



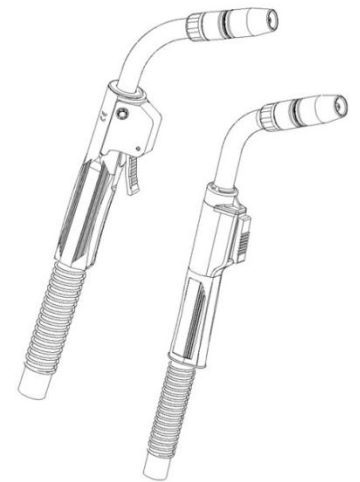
PARTS GUIDE

For TGX™ Air-Cooled MIG Guns XS180, XS260, XS300, XL300 and XL400 amp

GENERAL SAFETY

Before installation or operation of TGX™ MIG Guns, please read the safety precautions listed below.

1. Always wear a properly fitted welding helmet with the proper grade of filter plate and suitable welding gloves.
2. All exposed skin should be covered with flame resistant, protective clothing. **DO NOT WEAR CLOTHING MADE FROM FLAMMABLE SYNTHETIC FIBERS.**
3. Protective screens or barriers should be used to protect others from spatter, flash and glare while welding.
4. Prevent fires by ensuring that hot slag or sparks do not contact combustible solids, liquids or gases.
5. Ensure that operator's head is not too close to the arc and that adequate ventilation is available.
6. Constant repetitive motion may lead to cumulative trauma disorders.
7. Do not touch live electrical parts. The following should be checked to prevent electrical shock.
 - a) Equipment is adequate for the job, properly grounded and installed according to code.
 - b) Faulty or damaged equipment is repaired or replaced.
 - c) Proper operator maintenance is performed to prevent excess spatter accumulation in the nozzle, or the contact tip or other areas of the gun.
 - d) Electrical insulating components are in place and not damaged. Repair or replace if necessary.
 - e) Operator and surroundings are not wet.
 - f) Cables are not wrapped around operator's body.
 - g) Equipment is off when not in use.
8. CSA Standard W117.2 CODE FOR SAFETY IN WELDING AND CUTTING obtainable from the Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.
9. ANSI Standard Z49.1 CODE FOR SAFETY IN WELDING AND CUTTING obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018.



CALIFORNIA PROPOSITION 65 WARNING

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer.

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.*

(California Health & Safety Code Section 25249.5 at seq.)



STANDARD PARTS

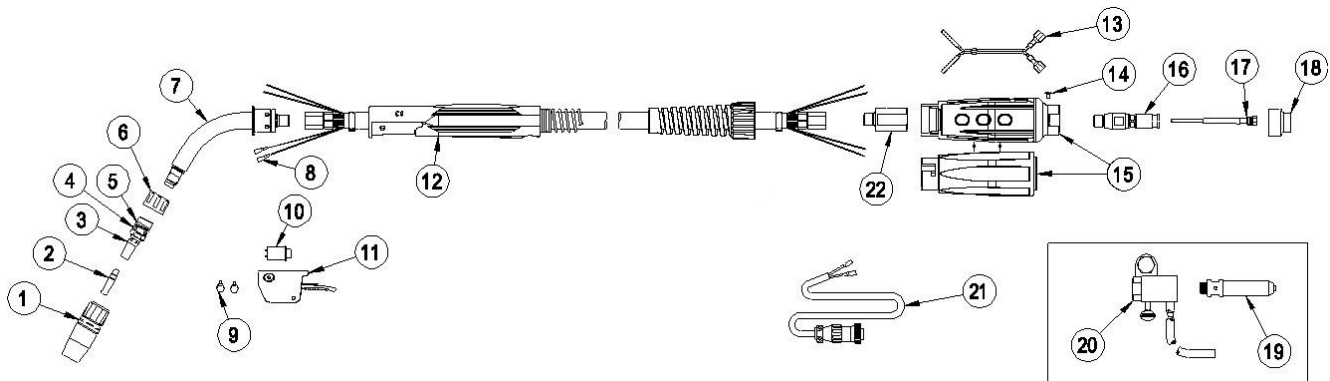
GUN MODEL	NOZZLE	CONTACT TIP	RETAINING HEAD	GOOSENECK INSULATOR	GOOSENECK	LENGTH (FT)	CHASSIS
180 amp (XS)	401-42-50	403-14-xx	404-18	402-7	205-60X	10	XS1810
						12	XS1812
						15	XS1815
260 amp (XS)	401-4-50	403-20-xx	404-26	402-7	205-60X	10	XS2610
						12	XS2612
						15	XS2615
300 amp (XS)	401-4-50	403-20-xx	404-26	402-7	205-60X	10	XS3210
						12	XS3212
						15	XS3215
300 amp (XL)	401-4-62	403-20-xx	404-26	402-7	405-60X	10	XL3010
						12	XL3012
						15	XL3015
400 amp (XL)	401-4-62	403-20-xx	404-26	402-7	405-60X	10	XL4010
						12	XL4012
						15	XL4015

AMPERAGE RATINGS

CHASSIS MODEL	60% DUTY CYCLE - MIXED GASES OR 100% DUTY CYCLE - CO ₂
180 amp XS	180 amp
260 amp XS	260 amp
300 amp XS	300 amp
300 amp XL	300 amp
400 amp XL	400 amp

NOTE: Ratings are based on tests that comply with IEC 60974-4 standards.

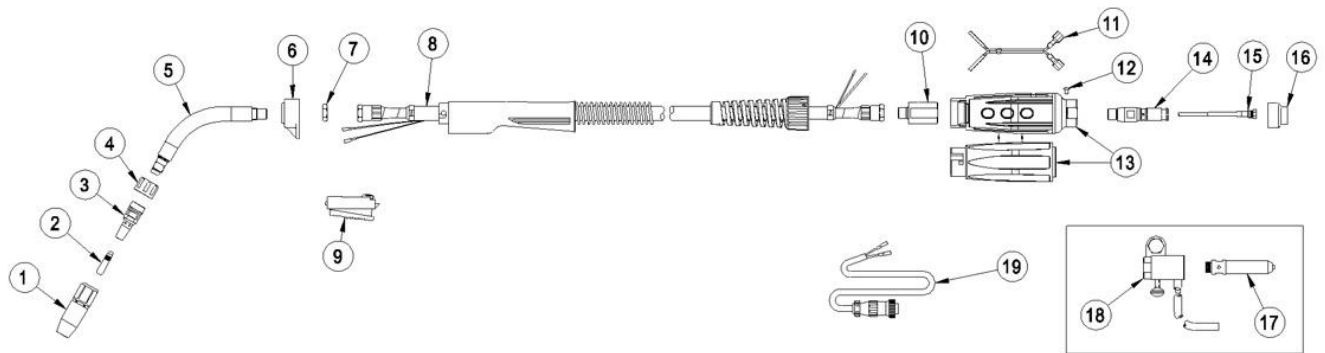
EXPLODED VIEW AND PARTS LIST – XL GUNS



Numbers in this column correspond to the exploded view images above.

PART #	DESCRIPTION
1	STANDARD DUTY NOZZLE (SELF-INSULATED)
2	403-14-xx STANDARD DUTY TOUGH LOCK™ CONTACT TIP
3	403-20-xx HEAVY DUTY TOUGH LOCK CONTACT TIP
4	404-26 HEAVY DUTY TOUGH LOCK RETAINING HEAD
5	454-1-2 RETAINING RING ONLY
6	402-6 O-RING ONLY
7	402-7 GOOSENECK INSULATOR
8	405-60X GOOSENECK 60 DEGREE 400 AMP
9	412-1 SWITCH LEAD CONNECTOR
10	411-3M MOUNTING SCREW (METRIC M5)
11	411-1 SWITCH ONLY
12	411-2X SWITCH HOUSING WITH SCREWS
13	CHASSIS
14	419-21 TGX JUMPER CABLE (SAME FOR ALL AMPERAGES)
15	S.B.H.C.S. - M4 x .7 x 6 LG
16	510X REAR HANDLE ASSEMBLY
17	214-xx POWER PIN
18	415-xx-xx LINER (CHOOSE CONVENTIONAL STYLE OR QUICK LOAD™ LINER)
19	414-400-xx POWER PIN INSULATOR
20	418-xx FEEDER ADAPTOR
	FEEDER ADAPTOR REQUIREMENTS (SOLD SEPARATELY)
	417 QUICK CONNECT BLOCK ASSEMBLY (TWECO #4)
	417-60 QUICK CONNECT BLOCK ASSEMBLY (TWECO #5)
	417-64 QUICK CONNECT BLOCK ASSEMBLY (MILLER TO EURO – DOES NOT REQUIRE FEEDER ADAPTOR ITEM 19 ABOVE)
	417-65 QUICK CONNECT BLOCK ASSEMBLY (TWECO #4 TO EURO – DOES NOT REQUIRE FEEDER ADAPTOR ITEM 19 ABOVE)
21	419-xx CONTROL PLUG
22	414-400X POWER PIN BLOCK

EXPLODED VIEW AND PARTS LIST – XS GUNS



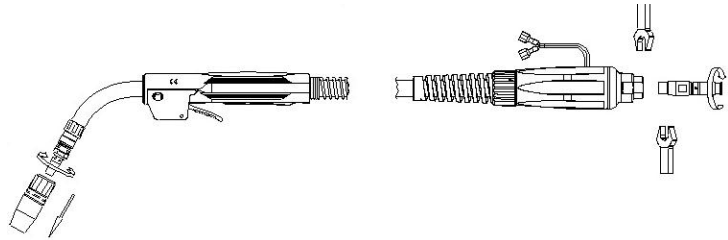
PART #	DESCRIPTION
1	STANDARD DUTY NOZZLE (SELF-INSULATED)
2	403-14-xx STANDARD DUTY TOUGH LOCK™ CONTACT TIP FOR 180 AMP (XS18xx)
	403-20-xx HEAVY DUTY TOUGH LOCK CONTACT TIP FOR 260 AMP (XS26xx) & 300 AMP (XS32xx)
3	404-18 STANDARD DUTY TOUGH LOCK RETAINING HEAD FOR 180 AMP (XS18xx)
	404-26 HEAVY DUTY TOUGH LOCK RETAINING HEAD FOR 260 AMP (XS26xx) & 300 AMP (XS32xx)
4	402-7 GOOSENECK INSULATOR
5	205-60X GOOSENECK 60 DEGREE 200 AMP
6	210-6 HANDLE LOCK NUT
7	208-2 JAM NUT
8	CHASSIS
9	211-5 SWITCH ASSEMBLY
10	414-400x POWER PIN BLOCK
11	419-21 TGX JUMPER CABLE (SAME FOR ALL AMPERAGES)
12	S.B.H.C.S. - M4 x .7 x 6 LG
13	510X REAR HANDLE ASSEMBLY
14	214-xx POWER PIN
15	415-xx-xx LINER (CHOOSE CONVENTIONAL STYLE OR QUICK LOAD™ LINER)
16	414-400-xx POWER PIN INSULATOR
17	418-xx FEEDER ADAPTOR
18	FEEDER ADAPTOR REQUIREMENTS (SOLD SEPARATELY)
	417 QUICK CONNECT BLOCK ASSEMBLY (TWECO #4)
	417-60 QUICK CONNECT BLOCK ASSEMBLY (TWECO #5)
	417-64 QUICK CONNECT BLOCK ASSEMBLY (MILLER TO EURO – DOES NOT REQUIRE FEEDER ADAPTOR ITEM 17 ABOVE)
	417-65 QUICK CONNECT BLOCK ASSEMBLY (TWECO #4 TO EURO – DOES NOT REQUIRE FEEDER ADAPTOR ITEM 17 ABOVE)
19	419-xx CONTROL PLUG

1.0 ASSEMBLY INSTRUCTIONS – EASY AS 1-2-3! GUNS ONLY

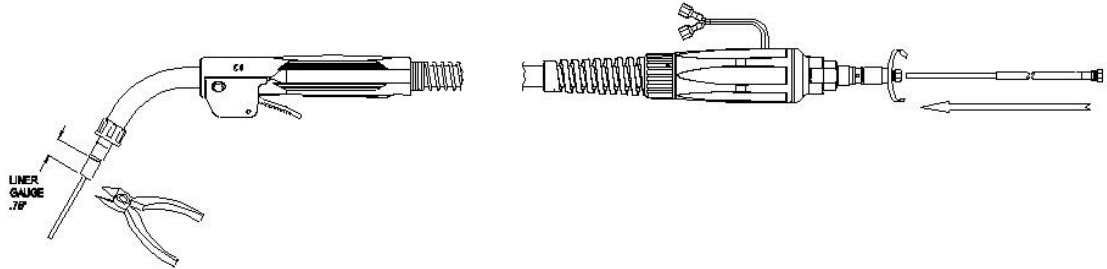
STEP #1

NOTE: Applies to all TGX™ XS and XL gun models

- Remove gun from box and extend to full length.
- Slide nozzle off of front end of gun.
- Thread retaining head off of front end of gun.
- Remove power pin from package and thread on to rear of gun using a 3/4" (19 mm) wrench on the rear block and a 5/8" (16 mm) or 3/4" (19 mm) wrench on power pin. Torque to 18 ft.-lbs. Install power pin / block insulator.



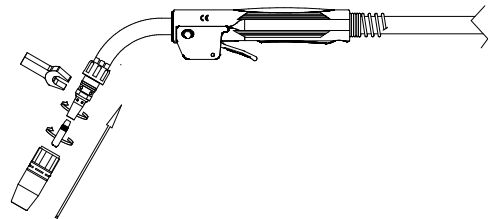
STEP #2



- Remove liner from package end extend to full length. Feed liner into the back end of the gun using short strokes to avoid kinking. Twist liner counter clockwise if necessary, to ease insertion.
- Seat liner retainer to end of power pin and using a 10 mm wrench, turn retainer in a clockwise direction and tighten into power pin.
- Measure the proper liner stick-out at the front end of the gun using liner gauge (provided). Before cutting, push liner into gun to compress liner then cut the liner and remove any burrs that may obstruct wire feed.

STEP #3

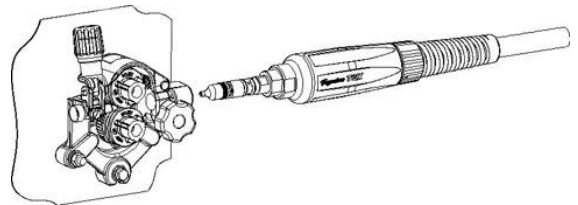
- Thread TOUGH LOCK™ Retaining Head onto neck and securely tighten using a wrench.
- Remove TOUGH LOCK Contact Tip from package and thread securely into retaining head.
- Slip nozzle fully onto head.



2.0 INSERTING MIG GUN INTO A WIRE FEEDER

For most power pins:

1. Insert power pin to shoulder and secure.
2. Insert control plug to control housing of MIG gun.
3. Insert control plug into feeder.
4. Feed welding wire into power pin by hand and tighten drive rolls.



NOTE: On Lincoln feeders it is necessary to connect the gas hose to the barbed fitting on the power pin.



For Technical Support:

Canada & U.S.A. Phone: 1-877-737-3111

International Phone: +1-519-737-3000

Email: techservices@tregaskiss.com

www.tregaskiss.com

TREGASKISS is an industry leader in the development and manufacture of semi-automatic and robotic MIG welding guns and robotic peripherals.

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