

# LF-72 AND LF-74 WIRE FEEDERS



Shown with options:  
See page 4 for all models



## 2-ROLL OR 4-ROLL HEAVY DUTY INDUSTRIAL FEEDERS

Designed for MIG and cored wire welding in job shop and manufacturing environments, the rugged LF-72 and LF-74 wire feeders are built to deliver reliable performance day after day.

- **Patented MAXTRAC® heavy-duty cast aluminum wire drive system** provides reliable feeding and durability.
- **Brass-to-brass gun connections** for better electrical conductivity that results in better arc performance.
- **Totally tool-less drive rolls and wire guide installation.** Two or four gear-driven wire drive rolls slide on and off easily!
- **Calibrated wire feed speed dial** for precise and accurate settings.



Two Year Extended  
Warranty Available.

### Processes »

MIG, Flux-Cored

### Applications »

Fabrication, Heavy Equipment, Job Shop

### Product Numbers »

See last page

### Output »



### Input »



### Recommended Power Sources »

CV-305, CV-400-I, CV-400, CV-500-I, CV-655, Invertec® V350-PRO, Invertec® V450-PRO, DC-400, DC-600, DC-655, Flextec power sources

### Compatible Competitive<sup>(1)</sup> Power Sources »

(requires K2335-2 competitive adapter)  
Deltaweld<sup>(1)</sup>, Dimension<sup>(1)</sup>, XMT<sup>(1)</sup> and CP302<sup>(1)</sup>

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# WHAT'S INCLUDED

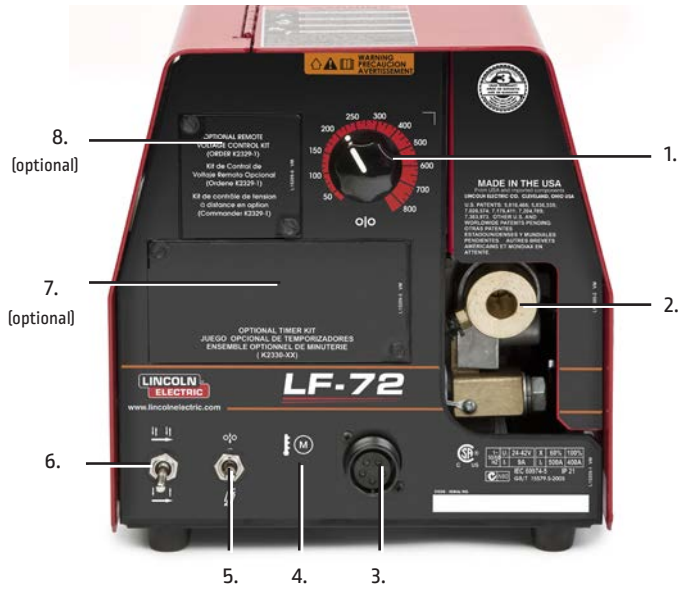
## All LF-72 and LF-74 Units Include:

- .035-.045 in. (0.9-1.2 mm) drive roll and wire guide kit.

## Select Units Include (see last page):

- 10 ft. (3.0 m) control cable with 14-pin female connector.
- 15 ft. (4.5 m) Magnum® PRO 350 gun and cable assembly with .035-.045 in. (0.9 mm-1.2 mm) liner.
- Standard duty or heavy Duty wire reel stand.

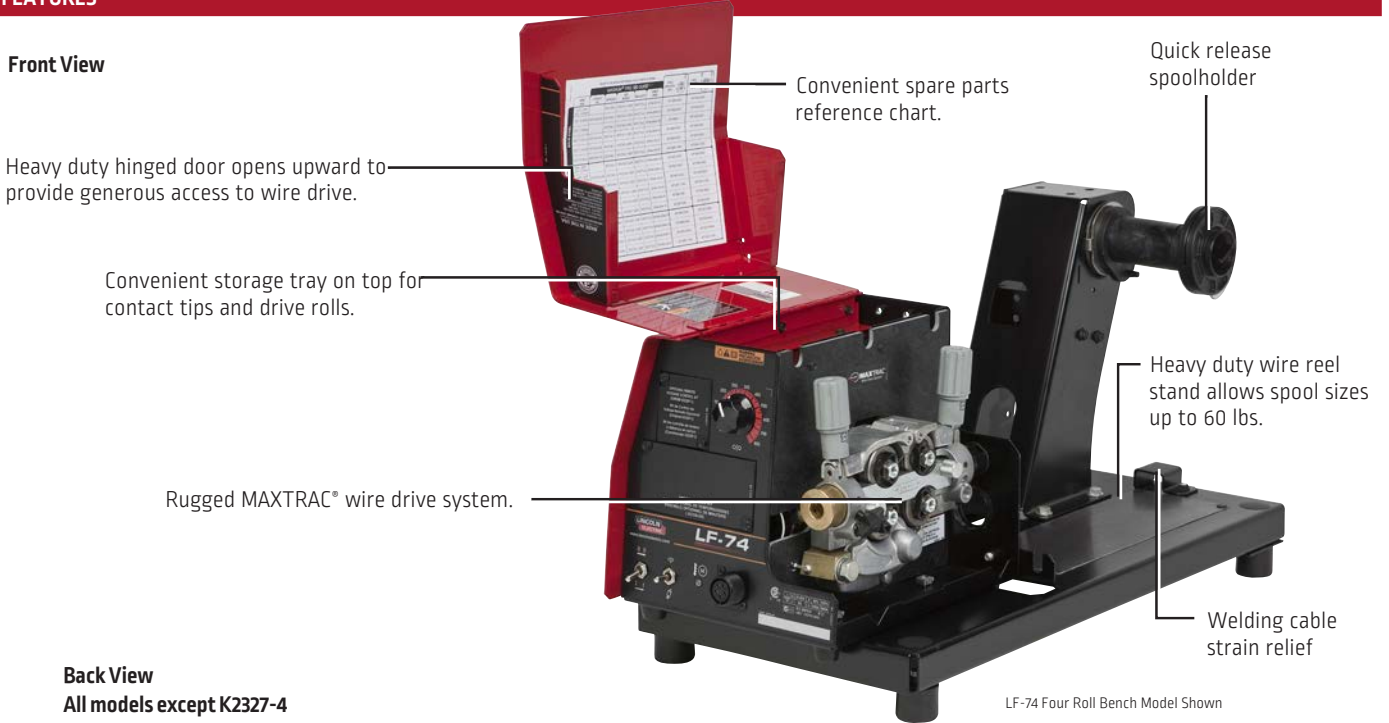
# KEY CONTROLS



- |                                    |                                    |   |
|------------------------------------|------------------------------------|---|
| 1. Calibrated Wire Feed Speed Dial | 4. Motor Thermal Protection Light  | 7. Burnback/Postflow Timer Kit (optional) |
| 2. Gun Connection (K1500-2)        | 5. Cold Feed/Gas Purge Switch      | 8. Remote Voltage Control Kit (optional)  |
| 3. 5-Pin Gun Connection            | 6. 2-Step/Trigger Interlock Switch |   |

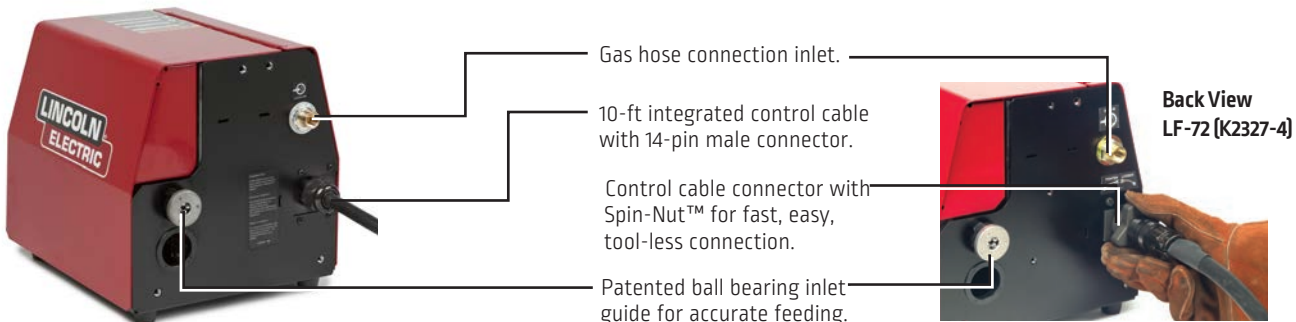
# FEATURES

## Front View



## Back View

All models except K2327-4





# MAXTRAC®

## Wire Drive System

### Patented Dual Spring Pressure Arm

- Easy turn numeric tension indicator
- Set heavy tension for solid steel and stainless steel wire
- Set moderate tension for cored wires
- Set soft tension for aluminum wire
- Wide idler arm hinge delivers improved drive roll clamping pressure

### Rigid Cast Aluminum Frame

- Enhances precise drive roll alignment



LF-74 Four Roll Drive

### Twist-Lock Drive Roll Hubs

- Two or four gear driven rolls
- Fast, tool-less changeovers

### Patented Split Wire Guides

- Full support for wire throughout the drive path
- Removable outer wire guide for easy access
- No tools required
- No birdnesting



LF-72 Two Roll Drive

### Brass to Brass Interchangeable Gun Bushings

- More reliable electrical conductivity – no oxide build-up
- More efficient energy transfer – lower voltage drops
- Easily adapt any number of Lincoln Magnum®, Magnum® PRO or competitive guns

### New Patented Drive Rolls

- For steel - new design delivers 20% more feeding force
- For aluminum - chrome plated to resist build-up

### Separate Drive Gear

- Reduces pressure on motor for extended service life

## OPTIONS

### DRIVE ROLL & WIRE GUIDE KITS

Description	 LF-72 Two-Roll	 LF-74 Four-Roll
<b>Solid Wire Sizes (includes stainless steel):</b>		
.023-.030 in. (0.6-0.8 mm)	KP1696-030S	KP1505-030S
.035 in. (0.9 mm)	KP1696-035S	KP1505-035S
.040 in. (1.0 mm)	KP1696-2	KP1505-040S
.045 in. (1.2 mm)	KP1696-045S	KP1505-045S
.052 in. (1.4 mm)	KP1696-052S	KP1505-052S
.035, .045 in. (0.9, 1.2 mm)	KP1696-1 <sup>(f)</sup>	KP1505-1 <sup>(f)</sup>
1/16 in. (1.6 mm)	KP1696-1/16S	KP1505-1/16S
<b>Cored Wire Sizes:</b>		
.030-.035 in. (0.8-0.9 mm)	KP1697-035C	KP1505-035C
.045 in. (1.2 mm)	KP1697-045C	KP1505-045C
.052 in. (1.4 mm)	KP1697-052C	KP1505-052C
1/16 in. (1.6 mm)	KP1697-1/16C	KP1505-1/16C
<b>Solid or Cored Wire Sizes:</b>		
.068-.072 in. (1.8 mm)	KP1697-068	KP1505-068
5/64 in. (2.0 mm)	KP1697-5/64	KP1505-5/64
3/32 in. (2.4 mm)	—	KP1505-3/32
<b>Aluminum Wire Sizes:</b>		
.035 in. (0.9 mm)	KP1695-035A	KP1507-035A
.040 in. (1.0 mm)	KP1695-040A	KP1507-040A
3/64 in. (1.2 mm)	KP1695-3/64A	KP1507-3/64A
1/16 in. (1.6 mm)	KP1695-1/16A	KP1507-1/16A

<sup>(f)</sup> included with feeder

### CONTROL EXTENSION CABLES

Cable Type	Description
<b>Wire Feeder Control Extension Cables</b>	
K1797-10 - 10 ft. (3 m) <sup>(2)</sup>	Male 14-pin to female 14-pin
K1797-25 - 25 ft. (7.6 m)	
K1797-50 - 50 ft. (15 m)	
K1797-100 - 100 ft. (30 m)	

<sup>(2)</sup> included with all LF-72 (except K2327-4) and LF-74 models.

### WELD CABLE REQUIRED

WELD CABLES	
Order No.	Description
K1840-10	Twist-Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft.
K1842-10	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.1 m)
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.7 m)
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.3 m)
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)

### FEED PLATE GUN ADAPTERS

K1500-1	K1500-2 (Included)	K1500-3	K1500-4	K1500-5	K489-7
Lincoln Electric	Tweco® #2 - #4	Tweco #5	Miller® guns	OXO® guns	Magnum® PRO Fast-Mate™
Compatible gun connector kits K466-1 K613-1 K613-6 K466-8	Compatible gun connector kits K466-10 K466-2 K466-6	Compatible gun connector kit K613-7 K613-2	Compatible gun connector kits K466-3 K613-3		Compatible gun connector kits K489-1 K489-2 K489-7 K489-8
					

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Oxo® is a registered trademark of Miller Electric Mfg. Co.

## RECOMMENDED ACCESSORIES

### GENERAL OPTIONS



#### Magnum® PRO Gun and Cable Assemblies

250-550 amps, air-cooled, gas-shielded welding guns. See publication E12.01



#### Magnum® PRO Curve Guns

200 – 400 amps, air-cooled, gas-shielded welding guns. See publication E12.09



#### Magnum® Self-Shielded Innershield® Gun and Cable Assemblies

Available 200-550 amps, air-cooled, gas-shielded welding guns. See publication E12.10



#### Magnum® Self-Shielded Innershield® Gun and Cable Assemblies

Available 250-600 amps. See publication E12.110



#### Postflow and Burnback Timer Kit

Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds. Order K2330-1



#### Remote Voltage Control Kit

Allows arc voltage to be changed at the feeder. Order K2329-1



#### Incoming Bushing for Lincoln Conduit

Feed Plate Incoming Bushings connect directly to wire conduit (not included), for use in boom system, long distances, or large payoff packages. Bushings can be used with any wire conduit (K515 or K565).

Order K1546-1 for .025-1/16 in. (0.6 - 1.6 mm) wire

Order K1546-2 for 1/16-1/8 in. (1.6 - 3.2 mm) wire



#### Spindle Adapter

for Readi-Reels® and Spools for fixture and other custom installations. Features 2 in. (51 mm) O.D. spindle for mounting Readi-Reels® and 2 in. (51 mm) I.D. spools up to 60 lb. (27.2 kg) capacity. Order K162-1



#### Deluxe Adjustable Gas Regulator & Hose Kit

Accommodates CO<sub>2</sub>, Argon, or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose. Order K586-1



#### Harris® Argon Flowmeter/Regulator and Hose Kit

Order 3100211



#### Adapter for Competitive Power Sources

Allows wire feeder to connect to select Miller Electric® power sources. Order K2335-2



#### Control Cable to Terminal Strip Adapter

Connects 14-pin control cable to power sources with terminal strip. Order K1798



#### 115V/42V Transformer Kit

Provides a way to use the wire feeder on power sources that have 115V AC available on the terminal strip. Order K1520-1



#### Welding Fume Extractors

Lincoln offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.

Request Publication E13.40



#### ADDITIONAL OPTIONS FOR BASE MODEL (DOES NOT INCLUDE WIRE REEL STAND)

#### Standard Duty Wire Reel Stand

For use with Lincoln 10-44 lb. (4.5-20 kg) wire packages that use a 2 in. (51 mm) spindle. Order K2328-1



#### Heavy Duty Wire Reel Stand

For use with Lincoln 10-60 lb. (4.5-27.2 kg) wire packages that use a 2 in. (51 mm) spindle. Hole in stand fits over lift bail. Order K1524-3



#### ADDITIONAL OPTIONS FOR FEEDERS EQUIPPED WITH STANDARD DUTY WIRE REEL STAND

#### Swivel Platform

Mounts to the lift bail on the power source and bottom of the Heavy Duty Wire Reel stand. Wire feeder may be lifted off if needed. Compatible with Light Duty Caster Kit. Includes "lazy susan" parts tray. Order K1557-1



#### 14 lb. Innershield® Coil Adapter

Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. Order K435



#### 8" O.D. Spool Adapter

Permits 8 in. (200 mm) O.D. spools to be mounted on 2 in. (51 mm) O.D. spindles. Order K468



#### Wire Reel Cover Kit

Plastic enclosure for up to 44 lb. (20 kg) wire packages. Order K1634-1



#### Insulated Lift Bail

Allows the entire wire feeder to be hung from a crane or hook. Use with Heavy Duty Wire Reel Stand. Order K1555-1



#### Caster Kit — Light Duty

Mounts to the Heavy Duty Wire Reel Stand. Allows for easy movement of wire feeder. Order K1556-1



#### Undercarriage

Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stands. Order K163-1



#### 50-60 lb. Coil Adapter

Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln wire to 2 in. (51 mm) spindle. Order K1504-1



#### Plastic Wire Cover Kit

Plastic enclosure for up to 60 lb. (27.2 kg) wire packages. Order K1634-2

NOTE: Miller Electric® is not a trademark of The Lincoln Electric Company.

## WIRE FEEDERS SELECTION GUIDE

### LF-72

#### Number of Rolls:



#### Inches Per Minute (m/min):

50-800 (1.3-20.3)

#### Wire Size:

in. (mm)

Solid .023-1/16 (0.6-1.6)

Cored .030-5/64 (0.8-2.0)

### LF-72 Base Model

(no gun, no control cable)  
(K2327-4)



For boom mounting  
or for use with bulk  
consumables.

#### Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045

### LF-72 Bench Model,

Standard Duty (K2327-5)  
Shown with optional wire.



For most welding needs that  
require a rugged  
and dependable wire  
feed system.

#### Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Magnum® PRO 350 Gun and Cable Assembly
- Control Cable 10 ft. (3 m)
- Standard Duty Wire Reel Stand

### LF-72 Bench Model, Heavy Duty

(K2327-6)  
Shown with optional wire.



For applications  
requiring up to 60 lb.  
wire packages.

#### Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Magnum® PRO 350 Gun and Cable Assembly
- Control Cable 10 ft. (3 m)
- Heavy Duty Wire Reel Stand

### LF-72 Bench Model,

Heavy Duty (no gun) (K2327-7)  
Shown with optional wire.



For applications  
requiring up to 60 lb. wire  
packages.

#### Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Control Cable 10 ft. (3 m)
- Heavy Duty Wire Reel Stand

### LF-74

#### Number of Rolls:



#### Inches Per Minute (m/min):

50-800 (1.3-20.3)

#### Wire Size:

in. (mm)

Solid .023-1/16 (0.6-1.6)

Cored .030-5/64 (0.8-2.0)

### LF-74 Base Model

(no gun)  
(K2426-4)



For boom mounting  
or for use with  
bulk consumables.

#### Unit Includes:

- Drive Roll and Wire Guide Kit
- Control Cable 10' (3 m)

### LF-74 Bench Model,

Heavy Duty (no gun)  
(K2426-5)  
Shown with  
optional wire.



For applications  
requiring up to 60 lb. wire  
packages.

#### Unit Includes:

- Drive Roll and Wire Guide Kit
- Control Cable 10' (3 m)
- Heavy Duty Wire Reel Stand

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current / Duty Cycle	Wire Feed Speed Range ipm (m/min.)	Wire Size Range In. (mm)	H x W x D inches (mm)	Net Weight lbs. (kg)
LF-72 Base Model (w/o gun or cable)	K2327-4	24-42 VAC 50/60 Hz 9 Amps	500 Amps @ 60%	50-800 (1.3-20.3)	Solid .023-1/16 (0.6-1.6)	Cored .030-5/64 (0.8-2.0)	24 (11)
LF-72 Bench Model Standard Duty	K2327-5						52 (24)
LF-72 Bench Model Heavy Duty	K2327-6						69 (31)
LF-72 Bench Model Heavy Duty (w/o gun)	K2327-7						63 (29)
LF-74 Base Model	K2426-4	600 Amps @ 60%					27 (12)
LF-74 Bench Model Heavy Duty	K2426-5						63 (29)

For best welding results with Lincoln Electric® equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

#### CUSTOMER ASSISTANCE POLICY

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