Continuum™ Systems

Quick Specs

Heavy Industrial Manufacturing
- Construction equipment
- Automotive components
- Recreational vehicles
- Farm machinery
- Office furniture
- Mining machinery
- Industrial fabrication

Processes
Advanced MIG processes:
- Accu-Pulse® pulsed MIG (GMAW-P)
- Versa-Pulse®
- RMD®
- MIG (GMAW)
- High-deposition MIG (GMAW)
- Flux-cored (FCAW)
- Air carbon arc (CAC-A)

Input Power
Auto-Line™ 230–575 V
3-phase, 50/60 Hz

Rated Output
350: 350 A at 100% duty cycle
500: 500 A at 100% duty cycle

Output Range
350: 20–400 A, 10–44 V
500: 20–600 A, 10–44 V

Take your welding to the next level

Advanced industrial welding solution improves productivity through weld quality, ease of use and system flexibility.

The Continuum system delivers exceptional arc performance with less spatter and higher-quality welds on both thin and thick metals. With user-friendly controls and system modularity, Continuum will make challenging jobs easier, and improve productivity — giving you a competitive advantage.

Insight

Integrated Welding Intelligence™ solutions deliver information to measure and improve your welding operation. See page 6 for more information.

Continuum 500 MIGRunner™ package shown (cable hanger, MIG 4/0 kit and motor cable not pictured). Filler metal sold separately.

Power source is warranted for three years, parts and labor.
Original main power rectifier parts are warranted for five years.
Gun warranted for 90 days, parts and labor.
Tru-Feed™ technology provides precise feeding operation for stable arc performance.

- **Low-inertia motor** provides faster response for the best arc starts with the least amount of spatter.
- **Balanced-pressure drive-roll design and tensioners** feed wire in its truest and straightest form for consistent feedability, resulting in better welding performance.

Spring-loaded Accu-Mate™ connection aligns gun perfectly in the drive-roll carrier — preventing the gun from being pulled loose and providing consistent wire feeding.

Quick-change dual-bearing drive rolls give you more consistent wire feeding.

Drive rolls and guides are common with other Miller industrial feeders (use existing, not new parts).

Inlet guide installation is toolless.

Toolless positive-locking rotatable drive assembly allows operator to rotate the drive, eliminating severe bends in the wire feed path. This extends gun-liner life and aids in feeding difficult wires.

Display and controls for program select, volts/arc length and wire feed speed

Memory buttons for quick program recall

LCD setup screen
- For easy selection of welding processes and functions
- Industrial design, full color display

Arc control to fine tune the welding arc

Trigger hold, jog and purge buttons

Quality-engineered rear cable management protects your connections to keep you productive.

Wind Tunnel Technology™ Internal air flow that protects electrical components and PC boards from dirt, dust, debris — greatly improving reliability.

Fan-On-Demand™ operates only when needed reducing noise, power consumption, and the amount of airborne contaminants pulled through the machine.

**AUTO-LINE Technology**

Allows for any input voltage hookup (230—575 V) with no manual linking. Provides convenience in any job setting and eliminates weld defects caused by dirty or unreliable power.
Continuum™ System Advantages

Intuitive user interface makes Continuum easier to use

Simple to set up and adjust with minimal training.

LCD display shows complete words, graphics and numeric values.

Memory buttons allow weld operators to quickly and easily change programs.

Remote connection to easily view and adjust machine parameters from virtually anywhere in the world using any Web-enabled device.

Easily update firmware, configure machine settings, view diagnostics and more.

USB functionality allows custom settings to be saved on a USB flash drive for duplicating settings for a specific operator, job, or to manage fleet configurations. The USB port is also used to update software.

Ability to set locks and limits for improved quality control using webpages.

Easy system interface and configuration via the Continuum webpage interface

- To use the webpage interface connect to the Continuum power source one of three ways:
  - Connect to factory network via Wi-Fi
  - Connect to factory network via Ethernet cable
  - Direct connect to PC via Ethernet cable (see page 10 for recommended Ethernet cable)

- Select language preference
- Check system status and vital information
- Configure machine settings
  - Locks and limits
  - Enable programs
  - Enable processes
- Set up programs
- View productivity information and various logs
  - Resettable/lifetime arc hours
  - Error logs
  - Heat input
  - And more
- Great for validating proper system setup as well as troubleshooting issues

Continuum grows with your business needs

Adaptable to a variety of weld cell configurations and requirements.

Control interface can be located on the bench feeder or on the remote operator interface (ROI) (see page 11 for configurations).

Welding Intelligence.” Improve your welding operations by increasing productivity, improving quality and managing costs.

Easily add processes and programs via the USB interface.

Wire feeder is easily configurable for standard spool sizes, 60-pound spools or bulk-feeding systems.

Auxiliary power outlets (factory option) for convenient operation of 120-volt electrical devices.
Continuum™ System Processes

Take the performance of each process to the highest level

Accu-Pulse®
- The most popular process for majority of industrial welding applications
- Most adaptive arc on 16 gauge (1.6 mm) and thicker
- Designed for all weld positions

Versa-Pulse™
- Fast, low-heat, low-spatter process — for materials 1/4 inch (6.35 mm) and thinner
- Great for gap filling
- Shortest arc length/lowest pulse voltage for lower heat and lower spatter at higher speeds

RMD®
- Lowest heat process, best for gap handling
- Limited travel speed

MIG
- Lower spatter than traditional MIG welders
- Better arc performance with silicon bronze and coated materials

High-deposition MIG
- Higher deposition rates than standard spray transfer on thicker materials
- Designed for welding applications in which spray transfer is preferred

<table>
<thead>
<tr>
<th>Best For</th>
<th>Standard Spray</th>
<th>High-Deposition MIG</th>
<th>Accu-Pulse</th>
<th>Versa-Pulse</th>
<th>Short Circuit</th>
<th>RMD</th>
</tr>
</thead>
<tbody>
<tr>
<td>Deposition</td>
<td>A</td>
<td>A</td>
<td>A</td>
<td>B</td>
<td>D</td>
<td>D</td>
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<tr>
<td>Gap Filling</td>
<td>D</td>
<td>D</td>
<td>B</td>
<td>B</td>
<td>A</td>
<td>A</td>
</tr>
<tr>
<td>Low Heat Input</td>
<td>D</td>
<td>C</td>
<td>B</td>
<td>A</td>
<td>A</td>
<td>A</td>
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<tr>
<td>Out-of-Position Welds</td>
<td>A</td>
<td></td>
<td>B</td>
<td>B</td>
<td>B</td>
<td></td>
</tr>
<tr>
<td>Low Spatter</td>
<td>A</td>
<td>A</td>
<td>A</td>
<td>B</td>
<td>C</td>
<td>B</td>
</tr>
<tr>
<td>Thick Metals</td>
<td>A</td>
<td>A</td>
<td>A</td>
<td>C</td>
<td>D</td>
<td>D</td>
</tr>
<tr>
<td>Thin Metals</td>
<td>B</td>
<td></td>
<td>A</td>
<td>A</td>
<td>A</td>
<td></td>
</tr>
<tr>
<td>Increased Travel Speed</td>
<td>A</td>
<td>A</td>
<td>A</td>
<td>B</td>
<td>C</td>
<td></td>
</tr>
</tbody>
</table>

Ratings A, B, C, and D are relative values. An “A” rating indicates a best fit between your performance needs and process. A “blank” rating indicates that the process is not recommended for that application.
**Continuum™ Power Source Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Model</th>
<th>Amp/Volt Ranges</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 50/60 Hz, 3-Phase</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Continuum 350</td>
<td>20–400 A</td>
<td>350 A at 31.5 VDC, 100% duty cycle</td>
<td>36.7 21.8 20.8 18.8 14.6 14.4 13.8 0–1* 0–1* 0–1* 0–1* 0–1* 0.8* 0.17*</td>
<td>71 VDC</td>
<td>H: 27.19 in. (691 mm) W: 17.5 in. (444 mm) D: 28.13 in. (714 mm)</td>
<td>127 lb. (57.6 kg)</td>
</tr>
<tr>
<td>Continuum 500</td>
<td>20–600 A</td>
<td>500 A at 39 VDC, 100% duty cycle</td>
<td>57.6 34.7 33.2 28.9 23.3 23.1 21.9 0–1* 0–1* 0–1* 0–1* 0–1* 0.8* 0.17*</td>
<td>71 VDC</td>
<td>H: 13.81 in. (351 mm) W: 17.5 in. (444 mm) D: 29.69 in. (754 mm)</td>
<td>148 lb. (67.1 kg)</td>
</tr>
</tbody>
</table>

*While idling.

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

**Continuum™ Feeder Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Welding Power Source</th>
<th>Input Welding Circuit Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Diameter Capacity</th>
<th>Maximum Spool Size Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>50 VDC</td>
<td>Continuum 350 or 500</td>
<td>500 A at 100% duty cycle</td>
<td>Standard 50–1,000 ipm (1.27–25.4 m/min.)</td>
<td>.035–.064 in. (0.9–2.0 mm)</td>
<td>18 in. (457 mm) 60 lb. (27 kg)</td>
<td>H: 13.81 in. (351 mm) W: 16.31 in. (414 mm) D: 29.69 in. (754 mm)</td>
<td>Single 43 lb. (19.5 kg) Dual 61.5 lb. (27.9 kg)</td>
</tr>
</tbody>
</table>

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

**Performance Data**

![Duty Cycle Chart](chart.png)

**Mounting Specifications**

**Bottom View**

A. 16.093 in. (409 mm)  
B. 17.5 in. (444 mm)  
C. 17.375 in. (441 mm)  
D. 2.28 in. (58 mm)  
E. 26.172 in. (665 mm)  
F. .468 in. (12 mm) dia.  
G. .468 in. x 1 in. (12 x 25 mm)

Height: 27.187 in. (691 mm)  
Width: 17.5 in. (444 mm)  
Depth: 28.125 in. (714 mm)
Insight Welding Intelligence™

Transform data into actionable information that drives continuous improvement. Learn more at MillerWelds.com/insight

Insight Core™ (Standard)

Simple, cloud-based welding information management solution that reports operator productivity and deposition, as well as weld parameter verification.

- Provides basic production metrics such as amps, volts, wire feed speed, arc on time and arc on time percentage

Insight Centerpoint™ (Optional)

Advanced, real-time operator feedback solution to prevent missed welds, enforce proper weld sequences and ensure consistent weld quality.

- With built-in features like Part Tracking™ to detect a bad weld and built-in reporting and welding analytics tools, Insight Centerpoint can help reduce rework costs and improve quality

Cost of a missed weld or defect

Part Tracking actively detects a bad weld when it happens to reduce rework and improve quality.

- Guide new inexperienced welders through the manufacturing process by presenting them with visual work instructions, reducing training time and out-of-date work instructions
- Centerpoint can prevent the next weld from occurring if missing or out-of-spec welds are detected, to alert and direct the operator to which weld(s) are out of parameter, reducing inspection time
- Repair can be done at the weld cell before paint, final assembly, or finished product delivery, which significantly reduces the cost of rework and improves overall parts quality

Insight Centerpoint Ordering Information

| Ethernet Cable | See page 10 for available lengths |

Centerpoint 10 License and Activation 951809

Gas Flow Sensors

- 301472 Continuum single-wire feeder sensor kit with gas sensor (order two for dual-wire feeders, works with Insight Core and Centerpoint)
- 301478 Continuum wire drive sensor kit with gas sensor (works with Insight Core and Centerpoint)

Insight LTD Guns

- 3DM4015-45Q BTB T Series
- Q4015JS3EML BTB C Series

Visit BernardWelds.com to customize your MIG Gun.

Insight LTD Remote 301383

Wired remote that can be added to any MIG gun. Provides controls for Insight Centerpoint.
Continuum™ Swingarc™

Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Component</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>4 ft. pipe post</td>
<td>H: 4 ft. (1.2 m)</td>
<td>110 lb. (49.9 kg)</td>
</tr>
<tr>
<td>6 ft. pipe post</td>
<td>H: 6 ft. (1.8 m)</td>
<td>130 lb. (59 kg)</td>
</tr>
<tr>
<td>Swingpak base</td>
<td>L: 65 in. (1.7 m), W: 50.875 in. (1.3 m)</td>
<td>285 lb. (129 kg)</td>
</tr>
</tbody>
</table>

Note: Swingarc includes 10-foot gas hose and 10-foot weld cable for the operator to hook up.
Continuum™ Packages

Steel (push-only) MIGRunner™ Packages

<table>
<thead>
<tr>
<th>Package Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951852</td>
<td>Continuum 350 MIGRunner, air cooled</td>
</tr>
<tr>
<td>951853</td>
<td>Continuum 500 MIGRunner, air cooled</td>
</tr>
</tbody>
</table>

Packages include:
- Continuum welding power source with running gear/cylinder rack and cable hanger
- Continuum single-wire feeder
- 15 ft. (4.6 m) Bernard® BTB Gun 400 A
- 3 ft. (0.9 m) control/motor cable
- Industrial MIG 4/0 kit for single-wire feeders consisting of flowmeter regulator with 10 ft. (3 m) gas hose, 10 ft. (3 m) 4/0 feeder weld cable with lugs, and 15 ft. (4.6 m) work cable with 600-amp C-clamp
- .035/.045 in. V-groove drive rolls

Multi-material (push-pull) MIGRunner™ Packages

<table>
<thead>
<tr>
<th>Package Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951854</td>
<td>Continuum 350 MIGRunner, air cooled</td>
</tr>
<tr>
<td>951855</td>
<td>Continuum 500 MIGRunner, air cooled</td>
</tr>
</tbody>
</table>

Packages include:
- Continuum welding power source with running gear/cylinder rack and cable hanger
- Continuum dual-wire feeder
- 25 ft. (7.6 m) XR-Aluma-Pro™ Plus push-pull gun
- 15 ft. (4.6 m) Bernard® BTB Gun 400 A
- 3 ft. (0.9 m) control/motor cable
- Industrial MIG 4/0 kit for dual-wire feeders consisting of two flowmeter regulators with two 10 ft. (3 m) gas hoses, 10 ft. (3 m) 4/0 feeder weld cable with lugs, and 15 ft. (4.6 m) work cable with 600-amp C-clamp
Bernard® Best of the Best (BTB) MIG Gun

Bernard BTB Gun 400 A Q4015VS3EML
Straight handle MIG gun ships with Continuum feeders and has the best of all Bernard options. This 400-amp, air-cooled MIG gun is recommended for heavy manufacturing environments and features a fixed 60-degree neck with aluminum armor. It has an ergonomic handle with rubber grip and rear ball and socket swivel to maximize comfort while welding.

Standard QUICK LOAD™ liner AutoLength™ system.
- QUICK LOAD liners require less than half the time and effort to replace (compared to conventional liners)
- The liner feeds from the front of the MIG gun — no need to remove the gun from the feeder or to cut and waste wire
- The AutoLength power pin contains a spring-loaded module that applies constant pressure on the liner, keeping it seated properly in the retaining head
- Allows for up to one-inch (2.54 cm) forgiveness if the liner is too short or moves during welding
- Reduces burnbacks and improves wire feedability by aligning wire from liner with contact tip

Available in air- or water-cooled versions in multiple lengths for extended reach with trouble-free, reliable feeding.

Aluminum-series-specific tension setting ensures smooth wire feeding performance with 4000 or 5000 series aluminum wires.

Replaceable feed cable liner is designed to provide consistent arc performance. It also reduces parts cost and service time by allowing a simple means of removing and replacing liner and not the complete feed cable.

Easy-to-rotate self-seating head tube allows for better access into tight spots, providing excellent current transfer.

Isolated common knurled drive roll helps reduce wear, reducing down time and cost.

Serviceability. These guns feature a full-length hook-and-loop seamed leather jacket with integrated strain reliefs for easy cable maintenance and protection. Additionally, the Aluma-Pro Plus guns feature quick connections between the control cable and electrical components (trigger, motor, potentiometer).

Certified by Canadian Standards Association to both the Canadian and U.S. Standards. Conforms to European standards.

Note: XR-Aluma-Pro Plus and XR-Pistol Plus guns are only compatible with MPA Plus feeders and the left-hand drive of Continuum dual-wire bench feeders.

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XR™ Push-Pull Guns (ONLY for use with left-hand drive of dual-wire bench feeders.)

XR-Aluma-Pro® Plus Guns
- 300000001 15 ft. (4.6 m), air-cooled
- 300001001 25 ft. (7.6 m), air-cooled
- 300003001 15 ft. (4.6 m), water-cooled
- 300004001 25 ft. (7.6 m), water-cooled

XR™-Pistol Plus Guns
- 300753 15 ft. (4.6 m), air-cooled
- 300754 25 ft. (7.6 m), air-cooled
- 300755 35 ft. (10.6 m), air-cooled
- 300757 25 ft. (7.6 m), water-cooled
- 300758 35 ft. (10.6 m), water-cooled

Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Welding Current Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter Capacity</th>
<th>Dimensions</th>
<th>Net Weight (Gun only)</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR-Aluma-Pro Plus (Air-cooled)</td>
<td>300 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Requires wire kit 230708 to run 1/16 in. (1.6 mm) wire</td>
<td>H: 5 in. (127 mm) W: 2.5 in. (64 mm) D: 17 in. (432 mm)</td>
<td>2.5 lb. (1.1 kg)</td>
</tr>
<tr>
<td>XR-Aluma-Pro Plus (Water-cooled)</td>
<td>400 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Requires wire kit 230708 to run 1/16 in. (1.6 mm) wire</td>
<td>H: 5 in. (127 mm) W: 2.5 in. (64 mm) D: 17 in. (432 mm)</td>
<td>2.9 lb. (1.3 kg)</td>
</tr>
<tr>
<td>XR-Pistol Plus (Air-cooled)</td>
<td>200 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Requires wire kit 230708 to run 1/16 in. (1.6 mm) wire</td>
<td>H: 7.375 in. (187 mm) W: 1.875 in. (48 mm) D: 10.625 in. (270 mm)</td>
<td>2.2 lb. (1 kg)</td>
</tr>
<tr>
<td>XR-Pistol Plus (Water-cooled)</td>
<td>400 A at 100% duty cycle</td>
<td></td>
<td></td>
<td>H: 5 in. (127 mm) W: 2.5 in. (64 mm) D: 17 in. (432 mm)</td>
<td>2.4 lb. (1.1 kg)</td>
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</tbody>
</table>
**Genuine Miller® Accessories**

**Continuum® Running Gear/Cylinder Rack 301264**
Small footprint and easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.

**Continuum Handles/ Cable Hanger 301585**
Used to hang welding cables or MIG guns when not welding.

**Industrial MIG 4/0 Kit 300390**
For single-wire feeders

**300957**
For dual-wire feeders

Consists of flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable with 600-amp C-clamp. Dual kit comes with two flowmeter regulators and gas hoses.

**Spool Covers**
- 274613 Left cover
- 274611 Left case
- 276961 Right cover
- 276962 Right case

**Continuum Control/Motor Cables**
- 263368003 3 ft. (0.9 m)
- 263368015 15 ft. (4.6 m)
- 263368025 25 ft. (7.6 m)
- 263368050 50 ft. (15.2 m)
- 263368080 80 ft. (24.4 m)
- 263368100 100 ft. (30.5 m)

Connects power source to feeder or remote operator interface. Also connects remote operator interface to remote motor drive.

**Volt-Sense Cables**
- 242212025 25 ft. (7.6 m)
- 242212050 50 ft. (15.2 m)

Connects power source to Ethernet port of PC or network. For use with webpages and Insight Centerpoint®.

**Coolant Systems**

**Continuum Cooler 301214**
For use with water-cooled torches rated up to 500 amps. Integrated coolant flow switch ensures coolant is flowing in the system. The Continuum cooler mounts to the bottom of the Continuum power source. Power is supplied via an internal connection with the power source.

**Low-Conductivity Coolant 043810**
Sold in cases of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37 degrees Fahrenheit (-38˚C) or boiling to 227 degrees Fahrenheit (108˚C). Also contains a compound that resists algae growth.

**Drive Roll Kits and Guides**

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include four drive rolls, necessary guides and feature an anti-wear sleeve for inlet guide.

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>V-groove for hard wire</th>
<th>U-groove for soft wire or soft-shelled cored wires</th>
<th>V-knurled for hard-shelled cored wires</th>
<th>U-cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)</th>
<th>U-groove for aluminum wires contains nylon guides</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 in.  (0.9 mm)</td>
<td>151026</td>
<td>---</td>
<td>151052</td>
<td>---</td>
<td>265255</td>
</tr>
<tr>
<td>.040 in.  (1.0 mm)</td>
<td>161190</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>.045 in. (1.1/1.2 mm)</td>
<td>151027</td>
<td>151037*</td>
<td>151053</td>
<td>151070</td>
<td>265256*</td>
</tr>
<tr>
<td>.052 in. (1.3/1.4 mm)</td>
<td>151028</td>
<td>---</td>
<td>151054</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>151029</td>
<td>151039</td>
<td>151055</td>
<td>151072</td>
<td>265257</td>
</tr>
<tr>
<td>0.068/.072 in. (1.8 mm)</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>5/64 in. (2.0 mm)</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>3/32 in. (2.4 mm)</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
</tbody>
</table>
| **Nylon Wire Guides for Feeding Aluminum Wire**

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>Inlet Guide</th>
<th>Intermediate Guide</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>221912</td>
<td>242417</td>
</tr>
<tr>
<td>.047 in. (1.2 mm)</td>
<td>221912</td>
<td>205936</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>221912</td>
<td>205937</td>
</tr>
</tbody>
</table>

*Accommodates .045- and .047-inch (3/64-inch) wire.

**Wire Guides**

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>Inlet Guide</th>
<th>Intermediate Guide</th>
</tr>
</thead>
<tbody>
<tr>
<td>.023–.040 in. (0.6–1.0 mm)</td>
<td>221030</td>
<td>149518</td>
</tr>
<tr>
<td>.045–.052 in. (1.1–1.4 mm)</td>
<td>221030</td>
<td>149519</td>
</tr>
<tr>
<td>1/16–5/64 in. (1.6–2.0 mm)</td>
<td>221030</td>
<td>149520</td>
</tr>
<tr>
<td>3/32–7/64 in. (2.4–2.8 mm)</td>
<td>229919</td>
<td>149521</td>
</tr>
</tbody>
</table>

Note: U-groove drive rolls are recommended when feeding aluminum wire.
**Typical Continuum™ Installations**

**Standard installation**

1. Continuum power source
2. Continuum control/motor cable (one required)
3. Continuum feeder

- Single-wire model with Bernard® BTB MIG gun
- Dual-wire model with Bernard® BTB MIG guns

**Swingarc boom-mounted installation**

Accommodates a wide variety of semi-automatic applications, including large weldments and hard-to-reach areas.

- Ethernet cable (see page 10)

1. Continuum power source
2. Continuum control/motor cable (one required)
3. Pipe post and optional Swingpak™ base
4. Required* pipe post
5. Optional* Swingpak base
6. Continuum Swingarc with Bernard® BTB MIG gun

*Required pipe post (bolts to floor or Swingpak base) and optional Swingpak base and single/dual spool carrier must be ordered separately. See page 8.

**Remote drive motor installation**

Ideal for fixed automation and boom applications where the wire drive motor is installed/controlled remotely.

- Ethernet cable (see page 10)

1. Continuum power source
2. Continuum control/motor cable*
3. Remote operator interface (ROI)
4. Single-wire model
5. Dual-wire model
6. Remote motor drives
7. Bernard® BTB MIG guns
8. Bernard® BTB MIG guns
9. Right-hand drive
10. Left-hand drive

*Single-wire remote drive installations require two total control/motor cables. Dual-wire remote drive installations require three total control/motor cables.
### Ordering Information

#### Continuum Packages

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>951852</td>
<td>Push-only package. Includes single-wire bench feeder with Bernard BTB gun.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951853</td>
<td>See page 8 for complete package description</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951854</td>
<td>Push-pull package. Includes dual-wire bench feeder with XR-Aluma-Pro™ Plus push-pull gun and Bernard® BTB Gun. See page 8 for complete package description</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Power Sources

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>907636</td>
<td>Power source only</td>
</tr>
<tr>
<td>907636001</td>
<td>Power source with running gear/cylinder rack</td>
</tr>
<tr>
<td>907637</td>
<td>Power source with auxiliary power</td>
</tr>
</tbody>
</table>

#### Wire Feeders and Gun

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951631</td>
<td>Single-wire model with Bernard BTB Gun 400 A and .035/.045 in. V-groove drive rolls</td>
</tr>
<tr>
<td>951673</td>
<td>Dual-wire model with two Bernard BTB Guns 400 A and .035/.045 in. V-groove drive rolls</td>
</tr>
<tr>
<td>951635</td>
<td>12 ft. single-wire model with Bernard BTB Gun 400 A and .035/.045 in. V-groove drive rolls</td>
</tr>
<tr>
<td>951636</td>
<td>16 ft. single-wire model with Bernard BTB Gun 400 A and .035/.045 in. V-groove drive rolls</td>
</tr>
<tr>
<td>951725</td>
<td>12 ft. dual-wire model with two Bernard BTB Guns 400 A and .035/.045 in. V-groove drive rolls</td>
</tr>
<tr>
<td>301227</td>
<td>Control box for single-wire drive assembly</td>
</tr>
<tr>
<td>301434</td>
<td>Control box for dual-wire drive assembly</td>
</tr>
<tr>
<td>301216</td>
<td>Left-hand single-wire drive assembly</td>
</tr>
<tr>
<td>301215</td>
<td>Right-hand single-wire drive assembly</td>
</tr>
<tr>
<td>Q4015VS3EML</td>
<td>Push-only MIG gun</td>
</tr>
</tbody>
</table>

#### XR™ Push-Pull Guns

- ONLY for left-hand drive of dual-wire bench feeder. See page 9

#### Cables

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951809</td>
<td>Centerpoint 10 license and activation for Continuum</td>
</tr>
</tbody>
</table>

#### Welding Intelligence™ Software

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951890</td>
<td>Centerpoint gas flow sensors</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>043810</td>
<td>1-gallon plastic bottle (must be ordered in quantities of 4)</td>
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</table>

#### Accessories

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>301264</td>
<td>For Continuum power source</td>
</tr>
<tr>
<td>301585</td>
<td>Available for single- and dual-wire bench feeders. See page 10</td>
</tr>
</tbody>
</table>

**Date:**

**Total Quoted Price:**

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**Distributed by:**

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