

TOUGH LOCK® CONSUMABLES


MIG (GMAW)
WELDING CONSUMABLES




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APPLICATIONS	• Automotive • General Manufacturing & Fabrication
SYSTEM COMPONENTS	• Contact Tips • Nozzles • Retaining Heads
COMPATIBLE WITH	• TOUGH GUN® Robotic MIG Guns • TOUGH GUN® Automatic MIG Guns • Bernard® BTB Semi-Automatic MIG Guns • Bernard® TGX® Semi-Automatic MIG Guns • Bernard® Clean Air™ Fume Extraction Guns


- **TOUGH LOCK® Consumables Series** can help to reduce your consumable costs and related downtime.
- **TOUGH LOCK® Retaining Heads**, when mated with TOUGH LOCK® Contact Tips, minimize contact tip temperature due to increased surface contact.
- **TOUGH LOCK® Contact Tips** are manufactured from high-quality, high-conductivity copper using a mandrel-drawn process that controls tip tolerances.
- **Tregaskiss® Nozzles** are engineered to be extremely durable and long-lasting. Made of hard-drawn copper or brass, the smooth surface finish and rounded edges minimize weld spatter build-up.



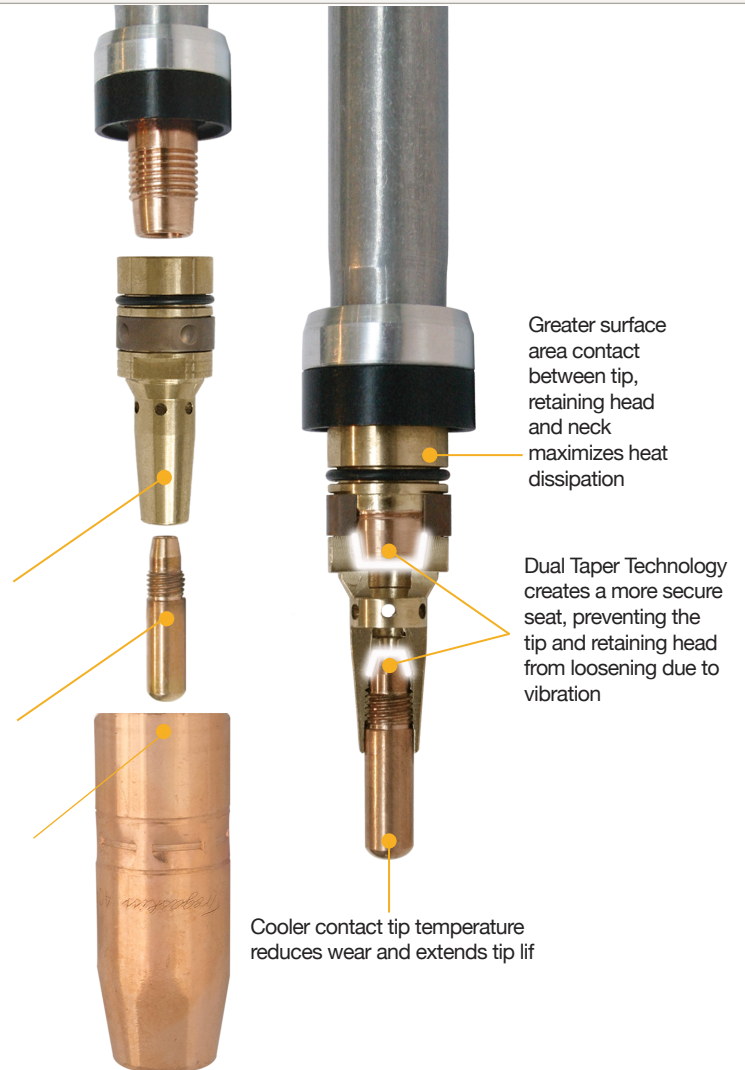
GOOD HEAT DISSIPATION
FOR SUPERIOR REPEATABILITY AND CONSISTENT, QUALITY WELDS



ONE QUICK TWIST
A QUICK TWIST IS ALL IT TAKES TO INSTALL QUIK TIP CONTACT TIPS

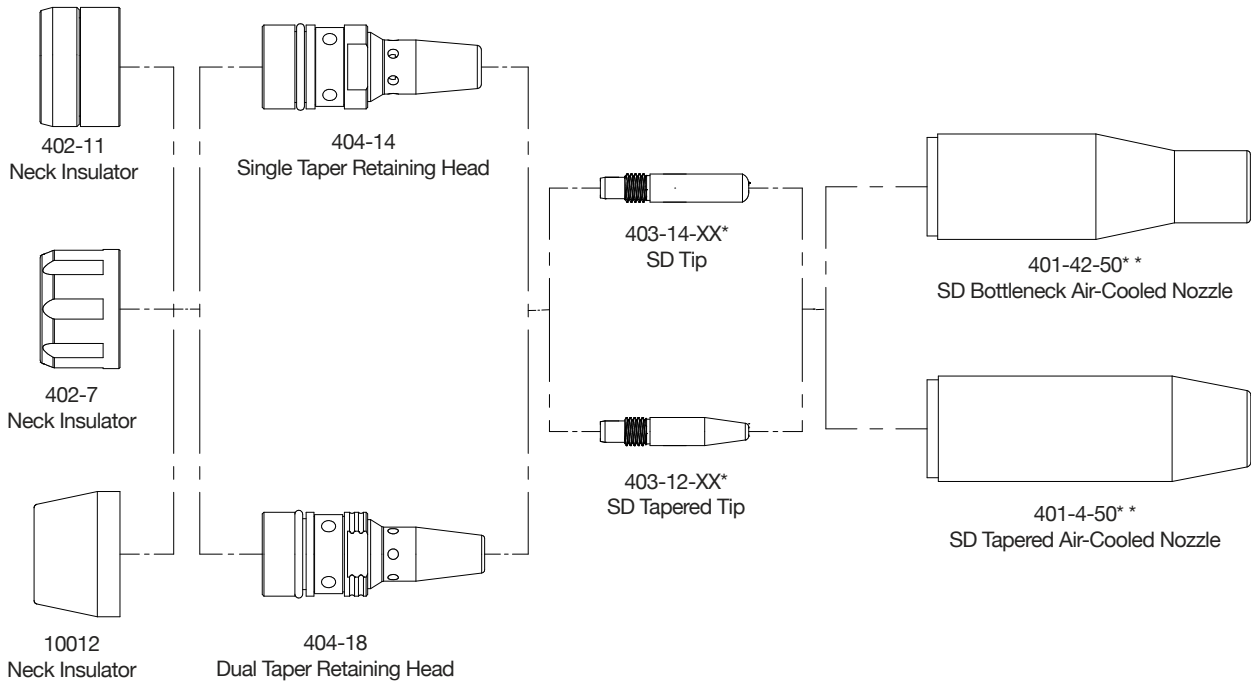


THREADED TAPER LOCK
INCREASES TIP LIFE BY PROVIDING EXCELLENT HEAT TRANSFER AND ELECTRICAL CONDUCTIVITY



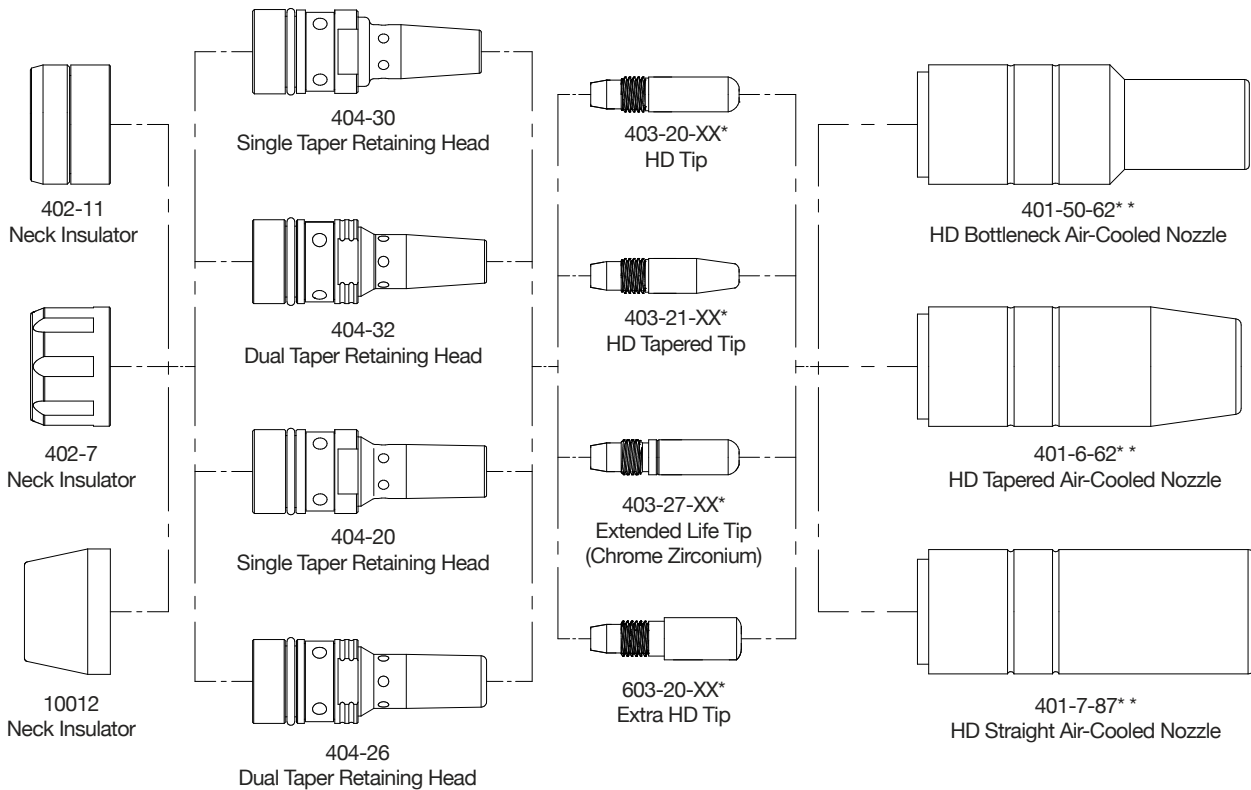
TOUGH LOCK® CONSUMABLE SERIES

STANDARD DUTY (SD) TOUGH LOCK® SERIES



* XX = WIRE SIZE, SEE CONTACT TIP INFORMATION STARTING ON PAGE 3

HEAVY DUTY (HD) TOUGH LOCK® SERIES



* XX = WIRE SIZE, SEE CONTACT TIP INFORMATION STARTING ON PAGE 3

**ADDITIONAL NOZZLES ARE AVAILABLE WITH VARIOUS STICKOUTS. SEE PAGES 4 & 5 FOR OPTIONS

RETAINING HEADS/DIFFUSERS

FOR ROBOTIC APPLICATIONS

Part Number	Description	Qty	Duty	Nozzle Type	Material	Platform	Notes
404-14-25	Retaining Head	25	SD	Slip-On	Brass	A/C	Single taper SD retaining head
404-18*	Dual Taper Retaining Head	100	SD	Slip-On	Brass	A/C	Dual taper SD retaining head
404-22	Retaining Head	100	HD	Slip-On	Brass	A/C	Single taper, set screw for liner retention
404-30*	Retaining Head	100	HD	Slip-On	Brass	A/C	Standard robotic dual taper retaining head
404-32*	Dual Taper Retaining Head	100	HD	Slip-On	Brass	A/C	Standard robotic dual taper retaining head
404-36-25	Retaining Head	25	HD	Slip-On	Copper	A/C	Single taper robotic retaining head
404-52-25	Dual Taper Retaining Head	25	HD	Thread-On	Brass	A/C	Standard thread on robotic retaining head
404-71	Diffuser	25	HD	Thread-On	Copper	W/C	Diffuser for 600 amp TOUGH GUN® robotic water cooled MIG gun

FOR SEMI-AUTOMATIC APPLICATIONS

Part Number	Description	Qty	Duty	Nozzle Type	Material	Platform	Notes
154-14	Retaining Head	25	SD	Slip-On	Brass	A/C	Single taper SD retaining head used on 18 amp TGX Guns
404-14-25	Retaining Head	25	SD	Slip-On	Brass	A/C	Single taper SD retaining head
404-20*	Retaining Head	100	HD	Slip-On	Brass	A/C	Single taper HD retaining head
404-26*	Dual Taper Retaining Head	100	HD	Slip-On	Brass	A/C	Standard dual taper retaining head
404-38-25	Diffuser	25	HD	Thread-On	Copper	W/C	Used on 62 & 64 series guns with 601 series nozzles & 601-5-75-3 ceramic insulator SD retaining head
404-44*	Retaining Head	100	HD	Slip-On	Brass	A/C	Bernard® legacy neck conversion retaining head
404-53-25	Dual Taper Retaining Head	25	HD	Thread-On	Brass	A/C	Standard thread on semi-automatic retaining head

*OTHER QUANTITIES AVAILABLE, CONTACT CUSTOMER SERVICE FOR MORE INFORMATION.
NOTE: AIR-COOLED (A/C) AND WATER-COOLED (W/C)

TOUGH LOCK® CONTACT TIPS

STANDARD DUTY [SD] CONTACT TIPS

(0.0250" Outside Diameter (O.D.))

403-14-23-25	for 0.023" (0.6 mm); qty. 25	403-14-35*	for 0.035" (0.9 mm); qty. 100
403-14-30*	for 0.030" (0.8 mm); qty. 100		

STANDARD DUTY [SD] TAPERED CONTACT TIPS

(0.0250" Outside Diameter (O.D.))

403-12-30-25	for 0.030" (0.8 mm); qty. 25	403-12-45-25	for 0.045" (1.2 mm); qty. 25
403-12-35-25	for 0.035" (0.9 mm); qty. 25		

EXTENDED LIFE TIPS [CHROME ZIRCONIUM]

(0.0250" Outside Diameter (O.D.))

403-27-30*	for 0.030" (0.8 mm); qty. 100	403-27-45*	for 0.045" (1.2 mm); qty. 100
403-27-35*	for 0.035" (0.9 mm); qty. 100	403-27-364*	for 3/64" (1.2 mm); qty. 100
403-27-1.0*	for 0.040" (1.0 mm); qty. 100	403-27-52*	for 0.052" (1.3 mm); qty. 100

HEAVY DUTY [HD] TIPS

(0.0250" Outside Diameter (O.D.))

403-20-30*	for 0.030" (0.8 mm); qty. 100	403-20-1.4*	for 0.055" (1.4 mm); qty. 100
403-20-35*	for 0.035" (0.9 mm); qty. 100	403-20-116*	for 1/16" (1.6 mm); qty. 100
403-20-1.0*	for 0.040" (1.0 mm); qty. 100	403-20-1.8*	for 0.070" (1.8 mm); qty. 100
403-20-45*	for 0.045" (1.2 mm); qty. 100	403-20-78*	for 0.078" (2.0 mm); qty. 100
403-20-364*	for 3/64" (1.2 mm); qty. 100	403-20-564*	for 5/64" (2.0 mm); qty. 100
403-20-52*	for 0.052" (1.3 mm); qty. 100	403-20-332*	for 3/32" (2.4 mm); qty. 100

HD TAPERED TIPS

(0.0250" Outside Diameter (O.D.))

403-21-30*	for 0.030" (0.8 mm); qty. 100	403-21-45*	for 0.045" (1.2 mm); qty. 100
403-21-35*	for 0.035" (0.9 mm); qty. 100	403-21-52*	for 0.052" (1.3 mm); qty. 100
403-21-1.0*	for 0.040" (1.0 mm); qty. 100	403-21-116*	for 1/16" (1.6 mm); qty. 100

EXTRA HEAVY DUTY TIPS

(0.0250" Outside Diameter (O.D.))

603-20-1.0-25	for 0.040" (1.0 mm); qty. 25	603-20-116-25	for 1/16" (1.6 mm); qty. 25
603-20-45-25	for 0.045" (1.2 mm); qty. 25	603-20-564-25	for 5/64" (2.0 mm); qty. 25
603-20-364-25	for 3/64" (1.2 mm); qty. 25	603-20-332-25	for 3/32" (2.4 mm); qty. 25
603-20-52-25	for 0.052" (1.3 mm); qty. 25	603-20-764-25	for 7/64" (2.8 mm); qty. 25
603-20-1.4-25	for 0.055" (1.4 mm); qty. 25	603-20-18-25	for 1/8" (3.2 mm); qty. 25

TOUGH LOCK® TEACH TIPS

(0.0250" Outside Diameter (O.D.))

403-20-01	Adjustable Teach Tip, qty. 1	403-20-075	Teach Tip, 3/4"; qty. 1
403-20-05	Teach Tip, 1/2"; qty. 1	403-20-10mm	Teach Tip, 10 mm; qty. 1
403-20-062	Teach Tip, 5/8"; qty. 1	403-20-15mm	Teach Tip, 15 mm; qty. 1

TOUGH LOCK® TIP TOOL

450-18	Tip Tool; qty. 1
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NOZZLES

Tregaskiss® nozzles feature:

- High-temperature resistant fiberglass insulators electrically insulate the nozzle from the diffuser
- Heavy duty crimp holds all three layers together
- Available in slip-on and thread-on styles



LIGHT DUTY AIR-COOLED NOZZLES [SLIP ON]

For use with TOUGH LOCK® Diffuser 154-14

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty
151-1-50	1/2"	1/8" Recess	Tapered	Brass	.0813"	2.13"	10

STANDARD DUTY [SD] AIR-COOLED NOZZLES [SLIP-ON]

For use with TOUGH LOCK® Diffuser 404-32 (Robotic) or 404-26 (Semi-Automatic)

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
401-40-38	3/8"	1/16" Recess	Taper	Brass	0.978"	2.81"	10	—
401-42-50	1/2"	1/8" Recess	Bottleneck*	Brass	0.938"	2.88"	10	RCT-04
401-4-38	3/8"	Flush	Taper	Copper	0.938"	2.74"	10	—
401-44-50	1/2"	1/4" Stick-out	Bottleneck*	Brass	0.938"	2.50"	10	RCT-04
401-44-62	5/8"	1/4" Stick-out	Taper	Copper	0.938"	2.51"	10	RCT-01
401-4-50	1/2"	1/8" Recess	Taper	Copper	0.938"	2.88"	10	RCT-04
401-4-62	5/8"	1/8" Recess	Taper	Copper	0.938"	2.88"	10	RCT-01
401-48-50	1/2"	1/8" Stick-out	Bottleneck*	Brass	0.938"	2.63"	10	RCT-04
401-8-62	5/8"	1/8" Stick-out	Taper	Copper	0.938"	2.63"	10	RCT-01401-
401-48-50C	1/2"	1/8" Stick-out	Bottleneck*	Copper	0.938"	2.63"	10	RCT-04

*STRAIGHT BORE; IDEAL FOR REAMING

NOZZLES

[CONTINUED]

STANDARD DUTY AIR-COOLED NOZZLES [THREAD -ON]

For use with TOUGH LOCK® Diffuser 404-52 (Robotic) or 404-53 (Semi-Automatic)

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
401-18-62	5/8"	1/8" Stick-out	Taper	Copper	0.938"	2.63"	10	RCT-01
401-42-38	3/8"	1/8" Recess	Taper	Copper	0.938"	2.88"	10	—
401-43-62	5/8"	1/8" Recess	Taper	Copper	0.938"	2.88"	10	RCT-01

HEAVY DUTY [HD] AIR-COOLED NOZZLES [SLIP-ON]

For use with TOUGH LOCK® Diffuser 404-32 (Robotic) or 404-26 (Semi-Automatic)

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
401-48-62	5/8"	Flush	Bottleneck*	Copper	1.062"	2.76"	10	RCT-01
401-49-62	5/8"	1/8" Stick-out	Bottleneck*	Copper	1.062"	2.63"	10	RCT-01
401-50-62	5/8"	5 mm Recess	Bottleneck*	Copper	1.062"	2.95"	10	RCT-01
401-51-62	5/8"	Flush	Bottleneck*	Brass	1.062"	2.76"	10	RCT-01
401-5-62	5/8"	1/4" Recess	Taper	Copper	1.062"	3.00"	10	RCT-01
401-5-75	3/4"	1/4" Recess	Taper	Copper	1.062"	3.00"	10	RCT-12
401-6-50	1/2"	1/8" Recess	Taper	Copper	1.062"	2.88"	10	RCT-04
401-6-62	5/8"	1/8" Recess	Taper	Copper	1.062"	2.88"	10	RCT-01
401-6-75	3/4"	1/8" Recess	Taper	Copper	1.062"	2.88"	10	RCT-12
401-71-62	5/8"	1/8" Recess	Taper*	Brass	1.106"	2.88"	10	RCT-01
401-72-62	5/8"	1/8" Recess	Taper	Brass	1.062"	2.88"	10	RCT-01
401-7-62	5/8"	1/4" Recess	Taper	Brass	1.106"	3.00"	10	RCT-01
401-7-75	3/4"	1/8" Recess	Taper	Brass	1.106"	2.88"	10	RCT-12
401-7-87	7/8"	1/4" Recess	Straight	Brass	1.106"	3.00"	10	RCT-12**
401-9-75***	3/4"	1/2" Recess	Taper	Copper	1.062"	3.15"	10	RCT-15
401-81-62	5/8"	1/8" Stick-Out	Taper	Copper	1.062"	2.63"	10	RCT-01
401-87-56	9/16"	1/8" Recess	Taper	Brass	1.062"	2.88"	10	RCT-04**
401-87-62	5/8"	1/8" Stick-Out	Taper	Brass	1.062"	3.00"	10	RCT-01
401-88-62	5/8"	Flush	Taper	Brass	1.062"	2.76"	10	RCT-01

*STRAIGHT BORE; IDEAL FOR REAMING

**MAY NOT CLEAN SPATTER RING INSIDE NOZZLE BORE

***FOR USE WITH MILLER ELECTRIC HD (HIGH-DEPOSITION) MIG CV GMAW PROCESS.

HEAVY DUTY AIR-COOLED NOZZLES [THREAD-ON]

For use with TOUGH LOCK® Diffuser 404-52 (Robotic) or 404-53 (Semi-Automatic)

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
401-14-62	5/8"	1/4" Recess	Taper	Copper	1.062"	2.88"	10	RCT-01
401-20-62	5/8"	1/8" Stick-Out	Taper	Copper	1.062"	2.63"	10	RCT-01
401-41-62	5/8"	1/8" Stick-Out	Taper	Brass	1.062"	2.63"	10	RCT-01
401-53-62	5/8"	1/8" Stick-Out	Taper	Brass	1.062"	2.63"	10	RCT-01

HEAVY DUTY WATER-COOLED NOZZLES

For use with 600 amp T-Gun™ Water-Cooled and TOUGH GUN® Automatic Water-Cooled MIG Guns

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
601-5-62	5/8"	1/4" Recess	Taper	Nickel-Plated Bronze	1.225"	3.13"	10	RCT-01
601-6-62	5/8"	1/8" Recess	Taper	Nickel-Plated Bronze	1.225"	3.00"	10	RCT-01
601-5-75	3/4"	1/4" Recess	Taper	Nickel-Plated Bronze	1.225"	3.13"	10	RC-12
601-6-75	3/4"	1/8" Recess	Taper	Nickel-Plated Bronze	1.225"	3.00"	10	RC-12

USE 601-5-75-3 INSULATOR FOR ALL 601 SERIES NOZZLES
 USE 404-38 DIFFUSER FOR ALL 601 SERIES NOZZLES

HEAVY DUTY NOZZLES FOR TOUGH GUN® WATER-COOLED MIG GUNS

Part Number	Bore	Tip Position	Type	Material	O.D.	Length	Qty	Reamer Cutter Blade
650-6-62	5/8"	1/8" Recess	Taper	Chrome	1.062"	3.60"	2	RCT-01
650-6-75	3/4"	1/8" Recess	Taper	Chrome	1.062"	3.60"	2	RC-12

USE 404-32 DIFFUSER FOR ALL 650 SERIES NOZZLES

TOUGH LOCK® CONVERSION SERIES

Add our TOUGH LOCK® Consumables, durable nozzles and neck insulators / adaptors to your Bernard®, Binzel®, Lincoln® and Tweco® style MIG Guns. Find your MIG gun make and model on the left, then follow the chart to the right for parts needed to upgrade

Gun Manufacturer	Gun Model	Gun Neck	TOUGH LOCK® Heavy Duty Retaining Head	Neck Insulator	Adaptor
Bernard®	Q-Gun™ Series	Legacy Neck	404-44	4423R	N/A
Lincoln®	Magnum® 300	KP1929 / KP1928 / KP1941	404-20*	4423R	N/A
	Magnum® 400	KP1929 / KP1928 / KP1941	404-20*	4423R	N/A
Tweco®	Tweco® #3	63J-60	404-20*	4423R	N/A
	Tweco® #4	64J-60	404-20*	4423R	N/A
	Spray Master™ 350	MS63-60	404-20*	4423R	N/A
	Spray Master™ 450	MS64H-60	404-20*	4423R	N/A
	WeldSkill® 400	64A-60	404-20*	4423R	N/A
	MINI-MIG	—	N/A	402-19	404-64

*NOTE: THE 404-20 TOUGH LOCK® RETAINING HEAD WILL FIT ON MOST NECKS WITH AN EXTERNAL 9/16"-18 THREAD REGARDLESS OF ANGLE

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