

# LN-7 and LN-7 GMA

## Semiautomatic, Constant Speed Wire Feeders

The LN-7 and LN-7 GMA are semiautomatic constant speed wire feeders that can be used with a variety of Lincoln engine drives, DC or CV power sources in a shop or field environment. Both models and a Ready-Pak™ package feature Lincoln's unique drive roll design, which provides positive feeding, quick reloading and durability for long life. Controlled wire feed speed during starting provides clean, positive starts and minimizes stubbing, skipping and spatter. For dependable operation and precise wire feeding in a rugged package, choose the LN-7 or LN-7 GMA.



Shown with options

### Processes

MIG Flux-Cored Submerged Arc<sup>(1)</sup>

### Advantage Lincoln

- The LN-7 feeds up to 3/32" (2.4mm) solid and 7/64" (2.8mm) flux-cored wires, from 50-500 inches per minute (1.3-12.7m/min) wire feed speed.
- The LN-7 GMA feeds up to 1/16" (1.6mm) solid and 5/64" (2.0mm) flux-cored wires, from 75-700 inches per minute (1.9-17.8 m/min) wire feed speed.
- Unique drive-roll design provides positive feeding and quick reloading by simply starting wire into guide tube. The drive rolls and guide tubes are designed for long life and precise wire feeding.
- Four-roll wire drive system available for additional wire feeding force and easier feeding of soft wires (LN-7 GMA model only).
- Completely enclosed case protects the heavy duty wire drive mechanism from damage, but allows easy access to drive rolls.
- Control circuit features "cold electrode" when the gun trigger is released for an added measure of safety.
- Low voltage (24 volts) gun trigger circuit.
- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.
- Three-year warranty on parts and labor.

### Description

Output  Input 

### Required Options

Gun and Cable Assembly, Drive Roll Kit, Control Cable, Weld Power Gun

### Recommended General Options

Universal Wire Reel Stand, Insulated Lift Bail, Caster Kit, Swivel Platform, Spindle Adapter, Reel-Feed Adapter, Coil Adapter, Plastic Wire Cover, Digital Voltmeter, Water Solenoid Kit, Gas Solenoid Assembly, Gas Guard Regulator, GMA Timer Kit, Bumpback Kit, Magnetic Flux Screen Separator, Flux Screen, Continuous Flux Feeding Tank Assembly, Undercarriage, Remote Output Control Kit, Remote Control Adapter

### Recommended Power Source Options

CV-250, CV-300, CV-400-L, CV-400, CV500-L, CV-555, V350-PRO, DC-400, DC-600, DC-655, DC-1000

### Order

K521 LN-7 Wire Feeder (2 Roll)  
 K440-2 LN-7 GMA (2 Roll) with gas solenoid valve  
 K567-2 LN-7 GMA (4 Roll) with gas solenoid valve  
 K1801-1 LN-7 GMA (2 Roll) Ready-Pak™ Wire Feeder

### TECHNICAL SPECIFICATIONS

| Product Name         | Product Number | Input Power                     | Rated Output Current / Duty Cycle | Wire Feed Speed Range<br>ipm (m/min) | Wire Size Range<br>in. (mm)            | Dimensions<br>H x W x D<br>in. (mm) | Net Weight<br>lbs. (kg) |
|----------------------|----------------|---------------------------------|-----------------------------------|--------------------------------------|----------------------------------------|-------------------------------------|-------------------------|
| LN-7<br>(2 Roll)     | K521           | 115 VAC<br>50/60 Hz<br>2.5 Amps | 600 Amps @ 60%                    | 50-500<br>(1.3-12.7)                 | <b>Solid</b><br>.023-3/32<br>(0.6-2.4) | .945-7/64<br>(1.2-2.8)              | 24<br>(10.9)            |
| LN-7 GMA<br>(2 Roll) | K440-2         |                                 |                                   | 75-700<br>(1.9-17.8)                 | .023-1/16<br>(0.6-1.6)                 | .945-5/64<br>(1.2-2.0)              | 26<br>(10.9)            |
| LN-7 GMA<br>(4 Roll) | K567-2         |                                 |                                   | 75-700<br>(1.9-17.8)                 | .023-1/16<br>(0.6-1.6)                 | .945-5/64<br>(1.2-2.0)              | 32<br>(13.8)            |

<sup>(1)</sup> LN-7 model only.

# Lincoln Electric Service Manual

**Minjie Lin**



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## **Table of Contents Lincoln Electric Service Manual**

1. Understanding the eBook Lincoln Electric Service Manual
  - The Rise of Digital Reading Lincoln Electric Service Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Lincoln Electric Service Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Lincoln Electric Service Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Lincoln Electric Service Manual
  - Personalized Recommendations
  - Lincoln Electric Service Manual User Reviews and Ratings
  - Lincoln Electric Service Manual and Bestseller Lists
5. Accessing Lincoln Electric Service Manual Free and Paid eBooks
  - Lincoln Electric Service Manual Public Domain eBooks
  - Lincoln Electric Service Manual eBook Subscription Services
  - Lincoln Electric Service Manual Budget-Friendly Options

6. Navigating Lincoln Electric Service Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Lincoln Electric Service Manual Compatibility with Devices
  - Lincoln Electric Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Lincoln Electric Service Manual
  - Highlighting and Note-Taking Lincoln Electric Service Manual
  - Interactive Elements Lincoln Electric Service Manual
8. Staying Engaged with Lincoln Electric Service Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Lincoln Electric Service Manual
9. Balancing eBooks and Physical Books Lincoln Electric Service Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Lincoln Electric Service Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Lincoln Electric Service Manual
  - Setting Reading Goals Lincoln Electric Service Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Lincoln Electric Service Manual
  - Fact-Checking eBook Content of Lincoln Electric Service Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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