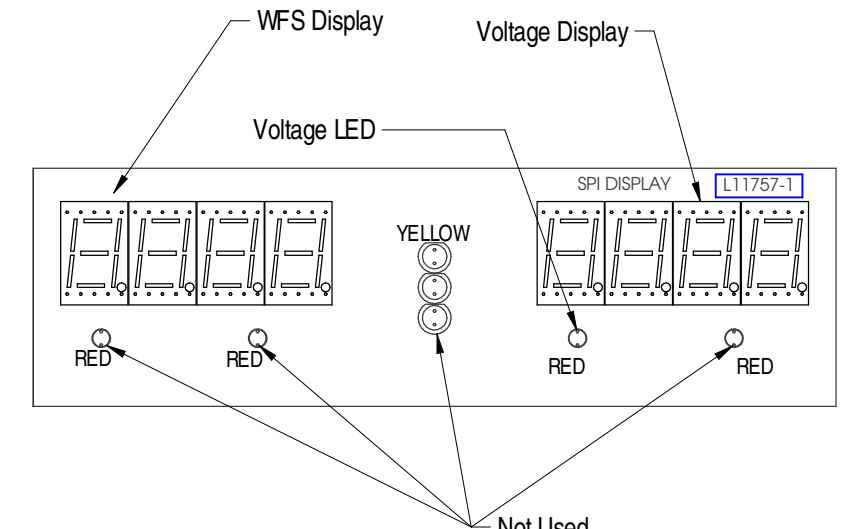
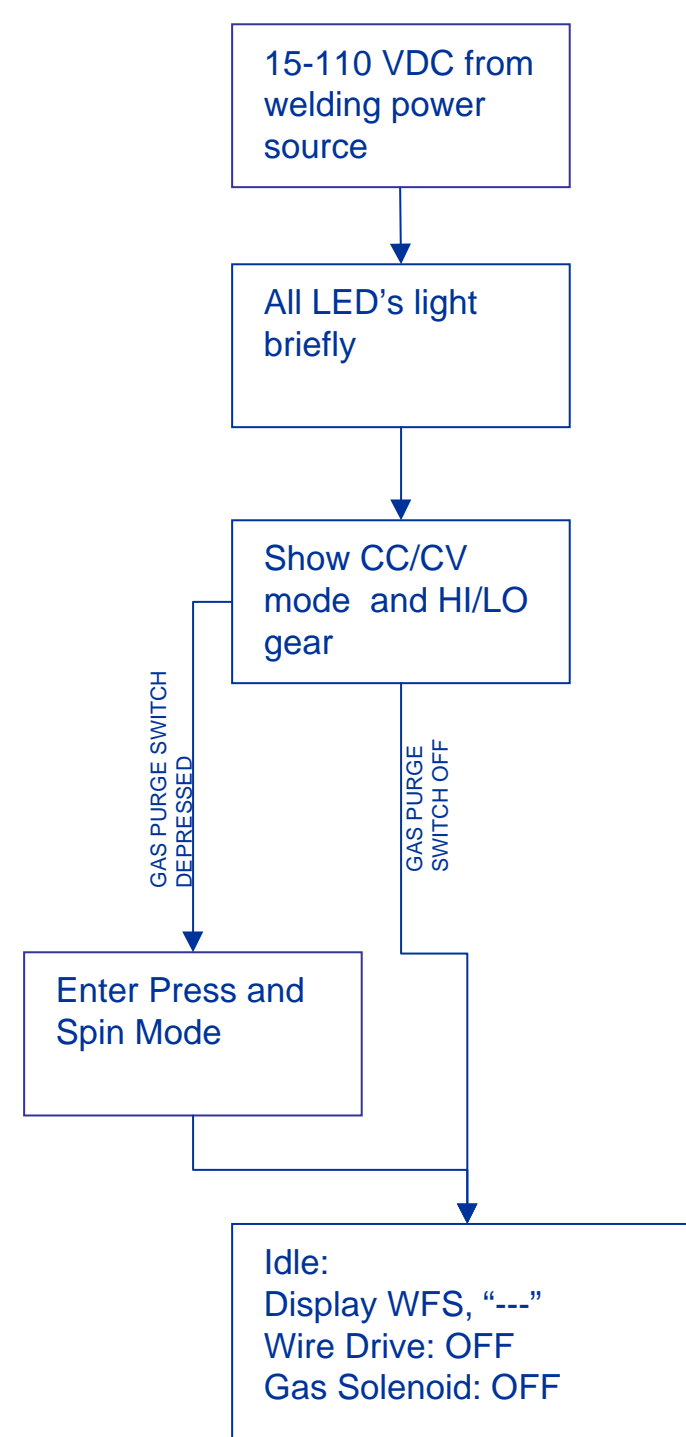


General Notes:
 • Codes 10864, 11033 & 11035 do not support the high/low speed gear change. Only the high speed (1.8" diameter) gear may be used.

Error Code	Description	Cause and Remedy
Err 0081	Average motor Over-current shutdown	The wire drive has exceeded the current rating: • 10 amps for 0.5 seconds or • 3.5 amps for 10 seconds. Wait 45 seconds for the error to reset. Reduce the current load on the motor by: • Verifying the electrode slides easily through the liner of the gun. • Reduce the spindle brake resistance. • Reduce the amount of tension in the wire drive pressure arm. • Use only Lincoln electrodes.
Err 0086	Trigger lockout	The voltage into the feed head board exceeds 150 VDC. Some inverters and choppers may have spikes on the output that charge the capacitors inside the LN-15 beyond limits. If this error occurs, lower the OCV of the power source. It may be likely that a different power source is required.



The display board communicates to the feedhead board through the SPI bus. Only the power supply signals can be monitored during servicing.
 The WFS always shows the present WFS.
 The voltage display shows the voltage while welding, plus holds the voltage for 5 seconds after the weld. It shows "-.-" when idle. A negative "-." sign will automatically be shown when welding with reverse polarity procedures.
 All the LEDs, including those not used, will briefly light on power up. The LED's not used are visible behind the nameplate when lit.



N.A. CAVITY NUMBERING SEQUENCE AS VIEWED FROM COMPONENT SIDE OF BOARD.
 N.B. CAVITY NUMBERING SEQUENCE AS VIEWED FROM LEAD SIDE OF CONNECTOR.
 N.C. TOGGLE SWITCHES AND POTENTIOMETERS SHOWN FROM CONNECTION SIDE OF SWITCH.

Model	Ranger 8,9	Classic	Ranger 250, 305 Commander 300,400,500 (Common Analog Controls)	V350 (Common Digital Controls)	DC-400, 600	Square Wave TIG 300/355	Miller Inverters	STT II	Note:
K1870-1,-2 Across the Arc	Recommended all CV operation.	Recommended for CV operation. (Wire Feed Module Required)	Recommended for CV operation.	Recommended for CV operation.	Recommended for CV and CC operation.	Not recommended for CC operation because the customer may experience short contactor life from inductive nature of the power source.	Recommended for CV voltage sense operation.	Not recommended for STT operation.	Most semiautomatic wire welding processes perform better using constant voltage power sources. Be sure the proper power source is used for your application. Contactor life may be shortened in applications using CC machines with high OCV.

LN-15 ACROSS THE ARC MODEL

CAVITY NUMBERING SEQUENCE (COMPONENT SIDE OF P.C. BOARD)

GENERAL INFORMATION

ELECTRICAL SYMBOLS PER E1537

COLOR CODE

B - BLACK
 W - WHITE
 R - RED
 U - BLUE

Positive Voltage Feedback

Input Power Circuit

Input Voltage Protection

WFS Control Circuit

Contactor

Interlock Circuit

Inch/Purge Circuit

Gun Trigger Circuit

Display Board Circuit

Boost Board

Wire Drive Circuit

Gas Solenoid Circuit

