

MIG/MAG-Welding Torch Push-Pull Inline "PPI"



The Features:

- Feeder specific direct connect with integrated handle mounted wire speed control
- Constant and problem-free wire feeding thanks to a powerful pull motor with dual drive rolls
- Precise and automatic contact pressure regulation of the wire feeding rollers
- Wearing parts are identical to those of the tried-and-trusted MB torch series - minimizes stocking
- Optimum torch cooling - long consumable life
- Sturdy design - long service life
- Electrically isolated drive rolls - no micro-arcing
- Ease of maintenance with simple quick cable replacement

Technical Data (EN 60 974-7):

Pi 36

Cooling:	air-cooled
Duty cycle:	60%
CO ₂	300 A
Mixed gases	270 A*
Wire size:	.030" - .062" (0.8 - 1.6mm)

Pi 401D

Cooling:	water-cooled
Duty cycle:	100%
CO ₂	400 A
Mixed gases	350 A*
Wire size:	.030" - .062" (0.8 - 1.6mm)

*For pulse welding reduce rating by 35%

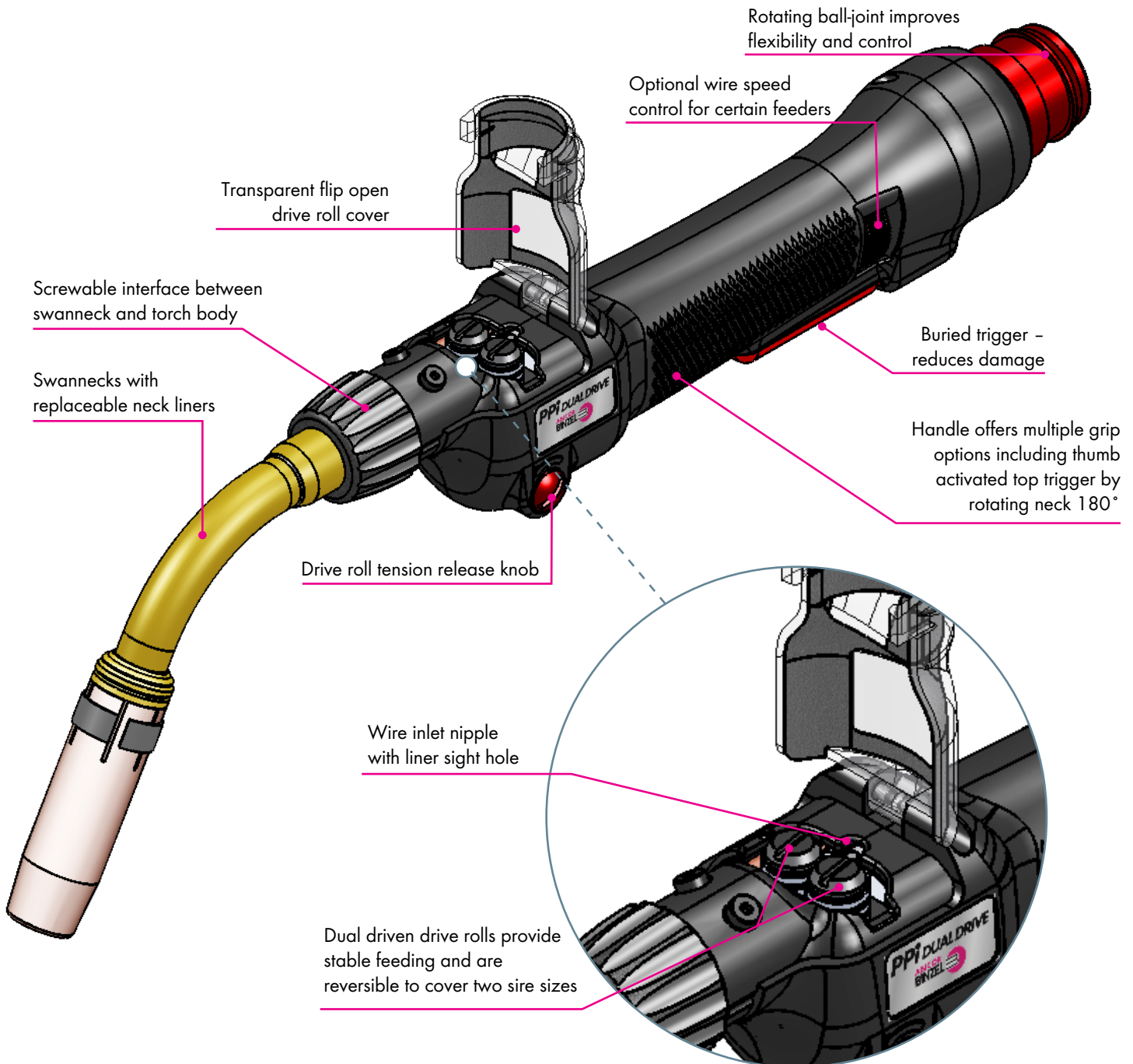


MIG/MAG-Welding Torch Push-Pull Inline "PPi" For constant and problem-free wire feeding!

The welding torches of the PPi- especially developed for aluminum welding requirements and the use of thin wires - makes problem-free and constant wire feed possible, even with longer cable assemblies. A powerful, sturdy pull motor guarantees exact speed regulation for optimum wire feed without frictional loss. The contact pressure of the dual feeding rollers occurs automatically. The ergonomic handle provides multiple grip positions and ensures optimum and low-fatigue handling.

The screw-on torch necks can be replaced quickly. A special interface between the handle and the torch neck makes it possible to rotate the necks up to 360°. Available in air-cooled for capacities up to 300 A and water-cooled up to 400 A. The PPi series necks are based on the tried-and-trusted "MB" torch neck structure.

The main areas of application for these welding torches include shipbuilding, container and tank manufacture etc., as well as in construction of automobile and railway vehicles. Wherever exact an constant wire feeding is essential.



PUSH-PULL Inline GUNS

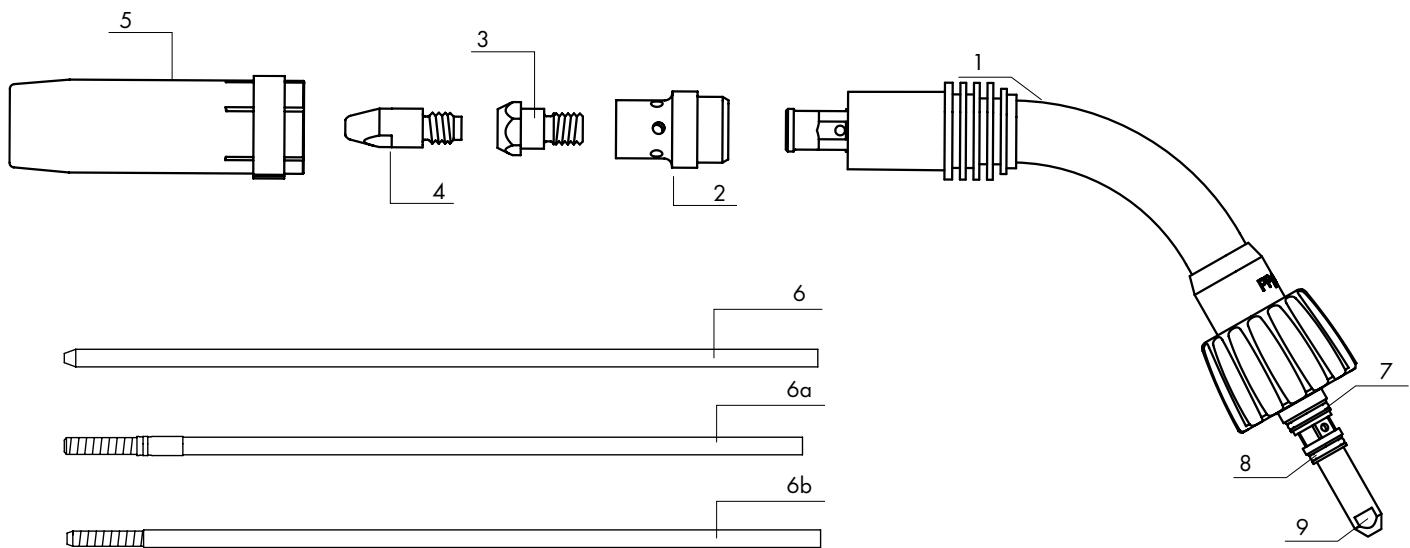
ORDERING INSTRUCTIONS FOR COMPLETE GUNS

Pi	A	25	-	6	S	-	35	E
Torch Model	Type	Cable Length		Swanneck Angle	Nozzle Type		Wire Size	Back End
Torch Model Ppi - Push-pull Inline	Type A - Air-cooled W - Water-cooled	Cable Length 15 - 15' 25 - 25'		Swanneck Angle 6 - 60 Degree bend	Nozzle Type S - Slip-on nozzle		Wire Size 30 - .030" 35 - .035" 45 - .045" - .047" 62 - .062"	Back End *B - Binzel Euro L - Lincoln 7-pin K - Lincoln 12-pin connection

* The BINZEL Euro option torch connects to any commercial available push wire feeder via a BINZEL Euro adaptor kit (See LIT.9039). These torches also require the use of a BINZEL Universal Power Supply P/N 284.0660, both of which are sold seperately.

PPI 36

MIG Gun Parts and Consumables: Front End



Item No.	Description	Pkg Qty	Part No.
1	Swanneck 60 Degree	1	093.0115.1
2	Diffuser	10	014.9374.US
3	*Tip Holder M8 Spray Arc (22mm)	10	142.0082
	Tip Holder M8 Short Arc (25mm)	10	142.0026
	Tip Holder M6 Spray Arc (22mm)	10	142.0007
	Tip Holder M6 Short Arc (25mm)	10	142.0012

Standard M8 Contact tips

4	Contact Tip .030" AL	25	141.0003
	Contact Tip .035" AL	25	141.0043
	Contact Tip .040" AL	25	141.0008
	Contact Tip .045" AL	25	141.0075
	Contact Tip .062" AL	25	141.0022

Optional M8 Contact tips

4	Contact Tip .030" CU	25	140.0114
	Contact Tip .035" CU	25	140.0214
	Contact Tip .040" CU	25	140.0313
	Contact Tip .045" CU	25	140.0442
	Contact Tip .062" CU	25	140.0587

Optional M6 Contact tips

4	Contact Tip .030" AL	25	141.0001
	Contact Tip .035" AL	25	141.0004
	Contact Tip .040" AL	25	141.0006
	Contact Tip .045" AL	25	141.0010
	Contact Tip .062" AL	25	141.0020
	Contact Tip .030" CU	25	140.0051
	Contact Tip .035" CU	25	140.0169
	Contact Tip .040" CU	25	140.0242
	Contact Tip .045" CU	25	140.0379
	Contact Tip .062" CU	25	140.0555

Nozzles

5	Nozzle Cylindrical	5	145.0051
	*Nozzle Conical (Standard)	5	145.0085
	Nozzle Conical Small	5	145.0132
	Nozzle Conical Heavy Duty	5	145.0086

Item No.	Description	Pkg Qty	Part No.
Neck liners			
6	*Neck liner orange .030"-.035" for 60D	1	093.0107.1
	*Neck liner blue .045"-.062" for 60D	1	093.0108.1
6a	Neck liner combi PA for 60D .030"-.035"	1	093.0109.1
	Neck liner combi PA for 60D .045"-.062"	1	093.0110.1
6b	Neck liner steel insulated for 60D .030"-.035"	1	093.0111.1
	Neck liner steel insulated for 60D .045"-.062"	1	093.0112.1
7	O-ring	1	165.0011
8	O-ring	1	165.0064
9	Wire Inlet Guide w/O-rings	1	093.0105.1

Drive Rolls

N/S	Drive Roll D shaped for .030"/.035" wire	1	093.0012.1
	Drive Roll D shaped for .045"/.062" wire	1	093.0013.1

Cable Liners for Aluminum

N/S	*Liner PA .030"-.035" f/15' PPI	1	128.0050
	*Liner PA .030"-.035" f/25' PPI	1	128.0051
	*Liner PA .045"-.062" f/15' PPI	1	128.0053
	*Liner PA .045"-.062" f/25' PPI	1	128.0054

Cable Liners for stainless steel wires

N/S	Liner C-TFE .024" - .030" 17'	1	127.9009
	Liner C-TFE .024" - .030" 28'	1	127.9012
	Liner C-TFE .035" - .045" 17'	1	127.9003
	Liner C-TFE .035" - .045" 28'	1	127.9011
	Liner C-TFE .052" - .062" 17'	1	127.9006
	Liner C-TFE .052" - .062" 28'	1	127.9010

AL - Designates oversized contact tips for aluminum wires.

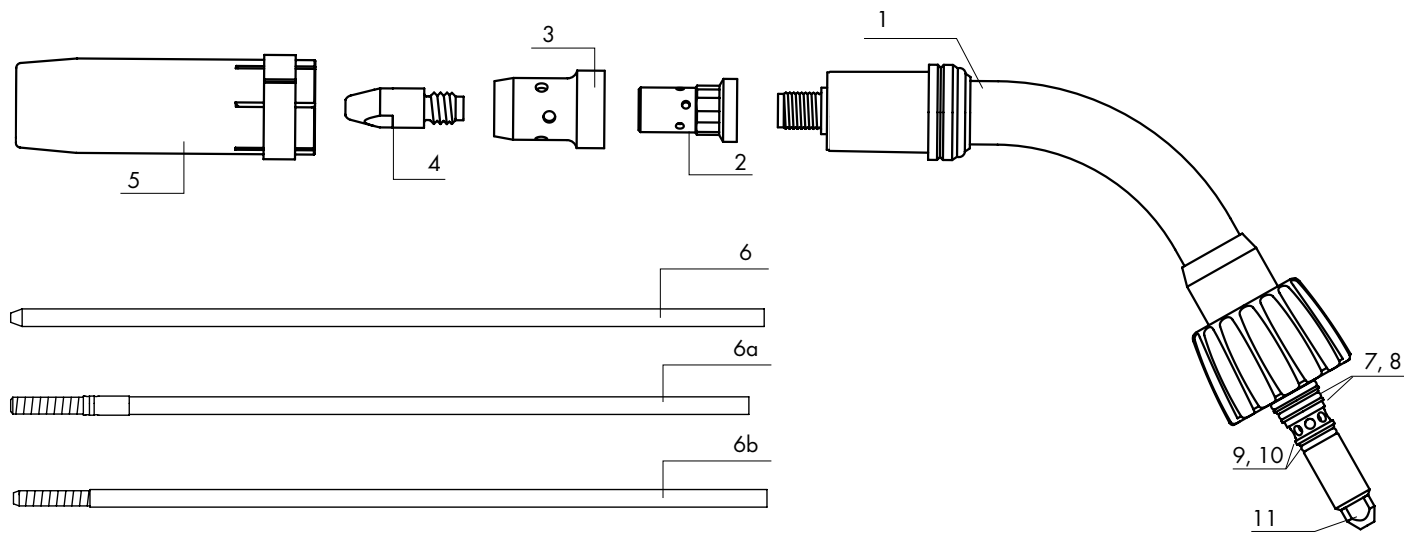
CU - Designates standard contact tips for steel and stainless steel wires.

* Designates standard factory set-up options.

Please contact our Product Department at 1-800-542-4867 for further information.

PPi 401D

MIG Gun Parts and Consumables: Front End



Item No.	Description	Pkg Qty	Part No.
1	Swanneck 60 Degree	1	093.0040.1
2	* Tip Holder M8 Spray Arc (25mm long)	10	142.0022
	Tip Holder M6 Spray Arc (25mm long)	10	142.0008
3	* Diffuser	10	030.0145
3	Diffuser Hi-Temp	10	030.0037
Standard M8 Contact tips			
4	Contact Tip .030" AL	25	141.0003
	Contact Tip .035" AL	25	141.0043
	Contact Tip .040" AL	25	141.0008
	Contact Tip .045" AL	25	141.0075
	Contact Tip .062" AL	25	141.0022
Optional M8 Contact tips			
4	Contact Tip .030" CU	25	140.0114
	Contact Tip .035" CU	25	140.0214
	Contact Tip .040" CU	25	140.0313
	Contact Tip .045" CU	25	140.0442
	Contact Tip .062" CU	25	140.0587
Optional M6 Contact tips			
4	Contact Tip .030" AL	25	141.0001
	Contact Tip .035" AL	25	141.0004
	Contact Tip .040" AL	25	141.0006
	Contact Tip .045" AL	25	141.0010
	Contact Tip .062" AL	25	141.0020
	Contact Tip .030" CU	25	140.0051
	Contact Tip .035" CU	25	140.0169
	Contact Tip .040" CU	25	140.0242
	Contact Tip .045" CU	25	140.0379
	Contact Tip .062" CU	25	140.0555
Nozzles			
5	Nozzle Cylindrical (20mm ID)	5	145.0051
	*Nozzle Conical (Standard) (16mm ID)	5	145.0085
	Nozzle Conical Small (14mm ID)	5	145.0132
	Nozzle Conical Heavy Duty (16mm ID)	5	145.0086

Item No.	Description	Pkg Qty	Part No.
Neck liners			
6	* Neck liner orange for 60D spray arc .030"-.035"	1	093.0099.1
	* Neck liner blue for 60D spray arc .045"-.062"	1	093.0100.1
6a	Neck liner combi PA for 60D spray arc .030"-.035"	1	093.0101.1
	Neck liner combi PA for 60D spray arc .045"-.062"	1	093.0102.1
6b	Neck liner steel insulated for 60D spray arc .030"-.035"	1	093.0113.1
	Neck liner steel insulated for 60D spray arc .045"-.062"	1	093.0114.1
7	O-ring	1	165.0014
8	O-ring	1	165.0012
9	O-ring	1	165.0011
10	O-ring	1	165.0064
11	Collet	1	093.0106.1
Drive Rolls			
N/S	Drive Roll D shaped for .030"/.035" wire	1	093.0012.1
	Drive Roll D shaped for .045"/.062" wire	1	093.0013.1
Cable Liners for Aluminum			
N/S	*Liner PA .030"-.035" f/15' PPi	1	128.0050
	*Liner PA .030"-.035" f/25' PPi	1	128.0051
	*Liner PA .045"-.062" f/15' PPi	1	128.0053
	*Liner PA .045"-.062" f/25' PPi	1	128.0054
Cable Liners for stainless steel wires			
N/S	Liner C-TFE .024" - .030" 17'	1	127.9009
	Liner C-TFE .024" - .030" 28'	1	127.9012
	Liner C-TFE .035" - .045" 17'	1	127.9003
	Liner C-TFE .035" - .045" 28'	1	127.9011
	Liner C-TFE .052" - .062" 17'	1	127.9006
	Liner C-TFE .052" - .062" 28'	1	127.9010

AL - Designates oversized contact tips for aluminum wires.

CU - Designates standard contact tips for steel and stainless steel wires.

* Designates factory standard.

Please contact our Product Department at 1-800-542-4867 for further information.

Push-Pull Inline Universal Power Supply P/N 284.0660

BINZEL PPI Universal Power Supply Description

Power for the Binzel PPI torch pull motor is obtained from the Binzel "PPI Universal Power Supply". The PPI power supply provides torque regulated power to the torch pull motor, and is compatible with any conventional push wire feeder, as long as crater fill and/or pre-flow gas modes are not selected.

How It Works

When the torch motor is switched on via the torch trigger, the torch pull motor attempts to run at maximum speed. The speed of the pull motor is inhibited by the wire speed feed, which is controlled by the main wire drive unit. This results in a tensioning of the wire in the liner, providing smooth and stable feeding.

The slowing of the pull motor due to the drag effect of the wire results in an increase in current, which is dissipated through a resistor in the form of heat. This will provide tension on the wire relative to the speed of the push motor without over load of the pull motor.

CAUTION! Obtaining current for the PPI torch from any other source that does not contain similar electrical circuitry could result in improper wire feeding, wire shavings, and damage to the pull motor or wire feeder.

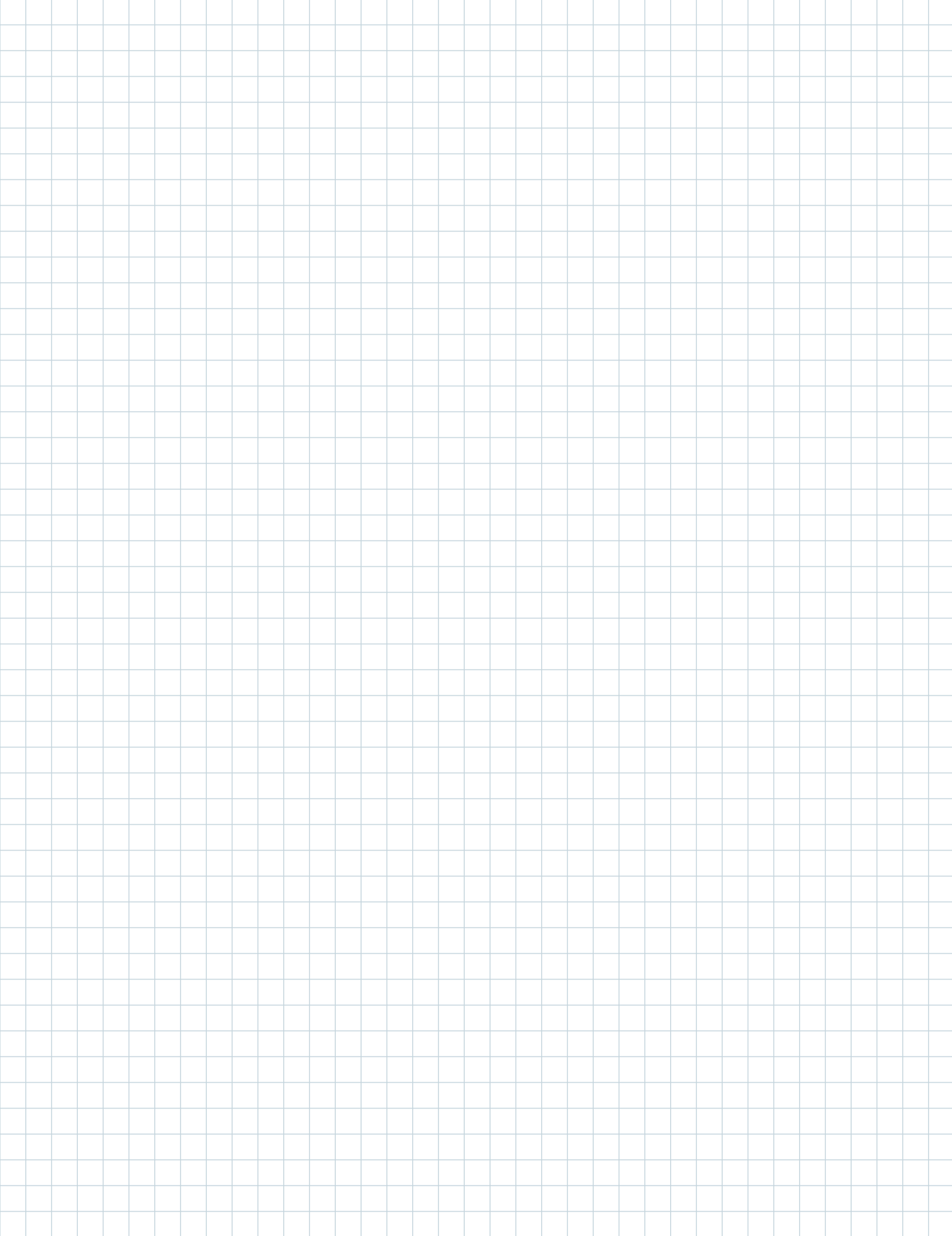
Installation

1. Connect the Binzel PPI Euro torch to a Euro equipped feeder (may require a Binzel adaptor kit - see Lit.9039)
2. Connect the 7-pin connector from the PPI torch to the 7-pin connector on the front of PPI power supply.
3. Plug the PPI power supply cord into a 120 volt, 60Hz receptacle.

Note: The PPI power supply is only suitable for torches with smart torch part numbers ending in "B".



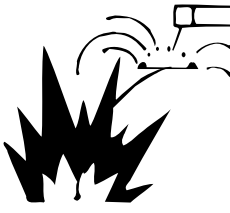

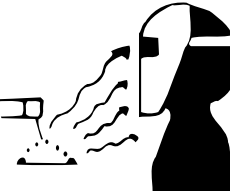



Notes



Safety Guidelines WARNING!

Please read all safety instructions.

 <h2 style="margin: 0;">WARNING</h2>			
<ul style="list-style-type: none"> • Read and follow the manufacturer's instructions, employer's safety practices and Material Safety Data Sheets (MSDSs). • Only qualified personnel should install, use or service this material and/or equipment. 		<p>ELECTRIC SHOCK can kill.</p> <ul style="list-style-type: none"> • Always wear dry insulating gloves. • Do not touch live electrical parts. • Always disconnect power source before hooking up or changing electrodes, nozzles and other parts. 	
	<p>WELDING SPARKS can cause fire or explosion.</p> <ul style="list-style-type: none"> • Do not weld near flammable material. • Do not weld on closed containers. • Remove combustibles from the work area and/or provide a fire watch. • Avoid oily or greasy clothing as a spark may ignite them. 		<p>FUMES AND GASES can be hazardous to your health.</p> <ul style="list-style-type: none"> • Keep your head out of the fumes. • Use enough ventilation or exhaust at the arc to keep fumes and gases from your breathing zone, and the general area. • Fumes from welding and cutting can deplete air quality, causing injury or death. Always wear an air supplied respirator in confined areas or if breathing air is not safe.
	<p>ARC RAYS can injure eyes and burn skin.</p> <ul style="list-style-type: none"> • Always wear correct eye, ear and body protection. • Always wear a welding helmet with the proper grade filter lens. Protect yourself and others from spatter arc flash rays by using protective screens, barriers and welding curtains. • Always wear protective gloves and clothing to cover exposed skin. This will aid in the prevention of arc and spatter burns. 		<p>LOUD NOISE can damage hearing.</p> <ul style="list-style-type: none"> • Always wear protective hearing devices to ensure protection when noise levels exceed OSHA standards.
<p>Do Not Remove This Label.</p>		<p>ID 123-4567C1</p>	
<p>Alexander BINZEL Corporation 650 Medimmune Court, Suite 110, Frederick, MD 21703 Tel: (301)846-4196 Fax: (301)846-4497 www.binzel-abicor.com</p>			
<p>Read American National Standard Z49.1, "Safety in Welding, Cutting and Allied Processes" available from the American Welding Society, 8669 NW 36th Street, Miami, FL 33166; OSHA Safety and Health Standards, available from U.S. Government Printing Office, Washington, DC 20402</p>			

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