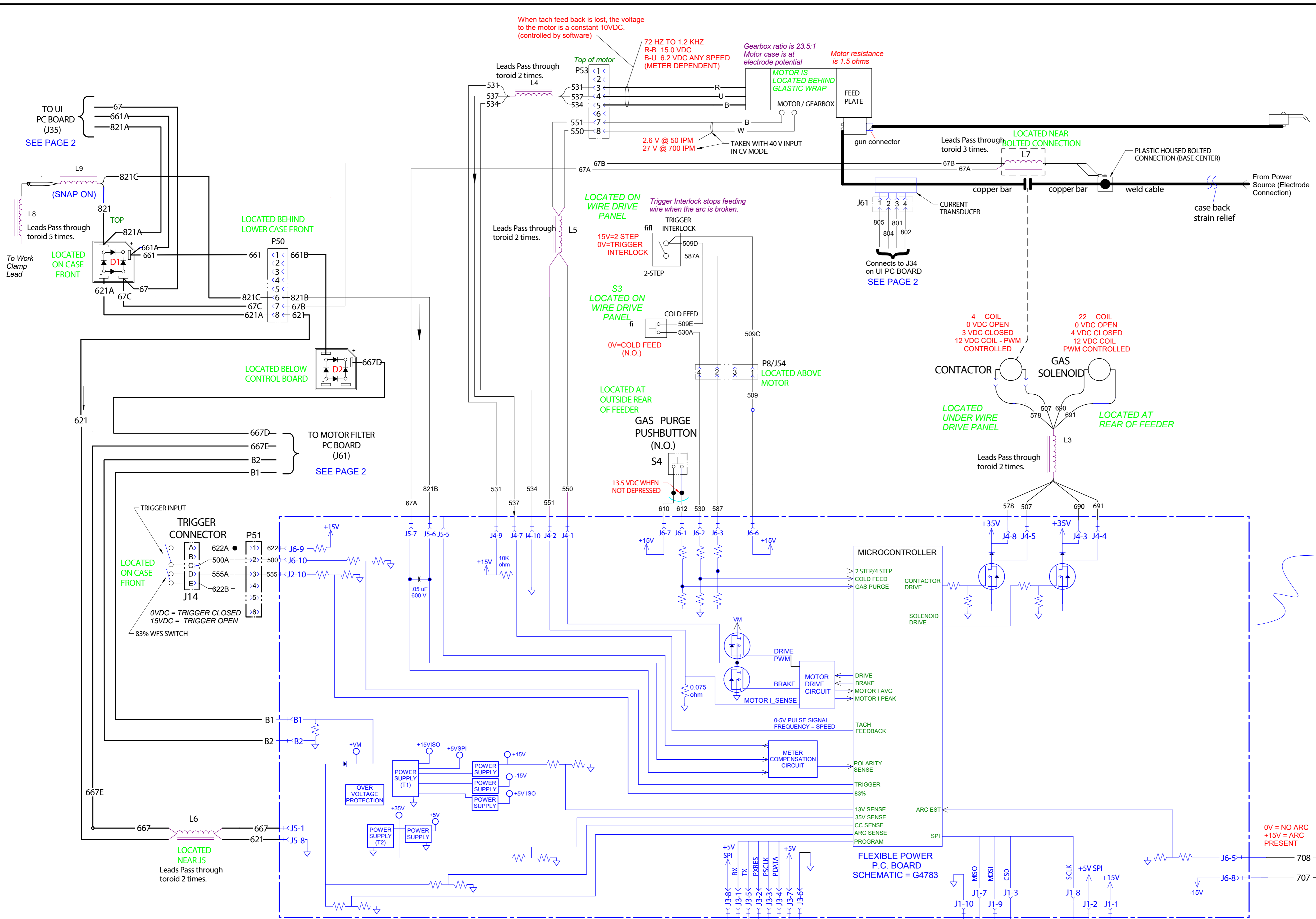
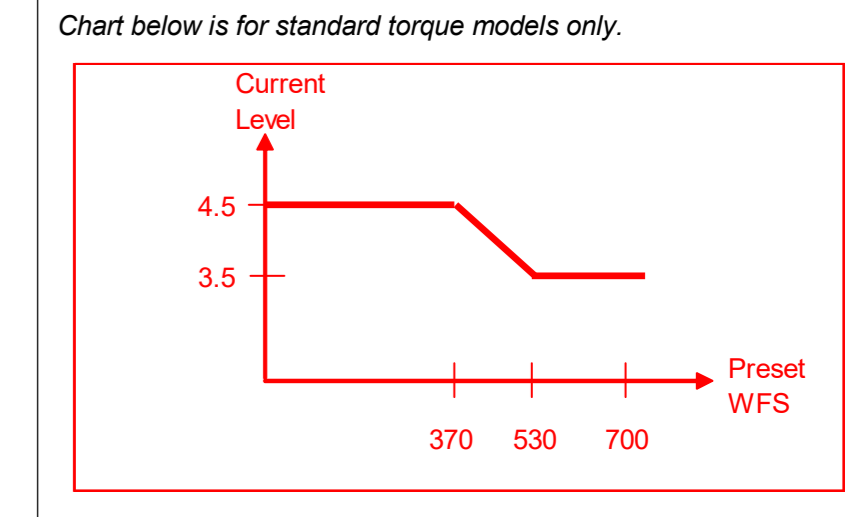


LN-25X MACHINE SCHEMATIC G9811 REV : B



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

Notes:
Motor overcurrent limit varies with WFS.
The WFS range of the LN-25x is 40 - 700 ipm for standard torque models.



Feeder Input Volts	Maximum WFS
15	305
17	360
21	460
24	535
27	620

Flexible Power Board Summary

- Converts arc power to a usable control circuit voltage.
- Receives switch signals from Trigger, Cold Feed, Gas Purge
- Communicates with optional timer kit.
- Controls motor speed with PWM.
- Turns Gas Solenoid on, off, PWM.
- Reads the motor tachometer.
- Operating Voltage= 15-110 VDC.
- Shut down Voltage= 130 VDC.

Code and Serial numbers are below Wire Drive on plastic housing Nameplate.

NOTE: THERMAL LED IS LOCATED ON THE UI BOARD.

LEAD COLOR CODE:	COMPONENT VALUE UNITS:
B-BLACK OR GRAY	CAPACITOR: MFD/VOLTS
G-GREEN	RESISTOR: OHMS/WATTS
O-ORANGE	
R-RED OR PINK	
U-BLUE	
W-WHITE	
Y-YELLOW	
LABELS:	
COMMON	
FRAME GROUND	
EARTH GROUND	

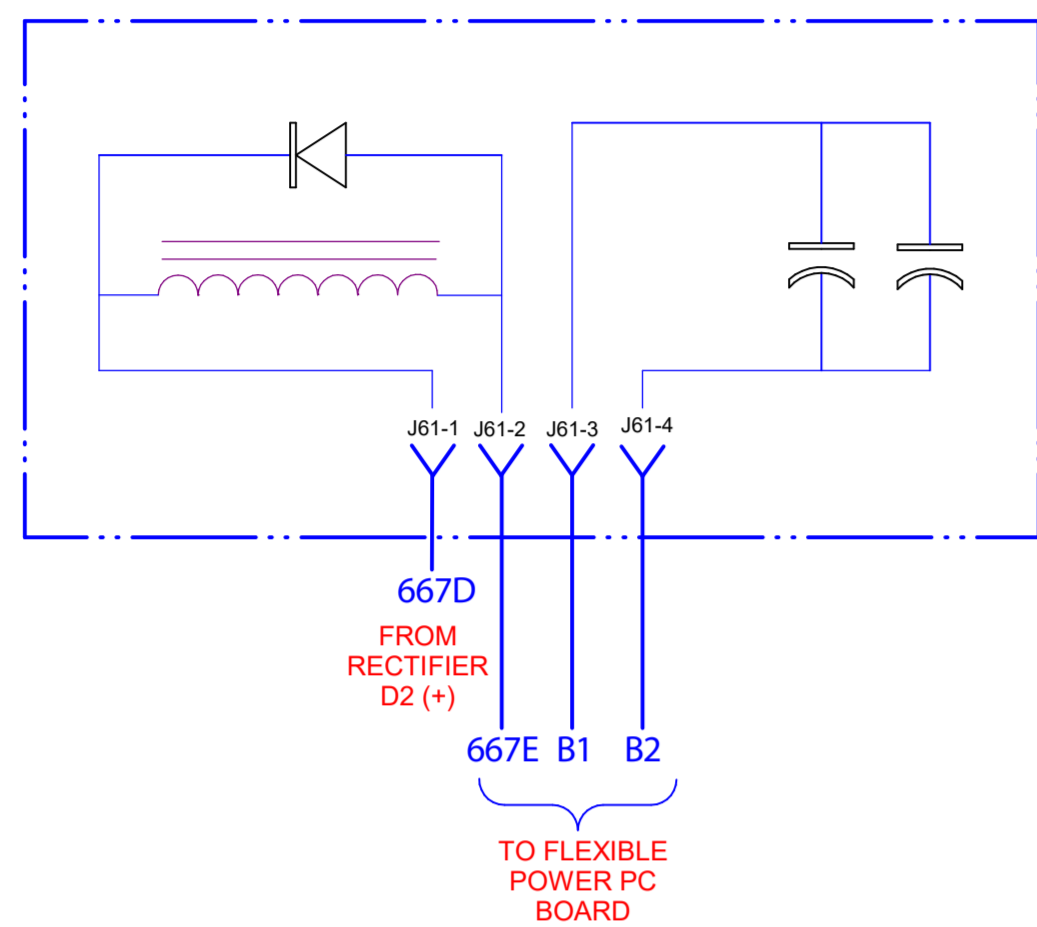
PROGRAMMING CONNECTOR FACTORY USE ONLY

DIGITAL COMMUNICATION AND SUPPLY TO UI BOARD

UI P.C. BOARD SCHEMATIC = G9232
SEE PAGE 2. FOR MORE DETAILS

MOTOR FILTER P. C. BOARD CIRCUIT

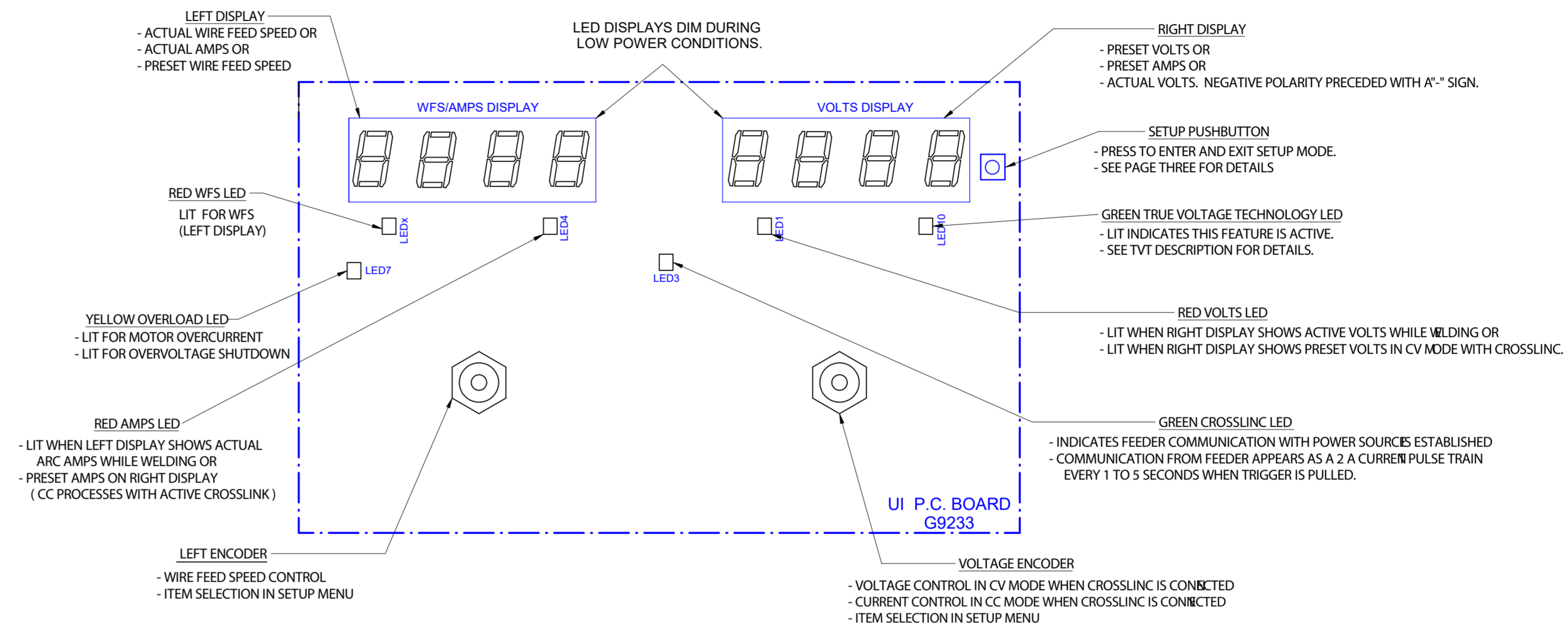
SCHEMATIC = S27505
 LOCATED ABOVE FLEXIBLE POWER PC BOARD



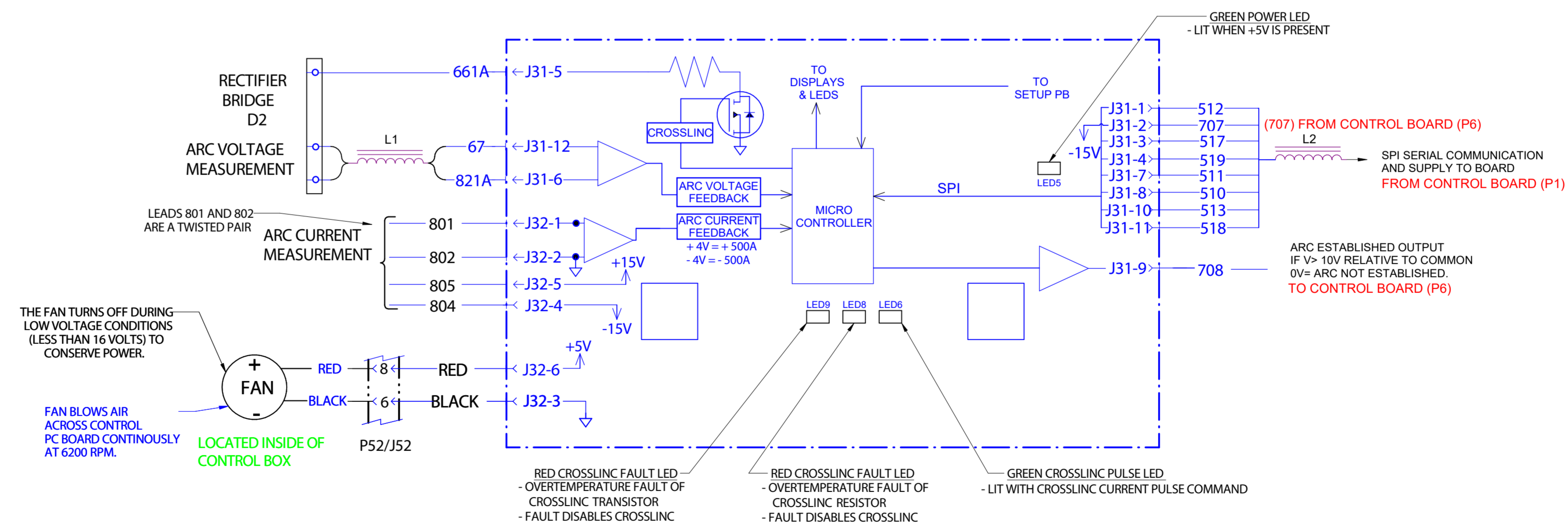
UI P. C. BOARD CIRCUITRY

SCHEMATIC = G9232
 LOCATED ON CASE FRONT

CONTROLS



CIRCUITRY



SETUP MENU

LN-25X Setup Menu Operation

The LN-25X setup menu is accessed through the hidden setup menu push button that is located below a small hole just right of the right 4 digit display.

To enter the setup menu, use a paper clip to quickly press and release the small button located to the right of the voltage display on the front of the LN-25X.

The setup menu settings (in order) are:

- Wire feed speed units (metric or English)
- Preweld time
- Run in wire feed speed
- Burnback time
- Postflow time
- Display of actual wire feed speed or arc current
- Arc hours display on/off
- After weld display hold time
- True Voltage Technology (TVT) enable/disable
- Crosslinc™ enable/disable
- CC or CV power source
- Wire feed speed calibration
- Arc voltage display calibration
- Arc current display calibration

The left display will show the menu item, and the right display will show the set value.

The left encoder is used to select the setup menu item to be changed.

The right encoder will be used to change the set value.

While in the setup menu, there are 3 ways to exit the menu and return to showing preset settings on the displays.

1. A quick press and release of the setup button.
 2. A quick gun trigger closure and release.
 3. 30 seconds of inactivity while in the setup menu.
-

Pressing and holding the hidden button for about 5 seconds enters the user into a special menu that displays the firmware version for both the motor control board and the user interface. While displaying the firmware versions after the hidden button has been released, an additional press and release of the hidden button prompts the user to choose whether they want to restore factory default settings. The right encoder can then be used to select whether an additional press of the hidden button will reset the LN-25X to the factory default settings.

Preset/ UI Board Summary

Thermal "Yellow" LED7 (ERR 82)

Motor Over-Current

Motor and trigger disabled for 30 seconds.

Must retrigger to start welding after 30 seconds pass.

Shutdown Voltage exceeded

May occur with some inverters.

May occur with some CC machines with high inductance.

Polarity Indicator

When operating in negative polarity, a "-" (minus) sign will appear in the voltmeter display.

Communications

The "Green" LED3 indicates that communication has been established between the feeder and the power source.

Communication will appear to be a 2 Amp current pulse train, occurring every 1 to 5 seconds while not welding.

When an arc has been established, the pulses will end.

It takes about one second for the power source to respond when the setpoint is changed at the feeder.