

Q™ and S™ Series with OXO® style small handle

200, 300, 400 Amp MIG Guns

Issued Jan. 2007 • Index No. SPEC QS234X-1.1

Q400 MIG S-Gun™ shown with OXO® style small curved handle, medium 45° rotating neck and standard trigger.



S-Guns™ built with ultra heavy-duty steel monocoil power cables are highly resistant to kinking for exceptional gas flow and wire feed in applications that cause other guns to fail.

Stay-Tite™ Technology

Long-lasting power cable compression fittings and necks with large tapered gun connections combine to form the foundation of Bernard® Stay-Tite™ technology. This technology ensures optimal conductivity to increase weld consistency and lessen heat output while improving product durability.

All Guns are Not Created Equal.

A MIG gun should be durable, easy to use and customized to your specific application. Our MIG guns put you in control: you choose the options you need and we'll build a gun to last. We even ship most of our guns within 24 hours.

Centerfire™ contact tips, nozzles and diffusers are easy-to-use and high performing - they provide better arc starts, less spatter and more consistent welds - and also last up to three times longer than competitive brands.

Necks available in fixed, rotatable and multiple length options for optimal weld accessibility and improved operator comfort. Rotatable necks changeover without tools.

Patented Jump Liner allows quick neck change and replacement of only most commonly worn or clogged liner area, which reduces the amount of time a gun is offline and minimizes inventory.

Liners coiled in-house with proprietary process that improves wire feed performance and 100 percent tested to ensure smoothest wire feed in the industry.

OXO® style handle option allows configuration of Bernard Q-Gun or S-Gun with feel similar to former OXO APX gun.

Back end with durable rigid strain relief and easily interchangeable direct plugs and trigger leads connect to wire feeders and machines from major manufacturers and allow simple maintenance.

MIG Gun	Amperage Ratings				Description
	Duty Cycle				
	100% NEMA	100% CE	60% CE	35% CE	
Q200	250	200	240	325	CO ₂ Gas
	n/a	175	200	240	80%AR20%CO ₂
Q300 / S300	350	320	370	470	CO ₂ Gas
	n/a	270	310	390	80%AR20%CO ₂
Q400 / S400	400	350	425	520	CO ₂ Gas
	n/a	285	350	440	80%AR20%CO ₂

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

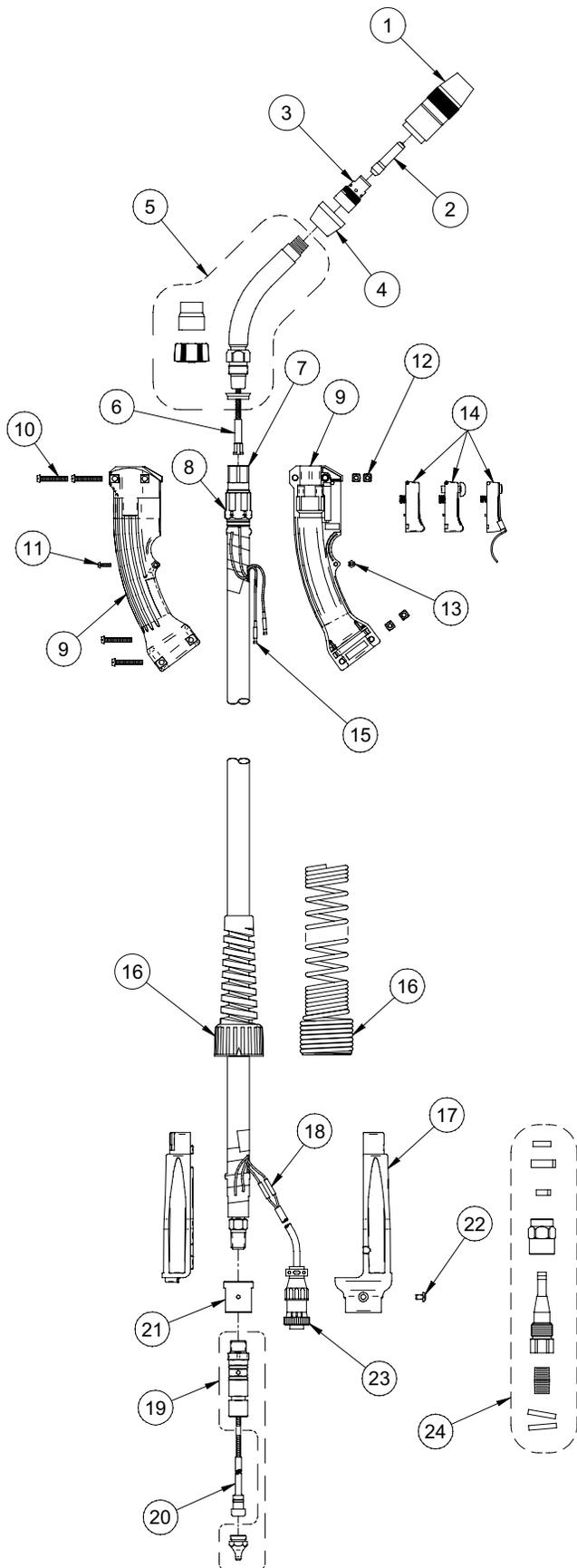
Bernard®

An Illinois Tool Works Company
449 West Corning Road, Box 667
Beecher, Illinois 60401 USA

Phone: 800-946-2281 (US Only) 708-946-2281 (Outside US)
Fax: 708-946-6726
For more information, visit us at BernardWelds.com



Replacement Parts List



ITEM #	Q200 PART #	Q300 / S300 PART #	Q400 / S400 PART #	DESCRIPTION
1	See Centerfire Spec Sheet			Nozzle Assy
2	See Centerfire Spec Sheet			Contact Tip
3	See Centerfire Spec Sheet			Gas Diffuser
4	See Centerfire Spec Sheet			Cap
5	See Neck Spec Sheet			Neck
6	See Jump Liner Spec Sheet			Jump Liner
7	4213B	Q300 4213B	Q400 4313B	Stay-Tite™ End Fitting
		S300 1680046	S400 1680046	
8	4305	Q300 4305	Q400 1540003	Stay-Tite™ Cone Nut
		S300 1540007	S400 1540008	
NS	4991	Q300 4991	Q400 1520017	Conduit Clamp (2 Req'd)
		S300 Not Needed	S400 Not Needed	
NS	407709-013			Jacket Clamp (2 Req'd)
9	1880219			*Handle Kit - Std. Trigger & Locking Trigger
10	203296-005			Handle Screw, Large (4 Req'd)
11	2280044			Handle Screw, Small
12	177272			Handle Nut (4 Req'd)
13	2030029			Handle Nut, Small
14	177488			Trigger, Standard
	MS2110			Trigger, Locking
	177379			Trigger, Standard w/Extension
15	177271			Trigger Pin (2 Req'd)
16	2520033	Q300 2520033	Q400 2520041	Spring, Strain Relief
		S300 2520056	S400 2520056	
17				Rigid Strain Relief Kit (Includes Top & Bottom Halves)
	2520073			Strain Relief with Installed Gas Pin (Bernard Direct Plug)
	2520069			Strain Relief (Euro Direct Plug)
	2520066			Strain Relief (All Other Direct Plugs)
18	4932			Butt Connector (2 Req'd)
19	See Direct Plug Spec Sheet			Direct Plug Components
20	See Liner Spec Sheet			Liner
21	1010027			Adapter Block (Not Req'd on Bernard or Euro Direct Plug)
22	W11127-002			Screw, Strain Relief (Not Req'd on Bernard Direct Plug)
23	GN2021			Electrical Plug - Non D/S (Not Req'd on Bernard Direct Plug)
24	1982	Q300 1983Q	Q400 1984Q	†Rear Stay-Tite™ Repair Kit
		S300 N/A	S400 N/A	

*1880219 Handle Kit includes halves, screws and nuts.

†1982, 1983Q and 1984Q Rear Stay-Tite™ Repair Kit includes, jacket clamp, conduit clamp, cone nut, end fitting, nipple, spacer & butt connectors.

