TOUGH LOCK™ Consumable Series

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MIG (GMAW) Welding Consumables

Quick Specs

Applications	Series Components	Compatible With	Wire Size
Automotive Fabrication Manufacturing	Retaining Heads Contact Tips Nozzles	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	0.023" to 1/8" (0.6 to 3.2 mm)

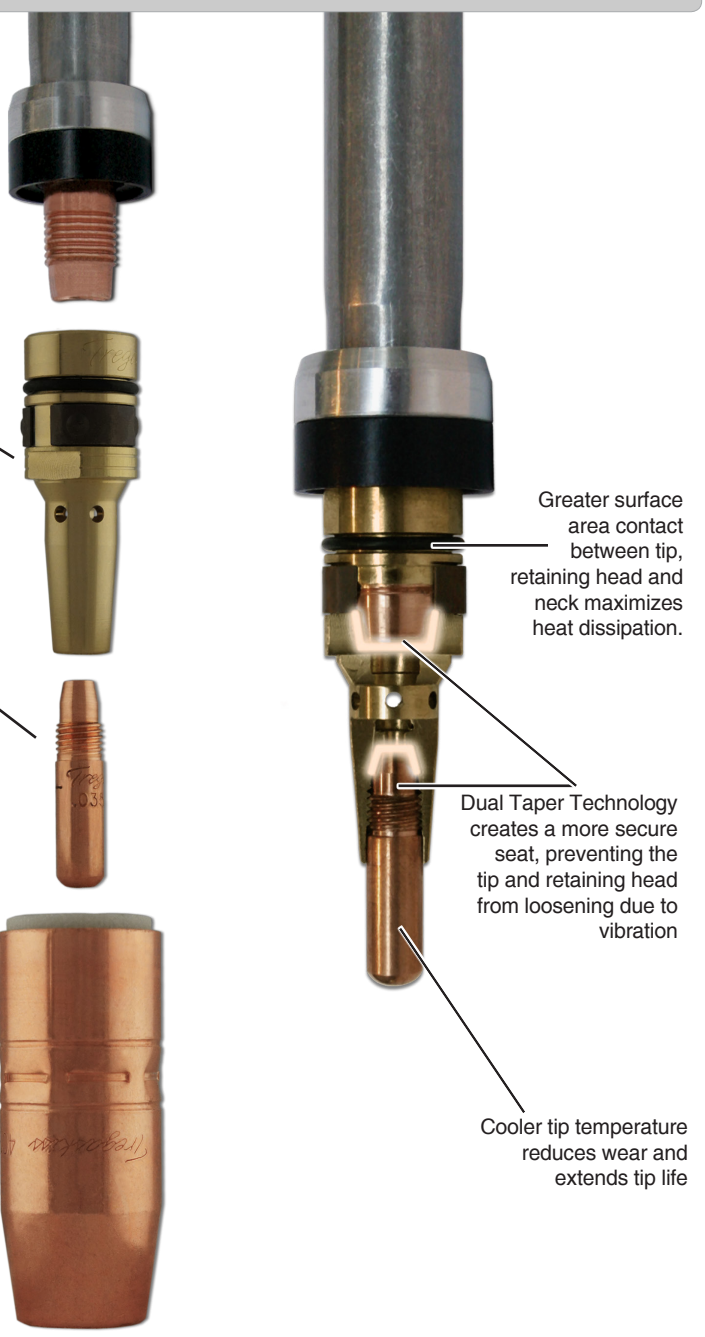
TOUGH LOCK™ Consumable Series
can help to reduce your consumable costs and maintenance downtime.

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
Tregaskiss Insulated Nozzles for MIG welding guns 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.

TOUGH LOCK Problem Solvers:
- SURE*START*™ Contact Tips
- TOUGH ACCESS™ Series
- TIGHT RADIUS™ System



Dual Taper Technology keeps consumables running cooler

Locking feature prevents tip and retaining head from loosening due to vibration

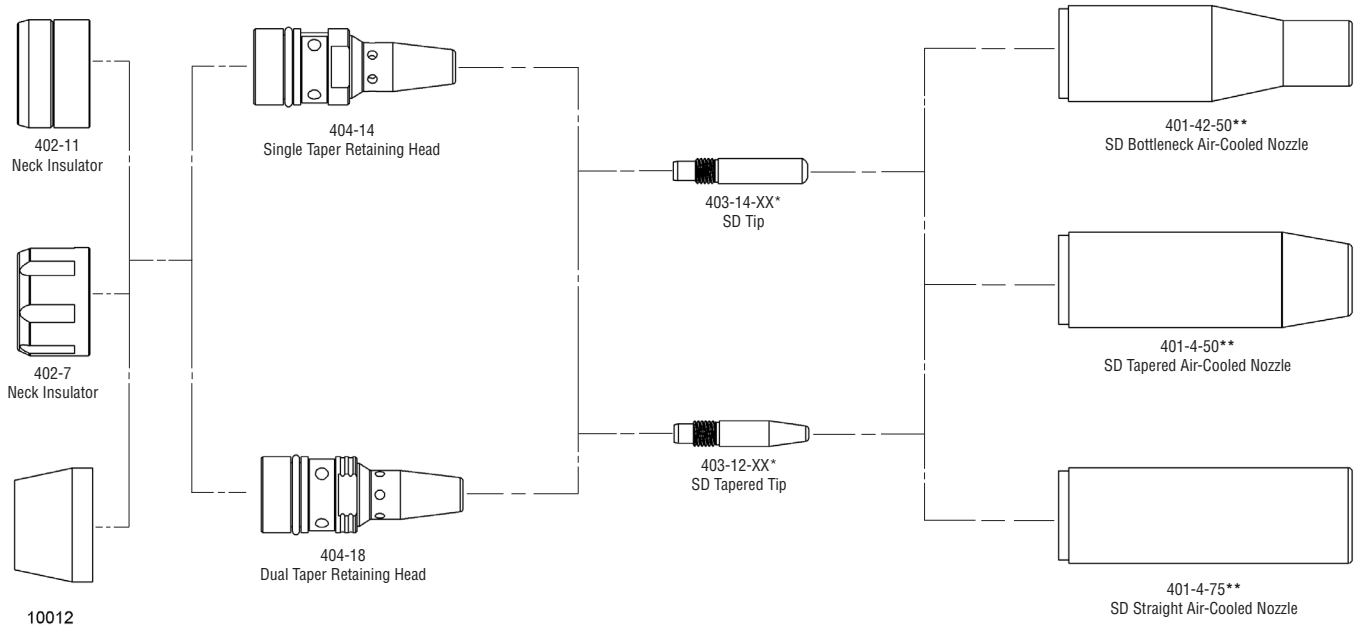
Tregaskiss™

Tregaskiss
2570 North Talbot Road
Windsor, Ontario N0R 1L0
Canada

Phone: 1-855-MIGWELD (644-9353) (US & Canada)
+1-519-737-3030 (International)
Fax: 519-737-2111
For more information, visit us at Tregaskiss.com

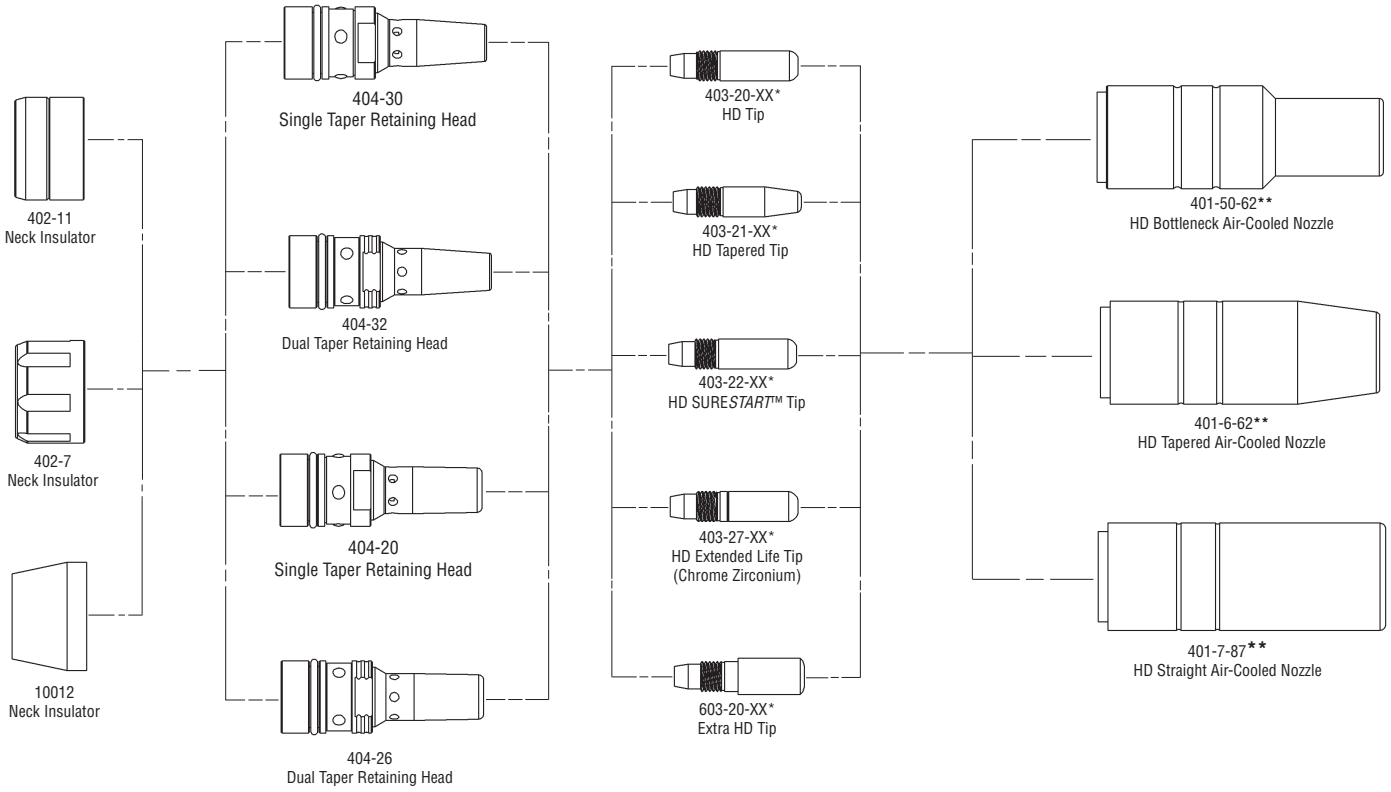
TOUGH LOCK™ Consumable Series

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

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
404-23-25	Retaining Head	25	HD	Slip-On	Brass	A/C	Single taper, no gas holes. Gasless Flux-Core
404-30*	Retaining Head	100	HD	Slip-On	Brass	A/C	Single taper robotic 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
404-50-25	TOUGH ACCESS Retaining Head	25	HD	Slip-On	Brass	A/C	TOUGH ACCESS HD retaining head, to be used with 404-17 neck insulator
404-52-25	Dual Taper Retaining Head	25	HD	Thread-On	Brass	A/C	Standard thread on robotic retaining head
404-54-25	TOUGH ACCESS Retaining Head	25	SD	Slip-On	Brass	A/C	TOUGH ACCESS SD retaining head, to be used with 404-17 neck insulator
404-61-25	TIGHT RADIUS Retaining Head	25	HD	Slip-On	Brass	A/C	Use with TIGHT RADIUS nozzles, 404-62 tip holder & 402-27-02 neck insulator.
404-71	Diffuser	25	HD	Thread-On	Copper	W/C	Diffuser for 600 amp TOUGH GUN Robotic Water-Cooled MIG Gun

Retaining Heads/Diffusers - 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
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) Tips
0.250" Outside Diameter (O.D.)

		Qty
403-14-23-25	for 0.023" (0.6 mm)	25
403-14-30*	for 0.030" (0.8 mm)	100
403-14-35*	for 0.035" (0.9 mm)	100
403-14-1.0*	for 0.040" (1.0 mm)	100

SD Tapered Tips *(0.250" O.D.)*

403-12-30-25	for 0.030" (0.8 mm)	25
403-12-35-25	for 0.035" (0.9 mm)	25
403-12-45-25	for 0.045" (1.2 mm)	25
403-12-52-25	for 0.052" (1.4 mm)	25

Extended Life Tips *(0.310" O.D.)*
(Chrome Zirconium)

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

Heavy Duty (HD) Tips *(0.310" O.D.)*

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

HD Tapered Tips *(0.310" O.D.)*

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

Extra Heavy Duty Tips *(0.375" O.D.)*

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

TOUGH LOCK Teach Tips *(0.310" O.D.)*
(for robotic programming)

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

** Other quantities available, contact Customer Service for more information.*