

OPERATOR'S INSTRUCTIONS



K283 APPLICATION

For accurate control of welding procedures on constant voltage (CV) systems, use Lincoln's K283 wire speed feed meter.

The wire speed feed meter is a hand-held portable unit that can be placed on .030" to 7/32" (0.89 to 5.6 mm) diameter automatic or semiautomatic wire to measure wire feed speed in inches per minute. The unit can be used on all wire feeder where there is access to the wire.

DESCRIPTION

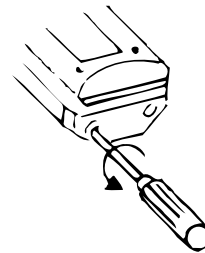
When the meter is used, a spring loaded guide keeps the pickup shaft on the wire to ensure accurate measurements. The speed is shown on a digital readout and is accurate within $\pm 1\%$ over a normal range of 100 to 600 inches per minute. The pickup shaft and guide are insulated from the case so the unit can be used when the wire starts. The meter displays the wire feed speed continuously and automatically updates reading very second. The last reading will be displayed for approximately 2 minutes before unit shuts off automatically.

The K283 is battery operated and can be operated in an ambient temperature of 32° to 120°F (0° to 49°C). Storage temperature range is -30° to 120°F (-34° to 49°C). A case is provided for storage when the meter is not in use.

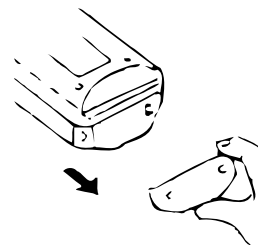
INSTALLATION

Batteries are shipped loose and should be installed per instructions below.

1. Loosen screws to release cover.



2. Insert two AA batteries, matching polarity marked on inside of battery cavity.



If the wire speed feed meter is not to be used for several months, remove batteries from the unit to prevent corrosion.

OPERATION

Open the guide with attached spring handle and place pickup shaft on wire so that guide traps the electrode against the shaft. The shaft must be kept square with the wire for accurate readings. *Brace meter against wire feeder case or something stationary so unit does not move while reading wire speed.*

Push the button on the side of the unit to have the digital display read wire speed in inches per minute.

To measure wire speed feed on the LN-22 and LN-23P with a S16001-A or S16001-B wire feed cable, push the sliding tube up on the cable so meter pickup shaft can be placed on the wire from the wire reel side. Check that the sliding tube does not rub on the pickup shaft.

For maximum life, the wire speed feed meter should be removed from the wire after wire speed has been determined. Leaving the meter on the electrode continuously can lead to reduced guide life and expose the

meter to mechanical abuse. A flashing "B" indicates batteries are low and they should be replaced with four AA alkaline batteries. If there is not display and if temperature is below 32°F (0°C), warm up unit until display returns. Be certain that batteries make a good electrical connection with battery terminals and spring contacts.

TROUBLESHOOTING

PROBLEMS (SYMPTOMS)	SOLUTION	RECOMMENDED COURSE OF ACTION
PROBLEMS		
1. Flashing "B" (or total Display)	1. Replace batteries.	
2. No Display	2. a. Check batteries. b. If temperature is below 32° (0°C), warm up unit until display returns. c. Be certain that batteries make a good electrical connection with battery terminals and that batteries make good contact with spring contacts inside meter housing.	Contact your Local Lincoln Authorized Field Service Facility for technical troubleshooting assistance.

Date of Purchase: _____

Serial Number: _____

Code Number: _____

Model: _____

Where Purchased: _____



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