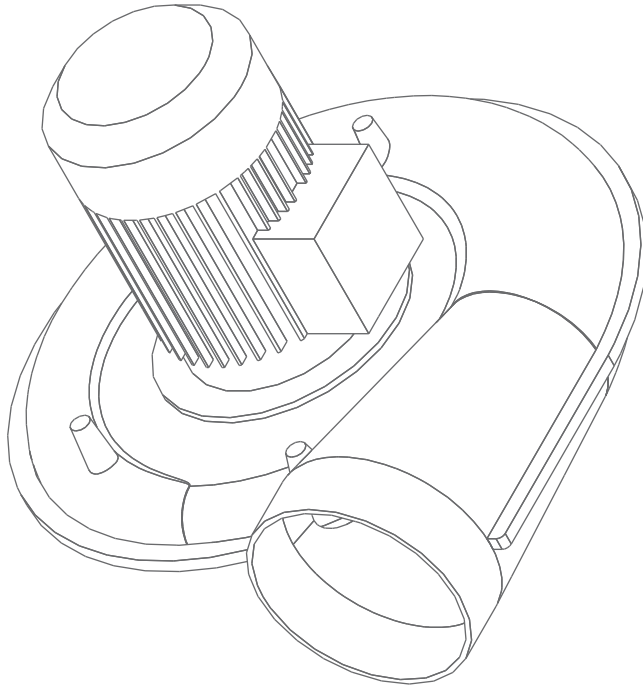


Operator's Manual

SF2400 Stationary Fan



For use with machines having Code Numbers:
12355, 12551



Register your machine:

www.lincolnelectric.com/register

Authorized Service and Distributor Locator:

www.lincolnelectric.com/locator

Save for future reference

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

SAFETY DEPENDS ON YOU

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

WARNING

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

CAUTION

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



KEEP YOUR HEAD OUT OF THE FUMES.

DON'T get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

READ and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

USE ENOUGH VENTILATION or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

IN A LARGE ROOM OR OUTDOORS, natural ventilation may be adequate if you keep your head out of the fumes (See below).

USE NATURAL DRAFTS or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



WEAR CORRECT EYE, EAR & BODY PROTECTION

PROTECT your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

PROTECT your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

PROTECT others from splatter, flash, and glare with protective screens or barriers.

IN SOME AREAS, protection from noise may be appropriate.

BE SURE protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



SPECIAL SITUATIONS

DO NOT WELD OR CUT containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

DO NOT WELD OR CUT painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

Additional precautionary measures

PROTECT compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

BE SURE cylinders are never grounded or part of an electrical circuit.

REMOVE all potential fire hazards from welding area.

ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.



SECTION A: WARNINGS



CALIFORNIA PROPOSITION 65 WARNINGS



WARNING: Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to www.P65warnings.ca.gov/diesel

WARNING: This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 *et seq.*)



WARNING: Cancer and Reproductive Harm
www.P65warnings.ca.gov

ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2-1974. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.



FOR ENGINE POWERED EQUIPMENT.

- 1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- 1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- 1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- 1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- 1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- 1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- 1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- 1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.



ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- 2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- 2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- 2.c. Exposure to EMF fields in welding may have other health effects which are now not known.
- 2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
 - 2.d.1. Route the electrode and work cables together - Secure them with tape when possible.
 - 2.d.2. Never coil the electrode lead around your body.
 - 2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
 - 2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.
 - 2.d.5. Do not work next to welding power source.



ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:

- Semiautomatic DC Constant Voltage (Wire) Welder.
 - DC Manual (Stick) Welder.
 - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
 - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
 - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
 - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
 - 3.g. Never dip the electrode in water for cooling.
 - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
 - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
 - 3.j. Also see Items 6.c. and 8.



ARC RAYS CAN BURN.



- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



FUMES AND GASES CAN BE DANGEROUS.



- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer’s instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer’s safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.



WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 022690-9101.
- 6.j. Do not use a welding power source for pipe thawing.



CYLINDER MAY EXPLODE IF DAMAGED.



- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
 - Away from areas where they may be struck or subjected to physical damage.
 - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



FOR ELECTRICALLY POWERED EQUIPMENT.



- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

Refer to
<http://www.lincolnelectric.com/safety>
for additional safety information.

TABLE OF CONTENTS

	Page
Installation	
General Description	1
Required Accessories for 120V/1/60 & 230V/1/50/60 Input Power:	1
Technical Specifications	1
Installation of Wall Mounting Brackets	3
Installation of SF2400 Stationary Fan With LFA 3.1 Or 4.1 Extraction Arm	4
Installation of SF2400 Stationary Fan With LTA 2.0 Telescopic Extraction Arm	6
Installing The Starter/Overload Switch	7
Operation	
Operating Instructions	8
Maintenance	
Routine Maintenance	8
Troubleshooting	
Troubleshooting Guide	9
Wiring Diagrams	10
Parts List	parts.lincolnelectric.com
Content/details may be changed or updated without notice.	
For most current Instruction Manuals, go to parts.lincolnelectric.com	

GENERAL DESCRIPTION

The SF2400 Stationary Fan provides low vacuum, high volume airflow for fume extraction and ventilation applications. It is intended for use with large diameter (6-8 in.) flexible arms or hoods and is most commonly paired with a Lincoln Electric LFA 3.1 (10 ft.) or LFA 4.1 (13 ft.) spring-balanced, articulated arm. The LTA 2.0 Telescopic Arm (length varies from 3 to 4.5 ft.) is a popular choice for small booth or workstation applications.

Extracted air can be vented to the outside through an Air Exhaust Silencer or filtered through a wall-mounted filtration unit such as the Statiflex® 200-M.

Operation of the SF2400 Stationary Fan is controlled using the Starter/Overload Switch or the Lamp Kit with Arc Sensor. The Starter/Overload Switch allows the operator to manually turn the SF2400 Stationary Fan on and off and protects the fan motor against overcurrent. The Lamp Kit with Arc Sensor includes a lamp for illuminating the work piece, hood-mounted on/off switches for the lamp and extraction fan, motor overload protection, and an arc sensor for automatic operation of the extraction fan.

REQUIRED ACCESSORIES FOR 120V/1/60 INPUT POWER:

K1494-2 STARTER/OVERLOAD SWITCH

REQUIRED ACCESSORIES FOR 230V/1/50/60 INPUT POWER:

K1494-3 STARTER/OVERLOAD SWITCH

Available Equipment:

- K1655-8 LFA 3.1, 10 ft. Extraction Arm
- K1655-9 LFA 4.1, 13 ft. Extraction Arm
- K1655-10 LTA 2.0, Telescopic Extraction Arm
- K1655-12 LFA 2.0, 6 ft. Extraction Arm
- K1655-13 LFA 4.1-LC, Low Ceiling 13 ft. Extraction Arm
- K1534-2 Air Exhaust Silencer

TECHNICAL SPECIFICATIONS

GENERAL		
PRODUCT NUMBER	K1656-9	K2497-13
INPUT POWER	115V, 1Ph, 60Hz	230V, 1Ph, 50Hz
RATED CURRENT DRAW	9.4A	4.7A
HORSEPOWER	1HP (0.75 kW)	
SOUND LEVEL	69 dB(A)	
WEIGHT	28 lbs. (14 kg)	

AMBIENT CONDITIONS	
MINIMUM TEMPERATURE	41°F (5°C)
MAXIMUM TEMPERATURE	113°F (45°C)
MAXIMUM RELATIVE HUMIDITY	80%

NOTE: Technical specifications are subject to change without prior notice. Specifications and guarantees are valid only when specified spare parts and filters are used.

FIGURE 1 – DIMENSIONS

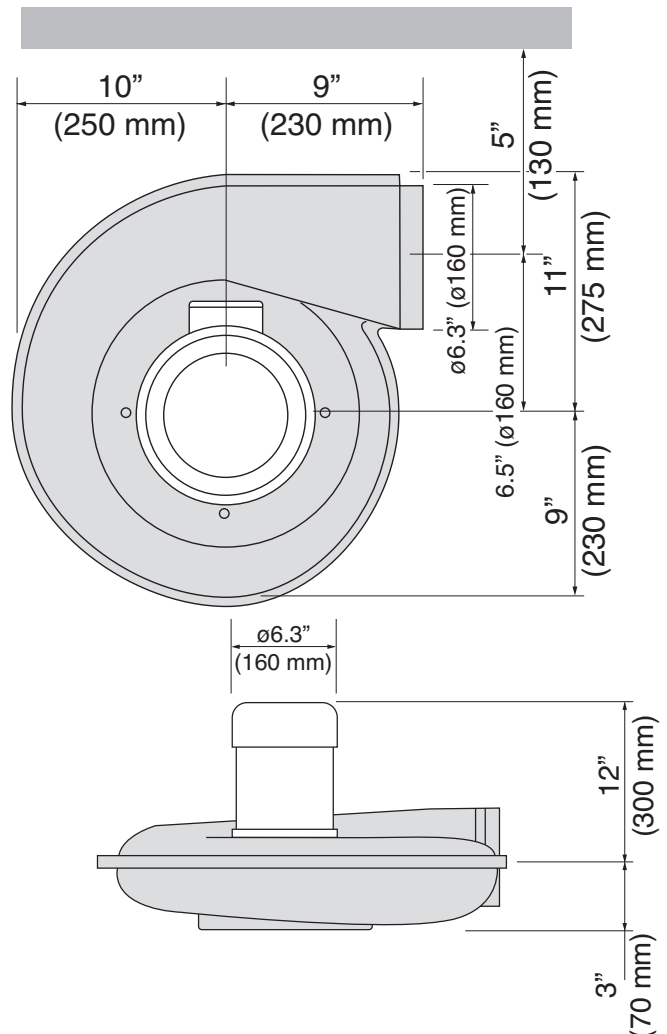


FIGURE 2 – PRESSURE DROP
SF2400 FAN AND LFA 3.1/4.1 ARMS

Vacuum (inches WG) vs. Airflow (CFM)

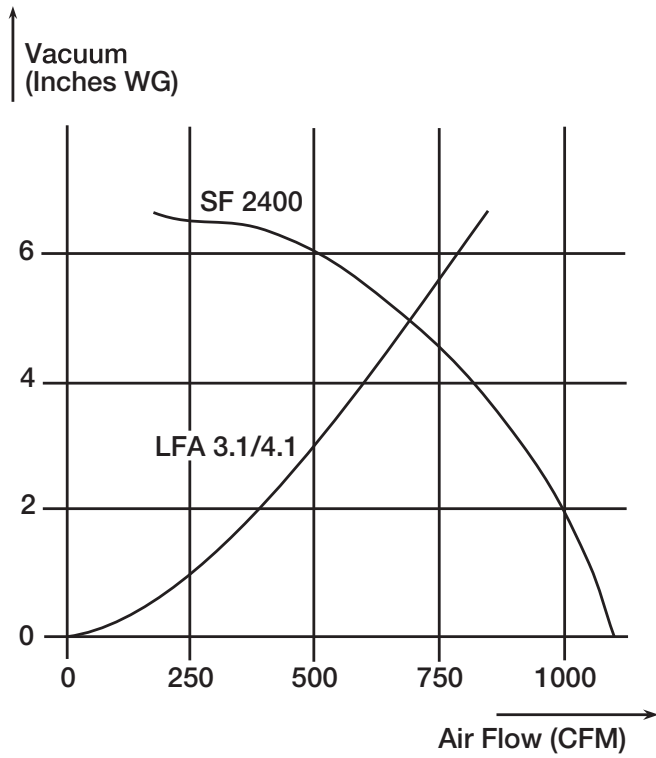
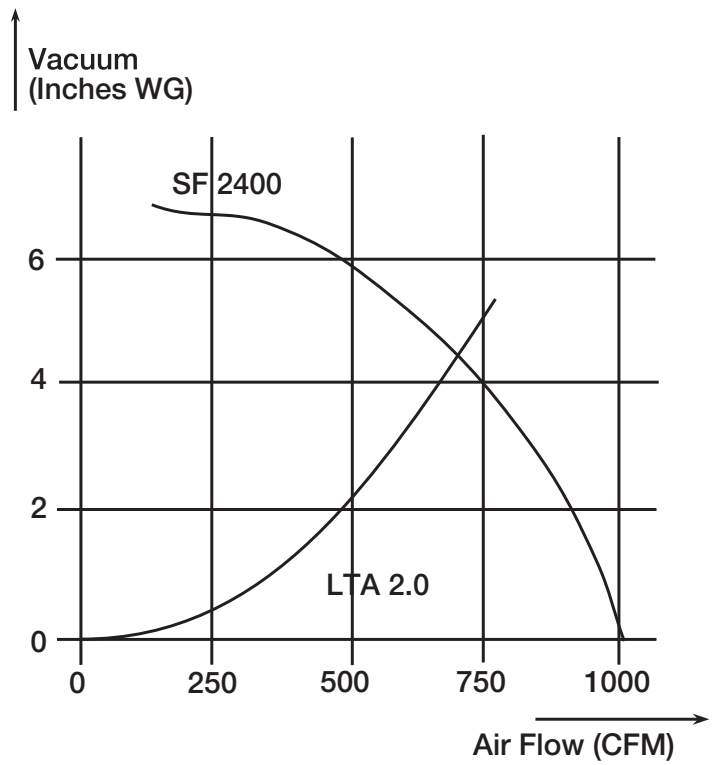


FIGURE 3 – PRESSURE DROP
SF2400 FAN AND LTA 2.0 ARM

Vacuum (inches WG) vs. Airflow (CFM)



INSTALLATION OF WALL MOUNTING BRACKETS



WARNING

The installer is responsible for following Federal, State and Local safety codes and regulations.

Before drilling, verify locations of existing gas, water, or electrical conduits.

ELECTRIC SHOCK can kill.

- Do not touch electrically live parts such as internal wiring.
- Turn the input power off at the fuse box before working on this equipment.
- Have a qualified person install and service this equipment.



MOVING PARTS can injure.

- Do not operate with covers open or filter removed.
- Keep away from moving parts.



ONLY QUALIFIED PERSONNEL SHOULD INSTALL, USE OR SERVICE THIS EQUIPMENT.

K1657-1 Wall Mounting Bracket kit includes:

- (2) Bracket pieces
- Hanging Adapter
- Spring Bracket
- Flexible Hose
- (2) Bolts, M8x1.25, about 1.75" (45mm) long
- (4) Bolts, M8x1.25, about 3.00" (75mm) long
- (6) Nuts, Self-Locking, M8
- (6) Washers, M8

K1657-2 Wall Mounting Bracket kit includes:

- (2) Bracket pieces
- Tapered connection flange
- Hose Clamp, 8" (203mm)

NOTE:

Starter/Overload Switch must be installed with this package. See the installation section later in this manual for details on installing this equipment.

K1494-2 STARTER/OVERLOAD SWITCH FOR 120V

K1494-3 STARTER/OVERLOAD SWITCH FOR 230V

Standard mounting height is approximately 8 ft., 2 in. from the floor to the top of the wall mounting bracket. See Figure 4 for drilling dimensions.

See Figure 5 for recommended mounting methods for installation on various wall types.

- Mounting on a thin wall (recommended minimum wall thickness 5 in. (100 mm), using four threaded rods, 3/8 in. (M10).
- Mounting on a thick wall using four cotter bolts 3/8 in. (M10).
- Mounting on a steel I-beam using four threaded rods 3/8 in. (M10) and two box-profile stabilizers (1x1x0.1 in., 30x30x3mm).

FIGURE 4

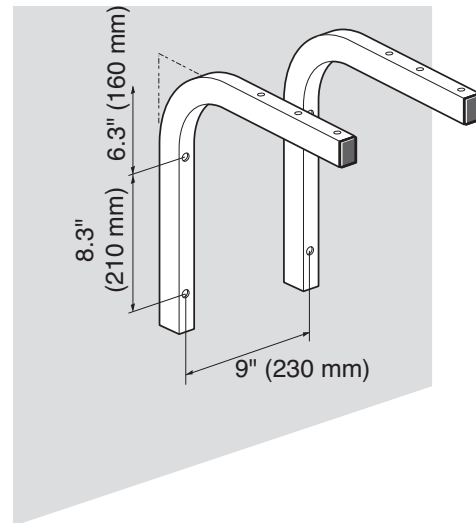
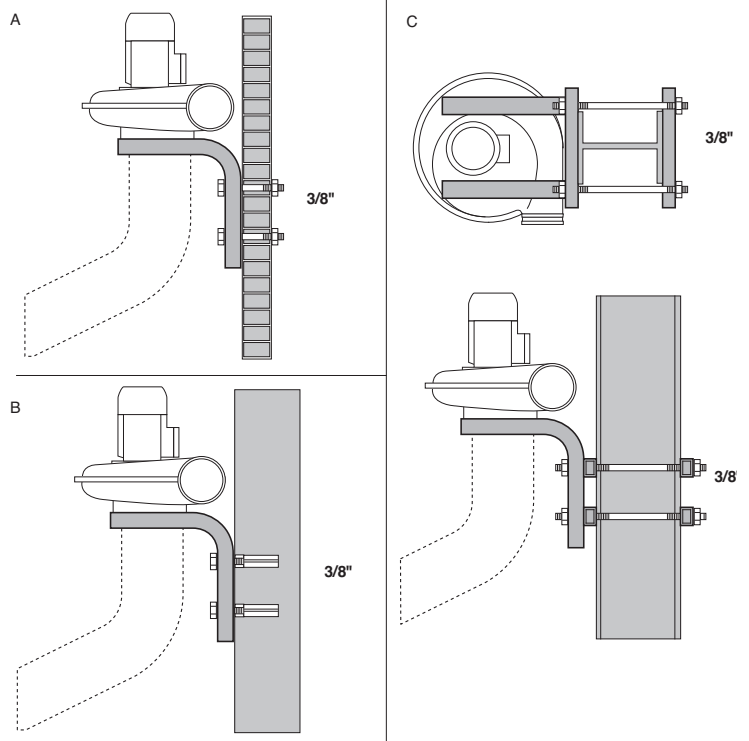


FIGURE 5



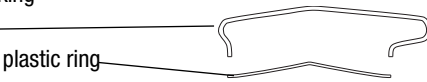
INSTALLATION OF SF2400 STATIONARY FAN WITH LFA 3.1 OR 4.1 EXTRACTION ARM

K1656-9 SF2400 Stationary Fan Includes:

- SF2400 Stationary Fan
- (2) Bolts, M8x1.25, about 0.75" (20mm) long
- (2) Bolts, M8x1.25, about 2.5" (65mm) long
- (4) Washers, M8

K1655-8 LFA 3.1 or K1655-9 LFA 4.1 Arm includes:

- Assembled arm, 2 sections
- Flexible hose, (2) 8" Rubber seals for hood hinge
- Hood assembly
- (2) Bolts, M8x1.25, about 1.75" (45mm) long
- (2) Nuts, M8 self-locking
- Hose running guard
- Clamping pin for red plastic ring
- Metal rotating hinge
- Red plastic ring



Install mounting brackets as detailed in the section titled "INSTALLATION OF WALL MOUNTING BRACKETS"

Mounting the Extraction Arm

Leave the tape and plastic packaging on the extraction arm sections until the arm is completely installed (including mounting the hood). The arm is spring-balanced to compensate for the weight of the hood and will spring out quickly if it is not mounted securely, with the hood in place.

The rotating hinge of the arm comes in three pieces: Metal rotating hinge, red plastic ring, and clamping pin. See Figure 6. Mount the red plastic ring to the metal rotating hinge by fitting the clamping pin through the hole in the rotating rod, and snapping it into place on the U-shaped indents on the red plastic ring. The lip of the ring should fit securely against the top edge of the rotating flange, yet rotate with the rod. The assembly should look like Part C in Figure 7.

Position the rotating hinge on the wall mounting bracket (See Figure 7) so that the cable hole (Item A) is on the wall side and the long side of the pin (Item B) is in the front. Use the four 3" bolts with washers and nuts supplied with the wall mounting brackets to secure the rotating hinge.

SEE THE LFA 3.1 AND 4.1 EXTRACTION ARMS OPERATOR'S MANUAL FOR DETAILS ON COMPLETING THE INSTALLATION OF THE ARM.

FIGURE 6

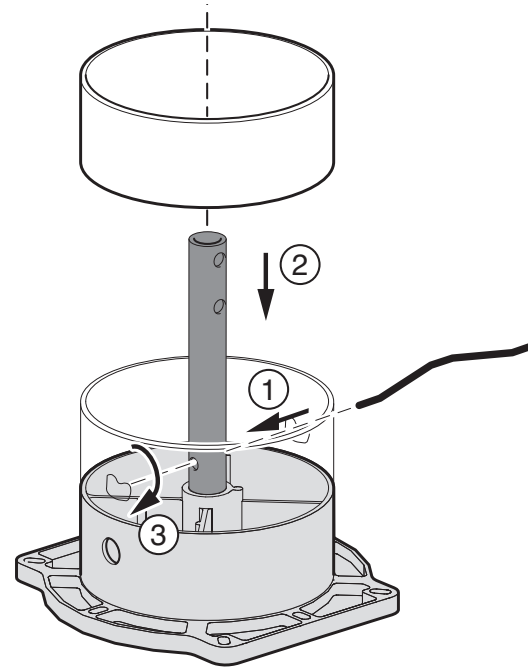
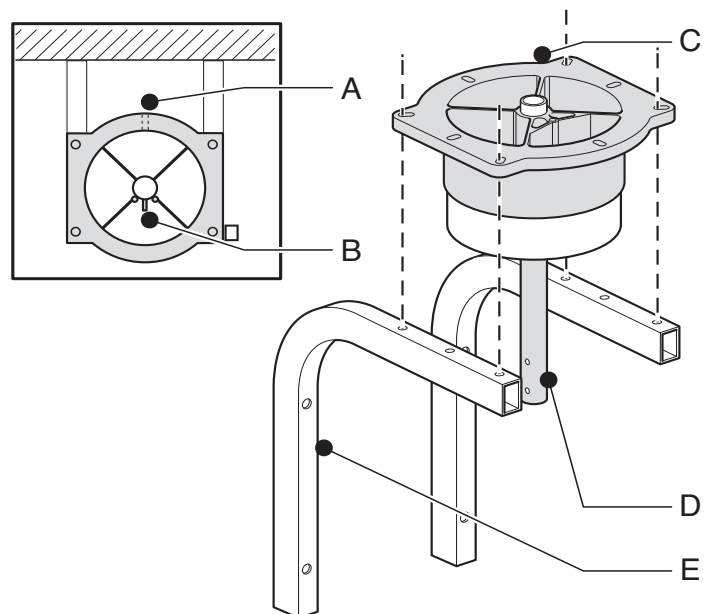
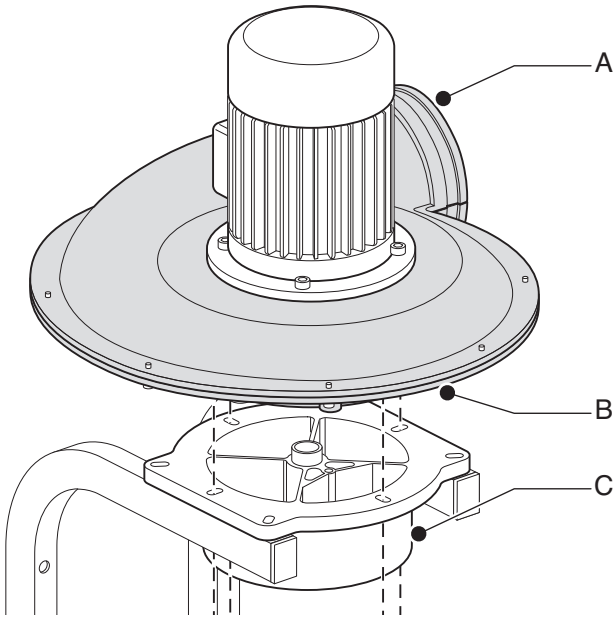


FIGURE 7



Mounting the SF2400 Fan

Use the (2) 0.75" bolts and the (2) 2.5" bolts with washers supplied with the fan to mount the fan (See Figure 8, Item B) to the rotating hinge (See Figure 8, Item C) as shown. Tighten all mounting bolts firmly to make the seal at the inlet of the fan.

FIGURE 8

**SEE INSTALLING THE STARTER/OVERLOAD SWITCH
AND INSTALLING THE OPTIONAL LAMP KIT AND
AUTOMATIC START/STOP ARC SENSOR.**

INSTALLATION OF SF2400 STATIONARY FAN WITH LTA 2.0 TELESCOPIC EXTRACTION ARM

K1656-9 SF2400 Stationary Fan Includes:

- SF2400 Stationary Fan
- (2) Bolts, M8x1.25, about 0.75" (20mm) long
- (2) Bolts, M8x1.25, about 2.5" (65mm) long
- (4) Washers, M8

K1655-10 LTA 2.0 Telescopic Extraction Arm includes:

- Telescopic Arm, Assembled
- Flexible hose, (2) 8" Rubber seals for connection to fan

Install wall mounting brackets as detailed in the section titled "INSTALLATION OF WALL MOUNTING BRACKETS"

Position the tapered connection flange (See Figure 9, item C) on the wall mounting brackets. Use the (2) 0.75" long and (2) 2.5" long bolts with washers supplied with the fan to secure the SF2400 Stationary Fan (See Figure 9, item B) and the tapered connection flange to the wall mounting brackets. Tighten all bolts securely to make a good seal on the inlet of the fan.

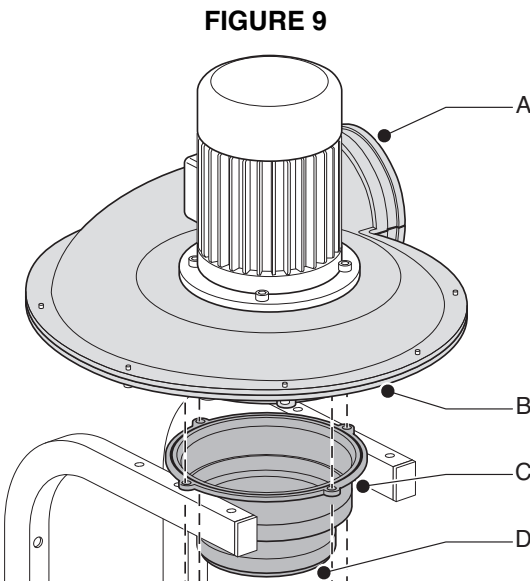


FIGURE 9

Position one of the 8" rubber seals supplied with the LTA 2.0 Telescopic Arm on the largest part (8" diameter) of the tapered connection flange. Roll the bottom of the rubber seal up, and slide one end of the 4 ft. flexible hose (supplied with the arm) up over the tapered connection flange until it butts up against the folded side of the rubber seal. Fold the rubber seal down over the hose.

Secure the connection with one 8" hose clamp. Apply the second 8" rubber seal and the other end of the flexible hose to the top of the telescopic arm tube.

SEE THE LTA 2.0 TELESCOPIC EXTRACTION ARM OPERATOR'S MANUAL FOR DETAILS ON COMPLETING THE INSTALLATION OF THE ARM.

INSTALLING WITH OPTIONAL STATIFLEX 200-M

The Statiflex 200-M Wall-Mounted Filter Unit can be installed to filter the exhausted air before it is recirculated or exhausted outside.

The K1654-4 Statiflex 200-M Filter Unit Includes:

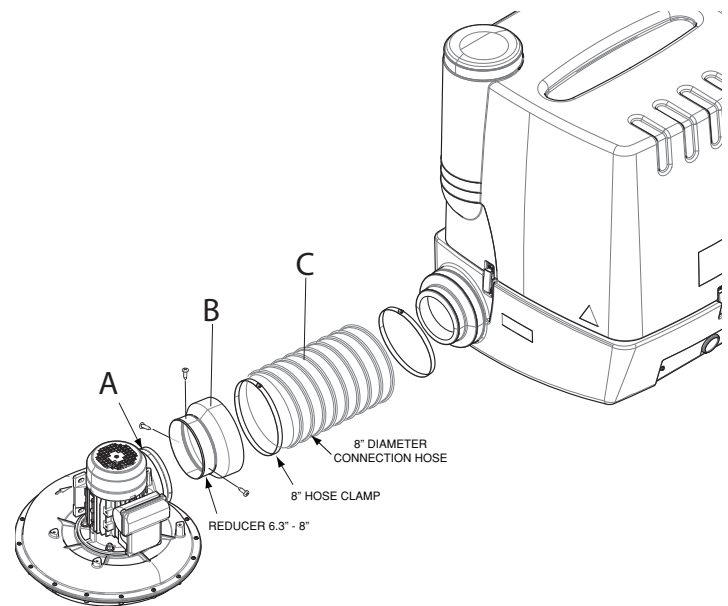
- Complete Filter Unit, with filter installed and inlet(s) and outlet(s) sealed
- Reducer, 6"-8"
- 8" Connection hose, 4 ft. long
- (2) 8" Hose Clamps

Fit the small (6" diam.) side of the 6"-8" Reducer (See Figure 10, item B) over the outlet of the SF2400 Fan (See Figure 10, item A); be sure to slide the Reducer all the way over the rubber seal. Secure with three sheet-metal screws through the reducer into the plastic-molded fan outlet.

Fit one end of the 8" Connection hose (See Figure 10, item C) over the larger side of the 6"-8" Reducer. Secure with one 8" hose clamp.

SEE STATIFLEX 200-M MANUAL FOR COMPLETION OF THE INSTALLATION PROCEDURE.

FIGURE 10



INSTALLING THE STARTER/OVERLOAD SWITCH

120V ARRANGEMENT

The K1494-2 Starter/Overload Switch is used for manual operation of the SF2400 Stationary Fan. The Starter/Overload Switch is not required if using a K1669-4 Lamp Kit with Arc Sensor.

Mount the Starter/Overload Switch to a wall in a location convenient to the operator.

Route a 120VAC, 1ph, 60hz supply cable into the switch compartment and a power cable between the switch and the SF2400 Stationary Fan. Have a qualified electrician make connections per the wiring diagram located in the diagram section of this manual. Set the overload to 10.0A.

230V ARRANGEMENT

The K1494-3 Starter/Overload Switch is used for manually operation SF2400 Stationary Fan. The Starter/Overload Switch is not required if using a K1669-4 Lamp Kit with Arc Sensor. The K1750-1 230V Conversion Kit adapts the Lamp Kit with Arc Sensor for operation on 230V.

- Mount the Starter/Overload Switch to a wall in a location convenient to the operator.
- Route a 230VAC, 1ph, 50/60hz supply cable into the switch compartment and a power cable between the switch and the SF2400 Stationary Fan. Have a qualified electrician make connections per the wiring diagram located in diagram section of this manual.

Connection changes are necessary to properly operate the fan motor on 230V/1ph. Refer to the connection diagram on motor nameplate.

OPERATING INSTRUCTIONS

Use the wall-mounted starter/overload switch or the hood-mounted remote switch (if a lamp kit is installed) to turn on the SF2400 Stationary Fan.

Position hood within 10-15 inches (250-400 mm) of the arc.

If using a Lamp Kit:

- **The switch on the hood with a lamp symbol operates the work lamp in the hood.**
- **The 0/1 switch operates the SF2400 Fan.**

If using an Auto Start/Stop Arc Sensor:

Leave the 0/1 switch in the 0 (off) position. The arc sensor will automatically switch the fan on when it senses an arc. Standard run-out time is approximately 20 sec. The work lamp operates independently of this sensor.

ROUTINE MAINTENANCE

Every 12 months, have a qualified technician check the blower fan and housing for encrusted particles and clean if necessary. Check the sealing material of the extraction fan and replace if necessary.

If used, refer to the Statiflex 200-M, Extraction arm, Extension crane, Lamp kit, and Auto start/stop arc sensor manuals for required routine maintenance operations.

TROUBLESHOOTING GUIDE



Service and Repair should only be performed by Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid ELECTRICAL SHOCK, please observe all safety notes and precautions detailed throughout this manual.

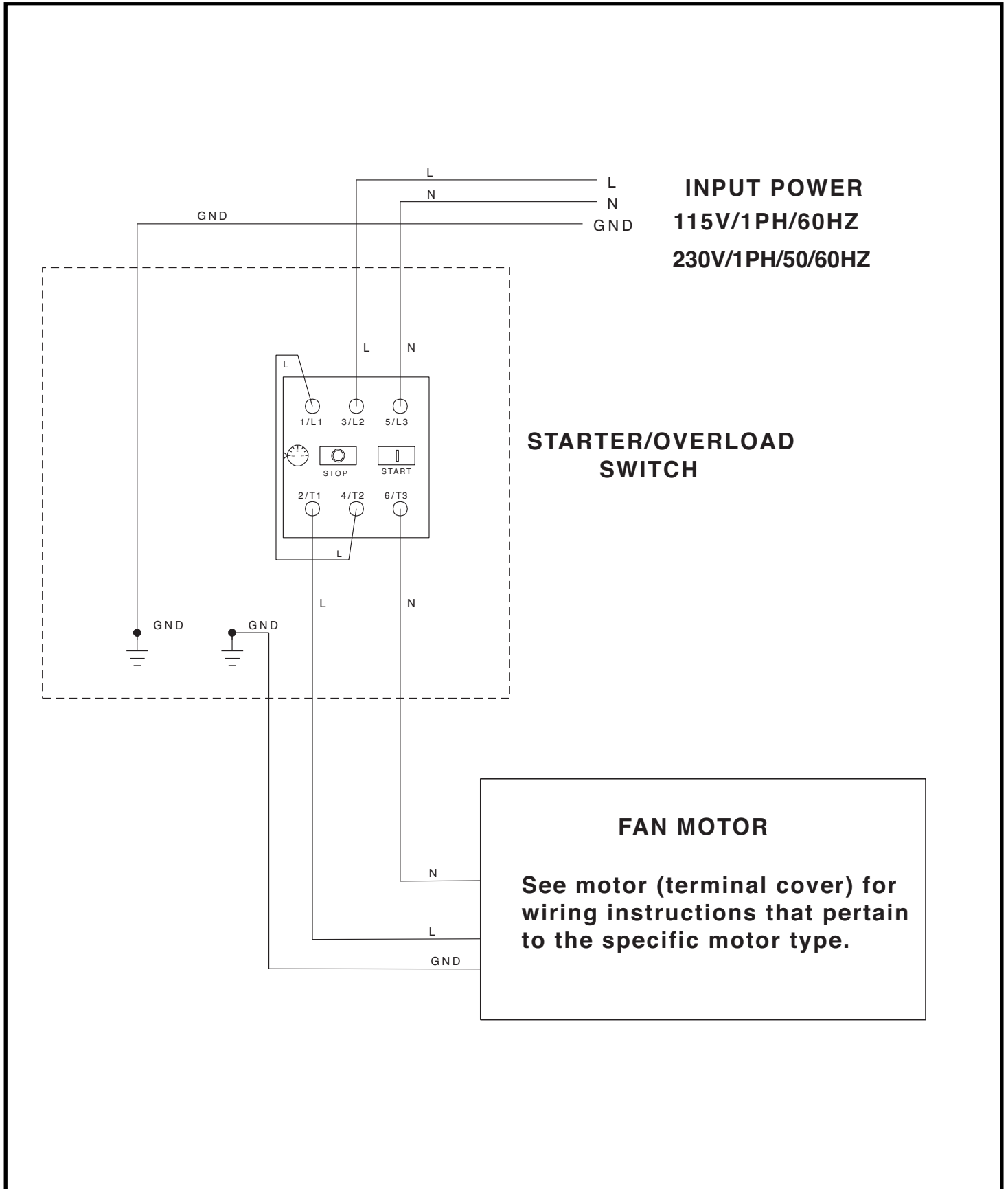
PROBLEMS / SYMPTOM(S)	POSSIBLE CAUSE(S)	RECOMMENDED COURSE(S) OF ACTION
MOTOR DOES NOT START.	No input power.	Verify 120VAC/60Hz, 1ph or 230VAC/50/60Hz, 1ph input power at the machine
	Input cord maybe damaged.	Check the integrity of the input cord
	Loose Contacts	Check the contacts.
	Starter/overload switch damaged or defective.	Contact Lincoln Authorized Service Facility
	Motor maybe damaged or defective.	Contact Lincoln Authorized Service Facility
MOTOR HUMS, BUT NO SUCTION.	Motor capacitor defective or not connected.	Contact Lincoln Authorized Service Facility
MOTOR STOPS AUTOMATICALLY	Motor overload protection activated.	Let the machine cool down for a few minutes.
	Motor defective or damaged	Contact Lincoln Authorized Service Facility
POOR SUCTION.	Leakage.	Check hose connections and integrity.
	Outlet grid blocked.	Remove obstructions from outlet grid.
	Air path in arm blocked.	Remove obstructions from arm.
	Filter blocked (check Maintenance Indicator).	Replace filter.
	Spark arrester blocked.	Clean the spark arrester.
	Blower fan blocked.	Clean excess fume or spatter from fan.
	Fan seal damaged.	Check or replace sealing material of fan.
DUST OR SMOKE COMING OUT OF OUTLET.	Filter damaged, or not seated correctly.	Replace the filter or reseal it.
VIBRATIONS IN THE MACHINE.	Imbalance in the fan.	Clean excess dirt from fan.



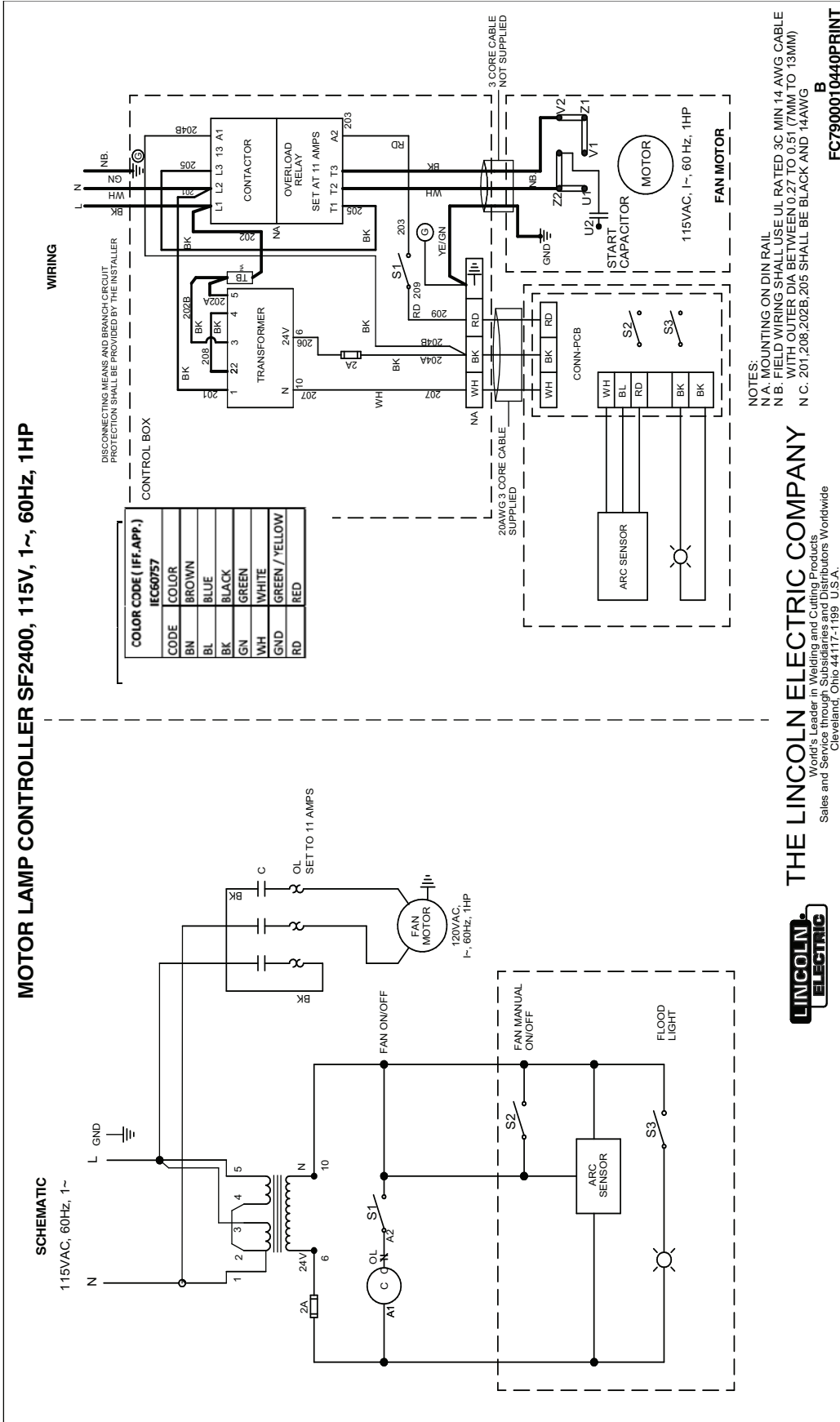
If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

WWW.LINCOLNELECTRIC.COM/LOCATOR

WIRING DIAGRAM FOR SF2400 FAN WITH K1494-2 STARTER/OVERLOAD SWITCH

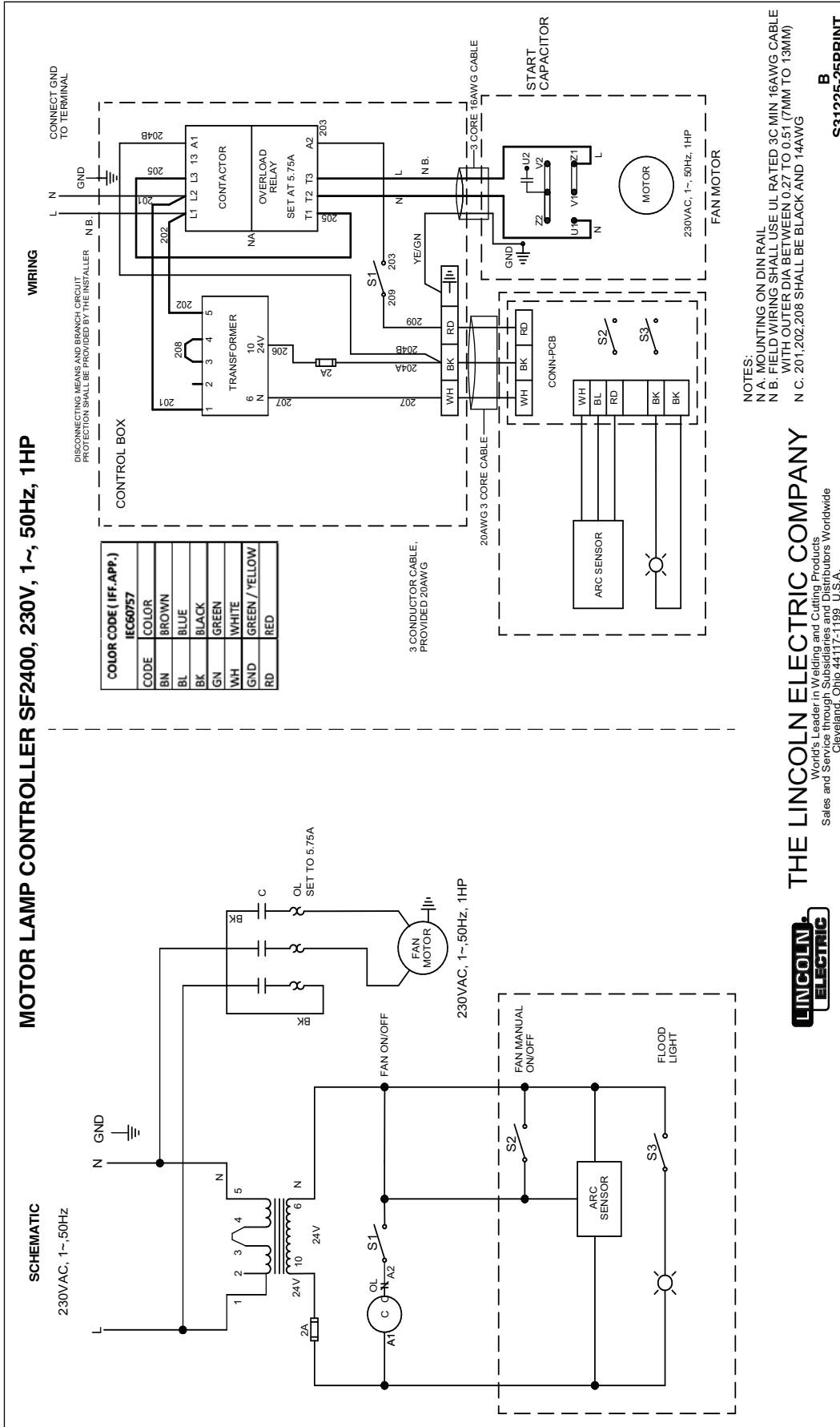


WIRING DIAGRAM FOR SF2400 FAN WITH K1669-4 LAMP KIT



NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.

WIRING DIAGRAM FOR SF2400 FAN WITH K1750-1 CONVERSION KIT



NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.



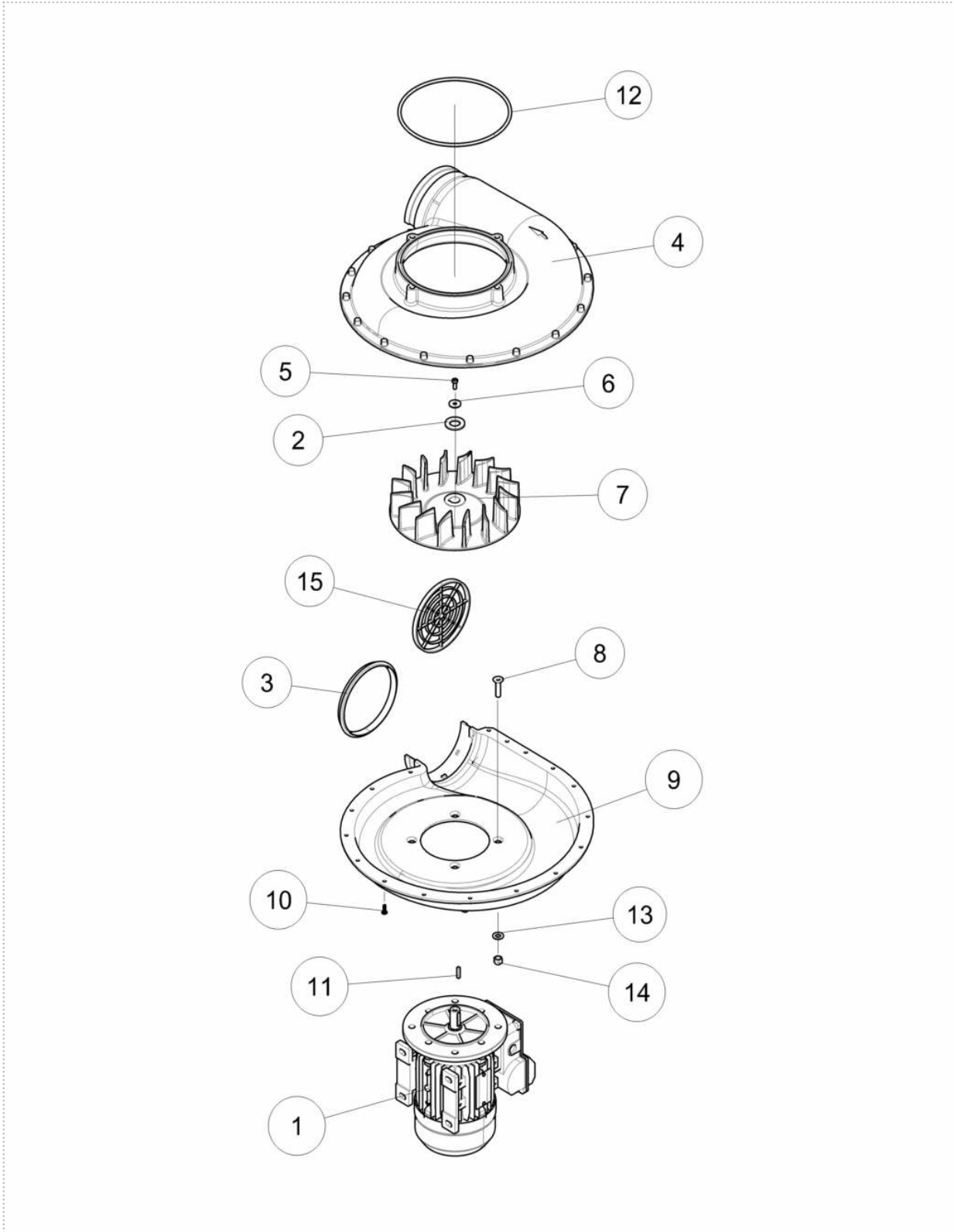
Service Navigator 2.0

SF2400 Stationary Fan - K1656-9

General Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
1	9SS31229-9	MOTOR 1HP 115/230V 1P 50/60HZ	1
2	9SS9262-26	PLAIN WASHER	1
3	9SFC0401102030	SEALING RING	1
4	9SS31229-4	FAN HOUSING INLET SIDE	1
5	9ST14731-38	METRIC HEX HD SCREW-M6 X1.0	1
6	9SS9262-69	PLAIN WASHER	1
7	9SFC0708020150	FAN WHEEL 60HZ	1
8	9SS31229-19	3/8-16 UNC X 1.50 SOCKET FHCS	4
9	9SS31229-5	HOUSING MOLDED MOBIFLEX MOTOR SIDE	1
10	9SFC0000101033	SCREW TORX BUTTON HEAD FLANGE	17
11	9SM8776-6	KEY	1
12	9SFC0401060040	GASKET	1
13	9SS9262-120	PLAIN WASHER	4
14	9ST9187-10	3/8-16HLN-1817/1-NYLON INSERT	4
15	9SS31224-41	INLET GRID TOP	1
	9SM16196	DECAL-WARNING	1

General Assembly



P-955-C.jpg

THIS PAGE INTENTIONALLY LEFT BLANK



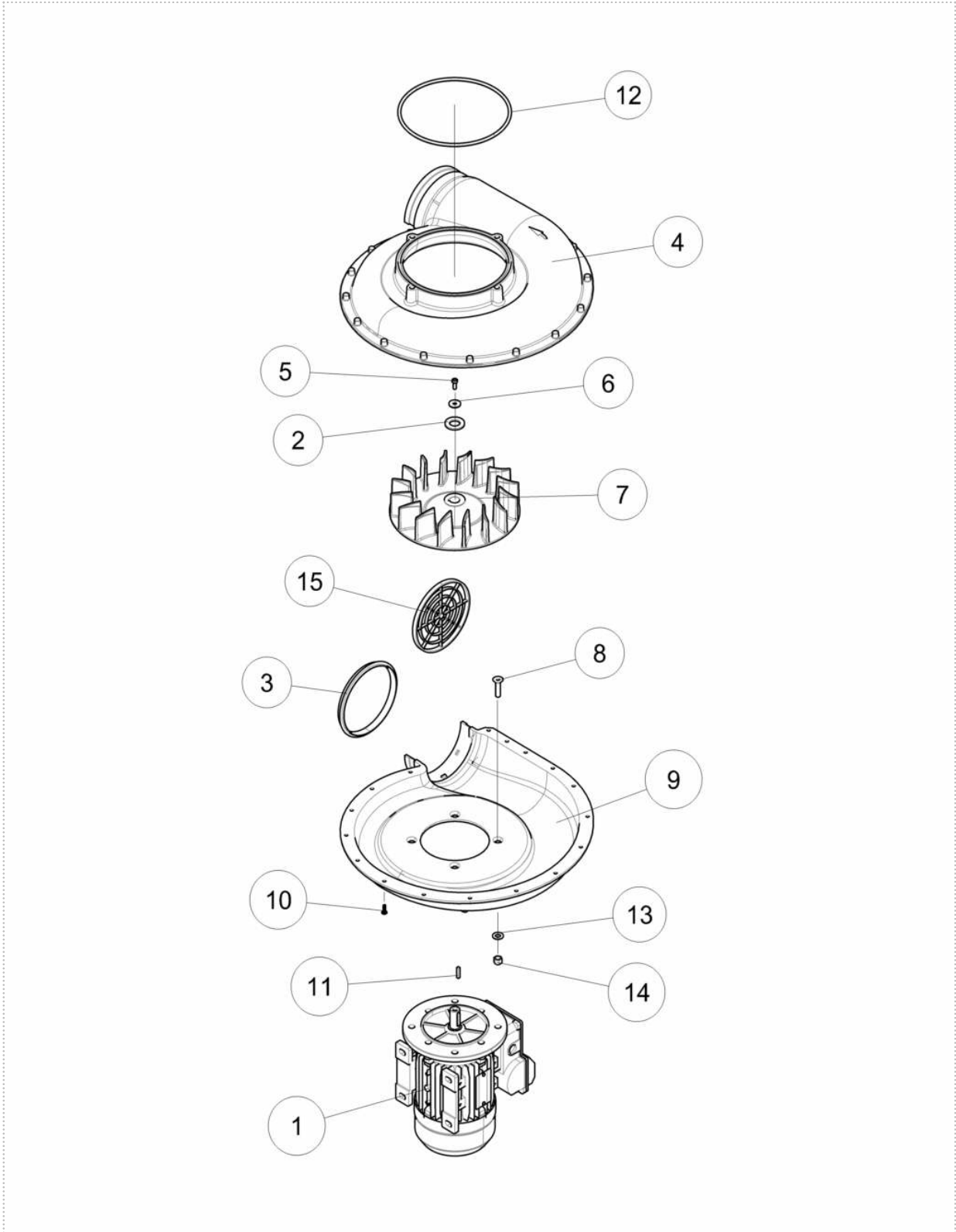
Service Navigator 2.0

SF2400 Stationary Fan, 230/1/50 - K2497-13

General Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
1	9SS31229-9	MOTOR 1HP 115/230V 1P 50/60HZ	1
2	9SS9262-26	PLAIN WASHER	1
3	9SFC0401102030	SEALING RING	1
4	9SS31229-4	FAN HOUSING INLET SIDE	1
5	9ST14731-38	METRIC HEX HD SCREW-M6 X1.0	1
6	9SS9262-69	PLAIN WASHER	1
7	9SFC0708020140	FAN WHEEL 50HZ	1
8	9SS31229-19	3/8-16 UNC X 1.50 SOCKET FHCS	4
9	9SS31229-5	HOUSING MOLDED MOBIFLEX MOTOR SIDE	1
10	9SFC0000101033	SCREW TORX BUTTON HEAD FLANGE	17
11	9SM8776-6	KEY	1
12	9SFC0401060040	GASKET	1
13	9SS9262-120	PLAIN WASHER	4
14	9ST9187-10	3/8-16HLN-1817/1-NYLON INSERT	4
15	9SS31224-41	INLET GRID TOP	1
	9SM16196	DECAL-WARNING	1

General Assembly



P-959-C.jpg

			
WARNING	<ul style="list-style-type: none"> ● Do not touch electrically live parts or electrode with skin or wet clothing. ● Insulate yourself from work and ground. 	<ul style="list-style-type: none"> ● Keep flammable materials away. 	<ul style="list-style-type: none"> ● Wear eye, ear and body protection.
Spanish AVISO DE PRECAUCION	<ul style="list-style-type: none"> ● No toque las partes o los electrodos bajo carga con la piel o ropa mojada. ● Aíslese del trabajo y de la tierra. 	<ul style="list-style-type: none"> ● Mantenga el material combustible fuera del área de trabajo. 	<ul style="list-style-type: none"> ● Protéjase los ojos, los oídos y el cuerpo.
French ATTENTION	<ul style="list-style-type: none"> ● Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension. ● Isolez-vous du travail et de la terre. 	<ul style="list-style-type: none"> ● Gardez à l'écart de tout matériel inflammable. 	<ul style="list-style-type: none"> ● Protégez vos yeux, vos oreilles et votre corps.
German WARNUNG	<ul style="list-style-type: none"> ● Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung! ● Isolieren Sie sich von den Elektroden und dem Erdboden! 	<ul style="list-style-type: none"> ● Entfernen Sie brennbares Material! 	<ul style="list-style-type: none"> ● Tragen Sie Augen-, Ohren- und Körperschutz!
Portuguese ATENÇÃO	<ul style="list-style-type: none"> ● Não toque partes elétricas e electrodos com a pele ou roupa molhada. ● Isole-se da peça e terra. 	<ul style="list-style-type: none"> ● Mantenha inflamáveis bem guardados. 	<ul style="list-style-type: none"> ● Use proteção para a vista, ouvido e corpo.
Japanese 注意事項	<ul style="list-style-type: none"> ● 通電中の電気部品、又は溶材にヒフやぬれた布で触れないこと。 ● 施工物やアースから身体が絶縁されている様にして下さい。 	<ul style="list-style-type: none"> ● 燃えやすいものの側での溶接作業は絶対にはなりません。 	<ul style="list-style-type: none"> ● 目、耳及び身体に保護具をして下さい。
Chinese 警告	<ul style="list-style-type: none"> ● 皮肤或湿衣物切勿接触带电部件及焊条。 ● 使你自已与地面和工作件绝缘。 	<ul style="list-style-type: none"> ● 把一切易燃物品移离工作场所。 	<ul style="list-style-type: none"> ● 佩戴眼、耳及身体劳动保护用具。
Korean 위험	<ul style="list-style-type: none"> ● 전도체나 용접봉을 젖은 형갑 또는 피부로 절대 접촉치 마십시오. ● 모재와 접지를 접촉치 마십시오. 	<ul style="list-style-type: none"> ● 인화성 물질을 접근시키지 마십시오. 	<ul style="list-style-type: none"> ● 눈, 귀와 몸에 보호장구를 착용하십시오.
Arabic تحذير	<ul style="list-style-type: none"> ● لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسدك أو بالملابس المبللة بالماء. ● ضع عازلا على جسمك خلال العمل. 	<ul style="list-style-type: none"> ● ضع المواد القابلة للاشتعال في مكان بعيد. 	<ul style="list-style-type: none"> ● ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.

READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.

SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.

LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.

LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.

			
<ul style="list-style-type: none"> ● Keep your head out of fumes. ● Use ventilation or exhaust to remove fumes from breathing zone. 	<ul style="list-style-type: none"> ● Turn power off before servicing. 	<ul style="list-style-type: none"> ● Do not operate with panel open or guards off. 	WARNING
<ul style="list-style-type: none"> ● Los humos fuera de la zona de respiración. ● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases. 	<ul style="list-style-type: none"> ● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio. 	<ul style="list-style-type: none"> ● No operar con panel abierto o guardas quitadas. 	Spanish AVISO DE PRECAUCION
<ul style="list-style-type: none"> ● Gardez la tête à l'écart des fumées. ● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail. 	<ul style="list-style-type: none"> ● Débranchez le courant avant l'entretien. 	<ul style="list-style-type: none"> ● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés. 	French ATTENTION
<ul style="list-style-type: none"> ● Vermeiden Sie das Einatmen von Schweißrauch! ● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes! 	<ul style="list-style-type: none"> ● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!) 	<ul style="list-style-type: none"> ● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen! 	German WARNUNG
<ul style="list-style-type: none"> ● Mantenha seu rosto da fumaça. ● Use ventilação e exaustão para remover fumo da zona respiratória. 	<ul style="list-style-type: none"> ● Não opere com as tampas removidas. ● Desligue a corrente antes de fazer serviço. ● Não toque as partes elétricas nuas. 	<ul style="list-style-type: none"> ● Mantenha-se afastado das partes moventes. ● Não opere com os painéis abertos ou guardas removidas. 	Portuguese ATENÇÃO
<ul style="list-style-type: none"> ● ヒュームから頭を離すようにして下さい。 ● 換気や排煙に十分留意して下さい。 	<ul style="list-style-type: none"> ● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切して下さい。 	<ul style="list-style-type: none"> ● パネルやカバーを取り外したままで機械操作をしないで下さい。 	Japanese 注意事項
<ul style="list-style-type: none"> ● 頭部遠離煙霧。 ● 在呼吸區使用通風或排風器除煙。 	<ul style="list-style-type: none"> ● 維修前切斷電源。 	<ul style="list-style-type: none"> ● 儀表板打開或沒有安全罩時不準作業。 	Chinese 警告
<ul style="list-style-type: none"> ● 얼굴로부터 용접가스를 멀리하십시오. ● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오. 	<ul style="list-style-type: none"> ● 보수전에 전원을 차단하십시오. 	<ul style="list-style-type: none"> ● 판넬이 열린 상태로 작동치 마십시오. 	Korean 위험
<ul style="list-style-type: none"> ● ابعء رأسك بعيداً عن الدخان. ● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها. 	<ul style="list-style-type: none"> ● اقطع التيار الكهربائي قبل القيام بأية صيانة. 	<ul style="list-style-type: none"> ● لا تشغيل هذا الجهاز اذا كانت الاغطية الحديدية الواقية ليست عليه. 	Arabic تحذير

LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有閣勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.



THE LINCOLN ELECTRIC COMPANY

22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
Phone: +1.216.481.8100 • www.lincolnelectric.com