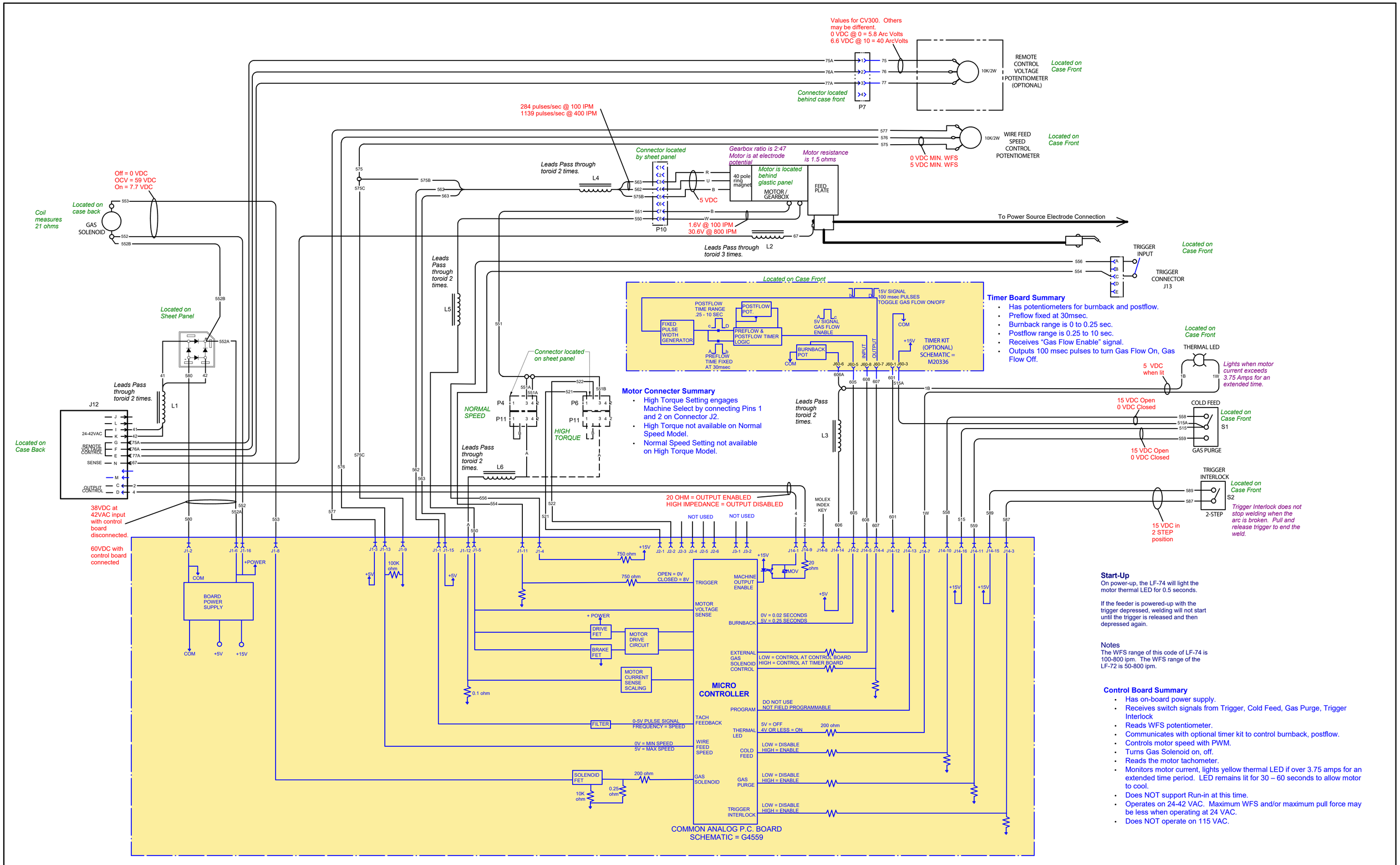
LF-74 WIRE FEEDER MACHINE SCHEMATIC G4942 REV : B



Start-Up

On power-up, the LF-74 will light the motor thermal LED for 0.5 seconds.

If the feeder is powered-up with the trigger depressed, welding will not start until the trigger is released and then depressed again.

Notes

The WFS range of this code of LF-74 is 100-800 ipm. The WFS range of the LF-72 is 50-800 ipm.

Control Board Summary

- Has on-board power supply.
- Receives switch signals from Trigger, Cold Feed, Gas Purge, Trigger Interlock
- Reads WFS potentiometer.
- Communicates with optional timer kit to control burnback, postflow.
- Controls motor speed with PWM.
- Turns Gas Solenoid on, off.
- Reads the motor tachometer.
- Monitors motor current, lights yellow thermal LED if over 3.75 amps for an extended time period. LED remains lit for 30 – 60 seconds to allow motor to cool.
- Does NOT support Run-in at this time.
- Operates on 24-42 VAC. Maximum WFS and/or maximum pull force may be less when operating at 24 VAC.
- Does NOT operate on 115 VAC.