Operator's Manual

Digital Wire Feed Speed Meter

For use with machines having Code Numbers:

K283-1

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K283-1 APPLICATION

For accurate control of welding procedures on constant voltage (CV) systems, use Lincoln's K283-1 wire feed speed meter.

The wire feed speed 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 any wire feeder where there is access to the wire.

DESCRIPTION

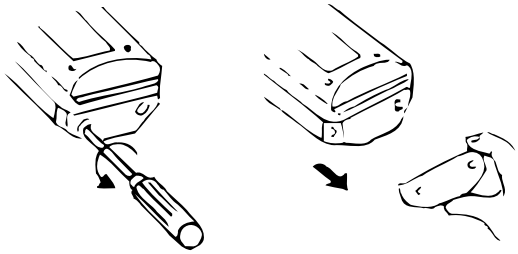
When the meter is used, a spring loaded guide keeps the pickup disk on the wire to ensure accurate measurements. The speed is shown on a digital readout and is accurate within ±1% over a normal range of 100 to 600 inches per minute. The pickup disk and guide are insulated from the case so the unit can 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 K283-1 is battery operated and can be operated in an ambient temperature of 32º to 120ºF (0º to 49ºC). Storage temperature range is -30º to 120ºF (-34º to 49ºC). 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 feed speed 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 disk on wire so that guide traps the electrode against the disk. The disk 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 feed speed on the LN-22 and LN-23P place this pickup disk directly on wire emerging from the welding gun (or from feeder, if gun is removed).

For maximum life, the wire feed speed 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 two AA alkaline batteries. If there is no display and if temperature is below 32ºF (0ºC), warm up unit until display returns. Be certain that batteries make a good electrical connection with battery terminals and spring contacts.

PROBLEMS / SYMPTOM(S)	POSSIBLE CAUSE(S)	RECOMMENDED COURSE(S) OF ACTION
FLASHING "B" (OR TOTAL DISPLAY)	Replace batteries.	
NO DISPLAY	Check batteries.	Contact your Local Lincoln Authorized Field Service Facility for technical troubleshooting assistance.
	If temperature is below 32º (0ºC), warm up unit until display returns.	
	Be certain that batteries make a good electrical connection with battery terminals and that batteries make good contact with spring contacts inside meter housing.	

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