



WELD THE WORLD

Push-pull torch kit

Installation Manual

ENGLISH

Translation of original instructions





ENGLISH



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1 GENERAL INFORMATION



IMPORTANT! For your safety

This documentation must be consigned to the user prior to installation and commissioning of the unit.

 **Read the manual "GENERAL INSTRUCTIONS FOR USE" provided separately from this manual before installing and commissioning the equipment.**

The meaning of the symbols in this manual and the associated precautionary information are given in the "GENERAL INSTRUCTIONS FOR USE".

If the "GENERAL INSTRUCTIONS FOR USE" are not present, it is mandatory to request a replacement copy from the Manufacturer or from your dealer.

Retain these documents for future consultation.

Meaning of the symbols



DANGER!

This pictogram warns of danger of death or serious injury.



WARNING!

This pictogram warns of a risk of injury or damage to property.



CAUTION!

This pictogram warns of a potentially hazardous situation.



NOTICE!

This pictogram gives important information concerning the execution of the relevant operations.



Information

This pictogram indicates additional information or refers to another section of the manual with the related information.

- **Note:** The figures in this manual are purely guideline and the images may contain differences with respect to the actual equipment to which they refer.

1.1 PRESENTATION

The kit allows the use of push-pull type torches with welding power sources and wire feeders designed for this function.

The kit can be installed on the following devices:

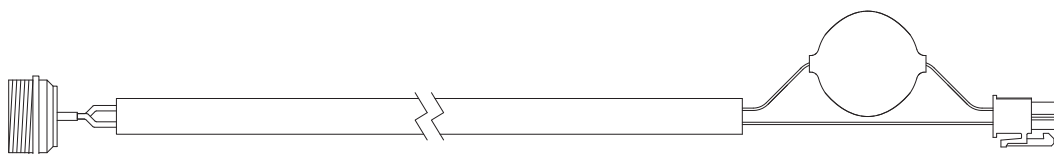
- Pioneer 3200K - 4000K - 5000K
- Pioneer Pulse 3200K - 4000K - 5000K
- Power Pulse 3200K - 4000K - 5000K
- WF204
- WF205 - WF205p
- WF210
- WF211
- WF212

i Information Robot wire feeders WF206 and WF207 do not require installation of the additional connector. Use this manual only for configuration of the push-pull torch parameters described in section 5.

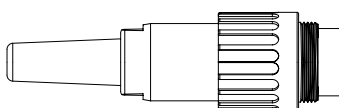
2 KIT CONTENTS

The push-pull torch kit includes the following components:

1. Internal wiring with 2-pin female Amphenol connector for panel mounting.





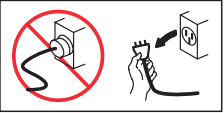
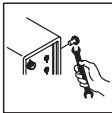




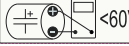


2. 2-pin male Amphenol connector for installation on the torch.



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3 KIT INSTALLATION

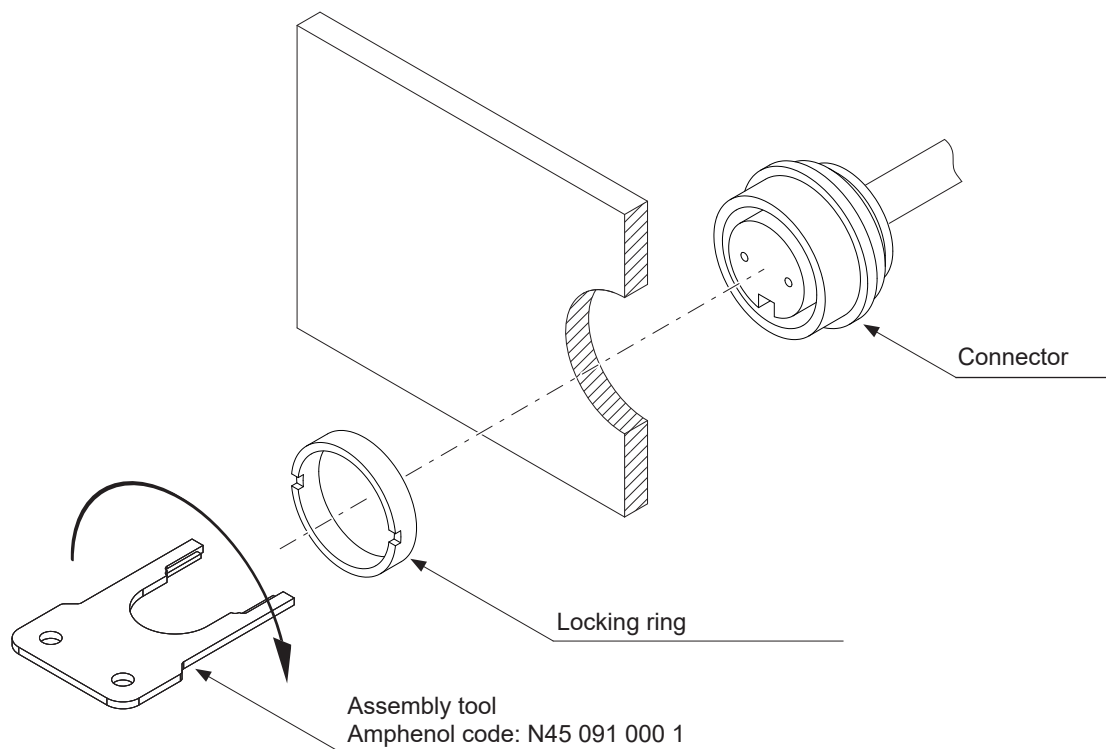
1. Remove the external protective covers of the machine.

 DANGER!	
	The assembly operations must be carried out by qualified technicians.
	Disconnect the equipment from the mains before opening it and performing any operations.
	Wait at least 5 minutes after switching off the machine before opening it and accessing the electrical parts. Even when the equipment is switched off and disconnected from the electrical power supply, some parts inside it may still be live due to capacitor charges.
 WARNING Hazardous voltage Measure voltage before operating    	Use a multimeter to check that the voltage across the terminals of the electrolytic capacitors is below 60 Vdc before touching any electrical parts.
	If the machine has just been switched off after a long period of operation, some internal parts may be hot.
	Static electricity can damage electronic components. Wear a grounding wrist strap before handling electronic boards.

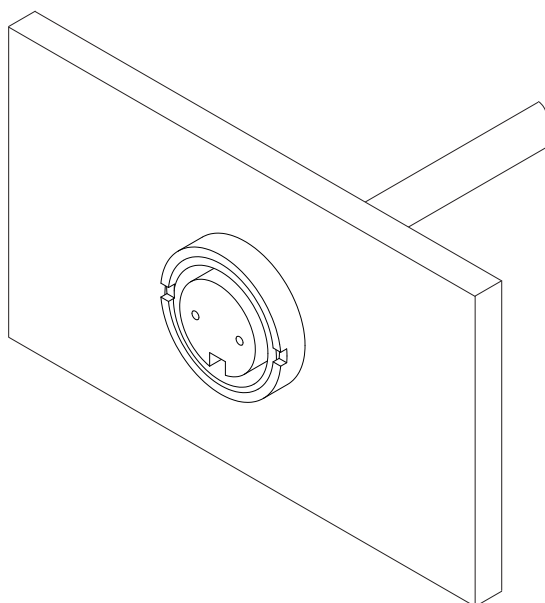
2. Refer to the specific machine manual to locate the position for installation of the push-pull torch connector.
3. For models with a pre-drilled panel: remove the cover plug.
4. For models requiring drilling: open the knock-out hole using a suitable tool. If necessary, use a file to remove any burrs or irregularities from the cut edge.

 **WARNING!** Do not damage the internal parts of the machine during drilling operations.

5. Insert the Amphenol connector into the panel and tighten the retaining nut from the outside using the appropriate spanner (not supplied with the kit).

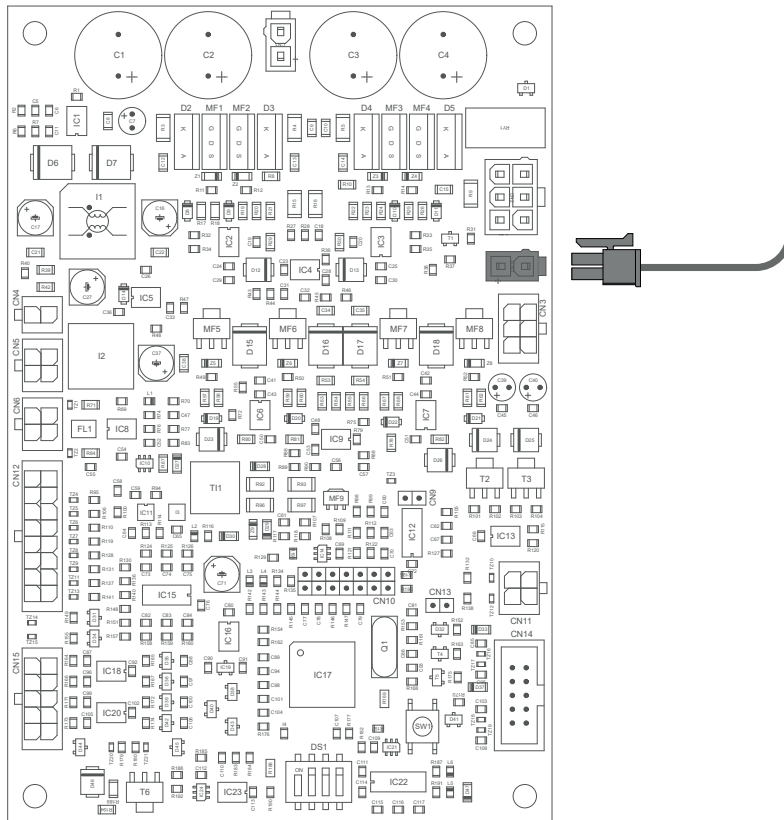


6. The final assembly is shown in the figure.



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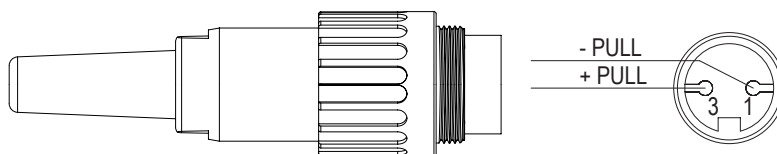
7. Locate the motor board inside the machine and connect the 2-pin Mini-Fit connector of the push-pull kit to the available socket labelled CN17.



8. If necessary, secure and route the wiring using cable ties, to prevent interference with the generator's metal structure and the other electronic boards inside.
9. Refit the external protective covers of the machine.

4 TORCH WIRING

1. Install the 2-pin male Amphenol connector on the push-pull torch cable, observing the polarity shown in the figure.



2. Connect the connector to the socket installed on the machine.

5 TORCH SETUP

To use the push-pull torch, the function must be enabled via the machine configuration menu and the correct torch balancing type must be selected.



NOTICE! Refer to the paragraph “PUSH-PULL SET-UP” in the machine user manual.

The list of Weco-approved torches and the type of balancing to set is shown in the following table.

MANUFACTURER	MODEL	MOTOR VOLTAGE	BALANCING
Binzel	Push-Pull Plus 36 D	40 V	Type 1
	Push-Pull Plus 240 D	40 V	Type 1
	Push-Pull Plus 401 D	40 V	Type 1
	PP 24 D	42 V	Type 2
	PP 36 D	42 V	Type 2
	PP 240 D	42 V	Type 2
	PP 401 D	42 V	Type 2
Parker	SGP 240W	42 V	Type 1
	SGP 401W	42 V	Type 1
	SGP 240A	42 V	Type 1
	SGP 360A	42 V	Type 1
Uniarc	PGLM360A Digital Pull-Mig	42 V	Type 1
	PGLM401W Digital Pull-Mig	42 V	Type 1
	UGP 240A Pull-Mig	42 V	Type 1
	UGP 360A Pull-Mig	42 V	Type 1
	UGP 401A Pull-Mig	42 V	Type 1
Dinse	MPZ.neo	48 V	Type 1
Dinse (for robotic applications)	DIX FD 200 M	48 V	Type 1
	DIX FD 200 ME	48 V	Type 1



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