser       | 185110            |
| 3. Head Tube O-Ring  | 191191            | 8. Collet Nut         | 136748            |
| 4. Head Tube (Air-cooled)  |                   | 9. Contact Tip        | (See chart below) |
| (Not available — must update to new style with Assembly Kit 231525 shown below.) |                   | 10. Adapter Jam Nut   | 185102            |
| 5. Lock Nut  | 185111            | 11. Nozzle Adapter    | 185105            |
|  |                   | 12. Nozzle (Standard) | 185100            |
|  |                   | Wrench (Not shown)    | 136821            |

Note: For optional nozzles see page 43.

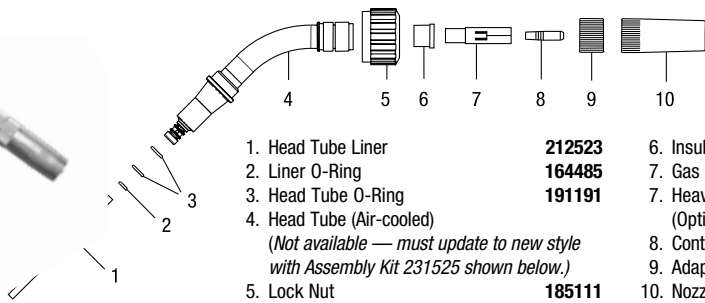
## XR-Edge™

Consumables

Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Wire Diameter	Standard Contact Tip I.D.	Optional (Smaller) Contact Tip I.D.	Gun Head Tube Liners	Aluminum Feed Cable Liners
.030 in (0.8 mm)	.041 in (1.0 mm) 135428	.036 in (0.9 mm) 135427	193793	191065 30 ft (9 m)
.035 in (0.9 mm)	.052 in (1.3 mm) 135430	.041 in (1.0 mm) 147314	193793	191066 50 ft (15.2 m)w
.040 in (1.0 mm)	.052 in (1.3 mm) 135430	—	193793	197440 500 ft (152 m)
.047 in (1.2 mm)	.061 in (1.5 mm) 135424	.052 in (1.3 mm) 135429	193792	

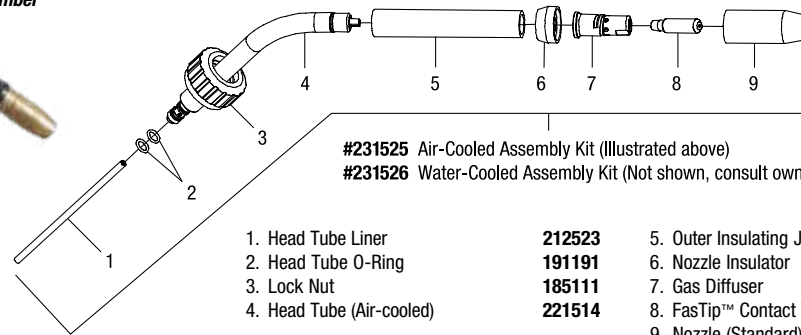
XR from serial number  
LC373394 to LE033394



- |  |        |                                       |                   |
|--|--------|---------------------------------------|-------------------|
| 1. Head Tube Liner   | 212523 | 6. Insulator                          | 185097            |
| 2. Liner O-Ring  | 164485 | 7. Gas Diffuser                       | 209875            |
| 3. Head Tube O-Ring  | 191191 | 7. Heavy-Duty Gas Diffuser (Optional) | 209875            |
| 4. Head Tube (Air-cooled)  |        | 8. Contact Tip                        | (See chart below) |
| (Not available — must update to new style with Assembly Kit 231525 shown below.) |        | 9. Adapter Jam Nut                    | 185102            |
| 5. Lock Nut  | 185111 | 10. Nozzle (Standard)                 | 197728            |

Note: For optional nozzles see page 39.

XR effective with serial number  
LE033395



#231525 Air-Cooled Assembly Kit (Illustrated above)  
#231526 Water-Cooled Assembly Kit (Not shown, consult owner's manual)

- |                           |        |                            |                   |
|---------------------------|--------|----------------------------|-------------------|
| 1. Head Tube Liner        | 212523 | 5. Outer Insulating Jacket | 220103            |
| 2. Head Tube O-Ring       | 191191 | 6. Nozzle Insulator        | 232284            |
| 3. Lock Nut               | 185111 | 7. Gas Diffuser            | 227749            |
| 4. Head Tube (Air-cooled) | 221514 | 8. FasTip™ Contact Tip     | (See chart below) |
|                           |        | 9. Nozzle (Standard)       | 199613            |

Note: For optional consumables see page 39.

## XR-Edge FasTip™

Consumables

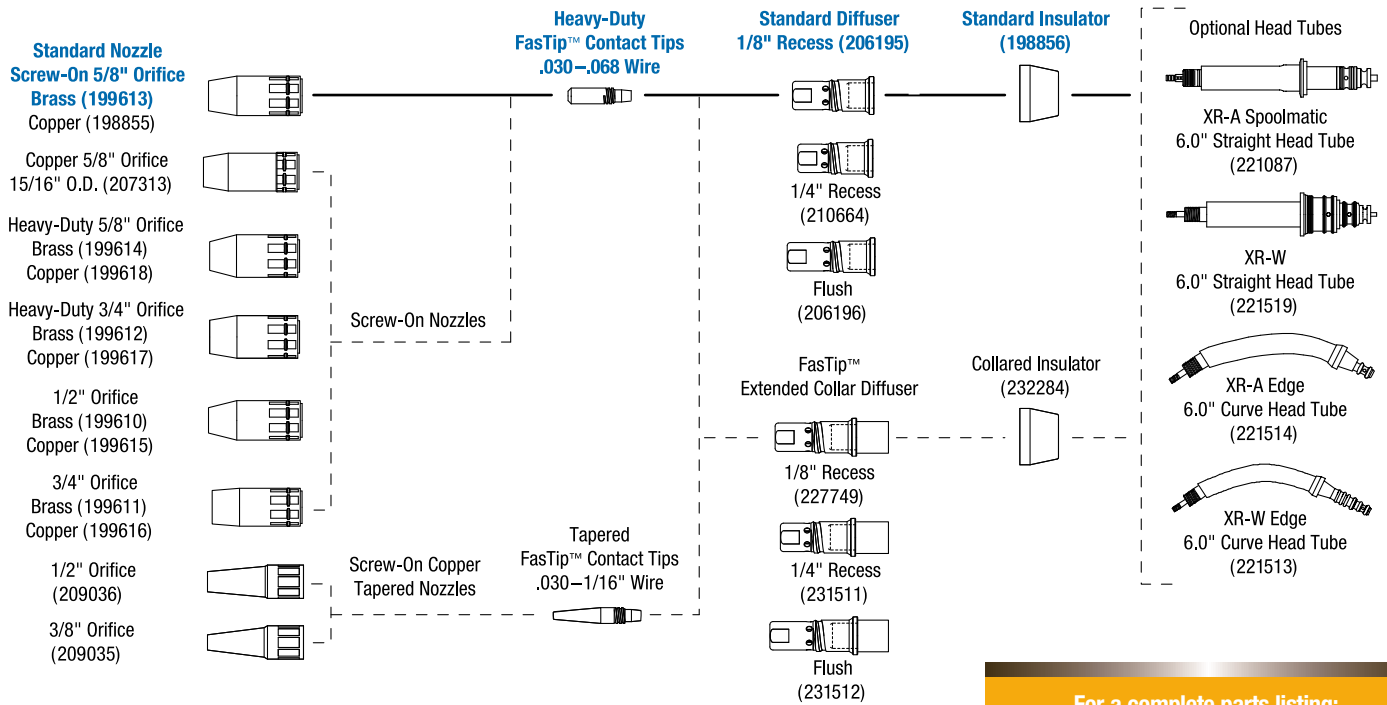
Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Wire Diameter Steel / Aluminum	FasTip Contact Tip I.D.	XR-Edge Drive Rolls	Optional Isolated XR-Edge Drive Rolls	Cable Liners
.035 in (0.9 mm) / .030 in (0.8 mm)	.041 in (1.0 mm) 206186	194114	198434 (N/A)	191065 15 ft (4.6 m) or
.040 in (1.0 mm) / .035 in (0.9 mm)	.047 in (1.2 mm) 206187	194115	198435	30 ft (9.1 m)
.045 in (1.2 mm) / —	.053 in (1.3 mm) 206188	196302 (N/A)	198436 (N/A)	191066 50 ft (15.2 m)
.052 in (1.3 mm) / .047 in (1.2 mm)	.061 in (1.5 mm) 206189	194116	198437	197440 500 ft (152 m)
.062 in (1.6 mm) / —	.071 in (1.8 mm) 206190	194117	198438 (N/A)	

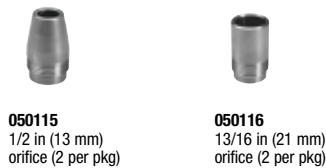


## New Style XR™-Edge and XR™/Spoolmatic® FasTip™ Consumables

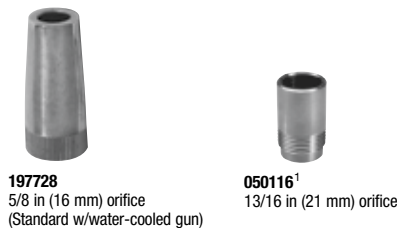
*Note: Standard gun components are in blue type.*



## XR™/Spoolmatic® 30A Nozzles (Serial Numbers KD376404-LC259177)



## XR™-Edge Nozzles (Serial Numbers KK082113 - LE033394)



<sup>1</sup>Can use with water-cooled guns, Nozzle Adapter Kit 193794 required.

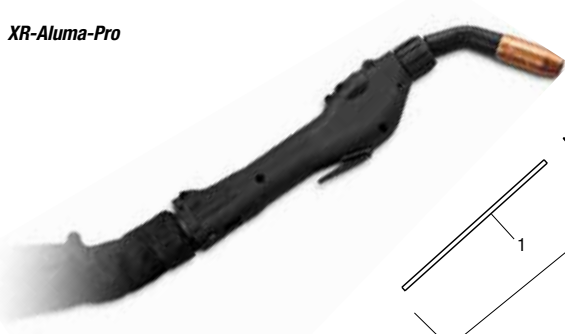
For a complete parts listing:

see pages 39-42

Contact Tips		
(10 p/pkg)	(25 p/pkg)	Description
<b>Heavy-Duty FasTip™</b>		
223016	206186	.030/.035 in (0.8/0.9 mm) aluminum wire
223017	206187	.035/.040 in (0.9/1.0 mm) aluminum wire
223018	206188	.040/.045 in (1.0/1.2 mm) aluminum wire
223019	206189	.052 in (1.3 mm) or 3/64 in (1.2 mm) aluminum wire
223200	206190	1/16 in (1.6 mm)
—	206191	.068 in (1.7 mm) or 1/16 in (1.6 mm) aluminum wire
<b>Tapered FasTip™</b>		
—	209026	.030/.035 in (0.8/0.9 mm) aluminum wire
—	209027	.035/.045 in (0.9/1.2 mm) aluminum wire
—	209028	3/64 in (1.2 mm)
—	209029	.052 in (1.3 mm)
—	209030	1/16 in (1.6 mm)

# SPOOL GUNS

## XR-Aluma-Pro



1. Head Tube Liner
2. Head Tube O-Rings
3. Lock Nut
4. Insulator Ring Rear
5. Head Tube Short  
Head Tube Long

(See chart below)

- 230969
- 227168
- 227416
- 227158
- 229672

**231519** Air-Cooled Assembly Kit  
Short Barrel, 4 in (102 mm)

**231518\*** Air-Cooled Assembly Kit  
Long Barrel, 6 in (152 mm)

- 6. Insulating Jacket, short **227159**  
Insulating Jacket, long **229673**
- 7. Gas Diffuser **229670**
- 8. FasTip™ Contact Tip (See chart below)
- 9. Nozzle (Standard) **198855**

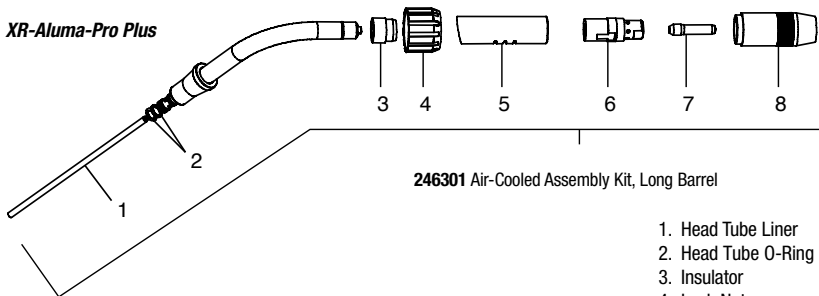
**Note: For optional consumables see page 43.**

## XR-Aluma-Pro™ Consumables

Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Wire Diameter Steel / Aluminum	FasTip Contact Tip I.D.	Drive Rolls	Idler Rolls	Inlet Guides	Air-Cooled Head Tube Liner Short Barrel, 4 in (102 mm)	Air/Water Cooled Head Tube Liner Long Barrel, 6 in (152 mm)	Cable Liners
.035 in (0.9 mm) / .030 in (0.8 mm)	.041 in (1.0 mm) <b>206186</b>	<b>254756</b>	<b>227439</b>	<b>227408</b>	<b>227161</b>	<b>229674</b>	<b>229887</b> 15 ft (4.6 m)
.040 in (1.0 mm) / .035 in (0.9 mm)	.047 in (1.2 mm) <b>206187</b>	<b>254756</b>	<b>227439</b>	<b>227408</b>	<b>227161</b>	<b>229674</b>	<b>229891</b> 25 ft (7.6 m)
.045 in (1.2 mm) / -	.053 in (1.3 mm) <b>206188</b>	<b>254756</b>	<b>227439</b>	<b>227408</b>	<b>230239</b>	<b>229431</b>	<b>232321</b> 35 ft (10.6 m)
.052 in (1.3 mm) / .047 in (1.2 mm)	.061 in (1.5 mm) <b>206189</b>	<b>254756</b>	<b>227439</b>	<b>227408</b>	<b>230239</b>	<b>229431</b>	
.062 in (1.6 mm) / -	.071 in (1.8 mm) <b>206190</b>	<b>254756</b>	<b>230710</b>	<b>230711</b>	<b>230239</b>	<b>229431</b>	
.030 in (0.8 mm) / 1/16 in (1.6 mm)					<b>233998</b>	<b>233999</b>	

## XR-Aluma-Pro Plus



**246301** Air-Cooled Assembly Kit, Long Barrel

1. Head Tube Liner
2. Head Tube O-Ring
3. Insulator
4. Lock Nut
5. Insulating Jacket, Long
6. Diffuser

- 230242**
- 191191**
- 227416**
- 227168**
- 229673**
- D-1AP**

- 7. Contact Tip (See chart below)
- 8. Nozzle (Standard) **N-5818C**

## XR-Aluma-Pro Plus™ Consumables

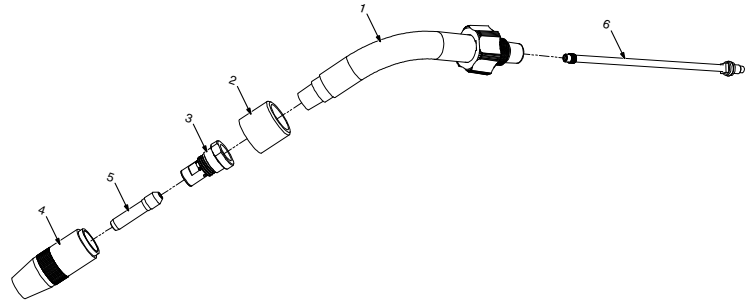
Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Wire Diameter Steel / Aluminum	Contact Tips (10 pack) Steel / Aluminum	Drive Rolls	Idler Rolls	Air/Water Cooled Head Tube Liner Long Barrel, 6 in (152 mm)	Cable Liners
.035 in (0.9 mm) / .030 in (0.8 mm)	<b>T-035</b> / -	<b>254756</b>	<b>230708</b>	<b>230235</b>	<b>229887</b> 15 ft (4.6 m)
.040 in (1.0 mm) / .035 in (0.9 mm)	- / <b>T-035AL</b>	<b>254756</b>	<b>230708</b>	<b>230235</b>	<b>229891</b> 25 ft (7.6 m)
.045 in (1.2 mm) / -	<b>T-045</b> / <b>T-047AL</b>	<b>254756</b>	<b>230708</b>	<b>229431</b>	<b>232321</b> 35 ft (10.6 m)
.052 in (1.3 mm) / .047 in (1.2 mm)	- / -	<b>254756</b>	<b>230708</b>	<b>229431</b>	<b>233999</b> Long*
.062 in (1.6 mm) / -	<b>T-062</b> / <b>T-062AL</b>	<b>254756</b>	<b>230708</b>	<b>229431</b>	<b>233998</b> Short*

Air-cooled parts breakdown and gun shown. Consult owner's manual for water-cooled parts and consumables.  
\*Optional phos bronze liners.

**For parts and support on the XR Python please contact MK Products at 949-863-1234**

XR-Aluma-Pro Lite



## XR™-Aluma-Pro™ Lite Consumables

Air-cooled parts breakdown and gun shown. Consult owner's manual for water-cooled parts and consumables.

Item #	Part #	Description	Quantity
	254477	Head Tube Assy, Aluma-Pro Lite (Including)	1
1	QT2-45	Tube, Body 45 Degree x 2.69 Lg	1
	1840057	Clip-on Q-Nut Cover	1
	1840031	Body Tube Insulating Sleeve	2
2	4323R	Insulator, Nozzle (Small)	1
3	DS-1	Diffuser, C-Fire (Small Nozzle)	1
4	NS-1218C	Nozzle, C-Fire Small Copper 1/2 in. Recess 1/8 in.	1
5	T-047AL	Centerfire Contact Tip, Aluminum 3/64 in.	1
5	T-035AL	Centerfire Contact Tip, Aluminum .035	1
6	258541	Kit, Jump Liner Assy .030-.035 (5 pk)	1
6	258542	Kit, Jump Liner Assy .047-.062 (5 pk)	1
6	258726	Kit, Jump Liner Assy .030-.035 14 in. Long (5 pk)	1
6	258727	Kit, Jump Liner Assy .047-.062 14 in. Long (5 pk)	1
	M1440	Cable Liner for Gun	1

## Optional Head Tube Assemblies (for XR-Aluma-Pro guns)



45 Degree/4 Inch (Air-Cooled) **255037**



45 Degree/4 Inch (Water-Cooled) **255338**



45 Degree/6 Inch (Air-Cooled) **255040**



45 Degree/6 Inch Heavy-Duty (Water-Cooled) **258293**



45 Degree/6 Inch (Water-Cooled) **231517**



45 Degree/10 Inch Tight ACS (Air-Cooled) **258295**

## Optional Head Tube Assemblies (for XR-Aluma-Pro guns) continued...



60 Degree/4 Inch (Air-Cooled) **231519**



60 Degree/4 Inch (Water-Cooled) **255038**



60 Degree/6 Inch (Air-Cooled) **231518**



60 Degree/6 Inch (Water-Cooled) **255041**



60 Degree/6 Inch Heavy-Duty (Water-Cooled) **258294**



180 Degree/4 Inch (Air-Cooled) **255716**



180 Degree/4 Inch (Water-Cooled) **255717**



180 Degree/6 Inch (Air-Cooled) **258476**



180 Degree/6 Inch (Water-Cooled) **258477**



180 Degree/8 Inch (Air-Cooled) **255042**



180 Degree/8 Inch (Water-Cooled) **255043**



45 Degree/6 Inch with Centerfire™ (Water-Cooled) **246205**



60 Degree/6 Inch with Centerfire™ (Air-Cooled) **246301**



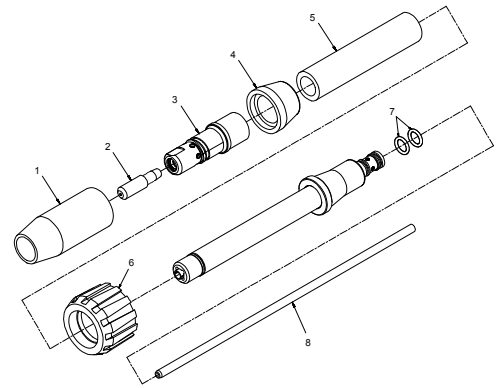
180 Degree/4 Inch with Centerfire™ (Air-Cooled) **258474**



180 Degree/4 Inch with Centerfire™ (Water-Cooled) **258475**



XR-Pistol Pro

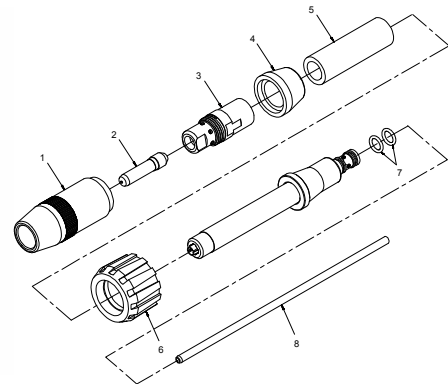


## XR-Pistol Pro Consumables

Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Item #	Part #	Description	Quantity
	255716	Kit, Head Tube Assy (Air) AP/PP 180 Degree 4 in.	1
1	198855	Nozzle, Copper 5/8 in.	1
2	206189	Tip, Fastip .312 Od .052 And 3/64 Al Wires	1
3	229670	Diffuser, .281/.312 Od Collar Fastip 1/8 Rec Aluma	1
4	232284	Insulator, Nozzle Collared	1
5	M1366	Jacket Outer Insulating A/C Pistol Pro	1
6	227168	Nut, Head Tube Rotation	1
7	191191	O-Ring, .312 Id x .070 Cs 70 Duro Buna-n	2
8	M1273	Liner, Teflon .047-.062 Wire Pistol Pro	1
	230969	Kit, Replacement O-Rings Head Tube Air	1

XR-Pistol Pro Plus



## XR-Pistol Pro Plus Consumables

Air-cooled parts breakdown and gun shown.  
Consult owner's manual for water-cooled parts and consumables.

Item #	Part #	Description	Quantity
	258474	Kit, Head Tube Assy (Air) AP/PP 180 Degree 4 in. Lg Cntrfr	1
1	N-5818C	Nozzle, C-Fire Large Copper 5/8 in. Recess 1/8 in.	1
2	T-047AL	Contact Tip, Centerfire .047 Aluminum	1
3	D-1AP	Diffuser, Centerfire-D-1AP	1
4	232284	Insulator, Nozzle Collared Diffuser (For 180 Degree/ Straight Only)	1
5	M1190 (N/A)	Insulator, Outer 180 Degree/ Straight (Air)	1
6	227168	Nut, Head Tube Rotation	1
	230969	Kit, Replacement O-Rings Head Tube Air (Includes)	1
7	191191	O-Ring, .312 Id x .070 Cs 70 Duro Buna-n	2
8	M1442	Liner, Teflon .047-.062 Wire Soft Pro/Plus	1

# DRIVE ROLLS



2 Roll Kit

Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. U-Grooved rolls for soft and soft shelled cored wires.
3. U-Cogged rolls for extremely soft shelled wires.
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirement (example: V-Knurled roll in combination with U-Grooved).

For a listing of special optional drive rolls:

see page 52

## Drive Rolls **Millermatic® 200/210/212/250/251/252/DVI's/Pulser/Vintage (2 Drive Roll)** **22/32/52 Series, SuitCase™ 8/12RC & 8/12VS, Reach Feeders (2 Drive Roll)**

Wire Diameter			Drive Rolls			
Fraction	Decimal	Metric	Type	Kit #	Individual Drive Roll Part #	Inlet Wire Guide #
.023 – .025 in	.023 – .025 in	0.6 mm	V-Grooved	087131	087130	056192
.030 in	.030 in	0.8 mm	V-Grooved	079594	053695	056192
.030 and .035 in	.030 and .035 in	0.8 and 0.9 mm	V-Grooved	204579 <sup>1</sup>	203526 <sup>1</sup>	056192
.035 and .045 in	.035 and .045 in	0.9 and 1.22 mm	V-Grooved	190300 <sup>1</sup>	189285 <sup>1</sup>	056193
.035 in	.035 in	0.9 mm	V-Grooved	079595	053700	056192
.045 in	.045 in	1.2 mm	V-Grooved	079596	053697	056193
.052 in	.052 in	1.3 mm	V-Grooved	079597	053698	056193
1/16 in	.062 in	1.6 mm	V-Grooved	079598	053699	056195
.035 in	.035 in	0.9 mm	U-Grooved	044749	072000	221912
3/64 in	.047 in	1.2 mm	U-Grooved	079599	053701	221912
.052 in	.052 in	1.3 mm	U-Grooved	—	053702	221912
1/16 in	.062 in	1.6 mm	U-Grooved	079601	053706	056195
5/64 in	.079 in	2.0 mm	U-Grooved	—	053704	056195
3/32 in	.094 in	2.4 mm	U-Grooved	—	053703	056196
7/64 in	.110 in	2.8 mm	U-Grooved	—	053705	056196
1/8 in	.126 in	3.2 mm	U-Grooved	—	053707	056197
.035 in	.035 in	0.9 mm	V-Knurled	079606	132958	056192
.045 in	.045 in	1.2 mm	V-Knurled	079607	132957	056193
.045 and 1/16 in	.045 and 1/16 in	1.22 and 1.6 mm	VK-Grooved	238687 <sup>1</sup>	238688 <sup>1</sup>	221030
.052 in	.052 in	1.3 mm	V-Knurled	079608	132956	056193
1/16 in	.062 in	1.6 mm	V-Knurled	079609	132955	056195
.068 – .072 in	.068 – .072 in	1.8 mm	V-Knurled	089984	132959	056195
5/64 in	.079 in	2.0 mm	V-Knurled	079610	132960	056195
3/32 in	.094 in	2.4 mm	V-Knurled	079611	132961	056196
7/64 in	.110 in	2.8 mm	V-Knurled	—	132962	056196
1/8 in	.126 in	3.2 mm	V-Knurled	—	132963	056197
.045 in	.045 in	1.2 mm	U-Cogged	083318	083489	056193
.052 in	.052 in	1.3 mm	U-Cogged	—	083490	056193
1/16 in	.062 in	1.6 mm	U-Cogged	079614	053708	056195
5/64 in	.079 in	2.0 mm	U-Cogged	—	053710	056195
3/32 in	.094 in	2.4 mm	U-Cogged	—	053709	056196
7/64 in	.110 in	2.8 mm	U-Cogged	—	053711	056196
1/8 in	.126 in	3.2 mm	U-Cogged	—	053712	056197

<sup>1</sup>Dual-size reversible drive roll

### 22/24 Series & SuitCase Feeders Nylon Wire Guides (For Feeding Aluminum Wire)

Wire Diameter	Inlet Guide #
.047 in (1.2 mm)	151203
1/16 in (1.6 mm)	151205
3/32 in (2.4 mm)	194264

Note: Each drive roll kit contains 2 Drive Rolls and an Inlet Guide.

Note: U-Groove drive rolls are recommended when feeding aluminum wire.



**4 Roll Kit**

## Drive Rolls **Millermatic® 300/350/350P with Meters (4 Drive Roll)** **54 Series, 24A & R-115 Feeders (4 Drive Roll)**

Wire Diameter			Drive Rolls			Wire Guide	
Fraction	Decimal	Metric	Type	Kit #	Individual Drive Roll Part #	Inlet #	Intermediate #
.023-.025 in	.023-.025 in	0.6 mm	V-Grooved	087132	087130	056192	056206
.030 in	.030 in	0.8 mm	V-Grooved	046780	053695	056192	056206
.035 in	.035 in	0.9 mm	V-Grooved	046781	053700	056192	056206
.035 and 3/64 in	.035/.045 in	0.9/1.2 mm	V-Grooved	227061 <sup>1</sup>	189285 <sup>1</sup>	056193	056207
3/64 in	.045 in	1.2 mm	V-Grooved	046782	053697	056193	056207
.052 in	.052 in	1.3 mm	V-Grooved	046783	053698	056193	056207
1/16 in	.062 in	1.6 mm	V-Grooved	046784	053699	056195	056209
.035 in	.035 in	0.9 mm	U-Grooved	044750	072000	221912	058853
3/64 in	.047 in	1.2 mm	U-Grooved	046785	053701	221912	058853
.035 and 3/64 in	.035 and .045 in	1.9 and 1.2 mm	U-Grooved	—	232826	221912	233843
.052 in	.052 in	1.3 mm	U-Grooved	—	053702	221912	058837
1/16 in	.062 in	1.6 mm	U-Grooved	046787	053706	058836	058837
5/64 in	.079 in	2.0 mm	U-Grooved	—	053704	056195	056209
3/32 in	.094 in	2.4 mm	U-Grooved	—	053703	056196	056210
7/64 in	.110 in	2.8 mm	U-Grooved	—	053705	056196	056210
1/8 in	.126 in	3.2 mm	U-Grooved	—	053707	056197	056211
.035 in	.035 in	0.9 mm	V-Knurlled	046792	132958	056192	056206
3/64 in	.045 in	1.2 mm	V-Knurlled	046793	132957	056193	056207
.052 in	.052 in	1.3 mm	V-Knurlled	046794	132956	056193	056207
1/16 in	.062 in	1.6 mm	V-Knurlled	046795	132955	056195	056209
5/64 in	.079 in	2.0 mm	V-Knurlled	046796	132960	056195	056209
3/32 in	.094 in	2.4 mm	V-Knurlled	046797	132961	056196	056210
7/64 in	.110 in	2.8 mm	V-Knurlled	—	132962	056196	056210
1/8 in	.126 in	3.2 mm	V-Knurlled	—	132963	056197	056211
3/64 in	.045 in	1.2 mm	U-Cogged	—	083489	056193	056207
.052 in	.052 in	1.3 mm	U-Cogged	—	083490	056193	056207
1/16 in	.062 in	1.6 mm	U-Cogged	—	053708	056195	056209
5/64 in	.079 in	2.0 mm	U-Cogged	—	053710	056195	056209
3/32 in	.094 in	2.4 mm	U-Cogged	—	053709	056196	056210
7/64 in	.110 in	2.8 mm	U-Cogged	—	053711	056196	056210
1/8 in	.126 in	3.2 mm	U-Cogged	—	053712	056197	056211

<sup>1</sup>Dual-size reversible V-groove drive roll (one .035 and one .045 in groove)

Wire Diameter	Inlet Guide #	Intermediate Guide #
.035-.047 in (0.9-1.2 mm)	058854	058853
1/16 in (1.6 mm)	058836	058837
.023-.052 in (0.6-1.3 mm)	221912	233843

**Note:** Each drive roll kit contains 4 Drive Rolls, an Inlet Guide, and an Intermediate Guide.

**Note:** U-Groove drive rolls are recommended when feeding aluminum wire.

# DRIVE ROLLS



Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. U-Grooved rolls for soft and soft shelled cored wires.
3. U-Cogged rolls for extremely soft shelled wires.
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirement (example: V-Knurled roll in combination with U-Grooved).

For a listing of special optional drive rolls:

**see page 52**

## Drive Rolls 62 series feeders, Pipe Pro 12 RC (2 roll kits), 64, 74 series feeder, Pipe Pro Single, Pipe Pro Single DX, Pipe Pro Dual DX, Pipe Worx 400 and all Axxess Feeders (4 roll kit)

Wire Diameter			Drive Rolls				Wire Guide		
Fraction	Decimal	Metric	Type	2 Roll Kit #	4 Roll Kit #	Individual Part #	Inlet #	Intermediate #	Antiwear #
.023 – .025 in	.023 – .025 in	0.6 mm	V-Grooved	151030	151024	087130	150993	149518	045233
.030 in	.030 in	0.8 mm	V-Grooved	—	151025	053695	150993	149518	045233
.035 in	.035 in	0.9 mm	V-Grooved	151032	151026	053700	150993	149518	045233
.035 and 3/64 in	.035/.045 in	0.9/1.2 mm	V-Grooved	190300 <sup>1</sup>	209533 <sup>1</sup>	189285 <sup>1</sup>	150994	149519	045233
.040 in	.040 in	1.0 mm	V-Grooved	—	161190	053696	150993	149518	045233
3/64 in	.045 in	1.2 mm	V-Grooved	151033	151027	053697	150994	149519	045233
.052 in	.052 in	1.3 mm	V-Grooved	151034	151028	053698	150994	149519	045233
1/16 in	.062 in	1.6 mm	V-Grooved	—	151029	053699	150995	149520	045233
.035 in	.035 in	0.9 mm	U-Grooved	151044	151036	072000	150993	149518	045233
.035 and 3/64 in	.035/.045 in	1.9/1.2 mm	U-Grooved	—	244293	232826	221912	242417 (.035) 205936 (3/64)	
3/64 in	.045 in	1.2 mm	U-Grooved	151045	151037	053701	150994	149519	045233
.047 in	.047 in	1.2 mm	U-Grooved	—	265256	053701	221912	205936	
.052 in	.052 in	1.3 mm	U-Grooved	—	—	053702	150994	149519	045233
1/16 in	.062 in	1.6 mm	U-Grooved	151047	151039	053706	150995	149520	045233
5/64 in	.079 in	2.0 mm	U-Grooved	—	—	053704	150995	149520	045233
3/32 in	.094 in	2.4 mm	U-Grooved	—	151041	053703	150996	149521	045233
7/64 in	.110 in	2.8 mm	U-Grooved	—	—	053705	150996	149521	045233
1/8 in	.126 in	3.2 mm	U-Grooved	—	—	053707	150997	149522	045233
.035 in	.035 in	0.9 mm	V-Knurled	151061	151052	132958	150993	149518	045233
3/64 in	.045 in	1.2 mm	V-Knurled	151062	151053	132957	150994	149519	045233
.052 in	.052 in	1.3 mm	V-Knurled	—	151054	132956	150994	149519	045233
1/16 in	.062 in	1.6 mm	V-Knurled	151064	151055	132955	150995	149520	045233
.068 – .072 in	.068 – .072 in	1.8 mm	V-Knurled	151065	151056	132959	150995	149520	045233
5/64 in	.079 in	2.0 mm	V-Knurled	151066	151057	132960	150995	149520	045233
3/32 in	.094 in	2.4 mm	V-Knurled	151067	151058	132961	150996	149521	045233
7/64 in	.110 in	2.8 mm	V-Knurled	—	151059	132962	150996	149521	045233
1/8 in	.126 in	3.2 mm	V-Knurled	—	151060	132963	150997	149522	045233
3/64 in	.045 in	1.2 mm	U-Cogged	—	151070	083489	150994	149519	045233
.052 in	.052 in	1.3 mm	U-Cogged	—	—	083490	150994	149519	045233
1/16 in	.062 in	1.6 mm	U-Cogged	—	151072	053708	150995	149520	045233
5/64 in	.079 in	2.0 mm	U-Cogged	—	—	053710	150995	149520	045233
3/32 in	.094 in	2.4 mm	U-Cogged	—	—	053709	150996	149521	045233
7/64 in	.110 in	2.8 mm	U-Cogged	—	—	053711	150996	149521	045233
1/8 in	.126 in	3.2 mm	U-Cogged	—	—	053712	150997	149522	045233

Dual-size reversible V-Groove drive roll (one .035 and one .045 in groove)

### 60 & 70 Series Nylon Wire Guides (For Feeding Aluminum Wire)

Wire Diameter	Inlet Guide #	Intermediate Guide #
.047 in (1.2 mm)	151203	151204
1/16 in (1.6 mm)	151205	151206

Note: Each drive roll kit contains 2 or 4 Drive Rolls, an Inlet Guide, an Intermediate Guide, and 045233 Antiwear Guide with 604612 Setscrew 8-32 x .125.

Note: U-Groove drive rolls are recommended when feeding aluminum wire.



# Miller Drive Rolls

	V-Groove	V-Groove	V-Groove	V-Groove	V-Knurl	V-Knurl	V-Knurl	Inlet Wire
<b>Machine</b>	.023/.024 (0.6 mm)	.030 (0.8 mm)	.035 (0.9 mm)	.045 (1.2 mm)	.030 (0.8 mm)	.035 (0.9 mm)	.045 (1.2 mm)	Guide
<b>SideKick™/SideKick™ XL</b>	090423	090423	090423	—	165603	165603	127229	058549
<b>Cricket®/Cricket® XL</b>	119028	119028	—	—	119028	119028	119028	058549
<b>Millermatic® 35</b>	—	057590 (2)	057590 (2)	—	—	—	—	058549
<b>Millermatic® 90/130/Challenger</b>	119028	119028	—	—	119028	119028	—	058549
<b>Millermatic® 130 XP/150/185</b>	090423	090423	090423	—	165603	165603	127229	058549
<b>Millermatic® Challenger™172</b>	090423	090423	090423	—	165603	165603	127229	058549
<b>Millermatic® Passport™/ Passport™ Plus 135/140/175/180/211</b>	202925	202925	202925	—	202926	202926	202926	058549
<b>Millermatic® 200/210/212/250/250x/251<sup>1</sup></b>	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
<b>Millermatic® 252/ 300 without meters<sup>1</sup></b>	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
<b>Millermatic® DVI™/Pulser/Vintage/Reach<sup>1</sup></b>	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
<b>Millermatic® 300 with meters/350P</b>	087132 (kit)	046780 (kit)	046781 (kit)	046782 (kit)	—	046792 (kit)	046793 (kit)	Page 54
<b>Millermatic® 125 Hobby/141/190/211 standard drive<sup>2</sup></b>	261157	261157	261157	—	261157	261157	—	261151
<b>Multimatic™ 200 standard drive rolls<sup>2</sup></b>	261157	261157	261157	—	261157	261157	261157	261151

<sup>1</sup>Optional Drive Rolls V-Groove .030(0.8mm) and .035(0.9mm) 204579<sup>2</sup>Optional Drive Rolls V-Groove .023/.024(0.6mm), .030(0.8mm) and .035(0.9mm) 220179; V-Knurl .030(0.8mm), .035(0.9mm) and .045(1.2mm) 202926; Inlet Wire 261151

# XR Controls Drive Rolls

Machine	U-Groove	U-Groove	U-Groove	U-Groove	U-Groove
<b>XR/XR-S/XR-D</b>	.030 in. (.76 mm)	.035 in. (.89 mm)	.040 in. (1.02 mm)	.47 in. (1.19 mm)	.062 in. (1.58 mm)
	268847	268847	268848	268849	268850

# Sub Arc Drive Rolls

Machine	Part #	Description	Wire sizes
<b>RAD-400, RAD-400T, RAD-780</b>			
	132955	V-K Groove Drive Roll	1/16 in. (.062 in.-1.6 mm)
	132960	V-K Groove Drive Roll	5/64 in. (0.79 in.-2.0 mm)
	132961	V-K Groove Drive Roll	3/32 in. (.094 in.-2.4 mm)
	132962	V-K Groove Drive Roll	7/64 in. (.110 in.-2.8 mm)
	132963	V-K Groove Drive Roll	1/8 in. (.125 in.-3.2 mm)
	193700	V-K Groove Drive Roll	5/32 in. (.156 in.-4.0 mm)
	193701	V-K Groove Drive Roll	3/16 in. (.188 in.-4.8 mm)

## Miller Spoolgun Drive Rolls

	V-Knurl	V-Knurl	V-Knurl	U-Knurl	Inlet Wire
Spoolguns	.030 in. (0.8 mm)	.035 in. (0.9 mm)	.045 in. (1.2 mm)	.062 in. (1.6 mm)	Guide
Spoolmate™ 100/185/3035	186414	186414	—	—	186410
Spoolmate™ 100/185/3035	186413	186413	—	—	186410
Spoolmate™ 200/3545	186414	186414	199397	—	186410
Spoolmate™ 200/3545	186413	186413	199396	—	186410
Spoolmate® 15A/30A	136135	136135	136135	136135	132521
Spoolmate® 15A/30A	183357	183357	183358	183358	132521
Spoolmate® 1, 2, 3	053131	053131	053131	053131	058549
XR™-15/XR™-30	053131	053131	053131	053131	on conduit
XR™-A /XR™-W Pistol	136135	136135	136135	136135	on conduit
XR™-A /XR™-W Pistol	183357	183357	183358	183358	on conduit
XR™-Edge	194114	194115	194116	194117	on conduit
XR™ Aluma-Pro™	227434	227434	227434	227434	227408
XR™ Aluma-Pro™ Lite	254756	254756	254756	254756	227408
XR™ Aluma-Pro™ Plus	227434	227434	227434	227434	227408

## Hobart Drive Rolls

Machine	Hard Wire (Steel)		Soft Wire (Aluminum)	HT Wire (Hard Tubular)			Inlet Wire Guide
	V-Groove .024 (0.6 mm)	V-Groove .030-.035 (0.8-0.9 mm)	Urethane .035 (0.9 mm)	V-Knurl .030-.035 & .045 (0.8-0.9 & 1.2 mm)	Rev. Knurl .030 & .035 (0.8 & 0.9 mm)	Rev. Knurl .039-.045 (0.8-1.2 mm)	
Handler® 120/130XL/ 135/140/150/170/175/1 80/187/190/210	202925	202925 261157	—	202926	193330	193331	—
IronMan™ 210/250	—	202925	—	202926	193330	193331	—
IronMan™ 275 IronMan™ 230	Standard drive roll is part number 235286 v-grooved wire size is .030 - .035 other sizes available on page 46 under 52 series feeders.						
Handler® 125/ 125EZ/130	212379 — 2-sided combination roll (.024 V-groove) (.030/.035 VK-groove)						212368 242524 (wire size .023-.045)

Note: For all Beta-MIG drive rolls, contact Miller Service Parts

Available for Handler 120 and IronMan 210

## Special Optional Drive Rolls

For 22/32/52/54/60/70 Series Feeders

Part #	Description
203526	Dual V-Groove (one .030 and one .035 in groove)
189285	Dual V-Groove (one .035 and one .045 in groove)
190300	Dual V-Groove (2 drive rolls each with one .035 and one .045 in groove plus inlet guide)
209533	Dual V-Groove 4 Roll Kit (4 drive rolls each with one .035 and one .045 in groove plus guides and setscrew)
198078	No-Groove, Universal Quick-Change (Steel)
088402	No-Groove, Non-Quick-Change (Hard Urethane—Green)
0537160010890	No-Groove (Soft Urethane—Blue)

## Conversion Kits

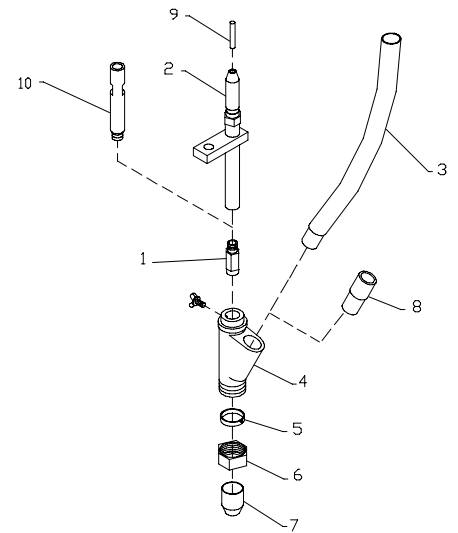
Part #	Description	Part #	Description
155454	2 Roll Conversion Kit	155455	4 Roll Conversion Kit



## OBT-600 Consumables

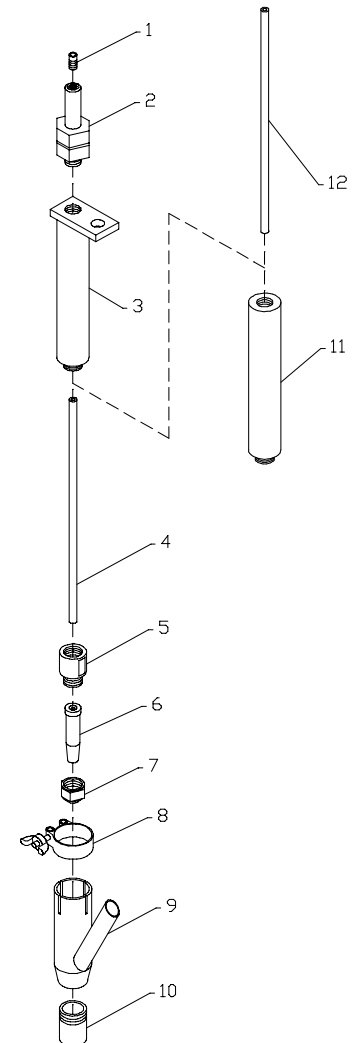
Item #	Part #	Description
	<b>043923</b>	<b>600 Amp Torch for 3/32–3/16 in. (1.6–4.8 mm) wires</b>
1	<b>192700<sup>2</sup></b>	Tip, contact 1/16 in. (1.6 mm)
1	<b>192701<sup>2</sup></b>	Tip, contact 5/64 in. (2.0 mm)
1	<b>192702<sup>2</sup></b>	Tip, contact 3/32 in. (2.4 mm)
1	<b>192703<sup>2</sup></b>	Tip, contact 7/64 in. (2.8 mm)
1	<b>192704<sup>2</sup></b>	Tip, contact 1/8 in. (3.2 mm)
1	<b>192705<sup>2</sup></b>	Tip, contact 5/32 in. (4.0 mm)
2	<b>192692</b>	Torch body
3	<b>192694</b>	Hose, flux with insulator
4	<b>192693</b>	Cone assembly, body
5	<b>192695</b>	Ferrule, locking
6	<b>192697</b>	Nut, retaining
7	<b>192696</b>	Cone, flux
8	<b>200566</b>	Adapter, hose
9	<b>193146<sup>1</sup></b>	Liner, wire 1/16 – 1/8 x 8.125
9	<b>193145<sup>1</sup></b>	Liner, wire 5/32 x 8.125
10	<b>043967<sup>2</sup></b>	Extension, torch body OBT–1 inch
10	<b>043969<sup>2</sup></b>	Extension, torch body OBT–2 inch
10	<b>043973<sup>2</sup></b>	Extension, torch body OBT–4 inch
10	<b>043975<sup>2</sup></b>	Extension, torch body OBT–6 inch

<sup>1</sup>Recommended spare part. <sup>2</sup>Optional.



## OBT-1200 Consumables

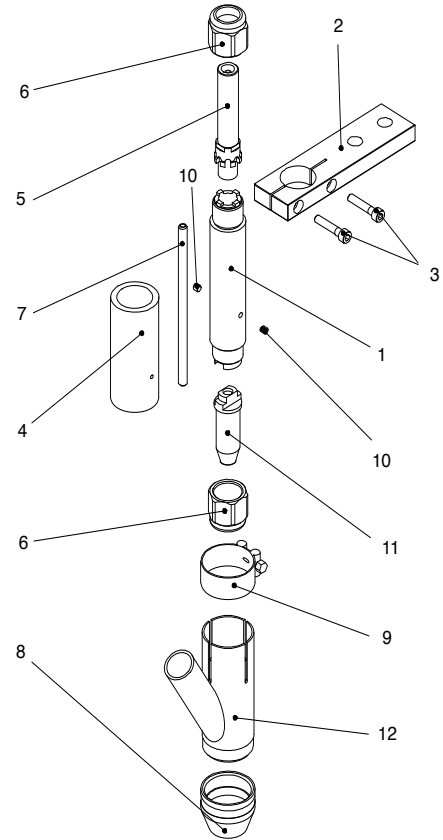
Item #	Part #	Description
	<b>043900</b>	<b>1200 Amp Subarc Torch 1/16–3/16 in. (1.6–4.8 mm) wire</b>
1	<b>199945</b>	Guide, wire inlet 5/32–1/4
1	<b>199946</b>	Guide, wire inlet 1/16–1/8
2	<b>192132</b>	Inlet guide adapter, with breakaway feature
3	<b>192131</b>	Torch body assembly
4	<b>192139</b>	Liner, wire 1/16–1/8 in
4	<b>192687</b>	Liner, wire 5/32–3/16 in
5	<b>192133</b>	Extender, tip
6	<b>192141</b>	Tip, contact 1/16 in. (1.6 mm)
6	<b>199026</b>	Tip, contact 5/64 in. (2.0 mm)
6	<b>192142</b>	Tip, contact 3/32 in. (2.4 mm)
6	<b>200771</b>	Tip, contact 7/64 in. (2.8 mm)
6	<b>192143</b>	Tip, contact 1/8 in. (3.2 mm)
6	<b>192144</b>	Tip, contact 5/32 in. (4.0 mm)
6	<b>192136</b>	Tip, contact 3/16 in. (4.8 mm)
7	<b>192135</b>	Nut, tip
8	<b>192758</b>	Clamp, securing
9	<b>192137</b>	Nozzle assembly, flux
10	<b>192138</b>	Nozzle, flux replaceable
11	<b>043981</b>	Torch body extension 8.5 in.
12	<b>200749</b>	Liner, wire 1/16–1/8 x 36 in.
12	<b>200750</b>	Liner, wire 5/32–3/16 x 36 in.



# SUBMERGED ARC

## 1200 Amp Single-Wire Torch Consumables

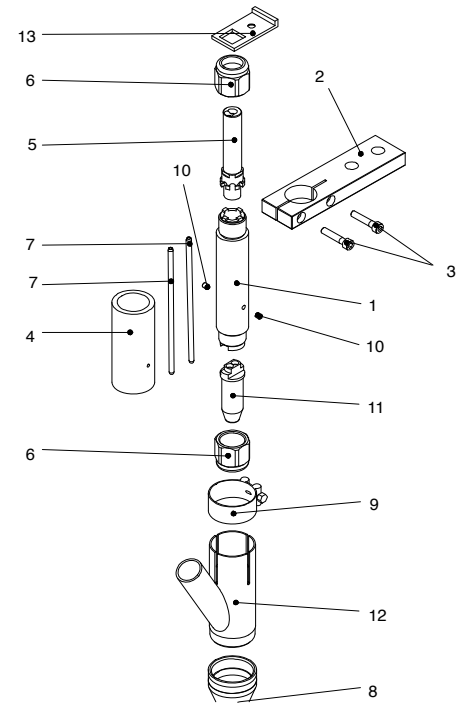
Item #	Part #	Description
	301141	Short, 11.3 in. (288 mm) 1200 Amp torch for 1/16–5/32in. (1.6–4.0mm) wire
1	266660	Torch body
2	266662	Power source connector
3	266665	Screw, HSHC, M6x30
4	266663	Torch body insulator
5	266666	Wire feeder connector
6	264580 <sup>1</sup>	Nut
7	264581 <sup>1</sup>	Wire liner, 286 mm
8	264586 <sup>1</sup>	Flux nozzle, D.26
9	266667	Clamp, D.40
10	266668	Nut, M5 X 5
11	264590 <sup>2</sup>	Tip, contact single wire 1/16 in. (1.6 mm) CuCrZr
11	264591 <sup>2</sup>	Tip, contact single wire 5/64 in. (2.0 mm) CuCrZr
11	264587 <sup>1</sup>	Tip, contact single wire 3/32 in. (2.4 mm) CuCrZr
11	264593 <sup>2</sup>	Tip, contact single wire 1/8 in. (3.2 mm) CuCrZr
11	264594 <sup>2</sup>	Tip, contact single wire 5/32 in. (4.0 mm) CuCrZr
12	264589 <sup>1</sup>	Flux conveyor



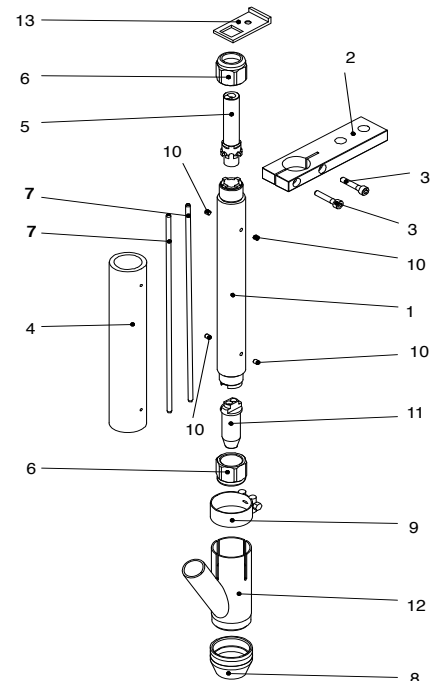


## 1200 Amp Twin-Wire Torch

Item #	Part #	Description
	<b>301143</b>	<b>Short, 11.3 in. (288 mm) 1200 Amp torch for 3/64–3/32 in. (1.2–2.4 mm) wire</b>
1	266660	Torch Body
2	266662	Power Source Connector
3	266665	Screw, HSHC, M6 X 30
4	266663	Torch Body Insulator
5	266669	Wire Feeder Connector
6	264580 <sup>1</sup>	Nut
7	264584 <sup>1</sup>	Wire Liner, D. 5 X 3 146 mm
8	264586 <sup>1</sup>	Flux Nozzle, D.26
9	266667	Clamp, D.40
10	266668 <sup>1</sup>	Nut, M5 X 5
11	264595 <sup>2</sup>	Tip, Contact Twin Wire 3/64 in. (1.2 mm) CuCrZr
11	264596 <sup>2</sup>	Tip, Contact Twin Wire 1/16 in. (1.6 mm) CuCrZr
11	264597 <sup>2</sup>	Tip, Contact Twin Wire 5/64 in. (2.0 mm) CuCrZr
11	264588 <sup>1</sup>	Tip, Contact Twin Wire 3/32 in. (2.4 mm) CuCrZr
12	264589 <sup>1</sup>	Flux Conveyor
13	266670	Alignment Plate



Item #	Part #	Description
	<b>301444</b>	<b>Long, 16.8 in. (427 mm) 1200 Amp torch for 3/64–3/32 in. (1.2–2.4 mm) wire</b>
1	266661	Torch Body
2	266662	Power Source Connector
3	266665	Screw, HSHC, M6 X 30
4	266664	Torch Body Insulator
5	266669	Wire Feeder Connector
6	264580 <sup>1</sup>	Nut
7	264585 <sup>1</sup>	Wire Liner, D. 5 X 3 287 mm
8	264586 <sup>1</sup>	Flux Nozzle, D.26
9	266667	Clamp, D.40
10	266668 <sup>1</sup>	Nut, M5 X 5
11	264595 <sup>2</sup>	Tip, Contact Twin Wire 3/64 in. (1.2 mm) CuCrZr
11	264596 <sup>2</sup>	Tip, Contact Twin Wire 1/16 in. (1.6 mm) CuCrZr
11	264597 <sup>2</sup>	Tip, Contact Twin Wire 5/64 in. (2.0 mm) CuCrZr
11	264588 <sup>1</sup>	Tip, Contact Twin Wire 3/32 in. (2.4 mm) CuCrZr
12	264589 <sup>1</sup>	Flux Conveyor
13	266670	Alignment Plate



<sup>1</sup>Recommended spare part. <sup>2</sup>Optional

## Spectrum® Plasma Torch History

Model	Machine Stock #	Original Torch	Recommended Replacement
Spectrum® 125C	907149, 907169 (N/A)	ICE-12C, pg 63	ICE-12C, 20 ft (6.1 m) Hand-Held 195172, pg 63
Spectrum® 300	903479, 903787 (N/A)	ICE-25C, pg 63	ICE-25CX, 20 ft (6.1 m) Hand-Held 195007, pg 63 (N/A)
Spectrum® 375	903891, 903871 CE (N/A)	ICE-27C, pg 63	XT30C, 20 ft (6.1 m) Hand-Held 255685, pg 60
	907532 (N/A)	XT-30C, pg 60	XT30C, 20 ft (6.1 m) Hand-Held 255685, pg 60
Spectrum® 375 X-TREME™	907339, 907303 (N/A)	ICE-27T, pg 63	XT30, 12 ft (3.7 m) Hand-Held 249949, pg 60
	907529 (N/A)	XT30, pg 60	XT30, 12 ft (3.7 m) Hand-Held 249949, pg 60
Spectrum® 500	903143, 903144, (N/A)	APT-5000 (N/A)	ICE-50, 30 ft (9 m) Hand-Held 169199 <sup>1</sup> , pg 67 (N/A)
	903145, 903146, (N/A)		ICE-50, 50 ft (15.2 m) Hand-Held 169244 <sup>1</sup> , pg 67 (N/A)
	903187, 903201 (N/A)		
Spectrum® 625	907058, (N/A)	ICE-40C, pg 64	ICE-40C, 25 ft (7.6 m) Hand-Held 195110, pg 64
	907058011 (N/A)		ICE-40C, 50 ft (15.2 m) Hand-Held 195111, pg 64
Spectrum® 625 X-TREME	907404, 907404011 (N/A)	ICE-40T, pg 64	XT-40, 12 ft (3.7 m) Hand-Held 249951, pg 61
	9074041012 (N/A)		XT40, 20 ft (6.1 m) Hand-Held 249952, pg 61
	907531, (N/A)	XT40, pg 61	XT40, 12 ft (3.7 m) Hand-Held 249951, pg 61
	907531001 (N/A)		XT40, 20 ft (6.1 m) Hand-Held 249952, pg 61
Spectrum® 625 X-TREME	907579	XT40 w/Connect	XT40, 12 ft (3.7 m) Hand-Held W/ Disconnect 260633, pg 61
	907579001		XT40, 20 ft (6.1 m) Hand-HeldW/ Disconnect 260635, pg 61
	907579002		XT40M Machine Long Body 25 ft (7.6 m) 259305, pg 61
	90757903 (N/A)		XT40M Machine Torch Short Body 25 ft (7.6 m) 257462, pg 61 (N/A)
Spectrum® 650	903788, 903790 (N/A)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65
			ICE-50C, 50 ft (15.2 m) Hand-Held 176826, pg 65
			ICE-50CM, 50 ft (15.2 m) Machine-Held 176828, pg 65
			<b>Note: ICE-55C Not Recommended</b>
Spectrum® 700	903444, 903445 (N/A) 903446, 903447 (N/A)	ICE-50, pg 67	ICE-50, 30 ft (9 m) Hand-Held 169199, (N/A)
			ICE-50, 50 ft (15.2 m) Hand-Held 169244, (N/A)
			ICE-70 with 50 Amp Tip, 30 ft (9 m) Hand-Held 169203, pg 67 (N/A)
			ICE-70 with 50 Amp Tip, 50 ft (15.2 m) Hand-Held 169245, pg 67 (N/A)
Spectrum® 701	950468, 950471 (N/A) 950469, 950472 (N/A) 950470, 950473 (N/A)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65
			ICE-50C, 50 ft (15.2 m) Hand-Held 176826, pg 65
			ICE-50CM, 50 ft (15.2 m) Machine-Held 176828
			<b>Note: ICE-55C Not Recommended.</b>
Spectrum® 750	903193, 903194, (N/A) 903195 (N/A)	APT-7000 (N/A)	ICE-70, 30 ft (9 m) Hand-Held 169203 <sup>2</sup> , pg 67 (N/A)
			ICE-70, 50 ft (15.2 m) Hand-Held 169245 <sup>2</sup> , pg 67 (N/A)
			ICE-100 with 70 Amp Tip, 30 ft (9 m) Hand-Held 169207 <sup>2</sup> , pg 67 (N/A)
Spectrum® 875	907390011 (N/A) 907390012 (N/A)	ICE-60T, pg 68	ICE-60T, 20 ft (7.6 m) Hand-Held 234132, pg 68
			ICE-60T, 50 ft (15.2 m) Hand-Held 234134, pg 68
			XT60, 20 ft Hand-Held Torch 249953, pg 62
			XT60, 50 ft Hand-Held Torch 249954, pg 62
			XT60M 25 ft (7.6 m) Machine Torch Long Body 249955, pg 62
			XT60M 50 ft (15.2 m) Machine Torch Long Body 249956, pg 62
			XT60M 25 ft (7.6 m) Machine Torch Short Body 257464, pg 62 (N/A)
XT60M 50 ft (15.2 m) Machine Torch Short Body 263952, pg 62 (N/A)			
Spectrum® 875	907583 907583001 907583002 907583003	XT60, pg 62	XT60 20 ft (7.6 m) Hand-Held 249953, pg 62
			XT60 50 ft (15.2 m) Hand-Held 249954, pg 62
			XT60M 25 ft (7.6 m) Machine Torch Long Body 249955, pg 62
			XT60M 50 ft (15.2 m) Machine Torch Long Body 249956, pg 62
			XT60M 25 ft (7.6 m) Machine Torch Short Body 257464, pg 62 (N/A)

<sup>1</sup>Requires Retrofit Kit 172155 (N/A) <sup>2</sup>Requires Retrofit Kit 172156 (N/A)

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More Torch models continued on next page



## Spectrum® Plasma Torch History Continued

Spectrum® 875 Auto-Line	907396 (N/A)		XT60M, 20 ft (7.6 m) Hand-Held 249953, pg 62										
	907396001 (N/A)		XT60, 50 ft (15.2 m) Hand-Held 249954, pg 62										
	907396002 (N/A)		ICE-60TM, 25 ft (7.6 m) Machine-Held Torch with Pendant 300759, pg 68										
	907396003 (N/A)		Kit, ICE-60TM, Machine Torch 50 ft 300760 pg 68										
Spectrum® 875 Auto-Line	907584		XT60, 20 ft (7.6 m) Hand-Held 249953, pg 62										
	907584001		XT60, 50 ft (15.2 m) Hand-Held 249954, pg 62										
	907584002		XT60M, 25 ft (7.6 m) Machine Torch Long Body 249955, pg 62										
	907584003		XT60M, 25 ft (7.6 m) Machine Torch Short Body 257464, pg 62 (N/A)										
	907584004		XT60M, 50 ft (15.2 m) Machine Torch Short Body 263952, pg 62 (N/A)										
	907584005		XT60M, 50 ft (15.2 m) Machine Torch Long Body 249956, pg 62										
Spectrum® 1000	903448, 903449 (N/A)	ICE-70, pg 67	ICE-70, 30 ft (9 m) Hand-Held 169203, pg 67 (N/A)										
	903448011 (N/A)		ICE-70, 50 ft (15.2 m) Hand-Held 169245, pg 67 (N/A)										
			ICE-100 with 70 Amp Tip, 30 ft (9 m) Hand-Held 169207, pg 67 (N/A)										
			ICE-100 with 70 Amp Tip, 50 ft (15.2 m) Hand-Held 169246, pg 67 (N/A)										
	907162 (N/A)	ICE-80T, pg 70	ICE-80T, 25 ft (7.6 m) Hand-Held 195223, pg 70										
			ICE-80T, 50 ft (15.2 m) Hand-Held 195225, pg 70										
			ICE-80TM, 25 ft (7.6 m) Machine-Held 195221, No Pendant <sup>4</sup> (N/A)										
			ICE-80TM, 50 ft (15.2 m) Machine-Held 223535, No Pendant <sup>4</sup> (N/A)										
Spectrum® 1250	903450, 903451 (N/A)	ICE-100, pg 67	ICE-100, 30 ft (9 m) Hand-Held 169207, pg 67 (N/A)										
	903452 (N/A)		ICE-100, 50 ft (15.2 m) Hand-Held 169246, pg 67 (N/A)										
			ICE-100M, 50 ft (15.2 m) Machine-Held 169247, (N/A)										
Spectrum® 1251	907305011 (N/A)	ICE-100T, pg 72	ICE-100T, 25 ft (7.6 m) Hand-Held 225702, pg 72										
	907305012 (N/A)		ICE-100T, 50 ft (15.2 m) Hand-Held 225704, pg 72 (N/A)										
	907305013 (N/A)		ICE-100TM, 25 ft (7.6 m) Machine-Held 225706 <sup>4</sup> , pg 72 (N/A)										
	907305014 (N/A)		ICE-100TM w/Pendant, 25 ft (7.6 m) Machine-Held 226057 <sup>4</sup>										
			ICE-100TM, 50 ft (15.2 m) Machine-Held 225708 <sup>4</sup> , pg 72 (N/A)										
			ICE-100TM, 50 ft (15.2 m) Machine-Held 226058 <sup>4</sup> , (N/A)										
Spectrum® 1500	903147, 903148 (N/A)	APT-8000 (N/A)	ICE-70, 30 ft (9 m) Hand-Held 169203 <sup>5</sup> , pg 67 (N/A)										
	903186, 903149 (N/A)		ICE-70, 50 ft (15.2 m) Hand-Held 169245 <sup>5</sup> , pg 67										
			ICE-100 with 70 Amp Tip, 30 ft (9 m) Hand-Held 169207 <sup>5</sup> , pg 67										
Spectrum® 1500D	907305 (N/A)	APT-8000 (N/A)	ICE-70, 30 ft (9 m) Hand-Held 169203, pg 67 (N/A)										
			ICE-70, 50 ft (15.2 m) Hand-Held 169245, pg 67										
			ICE-100 with 70 Amp Tip, 30 ft (9 m) Hand-Held 169207, pg 67										
Spectrum® 2050	903789 (N/A)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65										
			ICE-50C, 50 ft (15.2 m) Hand-Held 176826, pg 65										
Spectrum® 2050	903777012 (N/A)	ICE-55C, pg 66	ICE-55C, 25 ft (7.6 m) Hand-Held 193347, pg 66										
	903777013 (N/A)		ICE-55C, 50 ft (15.2 m) Hand-Held 193348, pg 66										
	903777022 (N/A)		ICE-55CM, 50 ft (15.2 m) Machine-Held 193349, pg 66, No Pendant										
Spectrum® 2255	903755 (N/A)		ICE-80CX, 25 ft (7.6 m) Hand-Held 216300, pg 71										
Spectrum® 3080	903793012, 903795011 (N/A)	ICE-80CX, pg 70	ICE-80CX, 25 ft (7.6 m) Hand-Held 216300, pg 71										
	903793013, 903795012 (N/A)		ICE-80CX, 50 ft (15.2 m) Hand-Held 218044, pg 71										
	903793021, 903795021 (N/A)		ICE-80CXM, 50 ft (15.2 m) Machine-Held 219944										
Spectrum®LYNX	903552, 950611 (N/A)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65										
			ICE-50C, 50 ft (15.2 m) Hand-Held 176826, pg 65										
Spectrum® Thunder			<b>Note: ICE-55C Not Recommended</b>										
	903741, 903742 (N/A)	ICE-12C (N/A), pg 62	ICE-12C, 20 ft ( 6.1 m) Hand-Held (kit) 216407, pg 63										
			<table border="1"> <thead> <tr> <th colspan="2">Leather Torch Cable Covers</th> </tr> <tr> <th>Description</th> <th>Part #</th> </tr> </thead> <tbody> <tr> <td>20 ft Cable Cover</td> <td>239642</td> </tr> <tr> <td>25 ft Cable Cover</td> <td>231867</td> </tr> <tr> <td>50 ft Cable Cover</td> <td>231868</td> </tr> </tbody> </table>	Leather Torch Cable Covers		Description	Part #	20 ft Cable Cover	239642	25 ft Cable Cover	231867	50 ft Cable Cover	231868
Leather Torch Cable Covers													
Description	Part #												
20 ft Cable Cover	239642												
25 ft Cable Cover	231867												
50 ft Cable Cover	231868												

<sup>1</sup> Requires Retrofit Kit 172155 N/A <sup>2</sup> Requires Retrofit Kit 172156 (N/A) <sup>3</sup> Requires Remote Pendant Control 180605

<sup>4</sup> Requires Remote Pendant Control 195513 <sup>5</sup> Requires Retrofit Kit 172157 (N/A).

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## AirForce™ and Cybercut (Hobart) Plasma Torch History

Model	Machine Stock #	Original Torch	Recommended Replacement
AirForce™ 250	500436 (NA)	ICE-12C, pg 63	ICE-12C, 20 ft (6.1 m) Hand-Held 216407, pg 63
AirForce™ 250A	500437 (NA)	ICE-12C, pg 63	ICE-12C, 20 ft (6.1 m) Hand-Held 216407, pg 63
AirForce™ 250CI	500534 (NA)	HP-25, pg 73	HP-25, 16 ft (5 m) Hand-Held 232647, pg 73
AirForce™ 12CI	<b>500564</b>	XT12R, pg 59	XT-12R, 12 ft (3.6 m) Hand-Held 268919
AirForce™ 375	500453 (NA)	ICE-25C, pg 63	ICE-25CX, 20 ft (6.1 m) Hand-Held 195007, pg 63 (N/A)
AirForce™ 400	500474 (NA)	ICE-27C, pg 63	XT-30C, 20 ft (6.1m) Hand-Held 255685, pg 60
AirForce™ 500i	500548 (NA)	HP-50, pg 73	HP-50, 16 ft (5 m) Hand-Held 244121, pg 73
AirForce™ 271	<b>500565</b>	XT30R, pg 60	XT-30R, 12 ft (3.6 m) Hand-Held 268921
AirForce™ 625	500493 (NA)	ICE-40C, pg 64	ICE-40C, 25 ft (7.6 m) Hand-Held 195110, pg 64
	500494 (NA)		ICE-40C, 50 ft (15.2 m) Hand-Held 195111, pg 64
AirForce™ 700i	500546 (NA)	HP-70, pg 73	HP-70, 16 ft (5 m) Hand-Held 244122, pg 73
AirForce™ 401	<b>500566</b>	XT40R, pg 61	XT-40R, 12 FT (3.6 m) Hand-Held 268923, pg 60
AirForce™ 750	500455 (NA)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65
Cybercut 1025	903665 (NA)	ICE-25C, pg 63	ICE-25CX, 20 ft (6.1 m) Hand-Held 195007, pg 63 (N/A)
Cybercut 2050	950674 (NA)	ICE-50C, pg 65	ICE-50C, 25 ft (7.6 m) Hand-Held 176824, pg 65
	950673, 950681 (NA)		

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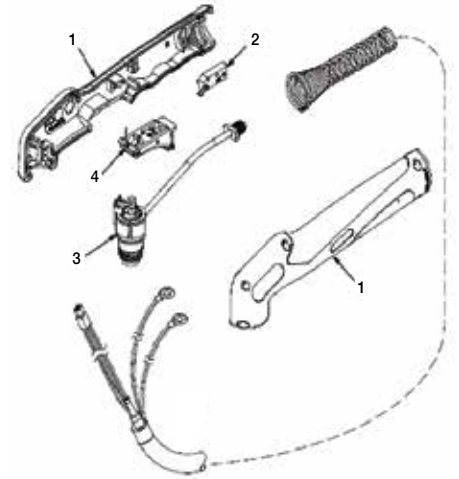




## XT12R

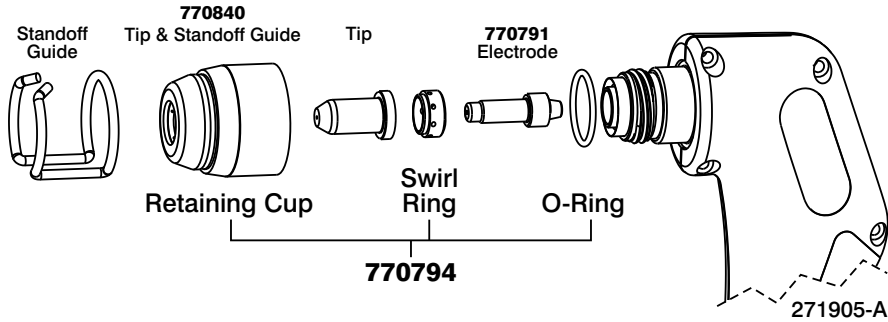
### Service Parts/Consumables

Item #	Part #	Description	Quantity
	<b>249949</b>	<b>XT12R, 12 ft Hand-Held Torch (replacement)</b>	<b>1</b>
1	<b>268929</b>	Torch Handle Kit	1
2	<b>249971</b>	Torch Trigger	1
3	<b>252938</b>	Torch Body w/Cup Switch	1
4	<b>249972</b>	Torch Trigger Assembly w/Spring	1
<b>Consumables</b>			
	<b>252951</b>	Grease, Silicone	
	<b>770840</b>	Tip & Standoff Guide	
	<b>770791</b>	Electrode	
	<b>770794</b>	Retaining Cup, Swirl Ring, & O-Ring	



XT12R

### Consumables for XT12R



# PLASMA CUTTING

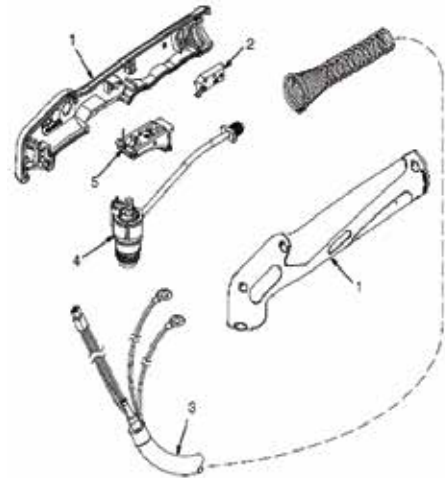
## XT30, XT30C & XT30R

### Service Parts/Consumables

Item #	Part #	Description	Quantity
	249949	XT30, 12 ft Hand-Held Torch (replacement)	1
	255685	XT30C, 20 ft Hand-Held Torch (replacement)	1
	268920	XT30R, 12 ft Hand-Held Torch (replacement)	
1	268929	Torch Handle Kit	1
1	259870	Torch Handle Kit	
2	249971	Torch Trigger	1
3	N/A	Leads XT30R, no replacement leads	
3	249957	Leads, XT30 12ft	
3	255686	Leads, XT30C 20 ft Hand Held Torch	
4	252938	Torch Body w/Cup Switch for XT30, XT30C, XT30R	1
5	249972	Torch Trigger Assembly w/Spring	1
	249973	Cup Detect Switch w/Screws	

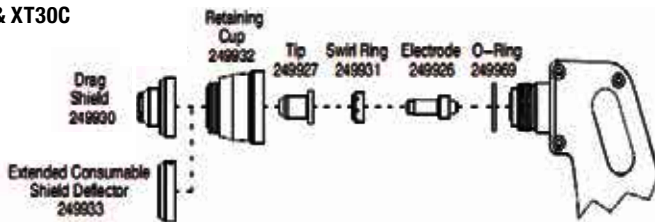
Consumables for XT30 and XT30C			
	249930	Drag Shield	1
	249933	Shield Deflector	1
	249932	Retaining Cup	1
	249927	Tip	3
	249931	Swirl Ring	1
	249926	Electrode	3
	249969	O-Ring	3
	253054	Stand-Off Guide	
	253520	Consumables Kit XT30	

XT30 & XT30C Consumables Kit Includes - v(1) O-ring 249969, (5) Electrode 249926, (5) Tip 249927, (1) Swirl Ring 249931, (1) Retaining Cup 249932, (1) Silicone Grease 252951, (1) Plastic Box 127493

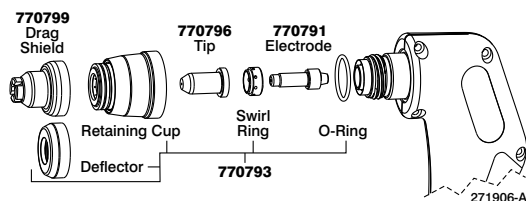


XT30, XT30C & XT30R Torch

### Consumables for XT30 & XT30C



### Consumables for XT30R





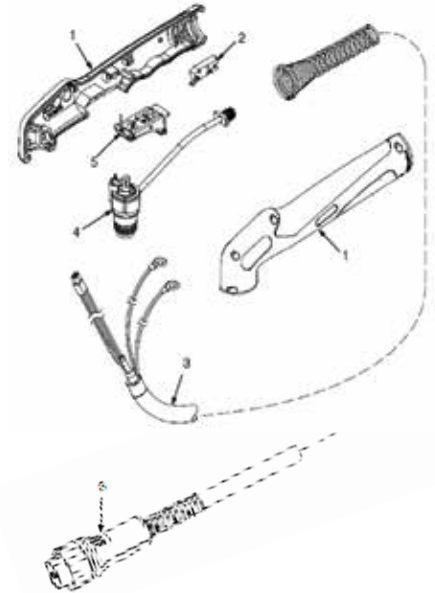
## XT40, XT40R & XT40M

### Service Parts/Consumables

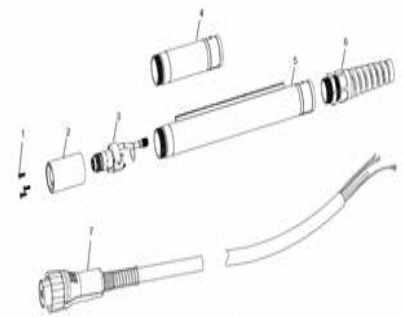
Item #	Part #	Description	Quantity
	249951	XT40, 12 ft Hand Held Torch	
	249952	XT40, 20 ft Hand-Held Torch	
	260633	XT40, 12 ft Hand-Held Torch w/Disconnect	
	260635	XT40, 20 ft Hand-Held Torch w/Disconnect	
	268923	XT40R, 12 ft Hand-Held Torch (Replacement)	
1	259870	Torch Handle Kit w/Screws	1
2	249971	Torch Trigger (Microswitch)	1
3	249959	Leads, XT40 12 ft Hand-Held Torch	1
3	249960	Leads, XT40 20 ft Hand-Held Torch	1
3	260637	Leads, XT40 12 ft Hand-Held Torch w/Disconnect	1
3	260638	Leads, XT40 20 ft Hand-Held Torch w/Disconnect	1
3	N/A	XT40R, No Replacement Leads	
4	252938	Torch Body Kit for XT40 and XT40R	1
4	252238	Torch Body Kit for XT40	
5	249972	Torch Trigger Assembly w/Spring	1
6	249973	Cup Detect Switch w/Screws	
	259305	XT40M, 25 ft Long Body Machine Torch w/Disconnect	
	257462	XT40M, 25 ft Short Body Machine Torch w/Disconnect	
1	259363	Mounting Screw for Machine Torch Body	3
2	259361	Mounting Sleeve for Machine Torch	1
3	259333 (N/A)	Kit, Torch Body w/Switch	1
4	263389	Positioning Sleeve Short Body	1
5	259357	Positioning Sleeve Long Body	1
6	259359	Stain Relief	1
7	259330	Leads, XT40M 25 ft Machine Torch	1
	253521	Consumables Kit XT40 <sup>1</sup>	

<sup>1</sup> Consumables Kit XT40 253521-includes (5) Electrode 249926, (5) Tips 40\_A 249928, (3) Tips 30A 249927(1) o-ring 249969, (1) Swirl ring 249931, (1) Retaining Cup 249932, (1) Gauge Tip 249936, (1) Gauge Shield 249936, (2) Drag Shield 30A 249930, (1) Drag Shield 40A 251960, (1) Deflector Shield 249933, (1) Silicone Grease 252951, (1) Plastic Box 127493

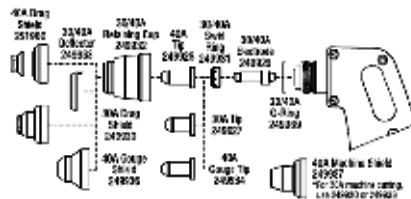
### XT40 & XT40 with Disconnect



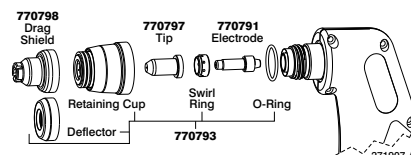
### XT40TM Torch Long & Short



### Consumables for XT40



### Consumables for XT40R



263310  
Shield Sense

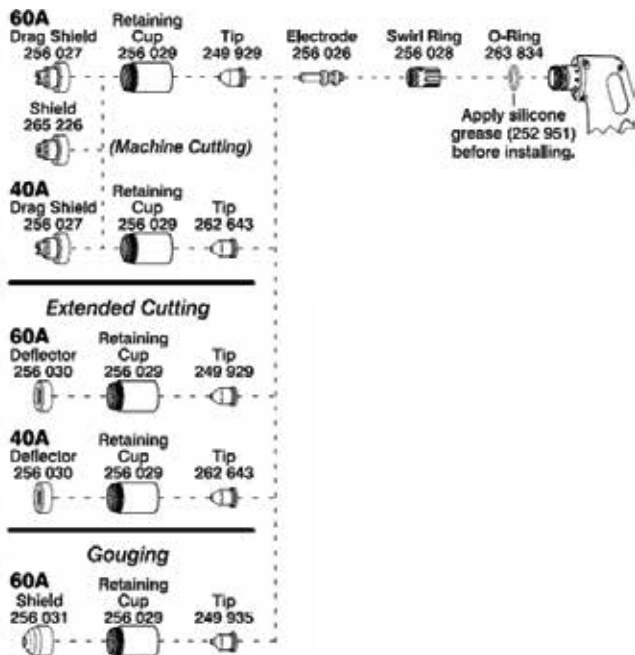
# PLASMA CUTTING

## XT60 & XT60M Service Parts/Consumables

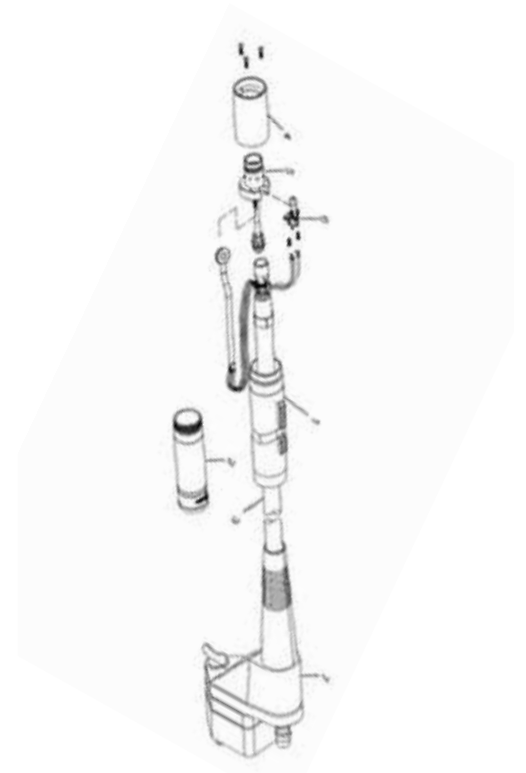
Item #	Part #	Description	Quantity
	249953	XT60, 20 ft Hand Held Replacement Torch	
	249954	XT60, 50 ft Hand Held Replacement Torch	
1	263950	Torch Handle Kit w/Screws	1
2	249971	Torch Trigger (Microswitch)	1
3	249961	Leads, XT60 20 ft Hand-Held Replacement Torch	1
3	249962	Leads, XT60 50 ft Hand-Held Replacement Torch	1
4	256039	Torch Body Kit w/Switch	1
5	249972	Torch Trigger Assembly w/Spring	1
6	249973	Cup Detect Switch w/Screws	1
		<b>XT60M Machine Torches</b>	
	249955	XT60M, 25 ft Long Body Machine Torch	
	249956	XT60M, 50 ft Long Body Machine Torch	
	257464	XT60M, 25 ft Short Body Machine Torch (N/A)	
	263952	XT60M, 50 ft Short Body Machine Torch (N/A)	
1	259357	Long Body Positioning Sleeve	1
2	263389	Short Body Positioning Sleeve	1
3	249963	XT60M Lead, w/QD 25 ft	1
3	249964	XT60M Lead, w/QD 50 ft	1
4	259361	Torch Sleeve	1
5	256040	Main Body w/Switch	1
6	259334	Cup Detect Switch	1
7	243754	Kit, XT60M QD w/Wing Head Fastener	1
	252951	Grease, silicone	1
	256033	Consumable Kit, XT60 <sup>1</sup>	
	253054	Stand-off Roller Guide	1
	253055	Circle Cutting Guide	1

<sup>1</sup>XT60 Consumable kit Includes, (3) Electrodes 256026, (3) Tip XT60 249929, (1) Drag Shield 256027, (1) Swirl Ring 256028, (1) Retaining Cup 256029, (1) Deflector Shield 256030, (1) Gauge Tip 2499935, (1) O-ring 263834, (1) Grease, Silicone 252951, (1) Plastic Box 127493

### Consumables for XT60 & XT60M



XT60 Torch



XT60M Torch



263310  
Shield Sense

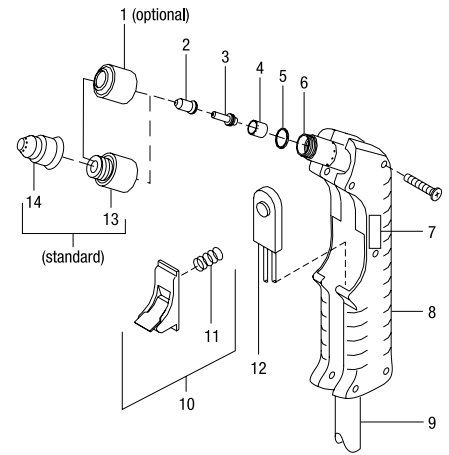


## ICE-12C Service Parts/Consumables

Item #	Part #	Description	Quantity
	216407	ICE-12C Replacement Torch w/Brass Elbow	1
	195172	ICE-12C, 20 ft Torch	1
<b>Consumables</b>			
1	196928	Cup, Shield (optional)	1
2	196926	Tip, 12 A	1 (5 per pkg)
3	196925	Electrode, 12 A	1 (5 per pkg)
4	196927	Swirl Ring, 12 A	1
5	196935	O-Ring, ICE-12C main body	1 (3 per pkg)
6	196932	Main Body w/Switch (N/A)	1
7	196930	Label, ICE-12C (N/A)	2
8	183427	Handle Assy, complete	1
9	196931 <sup>1</sup>	Leads, 20 ft (N/A)	1
10	185833	Switch Assembly (includes spring)	1
11	190220	Spring	1
12	171248	Push Button Switch	1
13	197567	Cup, Retaining (drag shield)	1
14	196929	Shield, Drag	1
	252951	Grease, Silicon	1
	222938 <sup>2</sup>	Consumable Kit (ICE-12C)	1
	253054	Stand-off Guide	1
	253055	Circle Cutting Guide	1

<sup>1</sup>If used with Spectrum Thunder, 216277 fitting required.

<sup>2</sup>ICE-12C Consumable Kit includes (1) drag shield 196929 (1) plastic case 127493, (1) shield cup 197567, (4) tips 196926, (4) electrodes 196925, (1) o-ring 196935, and (1) silicone grease 252951.



ICE-12C Torch

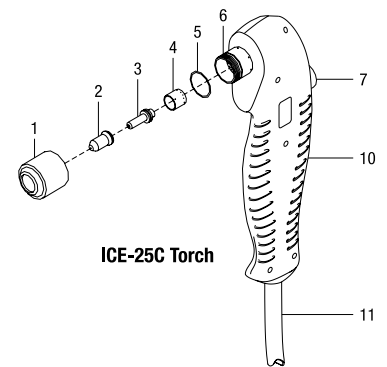
For a listing of original torch applications and replacements:

see pages 56-58

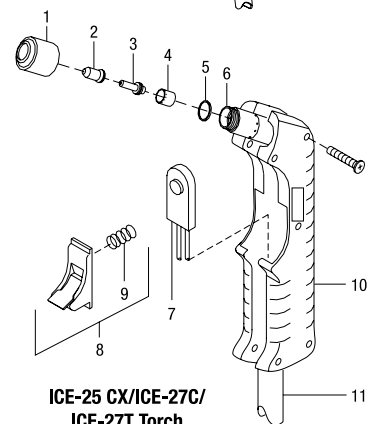
## ICE-25C & 25CX/27C/27T

Item #	Part # ICE-25C	Part # ICE-25 CX/27C/27T	Description	Quantity
	—	195007 (N/A)	ICE-25CX, 20 ft Hand Held Replacement Torch	
	—	195014 (N/A)	ICE-27C, 20 ft Hand Held Replacement Torch	
	—	225615 (N/A)	ICE-27T, 12 ft Hand Held Replacement Torch	
1	202808	202808	Cup, shield	1
2	176656	176656	Tip, 25/27 A (Non-Shielded)	1 (5 per pkg)
3	176655	176655	Electrode, 25/27 A	1 (5 per pkg)
4	202809	202809	Swirl Ring, 25/27 A	1
5	169232	169232	O-Ring (main body)	1 (3 per pkg)
6	178550 (N/A)	—	Main Body, ICE 25C	1
	—	203119	Main Body (ICE-27C/27T only)	1
7	171248	171248	Push Button Switch	1
8	—	185833	Switch Assembly (includes spring)	1
9	—	190220	Spring	1
10	183428 (N/A)	183427	Handle Assy, complete	1
11	—	228405	Leads, 12 ft (ICE-27T)	1
	177893 (N/A)	—	Leads, 15 ft (ICE-25C)	1
	177894 (N/A)	—	Leads, 25 ft (ICE-25C)	1
	—	205881 (N/A)	Leads, 20 ft (ICE-25 CX)	1
	—	203120 (N/A)	Leads, 20 ft (ICE-27C)	1
	225671	225671	Tip, drag shield	1 (5 per pkg)
	225672 (N/A)	225672 (N/A)	Retaining Cup, drag shield	1
	225616	225616	Drag Shield	1
	252951	252951	Grease, Silicon	1
	—	222939 <sup>3</sup>	Consumable Kit (ICE-27C/27T)	1
	253054	253054	Stand-off Guide	1
	253055	253055	Circle Cutting Guide	1

<sup>3</sup>ICE-27C Consumable Kit includes (1) plastic case 127493, (1) shield cups 202808, (5) tips 176656, (5) electrodes 176655, (1) swirl ring 202809, (1) o-ring 169232, and (1) silicone grease 252951.



ICE-25C Torch



ICE-25 CX/ICE-27C/  
ICE-27T Torch

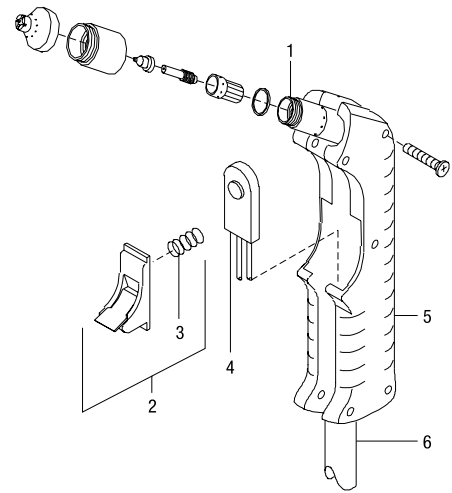
# PLASMA CUTTING

## ICE-40C/T

### Service Parts/Consumables

Item #	Part # ICE-40C	Part # ICE-40T	Description	Quantity
	195110	—	ICE-40C, 25 ft Hand Held Replacement Torch	1
	195111	—	ICE-40C, 50 ft Hand Held Replacement Torch	1
	—	237502 (N/A)	ICE-40T, 12 ft Hand Held Replacement Torch	1
	—	237504 (N/A)	ICE-40T, 20 ft Hand Held Replacement Torch	1
1	192059	192059	Main Body	1
2	185833	185833	Switch Assembly (includes switch)	1
3	190220	190220	Spring	1
4	171248	171248	Push Button Switch	1
5	183427	183427	Handle Assembly, complete	1
6	209298	238558	Leads, 25 ft/ Leads, 12ft	1
	209299 (N/A)	238559 (N/A)	Leads, 50 ft	1
	252951	252951	Grease, Silicon	1
<b>Consumables</b>				
7	204323	204323	Shield, drag	1
8	192050	192050	Cup, retaining	1
9	204325	204325	Tip, standard (40 A)	1 (5 per pkg)
10	192047	192047	Electrode, standard	1 (5 per pkg)
11	192049	192049	Swirl Ring	1
12	169232	169232	O-Ring	1 (3 per pkg)
13	177888	177888	Deflector	1
14	192052	192052	Tip, extended (40 A)	1 (5 per pkg)
15	192048	192048	Electrode, extended	1 (5 per pkg)
16	192203	192203	Shield, gouge	1
17	204332	204332	Tip, gouge	1 (5 per pkg)
	222940 <sup>1</sup>	222940 <sup>1</sup>	Consumable Kit (ICE-40C)	1
	253054	253054	Stand-off Guide	1
	253055	253055	Circle Cutting Guide	1

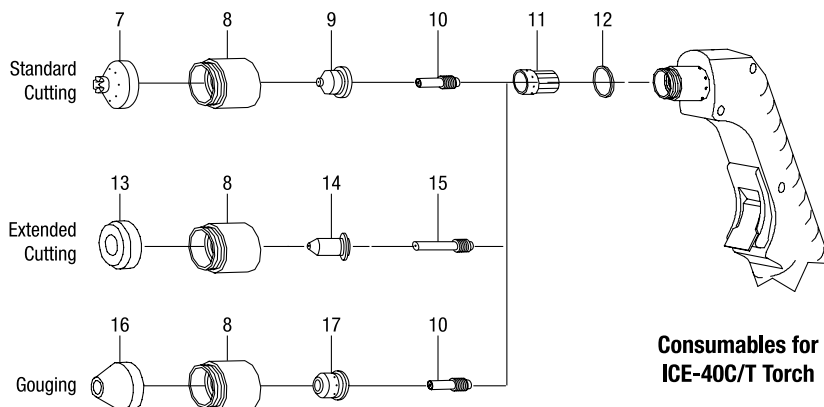
<sup>1</sup>ICE-40C/T Consumable Kit includes (1) plastic case 127493, (3) tips 204325, (3) electrodes 192047, (1) extended tip 192052, (1) extended electrode 192048, (1) gouge shield 192203, (1) gouge tip 204332, (1) o-ring 169232, (1) silicone grease 252951, (1) swirl ring 192049 and (1) retaining cup 192050.



ICE-40C/T Torch

For a listing of original torch applications and replacements:

see pages 56-58



Consumables for ICE-40C/T Torch





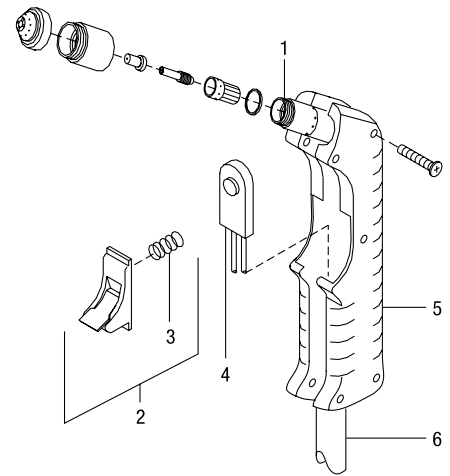
## ICE-50C & 50CM Service Parts/Consumables

Item #	Part #	Description	Quantity
	176824	ICE-50C, 25 ft Hand Held Replacement Torch	1
	176826	ICE-50C, 50 ft Hand Held Replacement Torch	1
	176828 (N/A)	Torch, 50 ft (ICE-50CM) N/A	
<b>ICE-50C Torch (Hand-Held)</b>			
1	188794 (N/A)	Main Body	1
2	185833	Switch Assembly (includes)	1
3	190220	Spring	1
4	171248	Push Button Switch	1
5	183427	Handle Assembly, complete	1
6	179829 (N/A)	Leads, 25 ft	1
	179830 (N/A)	Leads, 50 ft	1
	252951	Grease, Silicon	1
<b>Consumables</b>			
7	192053	Shield, drag	1
8	192050	Cup, retaining	1
9	177890	Tip, standard	1 (5 per pkg)
	192051 <sup>1</sup>	Tip, standard (ICE-55C)	1 (5 per pkg)
10	192047	Electrode, standard	1 (5 per pkg)
11	177886	Swirl Ring	1
	192049 <sup>1</sup>	Swirl Ring (ICE-55C)	1
12	169232	O-Ring	1 (3 per pkg)
13	192058	Shield, machine	1
14	177888	Deflector	1
15	177876	Tip, extended	1 (5 per pkg)
	192056 <sup>1</sup>	Tip, extended tapered 55 A (ICE-55C)	1 (5 per pkg)
	192052 <sup>1</sup>	Tip, extended tapered 40 A (ICE-55C)	1 (5 per pkg)
	189407 (N/A)	Tip, extended (flat)	1 (5 per pkg)
16	192048	Electrode, extended	1 (5 per pkg)
17	192203	Shield, gouge	1
18	177878	Tip, gouge	1
	192204 <sup>1</sup>	Tip, gouge (ICE-55C)	1 (5 per pkg)
19	226763	Sense Tab	1
	253055	Circle Cutting Guide	1

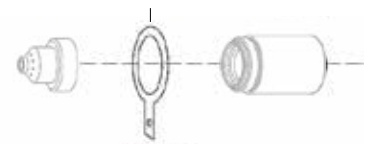
<sup>1</sup>**Spectrum 2050 Enhancement** — For improved cutting performance and increased consumable life, Spectrum 2050 users are encouraged to update their existing ICE-50C Cutting Tips and Swirl Ring with the ICE-55C components. (The ICE-55C Tips must be used in conjunction with the ICE-55C Swirl Ring.)

For a listing of original torch applications and replacements:

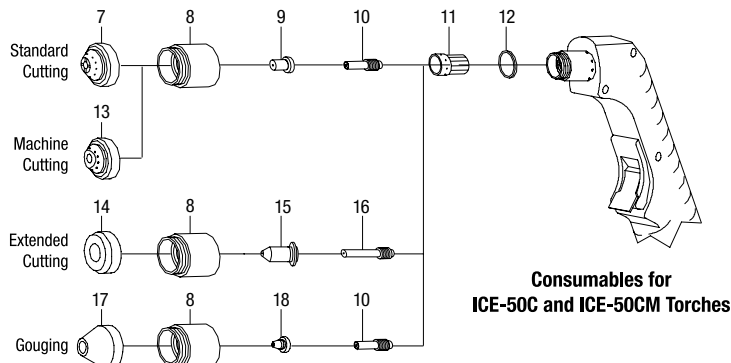
see pages 56-58



ICE-50C Torch



226763  
Sense Tab



Consumables for  
ICE-50C and ICE-50CM Torches

# PLASMA CUTTING

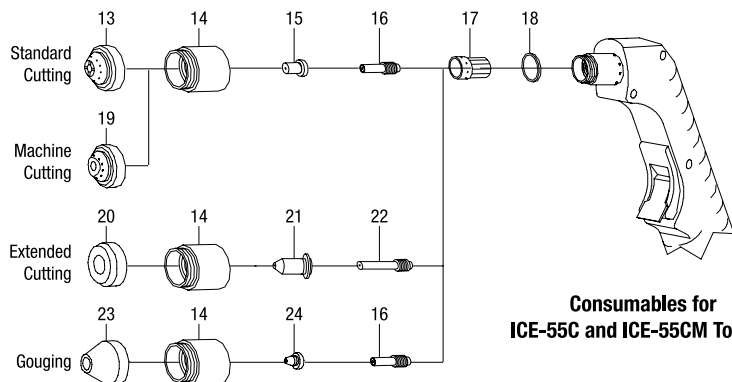
## ICE-55C & 55CM Service Parts/Consumables

Item #	Part #	Description	Quantity
	193347	Torch, 25 ft (ICE-55C)	1
	193348	Torch, 50 ft (ICE-55C)	1
	193349	Torch, 50 ft (ICE-55CM)	1
<b>ICE-55C Torch (Hand-Held)</b>			
1	192059	Main Body	1
	202932	Plunger Repair Kit	1
2	185833	Switch Assembly (includes)	1
3	190220	Spring	1
4	171248	Push Button Switch	1
5	183427	Handle Assy, complete	1
6	192062	Leads, 25 ft	1
	192063 (N/A)	Leads, 50 ft	1
	252951	Grease, Silicon	1
<b>ICE-55CM Torch (Machine-Held)</b>			
7	198644 (N/A)	Retaining Ring	1
8	198643 (N/A)	Torch Sleeve	1
9	192060 (N/A)	Main Body	1
10	180610 (N/A)	Position Sleeve	1
11	192061 (N/A)	Leads, 50 ft	1
12	180605 (N/A)	Remote Pendant Control	1
<b>Consumables</b>			
13	192053	Shield, drag	1
14	192050	Cup, retaining	1
15	192051	Tip, standard	1 (5 per pkg)
16	192047	Electrode, standard	1 (5 per pkg)
17	192049	Swirl Ring	1
18	169232	O-Ring	1 (3 per pkg)
19	192058	Shield, machine	1
20	177888	Deflector	1
21	192056	Tip, extended tapered (55 A)	1 (5 per pkg)
	192052	Tip, extended tapered (40 A)	1 (5 per pkg)
22	192048	Electrode, extended	1 (5 per pkg)
23	192203	Shield, gouge	1
24	192204	Tip, gouge	1 (5 per pkg)
25	226763	Sense Tab	1
	222941 <sup>1</sup>	Consumable Kit (ICE-55C)	1
	253055	Circle Cutting Guide	1

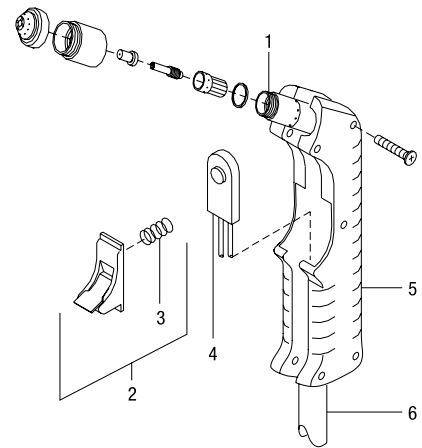
<sup>1</sup>ICE-55C Consumable Kit includes (1) plastic case 127493, (1) drag shield 192053, (1) retaining cup 192050, (4) tips 192051, (4) electrodes 192047, (2) extended tips 192056, (2) extended electrodes 192048, (1) gouge shield 192203, (1) gouge tip 192204, (3) o-rings 169232, and (1) silicone grease 252951.

For a listing of original torch applications and replacements:

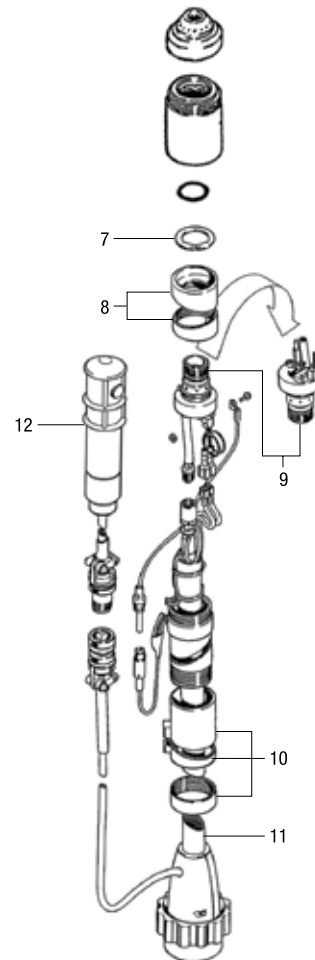
see pages 56-58



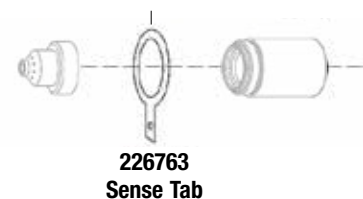
Consumables for ICE-55C and ICE-55CM Torches



ICE-55C Torch



ICE-55CM Torch



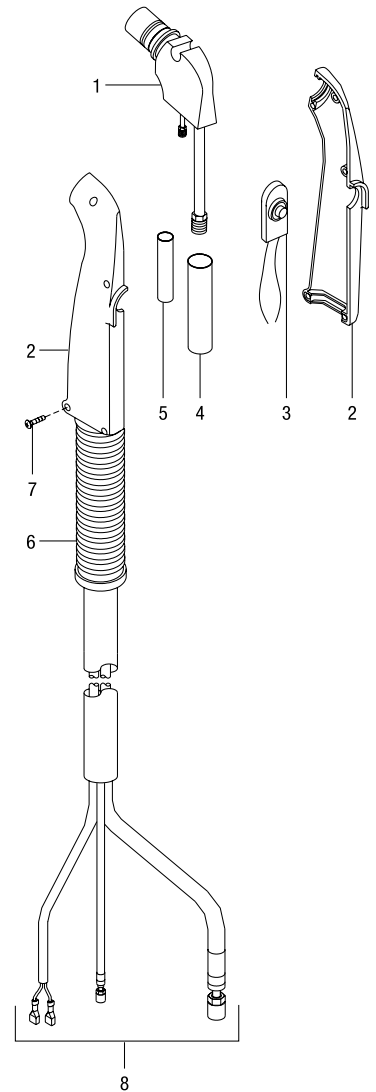
226763 Sense Tab



## ICE-50/70/100 Service Parts/Consumables

Item #	Part #	Description	Quantity	
			ICE-50	ICE-70 & 100
	169224 (N/A)	ICE-50, 50 ft Hand-Held Torch	1	—
	169203 (N/A)	ICE-70, 30 ft Hand-Held Torch	—	1
	169245 (N/A)	ICE-70, 50 ft Hand-Held Torch	—	1
	169207 (N/A)	ICE-100, 30 ft Hand-Held Replacement Torch	—	1
	169246 (N/A)	ICE-100 50 ft Hand-Held Replacement Torch	—	1
<b>Parts</b>				
1	171258 (N/A)	Torch, Main Body	1	—
	171257 (N/A)	Torch, Main Body	—	1
2	171246 (N/A)	Handle	1	1
3	171248	Pushbutton, Switch	1	1
	171255 (N/A)	Splice, 22 – 18 Butt N-insul Connector	2	2
4	171263 (N/A)	Lead Insulator, 5/8PVC 3.5 in long	1	—
	171252 (N/A)	Teflon Tube 11/16 ID x.030W x 3.5 in long	—	1
5	171260 (N/A)	Lead Insulator, 7/16PVC 3 in long	1	—
	171251 (N/A)	Teflon Tube 9/16 ID x.030W x 2.5 in long	—	1
6	171247 (N/A)	Boot	1	1
7	171256 (N/A)	Handle Screw, No. 6 x 3/4ph	5	5
8	171264 (N/A)	Leads, 30 ft	1	—
	171253 (N/A)	Leads, 30 ft	—	1
	171265 (N/A)	Leads, 50 ft	1	—
	171254 (N/A)	Leads, 50 ft	—	1
<b>Consumables</b>				
9	132657 <sup>1</sup> (N/A)	Standoff Guide	1 (2 per pkg)	
10	169216 <sup>1</sup>	Retaining Cup	1	
11	174034 <sup>1</sup>	Standard Tip	1 (5 per pkg)	
12	169215 <sup>1</sup>	Swirl Ring	1	
13	169212 <sup>1</sup>	Standard Electrode	1 (5 per pkg)	
14	169232 <sup>1</sup>	O-Ring	1 (3 per pkg)	
15	174035 <sup>1</sup> (N/A)	Stop-Guide Sleeve	1	
16	169214 <sup>1</sup>	Extended Tip	1 (5 per pkg)	
17	173895 <sup>1</sup>	Extended Electrode	1 (5 per pkg)	
18	169213 <sup>1</sup> (N/A)	Gouge Tip	1 (5 per pkg)	
	253054	Stand-off Guide	1	1
	253055	Circle Cutting Guide	1	1

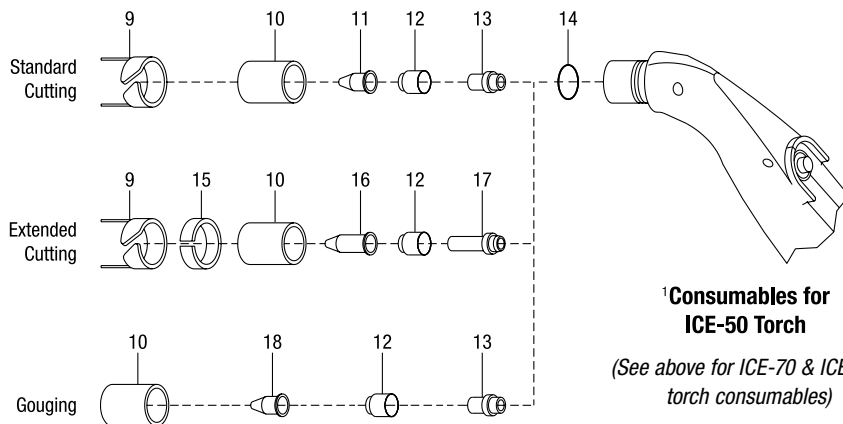
<sup>1</sup>For ICE-50 only — see page 66 for ICE-70 and ICE-100 torch consumables.



ICE-50 / ICE-70 & ICE-100 Torch

For a listing of original torch applications and replacements:

see pages 56-58



<sup>1</sup>Consumables for ICE-50 Torch

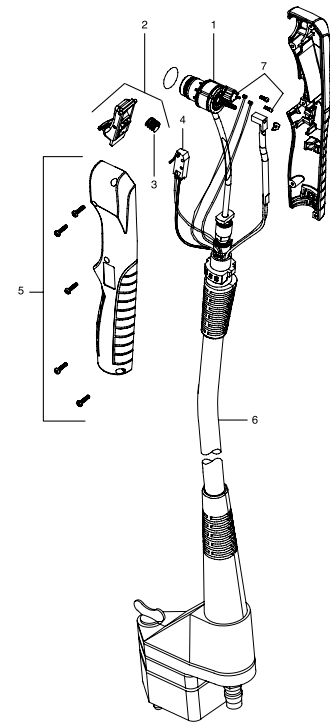
(See above for ICE-70 & ICE-100 torch consumables)

# PLASMA CUTTING

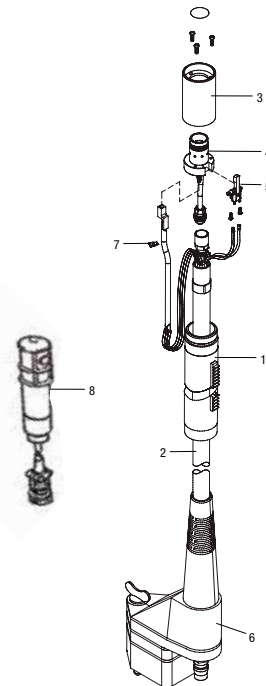
## ICE-60T & 60TM

### Service Parts/Consumables

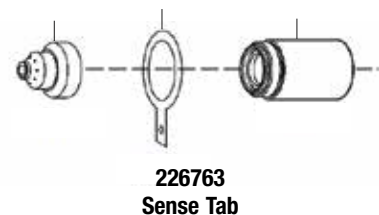
Item #	Part #	Description	Quantity
	234132	Torch, 20 ft (ICE-60T)	1
	234134	Torch, 50 ft (ICE-60T)	1
	234136 (N/A)	Torch, 25 ft (ICE-60TM)	1
	234138 (N/A)	Torch, 50 ft (ICE-60TM)	1
	300759	Torch with Pendant, 25 ft (ICE-60TM)	1
	300760 (N/A)	Torch with Pendant, 50 ft (ICE-60TM)	1
		<b>ICE-60T Torch</b>	
1	215477	Torch, Main Body	1
2	185833	Switch Assembly (includes spring)	1
3	190220	Spring	1
4	215592	Trigger Switch	1
5	215594	Handle Assembly	1
6	234170	Leads, 20 ft	1
	234171	Leads, 50 ft	1
	252951	Grease, Silicon	1
7	215478	Switch Cup, Sensor	1
		<b>ICE-60TM Torch</b>	
1	215607 (N/A)	Sleeve, Torch Position	1
2	234172 (N/A)	Torch Lead, 25 ft (7.6 m)	1
3	215599	Torch Sleeve	1
4	215598 (N/A)	Torch, Main Body	1
5	215478	Switch Cup, Sensor	1
6	234829 (N/A)	Kit, ICE-60T/TM QD w/Wing Head Fastener	1
7	215606	Clip, Retaining	1
8	195513	Remote Pendant Control	1
	220240	Cable, Remote Control Trigger 25 ft (7.6 m)	1
	220241	Cable, Remote Voltage Sense 26.5 ft (8 m)	1
		<b>Consumables</b>	
9	212735	O-Ring	1 (5 per pkg)
10	212734	Swirl Ring	1
11	212724	Electrode	1 (5 per pkg)
12	219676	Standard 60A tip	1 (5 per pkg)
13	212725	Standard 40A tip	1 (5 per pkg)
14	212733	Retaining Cup	1
15	212730	Drag Shield	1
16	212732	Shield	1
17	219682	Extended 60A tip	1 (5 per pkg)
18	212729	Extended 40A tip	1 (5 per pkg)
19	212736	Deflector	1
20	219680	Gouge Tip	1 (5 per pkg)
21	212731	Gouge Shield	1
22	226763	Sense Tab	1
23	253054	Stand-off Guide	1
24	253055	Cutting Guide	1



ICE-60T Torch



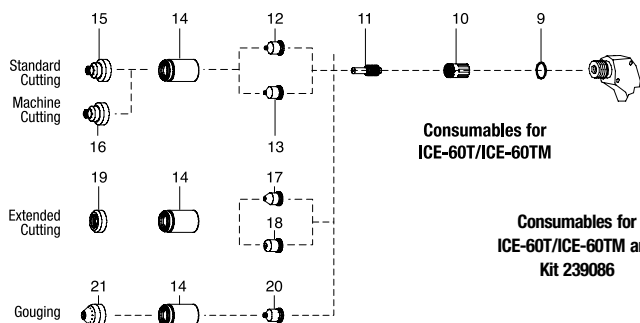
ICE-60TM Torch



226763  
Sense Tab

For a listing of original torch applications and replacements:

see pages 56-58





## ICE-70M/100M

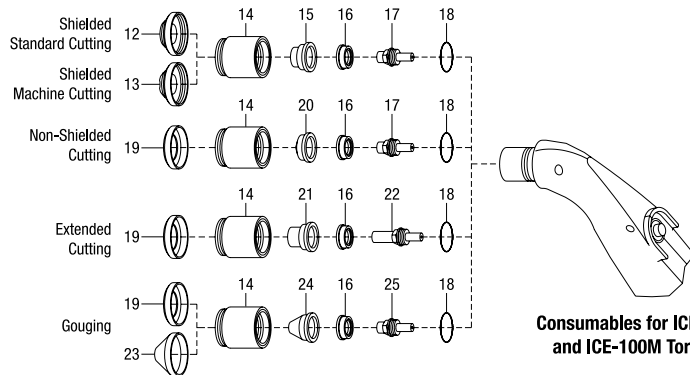
### Service Parts/Consumables

Item #	Part #	Description	Quantity
	169247 (N/A)	<b>ICE-100M, 50 ft Machine Torch</b>	<b>1</b>
1	171245	Torch, Main Body (N/A)	1
2	171241 (N/A)	Torch Assembly, Rack and Sleeve (consists of)	1
3	185999 (N/A)	Torch Position Sleeve	1
4	186000 (N/A)	Gear Rack	1
5	186001 (N/A)	Locking Ring	1
6	171243 (N/A)	Leads, 30 ft (ICE-70M)	1
	171242 (N/A)	Leads, 50 ft (ICE-100M)	1
7	010860 (N/A)	Clamp, Hose .750 – 1.750clp dia	1
8	170993 (N/A)	Collar, Brass	1
9	170825 (N/A)	Washer, shldr 1.251 x 1.750 OD x .125thk	1
10	010907	Nut, 1.000 – 11 (N/A)	1
11	171244 (N/A)	Black PVC, 5/8 ID x 3.5 long	1
<b>Consumables</b>			
12	169224	Shield, Drag	1
13	169230	Machine Shield	1
14	169223	Retaining Cup	1
	179282 <sup>1</sup> (N/A)	Cup, Bevel	1
15	169219	Tip (70 A)	1 (5 per pkg)
	169226	Tip (100 A)	1 (5 per pkg)
16	169222	Swirl Ring	1
17	169217	Electrode	1 (5 per pkg)
18	169233	O-Ring	1 (3 per pkg)
19	169225	Deflector	1
20	169220 (N/A)	Tip (70 A)	1 (5 per pkg)
	169227	Tip (100 A)	1 (5 per pkg)
21	173815	Tip (70 A)	1 (5 per pkg)
22	173816	Electrode	1 (5 per pkg)
23	170995 (N/A)	Gouge Shield (70 A)	1
24	169221 (N/A)	Tip (70 A) Gouging	1 (5 per pkg)
	169228 (N/A)	Tip (100 A) Gouging	1 (5 per pkg)
25	169218 (N/A)	Electrode (70 A) Gouging	1 (5 per pkg)
	169217	Electrode (100 A) Gouging	1 (5 per pkg)
26	226763	Sense Tab	1
	253054	Stand-off Guide	1
	253055	Circle Cutting Guide	1

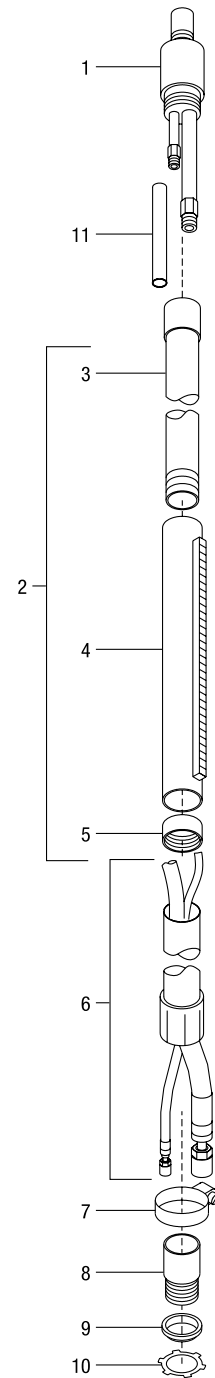
<sup>1</sup> Use of the 179282 Bevel Cup will eliminate the need to use item #19 (169225 Deflector).

For a listing of original torch applications and replacements:

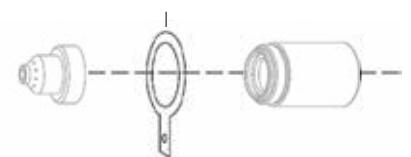
see pages 56-58



Consumables for ICE-70M and ICE-100M Torches



ICE-70M/ICE-100M Torch



226763  
Sense Tab

# PLASMA CUTTING

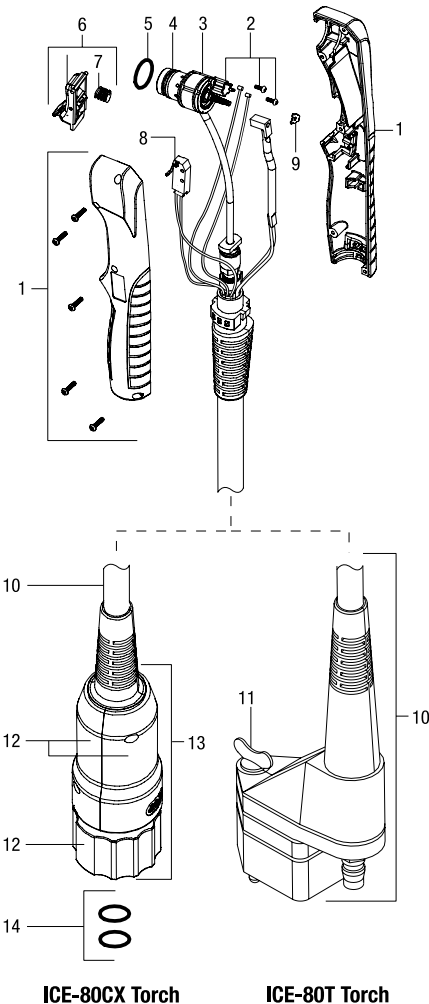
## ICE-80CX/80T

### Service Parts/Consumables

Item #	Part # ICE-80CX	Part # ICE-80T	Description	Quantity
	216300	195223	Torch, 25 ft	1
	218044	195225	Torch, 50 ft	1
1	215594	215594	Handle w/Screws	1
2	215478	215478	Cup Sensor Switch Kit	1
3	215477	215477	Main Body	1
4	215479	215479	Torch Head Repair Kit	1
5	212735	212735	O-Ring, main body	1 (5 per pkg)
6	185833	185833	Switch Assembly (includes)	1
7	190220	190220	Trigger sSpring	1
8	215592	215592	Switch Trigger	1
9	215606	215606	Clip, Retaining	1
10	216309 (N/A)	223543 <sup>1</sup> (N/A)	Torch Lead, 25 ft (7.6 m)	1
	218045 (N/A)	223544 <sup>1</sup> (N/A)	Torch Lead, 50 ft (15.2 m)	1
11	—	227546	Fastener Stud	1
12	218177 (N/A)	—	Plug Assy, quick disconnect	1
13	190497 (N/A)	—	Both Plastic Halves and Nut	1
14	187305	—	O-Ring, quick disconnect	2
<b>Consumables</b>				
15	212730	212730	Drag Shield	1
16	212733	212733	Retaining Cup	1
17	212725	212725	40 Amp Standard Tip	1 (5 per pkg)
18	212726	212726	80 Amp Standard Tip	1 (5 per pkg)
19	212724	212724	Electrode	1 (5 per pkg)
20	212734	212734	Swirl Ring	1
21	212735	212735	O-Ring	1 (5 per pkg)
22	212736	212736	Deflector	1
23	212729	212729	40 Amp Extended Tip	1 (5 per pkg)
24	212728	212728	80 Amp Extended Tip	1 (5 per pkg)
25	212731	212731	80 Amp Gouge Shield	1
26	212727	212727	80 Amp Gouge Tip	1 (5 per pkg)
	222942 <sup>2</sup>	222942 <sup>2</sup>	Consumable Kit (ICE-80T)	1
	253054	253054	Stand-off Guide	1
	253055	253055	Circle Cutting Guide	1

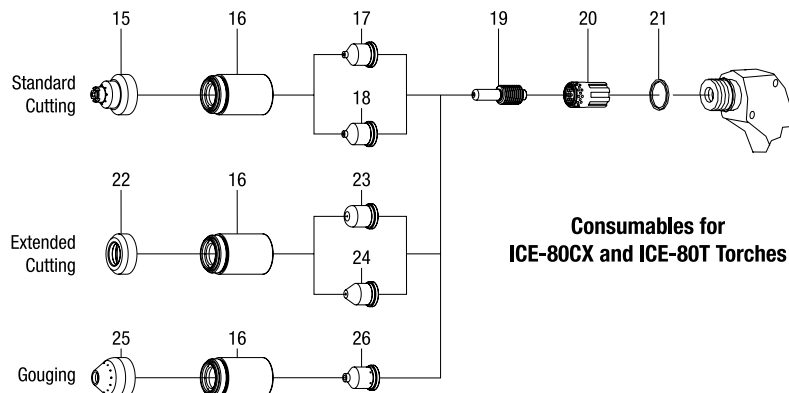
<sup>1</sup>Item #10 for ICE-80T is a combination unit that includes both torch lead and overmolded quick disconnect plug assembly.

<sup>2</sup>ICE-80T Consumable Kit includes (1) plastic case 127493, (1) drag shield 212730, (1) retaining cup 212733, (3) tips 212726, (6) electrodes 212724, (2) extended tips 212728, (1) gouge shield 212731, (1) gouge tip 212727, (3) o-rings 212735, and (1) silicon grease 252951.



For a listing of original torch applications and replacements:

see pages 56-58



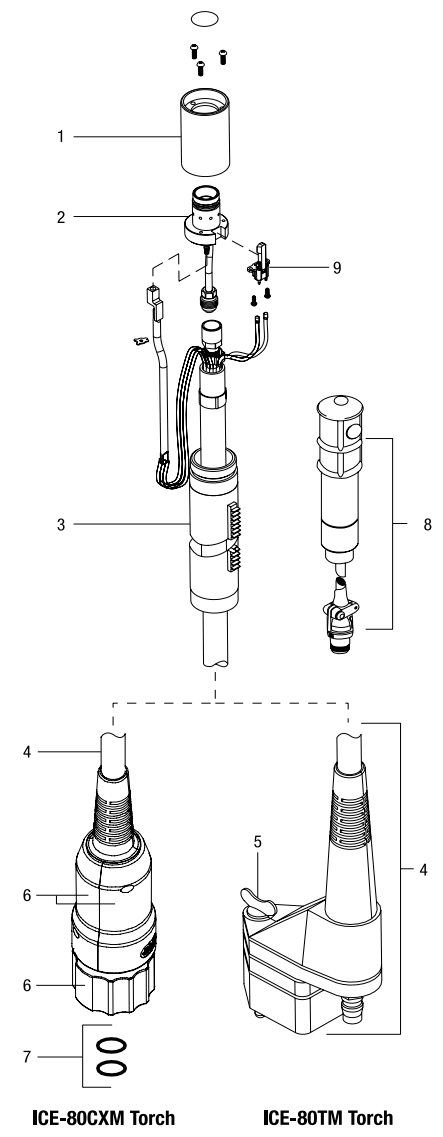




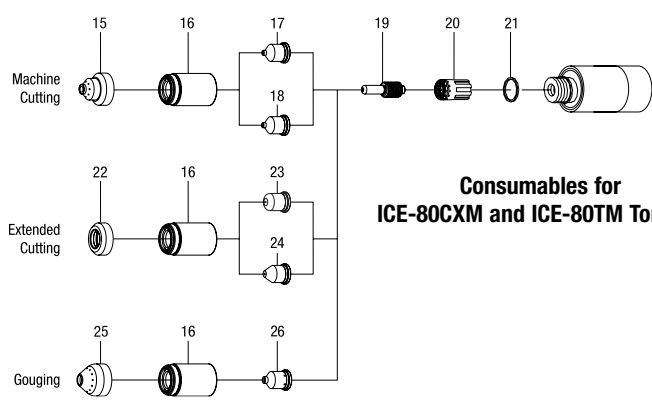
## ICE-80CXM/80TM Service Parts/Consumables

Item #	Part # ICE-80CX	Part # ICE-80T	Description	Quantity
	216300	195223	Torch, 25 ft	1
	218044	195225	Torch, 50 ft	1
1	215594	215594	Handle with screws	1
2	215478	215478	Cup Sensor Switch Kit	1
3	215477	215477	Main Body	1
4	215479	215479	Torch Head Repair Kit	1
5	212735	212735	O-Ring, main body	1 (5 per pkg)
6	185833	185833	Switch Assembly (includes)	1
7	190220	190220	Trigger spring	1
8	215592	215592	Switch trigger	1
9	215606	215606	Clip, retaining	1
10	216309 (N/A)	223543 <sup>1</sup> (N/A)	Torch Lead, 25 ft (7.6 m)	1
	218045 (N/A)	223544 <sup>1</sup> (N/A)	Torch Lead, 50 ft (15.2 m)	1
11	—	227546	Fastener Stud	1
12	218177 (N/A)	—	Plug Assy, quick disconnect	1
13	190497 (N/A)	—	Both Plastic Halves and Nut	1
14	187305	—	O-Ring, quick disconnect	2
<b>Consumables</b>				
15	212730	212730	Drag Shield	1
16	212733	212733	Retaining Cup	1
17	212725	212725	40 Amp Standard Tip	1 (5 per pkg)
18	212726	212726	80 Amp Standard Tip	1 (5 per pkg)
19	212724	212724	Electrode	1 (5 per pkg)
20	212734	212734	Swirl Ring	1
21	212735	212735	O-Ring	1 (5 per pkg)
22	212736	212736	Deflector	1
23	212729	212729	40 Amp Extended Tip	1 (5 per pkg)
24	212728	212728	80 Amp Extended Tip	1 (5 per pkg)
25	212731	212731	80 Amp Gouge Shield	1
26	212727	212727	80 Amp Gouge Tip	1 (5 per pkg)
	222942 <sup>2</sup>	222942 <sup>2</sup>	Consumable Kit (ICE-80T)	1
	253054	253054	Stand-off Guide	1
	253055	253055	Circle Cutting Guide	1

<sup>1</sup>Item #10 for ICE-80T is a combination unit that includes both torch lead and overmolded quick disconnect plug assembly.  
<sup>2</sup>ICE-80T Consumable Kit includes (1) plastic case 127493, (1) drag shield 212730, (1) retaining cup 212733, (3) tips 212726, (6) electrodes 212724, (2) extended tips 212728, (1) gouge shield 212731, (1) gouge tip 212727, (3) o-rings 212735, and (1) silicon grease 252951.



For a listing of original torch applications and replacements: **see pages 56-58**



**Consumables for ICE-80CXM and ICE-80TM Torches**



**226763 Sense Tab**

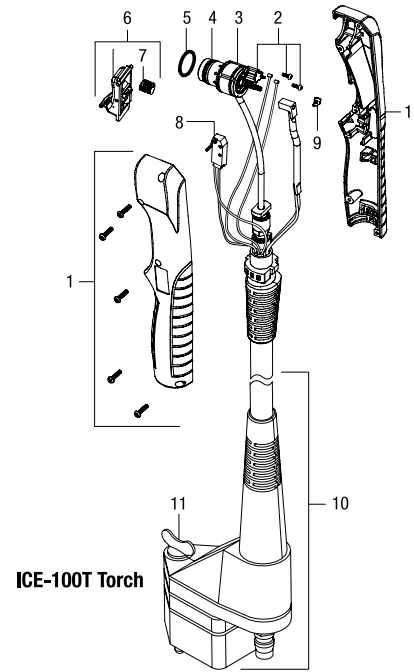
# PLASMA CUTTING

## ICE-100T & 100TM

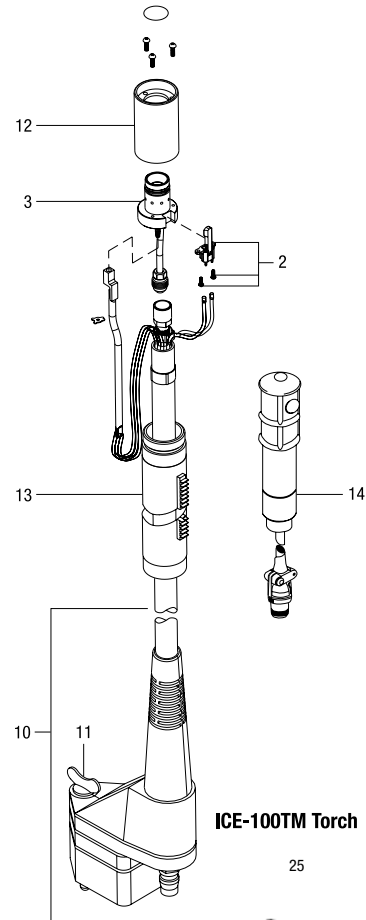
### Service Parts/Consumables

Item #	Part # ICE-100T	Part # ICE-100TM	Description	Quantity
	225702	225706	Torch, 25 ft	1
	225704	225708 (N/A)	Torch, 50 ft	1
1	215594	—	Handle w/Screws	1
2	215478	215478	Cup Sensor Switch Kit	1
3	223774	223773	Main Body w/Switch	1
4	223775	223775	Torch Head Repair Kit	1
5	212735	—	O-Ring, Main Body	1 (5 per pkg)
6	185833	—	Switch Assembly (includes)	1
7	190220	—	Trigger Spring	1
8	215592	—	Switch Trigger	1
9	215606	—	Clip, Retaining	1
10	223612 <sup>1</sup> (N/A)	223614 <sup>1</sup> (N/A)	Torch Lead, 25 ft (7.6 m)	1
	223613 <sup>1</sup> (N/A)	223615 <sup>1</sup> (N/A)	Torch Lead, 50 ft (15.2 m)	1
11	227546	227546	Fastener Stud	1
12	—	215599	Torch Sleeve, ICE-80TM	1
13	—	215607 (N/A)	Sleeve, Torch Position	1
14	—	195513	Remote Pendant Control	1
	—	220240	Cable, Remote Control Trigger 25 ft	1
	—	220241	Cable, Remote Voltage Sense 26.5 ft	1
<b>Consumables</b>				
15	212730/219685 <sup>2</sup>	212732/219687 <sup>2</sup>	Drag/Machine Shield	1
16	212733/219684 <sup>2</sup>	212733/219684 <sup>2</sup>	Retaining Cup	1
17	212725	212725	40 Amp Standard Tip	1 (5 per pkg)
	219676	219676	60 Amp Standard Tip	1 (5 per pkg)
	212726	212726	80 Amp Standard Tip	1 (5 per pkg)
	219679 (N/A)	219679 (N/A)	100 Amp Standard Tip	1 (5 per pkg)
18	212724/219 678 <sup>2</sup>	212724/219678 <sup>2</sup>	Electrode	1 (5 per pkg)
19	212734/219 677 <sup>2</sup>	212734/219677 <sup>2</sup>	Swirl Ring	1
20	212735	212735	O-Ring	1 (5 per pkg)
21	212736	212736	Deflector	1
22	212729	212729	40 Amp Extended Tip	1 (5 per pkg)
	219682	219682	60 Amp Extended Tip	1 (5 per pkg)
	212728	212728	80 Amp Extended Tip	1 (5 per pkg)
	219683	219683	100 Amp Extended Tip	1 (5 per pkg)
23	212731	212731	Gouge Shield	1
24	219680	219680	60 Amp Gouge Tip	1 (5 per pkg)
25	—	226763	Sense Tab	1
	212727	212727	80 Amp Gouge Tip	1 (5 per pkg)
	219681	219681	100 Amp Gouge Tip	1 (5 per pkg)
	227037 <sup>3</sup> (N/A)	227037 <sup>3</sup> (N/A)	Consumable Kit (ICE-100T)	1
	253054	—	Stand-off Guide	1
	253055	—	Circle Cutting Guide	1

<sup>1</sup>Item #10 includes both torch lead and overmolded quick disconnect plug assembly.  
<sup>2</sup>First number is for 40/60/80 Amp components and second number is for 100 Amp components.  
<sup>3</sup>ICE-100T Consumable Kit includes (1) plastic case 127493, (1) 100 A drag shield 219685, (1) 100 A retaining cup 219684, (3) 100 A tips 219679, (6) 100 A electrodes 219678, (2) 100 A extended tips 219683, (1) gouge shield 212731, (1) 100 A gouge tip 219681, (3) o-rings 212735, and (1) silicon grease 252951.



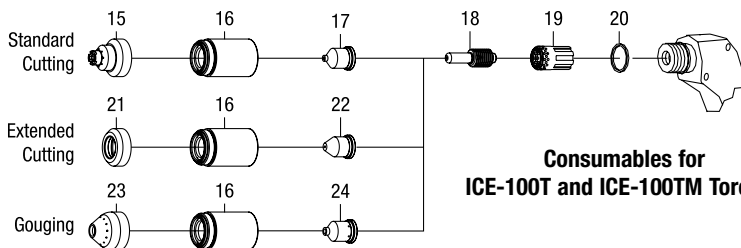
ICE-100T Torch



ICE-100TM Torch

For a listing of original torch applications and replacements:

see pages 56-58



Consumables for ICE-100T and ICE-100TM Torches

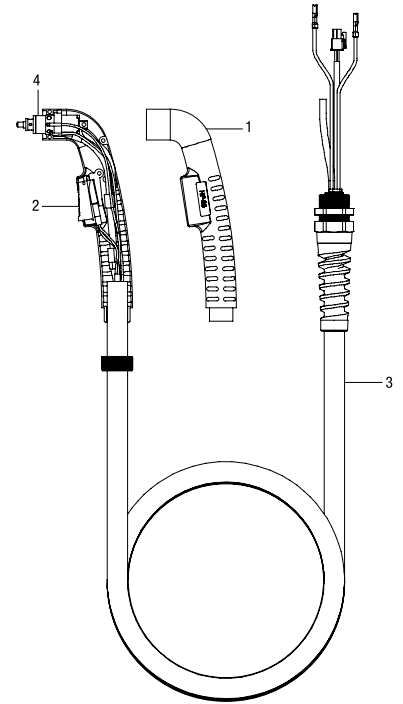
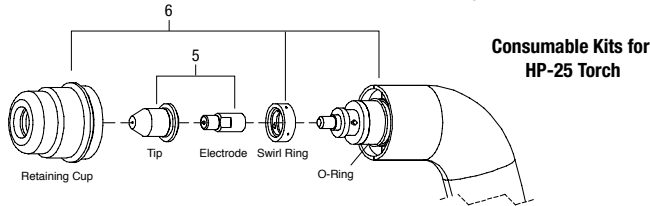
226763 Sense Tab



## HP-25/50/70 Service Parts/Consumables

Item #	Part #	Description	Quantity
	<b>232647</b>	<b>HP-25 Hand-Held Plasma Torch</b>	
1	<b>230429</b>	Handle Assy, Left and Right w/Screws	1
2	<b>232081</b>	Trigger Switch	1
3	<b>230432</b>	Leads, 16 ft	1
4	<b>230430</b>	Torch Head	1
5	<b>770496<sup>1</sup></b>	Consumable Kit, Tip/Electrode	2 each/kit
5	<b>770723 (N/A)</b>	Consumable Kit, Tip/Electrode	5 each/kit
6	<b>770497<sup>1</sup></b>	Consumable Kit, Cup/Swirl Ring/O-Ring	1
	<b>233321</b>	Stand-off Guide	1
	<b>233046</b>	Wrench	1
	<b>245993</b>	Kit, Detect Leads	1

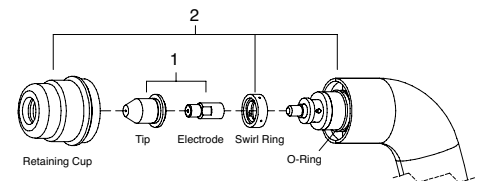
<sup>1</sup>Parts not sold individually.  
No circle cutting guide for the HP-25, HP-50, and HP-70 torches. 244117 Yellow Safety Switch.



**HP-25 Torch**

Item #	Part #	Description	Quantity
	<b>244121</b>	<b>HP-50 Hand-Held Plasma Torch</b>	
1	<b>770496<sup>1</sup></b>	Consumable Kit, Tip/Electrode	2 each/kit
1	<b>770723 (N/A)</b>	Consumable Kit, Tip/Electrode	5 each/kit
2	<b>770653<sup>1</sup></b>	Consumable Kit, Cup/Swirl Ring/O-Ring	1
3	<b>233321</b>	Stand-off Guide, HP-25/50/70 Plasma Torch	1
	<b>245993</b>	Kit, Detect Leads	1
	<b>233046</b>	Wrench	

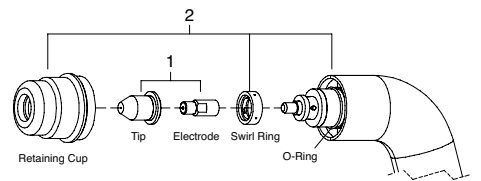
<sup>1</sup>Parts not sold individually.  
No circle cutting guide for the HP-25, HP-50, and HP-70 torches. 244117 Yellow Safety Switch.



**Consumable Kits for HP-50 Torch**

Item #	Part #	Description	Quantity
	<b>244122</b>	<b>HP-70 Hand-Held Plasma Torch</b>	
1	<b>770654<sup>1</sup></b>	Consumable kit, tip/electrode	2 each/kit
1	<b>770724</b>	Consumable kit, tip/electrode	5 each/kit
2	<b>770655<sup>1</sup></b>	Consumable kit, cup/swirl ring/O-ring	1
3	<b>233321</b>	Stand-off guide, HP-25/50/70 plasma torch	1
	<b>245993</b>	Kit, Detect Leads	1
	<b>233046</b>	Wrench	

<sup>1</sup>Parts not sold individually.  
No circle cutting guide for the HP-25, HP-50, and HP-70 torches. 244117 Yellow Safety Switch.



**Consumable Kits for HP-70 Torch**

For a listing of original torch applications and replacements:

see pages 56-58

## Hose Fittings

### Little Torch™ Hose Nuts

Stock No.	Type	Nut Thread & Number	Hose ID Size
R2A	Oxygen - A Fitting	9/16 in-18 RH	1/8 in (3 mm)
R3A	Fuel Gas - A Fitting	9/16 in-18 LH	1/8 in (3 mm)
16173	Oxygen - B Fitting	9/16 in-18 RH	1/8 in (3 mm)
16174	Fuel Gas - B Fitting	9/16 in-18 LH	1/8 in (3 mm)

### Little Torch™ Hose Tailpiece

Stock No.	Type	Style	Hose ID Size
14186	Oxygen/Fuel - A Fitting	Barbed	1/8 in (3 mm)
1882	Oxygen/Fuel - B Fitting	Barbed	1/8 in (3 mm)

NOTE: For Oxy and Fuel Connections.

### Little Torch™ & Quickbraze™ Hoze Ferrule

Stock No.	Inside Diameter	Length	Hose Type
7582	3/16 in/ 5 mm	9/32 in/ 7 mm	Oxygen/Fuel

NOTE: 7799 - Crimping tool to crimp ferrule on Little Torch™ hose.

### Hose Adaptors

Stock No.	Type	Male Thread	Female Thread
14389 (B to A)	Oxygen	3/8 in-24 RH	9/16 in-18 RH
14390 (B to A)	Fuel Gas	3/8 in-24 RH	9/16 in-18 RH

NOTE: "B" Regulators fitting to "A" hose fitting.

### Torch Hose Connections

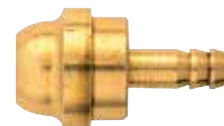
Stock No.	Type	Nut Thread & Number	Style
3060-1	Oxygen	9/16 in-18 RH	Nickel Plated
3060-2	Fuel Gas	9/16 in-18 LH	Nickel Plated

Use With: All heavy duty torch handles and hand torches.

16174



1882



Ferrule  
7582



Crimping Tool  
7799



14389



3060-2



3060-1



## Pressure Gauges & Filter

#GA136-03 2-inch Diameter Pressure Gauge (50 CFH/25 LPM)

#GA139-03 2-inch Diameter Pressure Gauge (4000 PSI/280 BAR)

■ Highly accurate read-out ■ UL listed ■ Shatter-proof polycarbonate crystal

15001-30 15001-20 15001-40

Gas Filter, Shielding (In-Line) - This in-line shielding gas filter is now standard on every Miller® wire feeder with a gas solenoid. It traps contaminants before they plug up solenoid valves which result in costly downtime cleaning.

15775-10 Sintered Filter (10 Pack)

Sintered filter to prevent debris from entering torch. Installs inside Smith "B" torch inlet connections.



GA136-03  
1/4 NPT



GA139-03  
1/4 NPT



15001-30  
15001-20  
15001-40



15775-10



## Single Hoses for Acetylene

**Important Note:** The Grade “R” hose is for use with acetylene only as specified by the RMA-CGA Hose Standard. “T” Grade hose must be used with all other gases.

### Single “R” Grade hoses for Acetylene Only - Red Hose

Stock No.	Length	Diameter	Weight (lbs & kg)	Connections	Use with Torch Series	I.D. Size
RL121	12-1/2 ft (3.8 m)	3/16 in (5 mm)	1-1/4 (.55 kg)	9/16 in-18 LH (“B”)	NE180 Handi-Heat	3/16 in (5 mm)

### Single Hose - Inert Gas - Black Hose

Stock No.	Use For	Length	Diameter	Connections
7294-1	Inert Gas	6 ft (1.8 m)	1/4 in (6 mm)	5/8 in-18 RH Male

### Single Hose - Nitrogen

**Heavy Duty Charging Hose for use with Nitrogen for HVAC Purging Applications.**

Stock No.	Length	Connections		Use with Regulators	I.D. Size
		To Regulator	To A/C Unit		
RL260	6 ft (1.8 m)	7/16 in-20 RH Internal	7/16 in-20 RH w/core	30-450-580 depress to open Schraeder Valve	1/4 in (6 mm)

### Little Torch™ Replacement Hoses

Stock No.	Length	Hose Type
13254-1-8'	8 ft	Oxygen (N/A)
13254-3-8'	8 ft	Any Fuel (N/A)
13254-4-8'	8 ft	Oxygen/Fuel
13254-5-8	8 ft	Australian Little Torch™ Twin Hose Assembly
13254-6-8	8 ft	British Little Torch™ Twin Hose Assembly
13254-7-8	8 ft	European Little Torch™ Twin Hose Assembly

**Note:** “B” - 9/16” Hose Fittings. Replacement hoses include installation tool 7799 and Ferrule 7582.

### QuickBraz™ Replacement Hoses

Stock No.	Length	Hose Type
14777-4-10	10 ft	“A” - 3/8 in
14778-4-10	10 ft	“B” - 9/16 in

**Note:** Replacement hoses include installation tool 7799 and Ferrule 7582.

## Kevlar® Brazing Hose

**14779-4-10** “A” & “B” Fitting Twin Hose 3/8 in and 9/16 in female connections.

### Kevlar® Hose Features & Benefits

Extremely durable, heat resistant, light weight and flexible. Excellent for repetitious brazing operations. (Not recommended for use with cutting attachments.)

RL121



7294-1



RL260



13254-1-8, 13254-3-8, 13254-4-8



14777-4-10, 14778-4-10



14779-4-10



## Twin Hoses for Acetylene & Oxygen

**WARNING:** Do not exceed the maximum working pressures (regulator setting) listed for the hoses during welding and cutting operations.

Oxygen ..... 150 PSIG Maximum  
 Acetylene ..... 15 PSIG Maximum  
 Propane, Propylene & all other Fuel Gases..... 40 PSIG Maximum

### Two-In-One "R" Grade Hose for Acetylene Only

Stock No.	Length	Diameter	Weight (lbs & kg)	Connections		Use with Torch Series	I.D. Size
				To Regulator	To Torches		
RL1131	25 ft (7.6 m)	1/4 in (mm)	6-1/2 (2.9 kg)	R11 (Oxygen) R12 (Fuel) 9/16 in-18("B")	R11 (Oxygen) R12 (Fuel) 9/16 in-18 ("B")	DG, SC, SW, CW, MW	1/4 in (6 mm)
RL921	12-1/2 ft (3.8 m)	3/16 in (5mm)	2-3/4 (1.2 kg)	R13D (Oxygen) R14D (Fuel) 9/16 in-18 ("B")	R13D (Oxygen) R14D (Fuel) 9/16 in-18 ("B")	DG, MW, CW, SC	3/16 in (5 mm)
RL935	20 ft (6.1 m)	3/16 in (5mm)	4 (1.8 kg)				
RA921	12-1/2 ft (3.8 m)	3/16 in (5 mm)	2-1/2 (1.1 kg)	R13D (Oxygen) R14D (Fuel) 9/16 in-18 ("B")	R13 (Oxygen) R14 (Fuel) 3/8 in-24 ("A")	AW1	

RL1131, RL921, RL935, RA921



### Two-In-One "T" Grade Hose use with fuel gases (LP or Acetylene Gas)

Stock No.	Length	Diameter	Weight (lbs & kg)	Connections		Use with Torch Series	I.D. Size
				To Regulator	To Torches		
TRL1131	20 ft (6.1 m)	1/4 in (6 mm)	6-1/2 (2.9 kg)	R11 (Oxygen) R12 (Fuel) 9/16 in-18("B")	R11 (Oxygen) R12 (Fuel) 9/16 in-18 ("B")	DG, SC, SW, CW, MW, AW10	1/4 in (6 mm)

TRL1131







## Repair Parts

### "O" Ring Replacements

Stock No.	Use with Welding/Heating Tips/Cutting Assemblies
AW15	AW Series Welding Tips / AT Series Heating Tips / AC309 Cutting Assembly / NE180 Series Air-Acetylene Tips
MW15	MW Series Welding Tips / MT Series Heating Tips / DG109A, MC509, MC505 & CC509P Cutting Assemblies
LW15	SW Series Welding Tips / ST Series Heating Tips / DG209, DG205, DG200, SC209, SC205, SC200 Cutting Assemblies

NOTE: 25 per package.

### Hand Cutting Torch Repair Kits

Stock No.	Use with Torches
15772	DG900 & SC900 Series
SC100	DG100, 200 & 300 Series; SC100, 200,300 Series

### Cutting Assembly Repair Kits

Stock No.	Use with Cutting Assemblies
SC101	Heavy Duty DG200 & SC Series
MC101	Medium Duty DG100 & MC Series

### The Little Torch™ Valve Assembly & Packing Replacements

Stock No.	
7345	Oxygen Valve Assembly
7346	Fuel Valve Assembly
7348	PTFE Packing for Valve Assembly (for Oxy and Fuel Valves)

### Torch Valve Replacements (2 valves per kit)

Stock No.	Use with Torch Handles & Hand Cutting Torches
LW17	WH100, MW5, MW5A, SW2, CW5A & AW10A
G729-5A	WH200, WH200A, SW1A, SW1B Series, 780 Series Machine Torch
AW11A	AW1A
LW14B-1	DG900, DG200, SC200, SC900 Series Hand Torches, 770 Series Machine Torches, SW1 Series Torch Handles

### Torch Head Replacement Nut

Stock No.	Use with Cutting Assemblies
G690-8	MC509, CC509P, AC309, MC505
G900-41A	Use with All SC Series Hand and Machine Torches & Cutting Torch Assemblies SC900 Series, SC772A, SC782A, SC781A, SC780A, SC771, SC770, SC509, SC300 Series Torches, SC300 Series Torches, SC100 Series Torches, SC300 Cutting Assembly
15555	Use with All Heavy Duty Dual Guard Hand Torch & Cutting Assemblies DG900 Series, DG209 Cutting Assembly, DG205 Cutting Assembly, DG300 Series, DG200 Series, DG100 Series
15720-1	Use with DG109A Cutting Assembly - DG109A



SC100



SC101



7345

7348

7346



G729-5A  
LW14B-1

LW17

AW11A



Cutting Tip Seat Grafitite® Packing Replacements	(1 Set Per Bag)
G691	"MC" Cutting Tips
G930	"SC" Cutting Tips



Torch Head  
Replacement Nut  
(Tip Nut)

## Smith Equipment®

The Little Torch™  
Service Parts/Consumables

### Jewelry Repair & Manufacture, Hobby & Crafts, Metal Sculpture, Glass Blowing, Plumbing, Electronics & Repair



**23-1014**

#### Outfit for Disposable Tanks

**23-1014** Includes 249-499B preset oxygen regulator, 249-500B preset propane regulator, cylinder holder, 11-1101C torch, #5 tip, 8ft (2.4m) hoses and instruction manual. Allows maximum portability and may be used in locations where larger pressurized cylinders are not allowed.

Kit shown in inset photo above may be used with disposable propylene or propane and oxygen cylinders (Cylinders not included).

*Disposable oxygen and fuel tanks may be purchased at most hardware locations. May not be used with LP Multi-Flame (Rosebud) tip.*

**23-1003B** Includes 11-1101C torch, #3-7 tips, 30-15-520 acetylene regulator (for "B" 40 cubic foot tank), 30-20-540 oxygen regulator, reverse flow check valves, 8' (2.4m) covered hoses and instruction manual.

**23-1003P** Kit with regulator fitting for propane or larger industrial acetylene cylinders. Includes 11-1101C torch, #3-7 tips, 30-15-510 fuel regulator, 30-20-540 oxygen regulator, reverse flow check valves, 8' (2.4m) covered hoses and instruction manual.

**23-1003** Kit with regulator fitting for acetylene (for "MC" tank) 10 cu. ft. cylinder. Includes 11-1101C torch, #3-7 tips, 30-15-200 fuel regulator, 30-20-540 oxygen regulator, check valves, 8' (2.4m) covered hoses and instruction manual.



**23-1001D**

**23-1001D** Works with any fuel gas and oxygen. Includes 11-1101C torch, #3-7 curved tips, 8' (2.4m) hoses and instruction manual. Packaged in display box as shown ("B" hose connections fuel 9/16"-18-LH, Oxygen 9/16"-18-RH).

**239-047B** with BRITISH hose connections (Fuel G-3/8"-19 LH, Oxygen G 3/8"-19 RH). Tips included #3-7. Replacement British hose 8 ft. 13254-6-8.

**239-048A** with EUROPEAN hose connections (Fuel G-3/8"-19 LH, Oxygen G 1/4"-19 RH). Tips included #3-7. Replacement European hose 8 ft. 13254-7-8.

**23-1013A** with AUSTRALIAN hose connections (Fuel 5/8"-18-LH, Oxygen 5/8"-18 RH). Replacement Australian hose 8 ft. 13254-5-8.

*Hoses may be connected to any standard oxy-fuel regulators (no adaptors required).*



**249-500B**  
Preset Propane Regulator

**249-499B**  
Preset Oxygen Regulator

**23-1003B**



OR



## Smith Equipment®

### The Little Torch™ Service Parts/Consumables

**Magnetic Torch Stand & Tip Organizer 14014** Solid metal stand comes with holes drilled and numbered for #2-7 tips. Just a twist of the wrist removes the torch from the magnet. Magnetic clip mounts easily on Little Torch™ body (torch and tips sold separately).



Stock No.	Gas	Capacity	Height-Diameter
0C20	Oxygen	20 cu.ft.	17 3/4" - 5 1/4"
2329E	"MC" Acetylene	10 cu.ft	14 1/2" - 4 1/8"
13558	Propane	5 lb.	12 1/2" - 8"

The Little Torch™ has unmatched flexibility - it can be used with several fuels including acetylene, hydrogen, propane, propylene, or natural gas. It produces a perfectly controlled, completely stable flame hot enough to melt commercially weldable metals, glass and even ceramics. It may also be used with special heating tips to melt up to 3 oz. of gold or silver. Excellent for soldering platinum.

It's the complete works in a handy self-contained lightweight unit. These highly portable kits come complete with everything you need for your soldering or brazing operations. Kits include tanks, regulators, safety check valves, five tips, torch and hoses all in a handy carrying case. Oxygen and acetylene cylinders can be refilled at most welding supply stores (disposable LP tanks are not included). Kits weight less than 32 lbs.



OR



Intertek



#### Propane Caddy

**23-1015P** Propane Caddy Includes 13558 (5 lb.) refillable propane tank, 0C20 (20 cu.ft.) oxygen tank, 11 1101C torch with 8 ft. (2.4m) covered hoses, #3-7 tips, 30-20-540 oxygen regulator, 30-15-510 propane regulator, H698 pair reverse flow check valves, 13787A powder coated metal carrier and complete operation and instruction manual.



#### Propane Caddy

**23-1010P** Propane Caddy Includes 11-1101C torch, 8' (2.4m) covered hoses, #3-7 tips, 249-500 B preset propane regulator, 30-20-540 oxygen regulator, 0C20 oxygen cylinder (20 cu.ft.) 13493 caddy carrier, H698 pair check valves, and complete instruction manual. The 14.1 oz. disposable LP tank provides up to 15 hours of running time with #5 tip.

*Disposable tanks not included.*



#### Acetylene Caddy

**23-1004A** Acetylene Caddy Includes 11-1101C torch, #3-7 tips, 30-15-200 acetylene regulator, 30-20-540 oxygen regulator, H698 pair reverse flow check valves, 8' (2.4m) covered hoses, 0C20 (20 cu.ft.) oxygen cylinder, 2329E (10 cu. ft.) acetylene cylinder, 13493 caddy carrier and instruction manual.

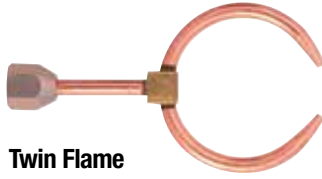


## Smith Equipment®

### The Little Torch™ Service Parts/Consumables



**Curved**  
12-1401-07



**Twin Flame**  
12-1402-04

#### Sapphire Tips

Due to the extraordinary small orifice diameter of tips sizes #2-3, tips are fitted with a laser drilled synthetic sapphire to assure accurate gas flow and consistent flame characteristics.

*All tips are 100% flame tested.*



#### Flexible Tip Extension

For customizing angle and distance from handle.

**Stock No.**  
2327-3SP

**Length**  
3 in. (76 mm)

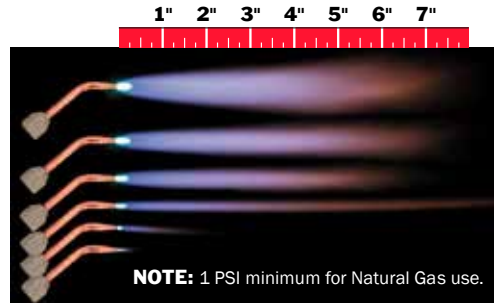
Size	Curved	Straight	Use With	Orifice Dia.	Drill Size	Gas Pressure (PSI)		Gas Consumption (CFH)		BTU/hr	Capacity
						Oxygen	Fuel	Fuel	Oxygen		
#2	12-1401-02	N/A	Acetylene, Hydrogen Only	0.006	97	2	2	0.09	0.11	130	N/A
#3	12-1401-03	N/A	Any Fuel Gas	0.011	85	4	4	0.78	0.94	1,150	Up to 1/8"
#4	12-1401-04	129-124-04		0.020	76	5	5	1.57	1.88	2,300	1/4"-3/8"
#5	12-1401-05	N/A		0.029	69	6	6	2.58	3.1	3,800	5/16"-5/8"
#6	12-1401-06	N/A		0.037	63	6	6	4.48	5.38	6,585	3/8"-3/4"
#7	12-1401-07	N/A		0.047	56	8	8	6.27	7.52	9,200	1/2"-7/8"

Size	Twin Flame	Use With	Orifice	Drill Size	Gas Pressure (PSI)		Gas Consumption (CFH)		BTU/hr	Brazing Capacity Copper Pipe
					Oxygen	Fuel	Fuel	Oxygen		
#4	12-1402-04 (N/A)	Any Fuel Gas	0.02	76	5	5	2.91	3.49	4,300	1/4"-5/8"
#5	12-1402-05		0.029	69	6	6	4.7	5.64	6,900	5/16"-3/4"
#6	12-1405-06		0.037	63	6	6	6.5	7.8	9,550	3/8" -7/8"



Twin Flame

Approximate flame sizes at neutral mixture (oxygen/acetylene)



**NOTE:** 1 PSI minimum for Natural Gas use.

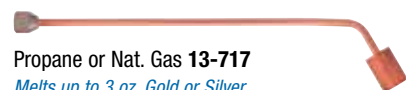
## Heating Tips

Stock No.	Fuel	Flame Average BTU/hr	Gas Pressure (PSI)		Length	Gas Consumption (CFH)	
			Oxygen	Fuel		Fuel	Oxygen
13-662	Acetylene	6,615	14	10	6" (153mm)	5	4.5
	Hydrogen	10,800				9	36.0
13717	Propane	3,497	14	10	6" (153mm)	5	1.4
	Natural Gas	2,300				7	5

*Note: Heating tips not for use with disposable oxygen tanks.*



**Acetylene 13-662**  
*Melts up to 3 oz. Gold or Silver*



**Propane or Nat. Gas 13-717**  
*Melts up to 3 oz. Gold or Silver*



## Smith Equipment®

## Quickbraze® Oxy-Fuel Outfits Refridgeration Outfits/Airconditioning



**23-5005A**

Adapts to A or B Style  
Regulator Connections



**S6**  
Single Flame Tip



**14711**  
Heating Tip



**T7**  
Twin Flame Tip



**C2**  
"C" Style Tip



**23-5004A**

**Caddy Kit** Tips supplied  
brazes up to 1-5/8"  
(41mm) diameter pipe fits  
10 cu.ft. "MC" acetylene  
and 20 cu. Ft. "R" oxygen  
tanks.

### Quickbraze® Tip Data Chart

Stock No.	Gas Pressure (PSI)		Gas Consumption (CFH)		BTU Output/Hr	Brazing Capacity Copper Pipe	No. Flames
	Oxygen	Fuel	Fuel	Oxygen			
S4 (N/A)	8	8	0.8	0.6	1,120	1/4"-3/8"	1
S6	8	8	3.2	3.4	7,360	1/2"-3/4"	1
T7	8	8	9.8	7.6	12,200	5/8"-1-3/8"	2
C2*	7	5	6.4	7.2	12,350	1/2"-1-1/8"	5
14711*	12	10	14.7	9.7	13,760	1/2"-1-5/8"	4

\*For use with Oxy-Acetylene only.

Kit Stock No.	Torch Assembly	Single Flame Tips	Twin Flame Tip	"C" Style Tip	Heating Tip	Regulators	Accessories
23-5004A	11-1114 "B" -9/16" Hose Fittings	S6	T7	C2	14711	30-20-540 30-15-200	Cylinder Caddy Carrier, Striker, Check Valves & Operations Manual (tanks not included)
23-5005A	11-1116 "A" -3/8" Hose Fittings					None	"A" to "B" Hose Adaptors & Operations Manual (hose may be attached to "A" or "B" Regulator Fittings)



Brazes solenoid and expansion valves so quickly that heat is unable to transfer to internal parts, protecting them from damage and eliminating the need for messy and costly heat sink materials.



Twin flame tips solder coil return bends quickly and evenly; concentrated heat will not heat and loosen surrounding joints.



Twin flame "C" style tips quickly braze reversing valves without burning internal components.



Revolutionary patented "C" style tips provide 100% flame wrap for fast, efficient, even heating. Heat is confined to the joint area protecting surroundings from burning. "C" style tips also assure even heat on the blind side of the braze joint.



Accumulators can be brazed extremely fast by simply laying the patented "C" style tip near the joint.





## Smith Equipment®

## Handi-Heat® & Silver Smith™ Acetylene-Air Kits Soldering, Brazing, Sweating & Heating

NE835A



### Acetylene-Air Handi-Heat®

Handi-Heat® soldering outfits provide fast heat with acetylene and atmospheric air. Concentrated soft flame delivers 4700 degrees F heat just where it is needed for maximum performance on all types of soldering, heating, thawing and other applications. Tough NE180A torch handle is built to last – machined from solid brass. Unlike plastic torches, it is not sensitive to temperature changes. Full length fluted handle provided firm comfortable grip. Needle valve provides excellent flame adjustment. Easy to operate. Just hold torch and set flame with one hand.

239-193



### Silver Smith™

Designed for jewelers, silver smiths and hobbyists (excellent choice for light brazing and soldering). Air-fuel torches deliver the ultimate in quality and flame control. The all metal torch provides strength and long life, while precision jeweled orifice tips produce a soft, consistent flame. The Silver Smith™ torch system is designed to work with air and acetylene gas.

Outfit No.	Torch Handle	Tips	Regulator	Fits Tanks	Accessories
NE835A	NE180A	NE180-1, NE180-2, NE180-3	30-15-520 (CGA520)	"B" 40 cu. ft.	RL121 12.5 ft. (3.8m) Hose N113A Lighter
239-193	NE180A	NE180-00			

Note: Torch does not require check valves or flashback arrestors.

## Air/Acetylene Torch & Tips



**NE180A**  
Length-5-3/8" (130mm)  
Weight 8-1/4 oz.

**NE180A Torch Handle**  
**1 Year Warranty**  
Use with acetylene gas. Machined from solid, brass. Hose connections 9/16"-18 LH thread, "B". Fits R12 or R14D hose Connections.

**NE180A Torch Handle**  
**1 Year Warranty**  
Burns acetylene with atmospheric air. Ideal for sweating copper joints up to 6" (152mm) in diameter, soldering, leading, thawing, heating and straightening.

- No oxygen tank needed
- Clean, economical heat
- No wrench needed-tips are hand tightened
- One-handed flame adjustment
- 360 degree Tip turning radius
- Tough all brass body
- Smooth turning needle valve
- Rugged tips
- Nickel plated for added heat resistance
- Fuel pressure setting: 12-14 PSIG

## Air/Acetylene Tips



**NE180-4**  
Length-8" (230mm)  
Weight 3-1/2 oz.

**NE180-4 Extra Large Tip**  
Use for fast paint burning, heavy soldering and heating. Replacement Orifice No. L704-6



**NE180-3**  
Length 7-5/8" (203mm)  
Weight 3-1/4 oz.

**NE180-3 Large Tip**  
Use for pipe thawing, light brazing and silver soldering. Replacement Orifice No. L703-6



**NE180-2**  
Length 6-7/8" (175mm)  
Weight 2-1/2 oz.

**NE180-2 Medium Tip**  
For all types of soft soldering, body leading, etc. Replacement Orifice No. L702-6



**NE180-1**  
Length 6-1/8" (156mm)  
Weight 1-7/8 oz.

**NE180-1 Small Tip**  
For fine instrument work, auto radiators, etc. Replacement Orifice No. L701-6



**NE180-0**  
Length 4-3/4" (121mm)  
Weight 1-3/4 oz.

**NE180-0 Fine Tip**  
For jewelry, small tube and electronics soldering. Replacement Orifice No. L711-6



**NE180-00**  
Length 4-3/4" (121mm)  
Weight 1-3/4 oz.

**NE180-00 Super Fine Tip**  
For delicate jewelry and electronic soldering. Replacement Orifice No. L710-6



Tip No	Flame Opening		Flame Inner Cone Length		Consumption SCFH	BTU Output
	Inch	mm	Inch	mm		
NE180-4	3/8"	10	1-3/4"	45	22.8	32,900
NE180-3	1/4"	6	1-1/2"	38	9	13,000
NE180-2	3/16"	5	1-1/4"	32	5.2	7,500
NE180-1	9/64"	3.6	3/4"	19	2.8	4,000
NE180-0	3/32"	2.4	1/4"	6	1.5	2,200
NE180-00	1/16"	1.7	1/8"	3	0.5	720







## Safety Accessories



HB190 Hard Hat



H195 Hard Hat

### Hard Hat™ Regulator Guards

Protect regulators from costly gauge replacement with our Hard Hat gauge guards. Promotes safety - designed to help prevent broken gauges which can lead to gas leaks. Time and cost savings - helps prevent costly equipment down time and expensive repairs.

**HB190 Hard Hat** is made from rugged steel with a bright yellow, baked-enamel finish. Quickly and easily attaches to regulator. Fits Series 40™, HB1500 and HB2100 Series brass regulators.

**H195 Hard Hat** is formed from extremely tough, impact-resistant polycarbonate resin with a bright, safety-yellow finish. Fits Series 30™ and 1700 Series single-stage regulators.

*Note: Will not work with flow gauge regulators.*

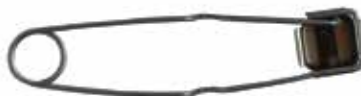
## Oxy Accessories



N230  
Cylinder Wrench



N250  
Tip Cleaner



N113ANB  
Lighter

NE135B  
Two-Hose Manifold



13493  
Torch and Cylinder Carrier

Stock Number	Product
N230	Cylinder Wrench
N250	Tip Cleaner (sharp point spiral)
N113ANB	Flint Lighter (N113-3 replacement flints) (5 per Pkg)
13493	Caddy Carrier with hose wrap and storage compartment for MC acetylene and 20 cu. ft. oxygen cylinders.
NE135B	Two-Hose Manifold – oxygen “B” connections
NE136B	Two-Hose Manifold – fuel “B” connections
16229	Circle Cutting Guide cuts from 5/8” to 12” diameter holes. Works with all SC and MC style cutting tips.



16229  
Adjustable Circle Cutting Guide

## GASAVER™



### Save money, save time and improve safety.

Ideal for production brazing and welding applications, our GASAVER can help you realize huge savings by eliminating wasted gas during torch start-up/shut-down and between flame applications. Save time by eliminating repeated torch adjustment. GASAVER gives you a safe place to temporarily put your torch and is used by America's largest production plants. Torch flame is automatically extinguished when torch is not in use. Simply pass torch over pilot flame to re-light.

**WDW100** is standard GASAVER for use with propylene gas and oxygen. Equipped with adjustable pilot light.

**WDW101** is standard GASAVER for general use with acetylene and oxygen. Can be installed in any convenient location on the line between regulators and torch. The closer the torch, the greater the savings in oxygen and acetylene. Equipped with adjustable pilot light.

**WDW103** is GASAVER equipped with separate adjustable pilot fuel inlet for use with low-pressure gas with injector type torches. Separate source of high-pressure pilot gas required. May also be used with hydrogen gas, however propane or natural gas is recommended to supply the adjustable pilot light.

**WDW104** is standard GASAVER equipped with adjustable pilot light for use with propane or natural gas at 4 PSI or more.

## Portable Engine Drive Tune-Up Components

Engine Drive	Engine Model	Tune-Up Kit #	Oil Filter #	Air Filter #	Air Filter Pre-Cleaner #	Spark Plug #	Battery
Blue Charger™	Onan Performer P218	137046	065251	064617	065653	065709 (2)	GP 58
Blue Charger™ NT	Onan Performer P218	137046	065251	064617	065653	065709 (2)	GP 58
Blue Star® 145	Kohler CS10TG	221581	—	221579	221580	203960	—
Blue Star® 145 DX	Kohler CS10STG	221584	—	221582	221583	203960	GP U1
	Yamaha MZ300	258078	—	258077	—	203960	GP U1
Blue Star® 185	Honda GX390	220305	—	220303 <sup>12</sup>	—	190108	—
BLUE STAR® 185 (ME330051R)	Kohler CH440	268469	NA	268468	NA	268467	GP U1
Blue Star® 185 DX	Kohler CS12STG	221584	—	221582	221583	203960	GP U1
	Yamaha MZ360	258078	—	258077	—	203960	GP U1
Blue Star® 3500	Honda GX270	—	—	190109	—	190108	U1
	Kohler Command CS8.5TG	—	—	203952	203954	203960	—
Blue Star® 6000	Honda GX390	—	—	220303	220304 (N/A)	190108	U1
	Kohler Command CS12STG	—	—	203952	203954	203960	—
Bobcat™ 225/250 (Rear Engine)	Kohler Command CH23/CH680	230015	066698	230016	230017	067007 (2)	GP 58
	Kohler Command CH20	180096	066698	067272	067273	067007 (2)	GP 58
	Kohler Command CH730LP	180096	066698	067272	067273	067007 (2)	GP 58
	Robin EH 64/65	199062	198754	198755	With Air Filter	198777 (2)	GP 58
Bobcat™ 250EF (Rear Engine)	Kohler Command ECH730	246115	066698	230016	230017	067007 (2)	GP 58
Bobcat™ 3 Phase (Front Engine)	Kohler Command CH23/CH680	230015	066698	230016	230017	067007 (2)	GP 58
	Kohler Command CH20	180096	066698	067272	067273	067007 (2)	GP 58
	Kohler Command CH730LP	180096	066698	067272	067273	067007 (2)	GP 58
Bobcat™ 225/250 (Front Engine)	Kohler Command CH730	230015	066698	230016	230017	067007 (2)	GP 58
	Kohler CH730LP	252838	066698	067272	067273	067007 (2)	GP 58
	Subaru EH65	199062	198754	198755	With Air Filter	198777 (2)	GP 58
Bobcat™ 250EF (Front Engine)	Kohler Command ECH730	246115	066698	230016	230017	067007 (2)	GP 58
Bobcat™ 3 Phase (Front Engine)	Kohler Command CH730	230015	066698	230016	230017	067007 (2)	GP 58
Bobcat™ 225D/225D Plus	Deutz/Rugg. MD-151	—	066702	066843	066842	—	(See note <sup>4</sup> )
Bobcat™ 225G/225G Plus	Onan Performer P-216	137046	065251	064617	065653	065709 (2)	(See note <sup>5</sup> )
Bobcat™ 225G Plus	Kohler Command CH18	180096	066698	067272	067273	067007 (2)	GP 58
Bobcat™ 225 NT	Kohler Command CH18/CH20	180096	066698	067272	067273	067007 (2)	GP 58
	Onan Performer P-216	137046	065251	064617	065653	065709 (2)	GP 58
Bobcat™ 250 NT	Kohler Command CH20	180096	066698	067272	067273	067007 (2)	GP 58
	Onan Performer P-220	137046	065251	064617	065653	065709 (2)	GP 58
	Onan Performer OHV220/Robin	199062	198754	198755	With Air Filter	198777 (2)	GP 58

<sup>1</sup>Prior to serial number KG045632 use 065629. Effective with serial number KG045632 use 067283.

<sup>2</sup>Prior to serial number KF926822 use 107297. Effective with serial number KF926822 use 164353.

**Note:** Number in (parenthesis) following the order number denotes quantity needed of particular component.

<sup>3</sup>Prior to JB482410 = U1.

<sup>4</sup>D=GP 24; DPlus=GP 58.

<sup>5</sup>G=GP U1; GPlus=GP 58.

<sup>6</sup>Prior to KF959177=24.

<sup>7</sup>250=GP 24; 251=GP 58.

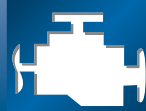
<sup>8</sup>Effective with LG070820.

<sup>9</sup>Effective with LG071468.

<sup>10</sup>Effective with LG073969.

<sup>11</sup>Effective with LG074229.

<sup>12</sup>220303 comes with pre-cleaner already installed on the Air Filter



## Portable Engine Drive Tune-Up Components

Engine Drive	Engine Model	Fuel Filter #	Fuel Pump #	Fuel Cap #	Voltage Regulator #	Muffler Gasket #	Muffler #
Blue Charger™	Onan Performer P218	237857	—	220711*	064846	065313 (2)	(See note <sup>1</sup> )
Blue Charger™ NT	Onan Performer P218	237857	—	220711*	064846	065313 (2)	183434
Blue Star® 145	Kohler CS10TG	—	—	203955	—	203959	203958 (N/A)
Blue Star® 145 DX	Kohler CS10STG	—	—	220711	—	203959	218411
	Yamaha MZ300	264220	—	220711	—	203959	218411
Blue Star® 185	Honda GX390	—	—	198522	—	—	—
Blue Star® 185 (ME330051R)	Kohler CH440	246110	—	250210	—	273877	267157
Blue Star® 185 DX	Kohler CS12STG	—	—	220711	—	203959	218411
	Yamaha MZ360	264220	—	220711	—	203959	218411
Blue Star® 3500	Honda GX270	—	—	198522	—	—	—
	Kohler Command CS8.5TG	—	—	203955	—	203959	203958 (N/A)
Blue Star® 6000	Honda GX390	—	—	198522	—	—	—
	Kohler Command CS12STG	—	—	203955	—	203959	203958 (N/A)
Bobcat™ 225/250 (Rear Engine)	Kohler Command CH23/CH680	215984	190248	220711*	190249	189477 (2)	228681
	Kohler Command CH20	215984	190248	220711	190249	189477 (2)	228681
	Kohler Command CH730LP	NA	NA	NA	190249	189477 (2)	228681
	Robin EH 64/65	237857	198756	220711	198778	217441 (2)	228680
Bobcat™ 250EFI (Rear Engine)	Kohler Command ECH730	246110	190248	220711*	244143	189477 (2)	245396
		246112					
Bobcat™ 3 Phase (Rear Engine)	Kohler Command CH23/CH680	215984	190248	220711*	190249	189477 (2)	228681
	Kohler Command CH20	215984	190248	220711	190249	189477 (2)	228681
	Kohler Command CH730LP	NA	NA	NA	190249	189477 (2)	228681
Bobcat™ 225/250 (Front Engine)	Kohler Command CH730	215984	190248	220711*	190249	189477 (2)	249313
	Kohler CH730LP	NA	NA	NA	190249	189477 (2)	249313
	Subaru EH65	237857	198756	220711*	198778	261651 (2)	249314
Bobcat™ 250EFI (Front Engine)	Kohler Command ECH730	246110	190248	220711*	244143	189477 (2)	249741
		246112					
Bobcat™ 3 Phase (Front Engine)	Kohler Command CH730	215984	190248	220711*	190249	189477 (2)	249313
Bobcat™ 225D/225D Plus	Deutz/Rugg. MD-151	066893	—	220711	—	—	—
Bobcat™ 225G/225G Plus	Onan Performer P-216	237857	—	220711	064846	065313 (2)	107297/164 353 (Plus)
Bobcat™ 225G Plus	Kohler Command CH18	215984	190248	220711	190249	189477 (2)	173065 (N/A)
Bobcat™ 225 NT	Kohler Command CH18/CH20	215984	190248	220711	190249	189477 (2)	183435
	Onan Performer P-216	237857	—	220711	064846	065313 (2)	183434
Bobcat™ 250 NT	Kohler Command CH20	215984	190248	220711	190249	189477 (2)	183435
	Onan Performer P-220	237857	—	220711	064846	065313 (2)	183434
	Onan Performer OHV220/Robin	237857	198756	220711	198778	065313 (2)	204841

<sup>1</sup> Prior to serial number KF926822 use 107297. Effective with serial number KF926822 use 164353.

<sup>2</sup> Prior to serial number MD210321R use 187428. Effective with serial number MD210321R use 257881.

Note: Number in (parenthesis) following the order number denotes quantity needed of particular component.

\*Gas tanks are EPA compliant starting 2012 week 10 (March 5, 2012). Contact Factory Service Department to ensure correct fuel cap is ordered.

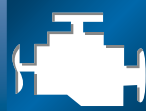
## Portable Engine Drive Tune-Up Components

Engine Drive	Engine Model	Tune-Up Kit #	Oil Filter #	Air Filter #	Air Filter Pre-Cleaner #	Spark Plug #	Battery
Bobcat™ 250 D NT	Kubota D722FB-25	206421	187443	187441	—	—	GP 58
Bobcat™ 250 Diesel	Kubota D722FB-25	206421	187443	187441	—	—	GP 58
Bobcat™ 250 Diesel (MD210321R)	Kubota D722	259935	187443	258349	—	—	GP 58
	Kohler Command CH20/CH730	180096	066698	067272	067273	067007(2)	GP 58
Miller Legend®	Onan Performer P-218	137046	065251	064617	065653	065709(2)	GP 58 <sup>6</sup>
Miller Legend® NT	Onan Performer P-218	137046	065251	064617	065653	065709(2)	GP 58
Miller Legend® 301 G/302	Kohler Command CH23	230015	066698	230016	230017	067007(2)	GP 58
	Kohler Command CH20	180096	066698	067272	067273	067007(2)	GP 58
Renegade™ 180	Kohler 8.5, CS10, 12.0	221581	—	221579	221580	203960	GP U1
Trailblazer® 250G/251	Onan Performer P-220	137046	065251	064617	065653	065709(2)	(See note <sup>8</sup> )
Trailblazer® 251 NT	Onan Performer P-220	137046	065251	064617	065653	065709(2)	GP 58
Trailblazer® 275 DC/302	Kohler Command CH23 <sup>11</sup>	230015	066698	230016	230017	067007(2)	GP 58
	Kohler Command CH20/CH730	180096	066698	067272	067273	067007(2)	GP 58
	Robin EH 64/65	199062	198754	198755	With Air Filter	198777(2)	GP 58
Trailblazer® 275 DC/302	Kohler Command CH23/CH680	230015	066 698	230016	230017	067007(2)	GP 58
Trailblazer® 275 DC/302 EFI	Kohler Command ECH730	246115	066 698	230016	230017	067007(2)	GP 58
Trailblazer® 275/325	Kohler Command CH730 w/e-gov	230015	066 698	230016	230017	067007(2)	GP 58
	Kohler Command CH730LP w/e-gov	252838	066 698	067272	067273	067007(2)	GP 58
Trailblazer® 275/325 EFI	Kohler Command ECH730 w/e-gov	246115	066698	230016	230017	067007(2)	GP 58
Trailblazer® 280 NT	Kohler Command CH20	180096	066698	067272	067273	067007(2)	GP 58
	Onan Performer P-220	137046	065251	064617	065653	065709(2)	GP 58
Trailblazer® DC/301 G	Kohler Command CH20	180096	066698	067272	067273	067007(2)	GP 58
Trailblazer® 301 G	Onan Performer P-220	137046	065251	064617	065653	065709(2)	GP 58
	Onan Performer OHV220/Robin	199062	198754	198755	With Air Filter	198777(2)	GP 58
Trailblazer® 300 D NT/301 D	Kubota D722FB-25	206421	187443	187441	—	—	GP 58
Trailblazer® 302 Diesel	Kubota D722FB-25	206421	187443	187441	—	—	GP 58
Trailblazer® 302 Air Pak	Kohler CH750	238743	066698	238744	238745	238746(2)	GP51R
Trailblazer® 325 Diesel	Kubota D902	259935	187443	258349	—	—	GP 58
Wildcat 200	Subaru	240585	—	240597	—	240598(2)	GP U1

<sup>1</sup>Prior to serial number KG045632 use 065629. Effective with serial number KG045632 use 067283.  
<sup>2</sup>Prior to serial number KF926822 use 107297. Effective with serial number KF926822 use 164353.  
**Note: Number in (parenthesis) following the order number denotes quantity needed of particular component.**

<sup>3</sup>Prior to JB482410 = U1.  
<sup>4</sup>D=GP 24; DPlus=GP 58.  
<sup>5</sup>G=GP U1; GPlus=GP 58.  
<sup>6</sup>Prior to KF959177=24.  
<sup>7</sup>250=GP 24; 251=GP 58.

<sup>8</sup>Effective with LG070820.  
<sup>9</sup>Effective with LG071468.  
<sup>10</sup>Effective with LG073969.  
<sup>11</sup>Effective with LG074229.



## Portable Engine Drive Tune-Up Components

Engine Drive	Engine Model	Fuel Filter #	Fuel Pump #	Fuel Cap #	Voltage Regulator #	Muffler Gasket #	Muffler #
Bobcat™ 250 D NT	Kubota D722FB-25	187442	—	220711	187821	189766	187428
Bobcat™ 250 Diesel	Kubota D722FB-25	187442	—	220711	187821	189766	187428
Bobcat™ 250 Diesel (MD210321R)	Kubota D722	213858, 259934	—	220711	—	192517	257880
Miller Legend®	Onan Performer P-218	237857	065629	220711	064846	065313(2)	(See note <sup>2</sup> )
Miller Legend® NT	Onan Performer P-218	237857	067283	220711	064846	065313(2)	183434
Miller Legend® 301 G/302	Kohler Command CH23	215984	190248	220711	190249	189477(2)	207458
	Kohler Command CH20	215984	190248	220711	190249	189477(2)	207458
Renegade™ 180	Kohler 8.5, CS10, 12.0	—	—	203955	—	203959	(See note <sup>3</sup> )
Trailblazer® 250G/251	Onan Performer P-220	237857	—	220711	064846	065313(2)	(See note <sup>3</sup> )
Trailblazer® 251 NT	Onan Performer P-220	237857	—	220711	064846	065313(2)	183434
Trailblazer® 275 DC/302	Kohler Command CH23	215984	190248	220711	190249	189477(2)	228 681
	Kohler Command CH20/CH730	215984	190248	220711	190249	189477(2)	228681
	Robin EH 64/65	215984	198756	220711	198778	217441(2)	228680
Trailblazer 275 DC/302	Kohler Command CH23/CH680	215984	190248	220711*	190249	189477(2)	228681
Trailblazer 275 DC/302 EFI	Kohler Command ECH730	246110, 246112	190248	220711*	190249	189477(2)	245396
Trailblazer 275/325	Kohler Command CH730 w/e-gov	215984	190248	255707	244143	189477(2)	249313
	Kohler Command CH730LP w/e-gov	—	190248	—	244143	189477(2)	249313
Trailblazer 275/325 EFI	Kohler Command ECH730 w/e-gov	246110, 246112	190248	255707	244143	189477(2)	249741
Trailblazer® 280 NT	Kohler Command CH20	215984	190248	220711	190249	189477(2)	183435
	Onan Performer P-220	237857	—	220711	064846	065313(2)	183434
Trailblazer® DC/301 G	Kohler Command CH20	215984	190248	220711	190249	189477(2)	183435
Trailblazer® 301 G	Onan Performer P-220	237857	—	220711	064846	065313(2)	183434
	Onan Performer OHV220/Robin	237857	198756	220711	198778	065313(2)	204841
Trailblazer® 300 D NT/301 D	Kubota D722FB-25	213858	—	220711	187821	189766	187428
Trailblazer® 302 Diesel	Kubota D722FB-25	213858	—	220711	187821	189766	187428
Trailblazer® 302 Air Pak	Kohler CH750	215985	190248	220711	244143	189477	235107
Trailblazer® 325 Diesel	Kubota D902	213858, 187442	—	220711	—	192517	257880
Wildcat 200	Subaru	241408	246926	220711	241434	246923	237720

<sup>1</sup> Prior to serial number KG045632 use 065629. Effective with serial number KG045632 use 067283.

<sup>2</sup> Prior to serial number KF926822 use 107297. Effective with serial number KF926822 use 164353.

Note: Number in (parenthesis) following the order number denotes quantity needed of particular component.

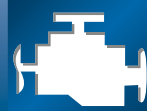
\*Gas tanks are EPA compliant starting 2012 week 10 (March 5, 2012). Contact Factory Service Department to ensure correct fuel cap is ordered.

## Portable Engine Drive Service Parts

*Note: Number in (parenthesis) following the order number denotes quantity needed of particular component.*

Model	Serial # Effective	Engine Model	Ignition/ Start Switch #	Brushes/ Brush Assy #	Idle Solenoid #	230 Volt Plug #	Rheostat/ Pot #	Module (Idle) #
Blue Charger™	JJ377166	Onan	172070	126984 (3)	106977	—	081712	142725
Blue Charger™ NT	KH477915	Onan	176606	126984 (3)	186308	119172	081712	See manual
Blue Star® 145/145 DX	LE366434	Kohler	Engine Mfg	493509 (1)	218794	213380	241165	201936
Blue Star® 185/185 DX	LE366294	Honda/Kohler	Engine Mfg	493509 (1)	218794	213380	241165	201936
Blue Star® 3500	KH519597	Honda/Kohler	Engine Mfg	493509 (1)	—	—	494618 (N/A)	—
Blue Star® 6000	KH467216	Honda/Kohler	Engine Mfg	493509 (1)	—	—	See manual	—
Bobcat™ 225	LE294172	Kohler/Robin	217680	205725 (1)	Engine Mfg	119172	233060	201936
Bobcat™ 225D	KB032454	Deutz/Rugg.	172070	126984 (2)	149618	119172	205839	142725
Bobcat™ 225D Plus	KG076022	Deutz/Rugg.	176606	See manual	See manual	119172	205839	See manual
Bobcat™ 225G	JK561993	Onan	172070	126984 (2)	151485	119172	205839	189742
Bobcat™ 225G Plus	KE582332	Kohler	176606	126984 (2)	199530	119172	205839	189742
		Onan	See manual	126984 (2)	165810	119172	205839	189742
Bobcat™ 225 NT	KH329624	Kohler	See manual	See manual	See manual	119172	See manual	See manual
		Onan	See manual	See manual	See manual	119172	See manual	See manual
Bobcat™ 250	LE237205	Kohler/Robin	217680	205725 (1)	Engine Mfg	119172	233060	201936
Bobcat™ 250 NT	LB097734	Kohler	See manual	See manual	199530	119172	233060	201936
		Onan/Robin	See manual	See manual	See manual	119172	233060	201936
Bobcat™ 250 D NT	LC357432	Kubota	See manual	205725 (1)	248995	119172	233060	212062
Bobcat™ 3 Phase	LE295787	Kohler	See manual	205725 (1)	Engine Mfg	119172	233060	201936
Miller Legend®	JH242114	Onan	172070	126984 (3)	106977	See manual	081712	142725
Miller Legend® NT	KH329624	Onan	176606	126984 (3)	See manual	119172	081712	See manual
Miller Legend® 301G	KH329624	Kohler	176606	205725 (1)	Engine Mfg	119172	See manual	—
Miller Legend® 302	KH329624	Kohler	217680	205725 (1)	Engine Mfg	119172	See manual	—
Trailblazer® 250G	JG018501	Onan	See manual	126984 (3)	See manual	025234 (N/A)	072462	See manual
Trailblazer® 251	KG160691	Onan	176606	126984 (3)	165810	025234 (N/A)	072623	See manual
Trailblazer® 251 NT	KJ003470	Onan	176606	126984 (3)	165810	119172	072623	216273
Trailblazer® 275 DC/302	LE246322	Kohler/Robin	217680	205725 (1)	Engine Mfg	119172	See manual	
Trailblazer® 280 NT	LA095390	Kohler	176606	126984 (3)	Engine Mfg	119172	072623	216273
		Onan	176606	126984 (3)	165810	119172	072623	216273
Trailblazer® DC	LB159073	Onan	176606	205725 (1)	165810	119172	See manual	—
		Robin	176606	205725 (1)	165810	119172	See manual	—
Trailblazer® 301 G	LB159073	Kohler	176606	205725 (1)	199530	119172	See manual	—
		Onan	176606	205725 (1)	165810	119172	See manual	—
		Robin	176606	205725 (1)	165810	119172	See manual	—
Trailblazer® 300 D NT	KJ022682	Kubota	176606	126984 (3)	See manual	119172	072462	—
Trailblazer® 301 D	LC119875	Kubota	176606	205725 (1)	248995	119172	See manual	—
Wildcat™ 200	LJ450001H	Subaru	217680	493509 (1)	—	119172	238905	189742
Wildcat™ 225G	JJ367046	Onan	172070	126984 (4)	—	119172	205839	189742





## Industrial Engine Drive Tune-Up Components

Engine Drive	Engine Model	Oil Filter #	Air Filter #	Air Filter (Safety Element) #	Fuel Filter (Primary) #	Fuel Filter (Secondary) #	Engine Filter Kit	Battery
Big 40®	Continental F-163	061760	017309	—	—	—		GP 24
Big 40®G	Continental TM-20	114559	017309	—	047420	—		GP 24
Big 40® Diesel	Continental TMD-20	064983	020319	—	192744	—		GP 24
Big 40® Diesel (CAT)	CATERPILLAR 3024C/C2.2	202166	192938	192939	192744	202167	246985	GP 24
Big 50 Diesel™ (Prior to JK718458)	Continental TMD-27	064983	020319	—	062342	—		GP 24
Big 50 Diesel™ (Eff. with JK718458)	Continental TMD-27	064983	020319	—	192744	—		GP 24
Big Blue® 251D (Prior to KF846844)	Deutz F3L1011	—	—	—	192744	066217		GP 55
Big Blue® 251D (Eff. with KF846844)	Deutz F3L1011	067265	—	—	192744	066217		GP 55
Big Blue® 251D (Eff. with LA153592)	Deutz F3L1011	067265	197676	197679	192744	066217		GP 55
Big Blue® 300/Pro	Perkins 403C-15	197899	197676	197679	213858	197997		GP 55
	CATERPILLAR C1.5	202166	197676	197679	213858	202167	246987	GP 55
	Deutz 2008	228778	197676	197679	213858	202167	246986	GP 55
	Mitsubishi-S4L2	242882	197676	—	252781	213858	252782	GP 55
Big Blue® 302D	Deutz F3L1011	067265	192938	192939	192744	066217		GP 24
Big Blue® 302P	Perkins 104.22	197899	192938	192939	192744	197997		GP 24
Big Blue® 350 PipePro® (Prior to MA 250132E)	Mitsubishi-S4L2	242882	197676	197679	213858	242881	244711	GP 55
Big Blue® 350 PipePro® (Eff. s/n MA250132)	Mitsubishi-S4L2	242882	197676	197679	213858	252781	252782	GP 55
Big Blue® 350 PipePro®	Caterpillar C1.5	202166	197676	197679	—	202167	246987	GP 55
Big Blue® 400D	Deutz F3L2011	067265	192938	192939	192744	066217	246988	GP 24
	Perkins 404.22	197899	192938	192939	192744	197997	246985	GP 24
Big Blue® 400D	Deutz F3L912	064677	020319	—	062342	064686		GP 24
Big Blue® 400 KX	Kubota V1505-EBG1	196428	197676	197679	213858	207715		GP 55
Big Blue® 400 Pro	Mitsubishi S4L2	252782	197676	N/A	213858	252781	244711	GP 35
Big Blue® 400 Pro	Cat C1.5	202166	197676	197679	213858	202167	246987	GP 35
Big Blue® 400 Pro	Kubota 1505 E3BG	196428	197676	197679	233482	207715	N/A	GP 35
Big Blue® 402D /502D/602D	Deutz F4L1011	067265	192938	192939	192744	066217		GP 24
	Deutz F3L912	064677	192938	192939	192744	064686		GP 24
Big Blue® 402P/502P/602P	Perkins 3.152	192936	192938	192939	192744	192937		GP 24
Big Blue® 450 duo CST™	Mitsubishi S4L2	242882	197676	197679	213858	252781	244711	GP 35
Big Blue® 400/500 ECO Pro	Mitsubishi-S4L2	242882	197676	197679	213858	252781		
Big Blue® 500 Pro (Deutz) <sup>4</sup>	Deutz 2.9L4	067265	192938	192939	255764	255765	262459	GP 31
Big Blue® 500X	Deutz F3L912	064677	192938	192939	192744	064686	246989	GP 24
	Deutz F4L2011	067265	192938	192939	192744	066217	246988	GP 24
	Perkins 404.22T	197899	192938	192939	192744	197997	246985	GP 24
Big Blue® 600D	Deutz F4L912	064677	020319	—	062342	064686		GP 24
Big Blue® 600 Pro	Kubota V2403	273287	273283	273284	273285	273286	273293	GP 31
Big Blue® 700 Dual Pro <sup>4</sup>	Deutz F4L2011	067265	192938	192939	192744	066217	246988	GP 24
Big Blue® 800 Duo Pro	Deutz TD2.94L4	067265	192938	192393	255764	255765	262459	GP 31
Big Blue® 800 Duo Pro Air Pak™	Deutz TD2.94L4	067265	192939	192939	255754	255765	262459	GP 31
Big Blue® 800 Pro Air Pak (Deutz) <sup>4</sup>	Deutz 2.9L4	067265	192938	192939	225764	255765	262459	GP 31
Big Blue® Air Pak™ <sup>1</sup>	Deutz BF4M 2011	067265	192938	192939	192744	066217	246988	GP 24
Big Blue® Turbo	Deutz BF4M 2011	067265	192938	192939	192744	066217	246988	GP 24
Miller Air Pak™	Deutz F4L912	064677	020319	—	062342	064686		GP 24
Miller Du-Op™	Deutz F3L912/914	064677	(See note <sup>2</sup> )	(See note <sup>3</sup> )	062342	064686	246989	GP 24
PRO 300	CATERPILLAR 3013C/C1.5	202166	197676	197679	213858	202167	246987	GP 24
PipePro™ 304	Kubota DH905/1005	196428	187441	202102	237857	192744	246990	GP 55
Trailblazer®Pro 350	Kubota DH905/1005	196428	187441	202102	237857	192744	246990	GP 55

<sup>1</sup>IR Compressor Filter Kit 246991, Oil Filter 206745, Separator Filter 206747 and Air Filter 197676.  
<sup>2</sup>Prior to serial number LB043908 use 020319. Effective with serial number LB043908 use 192938.  
<sup>3</sup>Effective with serial number LB043908 use 192939.  
<sup>4</sup>Single-Phase Plug 119172, Three-Phase Plug 254140.

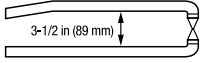


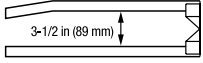

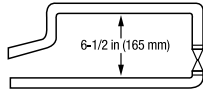


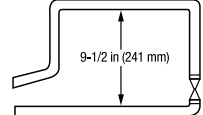


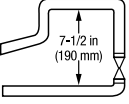


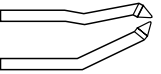

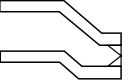
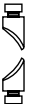


## Industrial Engine Drive Tune-Up Components

Engine Drive	Engine Model	Fuel Cap #	Blower/ Fan Belt #	Alternator Belt #	Fuel Filter (Primary) #	Fuel Filter (Secondary) #	Engine Filter Kit	Battery
Big 40®	Continental F-163	182022	—	—	—	—		GP 24
Big 40®G	Continental TM-20	182022	118156	—	047420	—		GP 24
Big 40® Diesel	Continental TMD-20	182022	118156	—	192744	—		GP 24
Big 40® Diesel (CAT)	CATERPILLAR 3024/C2.2	254678	197944	—	192744	202167	246985	GP 24
Big 50 Diesel™ (Prior to JK718458)	Continental TMD-27	182022	118156	—	062342	065346		GP 24
Big 50 Diesel™ (Eff. with JK718458)	Continental TMD-27	182022	118156	—	192744	—		GP 24
Big Blue® 251D (Prior to KF846844)	Deutz F3L1011	182022	—	—	192744	066217		GP 55
Big Blue® 251D (Eff. with KF846844)	Deutz F3L1011	182022	—	—	192744	066217		GP 55
Big Blue® 251D (Eff. with LA153592)	Deutz F3L1011	182022	—	—	192744	066217		GP 55
Big Blue® 300/Pro	Perkins 403C-15	254678	217686	—	213858	197997		GP 55
	CATERPILLAR C1.5	254678	217686	—	213858	217687	246987	GP 55
	Duetz 2008	254678	228780	—	213858	202167	246986	GP 55
	Mitsubishi-S4L2	254678	242883	—	252781	213858	252782	GP 55
Big Blue® 302D	Deutz F3L1011	254678	067266	—	192744	066217		GP 24
Big Blue® 302P	Perkins 104.22	254678	197944	—	192744	197997		GP 24
Big Blue® 350 PipePro® (Prior to MA 250132E)	Mitsubishi-S4L2	254678	242883	—	213858	242881	252782	GP 55
Big Blue® 350 PipePro® (Eff. s/n MA250132)	Mitsubishi-S4L2	254678	242883	—	213858	252781	252782	GP 55
Big Blue® 350 PipePro®	Caterpillar C1.5	254678	217686	—	213185	202167	246987	GP 55
Big Blue® 400D	Deutz F3L2011	254678	216959	—	192744	066217	246988	GP 24
	Perkins 404.22	254678	197944	—	192744	197997	246985	GP 24
Big Blue® 400D	Deutz F3L912	182022	—	136250	062342	064686		GP 24
Big Blue® 400 KX	Kubota V1505-EBG1	254678	218468	—	213858	207715		GP 55
Big Blue® 400 Pro	Mitsubishi S4L2	254678	N/A	242883	213858	252781	244711	GP 35
Big Blue® 400 Pro	Cat C1.5	254678	N/A	217686	213858	217687	246987	GP 35
Big Blue® 400 Pro	Kubota 1505 E3BG	254678	N/A	218468	233482	207715	N/A	GP 35
Big Blue® 402D/502D/602D	Deutz F4L1011	254678	067266	—	192744	066217		GP 24
	Deutz F3L912	254678	066271	—	192744	064686		GP 24
Big Blue® 402P/502P/602P	Perkins 3.152	254678	193163	—	192744	192937		GP 24
Big Blue® 450 duo CST™	Mitsubishi S4L2	254678	N/A	242883	213858	252781	244711	GP 35
Big Blue® 500 ECO Pro					213858	252781		
Big Blue® 500 Pro (Deutz)	Deutz 2.9L4	254678	260572	—	255764	255765	262459	GP 31
Big Blue® 500X	Deutz F3L912	254678	066271	—	192744	064686	246989	GP 24
	Deutz F4L2011	254678	067266	—	192744	066217	246988	GP 24
	Perkins 404.22T	254678	197944	—	192744	197997	246985	GP 24
Big Blue® 600D	Deutz F4L912	—	066271	—	062342	064686		GP 24
Big Blue® 600 Pro	Kubota V2403	254678	—	273288	273285	273286	273293	GP 31
Big Blue® 700 Dual Pro	Deutz F4L2011	254678	197944	—	192744	066217	246988	GP 24
Big Blue® 800 Duo Pro	Deutz TD2.9L4	190198	N/A	260572	255764	255765	262459	GP 31
Big Blue® 800 Duo Pro Air Pak™	Deutz TD2.9L4	190198	N/A	253944	255754	255765	262459	GP 31
Big Blue® 800 Duo Pro Air Pak (Deutz)	Deutz 2.9L4	254678	260572	—	225764	255765	262459	GP 31
Big Blue® Air Pak™ 1	Deutz BF4M 2011	254678	207808	—	192744	066217	246988	GP 24
Big Blue® Turbo	Deutz F4L 2011	254678	067266	—	192744	066217	246988	GP 24
Miller Air Pak™	Deutz F4L912	—	066271	—	062342	064686		GP 24
Miller Du-Op™	Deutz F3L912/914	182022	—	066213	062342	064686	246989	GP 24
PRO 300	CATERPILLAR 3013C/C1.5	254678	217686	—	213858	202167	246987	GP 24
PipePro™ 304	Kubota DH905/1005	182022	197197	—	—	192744	246990	GP 55
Trailblazer® Pro 350	Kubota DH905/1005	182022	197197	—	—	192744	246990	GP 55

<sup>1</sup>IR Compressor Filter Kit 246991, Oil Filter 206745, Separator Filter 206747 and Air Filter 197676.  
<sup>2</sup>Prior to serial number LB043908 use 020319. Effective with serial number LB043908 use 192938.  
<sup>3</sup>Effective with serial number LB043908 use 192939.

## MSW and LMSW Series Tongs and Tips

TONGS	6 in (152 mm)	12 in (305 mm)	18 in (457 mm)	Tips
Standard 	040197	040198	040199	Standard 040211  Flat 040212 
MO Offset 	040200	040201	040202	MO Offset 040215 
TT-6 	—	040203	040204	Standard 040211  Flat 040212 
TT-9 	—	040205	040206	Standard 040211  Flat 040212 
G-7 		8 in (203 mm) 040207		Standard 040211  Flat 040212 
FF 		8 in (203 mm) 040208		FF 040213 
FH 		5 in (127 mm) 040209		FH 040214 

For your added convenience, spot welder tongs and tips can now be ordered through the Miller Service Parts business for use with the following models:

- MSW-41, MSW-41T, MSW-42, MSW-42T, LMSW-52 and LMSW-52T



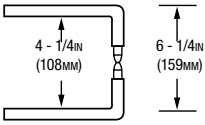
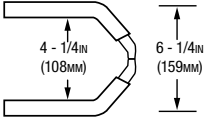
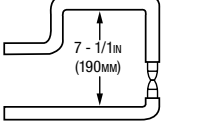
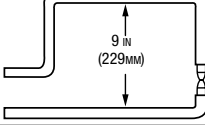
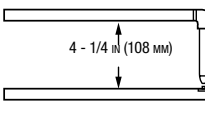
**Gyro Bail 041979**  
Supports the weight of the welder. Operates with boom and counterweight or from spring-loaded cable. Spot welds in any position.








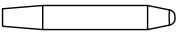


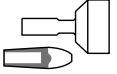

### Important Ordering Information

- To determine the correct tong reorder length, measure exposed tong length when installed in spot welder.  
Removed tongs measure 2 inches longer than the listed chart length. For correct reorder length, deduct 2 inches from the removed tong.
- One set of tips is supplied with each set of tongs.
- Maximum welding capabilities are obtained with minimum tong length.
- Tips are made of RWMA Class 2 Alloy.

# SPOT WELDERS

## PSW & SSW Series Tongs and Tips

TONGS	Description	6 in (152 mm)	12 in (305 mm)	18 in (457 mm)	Tips Included
	Standard 90° No. 1 MT No. 2 MT	040218 —	040219 —	040220 041001	040223 040308
	Standard 45° No. 1 MT No. 2 MT	—	041004 —	041005 (N/A) 041001 (N/A)	040851 040225
	TT-6W No. 2 MT	—	—	041838	040308
	TT-9W No. 2 MT	—	—	041840 (N/A)	040308
	SW-12	—	071465 (N/A)	—	No. 1 Pointed 071466 Top Flat Threaded 071467 Bottom

TIPS	Description	Part #	Quantity	Where Used
	No. 1 MT (Pointed)	040223	2 tips	Standard 90° No. 1 Tongs
	No. 1 MT (Offset)	040224	2 tips	Standard 90° No. 1 Tongs
	No. 2 MT (Pointed)	040308	2 tips	Standard 90° No. 2 Tongs, TT-6W Tongs, TT-9W Tongs
	No. 1 MT (Offset)	040851	2 tips	Standard 45° No. 1 Tongs
	No. 1 MT (Offset)	040226	2 tips	Standard 90° No. 1 Tongs
	No. 1 MT (Offset)	040298	2 tips	Standard 90° No. 1 Tongs
	No. 2 MT (Offset)	040225	2 tips	Standard 45° No. 2 Tongs
	No. 1 MT (Pointed)	071466	1 tip for top tong	SW-12 Tongs
	Threaded (Flat)	071343	1 tip for bottom tong	SW-12 Tongs (Optional)
	Threaded (Flat)	071467	1 tip for bottom tong	SW-12 Tongs
	No. 1 MT (Flat Swivel Tip)	040216	2 tips	Standard 90° No. 1 Tongs
	Adapter (Adapts No. 1 Morse Taper Tip to No. 2 Receptacle)	040227	2 adapters	Standard 90° No. 2 Tongs, TT-6W Tongs (Top), TT-9W Tongs (Top)

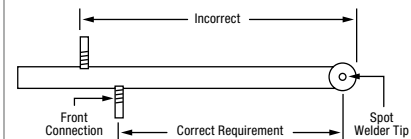
For your added convenience, spot welder tongs and tips can now be ordered through the Miller Service Parts business for use with the following models:

- PSW-1020 ATT and PSW-2020 ATT
- SSW-1020 ATT, SSW-2020 ATT and SSW-2040 ATT



### Important Ordering Information

- To determine the correct tong reorder length, measure from the center of the spot weld tip back to the front water hose connection.



- Tongs and tips shown to the left can be used with all PSW and SSW model spot welders. Recommended maximum tong length is 18 in (457 mm). A limited group of special tongs are available, contact Miller Service Parts.
- Tong throat-height dimension for standard 90° and 45° tongs is 4-1/4 in (108 mm). Throat length is measured from the center of the spot tips to the front water hose connection on the tong.
- One set of tips is supplied with each set of tongs.
- Tips are made of RWMA Class 2 alloy.
- Maximum welding capabilities are obtained with minimum tong length.
- MT = Morse Taper  
No. 1 Morse Taper diameter = 1/2 inch  
No. 2 Morse Taper diameter = 5/8 inch



## TIG Connectors

### A-150/A-200 1-Piece Power Cable Connectors



**194722 / 194723**  
50 mm Dinse-style gas thru for one-piece air-cooled torch.



**195378 / 195379**  
50 mm Dinse-style for one-piece air-cooled torch.



**105Z57**  
Power cable adapter for one-piece A-150 torch.



**45V62**  
Power cable adapter for one-piece A-200 torch.

**225564**  
Replacement Back Hose

### A-150/A-200 2-Piece Power Cable Connector



**129527**  
50 mm Dinse-style for two-piece cable air-cooled torch.

### W-225 Power Cable Connectors



**195380**  
50 mm Dinse-style gas thru with gas and water return lines for water-cooled torch.



**195377**  
50 mm Dinse-style with water return line for water-cooled torch.



**45V11**  
Power cable adapter for water-cooled torch.



**225028**  
50 mm thread lock-style for water-cooled torch.

**222809**  
Replacement Red Hose

**225564**  
Replacement Black Hose

**222809**  
Replacement Red Hose

**221170**  
Replacement Black Hose

Machines	Connection Type	A-150 Power Cable Connector		A-200 Power Cable Connector		W-225 Power Cable Connector
		1-Piece	2-Piece	1-Piece	2-Piece	
<b>TIG Machines</b>						
Syncrowave® 200/210	50 mm Dinse, Gas Thru	194722	129527*	194723	129527*	195380
Syncrowave® 250 DX/350 DX (Dinse)	50 mm Dinse	195378	129527	195379	129527	195377
Syncrowave® 250 DX/350 DX (Stud)	1/2 in Stud	105Z57	N/A	45V62	N/A	45V11
Maxstar® 150 STL/STH	25 mm Dinse, Gas Thru	273483	127836*	N/A	N/A	N/A
Dynasty® 200/350, Maxstar® 200/350	50 mm Dinse	195378	129527	195379	129527	195377
Dynasty® 700, Maxstar® 700	50 mm Thread Lock	N/A	N/A	N/A	N/A	225028
<b>Multiprocess Machines</b>						
Multimatic™ 200	25 mm Dinse, Gas Thru	273483	263801*	N/A	N/A	N/A
Dimension™ 302/452/NT 450/652	1/2 in Stud	105Z57	N/A	45V62	N/A	45V11
Pipeworx	1/2 in Stud	105Z57	N/A	45V62	N/A	45V11
XMT® 304/350	50 mm Dinse	195378	129527	195379	129527	195377
XMT® 450	1/2 in Stud	105Z57	N/A	45V62	N/A	45V11
<b>Engine-Driven Machines</b>						
Most Big Blue®, Trailblazer®, Bobcat®, Blue Star®, and Wildcat® models	1/2 in Stud	105Z57	N/A	45V62	N/A	45V11
Big Blue® 450 Duo CST	50 mm Dinse	195378	129527	195379	129527	195377
<b>General Reference</b>						
	25 mm Dinse, Gas Thru	273483	N/A	N/A	N/A	N/A
	50 mm Dinse	195378	129527	129527	195379	195377
	50 mm Dinse, Gas Thru	194722	N/A	N/A	194723	195380
	50 mm Thread Lock	N/A	N/A	N/A	N/A	225028
	1/2 in Stud	105Z57	N/A	N/A	45V62	45V11
<b>Other Adapter</b>						
	Stud to Dinse Adapter	232728	N/A	232728	N/A	232728

\*Two-piece power cable connector is not gas thru.

# TIG TORCHES

## Weldcraft® A-125 Series Formerly WP-9 Series

Hand-Held Air-Cooled  
Service Parts/Consumables



A-125  
(WP-9)

### Additional Torch Models



Note: Torches delivered may vary slightly from images shown.

Models		1-Piece Power Cable Standard Rubber		2-Piece Power Cable Rubber	
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
WP-9	A-125	WP-9-12-R	WP-9-25-R	WP-9-12-2	WP-9-25-2
WP-9V	A-125 Valve	WP-9V-12-R	WP-9V-25-R	WP-9V-12-2	WP-9V-25-2
WP-9F	A-125 Flex	WP-9F-12-R	WP-9F-25-R	WP-9F-12-2	WP-9F-25-2
WP-9FV	A-125 Flex Valve	WP-9FV-12-R	WP-9FV-25-R	WP-9FV-12-2	WP-9FV-25-2
WP-9P	A-125 Pencil	WP-9P-12-R	WP-9P-25-R	—	—

V= Valve F=Flex FV=Flex Valve P=Pencil  
Torch packages include torch body, handle, power cable, and long back cap (excluding the A-125 Pencil model).

Torch Bodies		Valves		Handles	
A-125	WP-9	—		Ribbed	H-100R
A-125 Valve	WP-9V	VS-2		Knurled	H-100
Torch Bodies Optional			Flex Head ONLY		
A-125 Flex	WP-9F	—	9F	Ribbed	105Z55R
A-125 Flex Valve	WP-9FV	VS-2	9F	Knurled	105Z55
A-125 Redhead Flex	WP-R9F	—	R9F		
A-125 Redhead Flex Valve	WP-R9FV	VS-2	R9F		

Power Cables					
Rubber		2-Piece		Mono Flex	
12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
57Y01R	57Y03R	57Y01-2	57Y03-2	57Y01MF	57Y03MF
Replacement Gas Hose					
—	—	45V09R	45V10R	—	—

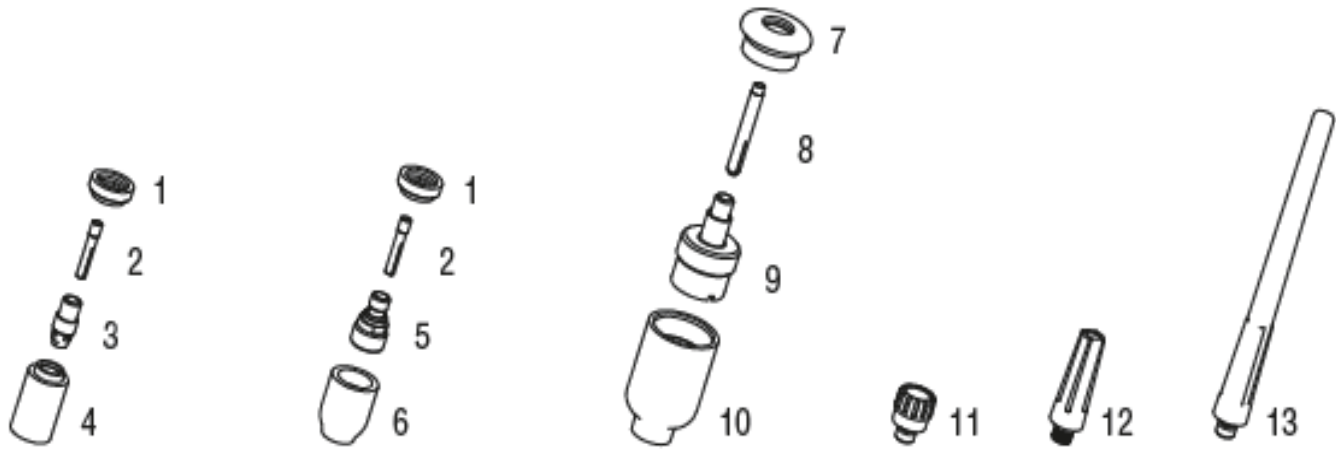
**#AK1C Accessory Kit**  
Includes one long back cap, two collets (one collet per size: .040, 1/16), three alumina nozzles (one nozzle per size: 4, 5, 6), and two 7-inch 2% ceriated tungsten electrodes (one electrode per size: .040, 1/16).



**Cable Covers**  
#WC-3-10  
10 ft (3 m)  
#WC-3-22  
22 ft (6.7 m)  
#WC-3-48  
48 ft (14.6 m)



**Extension Kit**  
#EK-2-25-R 25 ft (7.6 m), Rubber



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
3 Collet Body	13N25		13N26		13N27		13N28		13N29
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
5 Gas Lens	45V41		45V42		45V43		45V44		45V45
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
7 Insulator (required)	54N63-20		54N63-20		54N63-20		54N63-20		54N63-20
8 Collet	13N20L		13N21L		13N22L		13N23L		13N24L
9 Large Diameter Gas Lens	45V0204S		45V0204S		45V116S		45V64S		995795S
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short 41V33	12 Medium 41V35	13 Long 41V24
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\*Not shown.



# TIG TORCHES

## Weldcraft® A-150 Series Formerly WP-17 Series

Hand-Held Air-Cooled  
Service Parts/Consumables



A-150  
(WP-17)

### Additional Torch Models



A-150 Flex  
(WP-17F)

A-150 Flex Valve  
(WP-17FV)



A-150 Flex  
Redhead  
(WP-R17F)

A-150 Flex  
Valve Redhead  
(WP-R17FV)



A-150 Valve  
(WP-17V)

A-150 PSH\*  
(WP-17-PSH)

A-150 Valve PSH\*  
(WP-17V-PSH)

Note: Torches delivered may vary slightly from images shown.

Models		1-Piece Power Cable Standard Rubber		1-Piece Power Cable Mono-Flex™		2-Piece Power Cable Rubber	
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
WP-17	A-150	WP-17-12-R	WP-17-25-R	WP-17-12-MF	WP-17-25-MF	WP-17-12-2	WP-17-25-2
WP-17V	A-150 Valve	WP-17V-12-R	WP-17V-25-R	—	WP-17V-25-MF	WP-17V-12-2	WP-17V-25-2
WP-17F	A-150 Flex	WP-17F-12-R	WP-17F-25-R	—	—	WP-17F-12-2	WP-17F-25-2
WP-17FV	A-150 Flex Valve	WP-17FV-12-R	WP-17FV-25-R	—	—	WP-17FV-12-2	WP-17FV-25-2
WP-R17FV	A-150 Flex Valve Redhead™	WP-R17FV-12-R	WP-R17FV-25-R	—	—	—	—
WP-17-PSH	A-150 PSH	—	WP-17-25-R-PSH	—	—	WP-17-12-2-PSH	WP-17-25-2-PSH
WP-17V-PSH	A-150 Valve PSH	WP-17V-12-R-PSH	WP-17V-25-R-PSH	—	—	—	WP-17V-25-2-PSH

V= Valve F=Flex FV=Flex Valve PSH=Positive Stop Handle (threaded handle); Torch packages include torch body, handle, power cable, and long back cap.

Torch Bodies		Valves		Handles	
A-150	WP-17	—		Ribbed	H-100R
A-150 Valve	WP-17V	VS-2		Knurled	H-100
Torch Bodies Optional		Flex Head ONLY			
A-150 Flex	WP-17F	—	17F	Ribbed	105Z55R
A-150 Flex Valve	WP-17FV	VS-2	17F	Knurled	105Z55
A-150 Redhead Flex	WP-R17F	—	R17F		
A-150 Redhead Flex Valve	WP-R17FV	VS-2	R17F		
A-150 PSH	WP-17-PSH	—			
A-150 Valve PSH	WP-17V-PSH	VS-2			
Power Cables					
Rubber		2-Piece		Mono Flex	
12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
57Y01R	57Y03R	57Y01-2	57Y03-2	57Y01MF	57Y03MF
Replacement Gas Hose					
—	—	45V09R	45V10R	—	—

### #AK2C Accessory Kit

Includes one short back cap, three collets (one collet per size: .040, 1/16, 3/32), three collet bodies (one collet body per size: .040, 1/16, 3/32), three alumina nozzles (one nozzle per size: 4, 5, 6), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: .040, 1/16, 3/32).



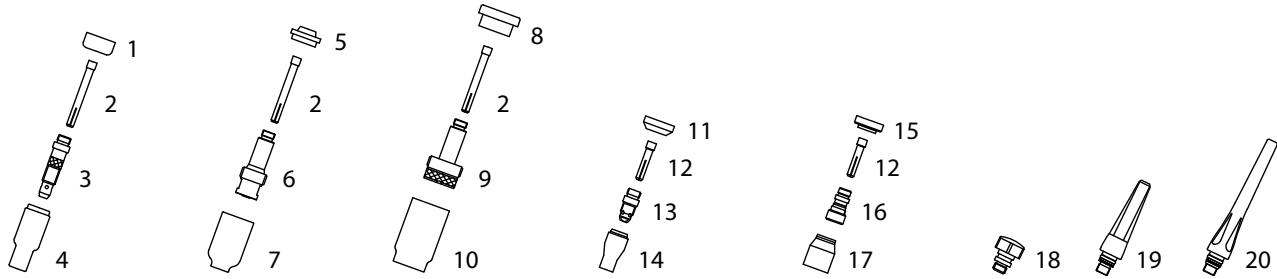
### Cable Covers

#WC-3-10 10 ft (3 m)  
#WC-3-22 22 ft (6.7 m)  
#WC-3-48 48 ft (14.6 m)



### Extension Kit

#EK-2-25-R 25 ft (7.6 m), Rubber



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	18CG	18CG		18CG		18CG		18CG
2 Collet	10N21	10N22		10N23		10N24		10N25
3 Collet Body	10N29	10N30		10N31		10N32		10N28
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
* Long Alumina	—	10N49L	10N48L	10N47L	—	—	—	—
* Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	—
* Long Lava	12N03	105Z60	12N02	105Z61	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
5 Insulator (required)	54N01	54N01		54N01		54N01		54N01
2 Collet	10N21	10N22		10N23		10N24		10N25
6 Gas Lens	45V29	45V24		45V25		45V26		45V27
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
7 Alumina Gas Lens	54N18	54N17	54N16	54N15	54N14	—	—	54N19
* Long Gas Lens	—	54N17L	54N16L	54N15L	54N14L	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
8 Insulator (required)	54N63	54N63		54N63		54N63		54N63
2 Collet	10N21	10N22		10N23		10N24		10N25
9 Large Diameter Gas Lens	45V0204	45V0204		45V116		45V64		995795
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	57N 75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Stubby Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
11 Insulator (required)	18CG20	18CG20		18CG20		18CG20		18CG20
12 Stubby Collet	—	10N22S		10N23S		10N24S		10N25S
13 Stubby Collet Body	17CB20	17CB20		17CB20		17CB20		17CB20
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
14 Stubby Alumina	13N08	13N09	13N10	13N11	13N12	13N13	—	—

### Stubby Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
15 Insulator (required)	17GLG20	17GLG20		17GLG20		17GLG20		17GLG20
12 Stubby Collet	—	10N22S		10N23S		10N24S		10N25S
16 Stubby Gas Lens	—	17GL040		17GL116		17GL332		17GL18
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
17 Alumina Gas Lens	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Back Caps

18 Short 57Y04	19 Medium 300M	20 Long 57Y02	18-7 Insulator Back Cap (not pictured)
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\*Not shown.

# TIG TORCHES

## Weldcraft® A-200 Series Formerly WP-26 Series

Hand-Held Air-Cooled  
Service Parts/Consumables



A-200  
(WP-26)

### Additional Torch Models



A-200 Flex  
(WP-26F)



A-200 Flex Valve  
(WP-26FV)



A-200 Valve  
(WP-26V)



A-200 Flex  
Redhead  
(WP-R26F)



A-200 Flex Valve  
Redhead  
(WP-R26FV)

Note: Torches delivered may vary slightly from images shown.

Models		1-Piece Power Cable Standard Rubber		2-Piece Power Cable Rubber
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	25 ft (7.6 m)
WP-26	A-200	WP-26-12-R	WP-26-25-R	WP-26-25-2
WP-26V	A-200 Valve	WP-26V-12-R	WP-26V-25-R	WP-26V-25-2
WP-26F	A-200 Flex	WP-26F-12-R	WP-26F-25-R	WP-26F-25-2
WP-26FV	A-200 Flex Valve	WP-26FV-12-R	WP-26FV-25-R	WP-26FV-25-2

V= Valve F=Flex FV=Flex Valve

Torch packages include torch body, handle, power cable, and long back cap.

### #AK3C Accessory Kit

Includes one short back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 8), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).



### Cable Covers

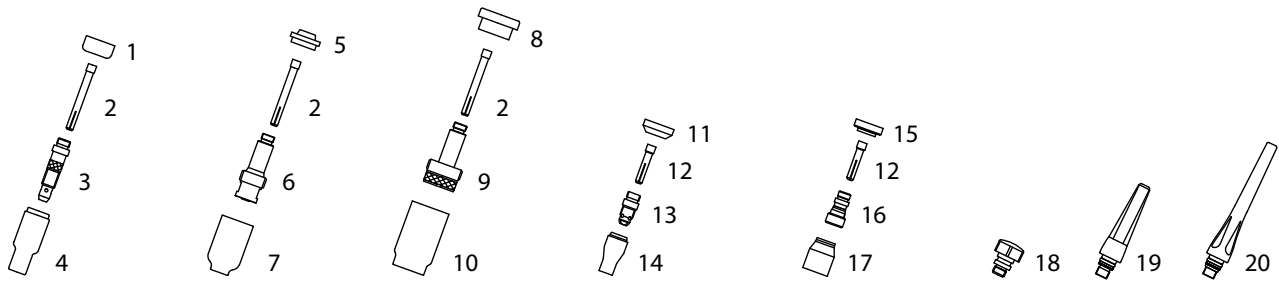
#WC-3-10 10 ft (3 m)

#WC-3-22 22 ft (6.7 m)

### Extension Kit

#EK325R 25 ft (7.6 m), Rubber

Torch Bodies		Valves	Handles	
A-200	WP-26	—	Ribbed	H-200R
A-200 Valve	WP-26V	VS-1	Knurled	H-200
Torch Bodies Optional				
A-200 Flex	WP-26F	—	Ribbed	10N15R
A-200 Flex Valve	WP-26FV	VS-1	Knurled	10N15
A-200 Redhead Flex	WP-R26F	—		
A-200 Redhead Flex Valve	WP-R26FV	VS-1		
Power Cables				
Rubber	1-Piece		2-Piece	
12.5 ft (3.8 m)	25 ft (7.6 m)		12.5 ft (3.8 m)	25 ft (7.6 m)
46V28R	46V30R		46V28-2	46V30-2
Replacement Gas Hose				
—	46V30R		45V05R	45V10R



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
1 Insulator (required)	18CG	18CG	18CG		18CG		18CG	18CG
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
3 Collet Body	10N29	10N30	10N31		10N32		10N28	406488
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
* Long Alumina	—	10N49L	10N48L	10N47L	—	—	—	—
* Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	—
* Long Lava	12N03	105Z60	12N02	105Z61	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
5 Insulator (required)	54N01	54N01	54N01		54N01		54N01	54N01
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
6 Gas Lens	45V29	45V24	45V25		45V26		45V27	45V28
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
7 Alumina Gas Lens	54N18	54N17	54N16	54N15	54N14	—	—	54N19
* Long Gas Lens	—	54N17L	54N16L	54N15L	54N14L	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
8 Insulator (required)	54N63	54N63	54N63		54N63		54N63	54N63
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
9 Large Diameter Gas Lens	45V0204	45V0204	45V116		45V64		995795	45V63
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Stubby Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	
11 Insulator (required)	18CG20	18CG20	18CG20		18CG20		18CG20	
12 Stubby Collet	—	10N22S	10N23S		10N24S		10N25S	
13 Stubby Collet Body	17CB20	17CB20	17CB20		17CB20		17CB20	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
14 Stubby Alumina	13N08	13N09	13N10	13N11	13N12	13N13	—	—

### Stubby Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	
15 Insulator (required)	17GLG20	17GLG20	17GLG20		17GLG20		17GLG20	
12 Stubby Collet	—	10N22S	10N23S		10N24S		10N25S	
16 Stubby Gas Lens	—	17GL040	17GL118		17GL332		17GL18	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
17 Alumina Gas Lens	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Back Caps

18 Short 57Y04	19 Medium 300M	20 Long 57Y02	18-7 Insulator Back Cap (not pictured)
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\*Not shown.

# TIG TORCHES

## Weldcraft® W-250 Series Formerly WP-20 Series

Hand-Held Water-Cooled  
Service Parts/Consumables



W-250  
(WP-20)

### Additional Torch Models



W-250 Valve  
(WP-20V)

Note: Torches delivered may vary slightly from images shown.

Models		Braided Rubber		Vinyl
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	25 ft (7.6 m)
WP-20	W-250	WP-20-12-R	WP-20-25-R	WP-20-25
WP-20V	W-250 Valve	—	—	WP-20V-25

V= Valve

Torch packages include torch body, handle, power cable, long back cap, gas hose and water hose.

### #AK4C Accessory Kit

Includes one long back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).



Torch Bodies		Valves	Handles	
W-250	WP-20	—	Knurled	53N06
W-250 Valve	WP-20V	VS-2	Ribbed	53N06R

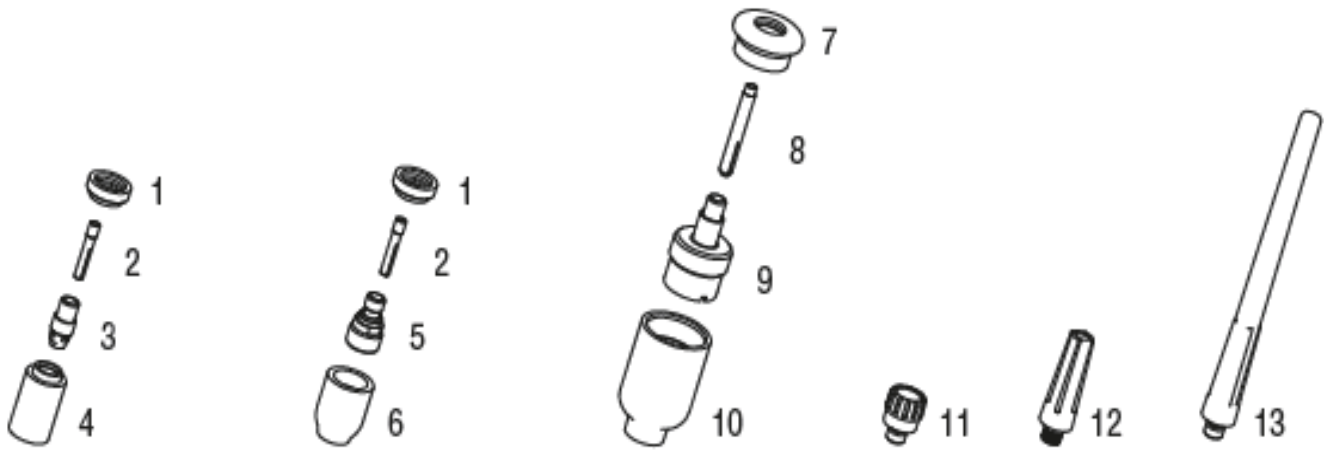
  

Power Cables				
	Vinyl		Braided	
	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
Power Cable (Red)	45V03HD	45V04HD	45V03RR	45V04RR
Water Hose (Blue)	45V07HD	45V08HD	45V07RBB	45V08RBB
Gas Hose (Black)	—	45V10HD	45V09R	45V10R



### Cable Covers

#WC-3-10 10 ft (3 m)  
#WC-3-22 22 ft (6.7 m)



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
3 Collet Body	13N25		13N26		13N27		13N28		13N29
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
5 Gas Lens	45V41		45V42		45V43		45V44		45V45
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
7 Insulator (required)	54N63-20		54N63-20		54N63-20		54N63-20		54N63-20
8 Collet	13N20L		13N21L		13N22L		13N23L		13N24L
9 Large Diameter Gas Lens	45V0204S		45V0204S		45V116S		45V64S		995795S
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short 41V33	12 Medium 41V35	13 Long 41V24
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\*Not shown.



# TIG TORCHES

## Weldcraft® W-280 Series

Hand-Held Water-Cooled  
Service Parts/Consumables

Formerly WP-280



W-280 Super Cool Torch Body  
(301251)

Models		Braided Rubber			Braided Rubber with 50 mm Dinse
Old Model	New Name	12.5 (3.8 m)	25 (7.6 m)	50 (15.2 m)	25 (7.6 m)
WP-280	W-280 Super Cool™	301251012	301251025	301251050	301251001*

Torch packages include torch body, handle, power cable, long back cap, gas hose and water hose.  
\*Cable cover included.

Hose Part #	Description
269766	Water Hose 14 ft (4.2m), Braided
269767	Water Hose 26.5 ft (8.0m), Braided
269769	Water Hose 51.5 ft (15.7m) Braided
269770	Gas Hose 13.25 ft (4.0m) Braided
269771	Gas Hose 25.75 ft (7.8m) Braided
269773	Gas Hose 50.0 ft (15.2m) Braided
269757	Power Cable, 12.5 ft (3.8m)
269758	Power Cable, 25.0 ft (7.6m)
269759	Power Cable, 50.0 ft (15.2m)

### #AK4C Accessory Kit

Includes one long back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).



### Cable Covers

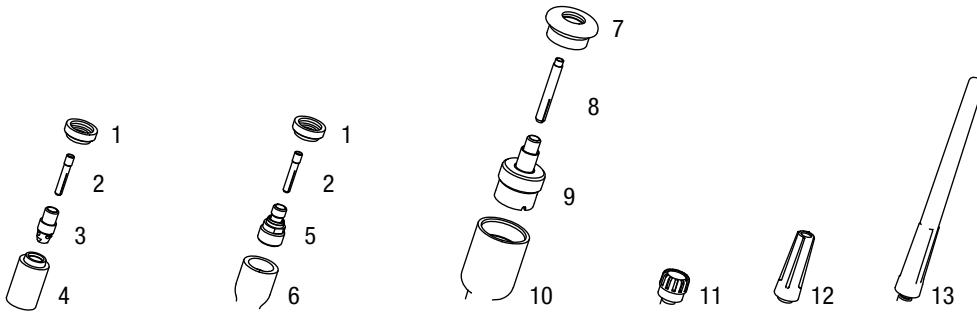
#WC0183 11.75 ft (3.6 m)  
for use with 301253012

#WC0182 24.25 ft (7.4 m)  
for use with 301253025  
and 301253001



### Extension Kit

#EK-1-25-R 25 ft (7.6 m), rubber



## Weldcraft® W-280 Consumables

### Non-Gas Lens

Electrode Size — inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)			3/32 (2.4)		1/8 (3.2)	
1 Insulator (required)	598882	598882	598882	598882	598882	598882	598882	598882	598882
2 Collet	13N20	13N21	13N22	13N22	13N22	13N23	13N23	13N24	13N24
3 Collet Body	13N25	13N26	13N27	13N27	13N27	13N28	13N28	13N29	13N29
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size — inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)			3/32 (2.4)		1/8 (3.2)	
1 Insulator (required)	598882	598882	598882	598882	598882	598882	598882	598882	
2 Collet	13N20	13N21	13N22	13N22	13N22	13N23	13N23	13N24	
5 Gas Lens	45V41	45V42	45V43	45V43	45V43	45V44	45V44	45V45	
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Electrode Size — inch (mm)

7 Insulator (required)	54N63-20	54N63-20	54N63-20	54N63-20	54N63-20	54N63-20	54N63-20	54N63-20	54N63-20
8 Collet	13N20L	13N21L	13N22L	13N22L	13N22L	13N23L	13N23L	13N24L	13N24L
9 Large Diameter Gas Lens	45V0204S	45V0204S	45V116S	45V116S	45V116S	45V64S	45V64S	995795S	995795S
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short 41V33      12 Medium 41V35      13 Long 41V24

\*Not shown.

# TIG TORCHES

## Weldcraft® W-310 Series **Hand-Held Water-Cooled** Formerly CS310 **Service Parts/Consumables**



W-310  
(CS310A)

Models		Braided Rubber		
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	50 ft (15.2 m)
CS310A	W-310	CS310-12	CS310-25	CS310-50

Torch packages include torch body, handle, power cable, long back cap, gas hose, water hose and cable cover.

Torch Bodies		Handles	
W-310	CS310A	D-Handle	CS110-H

Power Cables				
		Braided		
		12.5 ft (3.8m)	25 ft (7.6m)	50 ft (15.2m)
Power Cable	269764	269765	CS310-50PC	
Water Hose	CS310-12W	CS310-25W	CS310-50W	
Gas Hose	CS310-12G	CS310-25G	CS310-50G	

### #AK4C Accessory Kit

Includes one long back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).

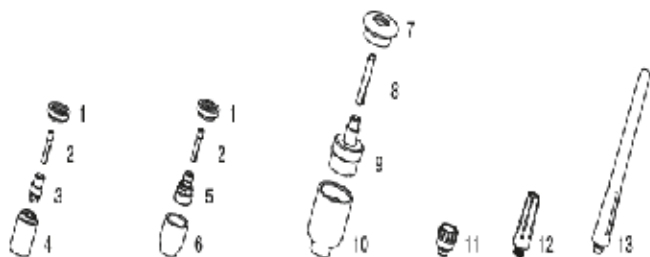


### Cable Covers

#WC-3-10 10 ft (3 m)  
#WC-3-22 22 ft (6.7 m)  
#WC-3-48 48 ft (14.6 m)

### Extension Kit

#EK-1-25-R 25 ft (7.6 m), Rubber



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
3 Collet Body	13N25		13N26		13N27		13N28		13N29
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
5 Gas Lens	45V41		45V42		45V43		45V44		45V45
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
7 Insulator (required)	54N63-20		54N63-20		54N63-20		54N63-20		54N63-20
8 Collet	13N20L		13N21L		13N22L		13N23L		13N24L
9 Large Diameter Gas Lens	45V0204S		45V0204S		45V116S		45V64S		995795S
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short CS110-BCS	12 Medium 41V35	13 Long 41V24
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\*Not shown.

# TIG TORCHES

## Weldcraft® W-350 Series

Hand-Held Water-Cooled  
Service Parts/Consumables

Formerly WP-18 Series



W-350  
(WP-18)

### Additional Torch Models



Note: Torches delivered may vary slightly from images shown.

Models		Rubber		Vinyl	
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
WP-18	W-350	WP-18-12-R	WP-18-25-R	WP-18-12	WP-18-25
WP-18V	W-350 Valve	—	WP-18V-25-R	—	WP-18V-25

V= Valve  
Torch packages include torch body, handle, power cable, long back cap, gas hose and water hose.

Torch Bodies		Valves	Handles	
W-350	WP-18	—	Ribbed	H-200R
W-350 Valve	WP-18V	VS-1	Knurled	H-200

Power Cables				
	Vinyl		Rubber (PC)	Braided (G&W)
	12.5 ft (3.8 m)	25 ft (7.6 m)	12.5 ft (3.8 m)	25 ft (7.6 m)
Power Cable	40V64	41V29	40V64R	41V29R
Water Hose	40V74	41V32	40V74R	41V32R
Gas Hose	40V75	41V30	40V75R18	41V30R18

### #AK3C Accessory Kit

Includes one short back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).

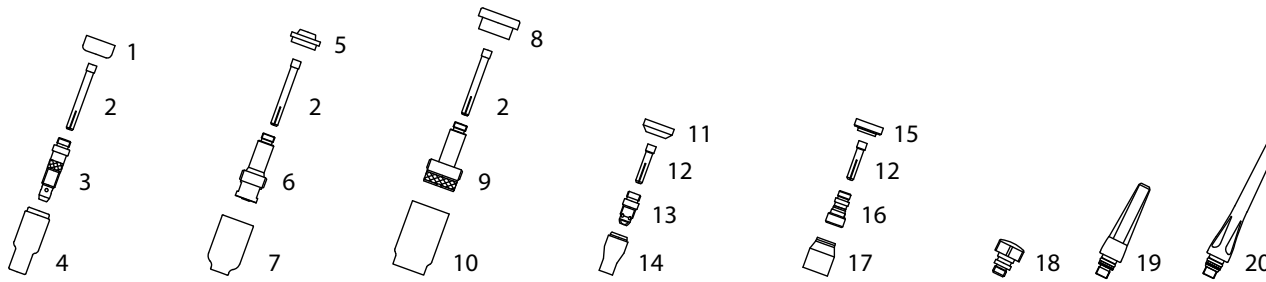


### Cable Covers

#WC-3-10 10 ft (3 m)  
#WC-3-22 22 ft (6.7 m)

### Extension Kit

#EK-1-25-R 25 ft (7.6 m), Rubber



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
1 Insulator (required)	18CG	18CG		18CG		18CG		18CG	18CG
2 Collet	10N21	10N22		10N23		10N24		10N25	54N20
3 Collet Body	10N29	10N30		10N31		10N32		10N28	406488
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	10N50	10N49		10N48	10N47	10N46	10N45	10N44	—
* Long Alumina	—	10N49L		10N48L	10N47L	—	—	—	—
* Lava	105Z43	105Z42		105Z44	105Z45	08N78	08N79	08N80	—
* Long Lava	12N03	105Z60		12N02	105Z61	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
5 Insulator (required)	54N01	54N01		54N01		54N01		54N01	54N01
2 Collet	10N21	10N22		10N23		10N24		10N25	54N20
6 Gas Lens	45V29	45V24		45V25		45V26		45V27	45V28
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
7 Alumina Gas Lens	54N18	54N17		54N16	54N15	54N14	—	—	54N19
* Long Gas Lens	—	54N17L		54N16L	54N15L	54N14L	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
8 Insulator (required)	54N63	54N63		54N63		54N63		54N63	54N63
2 Collet	10N21	10N22		10N23		10N24		10N25	54N20
9 Large Diameter Gas Lens	45V0204	45V0204		45V116		45V64		995795	45V63
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—		57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—		57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—		57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—		57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Stubby Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
11 Insulator (required)	18CG20	18CG20		18CG20		18CG20		18CG20
12 Stubby Collet	—	10N22S		10N23S		10N24S		10N25S
13 Stubby Body Collet	17CB20	17CB20		17CB20		17CB20		17CB20
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)
14 Stubby Alumina	13N08	13N09		13N10	13N11	13N12	13N13	—

### Stubby Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
15 Insulator (required)	17GLG20	17GLG20		17GLG20		17GLG20		17GLG20
12 Stubby Collet	—	10N22S		10N23S		10N24S		10N25S
16 Stubby Gas Lens	—	17GL040		17GL118		17GL332		17GL18
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)
17 Alumina Gas Lens	53N58	53N59		53N60	53N61	53N61S	—	—

### Back Caps

18 Short 57Y04	19 Medium 300M	20 Long 57Y02
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\*Not shown.



# TIG TORCHES

## Weldcraft® W-375 Series

Hand-Held Water-Cooled  
Service Parts/Consumables



W-375 Super Cool Torch Body  
(301253)  
**269335**  
Handle

	Braided Rubber		Braided Rubber with 50 mm Dinse
<b>New Name</b>	<b>12.5 (3.8 m)</b>	<b>25 (7.6 m)</b>	<b>25 (7.6 m)</b>
W-375 Super Cool™	301253012	301253025	301253001*

Torch packages include torch body, handle, power cable, long back cap, gas hose, water hose and cable cover.  
\*Cable cover included.

Hose Part #	Description
269766	Water Hose 14 ft (4.2m), Braided
269767	Water Hose 26.5 ft (8.0m), Braided
269770	Gas Hose 13.25 ft (4.0m) Braided
269771	Gas Hose 25.75 ft (7.8m) Braided
269764	Power Cable, 12.5 ft (3.8m)
269765	Power Cable, 25.0 ft (7.6m)

### #AK4C Accessory Kit

Includes one long back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).

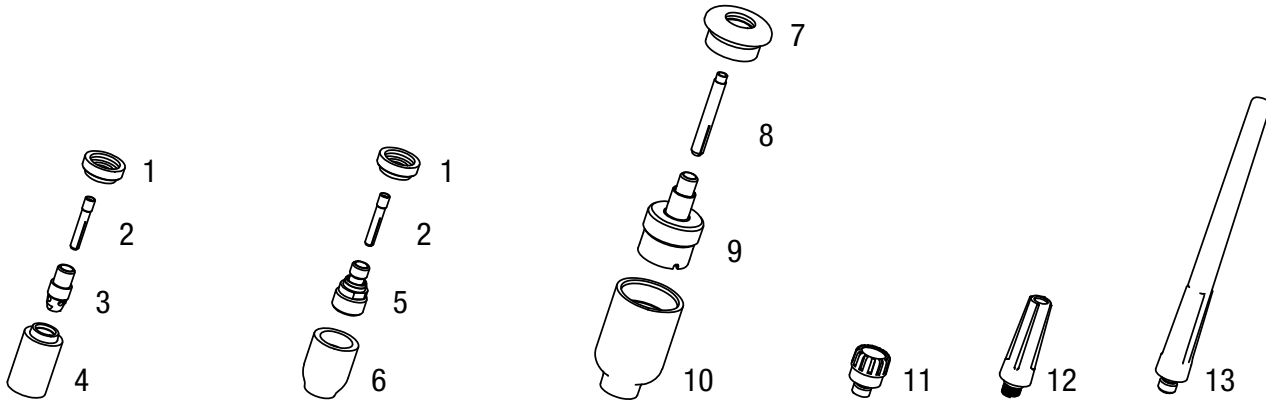


#WC0183 11.75 ft (3.6 m)  
for use with 301253012

#WC0182 24.25 ft (7.4 m)  
for use with 301253025  
and 301253001

**Extension Kit**  
#EK-1-25-R 25 ft (7.6 m), rubber





### Non-Gas Lens

Electrode Size — inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)			3/32 (2.4)		1/8 (3.2)	
1 Insulator (required)	598882	598882	598882			598882		598882	
2 Collet	13N20	13N21	13N22			13N23		13N24	
3 Collet Body	13N25	13N26	13N27			13N28		13N29	
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size — inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)			3/32 (2.4)		1/8 (3.2)	
1 Insulator (required)	598882	598882	598882			598882		598882	
2 Collet	13N20	13N21	13N22			13N23		13N24	
5 Gas Lens	45V41	45V42	45V43			45V44		45V45	
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Electrode Size — inch (mm)

7 Insulator (required)	54N63-20	54N63-20	54N63-20			54N63-20		54N63-20	
8 Collet	13N20L	13N21L	13N22L			13N23L		13N24L	
9 Large Diameter Gas Lens	45V0204S	45V0204S	45V116S			45V64S		995795S	
Nozzle Size — size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short 41V33    12 Medium 41V35    13 Long 41V24

*\*Not shown.*

# TIG TORCHES

## Weldcraft® W-410 Series

Hand-Held Water-Cooled  
Service Parts/Consumables

Formerly CS410



W-410  
(CS410A)

Models		Braided Rubber
Old Model	New Name	25 ft (7.6 m)
CS410A	W-410	CS410-25
		Soft CS410-50

Torch packages include torch body, handle, power cable, long back cap, gas hose, water hose and cable cover.

Torch Bodies		Handles	
W-410	CS410A	D-Handle	CS210-H

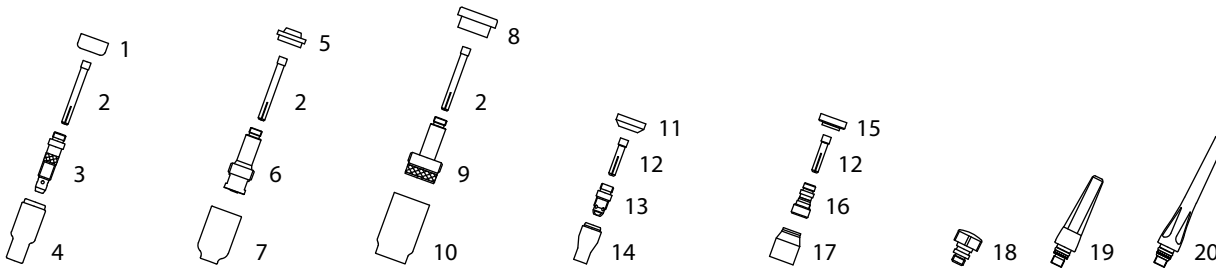
Power Cables		
	Braided	
	12.5 ft (3.8 m)	25 ft (7.6 m)
Power Cable	CS410-12PC	CS410-25PC
		CS410-50PC
Water Hose	CS310-12W	CS310-25W
		CS410-50W
Gas Hose	CS410-12G	CS410-25G
		CS410-50G

### #AK4C Accessory Kit

Includes one long back cap, three collets (one collet per size: 1/16, 3/32, 1/8), three collet bodies (one collet body per size: 1/16, 3/32, 1/8), three alumina nozzles (one nozzle per size: 5, 6, 7), and three 7-inch 2% ceriated tungsten electrodes (one electrode per size: 1/16, 3/32, 1/8).



Cable Covers  
#WC-4-10 and #WC-4-22 22 ft (6.7 m)



## Consumables

### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)		5/32 (4.0)	
1 Insulator (required)	18CG		18CG		18CG		18CG		18CG		18CG	
2 Collet	10N21		10N22		10N23		10N24		10N25		54N20	
3 Collet Body	10N29		10N30		10N31		10N32		10N28		406488	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short			
4 Alumina	10N50	10N49		10N48	10N47	10N46	10N45	10N44	—			
* Long Alumina	—		10N49L		10N48L	10N47L	—		—			
* Lava	105Z43		105Z42		105Z44	105Z45	08N78	08N79	08N80	—		
* Long Lava	12N03		105Z60		12N02	105Z61	—		—			

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)		5/32 (4.0)	
5 Insulator (required)	54N01		54N01		54N01		54N01		54N01		54N01	
2 Collet	10N21		10N22		10N23		10N24		10N25		54N20	
6 Gas Lens	45V29		45V24		45V25		45V26		45V27		45V28	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short			
7 Alumina Gas Lens	54N18	54N17		54N16	54N15	54N14	—		54N19			
* Long Gas Lens	—		54N17L		54N16L	54N15L	54N14L		—			

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)		5/32 (4.0)	
8 Insulator (required)	54N63		54N63		54N63		54N63		54N63		54N63	
2 Collet	10N21		10N22		10N23		10N24		10N25		54N20	
9 Large Diameter Gas Lens	45V0204		45V0204		45V116		45V64		995795		45V63	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short			
10 Large Dia. Gas Lens	—		—		57N75	—		57N74	53N88	53N87	53N89	
* Large Dia. Gas Lens-L	—		—		57N75L	—		57N74L	53N88L	53N87L	—	
* Large Dia. Gas Lens-XL	—		—		57N75XL	—		57N74XL	53N88XL	53N87XL	—	
* Large Dia. Gas Lens-XXL	—		—		57N75XXL	—		57N74XXL	53N88XXL	53N87XXL	—	

### Stubby Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)			
11 Insulator (required)	18CG20		18CG20		18CG20		18CG20		18CG20		18CG20	
12 Stubby Collet	—		10N22S		10N23S		10N24S		10N25S		—	
13 Stubby Body Collet	17CB20		17CB20		17CB20		17CB20		17CB20		17CB20	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short			
14 Stubby Alumina	13N08	13N09		13N10	13N11	13N12	13N13	—		—		

### Stubby Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)			
15 Insulator (required)	17GLG20		17GLG20		17GLG20		17GLG20		17GLG20		17GLG20	
12 Stubby Collet	—		10N22S		10N23S		10N24S		10N25S		—	
16 Stubby Gas Lens	—		17GL040		17GL116		17GL332		17GL18		—	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)		6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short			
17 Alumina Gas Lens	53N58	53N59		53N60	53N61	53N61S	—		—			

### Back Caps

18 Short 57Y04	19 Medium 300M	20 Long 57Y02
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\*Not shown.

# TIG TORCHES

## Weldcraft® Modular Series

### Hand-Held TIG Service Parts/Consumables

**Type**

Water-Cooled

**Rated Output**

DC: 225 A, AC: 160 A

**Duty Cycle**

100%

**Electrode Range**

.020-5/32 in (0.5-4.0 mm)



W-225 Modular  
(WP-225)

Models		Braided Rubber		Vinyl	Textured Handle
Old Model	New Name	12.5 ft (3.8 m)	25 ft (7.6 m)	25 ft (7.6 m)	—
WP-225	W-225 Modular	WP-225-12-R	WP-225-25-R	WP-225-25	53N06

Torch packages include torch body, handle, power cable, gas hose, water hose and 1726 and 9-70 torch heads.



Torch Head	Angle	Electrode Range	A-150 Modular* Amp Rating		A-200 Modular* Amp Rating		W-225 Modular** Amp Rating	
			DC	AC	DC	AC	DC	AC
24	70°	.020-3/32 in. (0.5-2.4 mm)	80	50	80	50	160	115
24-90	90°	.020-3/32 in. (0.5-2.4 mm)	80	50	80	50	160	115
9-70	70°	.020-1/8 in. (0.5-3.2 mm)	125	100	125	100	200	140
9-90	90°	.020-1/8 in. (0.5-3.2 mm)	125	100	125	100	200	140
9P	180°	.020-1/8 in. (0.5-3.2 mm)	125	100	125	100	200	140
1726	70°	.020-5/32 in. (0.5-4.0 mm)	150	115	200	140	225	160
1726P	180°	.020-5/32 in. (0.5-4.0 mm)	150	115	200	140	225	160



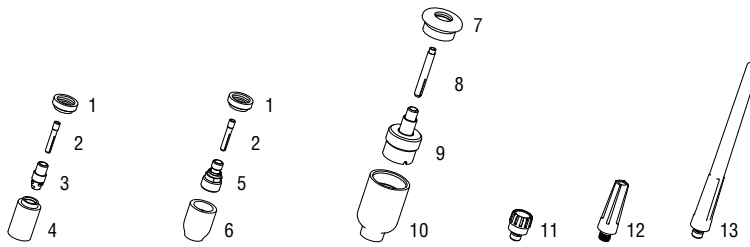
**#AK-225MFC Accessory Kit**  
Supplements W-225 (WP-225) modular torch packages. Includes 5 additional torch heads, collet, collet bodies, nozzles, handle and more.



**Cable Covers**  
#WC-3-10 10 ft (3 m)  
#WC-3-22 22 ft (6.7 m)



## 9-70, 9-90 and 9P Modular Series Consumables



### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
3 Collet Body	13N25		13N26		13N27		13N28		13N29
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
* Lava	—	13N14	13N15	13N16	13N17	13N18	13N19	—	—
* Long Lava	796F70	796F71	796F72	796F73	—	—	—	—	—
* X-Long Lava	796F74	796F75	796F76	796F77	—	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
1 Insulator (required)	598882		598882		598882		598882		598882
2 Collet	13N20		13N21		13N22		13N23		13N24
5 Gas Lens	45V41		45V42		45V43		45V44		45V45
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
6 Alumina Gas Lens	—	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Large Diameter Gas Lens

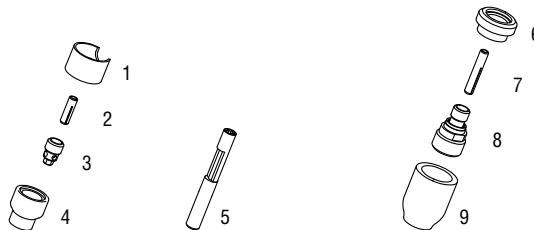
Electrode Size - inch (mm)	.020 (0.5)		.040 (1.0)		1/16 (1.6)		3/32 (2.4)		1/8 (3.2)
7 Insulator (required)	54N63-20		54N63-20		54N63-20		54N63-20		54N63-20
8 Collet	13N20L		13N21L		13N22L		13N23L		13N24L
9 Large Diameter Gas Lens	45V0204S		45V0204S		45V116S		45V64S		995795S
Nozzle Size - size # (inch)	3 (3/16)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	—	57N75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Back Caps

11 Short 41V33	12 Medium 41V35	13 Long 41V24
----------------	-----------------	---------------

\*Not shown.

## 24 and 24-90 Torch Head Modular Series Consumables



### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)	3/32 (2.4)
1 Insulator (required)	53N22	53N22	53N22	53N22
2 Collet	53N15	53N16	53N14	24C332
3 Collet Body	53N17	53N18	53N19	24CB332
Nozzle Size - size # (inch)	.165	4 (1/4)	5 (5/16)	6 (3/8)
4 Alumina	—	A53N24	A53N25	A53N27
* Lava	53N23	53N24	53N25	53N27
* Long Lava	—	53N28	—	53N26

### Collet Body Wrench

5 53N20

### Gas Lens

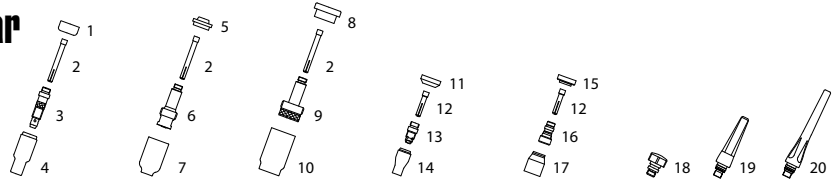
Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)	3/32 (2.4)
6 Insulator (required)	53N66	53N66	53N66	53N66
7 Collet	53N62	53N63	53N64	24GLC332
8 Gas Lens	45V41	45V42	45V43	45V44
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)
9 Alumina Gas Lens	53N58	53N59	53N60	53N61
53N61S	—	—	—	—

\*Not shown.



# TIG TORCHES

## 1726 and 1726P Torch Head Modular Series Consumables



### Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
1 Insulator (required)	18CG	18CG	18CG		18CG		18CG	18CG
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
3 Collet Body	10N29	10N30	10N31		10N32		10N28	406488
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
4 Alumina	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
* Long Alumina	—	10N49L	10N48L	10N47L	—	—	—	—
* Lava	105Z43	105Z42	105Z44	105Z45	08N78	08N79	08N80	—
* Long Lava	12N03	105Z60	12N02	105Z61	—	—	—	—

### Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
5 Insulator (required)	54N01	54N01	54N01		54N01		54N01	54N01
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
6 Gas Lens	45V29	45V24	45V25		45V26		45V27	45V28
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
7 Alumina Gas Lens	54N18	54N17	54N16	54N15	54N14	—	—	54N19
* Long Gas Lens	—	54N17L	54N16L	54N15	54N14L	—	—	—

### Large Diameter Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	5/32 (4.0)
8 Insulator (required)	54N63	54N63	54N63		54N63		54N63	54N63
2 Collet	10N21	10N22	10N23		10N24		10N25	54N20
9 Large Diameter Gas Lens	45V0204	45V0204	45V116		45V64		995795	45V63
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
10 Large Dia. Gas Lens	—	—	57N 75	—	57N74	53N88	53N87	53N89
* Large Dia. Gas Lens-L	—	—	57N75L	—	57N74L	53N88L	53N87L	—
* Large Dia. Gas Lens-XL	—	—	57N75XL	—	57N74XL	53N88XL	53N87XL	—
* Large Dia. Gas Lens-XXL	—	—	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—

### Stubby Non-Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	
11 Insulator (required)	18CG20	18CG20	18CG20		18CG20		18CG20	
12 Stubby Collet	—	10N22S	10N23S		10N24S		10N25S	
13 Stubby Body Collet	17CB20	17CB20	17CB20		17CB20		17CB20	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
14 Stubby Alumina	13N08	13N09	13N10	13N11	13N12	13N13	—	—

### Stubby Gas Lens

Electrode Size - inch (mm)	.020 (0.5)	.040 (1.0)	1/16 (1.6)		3/32 (2.4)		1/8 (3.2)	
15 Insulator (required)	17GLG20	17GLG20	17GLG20		17GLG20		17GLG20	
12 Stubby Collet	—	10N22S	10N23S		10N24S		10N25S	
16 Stubby Gas Lens	—	17GL040	17GL118		17GL332		17GL18	
Nozzle Size - size # (inch)	4 (1/4)	5 (5/16)	6 (3/8)	7 (7/16)	8 (1/2)	10 (5/8)	12 (3/4)	Short
17 Alumina Gas Lens	53N58	53N59	53N60	53N61	53N61S	—	—	—

### Back Caps

18 Short 57Y04	19 Medium 300M	20 Long 57Y02
----------------	----------------	---------------

\*Not shown.

## ITW Dykem® Paint Markers

Dykem® Brite-Mark® is a general purpose permanent marker ideal for making clear, bold markings on almost any surface (i.e. metal, rubber, plastic, glass, concrete, leather, stone, wood, vinyl, and more). Its quick drying, oil-based paint withstands indoor and outdoor conditions without fading, chipping, or losing its opacity. Dykem Brite-Mark can be used to permanently identify inventory, assemblies, tools, finished products, or work-in-progress while resisting most work related abuses or compounds.

Part #	Tip	Description	Package Quantity
84001	Fiber/Bullet	12.0 cc Blue, Dykem® Brite-Mark®	12
84002	Fiber/Bullet	12.0 cc Black, Dykem® Brite-Mark®	12
84003	Fiber/Bullet	12.0 cc White, Dykem® Brite-Mark®	12
84004	Fiber/Bullet	12.0 cc Yellow, Dykem® Brite-Mark®	12
84005	Fiber/Bullet	12.0 cc Orange, Dykem® Brite-Mark®	12
84006	Fiber/Bullet	12.0 cc Red, Dykem® Brite-Mark®	12
84007	Fiber/Bullet	12.0 cc Green, Dykem® Brite-Mark®	12

Dykem® TexPen® is one of the most rugged markers you'll ever use. It can easily write through oil, grease, and even underwater. The Dykem TexPen features a stainless-steel ball tip so you'll never have to worry about the tip wearing out before the paint is gone, even if you're writing on rough concrete or rusty metal. The thick, bold paint markings withstand extreme weather conditions without losing legibility or brightness.



Brite-Mark® (Fiber/Bullet)



TexPen®  
(#3, Medium)

For products not listed in this catalog, please call ITW DYKEM® at 1-800-443-9536.

## Paint Original Equipment Color Matched

Part #	Description
098205	12 oz. Spray Can, (new) Miller Blue Enamel

From showroom touch-ups to complete machine repaints, depend on Miller O.E.M. color-matched paints to give you and your customers professional results. Available in air-dry aerosols.



## SCRUBS®

Part #	Dimensions	Quantity	Case Quantity
202239	10-1/2 x 12-1/4 in	72 towel canister	6 canisters per case

They're the original patented one-step hand cleaner towels in-a-bucket. SCRUBS® combine the scrubbing power of pumice with powerful yet safe cleaning agents into an absorbent, non-scratching abrasive hand-cleaning towel. Fast and easy, no rinsing, no drying, leaves hands clean and protected, germ-free with a pleasant fragrance and no residue.



202239

## Welpers®

Part #	Size	Description	Part #	Size	Description
YS50	8-1/2 in	Original full size model	YS20 (N/A)	7 in	Mini-welper

The original patented multipurpose MIG tool that does it all. Welpers® perform eight different tasks saving time and increasing productivity! It's a must have tool for every welder, now available in the smaller more convenient YS20 version, ideal for the growing population of light-duty 150 amp and below MIG welding guns.



YS50

# SERVICE PARTS

## 4-Pin Amp Plastic Connectors



- |   |   |  |
|---|---|--|
| <b>048283</b> Kit (consists of)<br><b>081905</b> Receptacle<br><b>079535</b> Pins (Qty 5) | <b>048284</b> Kit (consists of)<br><b>081906</b> Connector<br><b>079534</b> Sockets (Qty 5) | <b>046958</b> Kit (consists of)<br><b>046080</b> Connector<br><b>079535</b> Pins (Qty 5) |
|---|---|--|

Note: Strain relief clamp **079531** needs to be ordered separately with cord-mounted connections.



- |  |  |   |
|--|--|---|
| <b>048282</b> Kit (consists of)<br><b>081560</b> Receptacle<br><b>079534</b> Sockets (Qty 5) | <b>079878</b> Kit (consists of)<br><b>079532</b> Connector<br><b>079535</b> Pins (Qty 5) | <b>080328</b> Kit (consists of)<br><b>079533</b> Connector<br><b>079534</b> Sockets (Qty 5) |
|--|--|---|

Note: Strain relief clamp **079531** needs to be ordered separately with cord-mounted connections.

## 4-Pin Amphenol Metal Connectors



- |                        |               |                        |
|------------------------|---------------|------------------------|
| <b>076624</b><br>(N/A) | <b>073686</b> | <b>073688</b><br>(N/A) |
|------------------------|---------------|------------------------|

Note: Pins are the solderable type and are pre-inserted into the receptacle  
Strain relief clamp **039828** needs to be ordered separately w/cord-mounted connections

## 5-Pin Amphenol Metal Connectors



- |               |               |               |
|---------------|---------------|---------------|
| <b>035523</b> | <b>039273</b> | <b>052654</b> |
|---------------|---------------|---------------|

Note: Pins are the solderable type and are pre-inserted into the receptacle.  
Strain relief clamp **039685** needs to be ordered separately w/cord-mounted connections.

## 6-Pin Amphenol Metal Connectors



- |               |                     |  |
|---------------|---------------------|--|
| <b>039825</b> | <b>039827</b> (N/A) |  |
|---------------|---------------------|--|

Note: Pins are the solderable type and are pre-inserted into the receptacle.  
Strain relief clamp **039828** needs to be ordered separately w/cord-mounted connections.



- |               |               |  |
|---------------|---------------|--|
| <b>235429</b> | <b>217796</b> |  |
|---------------|---------------|--|

Note: For Maxstar 140 and 150's.

## 9-Pin Amp Plastic Connectors



- |  |  |   |
|--|--|---|
| <b>170646</b> Receptacle (N/A)<br><b>079535</b> Pins (Qty 5) | <b>048380</b> Kit (consists of)<br><b>079705</b> Connector<br><b>079534</b> Sockets (Qty 10) | <b>048306</b> Kit (consists of)<br><b>079707</b> Connector<br><b>079535</b> Pins (Qty 10) |
|--|--|---|

Note: Strain relief clamp **079706** needs to be ordered separately with cord-mounted connections.

## 10-Pin Amphenol Metal Connectors



- |               |               |                     |
|---------------|---------------|---------------------|
| <b>039718</b> | <b>039716</b> | <b>091380</b> (N/A) |
|---------------|---------------|---------------------|

Note: Pins are the solderable type and are pre-inserted into the receptacle.  
Strain relief clamp **#073 332** needs to be ordered separately w/cord-mounted connections.



- |               |               |               |
|---------------|---------------|---------------|
| <b>139268</b> | <b>146212</b> | <b>146213</b> |
|---------------|---------------|---------------|

Note: Pins are the solderable type and are pre-inserted into the receptacle.  
Strain relief clamp **073332** needs to be ordered separately w/cord-mounted connections.

## 10-Pin Amp Plastic Connectors



- |   |  |  |
|---|--|--|
| <b>221777</b> Kit (consists of)<br><b>189238</b> Receptacle<br><b>134733</b> (N/A) Sockets (Qty 10) | <b>217292</b> Kit (consists of)<br><b>190294</b> Connector<br><b>134731</b> Pins (Qty 10)<br><b>134732</b> Pins (Qty 10)<br><b>079739</b> Clamp<br><b>143922</b> Clamp | <b>222857</b> Kit (consists of)<br><b>207194</b> Connector<br><b>079534</b> Sockets (Qty 10)<br><b>141685</b> Sockets (Qty 10)<br><b>079739</b> Clamp<br><b>143922</b> Clamp |
|---|--|--|

## 14-Pin Amphenol Plastic Connectors (Size 20)



- |   |  |  |
|---|--|--|
| <b>143976</b> Kit (consists of)<br><b>134735</b> Receptacle<br><b>079534</b> Sockets (Qty 15) | <b>141162</b> Kit (14-18 ga wire)<br><b>134734</b> Connector<br><b>134 731</b> Pins (Qty 15)<br><b>079739</b> Clamp<br><b>143922</b> Clamp | <b>152369</b> Kit (consists of)<br><b>143424</b> Connector<br><b>079534</b> Sockets (Qty 15)<br><b>079739</b> Clamp<br><b>143922</b> Clamp |
| <b>143976</b> Kit (consists of)<br><b>134735</b> Receptacle<br><b>079534</b> Sockets (Qty 15) | <b>144310</b> Kit (20-24 ga wire)<br><b>134734</b> Connector<br><b>134732</b> Pins (Qty 15)<br><b>079739</b> Clamp<br><b>143922</b> Clamp  | <b>152568</b> Kit (consists of)<br><b>143424</b> Connector<br><b>141685</b> Sockets (Qty 15)<br><b>079739</b> Clamp<br><b>143922</b> Clamp |

## 14-Pin Amphenol Plastic Connectors (Size 17)



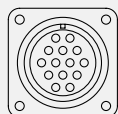
- |   |   |  |
|---|---|--|
| <b>047637</b> Kit (consists of)<br><b>048286</b> Receptacle<br><b>079534</b> Sockets (Qty 15) | <b>047636</b> Kit (consists of)<br><b>048287</b> Connector<br><b>079535</b> Pins (Qty 15) | <b>071892</b> Kit (consists of)<br><b>045349</b> Connector<br><b>079534</b> Sockets (Qty 15) |
|---|---|--|

Note: Strain relief clamp **079739** needs to be ordered separately with cord-mounted connections.



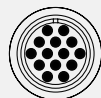
## 14-Pin Amphenol Metal Connectors

**Panel-Mounted Female**



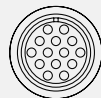
086022 Receptacle

**Cord-Mounted Male**



136961 Kit (consists of)  
094481 Connector  
116964 Clamp

**Cord-Mounted Female**

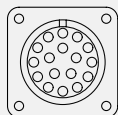


136960 Kit (consists of)  
137301 Connector  
116964 Clamp

Note: Pins are the solderable type and are pre-inserted into the receptacle.

## 17-Pin Amphenol Metal Connectors

**Panel-Mounted Female**

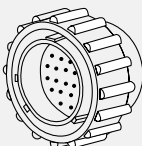


097869 (N/A)

Note: Pins are the solderable type and are pre-inserted into the receptacle. Strain relief clamp 073296 needs to be ordered separately w/cord-mounted connections.

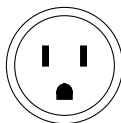
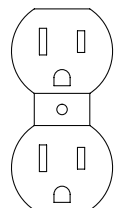
## 28-Pin Amphenol Plastic Connector (Size-17)

**Panel-Mounted Female**  
218715

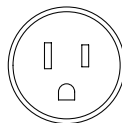


## Connector Bodies, Plugs and Receptacles

15A, 125V  
**Panel-Mounted Female**  
604176



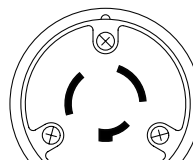
15A, 125V  
**Cord-Mounted Male**  
073690



15A, 125V  
**Cord-Mounted Female**  
124150



15A, 125V  
**Panel-Mounted Female**  
032897

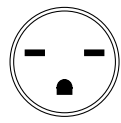
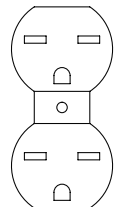


20A, 125V  
**Cord-Mounted Male**  
605797

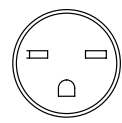


20A, 125V  
**Cord-Mounted Female**  
080280 (N/A)

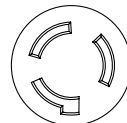
15A, 250V  
**Panel-Mounted Female**  
604103 (N/A)



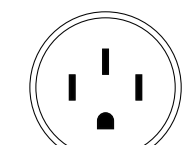
15A, 250V  
**Cord-Mounted Male**  
025234 (N/A)



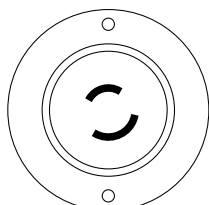
**Cord-Mounted Female**  
603029 (N/A)



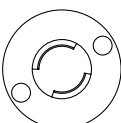
20A, 250V  
**Panel-Mounted Female**  
039607



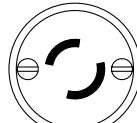
50A, 125/250V  
**Cord-Mounted Male**  
119172



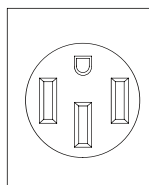
20A, 250V  
**Panel-Mounted Male**  
141840



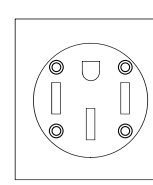
20A, 250V  
**Cord-Mounted Female**  
039635



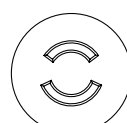
20A, 250V  
**Cord-Mounted Male**  
039618



50A, 125/250V  
**Flanged-Mounted Female**  
164704  
117512 (N/A)



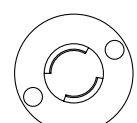
50A, 125/250V  
**Panel-Mounted Female**  
182954



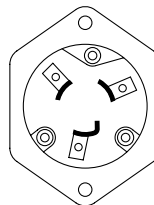
20A, 250V  
**Panel-Mounted Female**  
039602



20A, 250V  
**Cord-Mounted Male**  
039618



20A, 250V  
**Cord-Mounted Female**  
039635



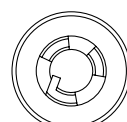
15A  
**Panel-Mounted Male**  
056665 (N/A)



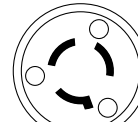
15A, 277V  
**Cord-Mounted Male**  
039687 (N/A)



15A, 277V  
**Cord-Mounted Female**  
056442



15A, 277V  
**Panel-Mounted Female**  
039686



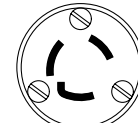
15A, 250V  
**Cord-Mounted Male**  
035494



**Cord-Mounted Female**  
035492 (N/A)



**Panel-Mounted Female**  
035493 (N/A)



15A, 125V  
**Cord-Mounted Male**  
032898



**Cord-Mounted Female**  
035243 (N/A)

## Cable Connectors

### Cam-Lok Twistlock Receptacles/Connectors

Item #	Part #	Description	Color	Cable Capacity
		<b>Receptacles</b>		
1	<b>039628</b>	Receptacle, Insul. (Female)	Black	No. 2/0 – 3/0 (25 – 70 mm)
	<b>039638</b>	Receptacle, Insul. (Female)	Black	No. 3/0 – 4/0 (70 – 95 mm)
2	<b>056271</b>	Receptacle, Uninsul. (Male)	Black	—
		<b>Connectors</b>		
3	<b>039633<sup>1</sup></b>	Connector, Insul. Set Scr. (In-Line Female)	Red	No. 1/0 – 3/0 (50 – 70 mm)
4	<b>039629</b>	Connector, Insul. Set Scr. (Male)	Red	No. 2 – 1/0 (35 – 50 mm)
	<b>039630</b>	Connector, Insul. Set Scr. (Male)	Red	No. 1/0 – 3/0 (50 – 70 mm)
	<b>039639</b>	Connector, Insul. Set Scr. (Male)	Red	No. 3/0 – 4/0 (70 – 95 mm)

<sup>1</sup>For In-Line Connections, use with **039629** or **039630**.

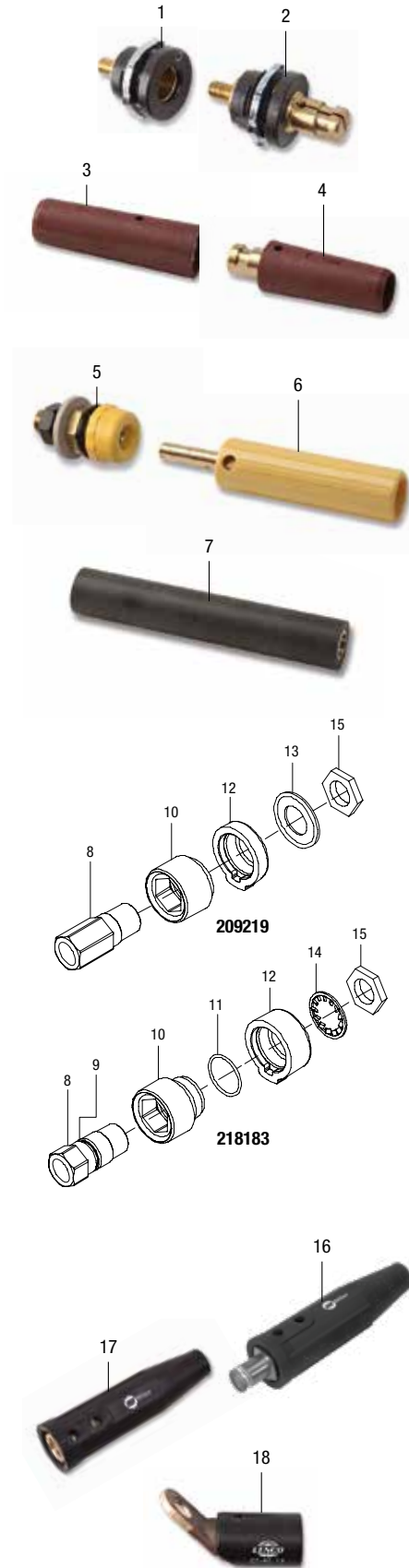
### Miller Receptacles/Connectors

Item #	Part #	Description	Color	Cable Capacity
		<b>Receptacles</b>		
5	<b>039801</b>	Receptacle, Insulated (Female)	Black	—
	<b>039800</b>	Receptacle, Insulated (Female)	Red	—
	<b>057608</b>	Receptacle, Insulated (Female)	Yellow	—
		<b>Plugs</b>		
6	<b>039901</b>	Plug, Insulated (Male)	Black	No. 1 – 4
	<b>039608</b>	Plug, Insulated (Male)	Red	No. 1 – 4
	<b>039878</b>	Plug, Insulated (Male)	Yellow	No. 1 – 4
		<b>Connectors</b>		
7	<b>039611<sup>2</sup></b>	Connector, Insulated (Female)	Black	No. 1 – 4

<sup>2</sup>For In-Line Connections (Quick-Connect).

### Tweco-Style Twistlock Receptacles/Connectors

Item #	Part #	Part #	Description
			<b>Receptacles</b>
	<b>209219</b>	<b>218183</b>	Receptacle Assembly (Female)
8	<b>208431</b>	<b>209473</b>	Receptacle, Brass (Female)
9	—	<b>186228</b>	O-Ring, 0.739 ID x 0.070 H
10	—	<b>185712</b>	Insulator, bulkhead front
11	—	<b>185718</b>	O-Ring, 0.989 ID x 0.070 H
12	—	<b>185713</b>	Insulator, bulkhead rear
13	<b>229338</b>	—	Washer, domed load .812 ID x 1.450 OD x .070 THK
14	—	<b>185714</b>	Tooth washer, 1 mm intern
15	<b>185717</b>	<b>185717</b>	Nut, M20-1.5 1.00 Hex .19 H BRS locking
			<b>Connectors</b>
16	<b>191981</b>	<b>191981</b>	Connector, Insulated (Male), No. 4 – 1/0 - 2/0 (25 – 50 mm)
17	<b>218677</b>	<b>218677</b>	Connector, Insulated (Female), No. 4 – 1/0 - 2/0 (25 – 50 mm)
			<b>Adapters</b>
18	<b>218678</b>	<b>218678</b>	Adapter, Threaded Stud to Tweco (stud hole dia. 5/8 in)
	<b>242251</b>	—	Connector, TW LK Insulated Female (Tweco-Lenco Type) HD 3/0-4/0







## Cable Connectors

### Dinse™ Twistlock Receptacles (50/70 Series)

Item #	Part #	Part #	Part #	Part #	Description
	<b>208967</b>	<b>202813</b>	<b>129525</b>	<b>186092</b>	Receptacle Assembly (Female)
1	208968 (N/A)	—	—	<b>202811</b>	Receptacle, Brass with O-ring (Female) (consists of items 2 and 3)
2	185711 (N/A)	<b>202553</b>	210752 (N/A)	202554 (N/A)	Receptacle, Brass (Female)
3	<b>185710</b>	—	—	<b>185710</b>	O-Ring, 0.296 ID x 0.139 H Silicone
4	<b>186228</b>	<b>186228</b>	—	<b>186228</b>	O-Ring, 0.739 ID x 0.070 H
5	<b>185712</b>	<b>185712</b>	208760 (N/A)	<b>185712</b>	Insulator, bulkhead front
6	<b>185718</b>	<b>185718</b>	—	<b>185718</b>	O-Ring, 0.989 ID x 0.070 H
7	<b>185713</b>	<b>185713</b>	208430 (N/A)	<b>185713</b>	Insulator, bulkhead rear
8	—	—	<b>229338</b>	—	Washer, domed load .812 ID x 1.450 OD x .070 THK
9	<b>185714</b>	<b>185714</b>	—	<b>185714</b>	Tooth washer, 1 mm intern
10	<b>185717</b>	<b>185717</b>	<b>185717</b>	<b>185717</b>	Nut, M20-1.5 1.00 Hex .19 H BRS locking
11	—	—	<b>229333</b>	—	Screw, M10-1.5x 20 Hex HD-PLN 8.8 PLD SEMS

### Dinse™ Twistlock Receptacles/Connectors

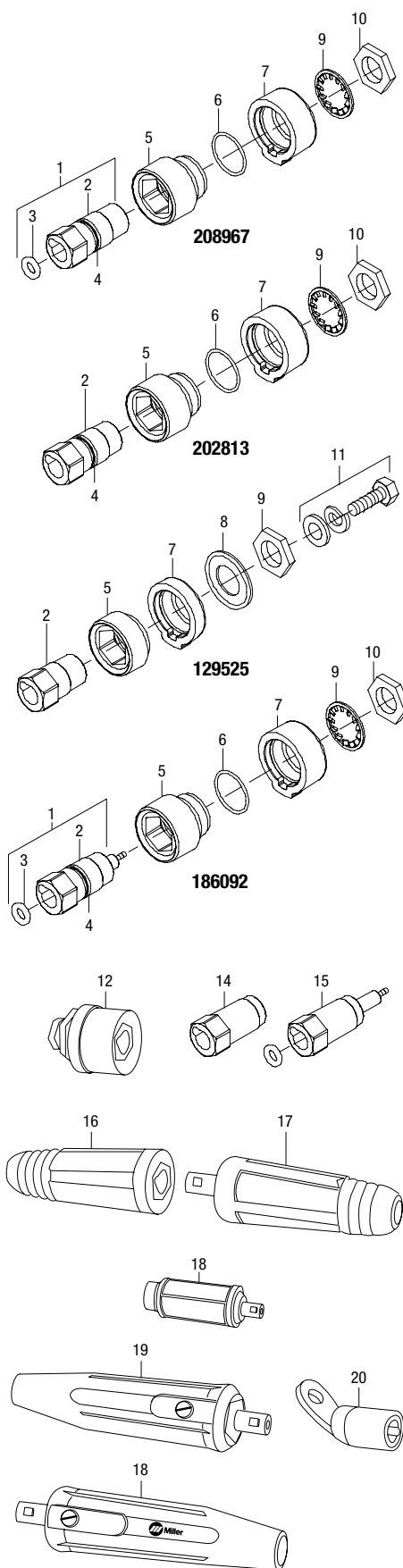
Item #	Part #	Series	Description	Cable Capacity/Thread Size
<b>Receptacles</b>				
12	<b>127837</b>	25	Receptacle, Insulated (Female)	—
13	<b>143419</b>	50	Receptacle, Insulated (Male)	—
14	<b>208698</b>	25	Receptacle, Brass Power Pos. (Female)	—
15	<b>208699</b>	25	Receptacle, Brass Power/Gas Neg. (Female) with O-Ring #188 380 (.174 ID x .103 H)	—
<b>Connectors</b>				
16	<b>127835</b>	25	Connector, Insulated (Female)	No. 3 – No. 4
	<b>129526</b>	50	Connector, Insulated (Female)	No. 2 – 1/0 (35 – 50 mm)
	<b>136600</b>	70	Connector, Insulated (Female)	No. 1/0 – 3/0 (50 – 70 mm)
	<b>138180</b>	95	Connector, Insulated (Female)	No. 3/0 – 4/0 (70 – 95 mm)
17	<b>127836</b>	25	Connector, Insulated (Male)	No. 3 – No. 4
	<b>129527</b>	50	Connector, Insulated (Male)	No. 2 – 1/0 (35 – 50 mm)
	<b>134460</b>	70	Connector, Insulated (Male)	No. 1/0 – 3/0 (50 – 70 mm)
	<b>241354</b>	95	Connector, Insulated (Male)	No. 3/0 – 4/0 (70 – 95 mm)
18	<b>273483</b>	25	Connector, Insulated (Male) Flow-Thru	3/8-24R
19	<b>194722</b>	50	Connector, Insulated (Male) Flow-Thru 125/150 A	3/8-24R
	<b>194723</b>	50	Connector, Insulated (Male) Flow-Thru 200 A	7/8-14R
<b>Adapters</b>				
20	<b>232728</b>	50/70	Adapter, Threaded Stud to Dinse (stud hole dia. 1/2 in)	
21	145739 (N/A)		Sleeve, clamping	

### Spectrum Connectors

Item #	Part #	Description
	<b>263801</b>	Connector, TW LK Insulated Male (Tweco-Lenco Type) SK 10-25

### Maxstar 700/Dynasty 700 Connectors

Item #	Part #	Description
<b>Connectors</b>		
	<b>225029</b>	Connection Kit, Thread Lock Double Dry
<b>Adapters</b>		
	<b>225028</b>	Adapter, Torch-Thread Lock Water (7/8 LHT)



## Electrode Holders

Part #	Amperage Capacity	Electrode Capacity	Cable Capacity	Length	Weight
<b>Professional Series</b>					
PA532	200	5/32 in (4.0 mm)	No. 2/0 (70 mm)	8-1/2 in (215 mm)	15 oz (415 g)
PA316	250	3/16 in (4.8 mm)	No. 2/0 (70 mm)	9-1/4 in (235 mm)	16 oz (450 g)
PA732	300	7/32 in (5.6 mm)	No. 2/0 (70 mm)	10 in (250 mm)	19 oz (530 g)
PA14HD	400	1/4 in (6.4 mm)	No. 4/0 (105 mm)	11 in (280 mm)	23 oz (650 g)

Electrode complete - no insulator replacements available

### Features include:

- Ergonomic — High lever design for greater grip and hand clearance
- Lightweight and easy-to-use
- Fully insulated, high-strength springs for excellent gripping power
- Heavy-duty, shock-proof nylon handle
- Grooved jaw design insures firm electrode grip
- High-impact, high-temperature fiberglass tip insulators
- Professional series features high copper alloy tongs, utility series features brass tongs
- Holders supplied with allen wrench and cable connections ferrule assuring efficient connections

## Work Clamps

Part #	Amperage Capacity	Electrode Capacity*	Cable Capacity	Length	Weight
EG200	200	1-1/2 in (40 mm)	No. 6-4 (10-16 mm)	7 in (175 mm)	7 oz (199 g)
EG300	300	2 in (50 mm)	No. 2-1 (25-35 mm)	8 in (200 mm)	14 oz (390 g)
EG500	500	2 in (50 mm)	No. 1/0-4/0 (50-105 mm)	10 in (245 mm)	17 oz (490 g)
PGC200	200	1 in (25 mm)	No. 1-1/0 (35-50 mm)	6 in (150 mm)	16 oz (445 g)
PGC300	300	1-1/2 in (40 mm)	No. 1/0-3/0 (50-95 mm)	8 in (200 mm)	25 oz (715 g)
MGC300	300	—	No. 1-1/0 (35-50 mm)	—	21 oz (600 g)
203988	180	1-1/2 in (40 mm)	2 in (25 mm)	7 in (175 mm)	9 oz (255 g)
213619	300	2 in (50 mm)	1/0 (50 mm)	8 in (200 mm)	13 oz (368 g)
010368	200	1-1/2 in (40 mm)	No. 4	6 in	5 oz (142 g)
233452	300	2 in (50 mm)	No. 4-2	8 in	10 oz (290 g)
240697	200	2 in (50 mm)	No. 6	6-1/4 in	6 oz (168 g)
235116	600	2 in (50 mm)	No. 3/0-4/0 (70-95 mm)	6-1/4 in	6 oz (168 g)

\* Jaw Distance

### EG Series — Steel Work Clamps

- Zinc plated
- Large hex screw cable connection assures safe cable connection every time
- Pure copper braided shunts on EG500 allows both jaws to carry welding current

### PGC Series — Copper Alloy

- Contoured handle lever for easy jaw opening
- Strong gripping power
- Large contact area assures positive grounding
- Fully insulated spring
- Conductor body holds the cable securely
- Large hex screw cable connection assures safe cable connection every time

### MGC Series — Magnetic Work Clamps

- Large contact area assures excellent electrical contact
- Strong gripping power
- Grounding concealed to prevent dislodgment
- Insulated to prevent annealing
- Easy installation or removal
- Most popular magnetic work clamps in the market

PA532



PA316  
PA14HD



PA532,  
PA316,  
PA732



PA14HD



EG500



PGC300



MGC300



240697

213619



010368



203988

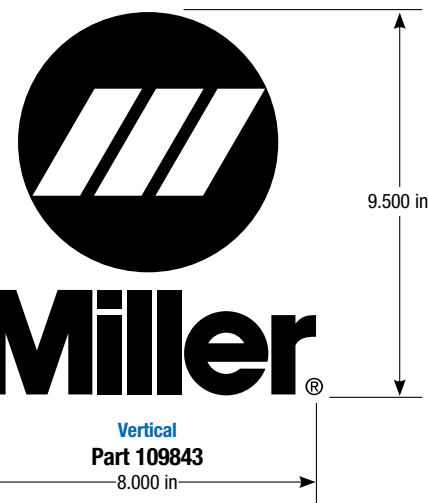




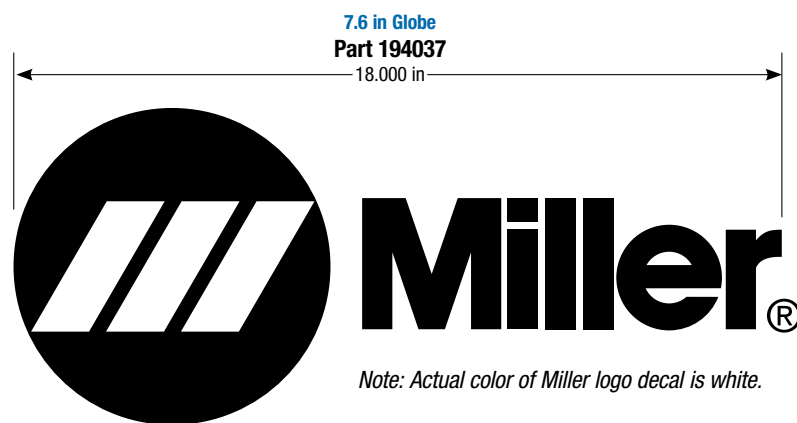
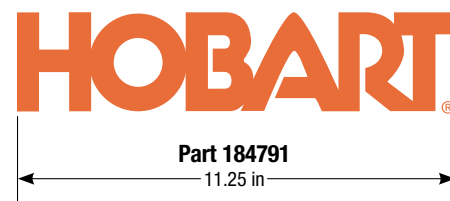
## Miller/Hobart Replacement Labels

Part #	Description	Format	Height	Width	Color
124462	Miller	Horizontal	1.625 in	3.750 in	White/Blue Bkgd
109844	Miller	Horizontal	2.500 in	6.000 in	White/Blue Bkgd
115496	Miller	Horizontal	3.500 in	8.250 in	White/Blue Bkgd
119503	Miller	Horizontal	4.000 in	9.562 in	White/Blue Bkgd
121389	Miller	Horizontal	5.250 in	12.437 in	White/Blue Bkgd
194037	Miller	Horizontal	7.600 in	18.000 in	White/Blue Bkgd
109838	Miller	Vertical	1.562 in	1.312 in	White/Blue Bkgd
109839 (N/A)	Miller	Vertical	3.000 in	2.500 in	White/Blue Bkgd
109840	Miller	Vertical	4.500 in	3.750 in	White/Blue Bkgd
109841	Miller	Vertical	6.000 in	5.125 in	White
109842	Miller	Vertical	7.750 in	6.500 in	White/Blue Bkgd
109843	Miller	Vertical	9.500 in	8.000 in	White
184791	Hobart	Horizontal	2.5 in	11.250 in	Orange

Nothing completes the repair and repaint of a machine like the addition of the original equipment factory fresh decals. Above is a complete list of the wide variety of sizes available in both the horizontal and vertical formats. For the availability of complete machine decal kits, please contact Miller Service Parts at 1-866-931-9730.



Note: Actual color of Miller logo decal is white.



Note: Actual color of Miller logo decal is white.



Note: Actual color of Miller logo decal is white.

## Power Terminals

### Power Terminal Output Assemblies

Part #	Description	Color	Dimension A	Bolt Dimensions
<b>Group 1</b>				
274848	With Hex Nut	Red	1-7/8 in	1/2 in x 1-1/2 in
274859	With Hex Nut	Black	1-7/8 in	1/2 in x 1-1/2 in
274843	With Hex Nut	White	1-7/8 in	1/2 in x 1-1/2 in
274848	With Hex Nut	Red	1-7/8 in	1/2 in x 1-3/4 in
274859	With Hex Nut	Black	1-7/8 in	1/2 in x 1-3/4 in
601879	Hex Nut — Replacement	—	—	—

### Power Terminal Boots

Part #	Description	Width	Height
179848	Rubber Boot (Positive) <sup>1</sup>	2 in ID	3-3/4 in ID
180732	Rubber Boot (Negative) <sup>1</sup>	2 in ID	3-3/4 in ID
186621	Rubber Boot (Generic) <sup>1</sup>	2 in ID	3-3/4 in ID
180735	Washer, Output Stud		
181169	Spacer, Output Stud		

<sup>1</sup> 180735 & 181169 are needed for Power Terminal Boots.

Part #	Description	Cord Range (Min. – Max.)
219515	50 amp, 230 volt pin-type wall receptacle	—
219516	50 amp, 230 volt pin-type male plug	0 – 1.00
213380	50 amp, 230 volt pin-type male plug (heavy-duty)	0.625 – 1.320
219535	50 amp, 230 volt pin-type cord-mount receptacle	0.425 – 1.31
119172	50 amp, 125/250 volt pin-type male plug	0.62 – 1.31
254140	Plug, str grd 3P4W 3PH 50A 240V 15-50P	—



039046



179848

180732



219515



219516



254140



219535



119172



# TRUE BLUE<sup>®</sup> WARRANTY

Effective January 1, 2018

(Equipment with a serial number preface of MJ or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

## Warranty Questions?

Call  
1-800-4-A-MILLER  
for your local  
Miller distributor.

Your distributor also gives  
you ...

### Service

You always get the fast,  
reliable response you  
need. Most replacement  
parts can be in your  
hands in 24 hours.

### Support

Need fast answers to the  
tough welding questions?  
Contact your distributor.  
The expertise of the  
distributor and Miller is  
there to help you, every  
step of the way.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. LLC, Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed. If notification is submitted as an online warranty claim, the claim must include a detailed description of the fault and the troubleshooting steps taken to identify failed components and the cause of their failure.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed twelve months after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an International distributor.

1. 5 Years Parts — 3 Years Labor
  - \* Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules
2. 3 Years — Parts and Labor
  - \* Auto-Darkening Helmet Lenses (Except Classic Series) (No Labor)
  - \* Engine Driven Welder/Generators  
**(NOTE: Engines are Warranted Separately by the Engine Manufacturer.)**
  - \* Inverter Power Sources
  - \* Plasma Arc Cutting Power Sources
  - \* Process Controllers
  - \* Semi-Automatic and Automatic Wire Feeders
  - \* Transformer/Rectifier Power Sources
3. 2 Years — Parts and Labor
  - \* Auto-Darkening Helmet Lenses – Classic Series Only (No Labor)
  - \* Auto-Darkening Weld Masks (No Labor)
  - \* Fume Extractors – Capture 5, Filair 400 and Industrial Collector Series
4. 1 Year — Parts and Labor Unless Specified
  - \* AugmentedArc and LiveArc Welding Systems
  - \* Automatic Motion Devices
  - \* Bernard BTB Air-Cooled MIG Guns (No Labor)
  - \* CoolBelt and CoolBand Blower Unit (No Labor)
  - \* Desiccant Air Dryer System
  - \* External Monitoring Equipment and Sensors
  - \* Field Options  
**(NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)**
  - \* RFCS Foot Controls (Except RFCS-RJ45)
  - \* Fume Extractors – Filair 130, MWX and SWX Series HF Units
  - \* ICE/XT Plasma Cutting Torches (No Labor)
  - \* Induction Heating Power Sources, Coolers  
**(NOTE: Digital Recorders are Warranted Separately by the Manufacturer.)**
  - \* Load Banks
  - \* Motor-Driven Guns (except Spoolmate Spoolguns)
  - \* PAPR Blower Unit (No Labor)
  - \* Positioners and Controllers
  - \* Racks
  - \* Running Gear/Trailers
  - \* Spot Welders
  - \* Subarc Wire Drive Assemblies
  - \* TIG Torches (No Labor)
  - \* Tregaskiss Guns (No Labor)
  - \* Water Cooling Systems
  - \* Wireless Remote Foot/Hand Controls and Receivers
  - \* Work Stations/Weld Tables (No Labor)

5. 6 Months — Parts
  - \* Batteries
6. 90 Days — Parts
  - \* Accessory (Kits)
  - \* Canvas Covers
  - \* Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
  - \* M-Guns
  - \* MIG Guns, Subarc (SAW) Torches, and External Cladding Heads
  - \* Remote Controls and RFCS-RJ45
  - \* Replacement Parts (No labor)
  - \* Spoolmate Spoolguns

Miller's True Blue Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR COMMERCIAL AND INDUSTRIAL USERS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

The exclusive remedies for warranty claims are, at Miller's option, either: (1) repair; or (2) replacement; or, if approved in writing by Miller, (3) the pre-approved cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon use). Products may not be returned without Miller's written approval. Return shipment shall be at customer's risk and expense.

The above remedies are F.O.B. Appleton, WI, or Miller's authorized service facility. Transportation and freight are the customer's responsibility. TO THE EXTENT PERMITTED BY LAW, THE REMEDIES HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES REGARDLESS OF THE LEGAL THEORY. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT) REGARDLESS OF THE LEGAL THEORY. ANY WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY, OR REPRESENTATION, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, ARE EXCLUDED AND DISCLAIMED BY MILLER.

Some US states do not allow limiting the duration of an implied warranty or the exclusion of certain damages, so the above limitations may not apply to you. This warranty provides specific legal rights, and other rights may be available depending on your state. In Canada, some provinces provide additional warranties or remedies, and to the extent the law prohibits their waiver, the limitations set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary by province.

# Miller Signature Service

Contacting us — Phone: 866-931-9730 Fax: 800-637-2315

<b>Option 1 Orders</b>	This option will get you to our experts in Customer Service. Here our team can help you with placing an order, checking status of previous orders, returning a product, and availability of product. Customer Service can also check orders or availability for TIG torches and oxy-fuel related items.			
<b>Option 1 Sub-Menu:</b>				
1	2			
Place/expedite order or RGA	Have part number and need price and availability			
<b>Option 2 Product Selection</b>	Select this option for assistance with determining which machine or accessories will work with your job or application. You can obtain help with freight damage, safety products, helmets, Oxy Fuel Systems, Regulators, TIG torches and accessories, and with looking up part numbers.			
<b>Option 2 Sub-Menu:</b>				
1	2	3	4	5
Machines & Accessories	Parts Look-Up	Safety Product & Helmets	Gas Equipment	TIG Torches
<b>Option 3 Warranty</b>	If you are looking for service warranty information or technical guidance with your Miller machine this is the option that will get you help. After pressing 3, you will then be connected to one of our friendly switchboard team members. They will direct you to the correct area that can assist you.			
<b>Option 4 Promotions &amp; Rebates</b>	This option is for questions regarding current Miller promotions and rebates, including Build with Blue.			
<b>Option 8 Contact by Name</b>	This option allows you to look up a person by name. Simply speak the person's first and last name, confirm that you have the correct person, and you will be automatically connected!			
<b>Option 0 Operator</b>	If you are unsure of which option to choose, you can press 0 and be connected with an operator who can direct your call.			



## Extranet <https://partners.itwwelds.com>

The Distributor Extranet, located at <https://partners.itwwelds.com>, is a secure, private website that offers personalized information to Miller distributors. It gives distributors the ability to check order status, track shipments, or check price and availability, whenever it is convenient — 24 hours a day, 7 days a week. It also provides access to product Specification Sheets, new product information, and gives you the ability to order Spec Sheets and sales tools online.

Because much of what you'll find at this site applies specifically to your company, a username and password are required to gain access. Controlled access to this information is very important for Miller and the distributor, which is why a formal "enrollment process" is required.



## On-Line Enrollment Process

Distributor management visit <https://partners.itwwelds.com> and click on "Register now," and you will be able to establish a Web Access Coordinator (WAC) for your business. When approved, the WAC will have the ability to enable access for all other employees within the distributorship that you wish to have access.

## On-Line Service Parts Ordering

Once your business is enrolled on the Extranet, you'll have the added convenience of placing your Miller Service Parts orders online. Contact your Web Access Coordinator to enable this feature. Then you'll be able to link to it from the "Sales Navigation."

Distributed By:

