

# Push-Pull Welding Torch PP 24 D/26 D/36 D air-cooled



**BINZEL.** The right welding torch for every job!

BINZEL welding torches incorporate the high quality and technology needed for trouble-free performance whatever the welding job. All BINZEL torches are constructed to the highest standards and offer the greatest working comfort.

Thanks to a supplementary pull motor in the handle, PUSH-PULL welding torches guarantee constant and problem-free wire feeding. Push-pull guns are ideally suited for hard-to-feed wire like aluminium, thin wire and for extended cable assemblies that allow welding at longer distances from the wire

#### Technical data (EN 50 078):

PP 24 D / PP 26 D / PP 36 D

Rating: 250 A / 230 A / 300 A CO<sub>2</sub>

220 A / 200 A / 270 A

Mixed Gases M 21 (DIN EN 439)

35% / 35% / 60% Duty Cycle

Wire sizes: 0.8 - 1.2

drive unit. PUSH-PULL torches have become the industry standard in shipbuilding, container and tank manufacture, and are also used extensively in the construction of automobiles, railroad cars and rolling stock.

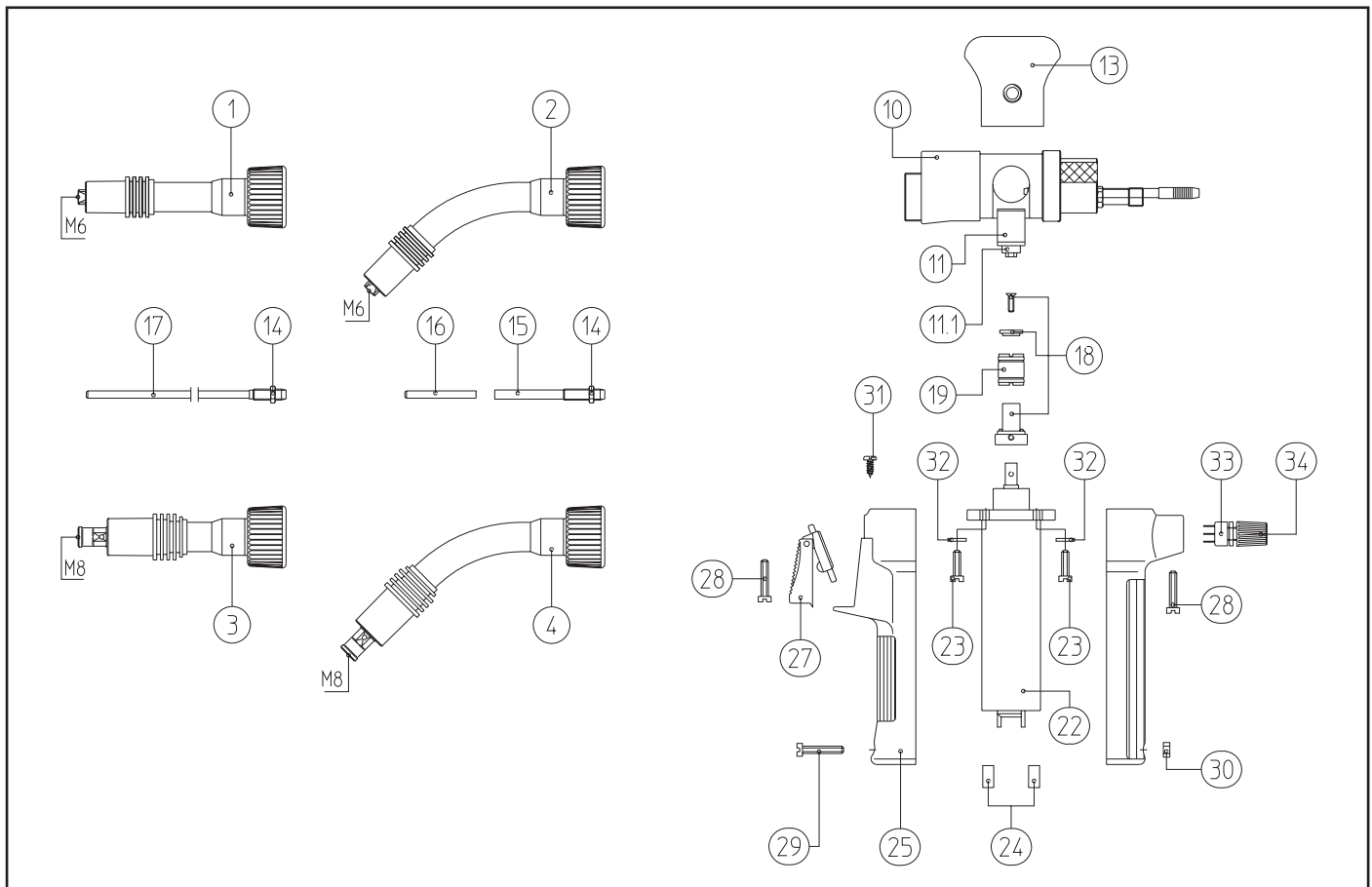
Rated using power source with VDE standard volt/amp characteristic ( $U=14+0,05xI$ ). When pulse welding, reduce rating by 35%.

Type	Version	Motor	Cable length	Part no.
PP 24 D	straight	42 V	8.00 m	082.0011
	45° bent	42 V	8.00 m	082.0014
PP 26 D	straight	42 V	8.00 m	081.0033
	45° bent	42 V	8.00 m	081.0035
PP 36 D	straight	42 V	8.00 m	083.0014
	45° bent	42 V	8.00 m	083.0017

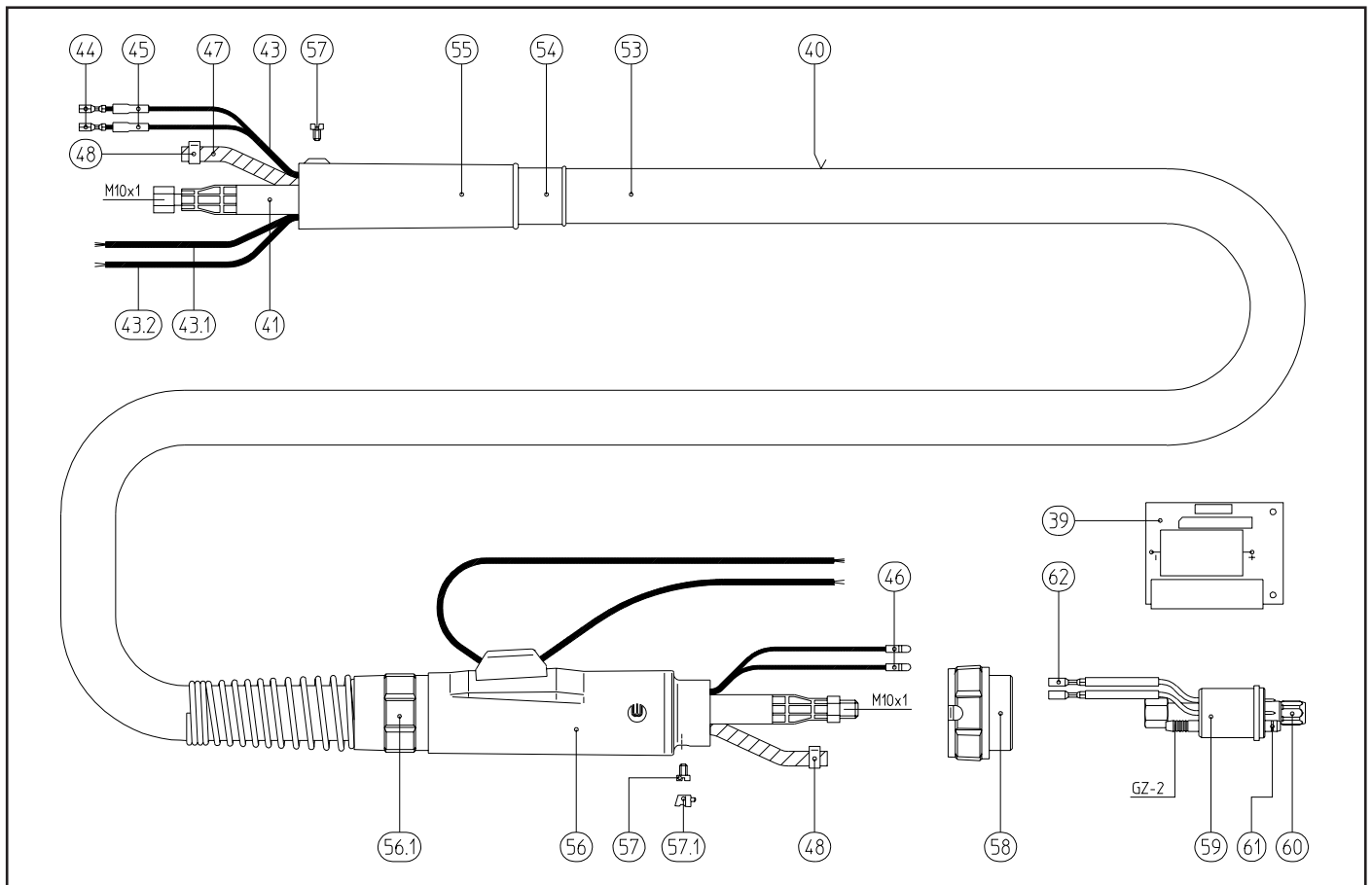
NB: Also available with 24 V Motor. If requested, the torch can be delivered with a potentiometer mounted in the handle.

Welding & cutting brought to the point.

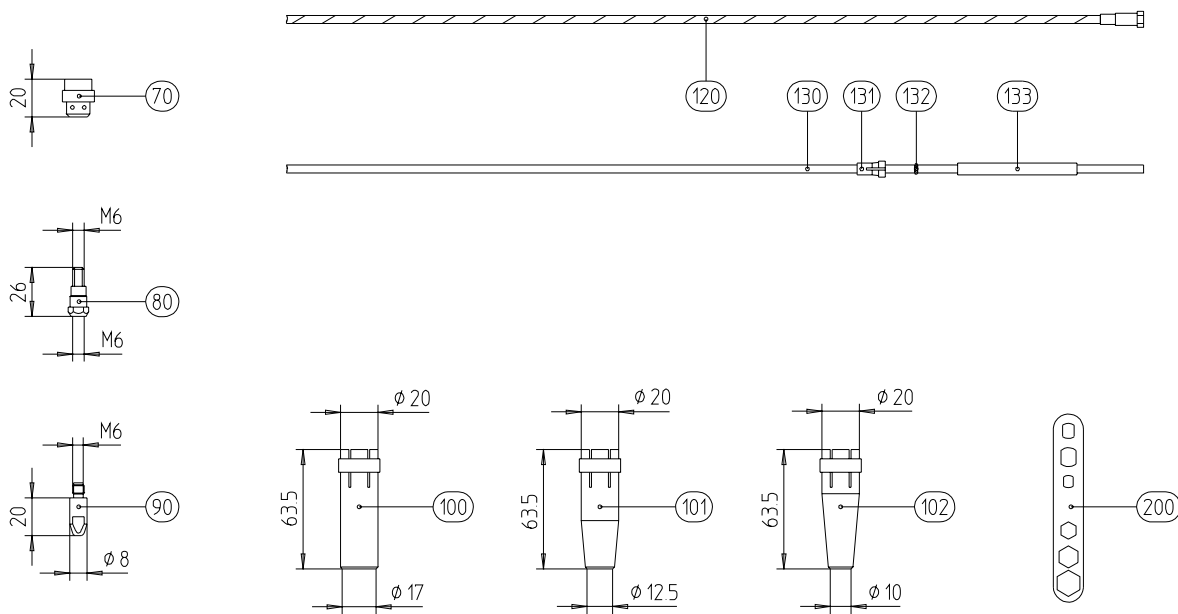




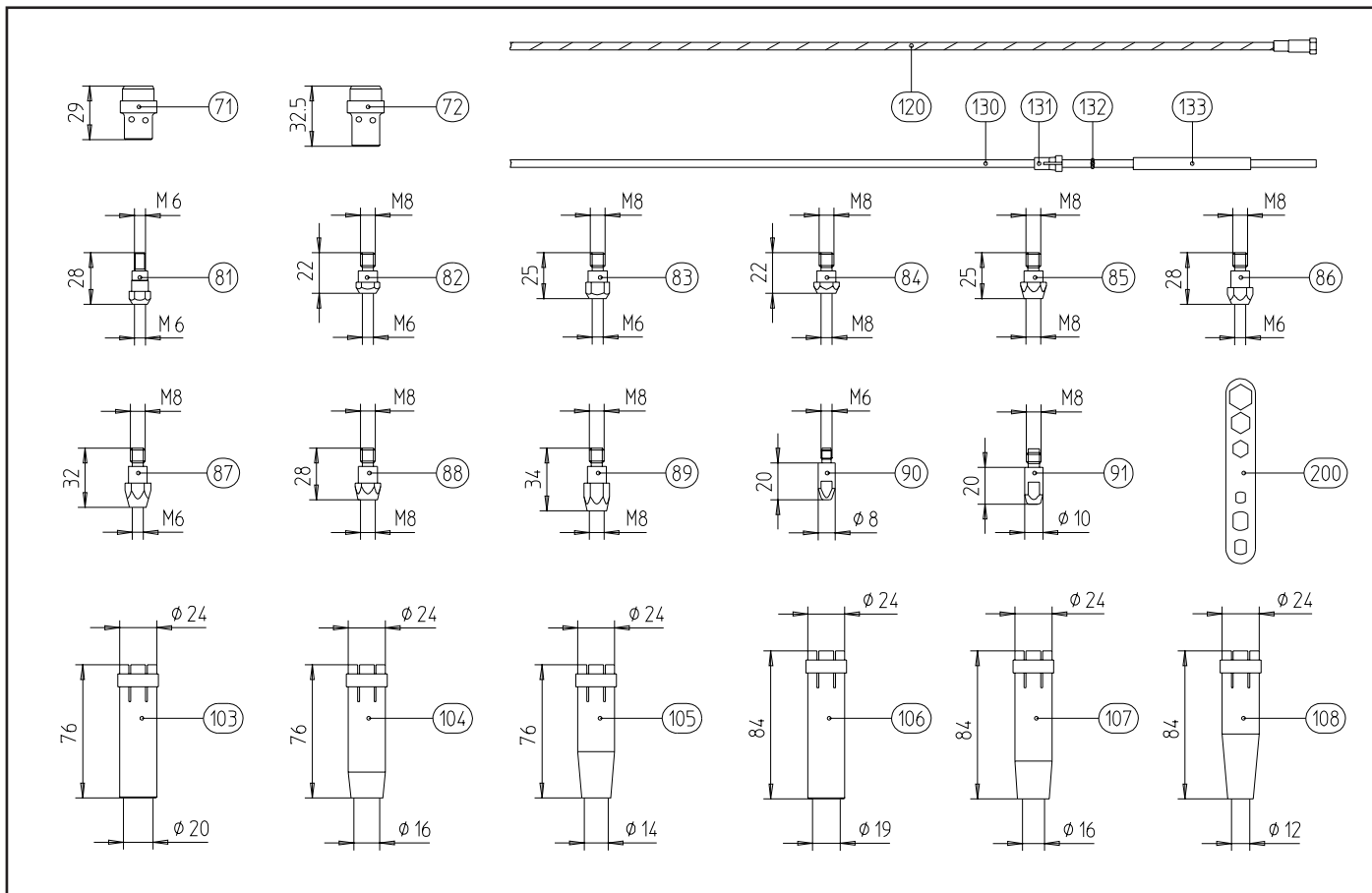
Build group	Pos.	Description	Specifications	Part no.
<b>Swan neck</b>	1	Straight neck PP 24 D		082.0001
	2	Swan neck PP 24 D, 45° bent		012.0194
	3	Straight neck PP 26/36 D		081.0002
	4	Swan neck PP 26/36 D, 45° bent		014.0095
<b>Torch body, gear motor and accessories</b>	10	Torch body PPL cpl.		081.0003
	11	Idler arm cpl.		080.0007
	11.1	Pressure roll		080.0042
	13	Drive roll cap cpl.		080.0003
		Pressure spring		080.0032
		Ball		080.0043
		Drive roll cap		080.0005
		Knob for drive roll cap		080.0006
	14	Lock nut M6	20 pcs.	081.0018
	15	Wire guide for bent neck 60.0 mm long		081.0016
	16	Brass-liner CuZn 37; 1.8/4.4 (up to wire Ø 1.2)	per meter	120.0018
	17	Wire guide for straight neck 148.0 mm long		081.0017
	18	Drive roll seat cpl.		080.0004
	19	Wire drive roll, for wire Ø 0.8 mm		080.0019
		Wire drive roll, for wire Ø 1.0 mm		080.0021
		Wire drive roll, for wire Ø 1.2 mm		080.0022
	22	Gear motor 42 V with flange for wire drive roll		080.0010
		Gear motor 24 V with flange for wire drive roll		080.0092
		w/o. fig. Transformer prim. 24 V / sec. 36 V		080.0045
		w/o. fig. Transformer prim. 110 V / sec. 36 V		080.0055



Build group	Pos.	Description	Specifications	Part no.
	23	Screw M3x10	20 pcs.	000.0543
	24	Brushes for gear motor		080.0046
<b>Handle</b>	25	Handle		080.0096
	27	Trigger 2 pol.		185.0005
	28	Screw M3x20	20 pcs.	000.0548
	29	Screw M4x25	20 pcs.	000.0560
	30	Hexagon nut M4	20 pcs.	009.0172
	31	Screw 2.9x6.5	20 pcs.	079.0003
	32	Ring	20 pcs.	001.0271
	33	Potentiometer 2.2 K $\Omega$		187.0006
		Potentiometer 4.7 K $\Omega$		187.0003
		Potentiometer 10.0 K $\Omega$		187.0004
	34	Potentiometer knob		400.0108
<b>Circuit board</b>	39	Printed circuit board for 42 V motor		080.0009
<b>Cable assembly</b>	40	Cable assembly, cpl. 8.00 m with 7-pol. control leads without central connector GZ-2 (for PP24 and PP26)		080.0065
		Cable assembly, cpl. 8.00 m with 7-pol. control leads without central connector GZ-2 (for PP36)		083.0002
	41	Bikox power cable 8.00 m (for PP24 and PP26)	B6	153.0054
		Bikox power cable 8.00 m (for PP36)	B7	153.0129
	43	Control cable 2 pol.	per meter	100.0019
	43.1	Control cable 3 pol.	per meter	100.0023
	43.2	Control cable 2 pol.	per meter	100.0123
	44	Trigger wire connector	20 pcs.	175.0022



Build group	Pos.	Description	Specifications	Part no.
<b>Cable assembly</b>	45	Insulating sleeve	20 pcs.	400.0119
	46	Trigger wire connector, male	20 pcs.	175.0004
	47	Hose 30 black Ø 4.9x1.5	per meter	109.0040
	48	Hose clamp Ø 8.7 mm	20 pcs.	171.0002
	53	Outer cover Ø 25x1.5	per meter	107.0004
	54	Cable support torch side		400.0189
	55	Cable support		080.0026
	56	Cable support 2 consisting of:		501.0342
		Cable support		501.2379
		Hose guide with hole		500.0334
	56.1	Connecting set machine side ND 29 consisting of:		501.2236
		Cable support spring		500.0233
		Biclip inside		400.0328
		Biclip Outside		400.0329
	57	Screw M4x6	20 pcs.	000.0552
57.1	Covering cap	20 pcs.	500.0251	
58	Adaptor nut		500.0213	
59	Central adaptor block GZ-2 with control leads		501.0005	
60	Nut M10x1	10 pcs.	501.0082	
61	O-ring 4x1	20 pcs.	165.0002	
62	Trigger wire connector, female	20 pcs.	175.0003	
<b>Wear parts</b>	70	Gas diffuser for PP 24 D, white	• 10 pcs.	012.0183
	71	Gas diffuser for PP 26 D, white	Δ 10 pcs.	018.0116
	72	Gas diffuser for PP 36 D, white	+ 10 pcs.	014.0261
		Gas diffuser for PP 36 D, long life	10 pcs.	014.0026



Build group	Pos.	Description	Specifications	Part no.
Wear parts	80	Contact tip holder M6, 26.0 mm (short) for PP 24 D	• 10 pcs.	142.0003
	81	Contact tip holder M6, 28.0 mm (long) for PP 24 D	10 pcs.	142.0010
	82	Contact tip holder M6, 22.0 mm (short) for PP 26 D	Δ 10 pcs.	142.0007
	83	Contact tip holder M6, 25.0 mm (long) for PP 26 D	10 pcs.	142.0012
	84	Contact tip holder M8, 22.0 mm (short) for PP 26 D	10 pcs.	142.0082
	85	Contact tip holder M8, 25.0 mm (long) for PP 26 D	10 pcs.	142.0026
	86	Contact tip holder M6, 28.0 mm (short) for PP 36 D	+ 10 pcs.	142.0005
	87	Contact tip holder M6, 32.0 mm (long) for PP 36 D	10 pcs.	142.0011
	88	Contact tip holder M8, 28.0 mm (short) for PP 36 D	10 pcs.	142.0020
	89	Contact tip holder M8, 34.0 mm (long) for PP 36 D	10 pcs.	142.0024
	90	Contact tip M6 E-Cu, Ø 0.8 <sup>4)</sup>	10 pcs.	140.0051
		Contact tip M6 E-Cu, Ø 1.0 <sup>4)</sup>	•Δ 10 pcs.	140.0242
		Contact tip M6 E-Cu, Ø 1.2 <sup>4)</sup>	+ 10 pcs.	140.0379
		Contact tip M6 CuCrZr, Ø 0.8 <sup>4)</sup>	10 pcs.	140.0054
		Contact tip M6 CuCrZr, Ø 1.0 <sup>4)</sup>	10 pcs.	140.0245
		Contact tip M6 CuCrZr, Ø 1.2 <sup>4)</sup>	10 pcs.	140.0382
		Contact tip M6 E-Cu, Ø 0.8 for alu wire <sup>4)</sup>	10 pcs.	141.0001
		Contact tip M6 E-Cu, Ø 1.0 for alu wire <sup>4)</sup>	10 pcs.	141.0006
		Contact tip M6 E-Cu, Ø 1.2 for alu wire <sup>4)</sup>	10 pcs.	141.0010
	91	Contact tip M8 E-Cu, Ø 0.8 <sup>4)</sup>	10 pcs.	140.0114
		Contact tip M8 E-Cu, Ø 1.0 <sup>4)</sup>	10 pcs.	140.0313
		Contact tip M8 E-Cu, Ø 1.2 <sup>4)</sup>	+ 10 pcs.	140.0442
		Contact tip M8 CuCrZr, Ø 0.8 <sup>4)</sup>	10 pcs.	140.0117
		Contact tip M8 CuCrZr, Ø 1.0 <sup>4)</sup>	10 pcs.	140.0316
		Contact tip M8 CuCrZr, Ø 1.2 <sup>4)</sup>	10 pcs.	140.0445
		Contact tip M8 E-Cu, Ø 0.8 for alu wire	10 pcs.	141.0003
		Contact tip M8 E-Cu, Ø 1.0 for alu wire	10 pcs.	141.0008
		Contact tip M8 E-Cu, Ø 1.2 for alu wire <sup>4)</sup>	10 pcs.	141.0015

Build group	Pos.	Description	Specifications	Part no.
<b>Wear parts</b>	100	Gas nozzle, cylindrical ND Ø 17.0 for PP 24 D	10 pcs.	145.0047
	101	Gas nozzle, conical ND Ø 12.5 for PP 24 D	• 10 pcs.	145.0080
	102	Gas nozzle, conical ND Ø 10.0 for PP 24 D	10 pcs.	145.0128
	103	Gas nozzle, cylindrical ND Ø 20.0 for PP 26 D	10 pcs.	145.0051
	104	Gas nozzle, conical ND Ø 16.0 for PP 26 Δ	10 pcs.	145.0085
	105	Gas nozzle, conical ND Ø 14.0 for PP 26 D	10 pcs.	145.0132
	106	Gas nozzle, cylindrical ND Ø 19.0 for PP 36 D	10 pcs.	145.0045
	107	Gas nozzle, conical ND Ø 16.0 for PP 36 D	+ 10 pcs.	145.0078
	108	Gas nozzle, conical ND Ø 12.0 for PP 36 D	10 pcs.	145.0126
	120	Guide spiral liner blank 1.5/4.0 with nipple for wire electrode <sup>1)</sup> Ø 0.6-0.9	for 8.00 m	122.0010
		Guide spiral liner blank 2.0/4.5 with nipple for wire electrode <sup>1)</sup> Ø 1.0-1.2	for 8.00 m	122.0040
	130	Teflon core liner 1.5/4.0 blue with collet and o-ring for wire electrode <sup>2)</sup> Ø 0.6-1.0	for 8.00 m	126.0013
		Teflon core liner 2.0/4.0 red with collet and o-ring for wire electrode <sup>2)</sup> Ø 1.0-1.2	for 8.00 m	126.0030
		Teflon carbon core liner 1.5/4.0 with collet and o-ring for wire electrode <sup>2)</sup> Ø 0.6-1.0	for 8.00 m	127.0015
		Teflon carbon core liner 2.0/4.0 with collet and o-ring for wire electrode <sup>2)</sup> Ø 1.0-1.2	for 8.00 m	127.0009
		Polyamid core liner <sup>3)</sup> 2.0/4.0 with collet and o-ring for wire electrode <sup>2)</sup> Ø 1.0-1.2	• Δ + for 8.00 m	128.0019
	131	Collet for core liner Ø 4.0	20 pcs.	131.0001
	132	O-ring 3.5x1.5	20 pcs.	165.0008
	133	Guide tube for core liners up to Ø 4.0	200 mm	129.0461
		Guide tube for core liners up to Ø 4.0	300 mm	129.0471
200	Spanner	10 pcs.	191.0001	

<sup>1)</sup> Applicable for GMA welding of unalloyed and low-alloyed steels (DIN 8555 and 8559).

<sup>2)</sup> Applicable for GMA welding of aluminium (DIN 1732), copper and copper alloys (DIN 1733) and nickel/nickel alloys (DIN 1736); Also for use with GMA welding of stainless and heat resistant steels (DIN 8556).

<sup>3)</sup> Applicable up to max. 150° C.

<sup>4)</sup> As an alternative: Packing unit 50 pcs. Specification of order: 140.xxxx.50 or 141.xxxx.50.

• Standard equipment PP 24 D

Δ Standard equipment PP 26 D

+ Standard equipment PP 36 D

The positions indicating "per meter" are available in commercial lengths.

Welding & cutting brought to the point.



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