

A close-up photograph of a Lincoln Electric wire dispensing system. The central component is a red motorized unit with two gears visible on its front face, labeled 'LINCOLN ELECTRIC'. It is mounted on a black, textured, conical base. Various brass fittings and a white knob are attached to the top of the red unit. The background is a blurred industrial setting with a red component visible on the left.

WIRE DISPENSING AND HANDLING SYSTEMS (GMAW)

www.lincolnelectric.eu

LINCOLN[®]
ELECTRIC

Small Improvements – Big Savings

Feeding a solid wire system requires a correct setup. Accessories help to straighten the wire coming out from the drum, avoiding excessive bends, improving wire feeding performances and removing friction in the feeding system.



Drums installation

1. Remove the plastic wrapping film around drums/pallet before use (1).
 2. To avoid damages to the drums, lift them using the belts with a lifter and handle them with carts/dollies (2).
 3. The drums come with the Mexican hat inside, tool used to hold the wire inside the drum, providing correct unwinding of the wire while feeding. To use the drum, remove the wooden stick to which the start of the wire is fixed. (3).
 4. If drum will be used with plastic hood, mount the plastic hood, and pull the wire out of the quick connector that should be placed on top of the plastic hood (4).
- If drum will be used will without the plastic hood, place the quick connector on the carton cover and pull the wire out (5).
5. Attach the liner to the quick connector and pull the wire through the feeding system.



Basic Steel Wire Setup

Special attention needs to be taken in the bends of the conduit that is attached to the drum, as excessive bending will affect wire feeding performance negatively.

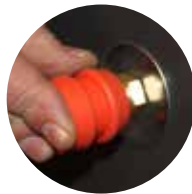
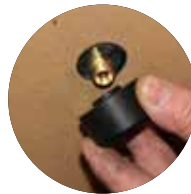
Accessories help to straighten the wire exiting the drum and avoid excessive bends, improving wire feeding performance and removing excess friction in the feeding system.

2 Connectors

Direct pull kit
AD1329-6

Cover inside

Cover outside



1 Drums and cones

Drum type	Diameter	Reference
ROUND 250/300 kg	520 mm	AD1329-576
ROUND 500 kg	670 mm	AD1329-211
ROUND 600 kg	750 mm	W000401960
GEMPAC/ALUPAC 136 kg	610 mm	AD1329-206

3 Liners

Wire diameter	Compression connectors	Liners for Mild Steel	Liners for Stainless Steel & Aluminum
0,6	AD1329-284	AD1329-620	AD1329-588
0,6-1,6	AD1329-42	AD1329-617	AD1329-591
1,6-2,4	AD1329-30	AD1329-623	AD1329-594
2,4-4,8	AD1329-29 + AD1329-38	AD1329-626	AD1329-597

Items refer to Bulk Packaging (30,5 m) – Connectors not included. Pre cut liners also available under request.

4 Liners Connectors

Wire Diameter	Compression connectors	Strain Relief Connectors
0,6	AD1329-284	–
0,6-1,6	AD1329-42	AD1329-43
1,6-2,4	AD1329-30	AD1329-31
2,4-4,8	AD1329-36 + AD1329-38	–

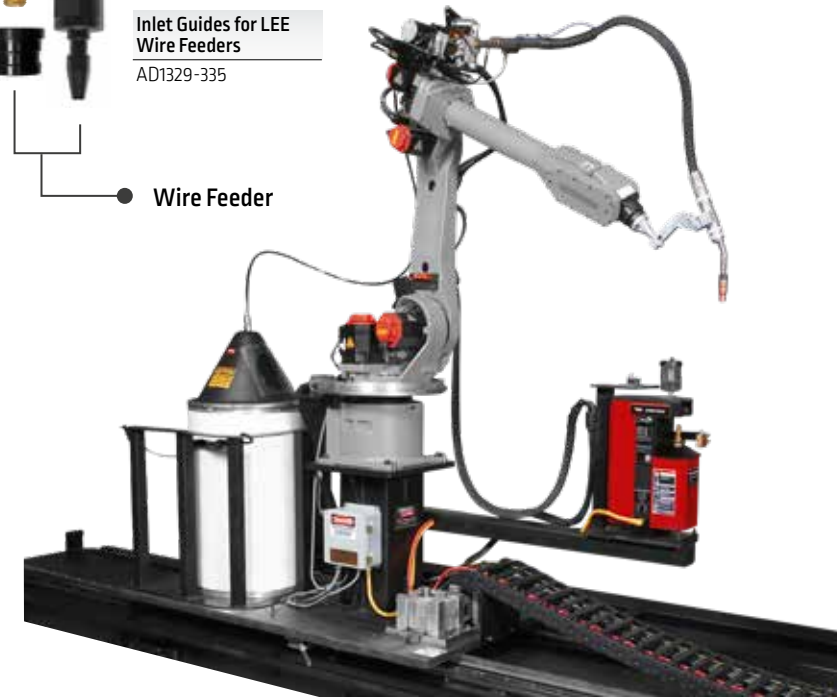
5 Feeders connectors

Inlet Guides for Wire Feeders
AD1329-559

Quick Disconnect
AD1329-578

Inlet Guides for LEE Wire Feeders
AD1329-335

Wire Feeder



1 Drums and cones

Square Drums



Round Drums



2 Connectors

Direct pull kit

Universal cone-connector fitting for 99% of applications

DIRECT PULL KIT
AD1329-6



Orbital arm kit

Developed to solve unwinding problems

ORBITAL ARM KIT
AD1329-220



3 Liners



Liners for Mild Steel

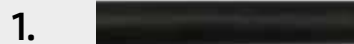
Extra Flexible Conduit

- Less contact with welding wire surface
- Minimum friction
- Smooth round edges in bends
- Easy to feed in new wire

Liners for Stainless Steel & Aluminum

Polymer Conduit

- Low friction coefficient
- Extended wear
- High durability
- Light in weight



1. Cut your conduit at the right length with a cutter or angle grinder.

Attention: do not strip it.








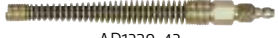









2. Push the connector onto the liner. Make sure the clamping rung is in place.



3. Tighten the connector with two wrenches.



4 Liners connectors

Wire Diameter	Liners	Compression connectors	Strain Relief Connectors	Press on	Replacement Ferrule for Compression Connectors
0,6	 AD1329-620 / AD1329-588	 AD1329-284	-	-	 AD1329-341
0,6-1,6	 AD1329-617 / AD1329-591	 AD1329-42	 AD1329-43	-	 AD1329-44
1,6-2,4	 AD1329-623 / AD1329-594	 AD1329-30	 AD1329-31	 AD1329-580	 AD1329-32
2,4-4,8	 AD1329-626 / AD1329-597	 AD1329-36+AD1329-38	-	 AD1329-526	-



Strain Relief Connectors

- Works great with feeder inlet adapters
- Prevents conduit droop and recasting of wire due to tight conduit radiuses
- Reduces stress on the quick connect points in robotic applications

5 Feeders Connectors

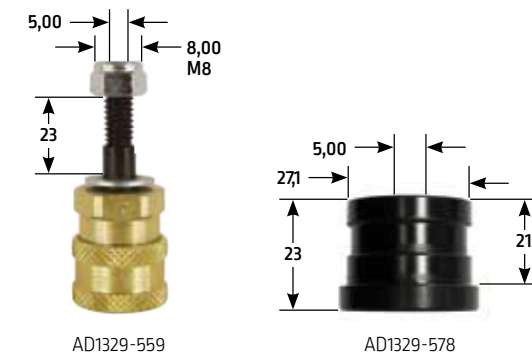
12 mm adapters

Suitable for following feeders:

- LF 22M
- LF 24M
- LF 24 PRO
- LF 52D
- LF 56D
- WF24/S
- PF 42
- PF 44
- PF 46
- DMU P400
- DMU P500
- DVU P400
- DVU P500
- DMU W 500
- DVU W500
- PF 84
- PF 84D



Other adapters



3 Liners

Basic Steel Wire Setup with PFA

Feeding a Mild Steel solid wire with a conduit length over 5 meters between the drum and the feeding unit requires a special setup. Longer Conduit lengths increase the friction force between the liner and make the wire feeding process more difficult. A wire feed assist motor together with physically constraining the conduit to avoid excessive spatial vibration can improve the feeding force required and achieve the best result.

By using the Pneumatic Feed Assist (PFA) you can bridge distances up to 30 meters.

This opens lots of opportunities to place the drum at long distance to avoid substantial loss of time by replacing and handing the drums. It is even possible to leave the drum on the the pallet and not to move it at all.

4 Liners Connectors

4

Filter/Regulator/Lubricator (included)

2 Connectors

AD1329-PFA-LM
(Drive Rolls sold separately)

Feed Assist Drive Rolls	wire (mm)
AD1329-DR035	0,9
AD1329-DR045	1,1
AD1329-DR052	1,3
AD1329-DR1/16	1,6
AD1329-574	3,2
AD1329-573	4,0

Drum Adapter Kit
AD1329-4

1 Drums and cones

Pneumatic Feed Assist

The PFA is used at those installations in which a long cable run cannot be avoid.

The air-powered motor pushes the wire to the outer corner of the conduit. The pushing-force is adjusted in a way that the motor keeps the wire at a mechanical tension. If welding starts the wire is pulled into the inner-corner which will undo the resistance and makes the air-motor run freely.

This process makes the wire float between the inner and outer corners inside the conduit.

- Works independent, NO SIGNAL NEEDED, shop air only
- Feeds wire up to 30 meters
- Works with all wires and all welding machines
- Reduces, drag, wear and arc failures
- Increases conduit life, feeder life and production

5

5 Feeders connectors

Wire Feeder

Wire Straighteners

Wire straighteners have aluminum body, insulated rollers and are made with a location calibration and a scale at the tension knob for fine adjustment.



**Small diameters
(till 1,2 mm)**

AD1329-359



**Large diameters
(from 1,6 mm)**

AD1329-361

Handling Equipment – Carts/Dollies



Round Drum Dolly

AD1329-FDD-MD (till 500 kg – 54 cm)
AD1329-192 (till 500 kg – 64 cm)
AD1329-FDD-MD-LD (till 500 kg – 76 cm)



Round Drum Cart

AD1329-194 (till 500 kg – 61 cm)

Handling Equipment – Drum Lifters



Drum lifter with safety hooks

500 kg max capacity
AD1329-11



Forklift Adapter

AD1329-12



AD1329-192

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 information or advice about their use of our products. Our employees respond to enquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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.eu for any updated information.



www.lincolnelectriceurope.com

**LINCOLN
ELECTRIC**