Power Pin Installation

*Each SpinArc® welding torch requires the correct power pin and wire liner be installed prior to use. This must be specified and ordered as a separate line item.*

**Typical Power Pins (Miller, Tweco, Lincoln styles)**

1. Unscrew the liner cap from the new power pin and set aside
2. Screw the new power pin into the back end of the cable assembly and tighten with two wrenches
3. Slide the rubber cover over the power pin
4. Insert a new liner through the power pin and through the cable
5. Make sure the threaded end of the liner seats flush against the power pin
6. Install and tighten the liner cap at the power pin
7. Cut the liner on the torch body end so that the liner extends 1 – 1.25” (25 – 32 mm)
**Fronius F++ Power Pin (PP-F3)**

1. Remove the spring strain relief from the plastic back end by twisting it off
2. Remove the plastic clam shell using a 2.5 mm Allen wrench (6 screws total)
3. Unscrew the cap holding the liner and remove the liner
4. Remove the existing brass bushing from the feeder end of the welding cable with two wrenches
5. Slide the Fronius nut over the power pin with threads on the nut facing the wire feeder end
6. Thread on the Fronius power pin assembly and tighten with two wrenches (rotate pin until clam shell properly seats)
7. Reinstall the plastic clam shell housing (careful not to pinch any lead wires)
8. Reinstall the spring on the plastic housing
9. Insert a new liner through the power pin and through the cable
10. Cut off threaded brass end from liner approx. ½" (12mm) from the end (discard the tressed liner end)
11. Press and twist the plastic coated liner end into the liner cap
12. Screw in the liner cap on to the power pin post
13. Cut the liner on the torch body end so that the liner extends **1 – 1.25" (25 - 32 mm)**
Euro Power Pin (PP-Euro)

1. Remove the spring strain relief from the plastic back end by twisting it off
2. Remove the plastic clam shell using a 2.5 mm Allen wrench (6 screws total)
3. Unscrew the back brass cap and remove the existing liner
4. Remove the existing brass bushing from the feeder end of the welding cable with two wrenches
5. Slide the Euro nut over the Euro connectors with threads on the nut facing the wire feeder end
6. Thread on the Euro connector assembly and tighten with two wrenches
7. Reinstall the plastic clam shell housing (careful not to pinch any lead wires)
8. Reinstall the spring on the plastic housing
9. Insert a new liner through the power pin and through the cable
10. Screw in the liner cap on to the power pin post
11. Cut the liner on the torch body end so that the liner extends 1 – 1.25” (25 - 32 mm)
12. Note: The electrical pins in the Euro connection power pin are not included and not required. The arc start is initiated through a user-supplied system (e.g., Bug-0). There are two open holes in the Euro power pin. The shielding gas is routed through the body in a separate port.
The electrical pins (arrows) are not used and are not connected electrically with the SpinArc torch. Arc start is initiated through a user-supplied system. The TC-15 trigger cable can be used to close the trigger circuit and start the welding arc.
# Power Pins

The correct power pin (wire feeder adaptor) is required to connect the torch to the wire feeder. Below is a list of the most common feeders and corresponding power pin part number.

**Note**: Most wire feeder manufacturers have the option to use a Tweco #4.

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Wire Feeder Model</th>
<th>Part #</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Euro</strong></td>
<td>Euro Connection</td>
<td>PP-EURO</td>
</tr>
<tr>
<td><strong>Fronius</strong></td>
<td>F++ Connector</td>
<td>PP-F3</td>
</tr>
<tr>
<td></td>
<td>Fronius Special Connector (&quot;FSC&quot;): TPS/i machines WF25 i feeder</td>
<td>PP-EURO with Fronius’ Euro Kit (Fronius PN 4,100,617,U)*</td>
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<tr>
<td><strong>Lincoln</strong></td>
<td>Newer Style Feeders: LN-10, DH-10, LF-72, LF-74, PF-10, PF-25M, PF-25M Aluminum, PF-84, LN-25 Pro, STT-10</td>
<td>PP-TW4</td>
</tr>
<tr>
<td></td>
<td>LN-4, LN-5, LN-6, LN-7, LN-8, LN-9, LN-22, LN-25, LN-742, Power-Feed 10 (Robotic), Power Wave 450/455, Synergic 7</td>
<td>PP-L2</td>
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<tr>
<td></td>
<td>Power Wave 4R Series</td>
<td>PP-L4</td>
</tr>
<tr>
<td><strong>Miller</strong></td>
<td>Series, 60 Series, 70 Series, Suitcase 8VS, 12VS, R115</td>
<td>PP-M1</td>
</tr>
<tr>
<td><strong>OTC Daihen</strong></td>
<td>CM741, CMRE741, AF4001, New D Series</td>
<td>PP-OTC</td>
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<tr>
<td><strong>Tweco</strong></td>
<td>Tweco #2 &amp; #4</td>
<td>PP-TW4</td>
</tr>
<tr>
<td></td>
<td>Tweco #5</td>
<td>PP-TW5</td>
</tr>
</tbody>
</table>

Additional power pins may be available by special request through our Customer Service Team by calling +1-832-585-1244.

* Must be purchased from Fronius