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.

Processes »
MIG, Flux-Cored

Applications »
Fabrication, Heavy Equipment, Job Shop

Product Numbers »
See last page

Output »
Input »

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

Compatible Competitive Power Sources »
(1) Requires K2335-2 competitive adapter
Deltaweld(1), Dimension(1), XMT(1) and CP302(1)

(1) Trademarks of the Miller Electric Manufacturing Company

Two Year Extended Warranty Available.
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
2. Gun Connection (K1500-2)
3. 5-Pin Gun Connection
4. Motor Thermal Protection Light
5. Cold Feed/Gas Purge Switch
6. 2-Step/Trigger Interlock Switch
7. Burnback/Postflow Timer Kit (optional)
8. Remote Voltage Control Kit (optional)

FEATURES

Front View

Heavy duty hinged door opens upward to provide generous access to wire drive.

Convenient storage tray on top for contact tips and drive rolls.

Rugged MAXTRAC® wire drive system.

Convenient spare parts reference chart.

Quick release spoolholder

Heavy duty wire reel stand allows spool sizes up to 60 lbs.

Welding cable strain relief

Gas hose connection inlet.

10-ft integrated control cable with 14-pin male connector.

Control cable connector with Spin-Nut™ for fast, easy, tool-less connection.

Patented ball bearing inlet guide for accurate feeding.

Back View

All models except K2327-4

Back View

LF-74 Four Roll Bench Model Shown

LF-72 and LF-74 | [ 2 ]
PERFORMANCE

MaxTrac® Wire Drive System

Rigid Cast Aluminum Frame
- Enhances precise drive roll alignment

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

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

Twist-Lock Drive Roll Hubs
- Two or four gear driven rolls
- Fast, tool-less changeovers

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

Separate Drive Gear
- Reduces pressure on motor for extended service life
**DRIVE ROLL & WIRE GUIDE KITS**

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

*() included with feeder

**CONTROL EXTENSION CABLES**

<table>
<thead>
<tr>
<th>Cable Type</th>
<th>Description</th>
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<tbody>
<tr>
<td>Wire Feeder Control Extension Cables</td>
<td></td>
</tr>
<tr>
<td>K1797-10 - 10 ft. (3 m)</td>
<td>Male 14-pin to female 14-pin</td>
</tr>
<tr>
<td>K1797-25 - 25 ft. (7.6 m)</td>
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<tr>
<td>K1797-50 - 50 ft. (15 m)</td>
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<tr>
<td>K1797-100 - 100 ft. (30 m)</td>
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</tbody>
</table>

*() included with all LF-72 (except K2327-4) and LF-74 models.

**WELD CABLES**

<table>
<thead>
<tr>
<th>Order No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>K1840-10</td>
<td>Twist-Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft.</td>
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<tr>
<td>K1842-10</td>
<td>Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.1 m)</td>
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<tr>
<td>K1842-35</td>
<td>Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.7 m)</td>
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<tr>
<td>K1842-60</td>
<td>Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.3 m)</td>
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<tr>
<td>K1842-110</td>
<td>Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)</td>
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</table>

**FEED PLATE GUN ADAPTERS**

<table>
<thead>
<tr>
<th></th>
<th>K1500-1</th>
<th>K1500-2 (Included)</th>
<th>K1500-3</th>
<th>K1500-4</th>
<th>K1500-5</th>
<th>K489-7</th>
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<tr>
<td>Compatible gun connector kits</td>
<td>K466-1</td>
<td>K613-1</td>
<td>K613-6</td>
<td>K466-6</td>
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<td>Tweco® #2 - #4</td>
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<tr>
<td>Compatible gun connector kits</td>
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<td>K466-2</td>
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<td>Miller® guns</td>
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<tr>
<td>Compatible gun connector kit</td>
<td>K613-7</td>
<td>K613-2</td>
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<td>DXO® guns</td>
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<tr>
<td>Compatible gun connector kit</td>
<td>K466-3</td>
<td>K613-3</td>
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Tweco® is a registered trademark of Victor Technologies. Miller® is a registered trademark of Miller Electric Mfg. Co. DXO® is a registered trademark of Miller Electric Mfg. Co.
**RECOMMENDED ACCESSORIES**

**GENERAL OPTIONS**

*Magnum® PRO Gun and Cable Assemblies*
200-550 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

*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 K2339-1

*Remote Voltage Control Kit*
Allows arc voltage to be changed at the feeder.
Order K3229-1

*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 (K315 or K565).
Order K1546-1 for .025-.06 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 K562-1

*Deluxe Adjustable Gas Regulator & Hose Kit*
Accommodates CO₂, 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 K566-1

*Control Cable to Terminal Strip Adapter*
Connects 14-pin control cable to power sources with terminal strip.
Order K7P8

*15V/42V Transformer Kit*
Provides a way to use the wire feeder on power sources that have 15V 42V AC available on the terminal strip.
Order K620-1

*Welding Fume Extractors*
Lincoln offers a wide variety of fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to ship-wide central systems servicing many dedicated welding stations.
Request Publication E10.40

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

*50-60 lb. Coil Adapter*
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln wire to 2 in. (51 mm) spindles.
Order K163-1

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

*Swivel Platform*
Mounts to the lift ball 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 K163P-1

*50-60 lb. Wire Reel 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.*

**ADDITIONAL OPTIONS FOR FEEDERS EQUIPPED WITH HEAVY DUTY WIRE REEL STAND**

*Insulated Lift Ball*
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) spindles.
Order K163-1

*Wire Reel Cover Kit*
Plastic enclosure for up to 44 lb. (20 kg) wire packages.
Order K1634-2

*Order K468*

*8” D.O.D Spool Adapter*
Permits 8 in. (200 mm) O.D. spools to be mounted on 2 in. (51 mm) O.D. spindles.
Order K163-1

**ADDITIONAL OPTIONS FOR FEEDERS**

*8” D.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

*Order K468*

*8” D.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 FEEDERS SELECTION GUIDE

LF-72
Number of Rolls:
0)

Inches Per Minute (m/min):
50-800 [1.3-20.3]
Wire Size:
in. [mm]
Solid .035-.045 [0.9-1.2]
Cored .023-.035 [0.6-0.9]

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

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

LF-74
Number of Rolls:
0)

Inches Per Minute (m/min):
50-800 [1.3-20.3]
Wire Size:
in. [mm]
Solid .035-.045 [0.9-1.2]
Cored .023-.035 [0.6-0.9]

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

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

PRODUCT SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Output Capacity Current/Duty Cycle</th>
<th>Wire Feed Speed Range (ips) (m/min.)</th>
<th>Wire Size Range (in. [mm])</th>
<th>H x W x D inches (mm)</th>
<th>Net Weight lbs. (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LF-72 Base Model (no gun, no control cable)</td>
<td>K2327-4</td>
<td>24-42 VAC 50-60 Hz</td>
<td>9 Amps</td>
<td>500 Amps @ 60%</td>
<td>50-800 (1.3-20.3)</td>
<td>Solid .035-.045 [0.9-1.2]</td>
<td>11.1 x 10.2 x 12.9</td>
</tr>
<tr>
<td>LF-72 Bench Model, Standard Duty</td>
<td>K2327-5</td>
<td>24-42 VAC 50-60 Hz</td>
<td>9 Amps</td>
<td>500 Amps @ 60%</td>
<td>50-800 (1.3-20.3)</td>
<td>Cored .035-.045 [0.9-1.2]</td>
<td>11.1 x 10.2 x 12.9</td>
</tr>
<tr>
<td>LF-72 Bench Model, Heavy Duty (no gun)</td>
<td>K2327-6</td>
<td>24-42 VAC 50-60 Hz</td>
<td>9 Amps</td>
<td>500 Amps @ 60%</td>
<td>50-800 (1.3-20.3)</td>
<td>Solid .035-.045 [0.9-1.2]</td>
<td>11.1 x 10.2 x 12.9</td>
</tr>
<tr>
<td>LF-74 Base Model (no gun, no control cable)</td>
<td>K2426-4</td>
<td>24-42 VAC 50-60 Hz</td>
<td>9 Amps</td>
<td>600 Amps @ 60%</td>
<td>50-800 (1.3-20.3)</td>
<td>Solid .035-.045 [0.9-1.2]</td>
<td>11.1 x 10.2 x 12.9</td>
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<tr>
<td>LF-74 Bench Model, Heavy Duty (no gun)</td>
<td>K2426-5</td>
<td>24-42 VAC 50-60 Hz</td>
<td>9 Amps</td>
<td>600 Amps @ 60%</td>
<td>50-800 (1.3-20.3)</td>
<td>Cored .035-.045 [0.9-1.2]</td>
<td>11.1 x 10.2 x 12.9</td>
</tr>
</tbody>
</table>


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 inquiries 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.

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For applications requiring up to 60 lb. wire packages.

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