

# LF-72 and LF-74 Wire Feeders



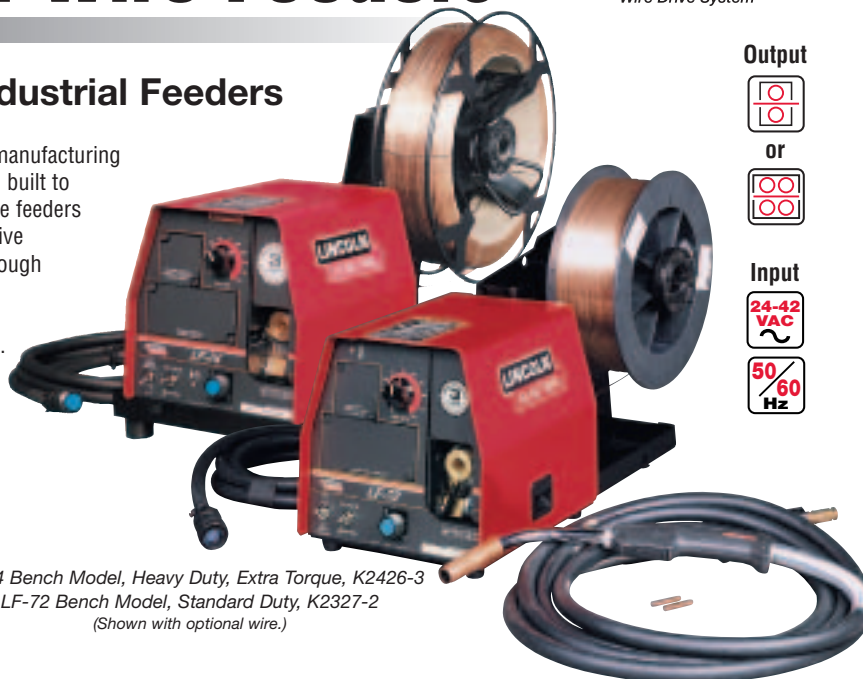
## 2-Roll or 4-Roll Heavy Duty Industrial Feeders

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. The heart of these feeders is the highly engineered 2-roll or 4-roll MAXTRAC™ wire drive system, delivering strong and consistent feeding force for tough applications.

Select the 2-roll LF-72 for most .035-.045 wire applications. Select the 4-roll LF-74 for large diameter wires, longer gun cables or long boom conduit or hard automation applications.

### Processes

MIG, Pulsed, Flux-Cored



Output



or



Input



LF-74 Bench Model, Heavy Duty, Extra Torque, K2426-3  
 LF-72 Bench Model, Standard Duty, K2327-2  
 (Shown with optional wire.)

### Advantage Lincoln

- 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.
- Rugged, industrial-grade wire feeder motor.
- In addition to great mild steel performance, these feeders deliver positive arc starting and feeding with stainless steel, aluminum and flux-cored wires!
- Control cable connector with a Spin-Nut™ makes connecting the control cable a simple twist-of-the-wrist.
- Totally enclosed wire drive.
- Manufactured under a quality system certified ISO 9001 requirements and ISO 14001 environmental standards.
- Three-year warranty on parts and labor.

### TECHNICAL SPECIFICATIONS

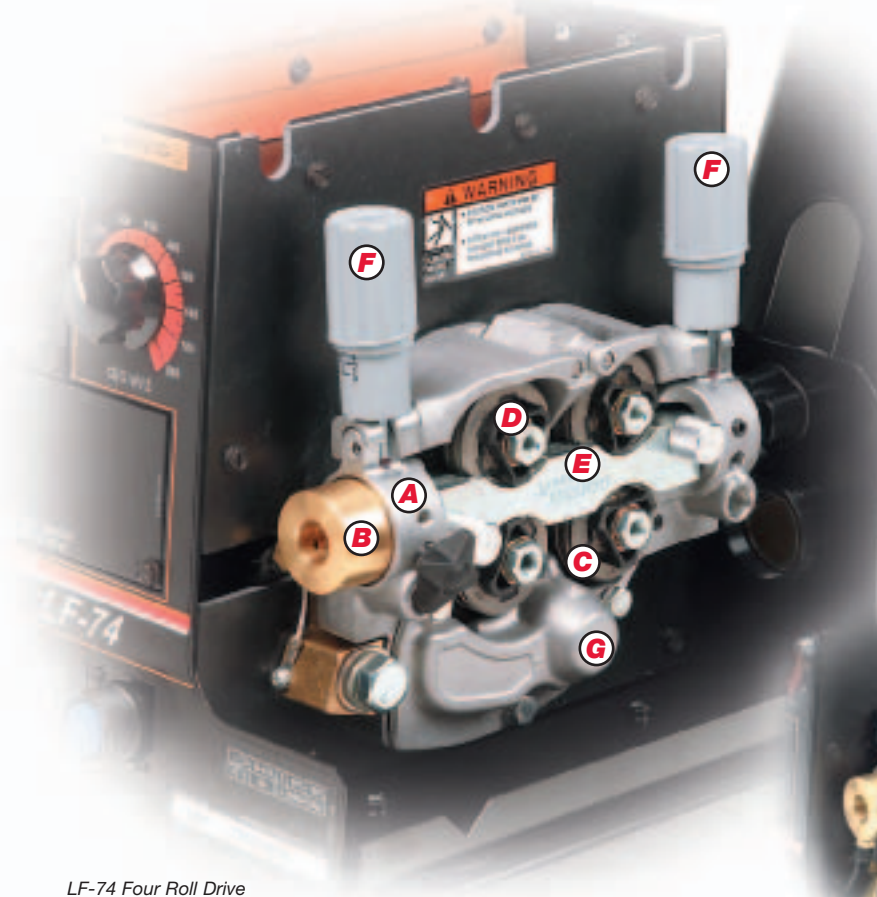
Product Name <sup>(1)</sup>	Product Number	Input Power	Output Capacity Current / Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)	Dimensions H x W x D in (mm)	Net Weight lbs (kg)	
LF-72 Base Model (with gun)	K2327-1	24-42 VAC 50/60 Hz 9 Amps	500 Amps @ 60% 400 Amps @ 100%	50-800 (1.3-20.3)	Solid .023-1/16 (0.6-1.6)	Cored .030-5/64 (0.8-2.0)	44 (20)	
LF-72 Base Model, (no gun, no cable)	K2327-4						27 (12)	
LF-72 Bench Model, Standard Duty	K2327-2						12.6 x 10.9 x 22.5 (320 x 277 x 572)	53 (24)
LF-72 Bench Model, Heavy Duty	K2327-3						15.3 x 13.0 x 27.7 (389 x 330 x 704)	68 (31)
LF-74 Base Model	K2426-1	24-42 VAC 50/60 Hz 9 Amps	600 Amps @ 60% 500 Amps @ 100%	100-800 (2.5-20.3)	.030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	46 (21)	
LF-74 Bench Model, Heavy Duty	K2426-2						15.3 x 13.0 x 27.7 (389 x 330 x 704)	71 (32)
LF-74 Bench Model, Heavy Duty, Extra Torque	K2426-3						50-400 (1.3-10.1)	.030-3/32 (0.8-2.4)

<sup>(1)</sup> See selection guide on page 4.



# MAXTRAC™

## Wire Drive System



LF-74 Four Roll Drive



LF-72 Two Roll Drive

**A Rigid Cast Aluminum Frame**

- Enhances precise drive roll alignment

**B 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 or competitive guns

**C New Patent-Pending Drive Rolls**

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

**D Twist-Lock Drive Roll Hubs**

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

**E Patented Split Wire Guides**

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

**F Patent-Pending Dual Spring Pressure Arm**

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

**G Separate Drive Gear**

- Reduces pressure on motor for extended service life

**A CLOSER LOOK**

**FEATURES**

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

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

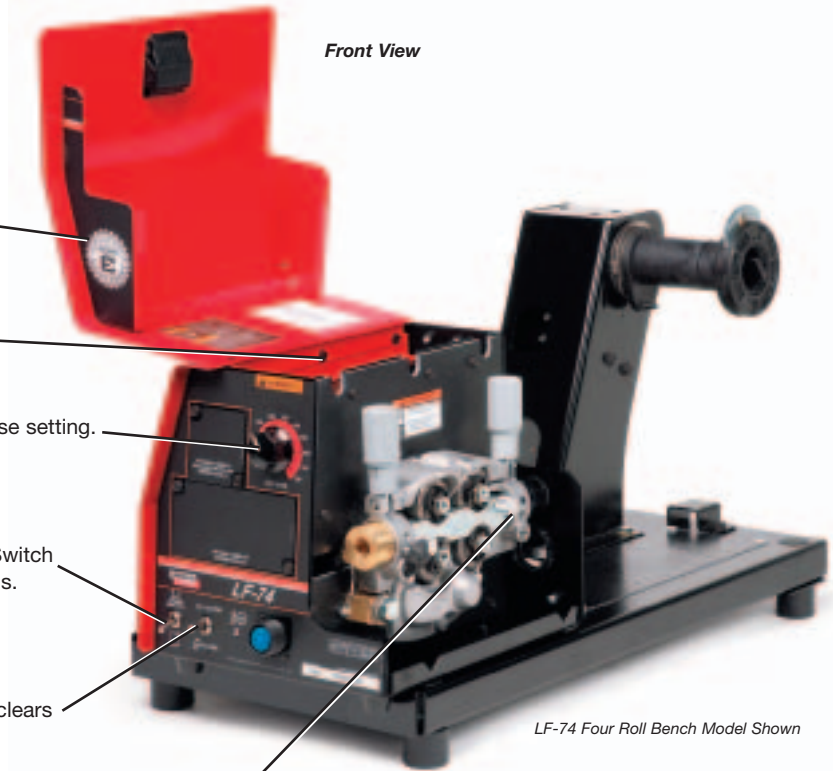
Calibrated Wire Feed Speed Dial for precise setting.

Convenient 2 Step/Trigger Interlock Switch for operator comfort during long welds.

Cold Feed for safety/Gas Purge clears shielding gas line.

Rugged MAXTRAC™ wire drive system.

Front View



LF-74 Four Roll Bench Model Shown

Back View

Gas Hose Connection Inlet.

Control Cable Connector with Spin-Nut™ for fast, easy, tool-less connection.

Patented Ball Bearing Inlet Guide for accurate feeding.










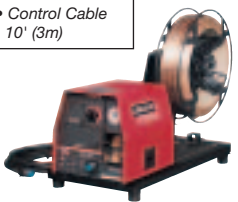


**Key Controls (LF-72 and LF-74)**

- A) Calibrated Wire Feed Speed Dial
- B) Gun Connection (K1500-2)
- C) 5-Pin Gun Connection
- D) Motor Thermal Protection Light
- E) Cold Feed/Gas Purge Switch
- F) 2-Step/Trigger Interlock Switch
- G) Burnback/Postflow Timer Kit (optional)
- H) Remote Voltage Control Kit (optional)

LF-72 shown with optional K2330-1 Postflow and Burnback Timer Kit and K2329-1 Remote Voltage Control Kit.

**WIRE FEEDER SELECTION GUIDE**

	<b>LF-72</b>	<b>LF-74</b>	<b>LF-74 Extra Torque</b>
<b>Number of Rolls:</b>			
<b>Inches Per Minute (m/min):</b>	50-800 (1.3-20.3)	100-800 (2.5-20.3)	50-400 (1.3-10.1)
<b>Wire Size, in. (mm):</b>	<b>Solid</b> .023-1/16 (0.6-1.6) <b>Cored</b> .030-5/64 (0.8-2.0)	<b>Solid</b> .023-1/16 (0.6-1.6) <b>Cored</b> .030-5/64 (0.8-2.0)	<b>Solid</b> .023-1/16 (0.6-1.6) <b>Cored</b> .030-3/32 (0.8-2.4)
<b>BASE MODEL</b> no gun, no cable  For boom mounting or for use with bulk consumables.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit   LF-72 Base Model (no gun, no cable) (K2327-4)		
<b>BASE MODEL</b>  For boom mounting or for use with bulk consumables.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Gun and Cable Assembly • Control Cable 10' (3m)   LF-72 Base Model with gun (K2327-1)	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Control Cable 10' (3m)   LF-74 Base Model (K2426-1)	
<b>BENCH MODEL</b> <b>STANDARD DUTY</b>  For most welding needs that require a rugged and dependable wire feed system.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Gun and Cable Assembly • Control Cable 10' (3m)   LF-72 Bench Model, Standard Duty (K2327-2) Shown with optional 10-44 lb. (4.5-19.9 kg) wire spool.		
<b>BENCH MODEL</b> <b>HEAVY DUTY</b>  For applications requiring up to 60 lb. wire packages.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Gun and Cable Assembly • Control Cable 10' (3m)   LF-72 Bench Model, Heavy Duty (K2327-3) Shown with optional 50-60 lb. (22.6-27.2 kg) coil adapter and wire.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Control Cable 10' (3m)   LF-74 Bench Model, Heavy Duty (K2426-2) Shown with optional 50-60 lb. (22.6-27.2 kg) coil adapter and wire.	<b>Unit Includes:</b> • Drive Roll and Wire Guide Kit • Control Cable 10' (3m)   LF-74 Bench Model, Heavy Duty, Extra Torque (K2426-3) Shown with optional 50-60 lb. (22.6-27.2 kg) coil adapter and wire. <b>Recommended for Flux-Cored Wire Feeding</b>

**LF-72 includes FREE:<sup>(1)</sup>**

.035"-.045" (0.9-1.2mm) Drive Roll and Wire Guide Kit (KP1696-1)

Male 14-pin to Female 14-pin Control Cable 10 ft. (3.0m) (K1797-10)

Magnum 400 Gun and 15 ft. (4.5m) Cable Assembly with .035"-.045" (0.9mm-1.2mm) liner (K471-21). LF-72 Base Model without gun also available (K2327-4).

**LF-74 includes FREE:**


.035"/.045" (0.9mm/1.2mm) Drive Rolls and Wire Guides

Male 14-pin to Female 14-pin Control Cable 10 ft. (3.0m) (K1797-10)

<sup>(1)</sup>K2327-4 includes Drive Roll & Wire Guide Kit Only

**OPTIONS**

**DRIVE ROLL & WIRE GUIDE KITS**

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

<sup>(1)</sup> Standard on LF-72.

**CONTROL EXTENSION CABLES**

Cable Type	Description
<b>Wire Feeder Control Extension Cables</b> K1797-10 - 10 ft. <sup>(1)</sup> K1797-25 - 25 ft. K1797-50 - 50 ft. K1797-100 - 100 ft.	Male 14-pin to female 14-pin

<sup>(1)</sup> Standard with all LF-72 (except K2327-4) and LF-74 models.

**WELD POWER CABLE REQUIRED**

**WELD POWER 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.
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft.
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft.
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft.

**FEED PLATE GUN RECEIVER BUSHINGS**

K1500-1 Gun Receiver Bushing (Optional)	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)	K1500-4 Gun Receiver Bushing (Optional)	K1500-5 Gun Receiver Bushing (Optional)	K489-7 Fast-Mate Gun Receiver Bushing (Optional)
<ul style="list-style-type: none"> <li>Magnum 200, 300 and 400 gun and cable assemblies with K466-1 connector kit.</li> <li>Lincoln Innershield gun and cable assembly.</li> <li>Magnum 550 gun and cable assembly with K613-1 connector kit.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum 200 and 400 fully assembled guns (K497-2x and K471-2x).</li> <li>Magnum 200, 300 and 400 gun and cable assemblies with K466-10 connector kit.</li> <li>Guns with Tweco #2, #3, and #4 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum 550 gun and cable assembly with K613-7 connection.</li> <li>Guns with Tweco #5 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum 200, 300 and 400 gun and cable assemblies with K466-3 connector kit.</li> </ul>	<ul style="list-style-type: none"> <li>To adapt to OXO guns.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum gun and cable assemblies with Fast-Mate connections.</li> <li>Handles both single and dual procedure guns.</li> </ul>



**GENERAL OPTIONS**



**Magnum Gas-Shielded Gun and Cable Assemblies**  
Available 200-550 amps, air-cooled, gas-shielded welding guns. See publication E12.10



**Magnum Self-Shielded 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" wire Order K1546-2 for 1/16-1/8" wire



**Spindle Adapter for Readi-Reels® and Spools**  
For fixture and other custom installations. Features 2" (51mm) O.D. spindle for mounting Readi-Reels and 2" (51mm) 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. (1.3m) gas hose. Order K586-1



**Gas Guard Regulator**  
For CO<sub>2</sub> and Argon blend gases. Reduces surge caused by excess pressure in supply hose. Includes adjustable flow regulator with removable adjuster key. Order K659-1



**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 K2335-1



**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" (51mm) 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" (51mm) spindle. Hole in stand fits over lift bail. Order K1524-3



**6000 Series Welding Arm**  
Create a safe, uncluttered work environment where floor space is used effectively with a Lincoln Series 6000 Welding Arm. Glide the arm effortlessly into position when in use or swing it conveniently against a wall or beam for safe, out-of-the-way storage. An 18" x 18" (457 x 457mm) footprint ties up very little floor space. Order K1778-1

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



**Lift Bail Kit**  
Allows the entire wire feeder to be hung from a crane or hook. Use with Standard Duty Wire Reel Stand.  
**Order K2331-1**



**Lightweight Swivel Kit**  
Allows wire feeder to freely turn. For use with Standard Duty Wire Reel Stand.  
**Order K2332-1**



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



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



**8" O.D. Spool Adapter**  
Permits 8" (200mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles.  
**Order K468**



**Wire Reel Cover Kit**  
Plastic enclosure for up to 44 lb. (20 kg) wire packages.  
**Order K1634-1**



**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**



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



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



**8" O.D. Spool Adapter**  
Permits 8" (200mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles.  
**Order K468**



**Wire Reel Cover Kit**  
Plastic enclosure for up to 44 lb. (20 kg) wire packages.  
**Order K1634-1**



**50-60 lb. Readi-Reel® Adapter**  
Adapts 60 lb. (27.2 kg) coils of Lincoln electrode to 2" (51mm) spindle.  
**Order K438**



**50-60 lb. Coil Adapter**  
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln electrode to 2" (51mm) spindle.  
**Order K1504-1**



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

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



**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**

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

**LF-72 AND LF-74 WIRE FEEDERS ORDER FORM**

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
LF-72 WIRE FEEDER, BASE MODEL, WITH GUN	K2327-1		
LF-72 WIRE FEEDER, BASE MODEL, NO GUN, NO CABLE	K2327-4		
LF-72 WIRE FEEDER, BENCH MODEL, STANDARD DUTY	K2327-2		
LF-72 WIRE FEEDER, BENCH MODEL, HEAVY DUTY	K2327-3		
LF-74 WIRE FEEDER, BASE MODEL	K2426-1		
LF-74 WIRE FEEDER, BENCH MODEL, HEAVY DUTY	K2426-2		
LF-74 WIRE FEEDER, BENCH MODEL, HEAVY DUTY, EXTRA TORQUE	K2426-3		
<b>UNIT REQUIRES</b>			
Weld Power Cable	See page 5		
Magnum Gas-Shielded Gun and Cable Assemblies	See publication E12.10		
Magnum Self-Shielded Gun and Cable Assemblies	See publication E12.110		
<b>GENERAL OPTIONS</b>			
Postflow and Burnback Timer Kit	K2330-1		
Remote Voltage Control Kit	K2329-1		
Incoming Bushing for Lincoln Conduit:			
for .025-1/16" wire	K1546-1		
for 1/16-1/8" wire	K1546-2		
Spindle Adapter	K162-1		
Deluxe Adjustable Gas Regulator & Hose Kit	K586-1		
Gas Guard Regulator	K659-1		
Harris Argon Flowmeter/Regulator & Hose Kit	3100211		
Adapter for Competitive Power Sources	K2335-1		
Control Cable to Terminal Strip Adapter	K1798		
115V/42V Transformer Kit	K1520-1		
Welding Fume Extractors	See publication E13.40		
<b>ADDITIONAL OPTIONS FOR BASE MODEL (Does Not Include Wire Reel Stand)</b>			
Standard Duty Wire Reel Stand	K2328-1		
Heavy Duty Wire Reel Stand	K1524-3		
6000 Series Welding Arm	K1778-1		
<b>ADDITIONAL OPTIONS FOR FEEDERS EQUIPPED WITH STANDARD DUTY WIRE REEL STAND</b>			
Lift Bail Kit	K2331-1		
Lightweight Swivel Kit	K2332-1		
Undercarriage	K163		
14 lb. Innershield® Coils Adapter	K435		
8" O.D. Spool Adapter	K468		
Wire Reel Cover Kit (for up to 44 lb. wire packages)	K1634-1		
<b>ADDITIONAL OPTIONS FOR FEEDERS EQUIPPED WITH UNIVERSAL WIRE REEL STAND</b>			
Insulated Lift Bail	K1555-1		
Caster Kit – Light Duty	K1556-1		
Swivel Platform	K1557-1		
Undercarriage	K163		
14 lb. Innershield® Coils Adapter	K435		
8" O.D. Spool Adapter	K468		
Wire Reel Cover Kit (for up to 44 lb. wire packages)	K1634-1		
50-60 lb. Readi-Reel® Adapter	K438		
50-60 lb. Coil Adapter	K1504-1		
Plastic Wire Cover Kit (for up to 60 lb. wire packages)	K1634-2		
<b>POWER SOURCE OPTIONS</b>			
CV-305, CV400-I, CV-400, CV500-I, CV-655, Invertec® V350-PRO, Invertec® V450-PRO, DC-400, DC-600, DC-655	See publications E4.22, E4.20.1, E4.30, E4.30.1, E4.40, E5.91, E5.94, E5.20, E5.40, E5.46		
	<b>TOTAL:</b>		

**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.

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**THE LINCOLN ELECTRIC COMPANY**

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