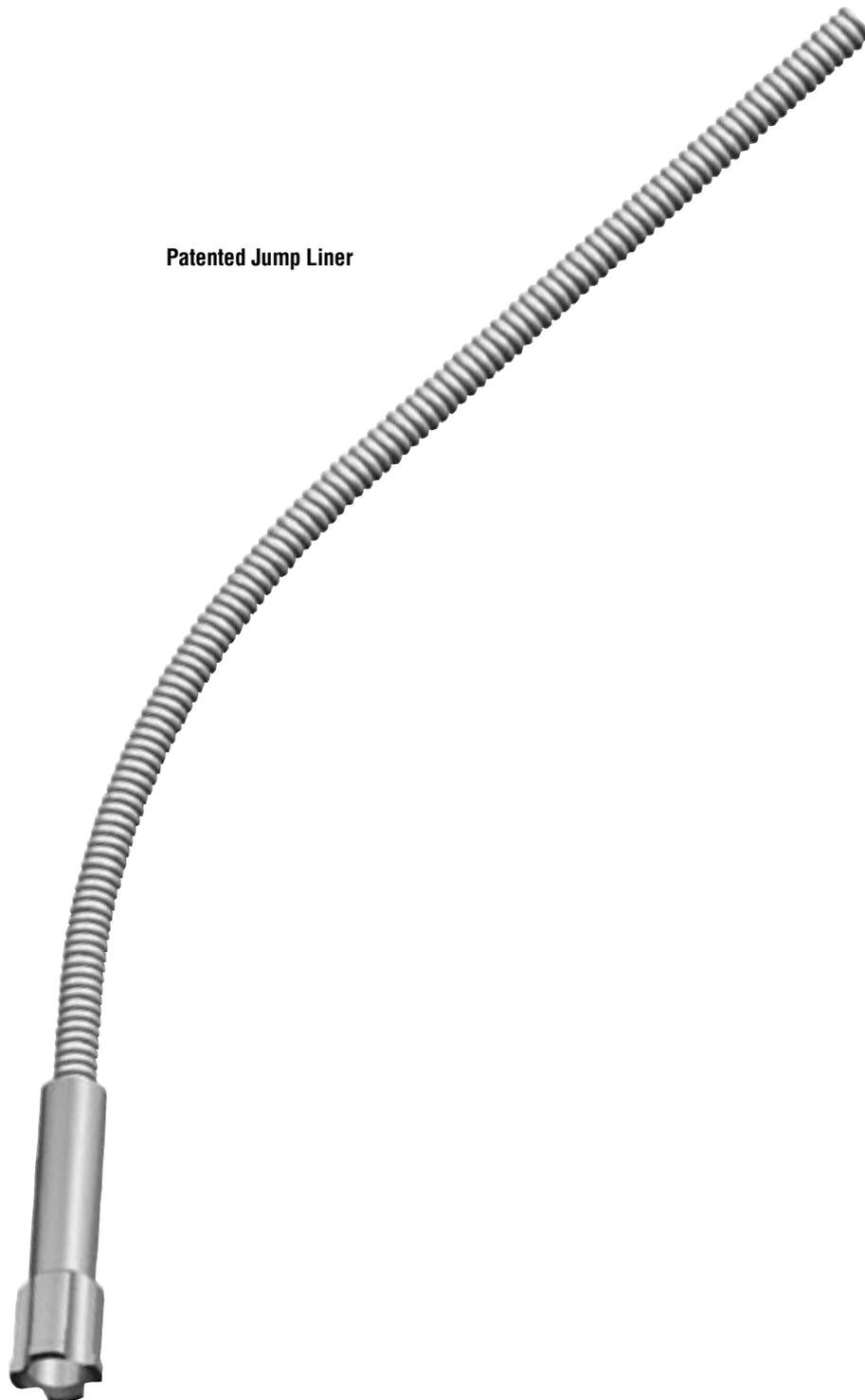


# Jump Liners

## MIG Welding Accessory

Issued August 2007 • Index No. SPEC JL-1.3

Patented Jump Liner



### 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.

**Patented Jump Liners** replace only the most commonly worn and clogged liner area to reduce the amount of time a gun is offline and minimize inventory.

**Enable quick and easy neck change-out** so gun can be easily adapted to fit multiple applications.

**Proprietary in-house coiling process and unique composition** eliminates flat spots or sharp edges inside Jump Liners to improve wire feed performance.

**Fit all Q-Guns™ and S-Guns™** - from 150 to 600 Amps.

**Available in sizes to fit .023" (0.6 mm) to 1/16" (1.6 mm) wire.**

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](http://BernardWelds.com)



# Available Jump Liners

PART NO.	ELECTRODE SIZE	LENGTH
QJL-2330	.023" - .030" (.6 mm - .8 mm)	14"
QJL-2330-XL	.023" - .030" (.6 mm - .8 mm)	27"
QJL-3545	.035" - .045" (.9 mm - 1.2 mm)	14"
QJL-3545-XL	.035" - .045" (.9 mm - 1.2 mm)	27"
QJL-116	1/16" (1.6 mm)	14"
QJL-116-XL	1/16" (1.6 mm)	27"
QJLH-116	1/16" Heavy Duty (1.6 mm)	14"
QJLN-364	*.035" - 3/64" Nylon (.9 mm - 1.2 mm)	14"
QJLN-116	*1/16" Nylon (1.6 mm)	14"

*\*Nylon liners available for aluminum wire. See liner speck sheet for details.*

## Installation Instructions

1. Turn off power.
2. Remove nozzle, insulator, tip gas diffuser and neck from gun.
3. Remove old jump liner from the back end of the neck.
4. Insert new jump liner making sure the liner stop is fully seated at back end of neck.
5. Take the tapered end of the neck and insert into the end fitting of the gun handle. Make sure that the liner extruding from the handle is trimmed to 1/4" beyond the gun handle to ensure proper fit up to new jump liner. Secure the neck to the gun by turning the insulated nut clockwise.
7. Trim the liner at the nozzle of the neck as follows:
  - DS-1 and D-1 Centerfire™ gas diffusers (used with Centerfire™ series tips) = between 5/8" and 3/4"
  - 4235 and 4635 gas diffusers (used with 1500 series tips) = 3/8"
  - 4335 and 4435 gas diffusers (used with 7400 or 4200 series tips) = 1-3/8"
  - D118Q gas diffusers (used with Quick Tips™) = 7/8"
  - D114Q gas diffusers (used with Quick Tips™) = 3/4"
8. File the cut end of the liner to eliminate burrs.
9. Reinstall the cap, gas diffuser, tip and nozzle.

