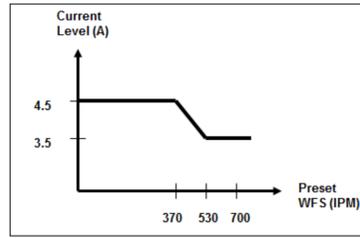
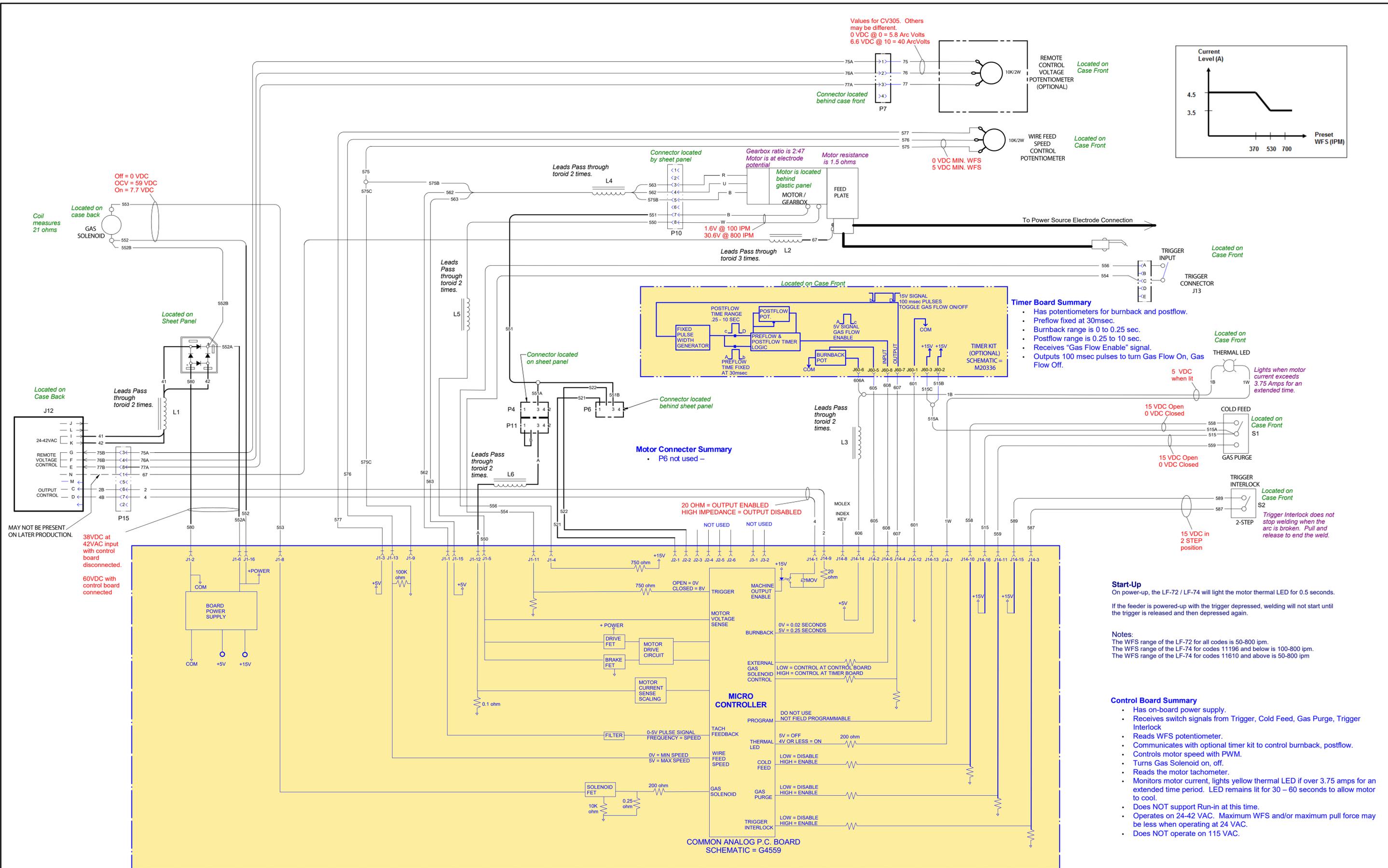


LF-72/74 WIRE FEEDER MACHINE SCHEMATIC G4617-3 REV: C



Timer Board Summary

- Has potentiometers for burnback and postflow.
- Preflow fixed at 30msec.
- Burnback range is 0 to 0.25 sec.
- Postflow range is 0.25 to 10 sec.
- Receives "Gas Flow Enable" signal.
- Outputs 100 msec pulses to turn Gas Flow On, Gas Flow Off.

Motor Connector Summary

- P6 not used

Start-Up
On power-up, the LF-72 / 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 the LF-72 for all codes is 50-800 ipm.
The WFS range of the LF-74 for codes 11196 and below is 100-800 ipm.
The WFS range of the LF-74 for codes 11610 and above 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.