

LN-8



Semiautomatic Wire Feeder

LN-8 WIRE FEEDER



LN-8 shown with DC-600 power source, K1524-1 universal wire reel stand, K1557-1 swivel platform and a Magnum® 400 gun and cable assembly.

The LN-8 is a semiautomatic constant speed wire feeder designed for flux-cored arc welding (FCAW), MIG welding (GMAW), and submerged arc welding (SAW) processes. It is designed to be used with a variety of Lincoln DC constant voltage power sources.

The LN-8 features controlled wire feed speed and voltage during starting which provide clean, positive starts and minimizes stubbing, skipping and spatter. This wire feeder provides dependable, interruption-free performance, and rugged and reliable operation. These features make the LN-8 ideal for shop or field applications.

The LN-8 is available with many accessories to fit your needs. See Recommended Options on pages 6, 7 and 8.

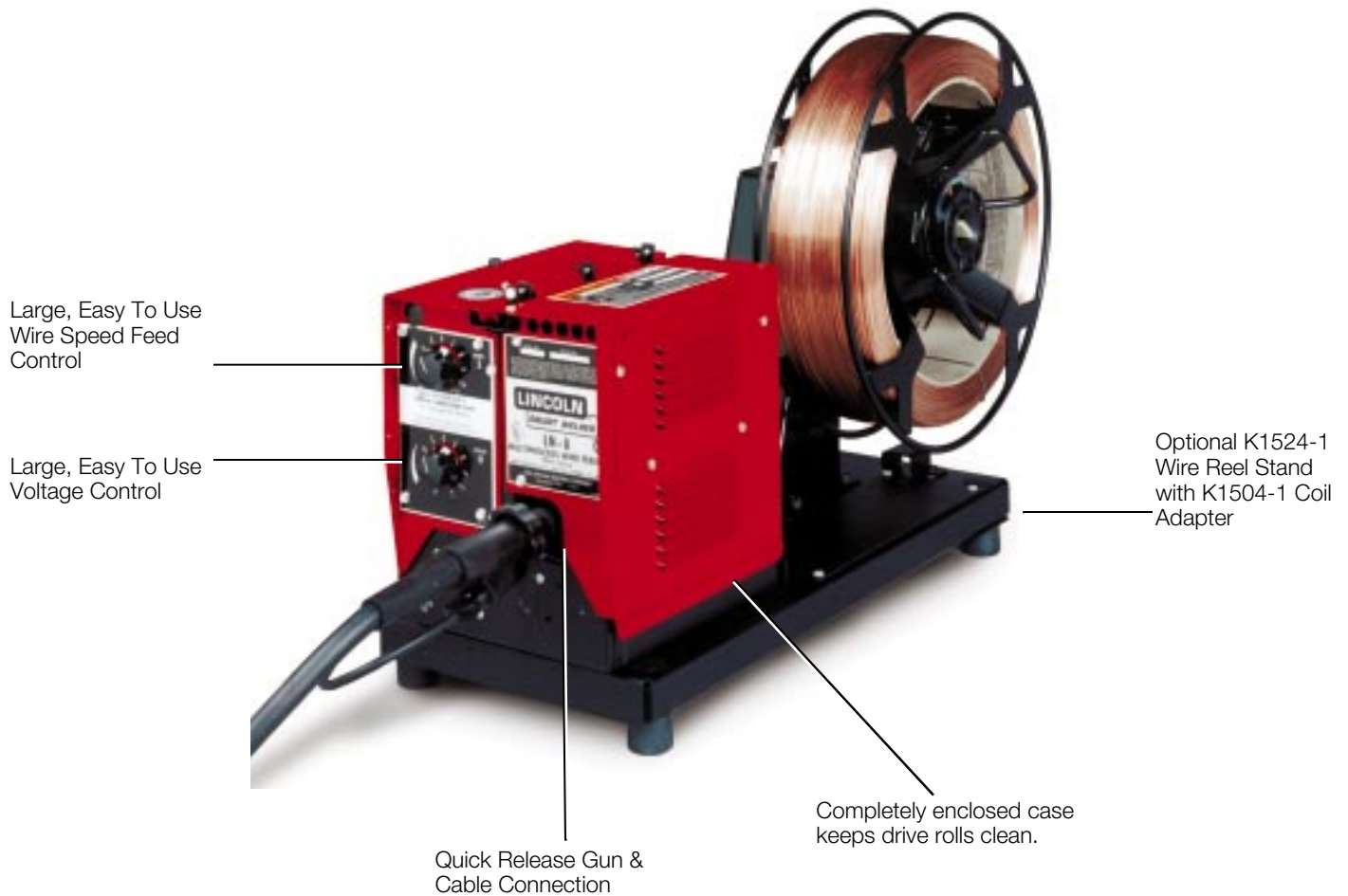
ADVANTAGE LINCOLN

- LN-8 models feed up to 3/32" (2.4mm) solid and .120" (3.0mm) flux-cored wires, from 50-600 inches per minute (1.3-12.7 m/min) wire feed speed.

- Unique drive roll design provides positive feeding and quick reloading by simply inserting the wire into the incoming guide tube. The drive rolls and guide tubes are designed for long life and precise wire feeding.
- Completely enclosed case protects the heavy duty wire drive mechanism from damage, but allows easy access to drive rolls.
- Control circuit features "cold electrode" when the gun trigger is released for an added measure of safety. Power source must be equipped with a contactor.
- Low voltage (24 volts) gun trigger circuit.
- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.
- Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed.
- Control of wire speed feed and voltage from the wire feeder, eliminates the need to return to the power source to adjust procedures.
- Optional burnback kit provides adjustable delay of power source output shut off to prevent electrode sticking when using high wire feed speeds or in automated applications.
- 3 year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9002 requirements.



A CLOSER LOOK



TECHNICAL SPECIFICATIONS

Description	Ordering Information	Wire Speed Range IPM (m/min)	Suggested Wire Size Range in. (mm)		Input	Net (1) Weight	Dimensions (1) H x W x D in. (mm)
			Solid	Cored			
LN-8	K297	50 - 600 ipm (1.3 - 15.2 m/min)	.030 - 3/32 (0.8 - 2.4)	.045 - .120 (1.2 - 3.0)	115 VAC 50/60 Hz	36 lbs (16.2 kg)	10.9 x 9.8 x 9.6 (277 x 248 x 244)

(1) Net weight and dimensions do not include wire reel stand.

DRIVE ROLL AND GUIDE TUBE KITS

Steel Wire Sizes:	
Solid Wire: .030 - .035" (0.8 - 0.9 mm) .040", .045 - .052" (1.0 - 1.4 mm) 1/16" (1.6 mm)	KP502-035 KP502-052 KP502-1/16
Cored Wire: .045 - .052" (1.0 - 1.4 mm) 1/16 - .062" (1.6 mm) 7/64 - .120" (2.8 - 3.0 mm)	KP502-052C KP502-1/16C KP502-120
Solid or Cored Wire: .068 - 3/32" (1.7 - 2.4 mm)	KP502-3/32

Steel Wire Sizes:	
Hardfacing: 7/64" (2.8 mm)	KP502-7/64H
Aluminum Wire: .035" (0.9mm) 3/64" (1.2mm) 1/16" (1.6mm)	KP503-035A KP503-3/64A KP503-1/16A

INPUT CABLE ASSEMBLIES

14 Pin MS-Type/Twist-Mate™ Cables

K596-xx

Rated 500 amps, 60% duty cycle cable with Magnum Twist-Mate™ and 14-pin MS-type (Amphenol) connector. The 10, 25, and 50 ft. (3.0, 7.5 and 15.2 m) lengths are available in 2/0 cable size and the 75 and 100 ft. (22.5 and 30.0 m) lengths are available in 3/0 cable size.
Order K596-10, -25, -50, -75 or -100

14 Pin MS-Type/Stud Cables

K595-xx

Rated 600 amps, 60% duty cycle cable with lugs and 14 pin MS-type (Amphenol) connector. The 10, 25, 50 and 75 ft. (3.0, 7.5, 15.2 and 22.5m) lengths are available in 3/0 cable size and the 100, 150 and 200 ft. (30.0, 45.0 and 60.0m) lengths, are available in 4/0 cable size.
Order K595-10, -25, -50, -75, -100, -150 or -200

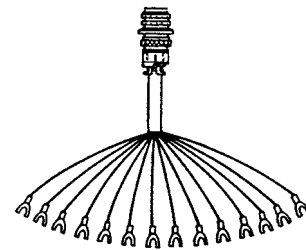
Terminal/Stud Cables

K196-xx-6

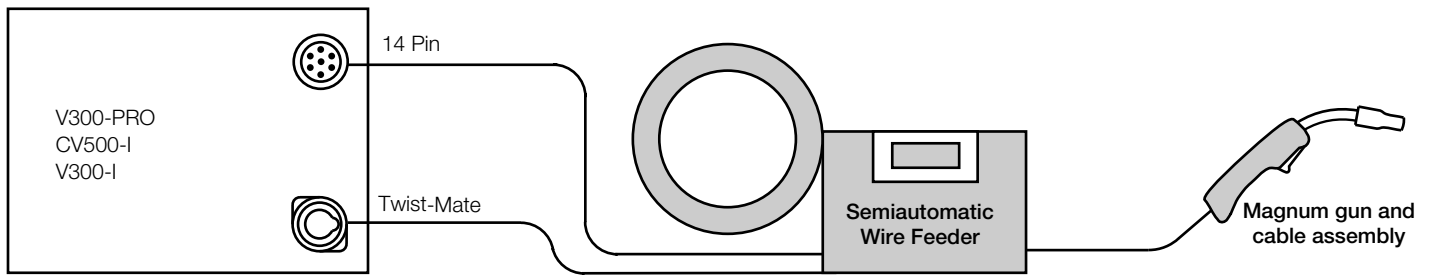
Rated 600 amps 60% duty cycle cable with lugs and terminal strip connections. The 10, 25, 50, and 75 ft. (3.0, 7.6 15.2, and 22.5 m) lengths are available in 3/0 cable size and the 100 and 200 ft. (30.0 and 60.0 m) lengths are available in 4/0 cable size.
Order K196-10, -25, -50, -75, -100, or -200.

K867 Adapter

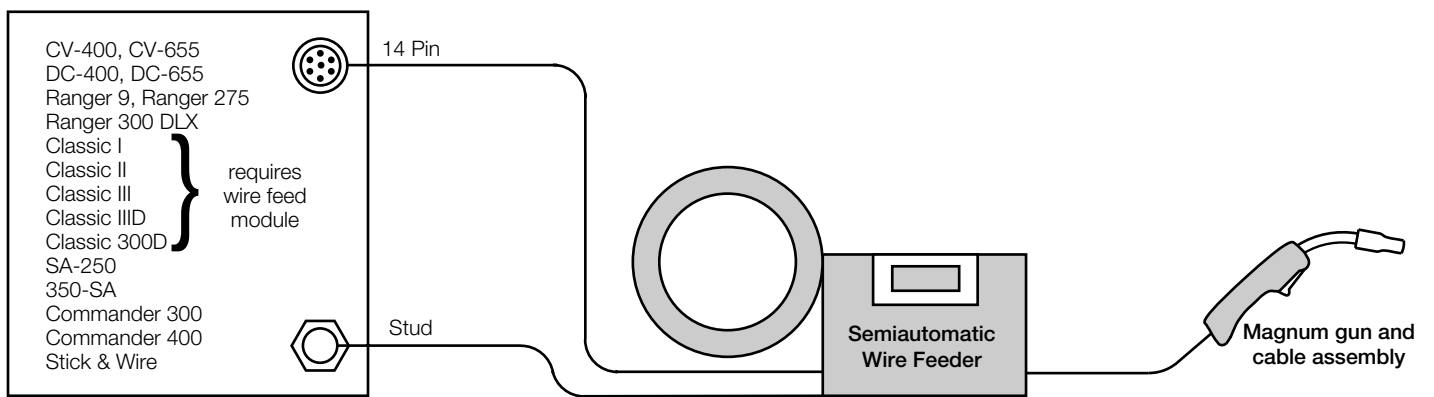
Contains a 14 pin plug that connects to the power source. The individual leads may be connected to K196 input cable. **Order K867.**



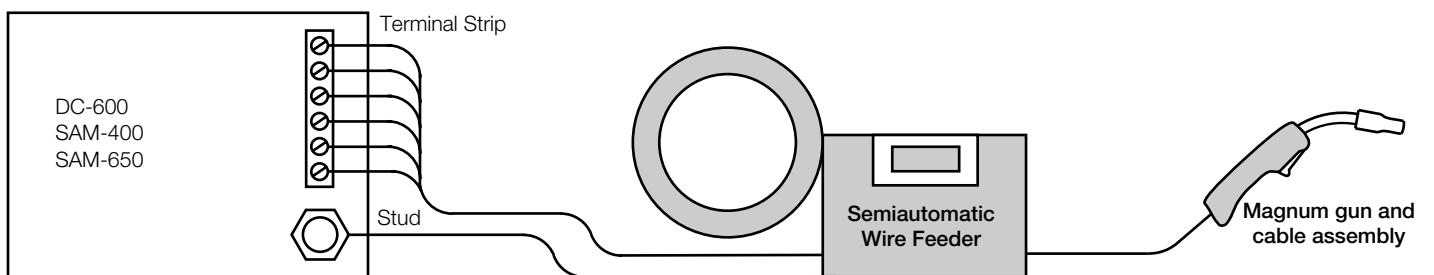
INPUT CABLE ASSEMBLY SELECTION GUIDE



14 Pin MS-Type/Twist-Mate™ Input Cable Assembly
K596 500 amp, 60% duty cycle.



14 Pin MS-Type/Stud Input Cable Assembly
K595 600 amp, 60% duty cycle



Terminal/Stud Input Cable Assembly
K196-xx-6 600 amp, 60% duty cycle

NOTE A: Specify length when ordering input cable assemblies. See page 4.

NOTE B: Connections are for current equipment design. Subject to change without notice.

NOTE C: To use an LN-8 with a power source that does not have an internal contactor, use with a K240 contactor kit.

REQUIRED OPTIONS

WIRE REEL STANDS

K303

For use with 50-60 lb. (22.7-27.2 kg) coils. Includes 1" (25.4mm) spindle, wire reel, lift bail and dust shield.

Order **K303**.



K303

K1524-1

Universal Wire Reel Stand for use with Lincoln 10-60 lb. (4.5-27.2 kg) wire packages that use a 2" (51mm) spindle. Hole in stand fits over lift bail.

Order **K1524-1**.



K1524-1

RECOMMENDED OPTIONS

SPINDLE ADAPTERS

For REDI-REELS and Spools

2" O.D. spindle for mounting REDI-REELS and 2" (51mm) I.D. spools up to 60 lb. (27.2 kg) capacity to a K303, or custom installations. Order **K162H**.

For 14 lb. (6 kg) Innershield Coils

Permits 14 lb. (6 kg) Innershield coils to be mounted on 2" (51mm) O.D. spindles. Order **K435**.

60 lb. (27.2 kg) Adapter

Adapts 50-60 lb. (22.7-27.2 kg) Lincoln REDI-REELS of electrode to 2" (51mm) spindle. Order **K438**.



K438

COVER KIT

Wire Reel Cover Kit

Plastic enclosure for 10 - 44 lb. (4.5 - 20 kg) wire packages.

Order **K1634-1**.

REDI-REEL® ADAPTERS

30 lb. (14 kg) Adapter

Adapts 22-30 lb. (10-14 kg) Lincoln REDI-REELS of electrode to 2" (51mm) spindle. Order **K363P**.



K363P

COIL ADAPTER

60 lb. (27.2 kg) Adapter

Adapts 60 lb. (27.2 kg) coils of Lincoln electrode to 2" (51mm) spindle.

Order **K1504-1**.



K1504-1

RECOMMENDED OPTIONS

Meter Kit

Contains an analog which indicates welding voltage and wire feed speed directly on a 0-60 volt scale.

Order K261.

Burnback Kit

Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds or on automated applications. Includes a cold inch switch. **Order K202.**

Gas Solenoid Assembly

Includes solenoid valve and mounting bracket, to mount solenoid inside the LN-8 case. **Order K437 (for code numbers below 9132) or K425 (for code numbers above 9131).**

Swivel Platform

For mounting wire feeder on top of suitable Lincoln power sources when using K303 wire reel stand.

Order K178-1.



Flux Screen

For submerged arc welding. Removes large particles from reused flux.

Includes air-driven vibrator.

Order K310.



Magnetic Flux Screen Separator

For submerged arc welding. Removes foreign magnetic particles from reused flux. **Order K58.**

Swivel Platform

Mounts to the lift bail on the power source and bottom of the K1524-1. Wire feeder may be lifted off if needed. Compatible with Light Duty Caster Kit. Includes "lazy susan" parts tray.

Order K1557-1.



K1557-1

Insulated Lift Bail

Allows the entire wire feeder to be hung from a crane or hook. Use with K1524-1.

Order K1555-1.



Portable Digital WFS Meter

When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute.

Order K283.

Caster Kit - Light Duty

Mounts to the K1524-1 wire reel stand. Allows for easy movement of wire feeder.

Order K1556-1.



K1556-1

Contactor Kit

Required for LN-8 with SAE power sources or other power sources that do not have an output contactor. Provides for a cold electrode. **Order K240.**

Continuous Flux Feeding Tank Asbly.

For submerged arc welding. Includes air filter, pressure regulator, gauge, tank, 18 ft. (5.4m) flux hose, funnel and lift bail assembly to mount wire feeder, K303 wire reel stand to K163 undercarriage. **Order K320.**

Undercarriage

Includes mounting frame, front casters, rear wheels and handle for hand towing. **Order K163.**

Wire Reel and Flux Tank Assembly

Includes K163 undercarriage, K320 Flux Feeding Tank Assembly and K303 wire reel stand.

Order K305.



K303

K320

K297

K163

RECOMMENDED OPTIONS

Mechanized SAW Gun

600 amp rating, for 5/64 and 3/32" (2.0 and 2.4mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit or Squirtmobile. For submerged arc welding.

Order K114.

Mechanized Hand Travel Unit

Carries the K114 Mechanized SAW Gun along the joint at a preset travel speed to help the operator make better welds 10 to 25% faster than with manual travel. Speed range is 7 - 60 ipm (0.2 - 1.5 m/min). Requires K161 Squirtmobile Power Pack to drive unit.

Order K110.

Power Pack

Includes travel mag-amp circuit required when using either a Squirtmobile or Mechanized Hand Travel Unit with a K114 SAW gun. Mounts near power source. Available in 25, or 50 ft. (7.5, or 15 m) lengths. Connect to the power source for input power.

Order K161-25, or -50.



Squirtmobile®

Self-propelled trackless carriage carries K114 Mechanized SAW Gun on long welds for automatic welder economy without high fixture costs.

Requires K161 Power Pack to drive unit.

Order K62.



Magnum® Submerged Arc Guns

Rated 500 amps, 15 ft. (4.5m) length cable, for 1/16" (1.6mm) electrode size. **Order K112.**

Rated 600 amps, 15 ft. (4.5m) length cable, for 5/64" (2.0 mm) electrode size. **Order K113-1.**

Rated 600 amps, 15 ft. (4.5m) length cable, for 3/32" (2.4mm) electrode size. **Order K113-2.**

Flux Cone

Fits K112 and K113 guns for welding without the Continuous Flux Feeding Tank Assembly, shown on page 7.

Order K119.

Self-Shielded, Flux-Cored Guns

Designed for welding with self-shielded, flux-cored arc welding (FCAW-SS) continuous feed wires. They are rugged and heavy duty, yet lightweight, flexible and maneuverable,

Order K115, K116 or K126.



Flux-Cored Gun & Cable Assemblies

Magnum Wire Conduit

Designed for connecting the LN-8 wire feeder to bulk packaging for added mobility. Available in 15, 25, 50 ft (4.5, 7.5, 15 m) or customized length.

Order K565-15, -25, -50, -FT



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