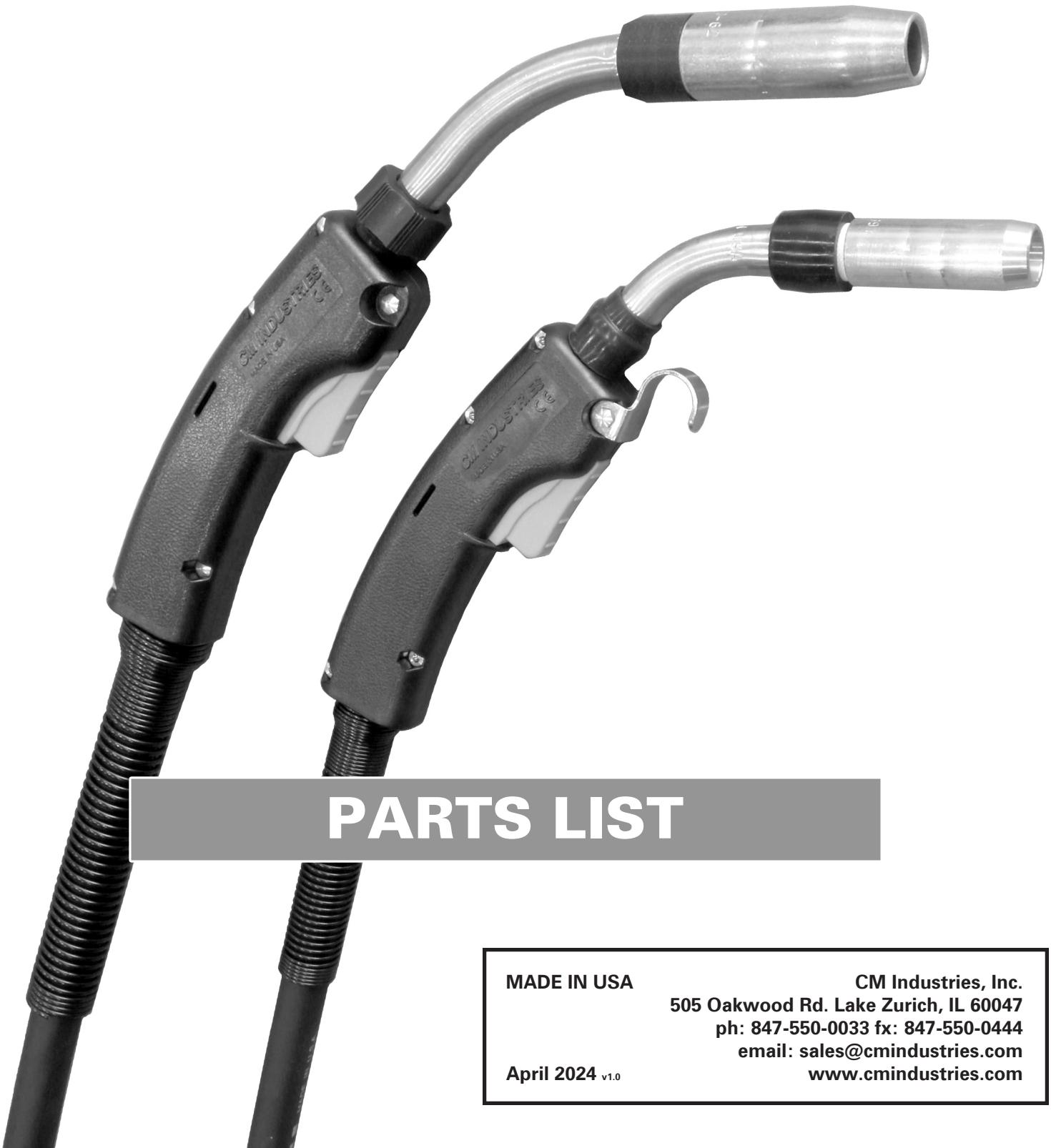


CM INDUSTRIES
INC.

B-Series MIG Guns

Semi-Automatic, Air-Cooled, MIG Welding Gun

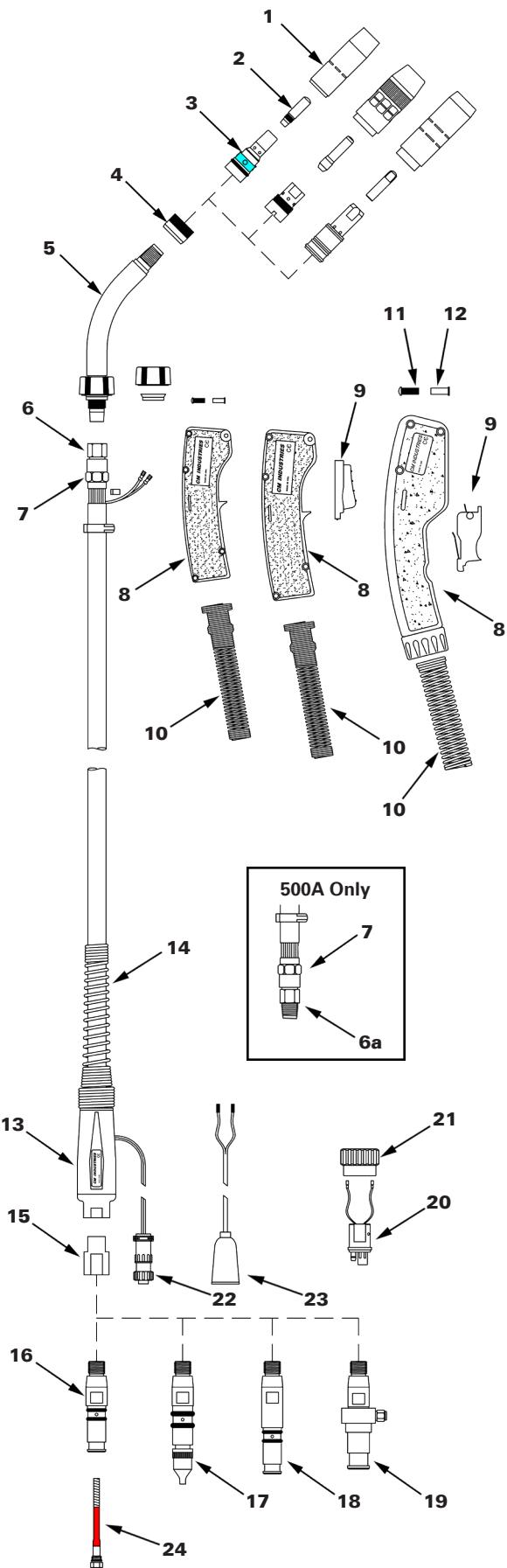


MADE IN USA

CM Industries, Inc.
505 Oakwood Rd. Lake Zurich, IL 60047
ph: 847-550-0033 fx: 847-550-0444
email: sales@cmindustries.com
www.cmindustries.com

April 2024 v1.0

PARTS LIST - B-Series Replacement Parts for 200, 300, 400 & 500 Amps



ITEM #	PART #				DESCRIPTION		
	Q20	Q30	Q40	Q50			
1	152-10-62C		152-30-62C		Nozzle, CMI Taper-LOCK™		
	R401-5-62		R401-6-62		Nozzle, Tregaskiss™ Comparable		
	B4391		B4491	B4591	Nozzle, Bernard™ Comparable		
	See Nozzle Selection				Nozzle, Optional Available		
2	See Contact Tip Selection				Contact Tip		
3	154-R505				Diffuser, CMI Taper-LOCK™		
	R404-20				Diffuser, Tough Lock™ Comparable		
	DS-1	D-1			Diffuser, Centerfire™ Comparable		
	B4335	B4435			Diffuser, Short Elliptical Tip		
4	B4235			B4635	Diffuser, Long Elliptical Tip		
	B10012				Neck Insulator, CMI Taper-LOCK™/Tough Lock™		
	B4323R		B4423R		Neck Insulator, Elliptical		
	See Neck in Ordering Information				Neck		
5	B4213B	B4313B	B1660086	B4513B	End Fitting (500Amp Front Only)		
6a	N/A			B4513M	End Fitting (500Amp Rear Only)		
7	B4305	B1540003	B4416		Cone Nut		
8	B1880155		N/A		Handle Kit, Small		
	N/A		B1880198	N/A	Handle Kit, Medium		
	N/A			B4408	Handle Kit, Large		
	B5662			B4422	Trigger Assembly		
10	B2520074		N/A		Spring for Small Handle		
	N/A		B2520042	N/A	Spring for Medium Handle		
	N/A			185-40-001	Spring for Large Handle		
	B4209			B4409	Handle Screw		
11	B4207			B4407	Post Fastener		
12	B1880004			B4426	Screw/Post Kit		
	B2520066				Strain Relief Kit		
	B2520041S		B2520041		Strain Relief Spring		
	B1010027R				Adapter Block		
13	214				Power Pin, Tweco® #4		
14	214-1				Power Pin, Miller®		
	214-116				Power Pin Cap, .023"-1/16"		
	214-332				Power Pin Cap, 5/64"-3/32"		
	214-25				Power Pin, Lincoln® PM & LF		
15	214-7				Power Pin, Lincoln® LN		
16	B5060CM				Euro Connector Plug		
	B4816				Euro Connector Nut		
	BGN2021				Control Plug, Miller® / Lincoln® PM		
	B4719				Control Plug, Lincoln® LN & LF		
17	See Liner Selection				Liner		



Scan this QR Code to take you directly to the Technical Info page of cmindustries.com

Consumable Selection

Nozzles (Optional Available)

CM Industries Taper-LOCK™

Light Duty

152-10-50C	1/2", 1/8" Recess
152-10-62C	5/8", 1/8" Recess
152-11-50C	1/2", 1/4" Recess
152-12-50C	1/2", Flush
152-13-50C	1/2", 1/8" Stickout
152-13-62C	5/8", 1/8" Stickout

Heavy Duty

152-30-50C	1/2", 1/8" Recess
152-30-62C	5/8", 1/8" Recess
152-31-562	5/8", 1/4" Recess
152-32-62C	5/8", Flush
152-33-62C	5/8", 1/8" Stickout
152-34-62C	5/8", 1/4" Stickout

Comparable to Tregaskiss™

Light Duty

R401-4-38	3/8", Flush
R401-4-50	1/2", 1/8" Recess
R401-4-62	5/8", 1/8" Recess
R401-4-75	3/4", 1/8" Recess
R401-8-62	5/8", 1/8" Stickout

Heavy Duty

R401-5-50	1/2", 1/4" Recess
R401-5-62	5/8", 1/4" Recess
R401-5-75	3/4", 1/4" Recess
R401-6-50	1/2", 1/8" Recess
R401-6-62	5/8", 1/8" Recess
R401-6-75	3/4", 1/8" Recess

Comparable to Bernard™

Nozzles for DS-1 Diffuser

NS-1218C	1/2", 1/8" Recess, Copper
NS-1200B	1/2", Flush, Brass
NS-1218B	1/2", 1/8" Recess, Brass
NS-5800C	5/8", Flush, Copper
NS-5818C	5/8", 1/8" Recess, Copper
NS-5800B	5/8", Flush, Brass
NS-5818B	5/8", 1/8" Recess, Brass

Nozzles for D-1 Diffuser

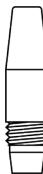
N-5800C	5/8", Flush, Copper
N-5818C	5/8", 1/8" Recess, Copper
N-5814C	5/8", 1/4" Recess, Copper
N-5818B	5/8", 1/8" Recess, Brass
N-5814B	5/8", 1/4" Recess, Brass
N-3400C	3/4", Flush, Copper
N-3418C	3/4", 1/8" Recess, Copper
N-3414C	3/4", 1/4" Recess, Copper
N-3418B	3/4", 1/8" Recess, Brass
N-3414B	3/4", 1/4" Recess, Brass

Contact Tips

CM Industries Taper-LOCK™ Contact Tips

Heavy Duty

155-1-030	0.030" (0.8mm)
155-1-035	0.035" (0.9mm)
155-1-040	0.040" (1.0mm)
155-1-045	.045" (1.2mm)
155-1-364	3/64" (1.2mm)
155-1-052	0.052" (1.4mm)
155-1-062	0.062" (1.6mm)
155-1-1.8	0.071" (1.8mm)
155-1-564	5/64" (2.0mm)
155-1-332	3/32" (2.4mm)
155-1-764	7/64" (2.8mm)



Heavy Duty - Tapered

155-2-030	0.030" (0.8mm)
155-2-035	0.035" (0.9mm)
155-2-040	0.040" (1.0mm)
155-2-045	0.045" (1.2mm)
155-2-364	3/64" (1.2mm)
155-2-052	0.052" (1.4mm)
155-2-062	0.062" (1.6mm)
155-2-078	5/64" (2.0mm)
155-2-1.8	0.071" (1.8mm)

Comparable to Bernard™ Centerfire™ Contact Tips

Heavy Duty

T-030	0.030" (0.8mm)
T-035	0.035" (0.9mm)
T-045	0.045" (1.2mm)
T-052	0.052" (1.4mm)
T-062	0.062" (1.6mm)
T-078	5/64" (2.0mm)
T-094	3/32" (2.4mm)

Tapered

TT-030	0.030" (0.8mm)
TT-035	0.035" (0.9mm)
TT-045	0.045" (1.2mm)
TT-052	0.052" (1.4mm)
TT-062	0.062" (1.6mm)

Comparable to Tregaskiss™ Tough Lock™ Contact Tips

Heavy Duty

R403-20-30	0.030" (0.8mm)
R403-20-35	0.035" (0.9mm)
R403-20-1.0	0.040" (1.0mm)
R403-20-45	0.045" (1.2mm)
R403-20-364	3/64" (1.2mm)
R403-20-52	0.052" (1.4mm)
R403-20-116	1/16" (1.6mm)
R403-20-1.8	0.071" (1.8mm)
R403-20-564	5/64" (2.0mm)
R403-20-332	3/32" (2.4mm)



Heavy Duty - Tapered

R403-21-30	0.030" (0.8mm)
R403-21-35	0.035" (0.9mm)
R403-21-1.0	0.040" (1.0mm)
R403-21-45	0.045" (1.2mm)
R403-21-52	0.052" (1.4mm)
R403-21-116	1/16" (1.6mm)



Extra Heavy Duty

R603-20-45	0.045" (1.2mm)
R603-20-52	0.052" (1.4mm)
R603-20-116	1/16" (1.6mm)
R603-20-564	5/64" (2.0mm)
R603-20-332	3/32" (2.4mm)

Conventional Liners for Aluminum

10' (3.05m) Gun Lengths

L3A-10	for 0.035" - 0.045" wire
L4A-10	for 0.045" - 1/16" wire
415-45-02	for 0.035" - 3/64" wire Polymer Liner
415-116-22	for 3/64" - 1/16" wire Polymer Liner

15' (4.57m) Gun Lengths

L1A-15	for 0.023" - 0.030" wire
L2A-15	for 0.030" - 0.035" wire
L3A-15	for 0.035" - 0.045" wire
L4A-15	for 0.045" - 1/16" wire
L6A-15	for 5/64" wire
L7A-15	for 3/32" wire
L8A-15	for 7/64" - 1/8" wire

25' (7.62m) Gun Lengths

415-45-04	for 0.035" - 3/64" wire Polymer Liner
415-35-22	for 0.035" - 0.045" wire Steel Wrapped Nylon
415-116-2	for 0.045" - 1/16" wire Steel Wrapped Nylon
415-116-23	for 0.045" - 1/16" wire Polymer Liner

Ordering Information

Amperage	
BQ20	200 Amps
BQ30	300 Amps
BQ40	400 Amps
BQ50	500 Amps

Gun Length	
08	8 ft. (2.44m)
10	10 ft. (3.05m)
12	12 ft. (3.66m)
15	15 ft. (4.57m)
20	20 ft. (6.16m)
25	25 ft. (7.63m)

Handle and Trigger	
200, 300 Amp	A Standard Trigger
Small Handle	
400 Amp	A Standard Trigger
Medium Handle	
500 Amp	A Standard Trigger
Large Handle	

BQ40 15 A E 4E M C*

Neck

A	Rotatable, Short	30° BQT2-30
B	Rotatable, Short	45° BQT2-45
C	Rotatable, Short	60° BQT2-60
J	Rotatable, Short	80° BQT2-80
D	Rotatable, Medium	30° BQT3-30
E	Rotatable, Medium	45° BQT3-45
F	Rotatable, Medium	60° BQT3-60
K	Rotatable, Medium	80° BQT3-80
G	Rotatable, Long	30° BQT5-30
H	Rotatable, Long	45° BQT5-45
I	Rotatable, Long	60° BQT5-60
N	Fixed, Short	30° BQT2-30
O	Fixed, Short	45° BQT2-45
P	Fixed, Short	60° BQT2-60
W	Fixed, Short	80° BQT2-80
Q	Fixed, Medium	30° BQT3-30
R	Fixed, Medium	45° BQT3-45
S	Fixed, Medium	60° BQT3-60
X	Fixed, Medium	80° BQT3-80
T	Fixed, Long	30° BQT5-30
U	Fixed, Long	45° BQT5-45
V	Fixed, Long	60° BQT5-60

Contact Tip

CMI Taper-LOCK™		
4B	0.030" (0.8mm)	155-1-030
4C	0.035" (0.9mm)	155-1-035
4D	0.040" (1.0mm)	155-1-040
4E	0.045" (1.2mm)	155-1-045
4R	3/64" (1.3mm)	155-1-364
4H	0.052" (1.4mm)	155-1-052
4I	1/16" (1.6mm)	155-1-062
4K	5/64" (2.0mm)	155-1-564
4L	3/32" (2.4mm)	155-1-332
<u>Compar. to Tregaskiss™ Tough Lock™</u>		
3	0.xxx" (x.xmm)	R403-20-xx
<u>Compar. to Bernard™ Centerfire™</u>		
8	0.xxx" (x.xmm)	T1xxx
<u>Compar. to Bernard™ Quik Tip™</u>		
5	0.xxx" (x.xmm)	T1xxx
<u>Compar. to Bernard™ 7-Series Elliptical</u>		
7	0.xxx" (x.xmm)	B74xx
<u>Compar. to Bernard™ 1-Series Elliptical</u>		
1	0.xxx" (x.xmm)	B15xx

Power Pin

B	Bernard™
E	Euro
H	Hobart®
L	Lincoln® LN
S	Lincoln® LF/Power Feed
R	Lincoln® Power MIG
M	Miller®
O	OXO®
P	Panasonic®
T	Tweco® 4 (Standard Lead)
W	Tweco® 5 (Standard Lead)
X	Tweco® 5 (Miller Lead)

*Universal Conventional Liner

CM Industries, Inc. is in no way affiliated with above-named manufacturers. References to above-named parts, feeders, and part numbers are for your reference only.

SAFETY WARNINGS! READ BEFORE USE

! The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the welding power source Owner's Manual.

! Read and follow all Safety Standards. Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

! During operation, keep everybody, especially children, away.

ELECTRIC SHOCK can kill.

- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrode or electrical parts.
- Replace worn, damaged, or cracked guns or cables.
- Turn off welding power source before changing contact tip or gun parts.
- Keep all covers and handle securely in place.

FUMES AND GASES can be hazardous.

- Keep your head out of the fumes.
- Ventilate area, or use breathing device. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.

WELDING can cause fire or explosion.

- Do not weld near flammable material.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F.4.1 and AWS A.6.0 (see Safety Standards).
- Watch for fire; keep extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.

HOT PARTS can burn.

- Allow gun to cool before touching.
- Do not touch hot metal.
- Protect hot metal from contact by others.



MOVING PARTS can injure.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin.

Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Check for noise level limits exceeding those specified by OSHA.
- Use approved ear plugs or ear muffs if noise level is high.
- Warn others nearby about noise hazard.



WELDING WIRE can injure.

- Keep hands and body away from gun tip when trigger is pressed.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit.
- Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.

CALIFORNIA PROPOSITION 65 WARNING

This product contains chemicals, including lead, known to the State of California to cause cancer, birth defects, or other reproductive harm. Wash hands after use. (California Health & Safety Code Section 25249.5)