The "long-range torch" with the Plus ...

The welding torches of the Push-Pull Plus series – especially developed for aluminium 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 with potentiometer guarantees exact speed regulation. For an optimum wire feed without frictional loss, the contact pressure of the feeding rollers can be regulated precisely and easily directly on the handle. The ergonomic handle ensures optimum and low-fatigue handling.

The screw-type torch necks can be replaced quickly. They are available as either straight or 45° angled versions. A special interface between the handle and the torch neck makes it possible to turn the necks by up to 360°. All torches, air and liquid cooled for capacities of up to 400 A, 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 construction of automobile and railway vehicles. Wherever exact and constant wire feeding is absolutely essential.

The features:

- Constant and problem-free wire feeding thanks to a powerful pull motor
- Precise contact pressure regulation of the wire feeding rollers directly on the torch
- Optionally available with potentiometer for speed regulation
- Wearing parts are identical to those of the tried-and-trusted MB torch series – minimised stocking
- Optimum torch cooling – long tool lives
- Sturdy design – long service life

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System overview
MIG/MAG Welding Torches Push-Pull Plus

General advice:
At pulsed arc the duty cycles decrease up to 35%.

Technical data
(EN 60 974-7):

<table>
<thead>
<tr>
<th>Type</th>
<th>Cooling</th>
<th>CO₂ Rating (A)</th>
<th>Duty cycle (%)</th>
<th>Wire-Ø (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Push-Pull Plus 36 D</td>
<td>air</td>
<td>300 Mixed Gases 270 M21</td>
<td>60</td>
<td>0.8 - 1.2</td>
</tr>
<tr>
<td>Push-Pull Plus 240 D</td>
<td>liquid**</td>
<td>270</td>
<td>100</td>
<td>0.8 - 1.2</td>
</tr>
<tr>
<td>Push-Pull Plus 401 D</td>
<td>liquid**</td>
<td>400</td>
<td>100</td>
<td>0.8 - 1.6</td>
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</table>

*For complete torches with potentiometer we need the additional indication of the required resistance value.

**To protect the cable assembly components from excessive heat build up we recommend a post welding cooling cycle of at least four minutes.

General advice:
At pulsed arc the duty cycles decrease up to 35%.
Order advice:
The initial equipment of the complete torches Push-Pull Plus contains the following wear parts:

<table>
<thead>
<tr>
<th>Wear parts for Push-Pull Plus</th>
<th>36 D Part-No.</th>
<th>240 D Part-No.</th>
<th>401 D Part-No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Contact tip holder (short)</td>
<td>142.0020</td>
<td>142.0003</td>
<td>142.0022</td>
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<tr>
<td>Gas diffuser</td>
<td>014.0261</td>
<td>012.0183</td>
<td>030.0145</td>
</tr>
<tr>
<td>Contact tip E-Cu; Ø 1.2</td>
<td>140.0442</td>
<td>140.0379</td>
<td>140.0442</td>
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<tr>
<td>Gas nozzle, conical</td>
<td>145.0078</td>
<td>145.0080</td>
<td>145.0085</td>
</tr>
<tr>
<td>Neckliner*</td>
<td>Pos. 16 and 17</td>
<td>Pos. 16 and 17</td>
<td>Pos. 16 and 17</td>
</tr>
<tr>
<td>PA liner</td>
<td>128.0019</td>
<td>128.0019</td>
<td>128.0019</td>
</tr>
<tr>
<td>Wire drive roll Ø 1.2 / 1.2</td>
<td>095.0066.1</td>
<td>095.0066.1</td>
<td>095.0066.1</td>
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</table>

Other wear parts can be ordered separately.

*Find Pos. 16 and 17 on the following pages.
<table>
<thead>
<tr>
<th>Pos.</th>
<th>Description</th>
<th>Indication</th>
<th>Part-No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Torch neck Push-Pull Plus 36 D; straight</td>
<td>085.0116.1</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Torch neck Push-Pull Plus 36 D; 45° bent</td>
<td>085.0117.1</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Wear parts set gasket rings</td>
<td>5 pcs.</td>
<td>085.0029</td>
</tr>
<tr>
<td>10</td>
<td>Torch adaptor cpl.</td>
<td>085.0019</td>
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<td>11</td>
<td>Pressure trigger cpl.</td>
<td>085.0018</td>
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<tr>
<td>11.1</td>
<td>Pressure roll</td>
<td>085.0042</td>
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</tr>
<tr>
<td>11.2</td>
<td>Pressure button cpl.</td>
<td>085.0043</td>
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</tr>
<tr>
<td>12</td>
<td>Gear motor 24 V DC incl. Pos. 19 (Wire-Ø 1.2 mm) and Pos. 20</td>
<td>085.0102.1</td>
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<tr>
<td>13</td>
<td>Gear motor 40 V DC incl. Pos. 19 (Wire-Ø 1.2 mm) and Pos. 20</td>
<td>085.0103.1</td>
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<td>16</td>
<td>Cover cpl.</td>
<td>400.1186</td>
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<tr>
<td>17</td>
<td>Neckliner Combi for Push-Pull Plus 36 D for Wire-Ø 0.8 – 1.0 mm</td>
<td>L=145 mm</td>
<td>149.0260.3</td>
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<tr>
<td></td>
<td>Neckliner Combi for Push-Pull Plus 36 D for Wire-Ø 1.2 – 1.6 mm</td>
<td>L=145 mm</td>
<td>149.0261.3</td>
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<tr>
<td>19</td>
<td>Wire drive roll for Wire-Ø 0.8 mm</td>
<td>universal</td>
<td>095.0064.1</td>
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<tr>
<td></td>
<td>Wire drive roll for Wire-Ø 1.0 mm</td>
<td>universal</td>
<td>095.0065.1</td>
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<tr>
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<td>Wire drive roll for Wire-Ø 1.2 mm</td>
<td>universal</td>
<td>095.0066.1</td>
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<tr>
<td>20</td>
<td>Knurled screw M4</td>
<td>085.0113.5</td>
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<tr>
<td>25</td>
<td>Handle cpl. incl. mounting screws and extension material</td>
<td>085.0017</td>
<td></td>
</tr>
<tr>
<td>27</td>
<td>Trigger 2-pole</td>
<td>185.0100</td>
<td></td>
</tr>
<tr>
<td>32</td>
<td>Sheet metal screw 2.9x6.5</td>
<td>20 pcs.</td>
<td>079.0003</td>
</tr>
<tr>
<td>33</td>
<td>Potentiometer housing cpl.</td>
<td>085.0016</td>
<td></td>
</tr>
<tr>
<td>34</td>
<td>Potentiometer</td>
<td>1.0 kΩ</td>
<td>187.0077</td>
</tr>
<tr>
<td></td>
<td>Potentiometer</td>
<td>2.0 kΩ</td>
<td>187.0078</td>
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# Component

<table>
<thead>
<tr>
<th>Pos.</th>
<th>Description</th>
<th>Indication</th>
<th>Part-No.</th>
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<tbody>
<tr>
<td></td>
<td><strong>Handle</strong></td>
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<tr>
<td>34</td>
<td>Potentiometer</td>
<td>5.5 kΩ</td>
<td>187.0076</td>
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<tr>
<td></td>
<td>Potentiometer</td>
<td>10.0 kΩ</td>
<td>187.0075</td>
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<td>Potentiometer</td>
<td>20.0 kΩ</td>
<td>187.0079</td>
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<td>35</td>
<td>Potentiometer knob cpl.</td>
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<tr>
<td>39</td>
<td>Printed circuit board</td>
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<tr>
<td>40</td>
<td>Cable assembly cpl. for 8.0 m with 7-pole control leads without central adaptor GZ-2</td>
<td>0.4 m</td>
<td>101.0054</td>
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<tr>
<td>41</td>
<td>Power cable cpl. Typ 35</td>
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<tr>
<td>43</td>
<td>Control lead cpl. 4-pole 0.4 m</td>
<td>100 m</td>
<td>100.0034</td>
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<tr>
<td>44</td>
<td>Control lead 7-pole 0.34 qmm</td>
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<td>46</td>
<td>Plug</td>
<td>20 pcs.</td>
<td>175.0004</td>
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<tr>
<td>47</td>
<td>Hose 30 black Ø 4.9x1.5 mm</td>
<td>100 m</td>
<td>109.0040</td>
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<tr>
<td>48</td>
<td>Hose clamp Ø 8.2 mm</td>
<td>100 pcs.</td>
<td>173.0005</td>
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<tr>
<td>49</td>
<td>Wire conduit cpl. for 8.0 m</td>
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<td></td>
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<tr>
<td>51</td>
<td>Fabrics hose 28x1.5 mm</td>
<td>40 m</td>
<td>107.0091</td>
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<tr>
<td>52</td>
<td>Cable support</td>
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<td></td>
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<tr>
<td>53</td>
<td>Cable support fastening cpl.</td>
<td></td>
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<tr>
<td>56</td>
<td>Cable support machine side big cpl. ND 31</td>
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</tr>
<tr>
<td>56.1</td>
<td>Cable support spring big ND 31</td>
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<td>57</td>
<td>Pan head screw M4x6</td>
<td>20 pcs.</td>
<td>000.0552</td>
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<tr>
<td>57.1</td>
<td>Sealing cap</td>
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<tr>
<td>58</td>
<td>Adaptor nut M33x2</td>
<td></td>
<td></td>
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<tr>
<td>59</td>
<td>Powerfitting cpl. M14x1</td>
<td></td>
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<tr>
<td>60</td>
<td>Central adaptor GZ-2 M14x1</td>
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<tr>
<td>61</td>
<td>Coupling nut M10x1</td>
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<tr>
<td>62</td>
<td>O-ring 4x1</td>
<td>20 pcs.</td>
<td>165.0002</td>
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<tr>
<td></td>
<td><strong>Wear parts</strong></td>
<td></td>
<td></td>
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<tr>
<td>72</td>
<td>Gas diffuser, white</td>
<td>10 pcs.</td>
<td>014.0261</td>
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<tr>
<td></td>
<td>Gas diffuser, long life</td>
<td>10 pcs.</td>
<td>014.0026</td>
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<tr>
<td></td>
<td>Gas diffuser, ceramic</td>
<td>10 pcs.</td>
<td>014.0023</td>
</tr>
</tbody>
</table>

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**Push-Pull Plus 36 D air cooled**

![Diagram of Push-Pull Plus 36 D air cooled](image-url)
### Component

**Wear parts**

<table>
<thead>
<tr>
<th>Pos.</th>
<th>Description</th>
<th>Indication</th>
<th>Part-No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>86</td>
<td>Contact tip holder M6; 28.0 mm (short)</td>
<td>10 pcs.</td>
<td>142.0005</td>
</tr>
<tr>
<td>87</td>
<td>Contact tip holder M6; 32.0 mm (long)</td>
<td>10 pcs.</td>
<td>142.0011</td>
</tr>
<tr>
<td>88</td>
<td>Contact tip holder M8; 28.0 mm (short)</td>
<td>10 pcs.</td>
<td>142.0020</td>
</tr>
<tr>
<td>89</td>
<td>Contact tip holder M8; 34.0 mm (long)</td>
<td>10 pcs.</td>
<td>142.0024</td>
</tr>
<tr>
<td>90</td>
<td>Contact tip M6 e-Cu; Ø 0.8 (8x28)</td>
<td>10 pcs.</td>
<td>140.0051</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 CuCrZr; Ø 0.8 (8x28)</td>
<td>10 pcs.</td>
<td>140.0054</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 e-Cu; Ø 1.0 (8x28)</td>
<td>10 pcs.</td>
<td>140.0242</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 CuCrZr; Ø 1.0 (8x28)</td>
<td>10 pcs.</td>
<td>140.0245</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 e-Cu; Ø 1.2 (8x28)</td>
<td>10 pcs.</td>
<td>140.0382</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 CuCrZr; Ø 1.2 (8x28)</td>
<td>10 pcs.</td>
<td>140.0385</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 e-Cu; Ø 0.8 for alu wire (8x28)</td>
<td>10 pcs.</td>
<td>141.0001</td>
</tr>
<tr>
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<td>Contact tip M6 e-Cu; Ø 1.0 for alu wire (8x28)</td>
<td>10 pcs.</td>
<td>141.0006</td>
</tr>
<tr>
<td></td>
<td>Contact tip M6 e-Cu; Ø 1.2 for alu wire (8x28)</td>
<td>10 pcs.</td>
<td>141.0010</td>
</tr>
<tr>
<td>91</td>
<td>Contact tip M8 e-Cu; Ø 0.8 (10x30)</td>
<td>10 pcs.</td>
<td>140.0114</td>
</tr>
<tr>
<td></td>
<td>Contact tip M8 e-Cu; Ø 1.0 (10x30)</td>
<td>10 pcs.</td>
<td>140.0313</td>
</tr>
<tr>
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<td>Contact tip M8 e-Cu; Ø 1.2 (10x30)</td>
<td>10 pcs.</td>
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<tr>
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<td>Contact tip M8 CuCrZr; Ø 0.8 (10x30)</td>
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<tr>
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<td>Contact tip M8 CuCrZr; Ø 1.0 (10x30)</td>
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<tr>
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<td>Contact tip M8 CuCrZr; Ø 1.2 (10x30)</td>
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<td>Contact tip M8 e-Cu; Ø 0.8 for alu wire (10x30)</td>
<td>10 pcs.</td>
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</tr>
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<td></td>
<td>Contact tip M8 e-Cu; Ø 1.0 for alu wire (10x30)</td>
<td>10 pcs.</td>
<td>141.0008</td>
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<tr>
<td></td>
<td>Contact tip M8 e-Cu; Ø 1.2 for alu wire (10x30)</td>
<td>10 pcs.</td>
<td>141.0015</td>
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<tr>
<td>106</td>
<td>Gas nozzle; cylindrical; NW Ø 19.0</td>
<td>10 pcs.</td>
<td>145.0045</td>
</tr>
<tr>
<td>107</td>
<td>Gas nozzle; conical; NW Ø 16.0</td>
<td>10 pcs.</td>
<td>145.0078</td>
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<tr>
<td>108</td>
<td>Gas nozzle; conical; NW Ø 12.0</td>
<td>10 pcs.</td>
<td>145.0126</td>
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<tr>
<td>120</td>
<td>Guide spiral liner blank; 2.0/4.5; Wire-Ø 0.8–1.2; for 8.00 m</td>
<td>10 pcs.</td>
<td>122.0040</td>
</tr>
<tr>
<td></td>
<td>Guide spiral liner insulated; 2.0/4.5; Wire-Ø 0.8–1.2; for 8.00 m</td>
<td>10 pcs.</td>
<td>124.0169</td>
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<tr>
<td>130</td>
<td>PTFE core liner 2.0/4.0; red; Wire-Ø 0.8–1.2; for 8.00 m</td>
<td>10 pcs.</td>
<td>126.0030</td>
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<tr>
<td>Pos.</td>
<td>Description</td>
<td>Indication</td>
<td>Part-No.</td>
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<tr>
<td>------</td>
<td>-------------------------------------------------------</td>
<td>------------</td>
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<td>PTFE carbon core liner 2.0/4.0; Wire-Ø 0.8 - 1.2; for 8.00 m</td>
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<td>127.0009</td>
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<td>Polyamid core liner 2.0/4.0; Wire-Ø 0.8 - 1.2; for 8.00 m</td>
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<td>128.0019</td>
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<td>131</td>
<td>Nipple for core liner at 4.0</td>
<td>20 pcs.</td>
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<tr>
<td>132</td>
<td>O-ring 3.5x1.5</td>
<td>20 pcs.</td>
<td>165.0008</td>
</tr>
<tr>
<td>133</td>
<td>Guide tube for core liners up to 4.0 (200 mm)</td>
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<td>129.0461</td>
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<tr>
<td>200</td>
<td>Spanner</td>
<td></td>
<td>191.0001</td>
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## Push-Pull Plus 240 D liquid cooled

### Component

#### Push-Pull Plus torch complete

<table>
<thead>
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<th>Indication</th>
<th>Part-No.</th>
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<tbody>
<tr>
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<td>not ill. Push-Pull Plus 240 D; straight; 40 V motor; WZ-2, 8.00 m</td>
<td>095.0110.1</td>
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<td>Push-Pull Plus 240 D; 45° bent; 40 V motor; WZ-2, 8.00 m</td>
<td>095.0111.1</td>
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<tr>
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<td>Push-Pull Plus 240 D; straight; 40 V motor; poti 10 kΩ; WZ-2, 8.00 m</td>
<td>095.0119.1</td>
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</tr>
<tr>
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<td>Push-Pull Plus 240 D; 45° bent; 40 V motor; poti 10 kΩ; WZ-2, 8.00 m</td>
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#### Torch neck

<table>
<thead>
<tr>
<th>Pos.</th>
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<th>Indication</th>
<th>Part-No.</th>
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<tbody>
<tr>
<td>1</td>
<td>Torch neck Push-Pull Plus 240 D; straight</td>
<td>095.0040.1</td>
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</tr>
<tr>
<td>2</td>
<td>Torch neck Push-Pull Plus 240 D; 45° bent</td>
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<td></td>
</tr>
<tr>
<td>3</td>
<td>Wear parts set gasket rings</td>
<td>5 pcs.</td>
<td>095.0001</td>
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#### Torch body, gear motor and equipment

<table>
<thead>
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<th>Description</th>
<th>Indication</th>
<th>Part-No.</th>
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<td>Torch adaptor cpl.</td>
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<td>11</td>
<td>Pressure trigger cpl.</td>
<td>085.0018</td>
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<tr>
<td>11.1</td>
<td>Pressure roll</td>
<td>085.0042</td>
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<td>11.2</td>
<td>Pressure button cpl.</td>
<td>085.0043</td>
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<tr>
<td>12</td>
<td>Gear motor 24 V DC incl. Pos. 19 (Wire-Ø 1.2 mm) and Pos. 20</td>
<td>085.0102.1</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Gear motor 40 V DC incl. Pos. 19 (Wire-Ø 1.2 mm) and Pos. 20</td>
<td>085.0103.1</td>
<td></td>
</tr>
<tr>
<td>13</td>
<td>Cover cpl.</td>
<td>095.0072.1</td>
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<tr>
<td>16</td>
<td>Neckliner Combi for Push-Pull Plus 240 D for Wire-Ø 0.8–1.2 mm</td>
<td>L=135 mm</td>
<td>149.0264.3</td>
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<tr>
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<td>L=195 mm</td>
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<td>Neckliner Combi for Push-Pull Plus 240 D 45° for Wire-Ø 1.2–1.6 mm</td>
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#### Handle

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<td>Trigger 2-pole</td>
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<td>Sheet metal screw 2.9x6.5</td>
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### Component

**Handle**

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**Printed circuit board**

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<td>43</td>
<td>Control lead cpl. 4-pole 0.4 m</td>
<td>0.4 m</td>
<td>101.0054</td>
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<td>44</td>
<td>Control lead 7-pole 0.34 qmm</td>
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<td>20 pcs.</td>
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<td>47</td>
<td>Hose 30 black Ø 4.9x1.5 mm</td>
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<td>100 pcs.</td>
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<td>Fastener cap blue</td>
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<td>Water hose 0.60 m</td>
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## Push-Pull Plus 240 D liquid cooled

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<tr>
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### Handle

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### Printed circuit board

### Cable assemblies and wear parts

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<th>Part-No.</th>
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<td>Hose 47 blue Ø 5.5x1.5</td>
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<tr>
<td>49.1</td>
<td>Fastener cap blue</td>
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<td>Water hose 0.60 m</td>
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<td>50.1</td>
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<td>501.2423</td>
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<td>51</td>
<td>Fabrics hose 28x1.5 mm</td>
<td>40 m</td>
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<td>52</td>
<td>Cable support</td>
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<td>53</td>
<td>Cable support fastening cpl.</td>
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<td>400.1247</td>
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<td>54</td>
<td>Hose clamp Ø 9.0</td>
<td>100 pcs.</td>
<td>173.0001</td>
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<tr>
<td>55</td>
<td>Plug nipple ND 5 mm / Ø 6.0</td>
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<tr>
<td>56</td>
<td>Cable support machine side big cpl.</td>
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<td>500.0342</td>
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<td>56.1</td>
<td>Cable support spring big ND 31</td>
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<td>57</td>
<td>Pan head screw M4x6</td>
<td>20 pcs.</td>
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<tr>
<td>57.1</td>
<td>Sealing cap</td>
<td>20 pcs.</td>
<td>500.0251</td>
</tr>
<tr>
<td>58</td>
<td>Hose clamp Ø 9.5 mm</td>
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<td>173.0002</td>
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### Cable assemblies and wear parts

<table>
<thead>
<tr>
<th>Pos.</th>
<th>Description</th>
<th>Indication</th>
<th>Part-No.</th>
</tr>
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<tr>
<td>59</td>
<td>Adaptor nut M33x2</td>
<td>500.0213</td>
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<td>60</td>
<td>Central adaptor WZ-2 M10x1</td>
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<td>61</td>
<td>Coupling nut M10x1</td>
<td>501.D536.5</td>
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<td>62</td>
<td>O-ring 4x1</td>
<td>20 pcs.</td>
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### Wear parts

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<tbody>
<tr>
<td>71</td>
<td>Gas diffuser, white</td>
<td>10 pcs.</td>
<td>030.0145</td>
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<tr>
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<td>Gas diffuser, long life</td>
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<td>Gas diffuser, ceramic</td>
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<td>82</td>
<td>Contact tip holder M6; 25.0 mm (short)</td>
<td>10 pcs.</td>
<td>142.0008</td>
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<tr>
<td>83</td>
<td>Contact tip holder M6; 29.0 mm (long)</td>
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<td>142.0013</td>
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<tr>
<td>84</td>
<td>Contact tip holder M8; 25.0 mm (short)</td>
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<td>142.0022</td>
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<tr>
<td>85</td>
<td>Contact tip holder M8; 29.0 mm (long)</td>
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<td>90</td>
<td>Contact tip M6 E-Cu; Ø 0.8 [8x28]</td>
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<td>Contact tip M6 E-Cu; Ø 1.0 [8x28]</td>
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<td>103</td>
<td>Gas nozzle; cylindrical; NW Ø 20.0</td>
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<td>104</td>
<td>Gas nozzle; conical; NW Ø 16.0</td>
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<td>105</td>
<td>Gas nozzle; conical; NW Ø 14.0</td>
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<td>131</td>
<td>Nipple for core liner at 4.0</td>
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<tr>
<td>131</td>
<td>Nipple for core liner at 4.7</td>
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<td>132</td>
<td>O-ring 3.5x1.5</td>
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<tr>
<td>133</td>
<td>Guide tube for core liners up to 4.0 (200 mm)</td>
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<td>200</td>
<td>Spanner</td>
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