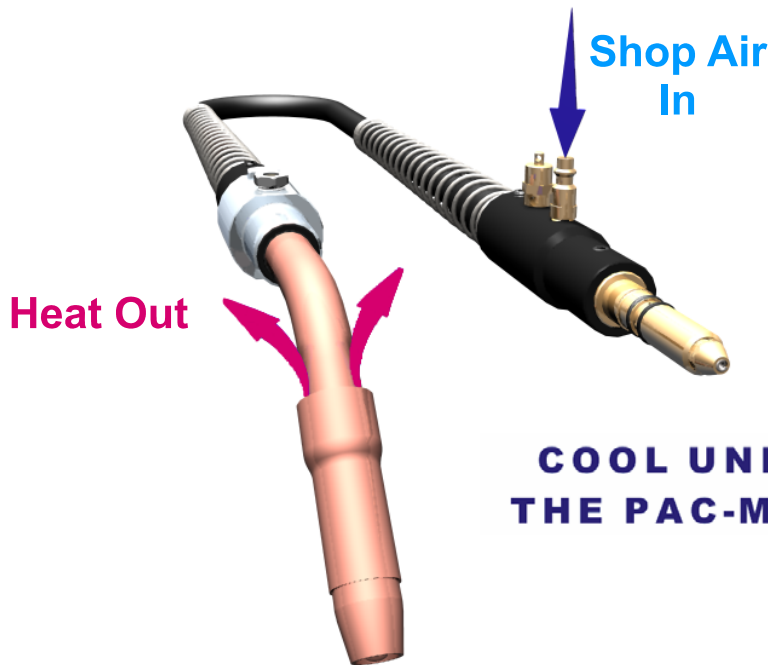




ROBOTIC & AUTOMATIC
PRESSURIZED-AIR-COOLED
MIG GUNS
400 & 650 AMPS



**COOL UNDER PRESSURE
THE PAC-MIG ADVANAGE™**

100% Duty Cycle With Any Gas

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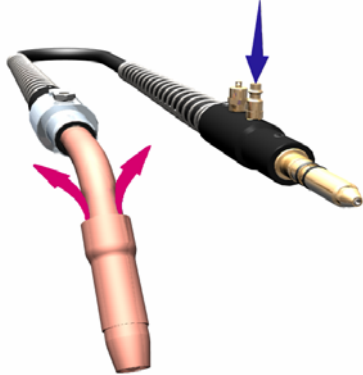


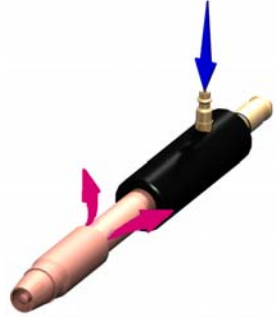
ROBOTIC AND AUTOMATIC PRESSURIZED AIR-COOLED MIG GUNS WITH ENDURA CABLE™

PRESSURIZED AIR-COOLED MIG GUN FEATURES

- Cooled with shop air (1.2 -1.8 cfm) from the rear case to the shrouded nozzle.
- Replaces water-cooled or hot running standard air-cooled guns.
- 100% duty cycle with any gas.
- Quick-change keyed conductor tubes are standard.
- The patented Pac-Mig™ Mig Guns are equipped with the patent pending **Endura-Cable™** which reduces cable movement and premature wear for optimum cable management.
- Cables can be changed without removing the front case assembly from the robot arm. This allows cables to be changed without disturbing TCP. (See maintenance manual)
- Kevlar cable protectors available.
- All Pac-Mig guns can be ordered to match existing mount diameters, conductor tube angles and lengths to minimize reprogramming.
- Guns can be ordered with a wire lock or an air blast installed.
- PAC-MIG™ guns will not be destroyed to lack of, or no air flow.
- Minimal maintenance is required.
- Front end consumable life is increased by a minimum of 20%.
- Specials available on request.

Ordering Instructions and Options

	PRESSURIZED AIR-COOLED ROBOTIC		PRESSURIZED AIR-COOLED AUTOMATIC
	Part No.	Amperage	Part No.
	XRX-4004-XXXX-X-XX XRX-4005-XXXX-X-XX XRX-4006-XXXX-X-XX XRX-4008-XXXX-X-XX XRX-4010-XXXX-X-XX XRX-4012-XXXX-X-XX XRX-4015-XXXX-X-XX	400 AMP	AX-4004-XXXX-XX AX-4005-XXXX-XX AX-4006-XXXX-XX AX-4008-XXXX-XX AX-4010-XXXX-XX AX-4012-XXXX-XX AX-4015-XXXX-XX
XRX-6504-XXXX-X-XX XRX-6505-XXXX-X-XX XRX-6506-XXXX-X-XX XRX-6508-XXXX-X-XX XRX-6510-XXXX-X-XX XRX-6512-XXXX-X-XX XRX-6515-XXXX-X-XX	650 AMP	AX-6504-XXXX-XX AX-6505-XXXX-XX AX-6506-XXXX-XX AX-6508-XXXX-XX AX-6510-XXXX-XX AX-6512-XXXX-XX AX-6515-XXXX-XX	

Pressurized Air-Cooled Automatic Auto-Pac™		
Part No.	Amperage	
AX-400-XXXX-XX AX-650-XXXX-XX	400 650	

Part No. Exclamation:			
Torch Type	XR = Robotic AX = Automatic WLR = Wire Lock Robotic Gun	Rear Connector Plug: T = Tweco M = Miller	L = Lincoln P = Panasonic E = Euro
Amp	400 650	Cable Length	4', 5', 6', 8', 10', 12', & 15'
Wire Size	.035", .040", .045", .052", 1/16", & 3/32"	Mount Sleeves (Robotic only): PM=Pac-Mig (1.562" Dia.) TR = Tregaskiss (1.375" Dia.) TRL = Tregaskiss (1.5"Dia.)	B = Binzel (1.415"Dia.) T = Tweco (1.625" Dia.) M = Motoman (2.0" Dia.)
Conductor Tubes	18, 22, 45, 60, 180 deg		
Example: XRT-4004-0116-T-22 Pressurized Air-Cooled ROBOTIC Mig Gun Tweco rear connection plug 400 amp 4 ft cable 1/16 wire conduit & tip Tweco 1.625" Dia. Sleeve 22 deg Std conductor tube		Example: AM-4006-3545-45 Pressurized Air-Cooled Automatic Mig Gun Miller rear connection plug 400 amp 6 ft cable .035 -.045" wire conduit & tip 45 deg Std conductor tube	
Options: <ul style="list-style-type: none"> • Anti-spatter line is optional (add AS to end of part number and \$34.95 to list price) • Custom lengths available on request. • WLR Robotic wire lock guns are available. Call customer service for pricing. • To order a gun equipped with an air blast, call customer service for details. 			

Consumable Options for 400 & 650 Amp Robotic & Automatic Mig Guns

Wire Size In./mm	Contact Tip Standard	Contact Tip Tapered	Gas Diffuser		Conduit Liner (Steel Wire)	Nylon Conduit Liner (Aluminum Wire)
			400Amp	650Amp		
.030/.8mm	TT-30	TT-30T	TD45	TD-65-SW	C6-3545-08 C6-3545-15	C6N-3545-08 C6N-3545-15
.035/.9mm	TT-35	TT-35T				
.040/1.0mm	TT-40	TT-40T				
.045/1.2mm	TT-45	TT-45T			N/A	C6N-116-08 C6N-116-15
3/64/1.2mm(Al)	TT-364	TT-364T				
.052/1.3mm	TT-52	TT-52T				
1/16/1.6mm	TT-116	TT-116T	N/A	TD65-H	C6-116-08 C6-116-15	C6N-116-08 C6N-116-15
5/64/2.0mm	TT-564	TT-564T				
3/32/2.4mm	TT-332	TT-332T				
					C6-564-08 C6-564-15	N/A
					C6H-332-08 C6H-332-15	N/A



Optional (collet type) Contact Tips & Diffuser for 650 Amp Robotic & Automatic Mig Guns

Optional (collet type) Contact Tips Package of 25 ea.		Diffuser (collet type) 650 Amp	Optional (collet type) Tapered Contact Tips Package of 25 ea.	
Part No.	Description		Part No.	Description
T6-30	Contact Tip .030	D65-SW	T6-30T	Tapered Contact Tip .030
T6-35	Contact Tip .035		T6-35T	Tapered Contact Tip .035
T6-40	Contact Tip .040		T6-40T	Tapered Contact Tip .040
T6-45	Contact Tip .045		T6-45T	Tapered Contact Tip .045
T6-52	Contact Tip .052		T6-52T	Tapered Contact Tip .052
T6-116	Contact Tip 1/16		T6-116T	Tapered Contact Tip 1/16
T6-564	Contact Tip 5/64		T6-564T	Tapered Contact Tip 5/64
T6-332	Contact Tip 3/32	D65-H	T6-332T	Tapered Contact Tip 3/32
T6-764	Contact Tip 7/64		T6-764T	Tapered Contact Tip 7/64
T6-18	Contact Tip 1/8		T6-18T	Tapered Contact Tip 1/8

Nozzles for 400 Amp Pressurized Air-Cooled Robotic and Automatic Mig Guns Package of 5 ea.

Standard Part No.	Heavy Duty Part No.	Description
PN40-50	HPN40-50	400 Amp Nozzle ½ " w/5/32 recess
PN40-50F	HPN40-50F	400 Amp Nozzle ½ " Flush
PN40-50-P	HPN40-50-P	400 Amp Nozzle ½ " w/1/8 Projection
PN40-62	HPN40-62	400 Amp Nozzle 5/8" w/5/32 Recess
PN40-62F	HPN40-62F	400 Amp Nozzle 5/8" Flush
PN40-62-P	HPN40-62-P	400 Amp Nozzle 5/8" w/1/8" projection
PN40-75	N/A	400 Amp Nozzle ¾" w/5/32 Recess
PN40-75F	N/A	400 Amp Nozzle ¾" Flush
PN40-75-P	N/A	400 Amp Nozzle ¾" w/1/8" projection

Nozzles for 650 Amp Pressurized Air-Cooled Robotic and Automatic Mig Guns Package of 5 ea.

Standard Part No.	Heavy Duty Part No.	Description
PN65-50	N/A	650 Amp Nozzle ½" w/5/32 recess
PN65-50F	N/A	650 Amp Nozzle ½" Flush
PN65-50-MS	N/A	650 Amp Nozzle ½" Mini Shroud w/5/32 recess
PN65-50F-MS	N/A	650 Amp Nozzle ½" Flush Mini Shroud
PN65-50-P	N/A	650 Amp Nozzle ½" w/1/8 Projection
PN65-50P-MS	N/A	650 Amp Nozzle ½" Mini Shroud w/1/8 Projection
PN65-50-SB	N/A	650 Amp Nozzle ½" Straight Bore
PN65-50F-SB	N/A	650 Amp Nozzle ½" Flush Straight Bore
PN65-50P-SB	N/A	650 Amp Nozzle ½" Straight Bore w/1/8 Projection
PN65-62	HPN65-62	650 Amp Nozzle 5/8" w/5/32 recess
PN65-62F	HPN65-62F	650 Amp Nozzle 5/8" Flush
PN65-62-MS	HPN65-62-MS	650 Amp Nozzle 5/8" Mini Shroud w/5/32 recess
PN65-62F-MS	HPN65-62F-MS	650 Amp Nozzle 5/8" Flush Mini Shroud
PN65-62-P	HPN65-62-P	650 Amp Nozzle 5/8" w/1/8 Projection
PN65-62P-MS	HPN65-62P-MS	650 Amp Nozzle 5/8" Mini Shroud w/1/8 Projection
PN65-75	HPN65-75	650 Amp Nozzle ¾" w/5/32 recess
PN65-75F	HPN65-75F	650 Amp Nozzle ¾" Flush
PN65-75-P	HPN65-75P	650 Amp Nozzle ¾" w/1/8 Projection
PN65-75-MS	HPN65-75LS	650 Amp Nozzle ¾" Flush Mini Shroud
PN65-75F-MS	HPN65-75LSF	650 Amp Nozzle ¾" Mini Shroud w/5/32 recess
PN65-75P-MS	HPN65-75LS-P	650 Amp Nozzle ¾" Mini Shroud w/1/8 Projection
PN65-87	N/A	650 Amp Nozzle 7/8" w/5/32 recess
PN65-87F	N/A	650 Amp Nozzle 7/8" Flush
PN65-87-P	N/A	650 Amp Nozzle 7/8" w/1/8 Projection

Optional Two Piece Nozzles & Insulators for 400 & 650 Amp Pressurized Air-Cooled Robotic and Automatic Mig Guns

Package of 5 ea. Note: Nozzle Insulator Controls Tip to Nozzle Distance. (See Below)

Nozzles		Insulators	
Part No.	Description	Part No.	Description
NT-37	Nozzle Tip 3/8" I.D.	PNI-4037	400 Amp Nozzle Insulator (For NT-4037 Only) w/5/32 recess
NT-4037	Nozzle Tip 3/8" I.D.	PNI-4037F	400 Amp Nozzle Insulator (For NT-4037 Only) Flush
NT-50	Nozzle Tip 1/2" I.D.	PNI-4037P	400 Amp Nozzle Insulator (For NT-4037 Only)
NT-62	Nozzle Tip 5/8" I.D.	PNI-40	400 Amp Nozzle Insulator w/5/32 recess
NT-75	Nozzle Tip 3/4" I.D.	PNI-40F	400 Amp Nozzle Insulator Flush
		PNI-40P	400 Amp Nozzle Insulator w/1/8 Projection
		PNI-65	650 Amp Nozzle Insulator w/5/32 recess
		PNI-65F	650 Amp Nozzle Insulator Flush
		PNI-65P	650 Amp Nozzle Insulator w/1/8 Projection
		PNI-65-MS	650 Amp Nozzle Insulator Mini-Shroud w/5/32 recess
		PNI-65-MSF	650 Amp Nozzle Insulator Mini-Shroud Flush
		PNI-65-MSP	650 Amp Nozzle Insulator Mini-Shroud w/1/8 Projection

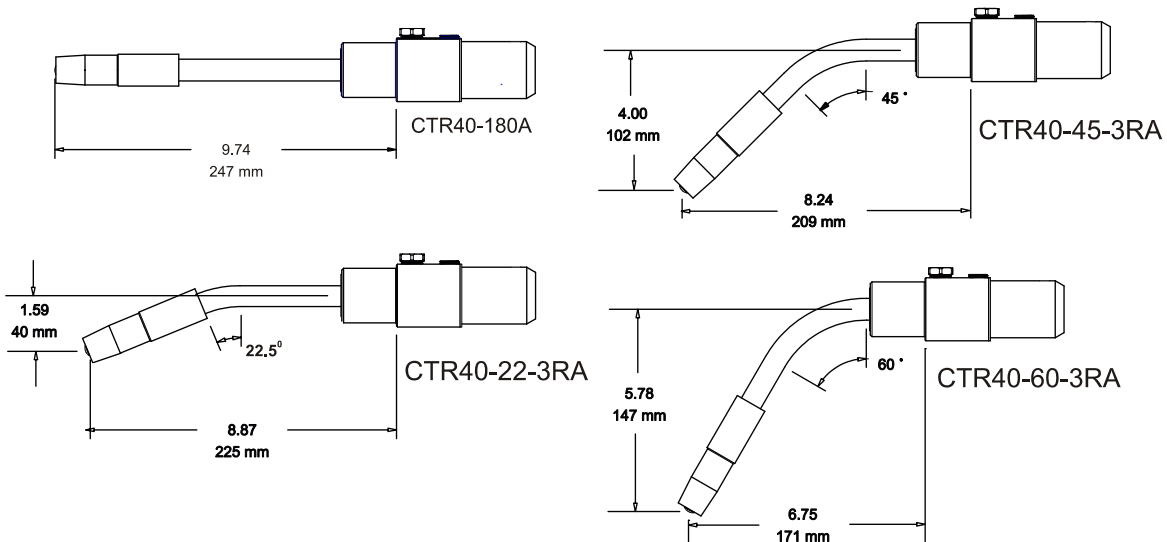
Conductor Tube Assembly For 400 Amp Pressurized Air-Cooled Robotic Mig Gun

Part No.	Description
CTR40-18-3R-A	400 Amp 18 Degree 3" Radius
CTR40-22-3R-A	400 Amp 22.5 Degree 3" Radius
TRAC40-22L	Order Part No. CTR40-22-3R-A
CTR40-45-3R-A	400 Amp 45 Degree 3" Radius
CTR40-60-3R-A	400 Amp 60 Degree 3" Radius
CTR40-80-3R-A	400 Amp 80 Degree 3" Radius
CTR40-180-A	400 Amp 180 Degree (Short) Straight
TRAC40-180L	Order Part No. CTR40-180-A
CTR40-18-5R-A	400 Amp 18 Degree 5" Radius
CTR40-22-5R-A	400 Amp 22.5 Degree 5" Radius
CTR40-45-5R-A	400 Amp 45 Degree 5" Radius
CTR40-60-5R-A	400 Amp 60 Degree 5" Radius
CTR40-80-5R-A	400 Amp 80 Degree 5" Radius
CTR40-180L-A	400 Amp 180 Degree (Long) Straight

Dimensional Drawings of 400 Amp Standard Front Assemblies

- All dimensions are from the end of the welding tip.
- PacMig™ case sleeve mount dimensions: 1.562" Dia x 1.562" long
- Optional sleeve mounts are available for Binzel™, Motoman™, Tregaskiss™, and Tweco™ torch mounting arms.

Custom conductor tubes are available. Call PacMig™ customer service.

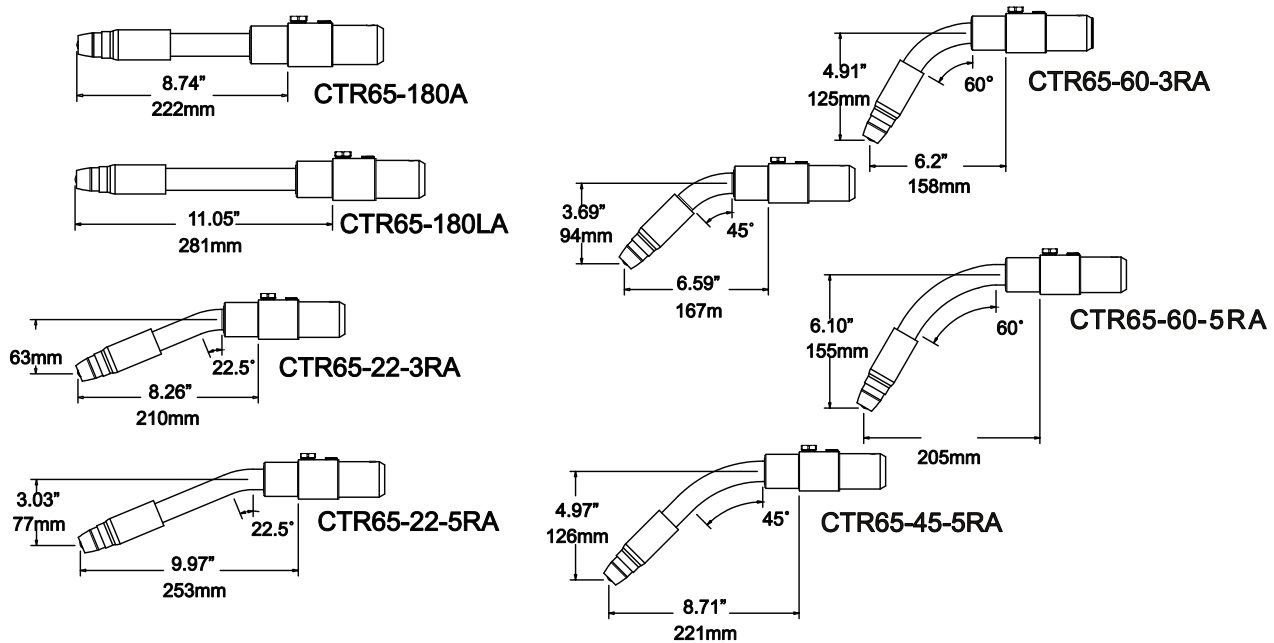


Conductor Tube Assembly For 650 Amp Pressurized Air-Cooled Robotic & Automatic Mig Gun

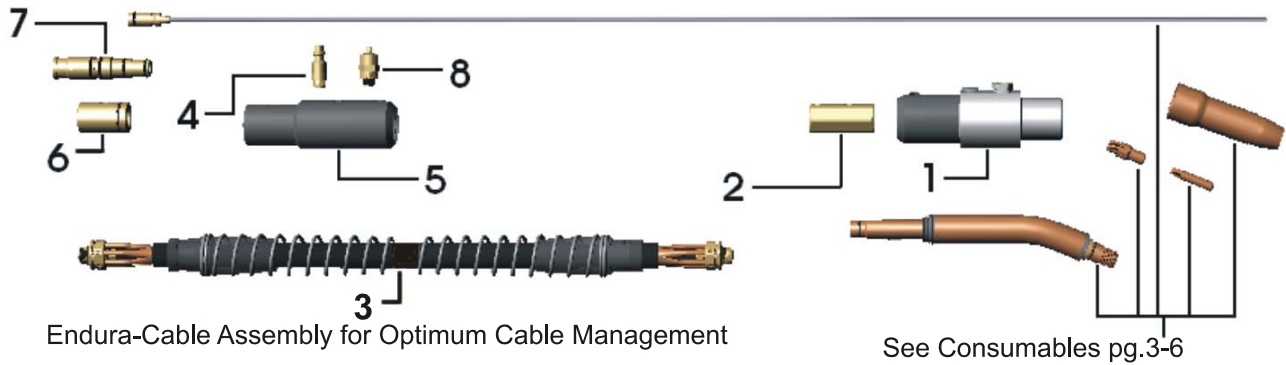
Part No.	Description
CTR65-18-3R-A	650 Amp 18 Degree 3" Radius
CTR65-22-3R-A	650 Amp 22.5 Degree 3" Radius
TRWC65-22QC	650 Amp 22.5 Degree To Match Tregaskiss Quick Change
TRWC65-22K	650 Amp 22.5 Degree To Match Tregaskiss Water Cooled Keyed
TWC65-22	650 Amp 22.5 Degree To Match Tweco Standard Length
TRAC65-45	650 Amp 45 Degree 3" Radius To Match Tregaskiss Air Cooled
CTR65-45-3R-A	650 Amp 45 Degree 3" Radius
CTR65-60-3R-A	650 Amp 60 Degree 3" Radius
CTR65-80-3R-A	650 Amp 80 Degree 3" Radius
CTR65-180-A	650 Amp 180 Degree (Short) Straight
CTR65-18-5R-A	650 Amp 18 Degree 5" Radius
CTR65-22-5R-A	650 Amp 22.5 Degree 5" Radius
TRAC65-22L	650 Amp 22.5 Degree 5" To Match Tregaskiss Air-Cooled Long
TWC65-22L	650 Amp 22.5 Degree 5" To Match Tweco Long
CTR65-45-5R-A	650 Amp 45 Degree 5" Radius
CTR65-60-5R-A	650 Amp 60 Degree 5" Radius
CTR65-80-5R-A	650 Amp 80 Degree 5" Radius
CTR65-180L-A	650 Amp 180 Degree (Long) Straight
TRWC65-180QC	Order Part No. CTR65-180L-A

Dimensional Drawings of 650 Amp Standard Front Assemblies

- All dimensions are from the end of the welding tip.
- PacMig™ case sleeve mount dimensions: 1.562" Dia x 1.562" long
- Optional sleeve mounts are available for Binzel™, Motoman™, Tregaskiss™, and Tweco™ torch mounting arms.
- Custom conductor tubes are available. Call PacMig™ customer service.



Replacement Parts for Robotic Gun

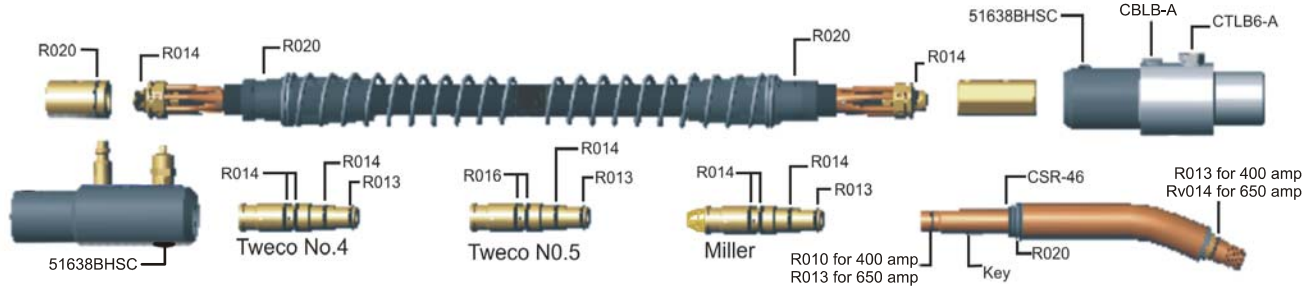


Endura-Cable Assembly for Optimum Cable Management

See Consumables pg.3-6

Item No.	Part No.	Description
1	HR-46A HRR-46-T-A HRR-46TRAC HRR-46TRWC-QC HRR-46-B-A HRR-46-G-A HRR-46-A-A HRR-46-M-A HRR-46-PM-A HRR-46WL-B-A HRR-46WL-PMA HRR-46WL-T-A HRR-46WL-TR-A HRR-46WL-PMA	Automatic Front Case Assembly - Plastic 1-5/8 Dia. Robotic Front Case Assembly For Tweco Mount Robotic Front Case Assembly Tregaskiss Air Cooled Mount 1.375" Dia. Robotic Front Case Assembly Tregaskiss Quick Change Mount 1.5" Dia. Robotic Front Case Assembly For Binzel Mount Robotic Front Case Assembly For General Mount Robotic Front Case Assembly For ABB Mount Robotic Front Case Assembly For Motoman Mount Robotic Front Case Assembly For PacMig Mount Robotic Front Case Assembly – Wire Lock PacMig Mount Robotic Front Case Assembly - Wire Lock Tweco Mount Robotic Front Case Assembly - Wire Lock Tregaskiss Mount – 1.375" Dia. Robotic Front Case Assembly - Wire Lock Tregaskiss Mount – 1.5" Dia. Robotic Front Case Assembly – Wire Lock PacMig Mount
2	FCBRR-40 FCBRR-65	Front Connector Block - Robotic 400 amp Front Connector Block – Robotic 650 amp
3	CHARX-4 CHARX-4.5 CHARX-5 CHARX-6 CHARX-8 CHARX-10 CHARX-12 CHARX-15 COAX-65	Endura Cable Hose Assembly (Robotic-Automatic) -4ft Endura Cable Hose Assembly (Robotic-Automatic) -4.5ft Endura Cable Hose Assembly (Robotic-Automatic) -5ft Endura Cable Hose Assembly (Robotic-Automatic) -6ft Endura Cable Hose Assembly (Robotic-Automatic) -8ft Endura Cable Hose Assembly (Robotic-Automatic) -10ft Endura Cable Hose Assembly (Robotic-Automatic) -12ft Endura Cable Hose Assembly (Robotic-Automatic) -15ft Endura Cable Hose per ft.
4	AIF	Air Intake Fitting
5	RCR-46A	Rear Case Assembly - Robotic Guns
6	RCBR-46A	Rear Connector Block Assembly - Robotic
7	CP-6T-A CP-6M-A CP-6L-A CP-46P-A CP-124XRA	Tweco Rear Connector Plug Assembly Miller Rear Connector Plug Assembly Lincoln Rear Connector Plug Assembly Panasonic Rear Connector Plug Assembly Euro Rear Connector Plug Assembly
8	PV-1	Pressure Relief valve

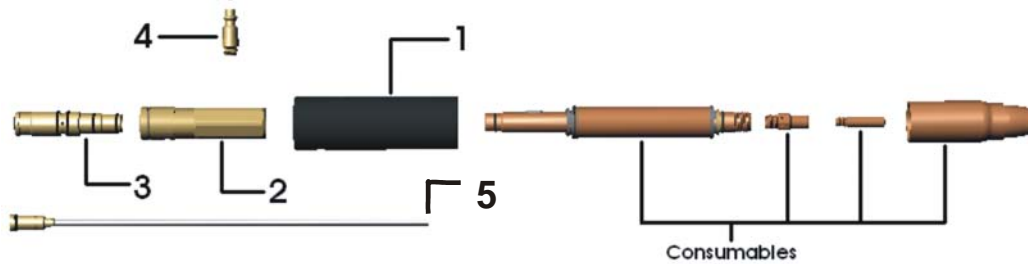
Maintenance Kit, O-Ring, Key, and Attachment Screws



Part No.	Description
R010	O-ring
R013	O-ring
R014	O-ring
RV014	O-ring (High Heat)
R016	O-ring
R020	O-ring

Part No.	Description
CBLB-A	Connector Block Locking Button Assy.
CTLB6-A	Conductor Tube Locking Button Assy.
CSR-46	Snap Ring
KEY	Conductor Tube Key
51638BHSC	Button Head Set Screw
MK-46	Maintenance Kit (contains all the above parts)
R-Kit	O-Ring Kit (contains o-rings only)

Replacement Parts for Automatic Auto-Pac™ Gun



Item No.	Part No.	Description	Item No.	Part No.	Description
1	AC	Case	4	AIF	Air Intake Fitting
2	ACB	Connector Block	5	C6-3545-01	Conduit Liner .030" to .045" Dia. wire
				C6-116-01	Conduit Liner .045" to 1/16" Dia. wire
				C6-564-01	Conduit Liner 1/16" to 5/64" Dia. wire
3	See Item 7 page 7 Rear Connector Plug				

Robotic End Of Arm Tooling

Part No.	Description
ARM-21A	Adjustable Torch Mount Arm – 2-1/8" Pivot Arm
ARM-22A	Adjustable Torch Mount Arm – 2-7/8" Pivot Arm
ARM-23A	Adjustable Torch Mount Arm – 3-3/4" Pivot Arm
400-83	Safety Mount with Quick Disconnect (Rumble Automation)
400-83-25	Insulator for Motoman (Rumble Automation)

For parts not listed or special requirements call Pac-Mig customer service

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