

CM INDUSTRIES
INC.

T-Series MIG Guns

Semi-Automatic, Air-Cooled, MIG Welding Gun



PARTS LIST

MADE IN USA

CM Industries, Inc.
505 Oakwood Rd. Lake Zurich, IL 60047

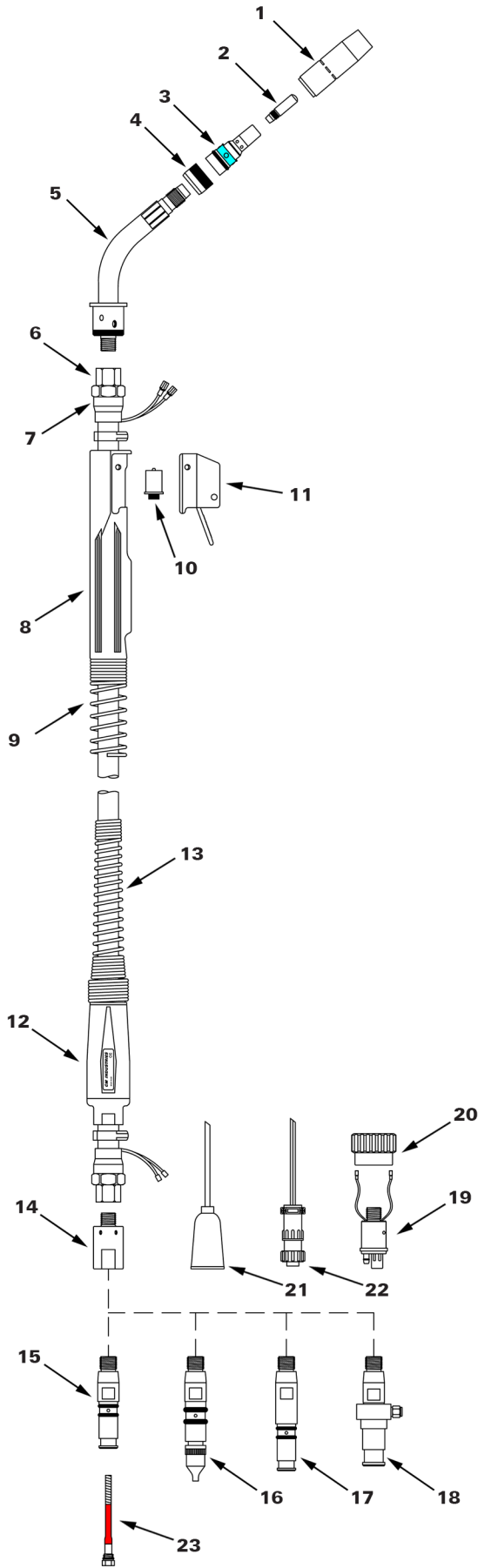
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PARTS LIST - T-Series Replacement Parts for 300, 400 & 500 Amps



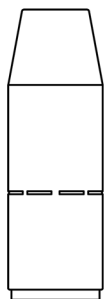
ITEM #	PART #			DESCRIPTION
	300	400	500	
1	R401-4-62	R401-6-62		Nozzle, std.
	See Nozzle Selection			Nozzle, Optional Available
2	See Contact Tip Selection			Contact Tip, CMI Taper-LOCK™
	See Contact Tip Selection			Contact Tip, Tough Lock™
3	154-R505			Diffuser, H.D., CMI Taper-LOCK™
	154-R506			Diffuser, Tapered, CMI Taper-LOCK™
	R404-20			Diffuser, H.D., Tough Lock™
	R404-26			Diffuser, Dual-Tapered, Tough Lock™
4	R402-11			Neck Insulator
5	R305-60	R405-60	R505-60	Neck, 60° - Standard
	R305-45	R405-45	R505-45	Neck, 45° - Optional
6	R408			Connector Cone
7	R409		R509	Cone Nut
8	R410			Handle
9	R413-2		R513-2	Handle Spring
10	R411-1			Switch
11	R411-2			Switch Housing
12	B2520066			Strain Relief Kit
13	B2520041-S			Strain Relief Spring
14	R414-400CM			Power Pin Block
15	214			Power Pin, Tweco® #4
16	214-1			Power Pin, Miller®
	214-116			Power Pin Cap, .023"-1/16"
	214-332			Power Pin Cap, 5/64"-3/32"
17	214-25			Power Pin, Lincoln® PM & LF
18	214-7			Power Pin, Lincoln® LN
19	R425-10CM			Euro Connector Plug
20	400-00-001			Euro Connector Nut
21	300-05-001			Control Plug, Miller® / Lincoln® PM
22	300-05-002			Control Plug, Lincoln® LN & LF
23	See Liner Selection			Liner



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Consumable Selection

Nozzles (Optional Available)



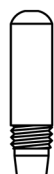
Light Duty	
R401-4-38	3/8", Flush Tip
R401-4-50	1/2", 1/8" Tip Recess
R401-4-62	5/8", 1/8" Tip Recess
R401-4-75	3/4", 1/8" Tip Recess
R401-8-62	5/8", 1/8" Tip Stickout, Short Arc
R401-42-50	1/2", Bottleneck, 1/8" Tip Recess
R401-48-50	1/2", Bottleneck, 1/8" Tip Stickout



Heavy Duty	
R401-5-50	1/2", 1/4" Tip Recess
R401-5-62	5/8", 1/4" Tip Recess
R401-5-75	3/4", 1/4" Tip Recess
R401-6-50	1/2", 1/8" Tip Recess
R401-6-62	5/8", 1/8" Tip Recess
R401-6-75	3/4", 1/8" Tip Recess
R401-7-62	5/8", 1/4" Tip Recess, Brass
R401-7-75	3/4", 1/4" Tip Recess, Brass
R401-7-87	7/8", 1/4" Tip 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	0.045" (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)



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)
155-2-1.8	0.071" (1.8mm)

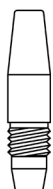


X-tra Heavy Duty	
155-3-030	0.030" (0.8mm)
155-3-035	0.035" (0.9mm)
155-3-040	0.040" (1.0mm)
155-3-045	0.045" (1.2mm)
155-3-364	3/64" (1.2mm)
155-3-052	0.052" (1.4mm)
155-3-062	0.062" (1.6mm)
155-1-564	5/64" (2.0mm)
155-3-332	3/32" (2.4mm)
155-3-764	7/64" (2.8mm)

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)

Liners

Universal Conventional Liners

10' (3.05m) Gun Lengths

L3A-10	for 0.035" - 0.045" wire
L4A-10	for 0.045" - 1/16" wire

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

L1A-25	for 0.023" - 0.030" wire
L2A-25	for 0.030" - 0.035" wire
L3A-25	for 0.035" - 0.045" wire
L4A-25	for 0.045" - 1/16" wire
L6A-25	for 5/64" wire
L7A-25	for 3/32" wire
L8A-25	for 7/64" - 1/8" wire

Conventional Liners

10' (3.05m) Gun Lengths

R415-35-10	for 0.035" - 0.045" wire
R415-116-10	for 0.045" - 1/16" wire

15' (4.57m) Gun Lengths

R415-30-15	for 0.030" - 0.035" wire
R415-35-15	for 0.035" - 0.045" wire
R415-116-15	for 0.045" - 1/16" wire
R415-564-15	for 5/64" wire
R415-332-15	for 3/32" wire

25' (7.62m) Gun Lengths

R415-30-25	for 0.030" - 0.035" wire
R415-35-25	for 0.035" - 0.045" wire
R415-116-25	for 0.045" - 1/16" wire
R415-564-25	for 5/64" wire
R415-332-25	for 3/32" wire

Conventional Liners for Aluminum

10' (3.05m) Gun Lengths

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

415-45-03	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

25' (7.62m) Gun Lengths

415-45-04	for 0.035" - 3/64" wire Polymer Liner
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Ordering Information

Amperage

RQ30	300 Amps
RQ40	400 Amps
RQ50	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

300 Amp	M	Standard Trigger
T-Series Straight Handle		
400 Amp	M	Standard Trigger
T-Series Straight Handle		
500 Amp	M	Standard Trigger
T-Series Straight Handle		

RQ40 15 M S 4E M C*

Neck

O	Fixed, Short	45°	R305-45
P	Fixed, Short	60°	R305-60
R	Fixed, Medium	45°	R405-45
S	Fixed, Medium	60°	R405-60
U	Fixed, Long	45°	R505-45
V	Fixed, Long	60°	R505-60

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

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)

Contact Tip

Comparable to Tregaskiss™


3B	0.030" (0.8mm)	R403-20-30
3C	0.035" (0.9mm)	R403-20-35
3D	0.040" (1.0mm)	R403-20-1.0
3E	0.045" (1.2mm)	R403-20-45
3R	3/64" (1.3mm)	R403-20-364
3H	0.052" (1.4mm)	R403-20-52
3I	1/16" (1.6mm)	R403-20-116
3K	5/64" (2.0mm)	R403-20-564
3L	3/32" (2.4mm)	R403-20-332


***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 defined as 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 F4.1 and AWS A6.0 (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.



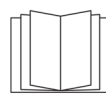
NOISE can damage hearing.

- 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)