

UNIMIG



PUSH-PULL & SPOOL GUNS

Push-Pull & Spool Guns | Operating Manual

Contents

1. Installation..... 3

1.1 Spool Gun..... 3

1.2 Push-Pull Gun..... 6

2. Spool Guns..... 8

2.1 150A Spool Gun..... 8

2.2 150A Spool Gun Consumables..... 9

2.3 220A Spool Gun..... 10

2.4 220A Spool Gun Consumables..... 11

3. Push-Pull Guns..... 12

3.1 300A Push-Pull Gun..... 12

3.2 300A Push-Pull Gun Consumables..... 13

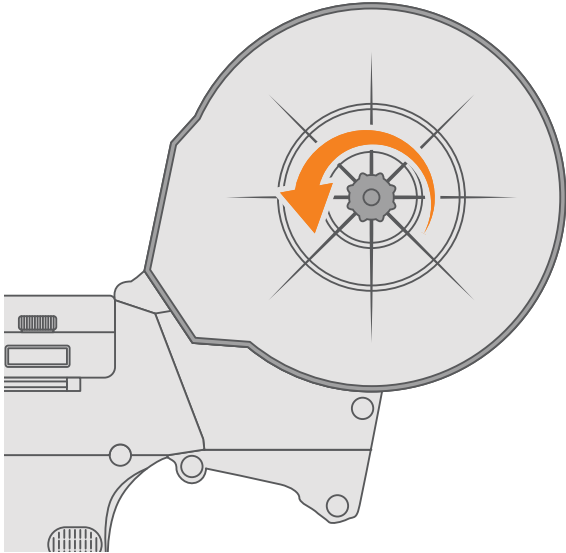
3.3 400A Water-Cooled Push-Pull Gun..... 14

3.4 400A Water-Cooled Push-Pull Consumables..... 15

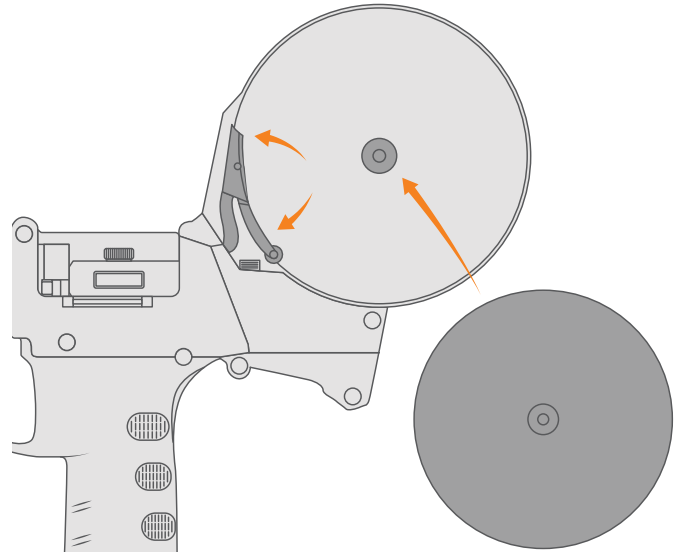
1. Installation

1.1 Spool Gun

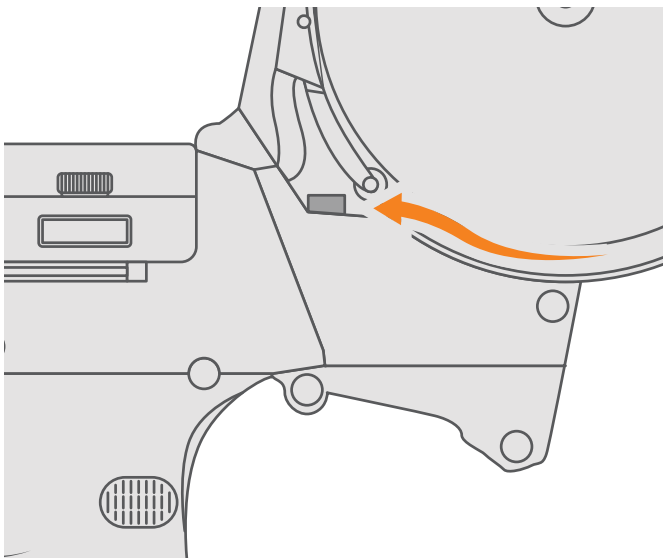
1. Unscrew the spool holder and remove the spool housing cover.



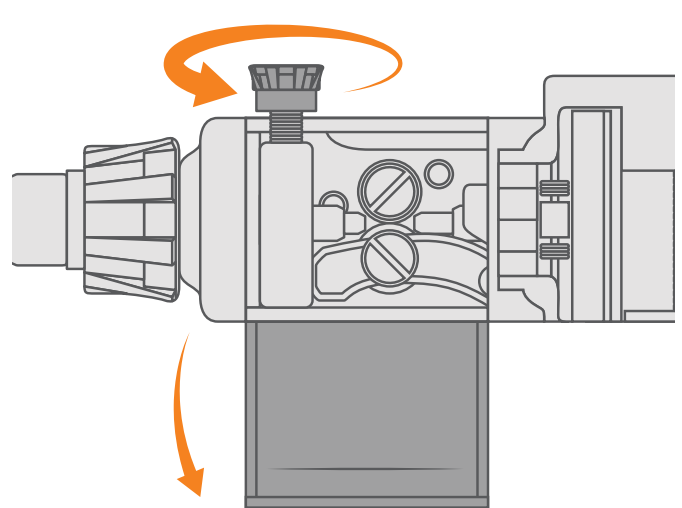
2. Push back the spool guides, and place the wire spool onto the spool nut.



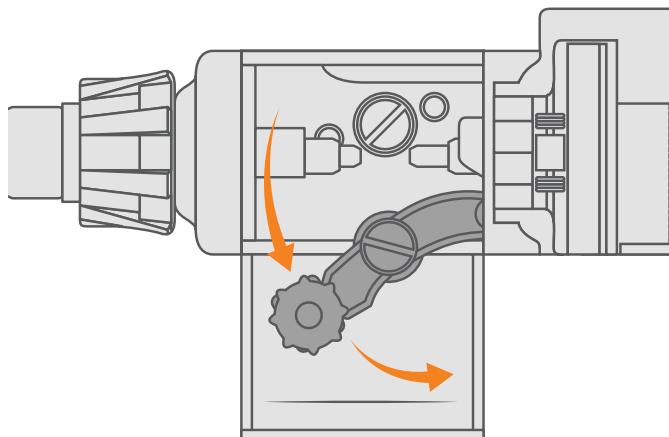
3. Feed the wire through the inlet guide tube.



4. Open the drive roller cover, and loosen the roller tension knob.

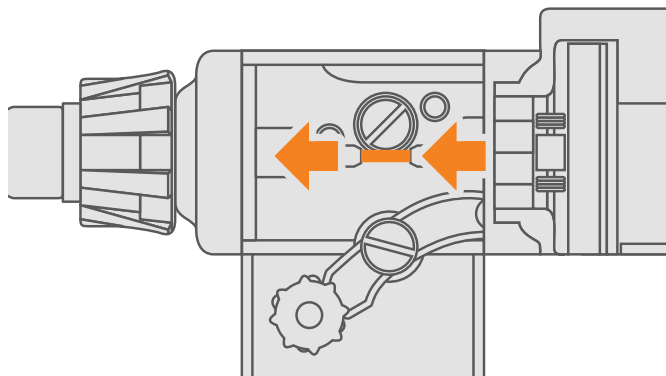


5. Lift the roller lock up and open the wire drive.

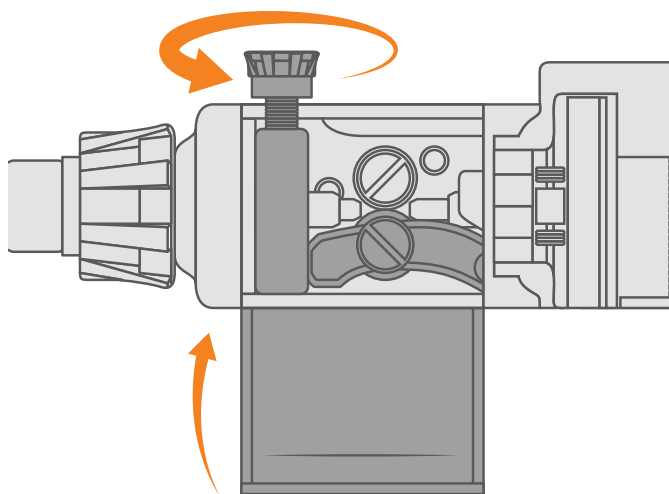


6. Feed the wire through the drive roller and through the outlet guide tube.

Note: Ensure you have the correct drive roller for the wire size you are using. If not, replace it with the correct size.



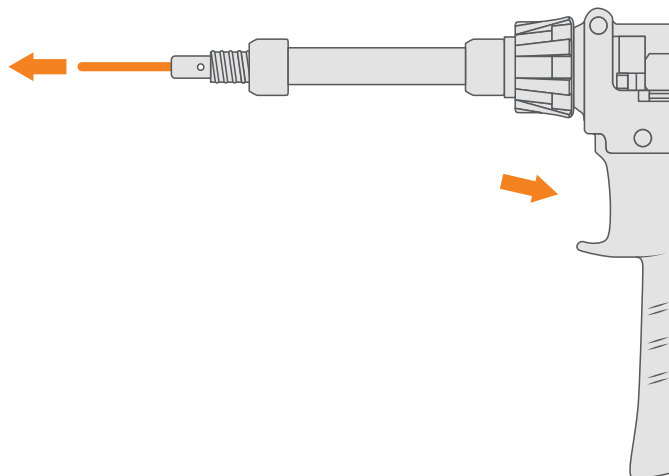
7. Close the wire drive and tighten the roller tension knob.



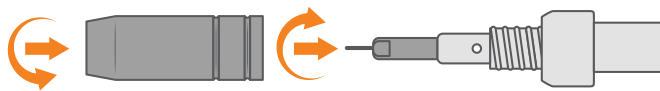
8. Remove the front-end consumables in preparation for feeding the wire.



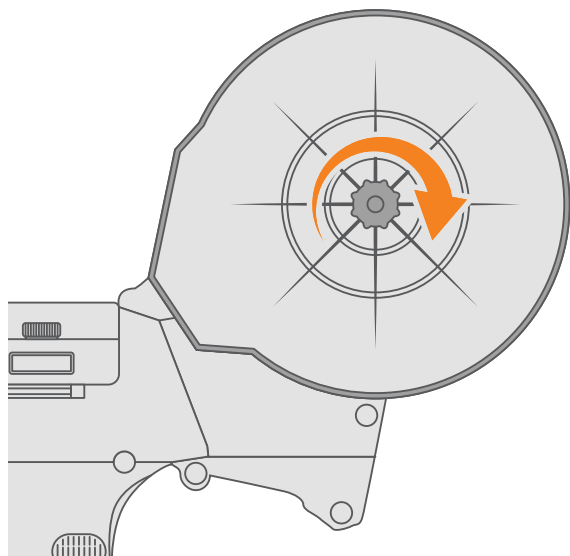
- 9.** Press the torch trigger to feed the wire out of the torch nozzle.



- 10.** Replace the front-end consumables.

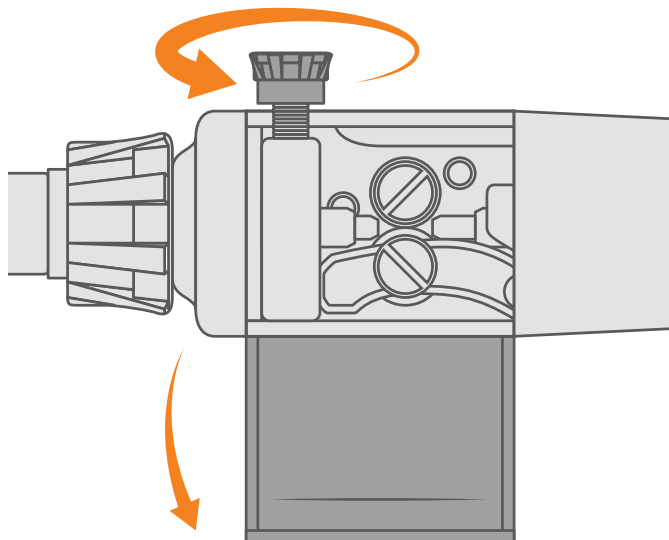


- 11.** Replace the spool housing cover and tighten it.

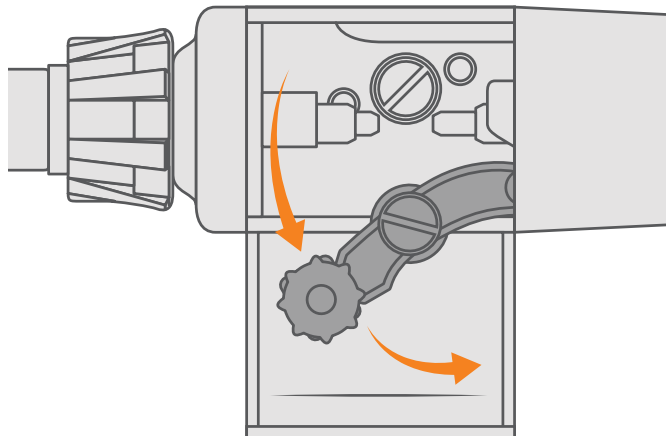


1.2 Push-Pull Gun

1. Open the drive roller cover, and loosen the roller tension knob.

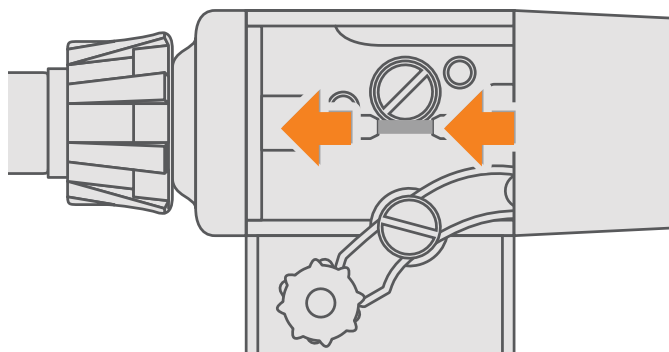


2. Lift the roller lock up and open the wire drive.

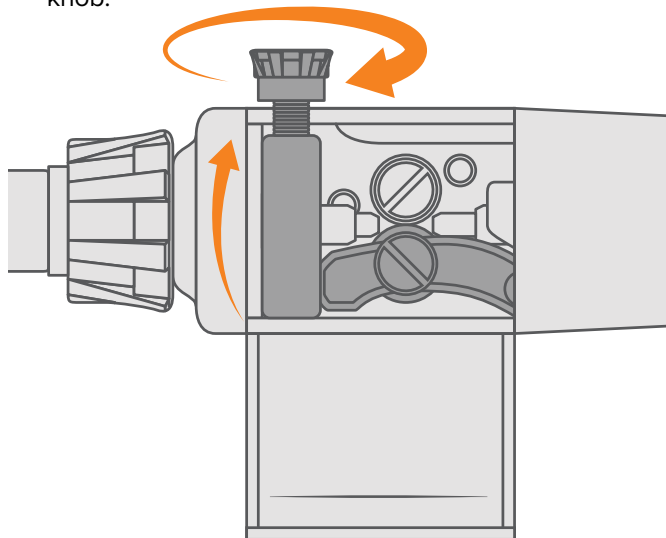


3. Feed wire through roller, and through the outlet guide tube.

Note: Ensure you have the correct drive roller for the wire size you are using. If not, replace it with the correct size.



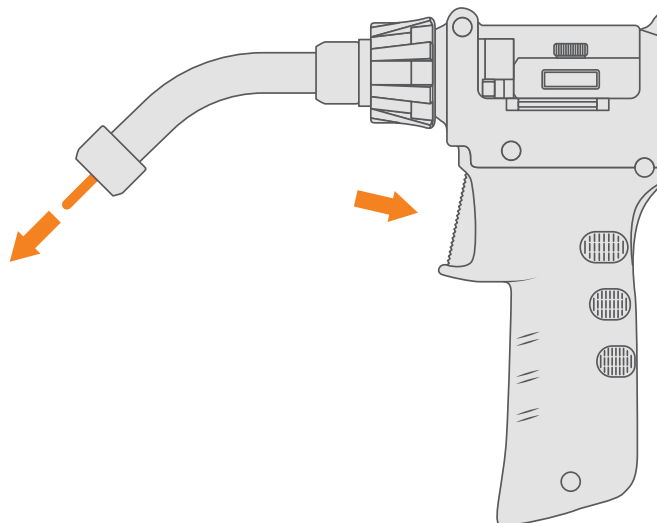
4. Close wire drive and tighten roller tension knob. Open the drive roller cover, and loosen the roller tension knob.



- 5.** Remove the front-end consumables in preparation for feeding the wire.



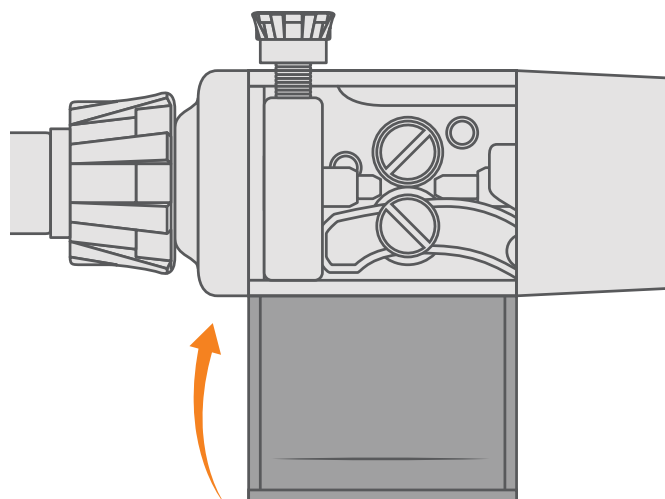
- 6.** Press the torch trigger to feed the wire out of the torch nozzle.



- 7.** Replace the front-end consumables.

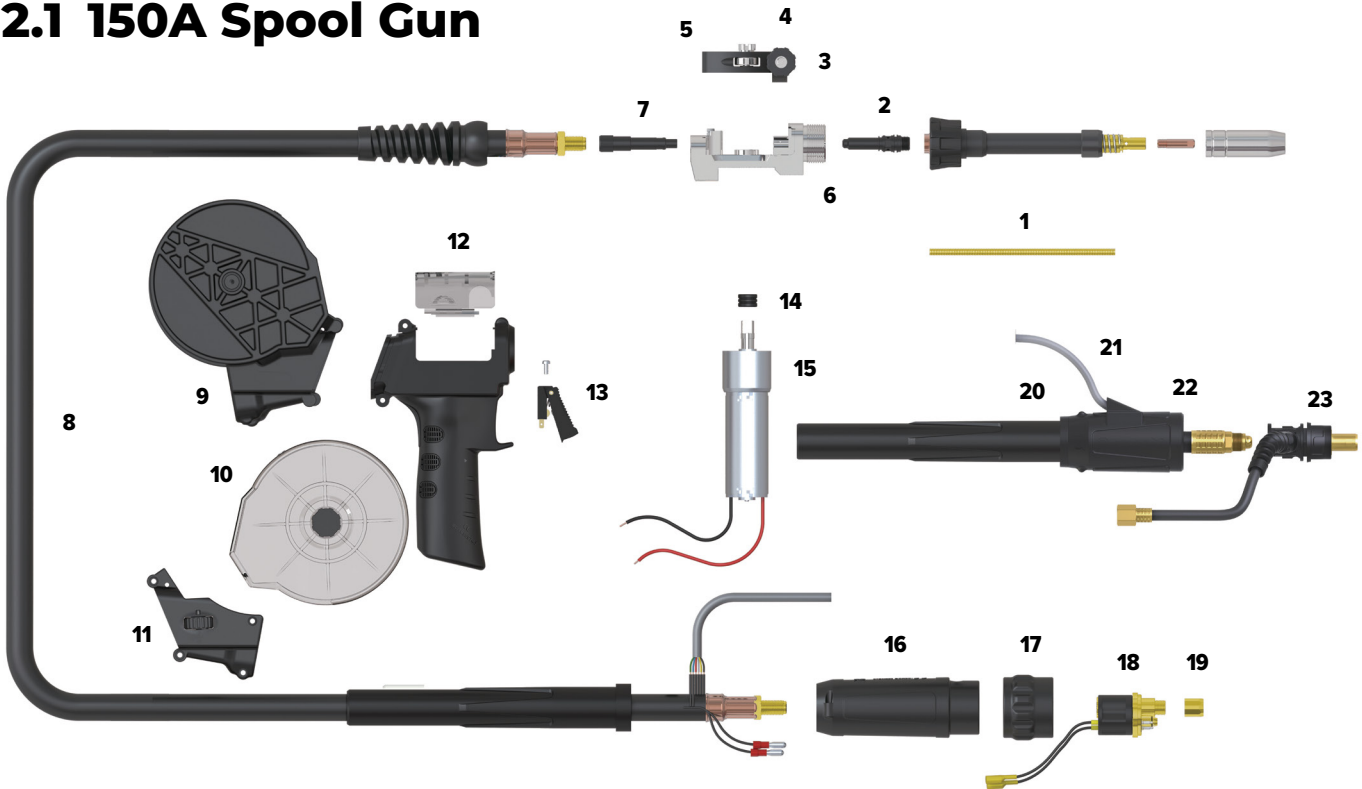


- 8.** Close the drive roller cover.



2. Spool Guns

2.1 150A Spool Gun



Length	6m
SKU	PLSP150A

COOLING METHOD	Air-Cooled
DUTY CYCLE - CO2	60% @ 150A
DUTY CYCLE - MIXED GAS	60% @ 130A

WIRE SIZE	0.8-1.0mm
STANDARD	EN60974-7
MINIMUM MOTOR LIFE (HOURS)	1000

1	USP1502	JUMP LINER
2	UGP36006	JUMP LINER NIPPLE
3	UGP36402B	TENSION KNOB
4	UGP36402	PRESSURE ARM ASSEMBLY
5	UGP36402R	PRESSURE ROLL
6	USP36001	MOTOR BODY
7	USP36006	WIRE GUIDE
8	PLSP1517-60ER	COAX CABLE ASSEMBLY, EURO TYPE
9	USP2515SP-B	SPOOL BOX
10	USP2515SP-C	SPOOL COVER
11	USP2515SP-PT-1K	WIRE SPEED CONTROL 1KΩ
11	USP2515SP-PT-5K	WIRE SPEED CONTROL 5KΩ
11	USP2515SP-PT-10K	WIRE SPEED CONTROL 10KΩ
11	USP2515SP-PT0	NO POTENTIOMETER
12	UGP2514-C	PUSH-PULL HANDLE COVER
13	UGP2516	PUSH-PULL TRIGGER
14	UGP7020W-08	DRIVE ROLLER SPOOL GUN V STEEL 0.8MM
14	UGP7020W-09	DRIVE ROLLER SPOOL GUN V STEEL 0.9MM

14	UGP7020W-10	DRIVE ROLLER SPOOL GUN V STEEL 1.0MM
14	UGP7020W-08U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 0.8MM
14	UGP7020W-09U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 0.9MM
14	UGP7020W-10U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 1.0MM
14	UGP7020W-12U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 1.2MM
15	UGP7020-24	MOTOR 24V DC
15	UGP7020-42	MOTOR 42V DC
16	SC2578H/L	GUN PLUG HOUSING ASSEMBLY
17	UC1519/S	HOUSING NUT
18	UC1528	HYBRID GUN PLUG BODY C/W SPRING PINS
19	UB1525	LINER NUT
20	USLH26-SM	CABLE SUPPORT LARGE
21	USLH26-C	HOUSING COVER
22	USLH26-H	HOUSING LARGE
23	USL3550	BODY & SUPPORT

2.2 150A Spool Gun Consumables



Tip Holder

PCTH15	TIP HOLDER SUIT M15 QTY 2
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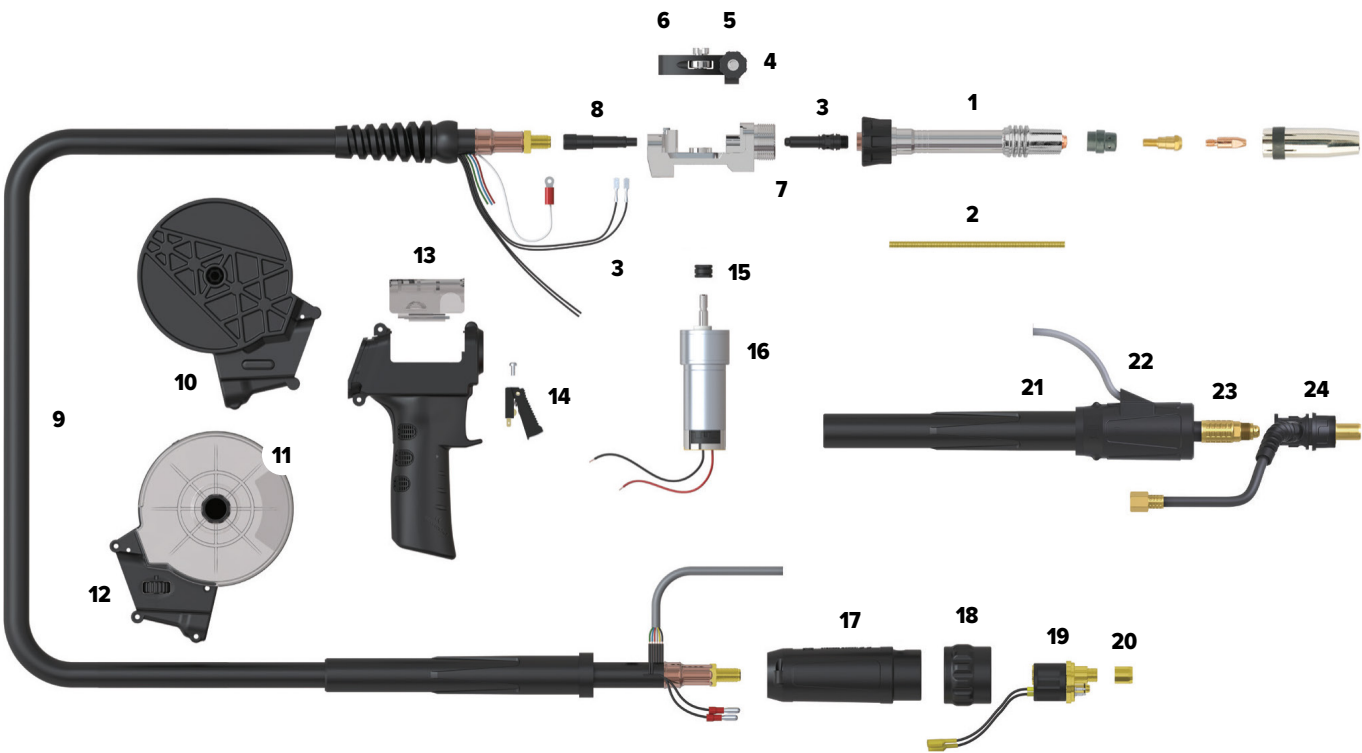
Contact Tip

PCTAL0008-09	CONTACT TIPS ALUMINIUM BINZEL STYLE 0.9MM QTY 10
PCTAL0008-10	CONTACT TIPS ALUMINIUM BINZEL STYLE 1.0MM QTY 10
PCTAL0008-12	CONTACT TIPS ALUMINIUM BINZEL STYLE 1.2MM QTY 10
PCT0008-06	CONTACT TIPS BINZEL STYLE 0.6MM QTY 10
PCT0008-08	CONTACT TIPS BINZEL STYLE 0.8MM QTY 10
PCT0008-09	CONTACT TIPS BINZEL STYLE 0.9MM QTY 10
PCT0008-10	CONTACT TIPS BINZEL STYLE 1.0MM QTY 10

Gas Nozzle

PGN15CON	GAS NOZZLE CONICAL SUIT M15 QTY 2
PGN15CYL	GAS NOZZLE CYLINDRICAL SUIT M15 QTY 2
PGN15SPOT	GAS NOZZLE SPOT SUIT M15 QTY 2
PGN15TAP	GAS NOZZLE TAPERED SUIT M15 QTY 2

2.3 220A Spool Gun



Length	9 Pin 1K Pot 6m	9 Pin 10K Pot 6m	12 Pin 1K Pot 6m	Digital 1K Pot 6m
SKU	PLSP240A	U41017	U41003	U41014

COOLING METHOD	Air-Cooled
DUTY CYCLE - CO2	60% @ 220A
DUTY CYCLE - MIXED GAS	60% @ 200A

WIRE SIZE	0.8-1.2mm
STANDARD	EN60974-7
MINIMUM MOTOR LIFE (HOURS)	1000

1	USP2401	STRAIGHT NECK ASSEMBLY
2	USP1502	JUMP LINER
3	UGP36006	JUMP LINER NIPPLE
4	UGP36402B	TENSION KNOB
5	UGP36402	PRESSURE ARM ASSEMBLY
6	UGP36402R	PRESSURE ROLL
7	USP36001	MOTOR BODY
8	USP36006	WIRE GUIDE
9	PLSP1517-60ER	COAX CABLE ASSEMBLY, EURO TYPE
10	USP2515SP-B	SPOOL BOX
11	USP2515SP-C	SPOOL COVER
12	USP2515SP-PT-1K	WIRE SPEED CONTROL 1KΩ
12	USP2515SP-PT-5K	WIRE SPEED CONTROL 5KΩ
12	USP2515SP-PT-10K	WIRE SPEED CONTROL 10KΩ
13	UGP2514-C	PUSH PULL HANDLE COVER
14	UGP2516	PUSH PULL TRIGGER
15	UGP7020W-08	DRIVE ROLLER SPOOL GUN V STEEL 0.8MM
15	UGP7020W-09	DRIVE ROLLER SPOOL GUN V STEEL 0.9MM

15	UGP7020W-10	DRIVE ROLLER SPOOL GUN V STEEL 1.0MM
15	UGP7020W-08U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 0.8MM
15	UGP7020W-09U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 0.9MM
15	UGP7020W-10U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 1.0MM
15	UGP7020W-12U	DRIVE ROLLER SPOOL GUN U ALUMINIUM 1.2MM
16	UGP7020-24	MOTOR 24V DC
16	UGP7020-42	MOTOR 42V DC
17	SC2578H/L	GUN PLUG HOUSING ASSEMBLY
18	UC1519/S	HOUSING NUT
19	UC1528	HYBRID GUN PLUG BODY C/W SPRING PINS
20	UB1525	LINER NUT
21	USLH26-SM	CABLE SUPPORT LARGE
22	USLH26-C	SURELOK HOUSING COVER
23	USLH26-H	SURELOK HOUSING LARGE
24	USL3550	SURELOK BODY & SUPPORT

2.4 220A Spool Gun Consumables



Gas Diffuser

PCGD24	GAS DIFFUSER CERAMIC SUIT M24 QTY2
U11182	GAS DIFFUSER PLASTIC SUIT M24 QTY2

Tip Holder

PCTH24	TIP HOLDER SUIT M24 QTY 2
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Contact Tip

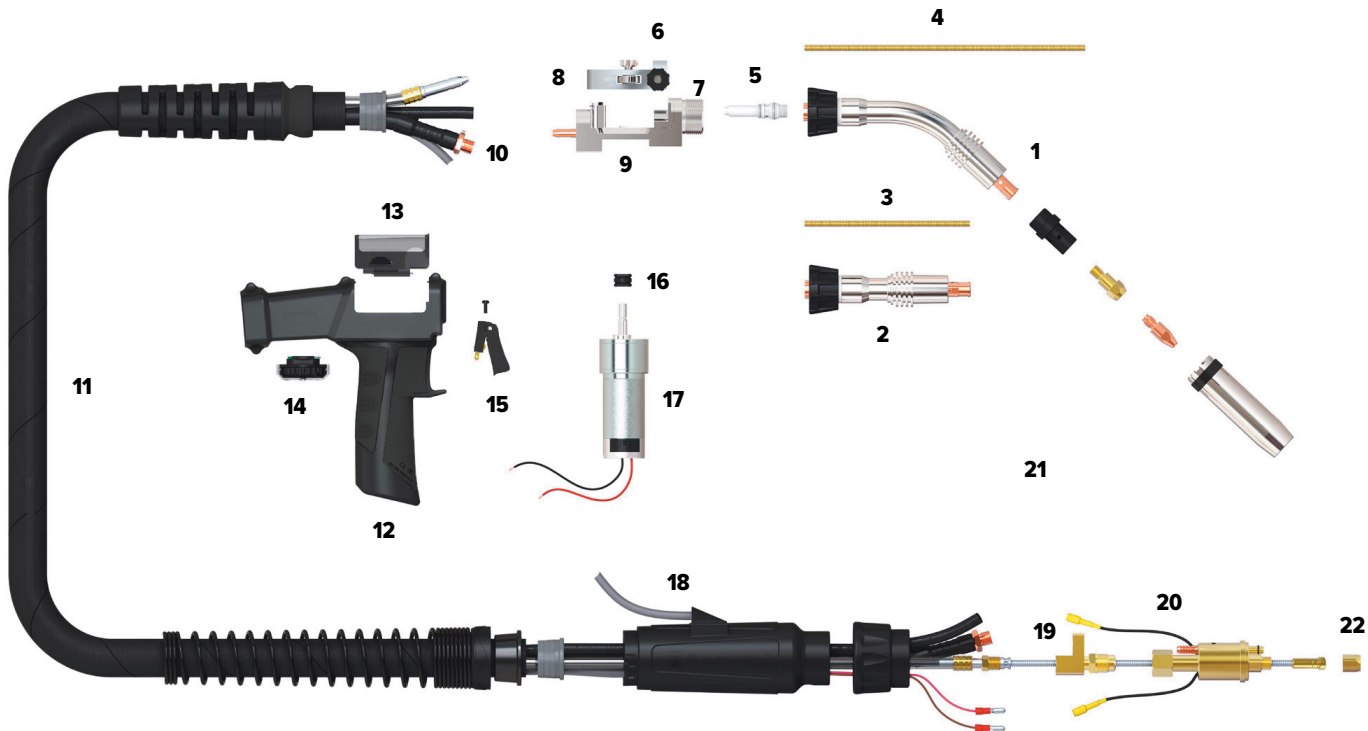
PCTAL0009-09	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 0.9MM QTY 10
PCTAL0009-10	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 1.0MM QTY 10
PCTAL0009-12	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 1.2MM QTY 10
PCT0009-06	CONTACT TIPS BINZEL STYLE M6 0.6MM QTY 10
PCT0009-08	CONTACT TIPS BINZEL STYLE M6 0.8MM QTY 10
PCT0009-09	CONTACT TIPS BINZEL STYLE M6 0.9MM QTY 10
PCT0009-10	CONTACT TIPS BINZEL STYLE M6 1.0MM QTY 10
PCT0009-12	CONTACT TIPS BINZEL STYLE M6 1.2MM QTY 10
PCT0009-16	CONTACT TIPS BINZEL STYLE M6 1.6MM QTY 10

Gas Nozzle

PGN24CON	GAS NOZZLE CONICAL SUIT M24 QTY 2
PGN24CYL	GAS NOZZLE CYLINDRICAL SUIT M24 QTY 2
PGN24TAP	GAS NOZZLE TAPERED SUIT M24 QTY 2

3. Push-Pull Guns

3.1 300A Push-Pull Gun



Length	24V Digital 8m	24V 8m	42V 8m	Digital
SKU	U41002	PPLU36-24V-8M	PPLU36-42V-8M	U11220

COOLING METHOD	Air-Cooled
DUTY CYCLE - CO2	60% @ 300A
DUTY CYCLE - MIXED GAS	60% @ 270A

WIRE SIZE	0.8-1.2mm
STANDARD	EN60974-7
MINIMUM MOTOR LIFE (HOURS)	3000

1	UGP3603	SWAN NECK SUIT PUSH-PULL 300A 45 DEGREE
2	UGP3603A	SWAN NECK SUIT PUSH-PULL 300A STRAIGHT
3	UGP3602	JUMP LINER
4	UGP3602A	JUMP LINER
5	UGP36006	JUMP LINER NIPPLE
6	UGP36402	PRESSURE ARM ASSEMBLY
7	UGP36402B	TENSION KNOB
8	UGP36402R	PRESSURE ROLL
9	UGP36001	MOTOR BODY
10	UGP36015-80	POWER CABLE ASSEMBLY
11	UGP36419-80	CANVAS COVER ASSEMBLY
12	UGP2514/KJ	PUSH PULL HANDLE
13	UGP2514/C	PUSH PULL HANDLE COVER
14	UGP0807-1	POTENTIOMETER KIT 1K
14	UGP0807-5	POTENTIOMETER KIT 5K
14	UGP0807-10	POTENTIOMETER KIT 10K
14	UGP0807-25	POTENTIOMETER KIT 25K
15	UGP2516	TRIGGER

16	UGP8224W-08	DRIVE ROLLER PUSH-PULL V STEEL 0.8MM
16	UGP8224W-09	DRIVE ROLLER PUSH-PULL V STEEL 0.9MM
16	UGP8224W-10	DRIVE ROLLER PUSH-PULL V STEEL 1.0MM
16	UGP8224W-12	DRIVE ROLLER PUSH-PULL V STEEL 1.2MM
16	UGP8224W-16	DRIVE ROLLER PUSH-PULL V STEEL 1.6MM
16	UGP8224W-09U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 0.9MM
16	UGP8224W-10U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.0MM
16	UGP8224W-12U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.2MM
16	UGP8224W-16U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.6MM
17	UGP8224-24	MOTOR 24V DC
18	USLH26-C	HOUSING INSERT
19	UGP3608C	POWER FITTING
20	UGP1528	A/C GUN PLUG BODY ASSEMBLY
21	UB1524	GUN PLUG 'O' RING
22	UB1525	LINER NUT

3.2 300A Push-Pull Gun Consumables



Gas Diffuser

PCGD36	GAS DIFFUSER CERAMIC SUIT SB36 QTY 2
U11183	GAS DIFFUSER PLASTIC SUIT SB36 QTY 2

Tip Holder

PCTH36M6L	TIP HOLDER LONG SUIT SB36 M6 QTY 2
PCTH36M8L	TIP HOLDER LONG SUIT SB36 M8 QTY 2
PCTH36M6S	TIP HOLDER SHORT SUIT SB36 M6 QTY 2

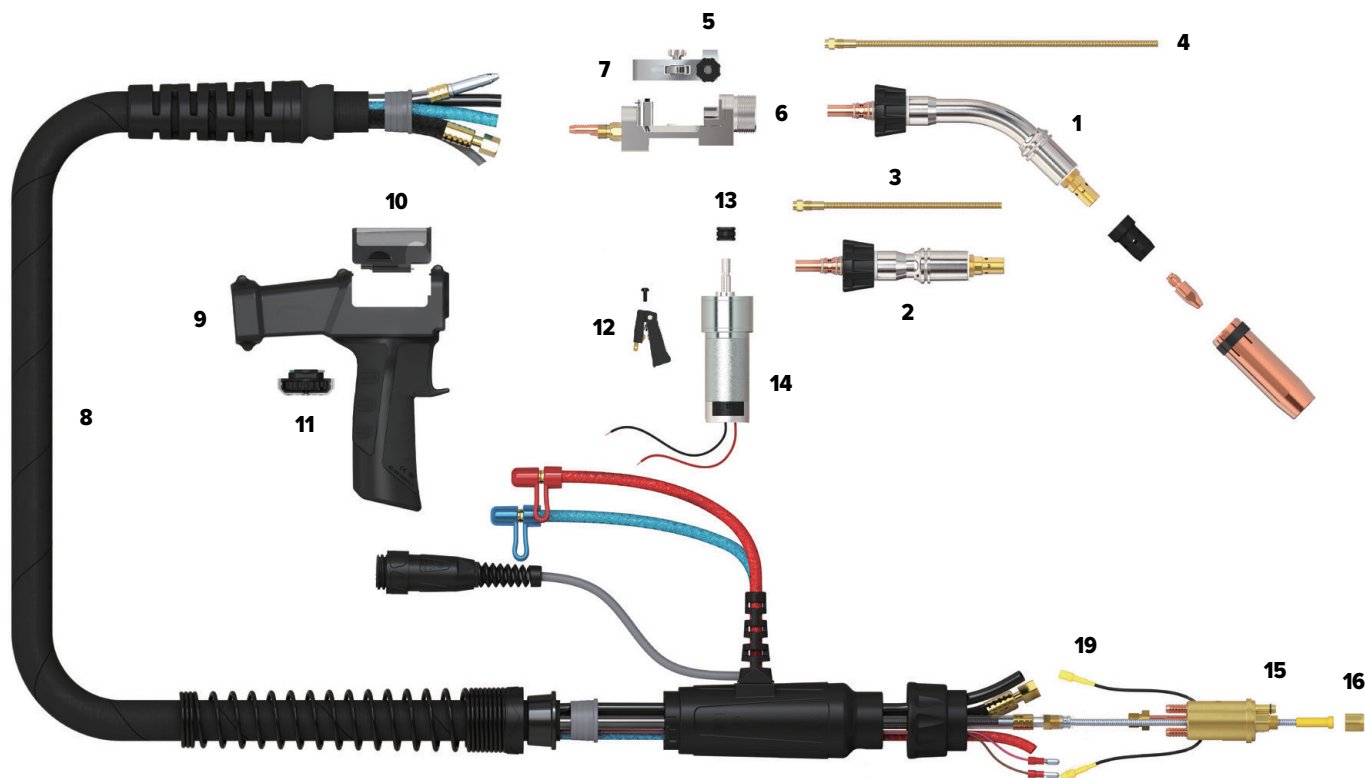
Contact Tip

PCTAL0009-09	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 0.9MM QTY 10
PCTAL0009-10	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 1.0MM QTY 10
PCTAL0009-12	CONTACT TIPS ALUMINIUM BINZEL STYLE M6 1.2MM QTY 10
PCTAL0005-08	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 0.8MM QTY 10
PCTAL0005-09	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 0.9MM QTY 10
PCTAL0005-10	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.0MM QTY 10
PCTAL0005-12	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.2MM QTY 10
PCTAL0005-16	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.6MM QTY 10
PCT0009-06	CONTACT TIPS BINZEL STYLE M6 0.6MM QTY 10
PCT0009-08	CONTACT TIPS BINZEL STYLE M6 0.8MM QTY 10
PCT0009-09	CONTACT TIPS BINZEL STYLE M6 0.9MM QTY 10
PCT0009-10	CONTACT TIPS BINZEL STYLE M6 1.0MM QTY 10
PCT0009-12	CONTACT TIPS BINZEL STYLE M6 1.2MM QTY 10
PCT0009-16	CONTACT TIPS BINZEL STYLE M6 1.6MM QTY 10
PCT0005-08	CONTACT TIPS BINZEL STYLE M8 0.8MM QTY 10
PCT0005-09	CONTACT TIPS BINZEL STYLE M8 0.9MM QTY 10
PCT0005-10	CONTACT TIPS BINZEL STYLE M8 1.0MM QTY 10
PCT0005-12	CONTACT TIPS BINZEL STYLE M8 1.2MM QTY 10

Gas Nozzle

PGN36CON	GAS NOZZLE CONICAL SUIT SB36 QTY 2
PGN36CYL	GAS NOZZLE CYLINDRICAL SUIT SB36 QTY 2
PGN36TAP	GAS NOZZLE TAPERED SUIT SB36 QTY 2

3.3 400A Water-Cooled Push-Pull Gun



Length	400A 42V 8m	Digital
SKU	PPLUWC40-42V-8M	U11221

COOLING METHOD	Water-Cooled
DUTY CYCLE - CO2	60% @ 400A
DUTY CYCLE - MIXED GAS	60% @ 350A
WIRE SIZE	1.0-1.6mm
LENGTHS (m)	8
STANDARD	EN60974-7

MINIMUM MOTOR LIFE (HOURS)	3000
MINIMUM WATER FLOW	1.2L/min
MINIMUM WATER INLET PRESSURE	2.0Bar
MINIMUM COOLING REQUIREMENTS	1600W
MAXIMUM WATER INLET PRESSURE	5.0Bar
MAXIMUM WATER INLET TEMPERATURE	50°C

1	UGP4011	SWAN NECK SUIT PUSH-PULL 400A 45 DEGREE
2	UGP4011A	SWAN NECK SUIT PUSH-PULL 400A STRAIGHT
3	UGP4002	JUMP LINER C/W NIPPLE
4	UGP4002A	JUMP LINER C/W NIPPLE
5	UGP36402	PRESSURE ARM ASSEMBLY
6	UGP36402B	TENSION KNOB
7	UGP36402R	PRESSURE ROLL
8	UGP36419-80	CANVAS COVER ASSEMBLY
9	UGP2514/KJ	PUSH PULL HANDLE
10	UGP2514/C	PUSH PULL HANDLE COVER
11	UGP0807-1	POTENTIOMETER KIT 1K
11	UGP0807-5	POTENTIOMETER KIT 5K
11	UGP0807-10	POTENTIOMETER KIT 10K
11	UGP0807-25	POTENTIOMETER KIT 25K
12	UGP2516	TRIGGER

13	UGP8224W-08	DRIVE ROLLER PUSH-PULL V STEEL 0.8MM
13	UGP8224W-09	DRIVE ROLLER PUSH-PULL V STEEL 0.9MM
13	UGP8224W-10	DRIVE ROLLER PUSH-PULL V STEEL 1.0MM
13	UGP8224W-12	DRIVE ROLLER PUSH-PULL V STEEL 1.2MM
13	UGP8224W-16	DRIVE ROLLER PUSH-PULL V STEEL 1.6MM
13	UGP8224W-09U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 0.9MM
13	UGP8224W-10U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.0MM
13	UGP8224W-12U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.2MM
13	UGP8224W-16U	DRIVE ROLLER PUSH-PULL U ALUMINIUM 1.6MM
14	UGP8224-24	MOTOR 24V DC
14	UGP8224-42	MOTOR 42V DC
15	UB1524	GUN PLUG 'O' RING
16	UB1525	LINER NUT

3.4 400A Water-Cooled Push-Pull Consumables



Tip Holder

PCTH38	TIP HOLDER SHORT SUIT SB38 M8 QTY 2
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Gas Diffuser

PCGD38	GAS DIFFUSER SUIT SB38 QTY 2
U1185	GAS DIFFUSER PLASTIC SUIT SB38 QTY2

Contact Tip

PCTAL0005-08	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 0.8MM QTY 10
PCTAL0005-09	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 0.9MM QTY 10
PCTAL0005-10	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.0MM QTY 10
PCTAL0005-12	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.2MM QTY 10
PCTAL0005-16	CONTACT TIPS ALUMINIUM BINZEL STYLE M8 1.6MM QTY 10
PCT0005-08	CONTACT TIPS BINZEL STYLE M8 0.8MM QTY 10
PCT0005-09	CONTACT TIPS BINZEL STYLE M8 0.9MM QTY 10
PCT0005-10	CONTACT TIPS BINZEL STYLE M8 1.0MM QTY 10
PCT0005-12	CONTACT TIPS BINZEL STYLE M8 1.2MM QTY 10
PCT0005-16	CONTACT TIPS BINZEL STYLE M8 1.6MM QTY 10

Gas Nozzle

PGN38CYL	GAS NOZZLE CYLINDRICAL SUIT SB38 QTY 2
PGN38CON	GAS NOZZLE CONICAL SUIT SB38 QTY 2

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