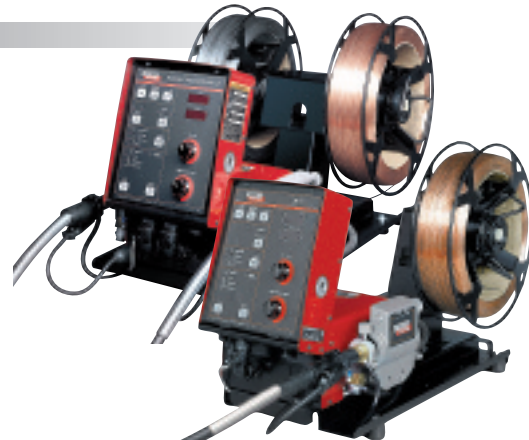


# LN-10 & DH-10

## Single and Double Header Wire Feeders

The LN-10 and the Double Header DH-10 wire feeders are available in both bench and boom mounted versions. The unique and creative modular designs of the LN-10 and DH-10 give the system maximum versatility in today's demanding industrial welding environment.

The LN-10 and DH-10 bench models are ideal for mounting on top of the power source, onto a portable undercarriage (LN-10 only), or hung from a jib crane or boom. The LN-10 and DH-10 boom models are designed specifically for boom or fixture mounting directly from the factory.



(Wire and guns not included.)

Output



Input



### Processes

MIG, Flux-Cored, Pulsed

### Advantage Lincoln

- Designed for feeding solid steel, flux-cored, metal-cored, stainless steel, low alloy, high alloy, aluminum and hardfacing wires.
- Rugged drive roll design with 4 rolls for positive wire feeding.
- Presettable voltage and wire feed speed using large control knobs allows easy adjustment with a gloved hand.
- Two large, easy to read digital meters allow operators and welding supervisors to monitor the welding process from a distance.
- Voltmeter "holds" reading of actual welding voltage for 5 seconds after welding has stopped. Lets operator verify true procedures without added assistant.
- Standard dual procedure for both wire drives. Selectable at the control box unit, with the optional dual procedure switch, dual schedule Magnum® gun, or with the optional dual procedure remote control.
- Cold feed forward and reverse controls for safe wire loading/unloading.
- Selectable trigger control for standard 2 step, interlocking 4 step, spot weld and cold feed trigger control (ideal for booms where cold wire feeding can be done at the gun trigger.)
- Five welding process control and timer functions:
  - preflow gas timer
  - run-in wfs/voltage control
  - spot weld timer
  - burnback control
  - postflow gas timer
- Security features are available to limit welding procedures.
- Three-year warranty on parts and labor. Two-year extended warranty available in U.S.
- Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.

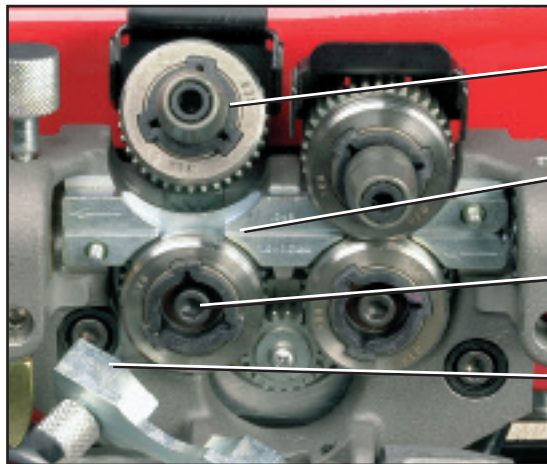
### TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)		H x W x D in. (mm)	Net Weight lbs. (kg)
					Solid	Cored		
LN-10 Bench Model	K1559-3	42 VAC 50/60 Hz 6 Amps	600A/60% 500A/100%	35-750 (0.8-19.0)	.023-3/32 (0.6-2.4)	.035-1/8 (0.9-3.2)	16 x 15 x 31 (406 x 381 x 787)	65 (29.5)
LN-10 Generic 16 Ft. Boom Package	K1564-4							
DH-10	K1499-3			21 x 20 x 32 (533 x 508 x 813)	98 (44.4)			
DH-10 Generic 16 Ft. Boom Package	K1521-7	35-750 (0.8-19.0)	.023-3/32 (0.6-2.4)			.030-1/8 (0.8-3.2)		
DH-10 (Std./High Speed)	K1499-4						Std: 35-750 (0.8-19.0) High: 55-1250 (1.3-31.7)	.023-3/32 (0.6-3.0) .023-1/16 (0.6-1.6)

NOTE: All units include 10 ft. (3.0 m) control cable. Boom packages also include a 25 ft. (7.6 m) control cable/welding cable (3/0) assembly.

**PERFORMANCE**

**Wire Drive System**



- A** Drive Rolls Flip Up for Easy Access
- B** Entire Wire Path is Visible for Easy Access
- C** Changable External Gear for Quick Speed Range Change
- D** Removable Outer Wire Guide for Easy Access to Wire. No Tools Required (Patented Split Wire Guide.)

- Four gear driven rolls with patent pending groove design. No tools needed to take rolls on or off. (Note: Some rolls have grooves of different sizes.)
- Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
- Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.
- User can change external speed range gear quickly. Feeder can be low speed/high torque or high speed. The standard speed model goes from 35-500 ipm with small pinion gear and 50-750 ipm with large pinion gear.
- Entire feed head can be removed for fast, easy servicing. Ideal for production shops where downtime must be minimized.
- Each side of the DH-10 wire drive system is driven by its own motor and gear box.
- Incoming guide bushing system is designed to accept wire guides, straighteners or conduits used with larger pay off wire packages.
- Simple drive roll pressure knob with indicator bar.
- Rugged electrically insulated door protects drive system with simple positive locking.
- Gun receiver bushings provide lower cost adapters for Magnum® or competitive guns. Easier interchangeability, better mechanical support and electrical current transfer.

FEATURES

DH-10 Control Box



LN-10 Wire Drive System



- E** Adjustable Cold Wire Feed
- F** Select Feed Head at Control or with a Trigger Pull (Not available on LN-10)
- G** Trigger Mode Selections
- H** Welding Process Control and Timer Functions
- J** Timer Select Key (Prewflow, Postflow, Spot and Burnback)
- K** Large, Easy to Use Wire Feed Speed Control
- L** Large, Easy to Use Voltage Control
- M** Dual Procedure Controls for Each Feeder
- N** Large, Easy to Read Digital Meters
- P** Standard Lincoln Electric® Trigger
- R** Electrically Insulated Door





*DH-10 Boom Model*

**CV-655/LN-10 Boom  
3/32 FCAW Welding System**

CV-655 (230/460/3/60)	K1480-1
LN-10 Generic 16 Ft. Boom Package	K1564-4
Drive Roll Kit - 3/32" Cored/Solid	KP1505-3/32
Magnum® 550 Gun, 15 ft., 5/64-3/32	K598-11
Magnum® 550 Gun Adapter	K1500-3
550 Connector Kit for 10 Series Feeders	K613-7
Ground Clamp	K910-2

**CV-655/DH-10 Boom  
.045 MIG and 3/32 FCAW Welding System**

CV-655 (230/460/3/60)	K1480-1
DH-10 Generic 16 Ft. Boom Package	K1521-7
Drive Roll Kit - .045" Solid	KP1505-045S
Drive Roll Kit - 3/32" Cored/Solid	KP1505-3/32
Magnum® 400 Gun Package, 15 ft., 035-045	K471-21
Magnum® 550 Gun, 15 ft., 5/64-3/32, 600A	K598-11
Magnum® 550 Gun Adapter	K1500-3
550 Connector Kit for 10 Series Feeders	K613-7
Deluxe Adjustable Gas Regulator & Hose (4.3 ft.) Kit	K586-1
Ground Clamp	K910-2

## RECOMMENDED OPTIONS

### For Connection Between Power Source and Wire Feeder Control Box (Only One Cable Needed. Included with all LN-10 and DH-10 units.)



#### Wire Feeder Control Cable

Male 14-pin to female 9-pin.  
10 ft. (3.0 m) length. (Included with each LN-10 and DH-10).  
Order K1501-10

### For Connection Between Control Box and Wire Drive (Boom Models Only.)

Male 14-pin to female 14-pin.  
Order K1785-12 for 12 ft. (3.6 m)  
Order K1785-16 for 16 ft. (4.8 m)  
Order K1785-25 for 25 ft. (7.6 m)  
Order K1785-50 for 50 ft. (15.2 m)



#### DRIVE ROLL & WIRE GUIDE KITS

Description	Order Number
<b>Solid Wire, Smooth V Groove:</b>	
.023-.030" (0.6-0.8 mm)	KP1505-030S
.035" (0.9 mm)	KP1505-035S
.040" (1.0 mm)	KP1505-040S
.045" (1.2 mm)	KP1505-045S
.052" (1.4 mm)	KP1505-052S
1/16" (1.6 mm)	KP1505-1/16S
<b>Cored Steel Wire, Knurled V Groove:</b>	
.030-.035" (0.8-0.9 mm)	KP1505-035C
.040-.045" (1.0-1.2 mm)	KP1505-045C
.052" (1.4 mm)	KP1505-052C
1/16" (1.6 mm)	KP1505-1/16C
7/64" (2.8 mm) Hardfacing	KP1505-7/64H
<b>Cored or Solid Steel Wire, Knurled V Groove:</b>	
.068-.072" (1.8 mm)	KP1505-068
5/64" (2.0 mm)	KP1505-5/64
3/32" (2.4 mm)	KP1505-3/32
7/64" (2.8 mm) Cored	KP1505-7/64
.120" (3.2 mm) Cored	KP1505-120
<b>Aluminum Wire, Smooth U Groove:</b>	
.035" (0.9 mm)	KP1507-035A
.040" (1.0 mm)	KP1507-040A
3/64" (1.2 mm)	KP1507-3/64A
1/16" (1.6 mm)	KP1507-1/16A
3/32" (2.4 mm)	KP1507-3/32A

#### WELD POWER CABLES

Connection	Description	Order Number
Twist-Mate™ to Lug	1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
Twist-Mate™ to Twist-Mate™	1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
	2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50
Lug to Lug	3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)	K1842-10
	3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)	K1842-35
	3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)	K1842-60
	4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)	K1842-110

#### CONTROL EXTENSION CABLES

Order Number	Description
<b>Wire Feeder Control Extension Cables</b>	
K1797-10 - 10 ft. (3.0 m)	Male 14-pin to female 14-pin
K1797-25 - 25 ft. (7.6 m)	
K1797-50 - 50 ft. (15.2 m)	
K1797-100 - 100 ft. (30 m)	

**RECOMMENDED OPTIONS**

**FEED PLATE GUN RECEIVER BUSHINGS**

<b>K1500-1 Gun Receiver Bushing (Optional)</b>	<b>K1500-2 Gun Receiver Bushing (Standard)</b>	<b>K1500-3 Gun Receiver Bushing (Optional)</b>	<b>K1500-4 Gun Receiver Bushing (Optional)</b>	<b>K1500-5 Gun Receiver Bushing (Optional)</b>	<b>K489-7 Fast-Mate™ Gun Receiver Bushing (Optional)</b>
<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®<sup>(1)</sup> #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®<sup>(1)</sup> #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®<sup>(2)</sup> 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>



<sup>(1)</sup> Tweco is a registered trademark of Thermadyne.

<sup>(2)</sup> OXO is a registered trademark of OXO International.

**GENERAL OPTIONS**



**Wire Straightener**  
Straightens wire for better, smoother feeding.  
**Order K1733-1**



**Remote Switch Interface Kit**  
Single input/output switch module for each LN-10 & DH-10 wire drive. Allows for control of wire feeder and external devices.  
**Order K1558-1**



**Water Connection Kit**  
Includes quick connect fittings on front and back of wire drive for use with water-cooled guns and Magnum® Coolers. Kit provides for one gun.  
**Order K590-6**

**GENERAL OPTIONS CONT.**



**Control Cable to Terminal Strip Adapter**  
Connects 14-pin control cable to power sources with terminal strip.  
**Order K1798**



**Wire Feed Control Cable**  
Male 14-pin to female 9-pin. 10 ft. (3.0 m) length. (Included with each LN-10 and DH-10).  
**Order K1501-10**



**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**

**GENERAL OPTIONS**



**Insulated Lift Bail**  
Allows the entire wire feeder to be hung from a crane or hook. (For LN-10 only).  
**Order K1555-1**



**Caster Kit — Light Duty**  
Mounts to the Heavy Duty Wire Reel Stand. Allows for easy movement of wire feeder. (For LN-10 only).  
**Order K1556-1**



**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. (For LN-10 only).  
**Order K1557-1**



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



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



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



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



**Undercarriage**  
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stands. For LN-10 only.  
**Order K163**

**GENERAL OPTIONS CONT.**



**Inverter and Wire Feeder Cart**  
Rear-wheeled cart includes front casters and no-lift gas bottle platform. Convenient handles allow for easy cable storage while full length side trays store parts and tools. Shipped fully assembled. Small footprint fits through 30 inch door.  
**Order K1764-1**



**22-30 lb. Readi-Reel® Adapter**  
Adapts 22-30 lb. (10-14 kg) Lincoln Readi-Reels® of electrode to 2" (51 mm) spindle.  
**Order K363P**



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



**Dual Procedure Switch**  
Allows the use of two welding procedures with one Lincoln® Magnum® gun. 15 ft. (4.5 m).  
**Order K683-3**



**Incoming Bushings for Lincoln® Conduit**  
Connects directly to Magnum® plastic conduit (not included), for use in boom systems, long distances, or large payoff packages.  
**Order K1546-1** for .025-1/16"  
**Order K1546-2** for 1/16-1/8"

**LN-10 & DH-10 WIRE FEEDERS ORDER FORM**

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
<b>LN-10 Bench Model (Standard Speed)</b>	<b>K1559-3</b>		
<b>LN-10 Generic Boom Package</b>	<b>K1564-4</b>		
<b>DH-10 (Std./Std. Speed)</b>	<b>K1499-3</b>		
<b>DH-10 Generic Boom Package</b>	<b>K1521-7</b>		
<b>DH-10 (Std./High Speed)</b>	<b>K1499-4</b>		
<b>Recommended Options</b>			
Wire Straightener	K1733-1		
Remote Switch Interface Kit	K1558-1		
Water Connection Kit	K590-6		
Control Cable to Terminal Strip Adapter	K1798		
Wire Feed Control Cable	K1501-10		
115V/42V Transformer Kit	K1520-1		
Insulated Lift Bail	K1555-1		
Caster Kit-Light Duty	K1556-1		
Swivel Platform	K1557-1		
50-60 lb. Coil Adapter	K1504-1		
Wire Reel Cover Kit	K1634-1		
Plastic Wire Cover Kit	K1634-2		
14 lb. Innershield® Coil Adapter	K435		
Undercarriage	K163		
Inverter and Wire Feeder Cart	K1764-1		
22-30 lb. Readi-Reel® Adapter	K363P		
50-60 lb. Readi-Reel® Adapter	K438		
Dual Procedure Switch	K683-3		
Incoming Bushings for Lincoln® Conduit- for .025-1/16"	K1546-1		
Incoming Bushings for Lincoln® Conduit- for 1/16-1/8"	K1546-2		
	<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 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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