

LINC FEED

22M, 24M & 24M PRO

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Spare Parts

SP50156/50196/50197 Rev. 2
07/03

LINC FEED 22M, 24M & 24M PRO

ASSEMBLY PAGE NAME			Machine Assembly	Panel Assembly	Rear Panel Assembly	Wire Drive Assembly LF 22M	Wire Drive Assembly LF 24M / LF 24M PRO		
CODE NO.:	K NO.:	FIGURE NO.:	A	B	C	D	E		
50196	K14064-1	LINC FEED 22M	1	1	1	1	-		
50197	K14065-1W	LINC FEED 24M	2	2	2	-	1		
50156	K14066-1W	LINC FEED 24M PRO	3	3	3	-	1		

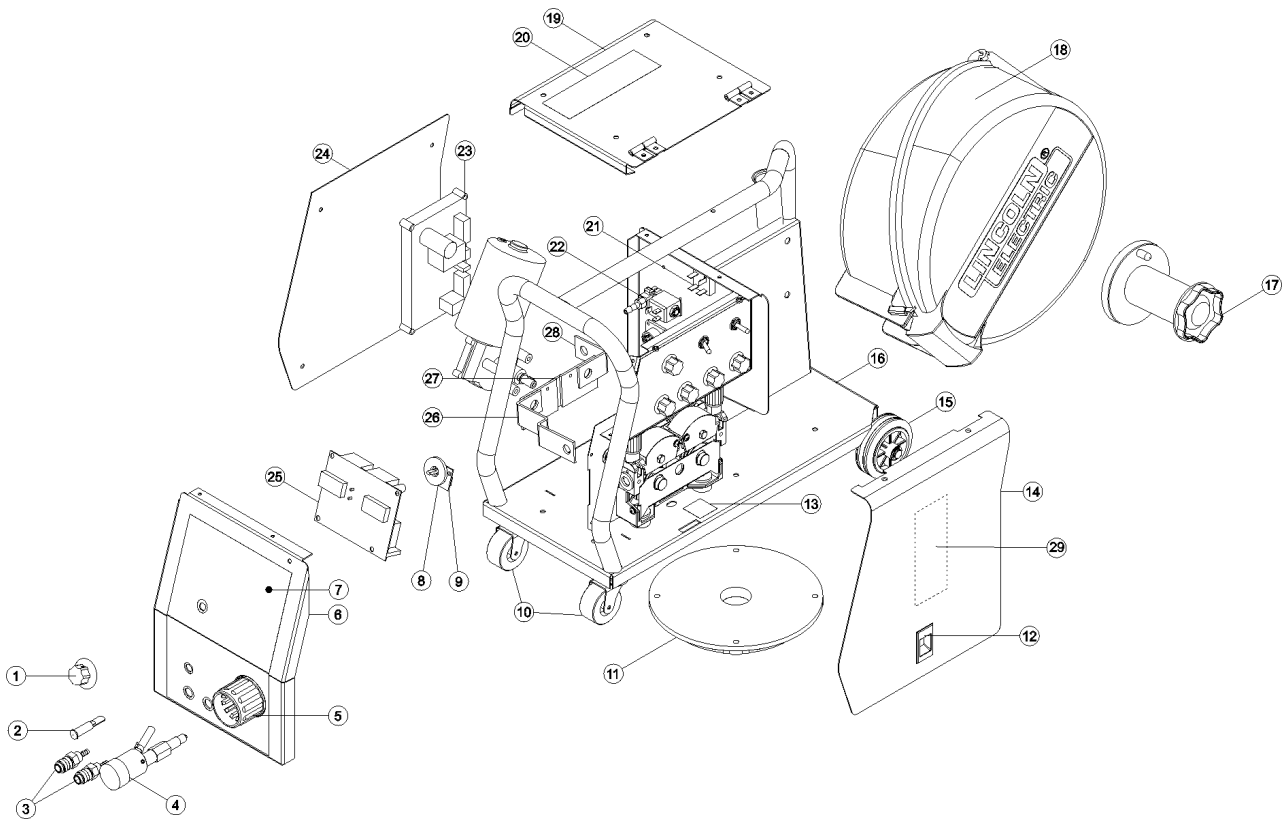
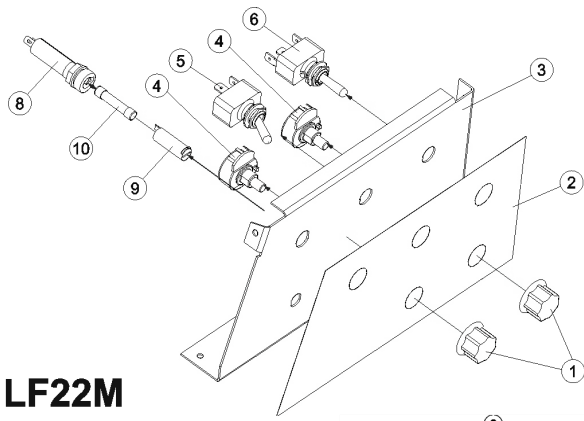


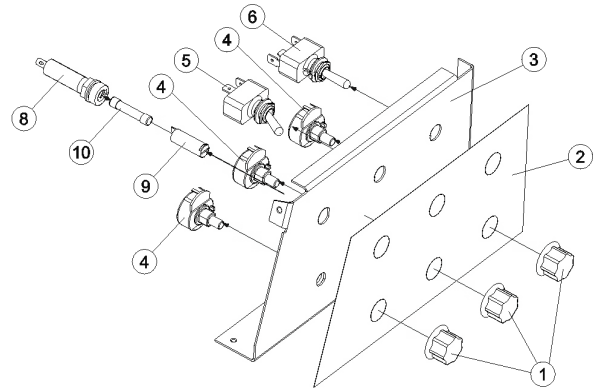
Figure A

Figure A: Machine Assembly

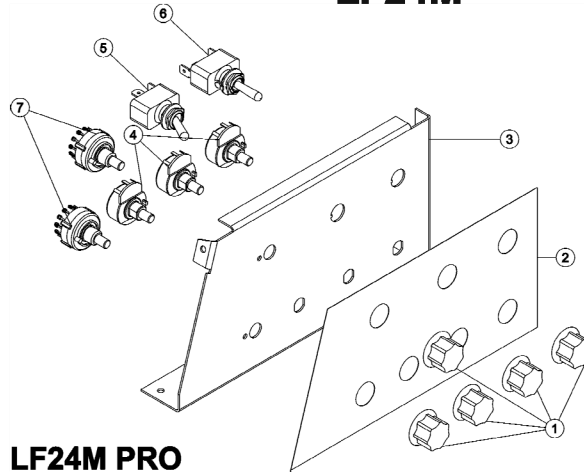
Item	Description	Part Number	QTY	1	2	3	4	5
1	KNOB FI38	9ET10491R	1	X	X	X		
2	LAMP	0917-421-024R	1	X	X	X		
3	QUICK COUPLING	0744-000-152R	2	•	X	X		
4	EURO SOCKET	R-8040-140-3R	1	•	X	X		
	EURO SOCKET	R-8040-042-3R	1	X	•	•		
5	EURO SLEEVE	1361-599-708R	1	X	X	X		
6	FRONT PANEL	R-3019-154-1/08R	1	•	•	X		
	FRONT PANEL	R-3019-154-3/08R	1	•	X	•		
	FRONT PANEL	R-3019-154-2/08R	1	X	•	•		
7	LABEL (22M)	R-0010-247-1R	1	X	•	•		
	LABEL (24M)	R-0010-248-1R	1	•	X	•		
	LABEL (24M PRO)	R-0010-249-1R	1	•	•	X		
8	WASHER	0744-200-041R	1	X	X	X		
9	PC BOARD PD5	0918-432-073R	1	•	•	X		
	POTENTIOMETR	1158-113-304R	1	X	X	•		
10	CASTER	1029-660-003R	2	X	X	X		
11	ROTARY BRACKET	1361-598-180R	1	X	X	X		
12	BOLT	0654-610-004R	1	X	X	X		
13	LABEL	2719-107-732R	1	X	X	X		
14	SIDE PANEL	R-1019-224-1R	1	X	X	X		
15	WHEEL PG80	1029-660-081R	2	X	X	X		
16	RACK	R-3019-156-1/08R	1	X	X	X		
17	REEL HUB STANDARD	0744-000-192R	1	X	X	X		
	FASTENING CUP	B11035-1	1	X	X	X		
18	SPOOL COVER	0749-901-003R	1	X	X	X		
19	COVER	R-3019-162-1/02R	1	X	X	X		
20	WARNING LABEL	2719-107-728R	1	X	X	X		
21	BRIDGE RECTIFIER	1156-112-044R	1	•	•	X		
22	SOLENOID GAS SWITCH	0972-423-002R	1	X	X	•		
22	SOLENOID GAS SWITCH	0972-423-038R	1	•	•	X		
23	PC BOARD G4560	C-3731-399-3R	1	•	•	X		
	PC BOARD US-69-6	Y024-6R	1	X	•	•		
	PC BOARD US-69 2	Y024-2R	1	•	X	•		
24	SIDE PANEL	R-1019-225-1R	1	X	X	X		
25	PC BOARD US67	C-3731-400-2R	1	•	•	x		
	PC BOARD WAV1	0918-432-006R	1	•	X	•		
26	CONTACT RAIL	R-1010-038-1R	1	•	X	X		
	CONTACT RAIL	R-1010-008-1R	1	X	•	•		
27	SHUNT	0941-712-026R	1	X	X	X		
28	CONTACT RAIL	R-1010-036-1R	1	•	X	X		
	CONTACT RAIL	R-1010-041-1R	1	X	•	•		
29	LABEL	R-0010-341-1R	1	•	•	X		



LF22M



LF24M



LF24M PRO

Figure B

Figure B: Panel Assembly

Item	Description	Part Number	QTY	1	2	3	4	5
1	KNOB FI25	9ET13639-3R	2	X	•	•		
	KNOB FI25	9ET13639-3R	3	•	X	•		
	KNOB FI25	9ET13639-3R	5	•	•	X		
2	LABEL	R-0010-278-1R	1	X	•	•		
	LABEL	R-0010-277-1R	1	•	X	•		
	LABEL	R-0010-252-1R	1	•	•	X		
3	DIVIDER	R-1019-209-1/08R	1	X	•	•		
	DIVIDER	R-1019-208-1/08R	1	•	X	•		
	DIVIDER	R-1019-181-1/08R	1	•	•	X		
4	POTENTIOMETR	1158-113-304R	2	X	•	•		
	POTENTIOMETR	1158-113-304R	3	•	X	X		
5	SWITCH 2FA53-73	1158-650-021R	1	X	X	X		
6	SWITCH 6FC53-73	1158-650-022R	1	X	X	X		
7	SWITCH PRS	D-4542-012-2R	2	•	•	X		
8	FUSE SOCKET	1158-632-032R	1	X	X	•		
9	CAP	1158-632-033R	1	X	X	•		
10	FUSE	1158-660-084R	1	X	X	•		

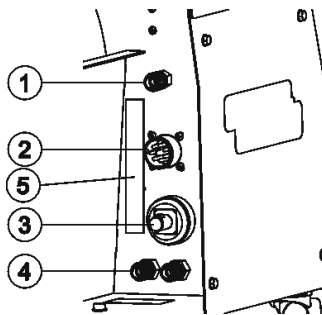


Figure C

Figure C: Rear Panel Assembly

Item	Description	Part Number	QTY	1	2	3	4	5
1	QUICK CONNECT COUPLING	0744-000-149R	1	X	X	X		
2	SOCKET X11	1158-641-129R	1	X	X	X		
3	SOCKET X5	D-2985-002-1R	1	X	X	X		
4	QUICK CONNECT COUPLING	0744-000-152R	2	•	X	X		
5	LABEL	R-0010-354-1R	1	X	X	X		

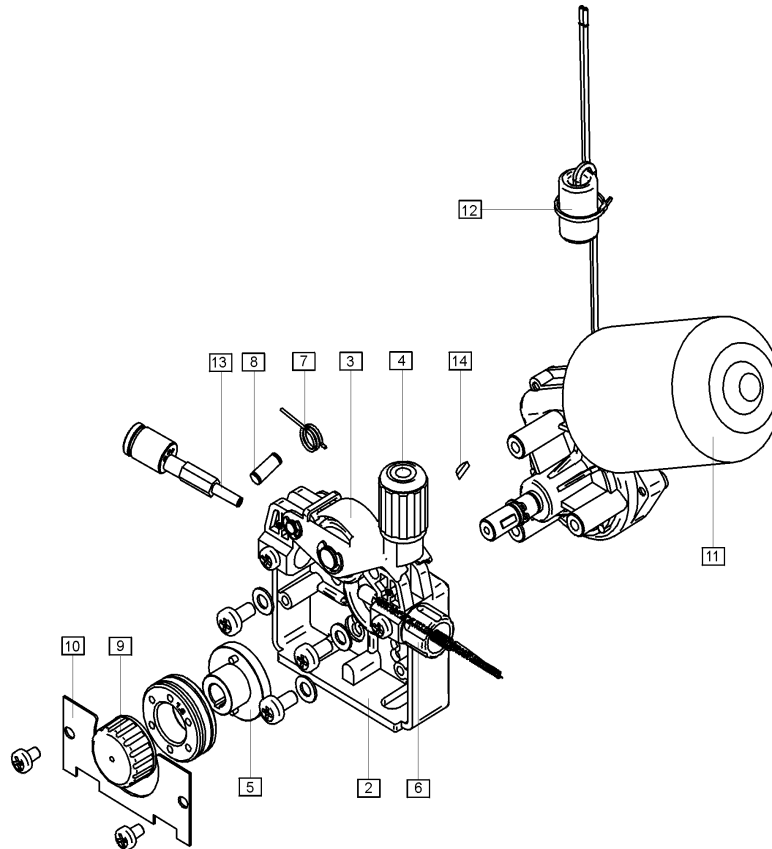


Figure D

Figure D: Wire Drive Assembly LF 22M

Item	Description	Part Number	QTY	1	2	3	4	5
1	WIRE FEEDER COMPLETE	0744-000-166R	1	X				
2	FEED PLATE	0646-231-123R	1	X				
3	PRESSURE ARM COMPLETE	0646-231-096R	1	X				
4	FIXING ARM COMPL.	0646-231-097R	1	X				
5	ADAPTER COPL.	0744-000-194R	1	X				
6	INLET GUIDE COMPLETE	0744-000-193R	1	X				
7	SPRING PRESSURE ARM	0646-231-125R	1	X				
8	AXIS PRESSURE ARM	0646-231-120R	1	X				
9	FIXING CAP	0744-000-195R	1	X				
10	METAL COVER	0646-231-127R	1	X				
11	D.C. MOTOR	1111-722-045R	1	X				
12	FERRITE TUBE	1158-290-036R	1	X				
13	WIRE GUIDE TUBE	D-1829-066-4R	1	X				
14	WOODRUFF KEY	0646-231-102R	1	X				

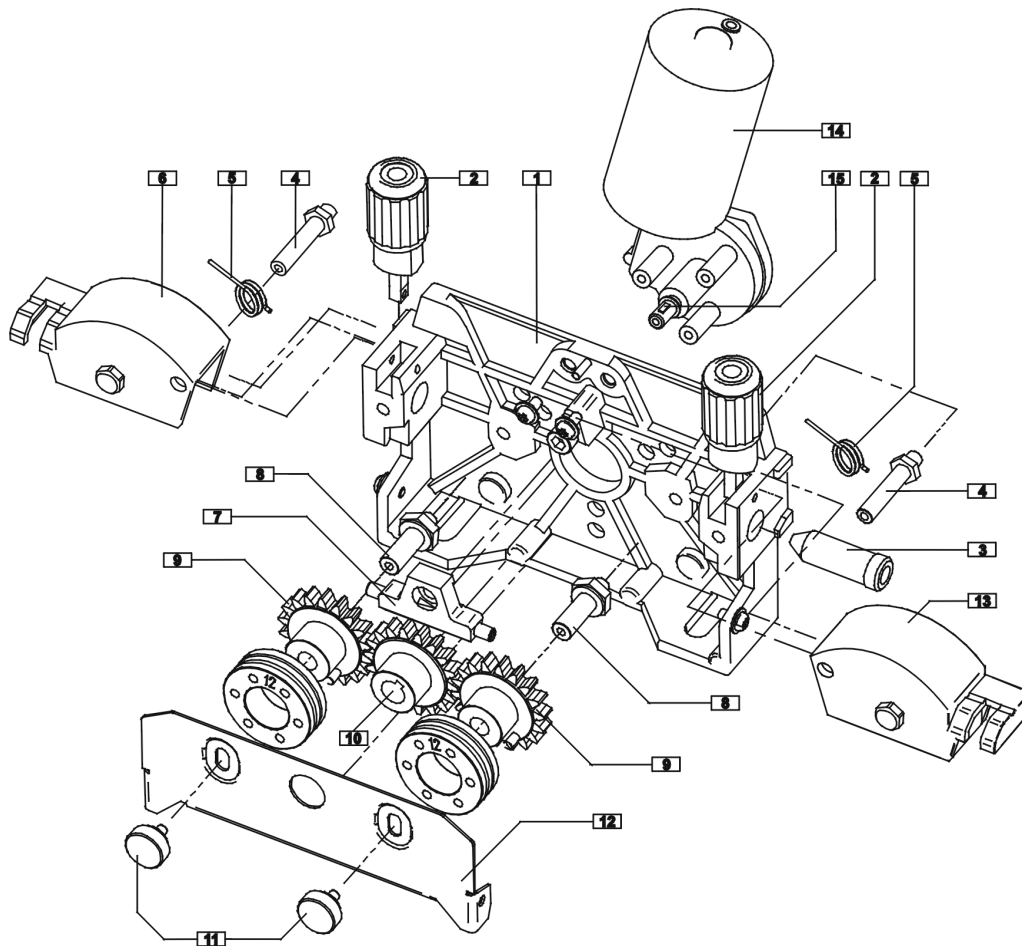
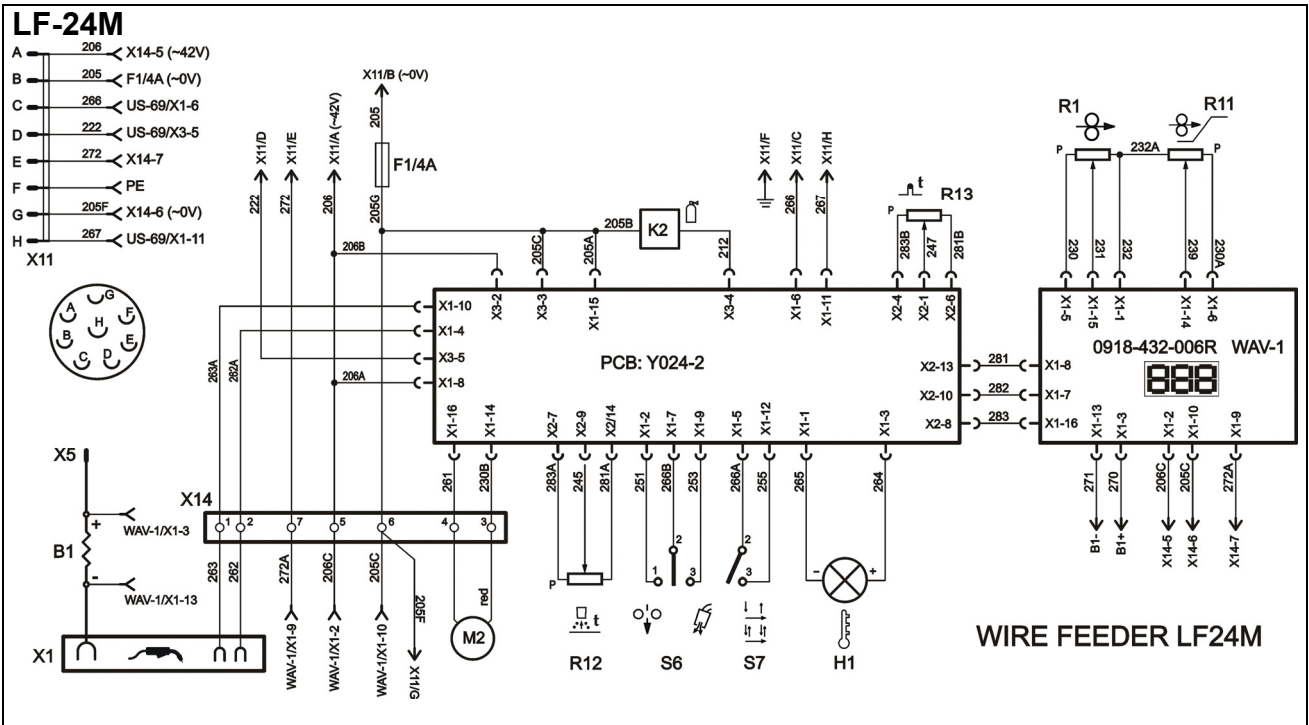
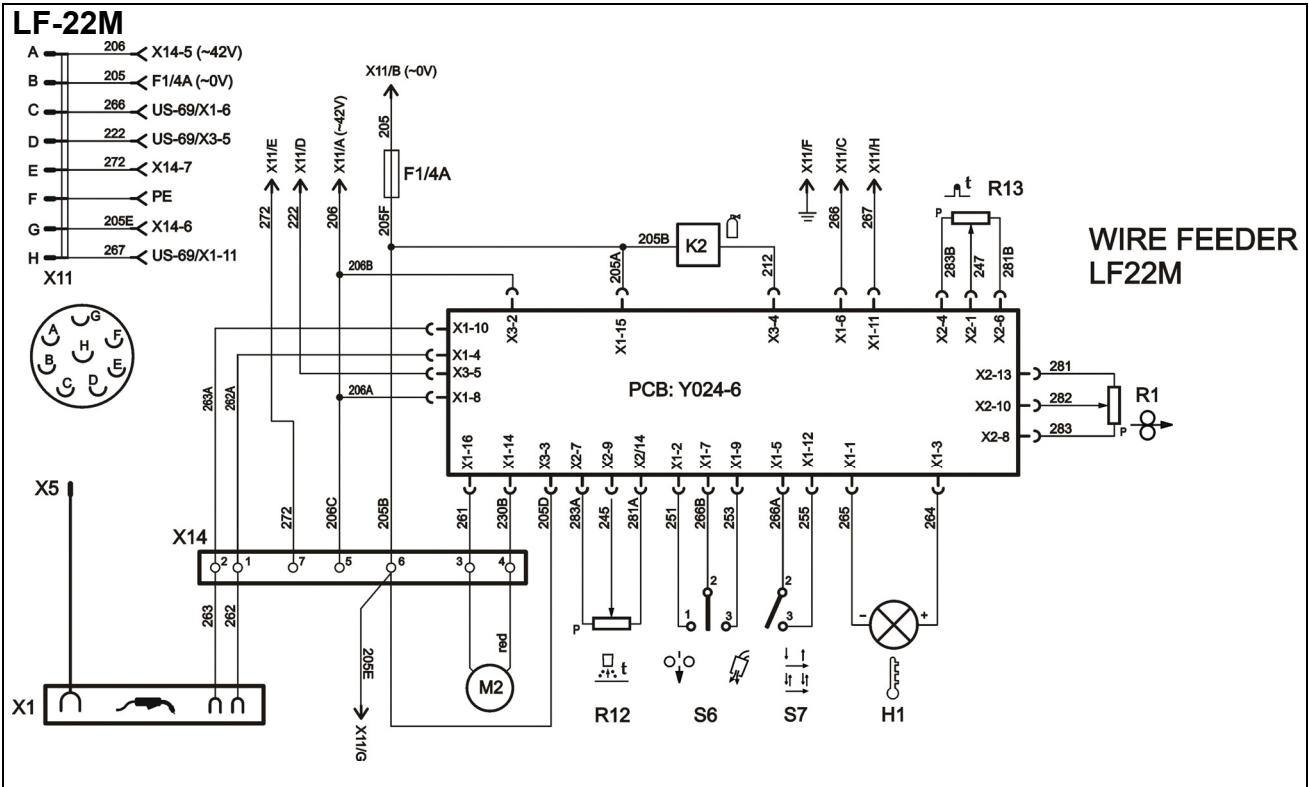


Figure E

Figure E: Wire Drive Assembly LF 24M / LF24M PRO

Item	Description	Part Number	OLD Part Number	QTY	1	2	3	4	5
	WIRE FEEDER COMPL.	0744-000-241R		1	X				
1	FEED PLATE	0646-233-002R	S51997-1	1	X				
2	FIXING ARM COMPL.	0646-233-015R		2	X				
3	INLET GUIDE	0646-233-025R	T51125	1	X				
4	AXIS PRESSURE ARM	0646-233-003R	S51997-2	2	X				
5	SPRING PRESSURE ARM	0646-233-013R	S51997-12	2	X				
6	PRESSURE ARM COMPL.L	0646-233-007R	S51997-5	1	X				
7	INTERMEDIATE GUIDE	0646-233-023R	T51126	1	X				
8	AXIS DRIVE ROLL	0646-233-020R	S51997-19	2	X				
9	GEAR WHEEL ROLL	0646-231-090R	S51889-2	2	X				
10	GEAR WHEEL MOTOR	0646-233-028R	S51888	1	X				
11	FIXING CAP	0646-233-022R	S51997-20	2	X				
12	METAL COVER	0646-233-027R	S51997-23	1	X				
13	PRESSURE ARM COMPL.R	0646-233-005R	S51997-4	1	X				
14	MOTOR -28V	1111-722-047R	L12073	1	X				
15	WOODRUFF KEY	0646-231-102R		1	X				

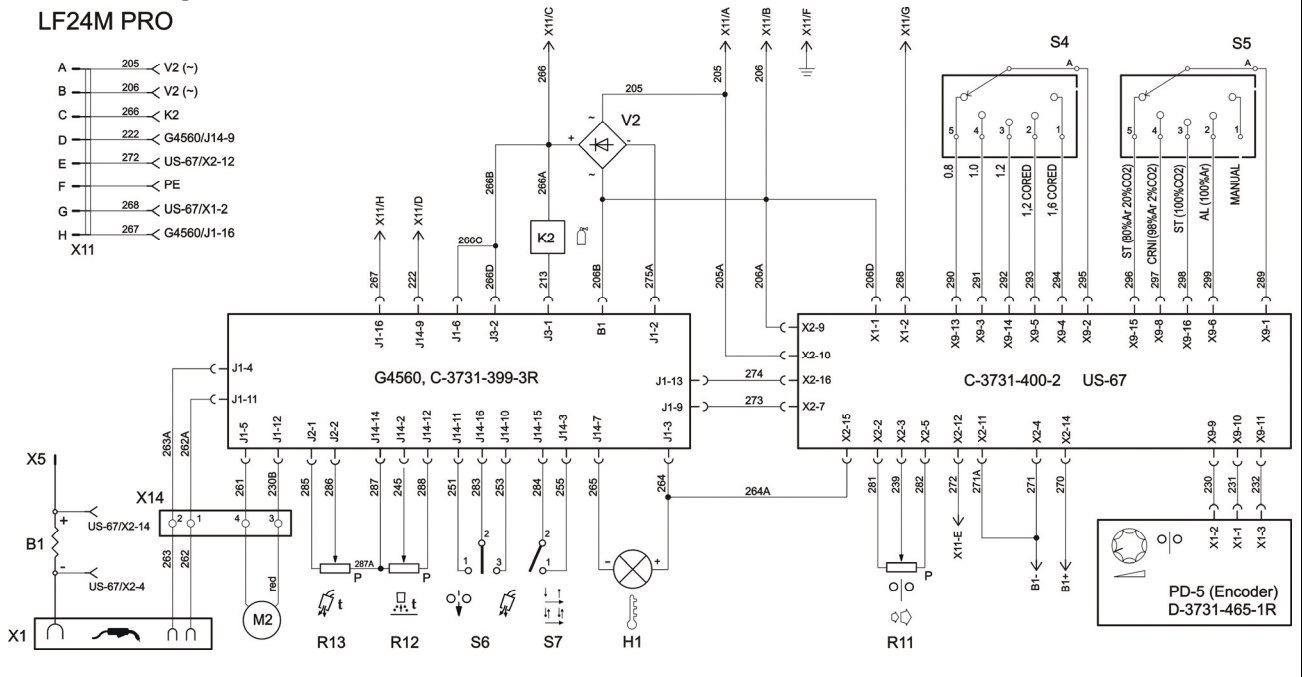
Electrical Schematic



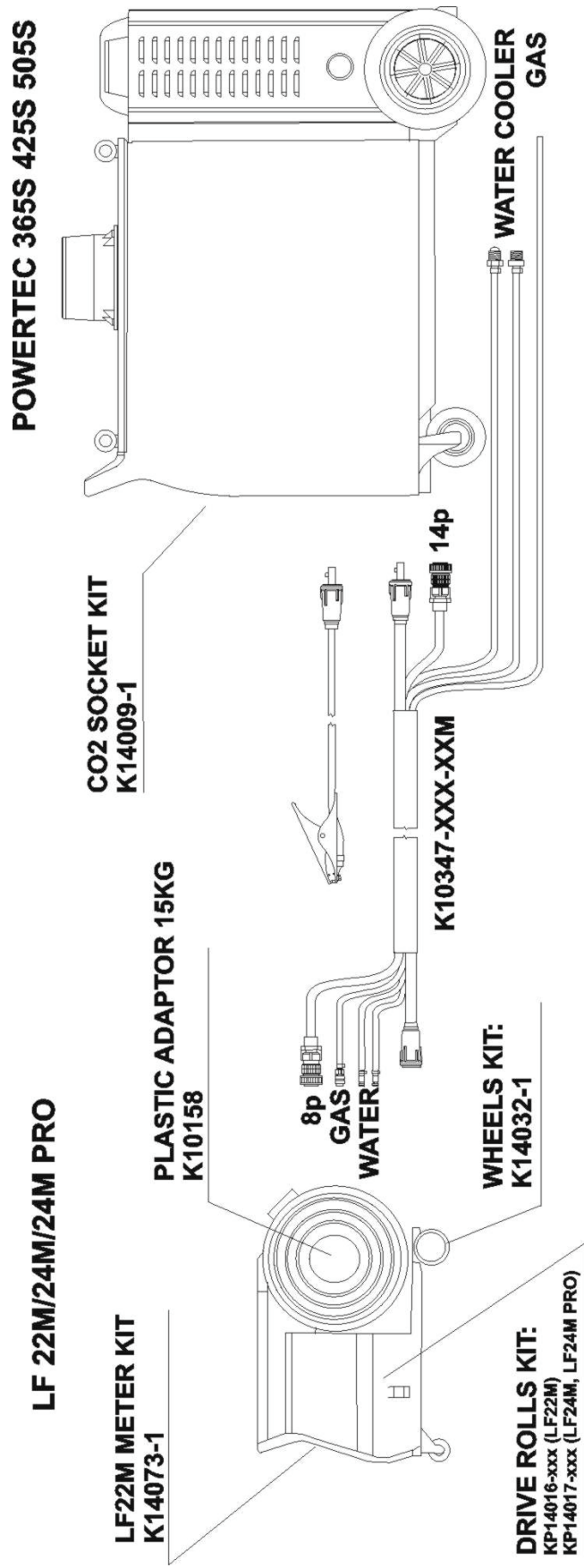
LF-24M PRO

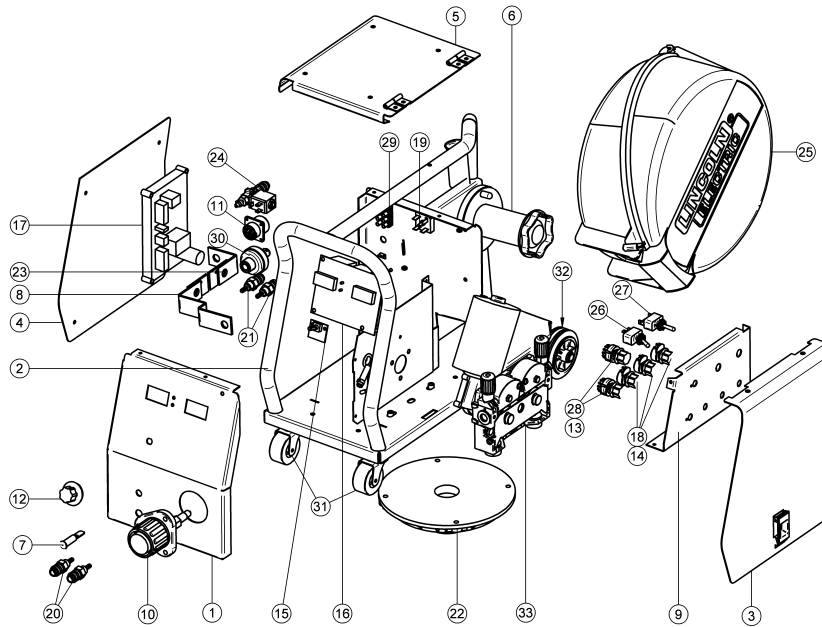
LF24M PRO

- A 205 V2 (-)
- B 206 V2 (-)
- C 266 K2
- D 222 G4560/J14-9
- E 272 US-67/X2-12
- F PE
- G 268 US-67/X1-2
- H 287 G4560/J1-16



LF 22M code 50196 LF 24M code 50197 & LF 24M PRO code 50156 Connection Diagram





Ref.	Recycle				ST				
	Fe	Al	Cu	Brass	Boards	Plastics	Liquid Cristal	External Electric Cables	Capacitors
Front Panel Assembly	1	X							
Rack Assembly	2	X							
Right Side Access Panel	3	X							
Left Side Panel	4	X							
Top Panel Assembly	5	X							
Brake	6					X			
Colorless Lamp	7			X		X			
Conductor Rail	8		X						
Cover	9	X							
Euro Connector Assembly	10			X		X			
Gas Heater Socket	11	X							
Knob	12,13,14					X			
P.C.Board Assembly OP-19	15			X	X				
P.C.Board Assembly	16, 17				X	X			
Potentiometers	18	X		X					
Rectifier Bridge	19	X							
Reinforced Hoses	20, 21		X	X					
Rotary Bracket	22					X			
Shunt	23		X						
Solenoid Valve	24		X	X					
Spool Cover	25					X			
Switches	26, 27, 28	X		X					
Terminal Blocks	29	X		X		X			
Welding Socket	30			X		X			
Wheels	31, 32	X				X			