



REVOLVER™ | THE POWER OF SPIN™

INFINITE ROTATION SEMI-AUTOMATIC MIG WELDING GUN

The REVOLVER™ series offer a uniquely designed handle-to-cable interface, capable of infinite rotation around the cable, giving the operator freedom to weld at any position without cable resistance.



• PATENT PENDING •

FEATURES

Infinite Rotation Capability

- Embedded proprietary **SPINPOWER™** technology allows for infinite rotation at the handle-to-cable interface.

One-Piece Ergonomic Handle

- Designed for operator comfort, dimensional stability and cross-sectional integrity.

High Conductivity Rotary Power Connector (RPC)

- Compact low torque, low resistance design provides thermal and electrical stability at high power requirements.

Robust Cable Design

- Coaxial design with integrated power cable, gas hose, and control wires.

Swivel & Lock Gooseneck

- Gooseneck rotates and locks in 90 degree increments for optimal ease of joint access.

High Quality Consumables

- Industry proven diffuser and nozzle geometry allows for consistent, optimized gas flow.
- Proprietary contact tip design for maximum conductivity, long life, superior arc starts and arc stability.
- Contact tips are available in DHP (Cu122) copper alloy and Copper Chrome Zirconium (CuCrZr).

TECHNICAL DATA

Processes

- MIG (GMAW) Welding

Applications

- Auto body, Heavy Equipment, Shipbuilding, Pipeline, Fabrication

Amperage Rating @ 60% Duty Cycle

- Revolver 3G®: 300A, 100% with CO2 gas, 60% with mixed gas
- Revolver 4G®: 400A, 100% with CO2 gas, 60% with mixed gas
- Revolver 5G®: 500A, 100% with CO2 gas, 60% with mixed gas

Cable Length ft. (m)

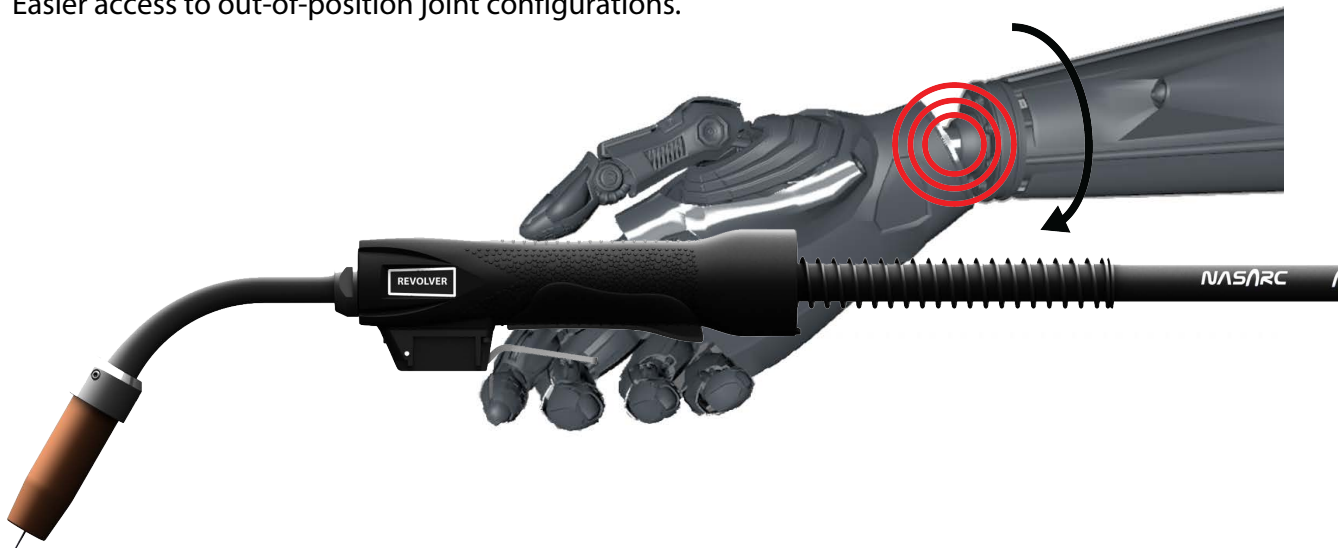
- 10 (3.0), 12 (3.6), 15 (4.5), 20 (6.1), 25 (7.6)

BENEFITS

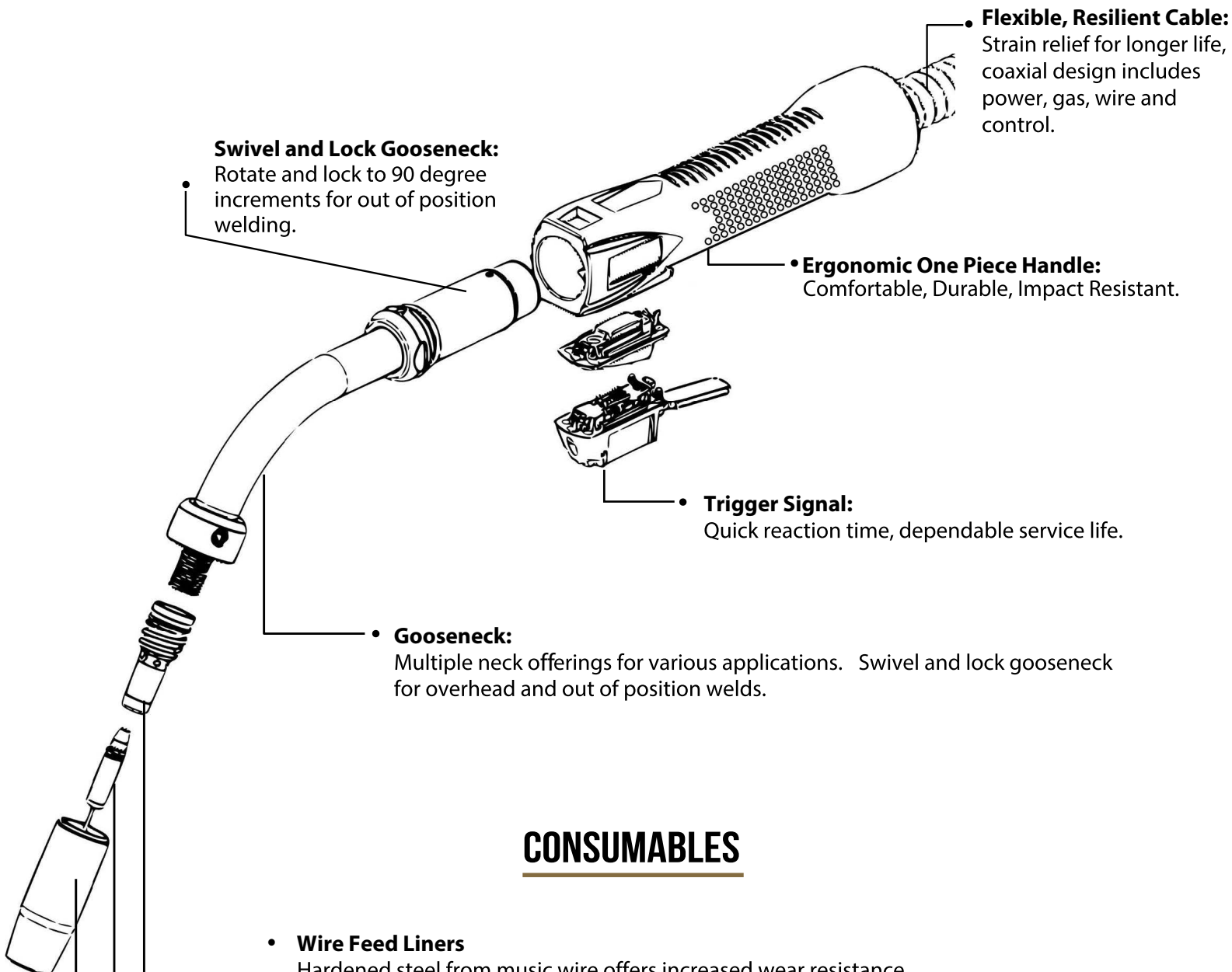
- Productivity:** • Uniquely designed 1-piece handle provides infinite rotation at the handle-to-cable interface, allowing the operator access to any angle.
- Performance:** • Consistent power and weld repeatability.
- Quality:** • Single body handle, abrasion resistant cable, precision crafted consumables.
- Safety:** • Minimize operator stress when accessing out of position welds.
- Serviceability:** • Easy maintenance and replacement of:
- trigger assembly
 - cable
 - gooseneck

TARGETED BENEFITS

- Minimize wrist flexion and rotation.
- Allows user to keep the wrist straight or in a neutral position.
- Relieves stress on wrist and elbows.
- Easier access to out-of-position joint configurations.



REVOLVER™ COMPONENTS



Swivel and Lock Gooseneck:

Rotate and lock to 90 degree increments for out of position welding.

Flexible, Resilient Cable:

Strain relief for longer life, coaxial design includes power, gas, wire and control.

Ergonomic One Piece Handle:

Comfortable, Durable, Impact Resistant.

Trigger Signal:

Quick reaction time, dependable service life.

Gooseneck:

Multiple neck offerings for various applications. Swivel and lock gooseneck for overhead and out of position welds.

CONSUMABLES

Wire Feed Liners

Hardened steel from music wire offers increased wear resistance.

Diffuser

Threaded nozzle-to-diffuser connection provides consistent engagement after repeated remove/replace and thermal cycles.

Tapered Contact Tip

Provides more contact surface area for higher current transfer.

Contact tips are available in either:

Heavy Duty DHP (Deoxidized High Phosphorus) for higher conductivity or

Heavy Duty CuCrZr (Copper Chrome Zirconium - Long Life) with superior hardness providing a more wear resistant tip.

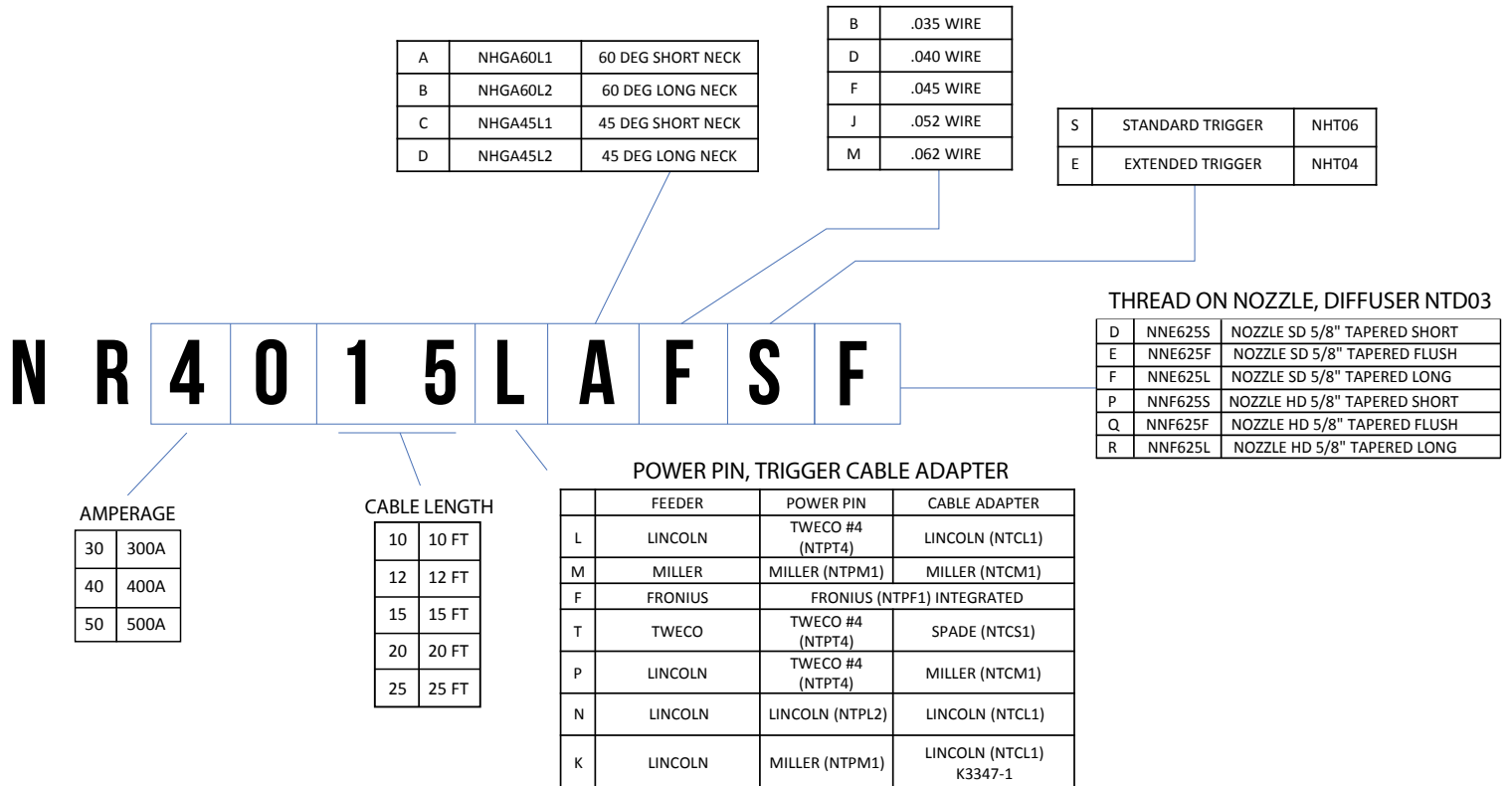
Threaded Nozzle

Standard duty and heavy duty nozzle designs are available with tapered and bottleneck geometries.

Realize the benefit of a simplified inventory with common Nasarc consumables between robotic and handheld welding equipment.

ORDERING INFORMATION

GUN CONFIGURATOR



COMMON PART NUMBERS


The following part numbers are configured with a 15 ft cable, 60 degree short neck, and an extended trigger.




Product Name	Amperage (Mixed Gas) 60% Duty Cycle	Nozzle	Part Number
For Lincoln™ Wire Feeders (Tweco #4 power pin)			
Revolver 3G	300	NNE625S	NR3015LAFED
Revolver 4G	400	NNE625L	NR4015LAFEF
Revolver 5G	500	NNF625L	NR5015LAJER
For Miller™ Wire Feeders			
Revolver 3G	300	NNE625S	NR3015MAFED
Revolver 4G	400	NNE625L	NR4015MAFEF
Revolver 5G	500	NNF625L	NR5015MAJER

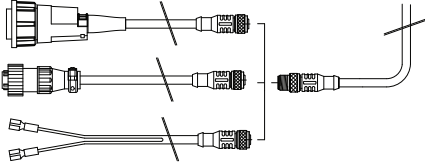
The following consumables are factory installed, others may be ordered separately.

Product Name	Contact Tip	Nozzle	Diffuser	Liner
Revolver 3G	NTTB-35	NNE625S	NTD03	NLB3545
Revolver 4G	NTTB-45	NNE625L	NTD03	NLB3545
Revolver 5G	NTTB-62	NNF625L	NTD03	NLB5262


COMPONENTS

GOOSENECK		
<p>· Forty-Five (45°) and Sixty degree (60°) goosenecks at various lengths to accommodate a wide variety of applications</p>		
Angle (degrees)	Length 1 - short	Length 2 - long
Forty Five (45°)	NHGA45L1	NHGA45L2
Sixty(60°)	NHGA60L1	NHGA60L2

POWER PIN		
Tweco #4	NTPT4	
Miller®	NTPM1	
Lincoln® LN	NTPL2	

TRIGGER CONTROL PLUG		
<p>The default type of trigger control plug is factory installed with each gun when built to order. These are also available separately as alternatives or replacements.</p>		
Lincoln®	NTCL1	
Miller®	NTCM1	
Spade	NTCS1	

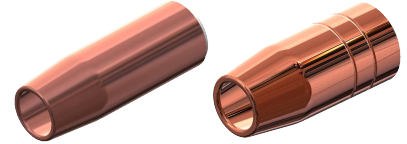
CONSUMABLES

CONTACT TIP				
<p>Heavy Duty DHP: (Deoxidized High Phosphorus): Consistent inner diameter bore and better material conductivity allows for superior arc starts and arc stability during production.</p> <p>Heavy Duty CuCrZr: (Copper Chrome Zirconium - Long Life): Engineered for high duty cycle welding, the consistent Inner Diameter bore and superior hardness provides a more wear resistant tip for longer production time.</p>				
Wire Diameter in. (mm)	HD Copper DHP		HD CuCrZr	
	Pkg. Qty. 25	Pkg. Qty. 100	Pkg. Qty. 25	Pkg. Qty. 100
.035 (0.9)	NTTB-35-PK25	NTTB-35-PK100	NTTC-35-PK25	NTTC-35-PK100
.040 (1.0)	NTTB-40-PK25	NTTB-40-PK100	NTTC-40-PK25	NTTC-40-PK100
.045 (1.2)	NTTB-45-PK25	NTTB-45-PK100	NTTC-45-PK25	NTTC-45-PK100
.052 (1.3)	NTTB-52-PK25	NTTB-52-PK100	NTTC-52-PK25	NTTC-52-PK100
1/16 (1.6)	NTTB-62-PK25	NTTB-62-PK100	NTTC-62-PK25	NTTC-62-PK100
Others	Contact Nasarc Sales			

ORDERING INFORMATION

NOZZLE

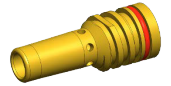
- Standard and Heavy-Duty designs are available with tapered (conical) geometry.
- Threads to diffuser NTD03.
- Other nozzle geometries are available, contact Nasarc Sales.



Nozzle-Tip relationship in (mm)	Standard Duty Pkg.Qty.5	Heavy Duty Pkg.Qty.5
(+) 1/8" (3.2) Stick-out	NNE625S-PK5	NNF625S-PK5
Flush (0)	NNE625F-PK5	NNF625F-PK5
(-) 1/8" (3.2) Recess	NNE625L-PK5	NNF625L-PK5

DIFFUSER

- Threaded nozzle-to-diffuser connection provides a consistent engagement after repeated replacement and thermal cycles.



	(Pkg.Qty.5)
Threaded type	NTD03-PK5

GUN LINER

- Hardened Steel from music wire offers increased wear resistance.
- Choose liner according to wire diameter and gun length.
- Liners are manufactured to extend past the diffuser and must be cut to proper length.

Wire Diameter Range in. (mm)	for 10 ft.	for 12 ft.	for 15 ft.	for 20 ft.	for 25 ft.
.035 - .045 (0.9 - 1.2)	NLG3545	NLD3545	NLB3545	NLE3545	NLF3545
.052 - .062 (1.3 - 1.6)	NLG5262	NLD5262	NLB5262	NLE5262	NLF5262