

Service Notice Number: 20200910-2

Date: 9/15/2020

To: Domestic and International Lincoln Electric Service Departments, District Sales Offices,
 Lincoln Authorized Service Facilities

Increased Risk of Error 82 on LN-25X and ACTIV8X

Product(s) Covered:

Machine	Code #	Serial Range
LN-25X	12432, 12869, 12870, 12871, 12872, 12873, 12625	U11511XXXXX- U1200900000
ACTIV8X	12759, 12877, SPLC81518	U11808XXXXX- U1200900000

Symptoms:

LN-25X and ACTIVE8X feeders may experience a higher risk of Error 82 due to electrical noise.

Recommended Action:

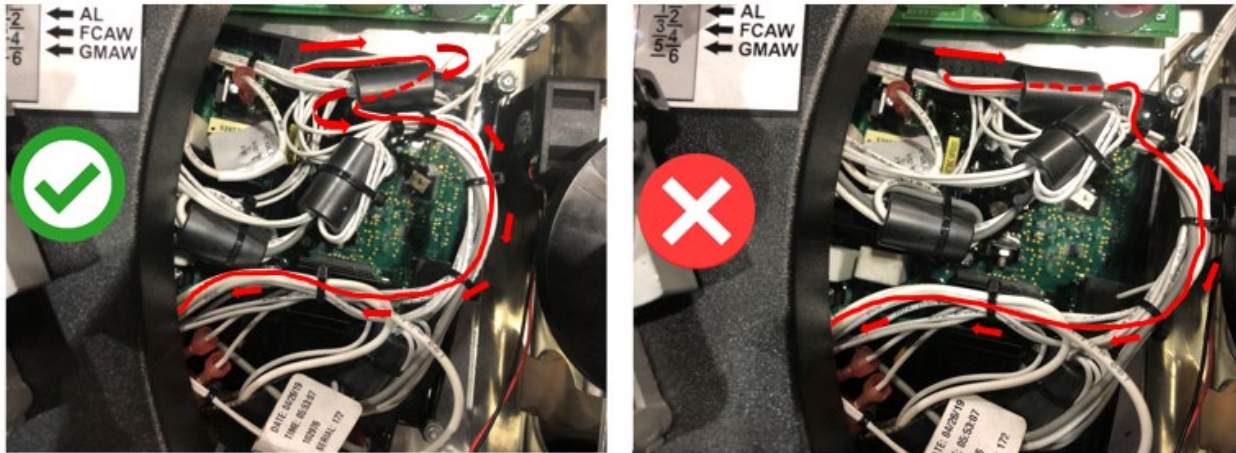
For products that fall within the serial number ranges above (“Covered Products”), check to see if the feeder has a red dot on the bottom of the feeder. If the feeder has a red dot, the unit has been repaired by the factory and no action is required.

If a Covered Product is brought in for repair, perform the below rewiring procedure and apply power to the machine. If Error 82 is present after the rewiring procedure, replace the flexible power pc board.

Repair Procedure (For LN-25X Only):

- A Molex removal tool is required for this repair (Molex Mini Fit 11-03-0044).
- Remove the wire drive assembly and control box cover to access the flexible power pc board.
- Locate wire lead 707 and disconnect it from the P6 Molex pin 8 using the Molex removal tool (note, the locking post needs to be removed first).
- Reroute wire lead 707 through the toroid containing the P1 leads 510, 511, 512, 513, 517, 518, 519. The direction does matter. See illustration of the correct routing below.

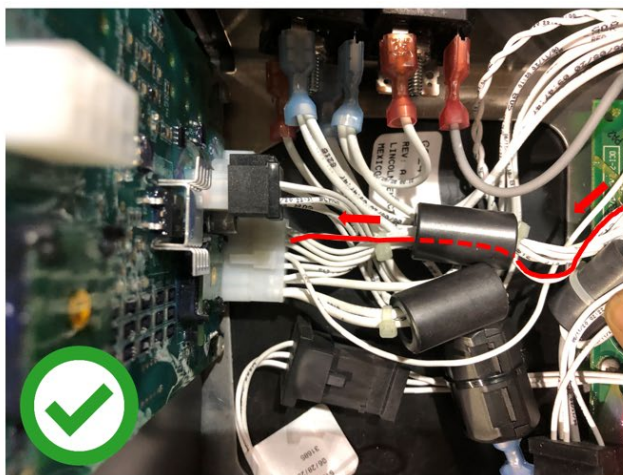
- Reconnect the wire lead 707 to the P6 Molex pin 8 and reinsert locking post.



LN-25X: Lead 707 being rerouted thru toroid. Direction arrows show routing from flexible power pc board to user interface pc board.

Repair Procedure (For Activ8X Only):

- A Molex removal tool is required for this repair (Molex Mini Fit 11-03-0044).
- Remove the case front assembly to access the user interface pc board.
- Locate the wire lead 707 and disconnect it from the J31 Molex pin 2 using the Molex removal tool.
- Reroute the wire lead 707 through the toroid (1 pass) in the same direction as the other leads in located in P31. The direction does matter.
- Reconnect the wire lead 707 to the P31 Molex pin 2 (Correct routing shown below).



Activ8X: Lead 707 being rerouted thru toroid. Direction arrows show routing from flexible power pc board to user interface pc board.

Submit a machine warranty claim on lincolnelectric.com and reference Service Notice 20200910-2. The approved repair time is 0.75 hours. If performing this procedure did not correct the Error 82, the flexible power pc board should be replaced and added to the claim.

Please contact Lincoln Electric with the subject line "SN 20200910-2" if you have any questions or need assistance. If in the United States or Canada email Service@LincolnElectric.com. If in another country contact your local Lincoln Electric Entity.

Jennifer Shafarenko
Manager, Customer Service

⚠ WARNING:

Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty.

Service and repair should only be performed by Lincoln Electric Factory Trained Personnel. If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. If in the United States or Canada Call 1-888-935-3877 or email service@lincolnelectric.com. If in another country contact your local Lincoln Electric Entity.