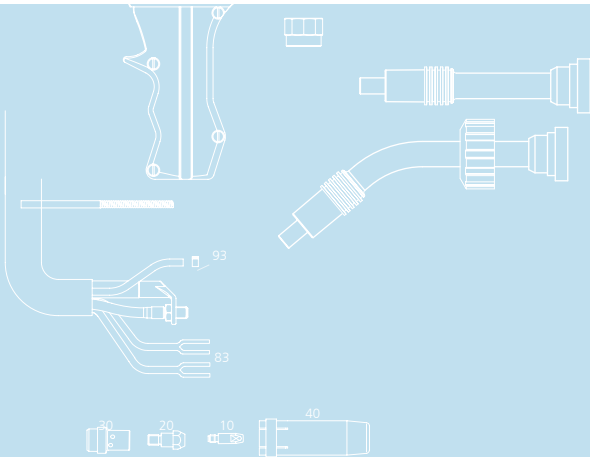




Classic TBi PP 411



Watercooled

Changeable swivel neck

Torch length 4 m - 12 m

Technical data

MIG / MAG Standard Push-Pull-torch TBi PP 411

Rating at 100% duty cycle
(10 min. cycle)

- mixed gas: 320 A
- CO₂: 350 A

Cooling method: watercooling

Wire diameter: 0.8 - 1.6 mm

Gas flow: 14 l/min

Technical specification: according to IEC 60974-7

Weight with 1.5 m cable: 2,65 kg

Connection: Euro-Central connector
other connectors (e.g. Cloos®, ESAB®) available upon request.

Torch rating will be reduced when using pulsed-arc power sources. Special torch necks and custom lengths of the coaxial cable are available upon request.

Ordering Information

TBi PP 411	40° bent, ESW, w/o pots	194P291A_0*
TBi PP 411	straight, ESW, w/o pots	194P191A_0*
TBi PP 411	40° bent, ESW, 2x pot. 10 kOhm	194P291B_0*
TBi PP 411	straight, ESW, 2x pot. 10 kOhm	194P191B_0*

* At the blank, please insert 4, 6 or 8 for a torch length of 4 m, 6 m or 8 m. For a torch length of 10 m, please insert 1A as the last two characters, for 12 m insert 1C respectively.



100



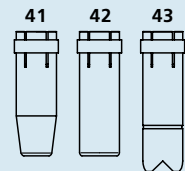
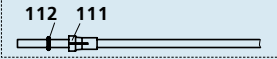
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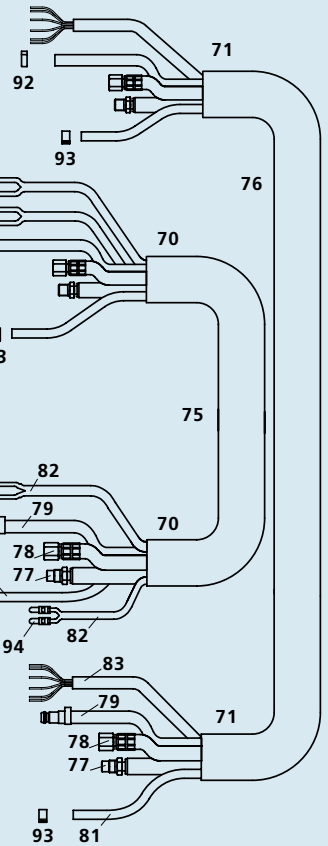
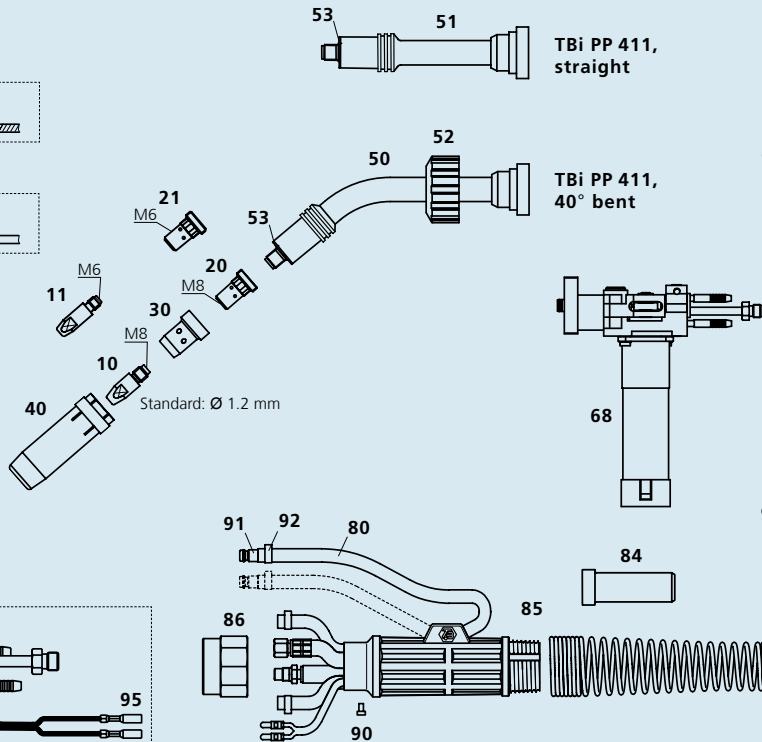
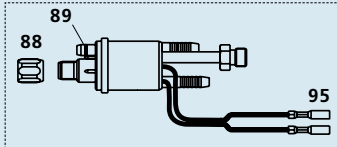
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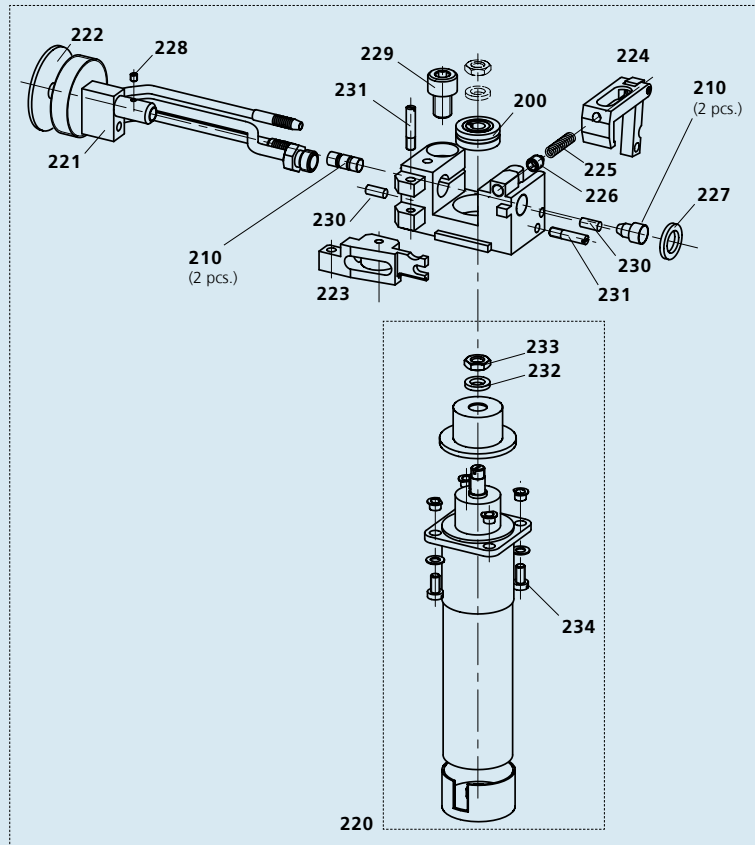
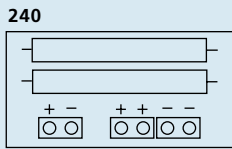
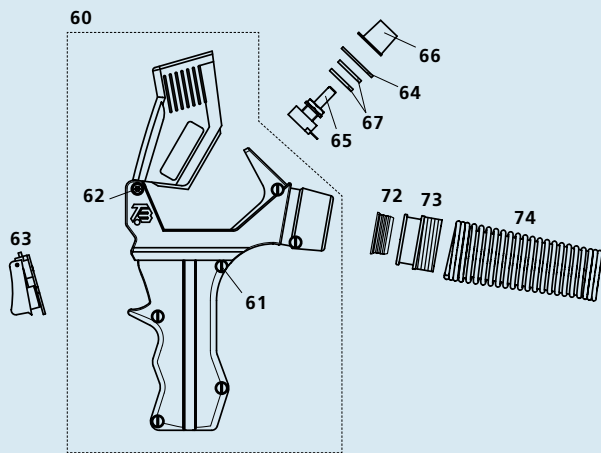
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Pos.	Description	Part. No.	Pos.	Description	Part. No.
Contact tips					
10	Contact tip M8x30, Ecu	340P__1262*	61	Socket cap screw M4x10	100P008403
10	Contact tip M8x30, CuCrZr	340P__3262*	62	Socket cap screw M4x30	109P091209
▶ 10	Contact tip M8x30 Alu, Ecu	341P__1262*	63	Micro switch, red, 3 poles	385P033011
11	Contact tip M6x28, Ecu	340P__1069*	64	Mounting plate for potentiometers	181P102157
11	Contact tip M6x28, CuCrZr	340P__3069*	64	Plate for PP handle w/o pots	181P102158
11	Contact tip M6x28 Alu, Ecu	341P__1069*	▶ 65	Potentiometer 10 kOhm	387P102003
Tip holders					
▶ 20	Tip holder M8 / L=25 mm	342P008033	65	Potentiometer 5 kOhm	387P102002
20	Tip holder M8 / L=29 mm	342P008133	65	Potentiometer 1 kOhm	387P102001
21	Tip holder M6 / L=25 mm	342P006033	66	Knob for potentiometer	181P002146
21	Tip holder M6 / L=29 mm	342P006133	67	Washer D=10.5 mm	100P012510
Gas diffusers					
▶ 30	Gas diffusor, white	130P002017	68	Drive unit cpl. for PP watercooled	191P001910
30	Gas diffusor, ceramic	130P002019	70	Cable assembly cpl. PP 411 (version w/o pots)	191P0080_0*
30	Gas diffusor, black	130P002026	71	Cable assembly cpl. PP 411 (version with pots)	191P0090_0*
30	Gas diffusor, brown	130P002031	72	Hose support	600P102102
Gas nozzles					
▶ 40	Nozzle con. diam. 16.0 mm	345P012030	73	Support for spring	600P102101
41	Nozzle con. diam. 14.0 mm	345P013030	74	Spring for handle, large	600P102100
42	Nozzle cyl. diam. 20.0 mm	345P011030	75	Fabric outer cover, 25x1.5 mm, per m	307P252800
43	Spot weld nozzle diam. 20.0 mm	345P015030	76	Fabric outer cover, 28x1.5 mm, per m	307P283100
Spare parts					
50	Torch neck TBi PP 411, 40° bent	191P001221	77	Wire conduit cpl., for PP 411	356P0101_0*
51	Swan neck TBi PP 411, straight	191P001220	78	Water-power cable, for PP-torches	315P1611_0*
52	Sleeve nut Push-Pull	181P001310	79	PVC-Water hose, blue 5x1.5 mm	303P050000
53	Insulating washer	130P002004	80	PVC-Water hose, red 5x1.5 mm	303P060000
60	Push-Pull handle, blue, cpl.	380P205100	81	PVC-Gas hose, black 4.5x1.5 mm	302P010000
			82	Control cable, 2x0.75 sqmm	300P020751
			83	Control cable, 10x0.34 sqmm	300P100341
			84	Cable support 70 sqmm	600P002107
			85	Cable support 3 parts cpl. with spring	701P101071
			86	Adaptor nut	701P001013
			87	Central adaptor ESW cpl., 2 poles, moveable pins	701P001049
			88	Sleeve nut M10x1	701P002005
			89	O-ring 4.0x1.0 mm (gas nipple)	365P100040
			90	Slotted screw M4x6	100P008401
			91	Quick connector	701P002064
			92	Hose clamp Ø 9.5 with ring	373P100095
			93	Hose clamp Ø 8.7	371P000087
			94	Insulated connector, male, round	375P000004
			95	Insulated connector, female, round	375P000003

▶ = Standard equipment

* At the blank, please insert suitable information for torch length or wire diameter, e.g. 08 for 0.8 or 4, 6 or 8 for 4m, 6m or 8m. For longer torches please refer to the section special lengths.



Pos.	Description	Part. No.
Wire guides (torch neck)		
▶ 100	Wire guide set PA/bronze for Al-wire 0.8-1.6 mm	181P001135
101	Wire guide set for steel wire 0.8-1.6 mm	181P001132

Pos.	Description	Part. No.
Wire guides (cable assembly)		
110	Liner w/o insulation (x.50 m) for wire 0.8-1.6 mm	322P2545_5*
111	Collet for teflon and PA liner 4.7 mm	331P027047
112	O-ring 3.50x1.50 mm (teflon liner)	365P150035
▶ 120	PA liner cpl. (x.50 m) for wire 0.8-1.6 mm	328P2947_5*

Pos.	Description	Part. No.
Special lengths for 10 and 12 m torches		
70	Cable assembly PP 411 (version w/o pots), 10 m	191P008010
70	Cable assembly PP 411 (version w/o pots), 12 m	191P008012
71	Cable assembly PP 411 (version with pots), 10 m	191P009010
71	Cable assembly PP 411 (version with pots), 12 m	191P009012
77	Wire conduit cpl., for PP 411, 10 m	356P01011A
77	Wire conduit cpl., for PP 411, 12 m	356P01011C
78	Water-power cable, for PP-torches, 10 m	315P16111A
78	Water-power cable, for PP-torches, 12 m	315P16111C
110	Liner w/o insulation, for wire 0.8-1.6 mm, 10.50 m	322P25451A
110	Liner w/o insulation, for wire 0.8-1.6 mm, 12.50 m	322P25451C
▶ 120	PA liner cpl., for Al-wire 0.8-1.6 mm, 10.50 m	328P29471A
▶ 120	PA liner cpl., for Al-wire 0.8-1.6 mm, 12.50 m	328P29471C

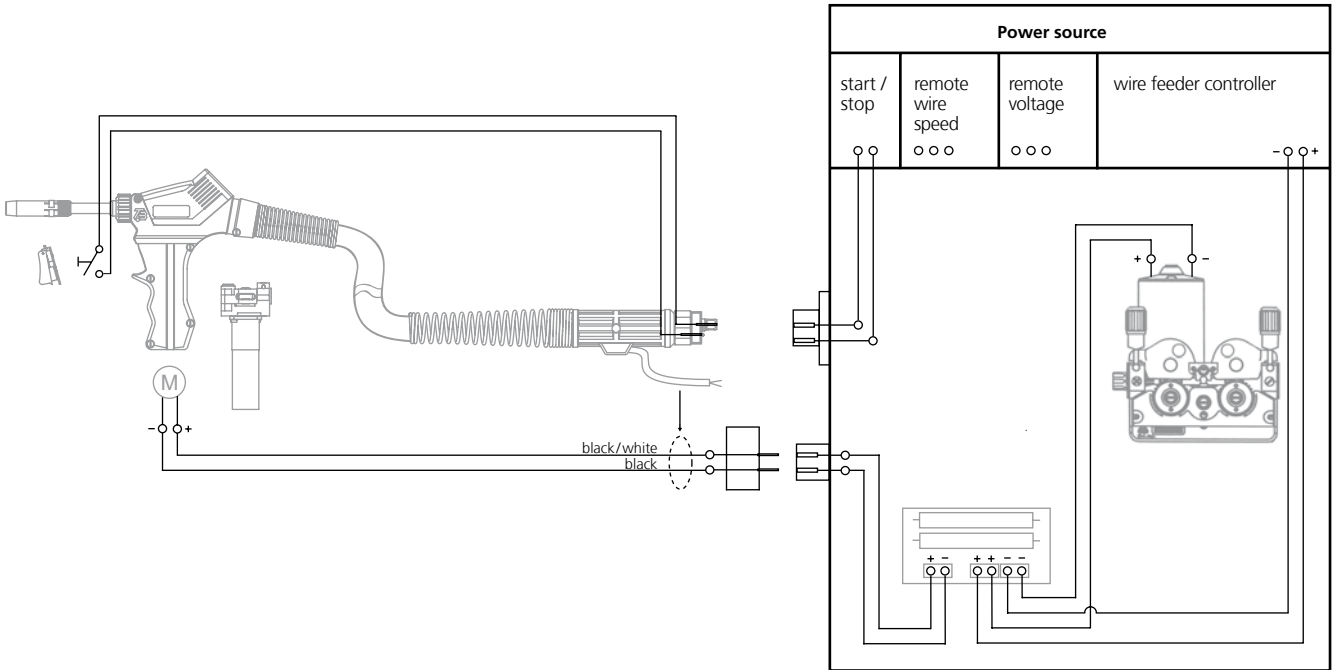
Pos.	Description	Part. No.
Feed rolls		
200	Feed roll for Al-wire 0.8 mm	181P101001
200	Feed roll for Al-wire 1.0 mm	181P101002
▶ 200	Feed roll for Al-wire 1.2 mm	181P101003
200	Feed roll for Al-wire 1.6 mm	181P101005
200	Feed roll for steel wire 0.8 mm	181P101009
200	Feed roll for steel wire 1.0 mm	181P101011
200	Feed roll for steel wire 1.2 mm	181P101013
200	Feed roll for steel wire 1.6 mm	181P101015
200	Knurled feed roll for cored wires 1.0-1.6 mm	181P002122

Pos.	Description	Part. No.
210	Wire inlet guides, set of 2 pcs.	181P001130

Pos.	Description	Part. No.
Spare parts for wire drive unit		
220	Motor 42V, set with insulation material	181P101020
221	Neck adaptor for PP 411	191P001302
222	Gasket	181P002101
223	lever with pressure roll, cpl.	181P101012
224	Tension bracket cpl.	181P101019
225	Spring	181P002109
226	Adjusting screw	181P002110
227	Washer	104P002013
228	Set screw M3x3	109P091310
229	Socket cap screw M8x12	109P091211
230	Cylindrical pin 4x10 mm	100P000702
231	Headless screw M4x20	100P042703
232	Serrated washer 6.4 mm	100P679801
233	Hex nut M6, flat	109P403501
234	Cheese head screw M4x8	100P008416

Pos.	Description	Part. No.
P/C board		
▶ 240	P/C board for connection to main drive motor	181P001016

TBi PP 411 without potentiometers



TBi PP 411 with potentiometers

