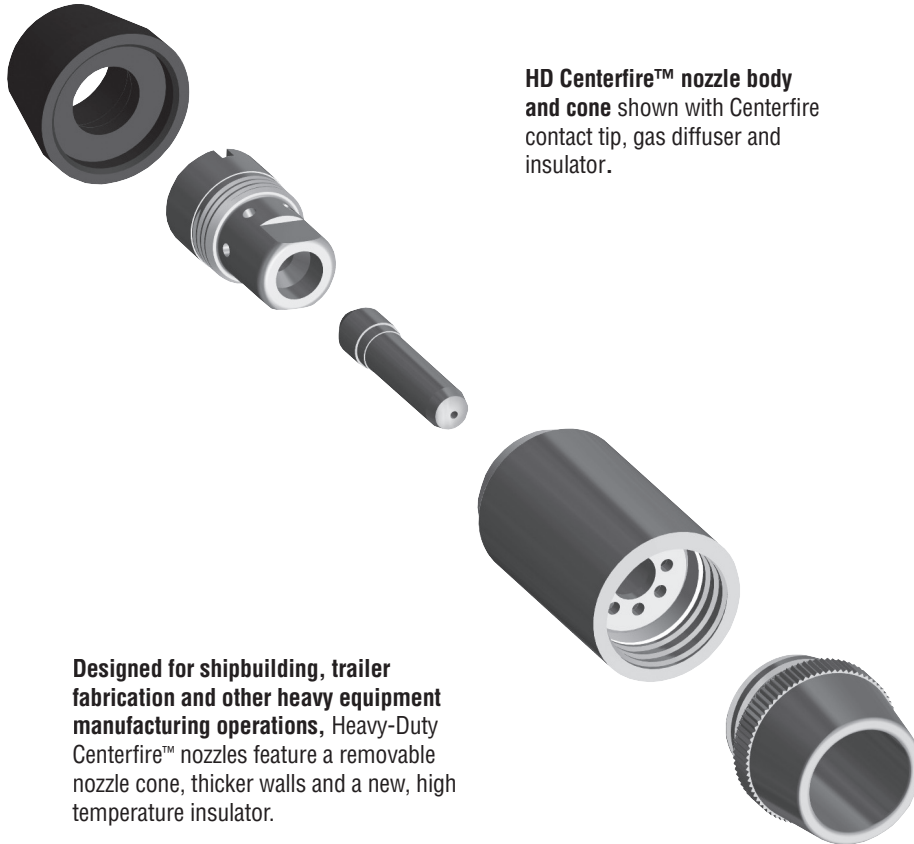


# HD Centerfire™ Series

## Nozzles

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**HD Centerfire™ nozzle body and cone** shown with Centerfire contact tip, gas diffuser and insulator.

**Designed for shipbuilding, trailer fabrication and other heavy equipment manufacturing operations**, Heavy-Duty Centerfire™ nozzles feature a removable nozzle cone, thicker walls and a new, high temperature insulator.

### All Consumables are Not Created Equal.

It's important to choose longer lasting consumables. They can make the difference between repeated consumable replacement and rework, or more arc time and better bottom line.

**Increased wall thickness and new insulating material** reduce number of changeovers caused by heat degradation.

**Removable nozzle cone lowers downtime and consumables cost** by allowing operators to replace only the cone, the most frequently damaged part of the nozzle, without removing and replacing the entire nozzle and contact tip.

**Nozzle cleaning made easy** - removable cone allows greater access to nozzle body for spatter removal.

**Built-in spatter guard produces a calmer gas flow** for improved weld puddle protection.

**Available in a variety of configurations**, with several nozzle orifices and tip recesses.

**Fully compatible with standard Centerfire contact tips, gas diffusers and insulating caps.**

**Fit most competitive brand guns** to enhance performance and allow standardization of one contact tip and nozzle for all gun brands to minimize inventory management costs.

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

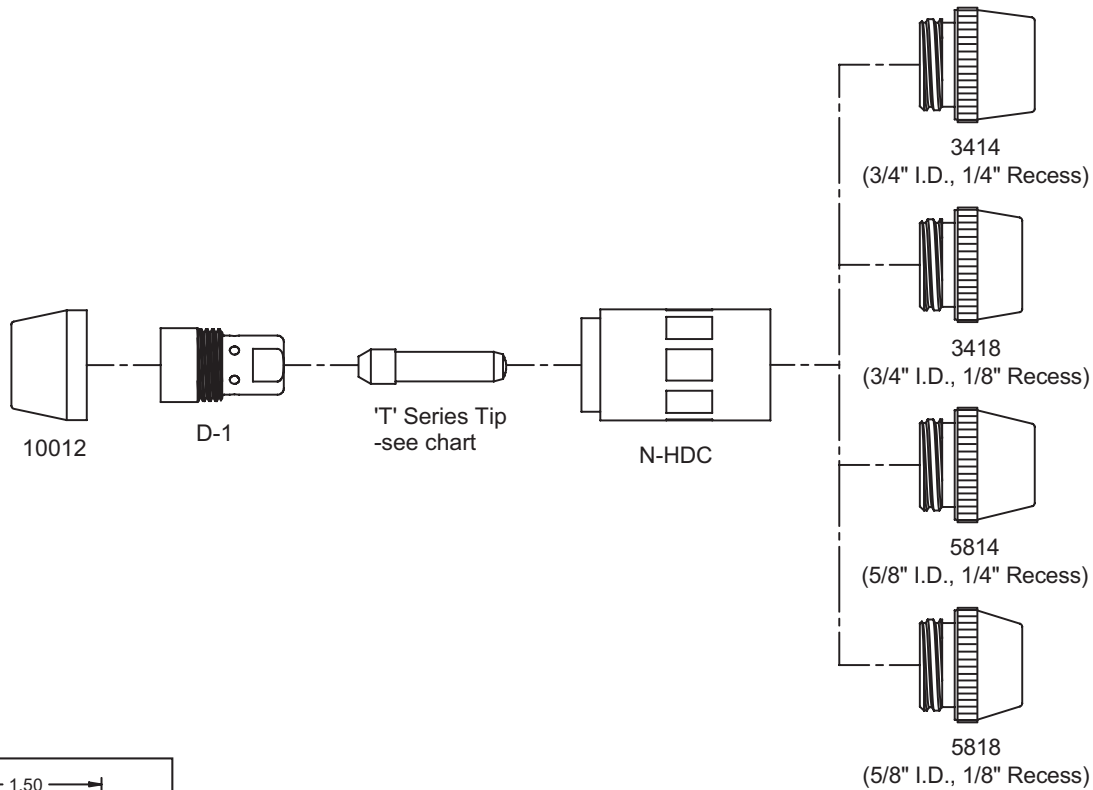
### Bernard®

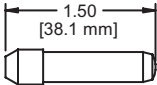
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# Available Parts



| <br>'T' Series Tip |                |
|--|----------------|
| T-023  | .023" (.6 mm)  |
| T-030  | .030" (.8 mm)  |
| T-035  | .035" (.9 mm)  |
| T-039  | .039" (1.0 mm) |
| T-045  | .045" (1.2 mm) |
| T-052  | .052" (1.4 mm) |
| T-062  | 1/16" (1.6 mm) |
| T-072  | .072" (1.8 mm) |
| T-078  | 5/64" (2.0 mm) |
| T-094  | 3/32" (2.4 mm) |
| T-109  | 7/64" (2.8 mm) |
| T-125  | 1/8" (3.2 mm)  |

- Couple the HD Centerfire nozzle body with an HD Centerfire nozzle cone to form a complete HD Centerfire nozzle.
- One nozzle body and one nozzle cone required, order separately.
- Use HD Centerfire nozzles with standard Centerfire 10012 insulator caps, D-1 gas diffusers and 'T' series contact tips.

## HD Centerfire™ Nozzle Part Number

Use an HD Centerfire nozzle cone's part number to identify its specifications. The part number below represents an HD Centerfire nozzle cone manufactured with 5/8" I.D. and 1/4" tip recess. The HD Centerfire nozzle body and all nozzle cone's are made of copper.

|  |   |                    |
|--|---|--------------------|
| <b>Nozzle Body</b>   | + | <b>Nozzle Cone</b> |
| <b>N-HDC</b>   |   | <b>5814</b>        |
| (i.e. 58 = 5/8" Orifice I.D.)<br>(i.e. 14 = 1/4" Tip Recess) |   |                    |

# Competitor Conversion

Simplify parts management and improve performance by converting all of your MIG guns to HD Centerfire nozzles and standard Centerfire tips and diffusers. Find your gun make and model on the left, then follow the chart to the right for parts needed to upgrade.

| Gun Manufacturer | Gun Model   | Gas Diffuser Style | Adapter      | Insulator | Gas Diffuser | Contact Tip               | Nozzle                      |
|------------------|---|--------------------|--------------|-----------|--------------|---------------------------|-----------------------------|
| Bernard®         | Q-Gun, EZ Feed II, G, H, F  | Large              | Not Required | 10012     | D-1          | Select from table on left | Select from drawing on left |
| Binzel®          | ALPHA 2, ALPHA 3, ALPHA 2 Automatic, ALPHA 3 Automatic                | Large              | Not Required | 4323R     | D-1B         |                           |                             |
| Lincoln®         | Magnum 250  | Large              | 1380005      | 10012     | D-1          |                           |                             |
|                  | Magnum 300, Magnum 400  | Large              | Not Required | 4423R     | D-1T         |                           |                             |
| Miller®          | XR Edge   | Large              | 1380018      | 10012     | D-1          |                           |                             |
|                  | XR30A, XR-W, M-25, Roughneck, Python                                  | Large              | Not Required | 10012     | D-1          |                           |                             |
| OXO®             | APX   | Large              | Not Required | 10012     | D-1          |                           |                             |
| Tregaskiss®      | Toughgun  | Large              | Not Required | 4423R     | D-1T         |                           |                             |
| Tweco®           | 160 Mini Mig  | Large              | 1380020      | 10012     | D-1          |                           |                             |
|                  | No. 1   | Large              | 1380019      | 10012     | D-1          |                           |                             |
|                  | No. 2   | Large              | 1380005      | 10012     | D-1          |                           |                             |
|                  | No. 3, No. 4, Tuff-n-Lite, Supra XT (HD Consumables), Spraymaster 450 | Large              | Not Required | 4423R     | D-1T         |                           |                             |
|                  | No. 5   | Large              | Not Required | 4423R     | D-1T-5       |                           |                             |
|                  | ELC 250, ELC 350, Spraymaster 250, Spraymaster 350                    | Large              | 1380012      | 10012     | D-1          |                           |                             |
|                  | ELC 450, EL 450, EL 600, Supra XT (EL Consumables)                    | Large              | 1380017      | 10012     | D-1          |                           |                             |

Centerfire™ nozzles, tips and gas diffusers are manufactured by Bernard®. Bernard® is the registered trademark of Illinois Tool Works, Inc. Other brands mentioned are for reference only and are the registered trade marks of their respective companies. Illinois Tool Works, Inc. is not affiliated with these other companies.

## Installation Instructions

### Standard Installation

1. Install insulator cap over neck.
2. Trim liner to between 5/8" and 3/4" beyond neck thread.
3. Torque diffuser onto neck to approx. 12ft-lbs.
4. Insert tip into gas diffuser.
5. Thread nozzle body onto gas diffuser/tip, and tighten firmly by hand.
6. Thread nozzle cone onto nozzle body, and tighten firmly by hand.

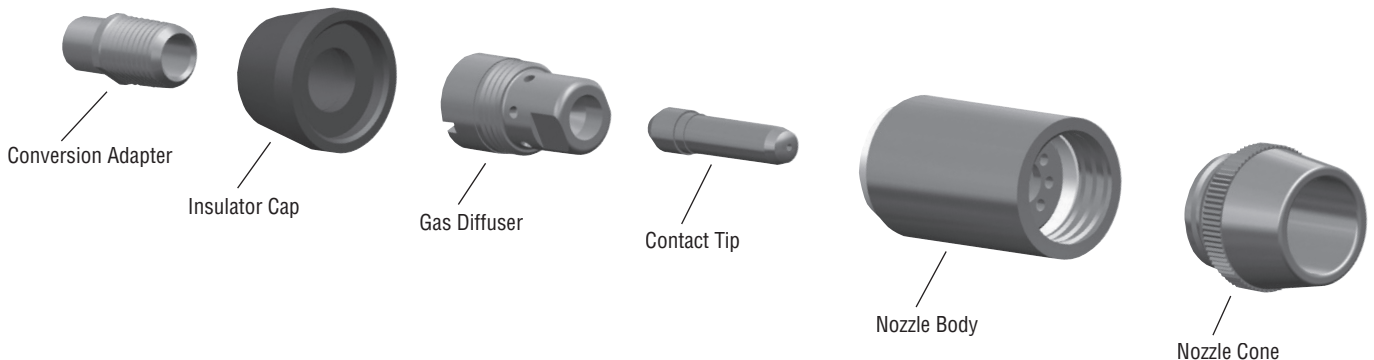
### Helpful Tip

The base of every Centerfire gas diffuser has a 3/4" diameter, and can be used as a liner trimming guide.



### Installation with Conversion Adapter

1. Install conversion adapter.
2. Install insulator cap over conversion adapter.
3. Trim liner to between 5/8" and 3/4" beyond adapter thread.
4. Torque diffuser onto adapter to approx. 12ft-lbs.
5. Insert tip into gas diffuser.
6. Thread nozzle body onto gas diffuser/tip, and tighten firmly by hand.
7. Thread nozzle cone onto nozzle body, and tighten firmly by hand.



# Notes