

Necks

MIG Welding Accessory

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The Right Tool for the Job.

To improve comfort and minimize downtime, we offer a wide variety of interchangeable necks for greater flexibility and better weld puddle visibility.

New! and Improved durable Q-Nut Cover.

A wide selection of fixed and rotatable necks are available for Best of the Best Platform MIG Guns - from 200 - 600 amp.

New! Dual thread on rotatable and fixed necks allow for your choice of Centerfire™, Quik Tip™ or TOUGH LOCK™ Consumable Series.

Rotatable necks changeover and rotate without tools.

Large tapered gun connection improves conductivity for better weld quality, lessens heat to increase operator comfort.

Available in multiple lengths and bends for limited access positions and improved operator comfort.

Rotatable necks are easily removable for Jump Liner changeover.



Made with
Pride and without
Compromise in the **USA**

CALIFORNIA PROPOSITION 65 WARNING

Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and in some cases, cancer. (California Health and Safety Code Section 25249.5 et seq.)

This product contains chemicals, including lead, known to the state of California to cause cancer, and birth defects or other reproductive harm. *Wash hands after use.*

Bernard

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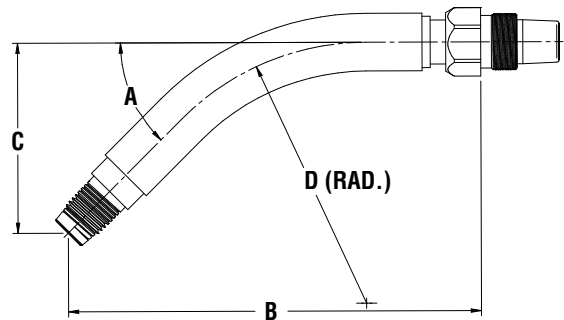
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1-519-737-3030 (International)

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For more information, visit us at BernardWelds.com

BERNARD™

Fixed Necks on Curved Handles and All Rotatable Necks

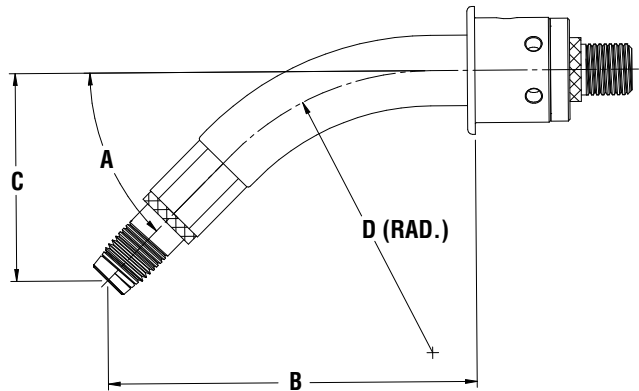
Neck	A	B		C		D	
	DEGREE	IN.	MM.	IN.	MM.	IN.	MM.
QT2-30	30°	4.0	101.6	1.2	30.5	2.2	55.9
QT2-45	45°	3.7	94.0	1.7	43.2	2.2	55.9
QT2-60	60°	4.6	116.8	2.7	68.6	2.2	55.9
QT2-80	80°	3.8	96.5	3.3	83.8	2.2	55.9
QT3-30	30°	5.4	137.2	1.8	45.7	3.2	81.3
QT3-45	45°	5.1	129.5	2.3	58.4	3.2	81.3
QT3-60	60°	4.6	116.8	2.9	73.7	3.2	81.3
QT3-80	80°	5.1	129.5	4.6	116.8	3.2	81.3
QT5-30	30°	7.5	190.5	2.1	53.3	5.0	127
QT5-45	45°	7.0	177.8	3.1	78.7	5.0	127
QT5-60	60°	6.4	162.6	3.8	96.5	5.0	127
QT2-45-12	45°	12.1	307.3	1.7	43.2	2.2	55.9
QT2-45-18	45°	18.1	459.7	1.7	43.2	2.2	55.9
QT2-45-24	45°	24.1	612.1	1.7	43.2	2.2	55.9
QT-180-3	0°	4.2	106.7	-----	-----	-----	-----
QT-180-5	0°	5.9	149.9	-----	-----	-----	-----
QT-180-7	0°	8.0	203.2	-----	-----	-----	-----
QT-180-12	0°	12.6	320	-----	-----	-----	-----
QT-180-18	0°	18.6	472.4	-----	-----	-----	-----
QT-180-24	0°	24.6	624.8	-----	-----	-----	-----



Fixed Necks on Straight Handles

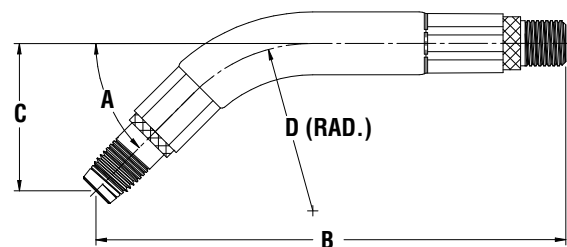
T Series Large Straight Handle

Neck	A	B		C		D	
	DEGREE	IN.	MM.	IN.	MM.	IN.	MM.
305-45	45°	3.84	98	1.76	45	2.0	51
305-60	60°	3.24	82	2.52	64	2.0	51
405-45	45°	3.85	98	2.21	56	3.0	76
405-60	60°	4.03	102	3.12	79	3.0	76
405-45LL	45°	7.35	187	2.21	56	3.0	76
405-60LL	60°	7.53	191	3.12	79	3.0	76
505-45	45°	7.89	150	2.52	64	4.0	102
505-60	60°	5.08	129	3.66	93	4.0	102



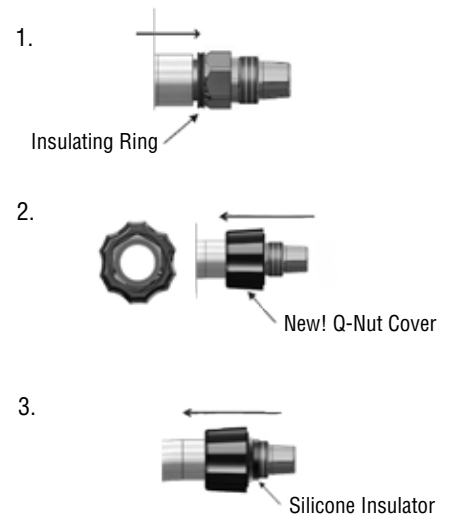
T Series Small Straight Handle

Neck	A	B		C		D	
	DEGREE	IN.	MM.	IN.	MM.	IN.	MM.
205-45	45°	4.54	115	1.82	46	2.0	51
205-60	60°	4.18	106	2.29	58	2.0	51
315-45	45°	5.61	142	1.76	45	2.0	51
315-60	60°	5.01	127	2.52	64	2.0	51
405-45NB	45°	5.59	142	2.21	56	3.0	76
405-60NB	60°	5.77	147	3.12	79	3.0	76

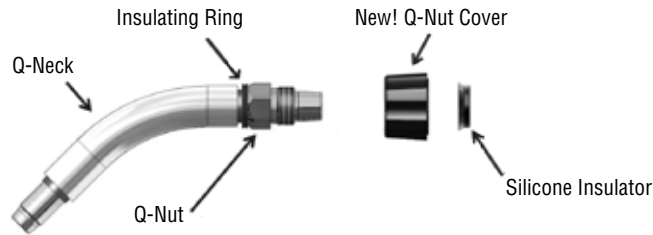


New! Q-Nut Cover Installation Instructions For Rotatable Necks

1. With gas diffuser/retaining head removed, install insulating ring over the front of the neck and into the space between the aluminum armor and the front face of the Q-Nut.
2. Line up the hex shape on the Q-Nut cover with the hex on the Q-Nut and slide the Q-Nut forward until the part bottoms out. When installed properly, there should be an approximate 1/16" gap between the rear face of the Q-Nut cover and the threads on the Q-Nut.
3. Slide the silicone insulator over the threads of the Q-Nut and press flush up against the rear face of the Q-Nut cover. Ensure that the silicone insulator is orientated in the position shown in the image below.

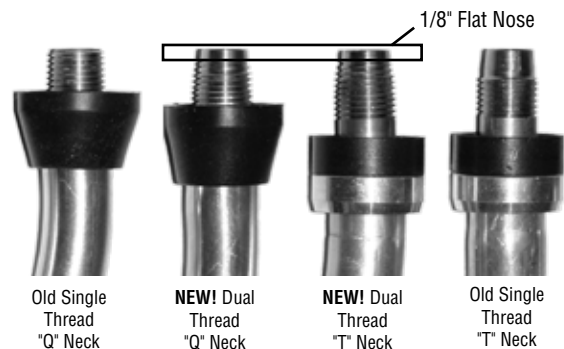


Pictorial Glossary:



New! Dual Thread vs. Old Single Thread

Beginning on June 2, 2014, Bernard's new Best of the Best Platform brings the Q-Gun™, S-Gun™ and T-Gun™ MIG Guns into a single gun line and single configurator. As part of this launch, all fixed and rotatable necks offered through the new Best of the Best MIG Gun Configurator will now feature a dual thread that allows the installation of your choice of consumables - TOUGH LOCK™, Centerfire™ or Quik Tip™ - without the need for special adaptor parts. There is a subtle difference to the appearance of the threads on the necks as shown below:



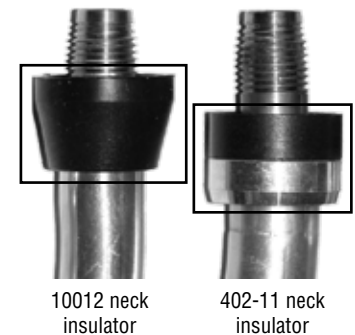
Neck Insulators

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

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

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

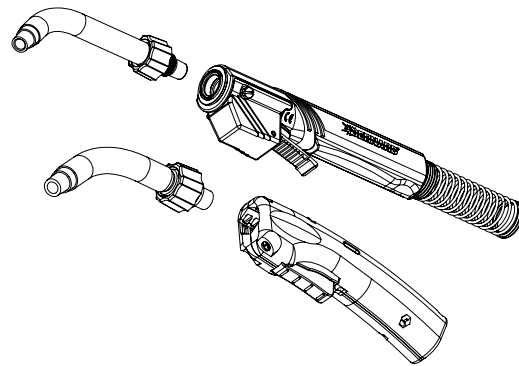
Neck/Handle	Consumables	200A	300A	400A	500A	600A
		Insulator Part Number				
Fixed Necks for T Series Straight Handles	Centerfire™	4523R		4423R		
	Quik Tip™	4423R				
	TOUGH LOCK™	402-11				
Rotatable Necks for O, B, T Series	Centerfire	4523R		4423R		
	Quik Tip	4423R				
	TOUGH LOCK	10012				
Fixed Necks for O and B Series Handles	Centerfire	4523R		4423R		
	Quik Tip	4423R				
	TOUGH LOCK	10012				



Neck Replacement Instructions

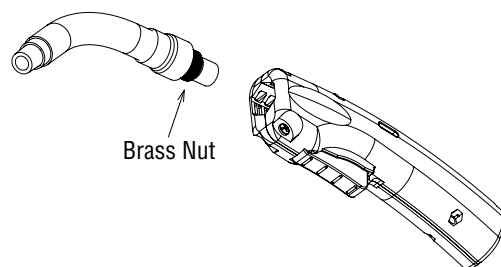
A. Changing the Neck - Rotatable

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



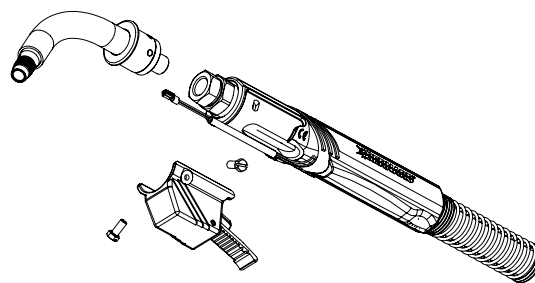
B. Changing the Neck - Fixed with Curved Handle

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



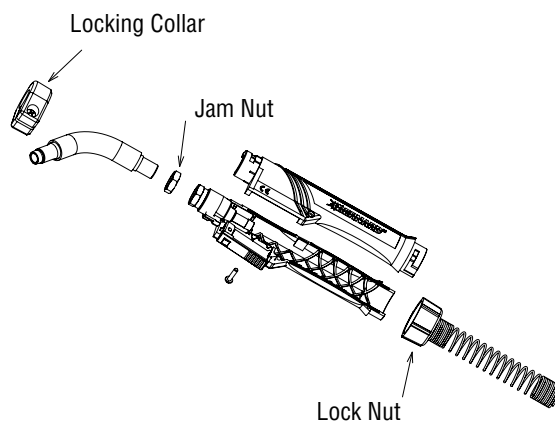
C. Changing the Neck - Fixed with T Series Large Straight Handle

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



D. Changing the Neck - Fixed with T Series Small Straight Handle

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



Additional resources are available in the Technical Support Section of our website at BernardWelds.com

Subject to Change - The information presented in this Spec Sheet is accurate to the best of our knowledge at the time of printing. Please refer to BernardWelds.com for the most up-to-date information.

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