

Lincoln Electric KP653-035S

Lincoln Electric KP653-035S Drive Roll Kit Instruction Manual

1. INTRODUCTION

This manual provides essential information for the proper installation, operation, and maintenance of the Lincoln Electric KP653-035S Drive Roll Kit. This kit is designed for feeding .035 inch (0.9 mm) solid welding wire in compatible MIG welding machines. Adhering to these instructions will help ensure optimal performance and longevity of the components.

2. PRODUCT OVERVIEW AND COMPONENTS

The KP653-035S Drive Roll Kit includes the necessary components for precise feeding of .035 inch (0.9 mm) solid welding wire. The kit typically consists of a drive roll and a guide tube.



This image displays the components of the Lincoln Electric KP653-035S Drive Roll Kit. It includes a metal drive roll with '0.9-0.35' and '0.035' markings, a brass guide tube with a white plastic tip, another brass guide tube with a pointed end and a black O-ring, and a C-shaped brass retaining clip.

- **Drive Roll:** A grooved wheel that grips the welding wire and pushes it through the welding gun. The grooves are specifically sized for .035 inch (0.9 mm) solid wire.
- **Guide Tube:** Directs the welding wire from the spool to the drive roll, ensuring smooth and consistent feeding.

3. SETUP AND INSTALLATION

Proper installation of the drive roll kit is crucial for reliable wire feeding. Always refer to your specific MIG welder's instruction manual for detailed steps on accessing and replacing drive roll components. Ensure the welding machine is disconnected from the power source before performing any installation or maintenance.

1. **Power Disconnection:** Turn off and unplug the welding machine from the power outlet.
2. **Access Drive Roll Area:** Open the wire feeder compartment door on your MIG welder.
3. **Remove Existing Components:** If replacing an old kit, carefully remove the existing drive roll and guide tube. Note their orientation for correct installation of the new components.
4. **Install Guide Tube:** Insert the new guide tube into its designated slot, ensuring it is seated correctly to align with the wire path.
5. **Install Drive Roll:** Place the .035 inch (0.9 mm) drive roll onto the drive shaft. Ensure the correct groove for solid wire is aligned with the wire path. The markings on the drive roll typically indicate the wire size.
6. **Secure Components:** Secure the drive roll and guide tube according to your welder's design, often involving a retaining clip or lever.

7. **Close Compartment:** Close the wire feeder compartment door.

4. OPERATION

Once installed, the drive roll kit facilitates the feeding of .035 inch (0.9 mm) solid welding wire. Ensure the wire tension is correctly set on your welding machine. Too little tension can cause wire slippage, while too much tension can deform the wire or damage the drive motor. Adjust tension until the wire feeds smoothly without slipping or deforming.

5. MAINTENANCE

Regular maintenance of the drive roll kit ensures consistent wire feeding and extends the life of the components.

- **Inspection:** Periodically inspect the drive roll grooves for wear, debris, or damage. Worn grooves can lead to inconsistent wire feeding.
- **Cleaning:** Clean the drive roll and guide tube regularly to remove any accumulated dust, metal particles, or wire coating residue. Use a clean, dry cloth or compressed air.
- **Replacement:** Replace the drive roll and guide tube if they show signs of significant wear, damage, or if wire feeding issues persist despite proper cleaning and tension adjustment.

6. TROUBLESHOOTING

If you experience issues with wire feeding, consider the following common troubleshooting steps:

- **Inconsistent Wire Feed:** Check drive roll tension. Ensure the drive roll grooves are clean and not worn. Verify the guide tube is clear of obstructions.
- **Wire Slipping:** Increase drive roll tension slightly. Inspect drive roll for wear or contamination.
- **Wire Deforming/Flattening:** Reduce drive roll tension. Ensure the correct drive roll groove is being used for the wire size.
- **Wire Tangling:** Check for proper spool tension. Ensure the guide tube is correctly aligned and free of bends or damage.

If problems persist, consult your welding machine's manual or contact Lincoln Electric customer support.

7. SPECIFICATIONS

Specification	Detail
Part Number	KP653-035S
Wire Type Compatibility	Solid Wire
Wire Diameter Compatibility	.035 inch (0.9 mm)
Kit Contents	2 Roll Kit (Drive Roll and Guide Tube)
Material	Alloy Steel
Item Weight	5.6 ounces

Specification	Detail
Product Dimensions	6 x 1 x 1 inches
Manufacturer	Lincoln Electric

8. WARRANTY AND SUPPORT

For information regarding product warranty, technical support, or service, please refer to the official Lincoln Electric website or contact their customer service department directly. Warranty terms and conditions may vary.

Visit the [Lincoln Electric Store](#) for more products and information.

Related Documents - KP653-035S

	Lincoln Electric POWER MIG® 210 MP Operator's Manual Comprehensive operator's manual for the Lincoln Electric POWER MIG® 210 MP welding machine, covering product description, specifications, installation, operation, maintenance, and troubleshooting. Includes safety guidelines for MIG, FCAW, GTAW, and SMAW welding processes.
	Lincoln Electric Ranger 250 GXT: Powerful Welder and Generator Discover the Lincoln Electric Ranger 250 GXT, a versatile AC/DC welder and 11,000-watt generator designed for construction and maintenance. Features include Stick, TIG, MIG, and flux-cored welding capabilities, a 23 HP Kohler engine, and rugged reliability.
	Lincoln Electric Power Wave C300: Portable Multi-Process Welder Specifications and Features Detailed overview of the Lincoln Electric Power Wave C300, a portable multi-process wire feeder welder. Features, key controls, processes, and technical specifications for production welding, fabrication, and training.
	Lincoln Electric SPEEDTEC 180C & 200C Operator's Manual Comprehensive operator's manual for Lincoln Electric SPEEDTEC 180C and 200C welding machines, detailing technical specifications, safety guidelines, installation, operation procedures, maintenance, and accessories.



[pdf] Troubleshooting Guide Guide Warranty Catalog

BK291 BK 291 Countertop Parts Guide Replacements Service parts for helmets gun consumables guns

torches drive rolls clamps stingers and cables bk291 guide countertop tips nozzles replacement KP 9S

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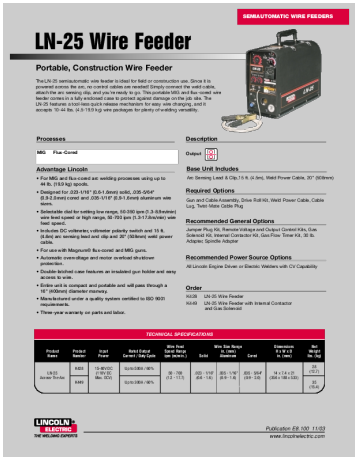
BK291 2014 Welding Cutting Solutions Parts Guide www.lincolnelectric.com/locator

WELDING PROTECT ... 9-1 KP2125-1 KP2124-1 .035 Knurled KP653-035C KP2139-

3 KP2125-1 KP2124-1 .035 V-groove **KP653-035S** KP2139-3 KP2125-1 KP2124-1

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Semiautomatic Wire Feeders LN 25 MIG welding flux cored portable e8100 Info lincolnelectric 80 assets

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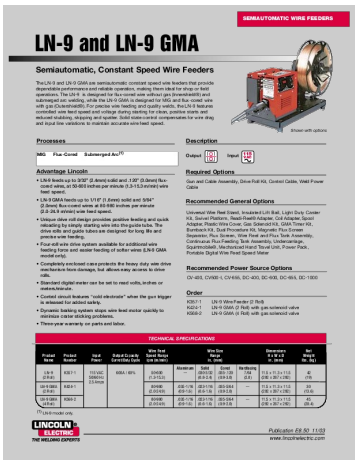
LN-25 Wire Feeder Portable, Construction Wire Feeder The LN-25 semiautomatic

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Order Number KP653-025S KP653-030S **KP653-035S** KP653-052S KP653-035C

KP653-052C KP653-1/16 KP653-3/32 KP654-035A KP654-3/64A KP654-1/16A...

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[pdf] User Manual

Semiautomatic Wire Feeders LN 9 and GMA MIG welding flux cored submerged arc Red D Arc

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K161 Power Pack drive unit Order K110 Spec Sheet red d

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Ranger 250 LPG 250 Amp DC LPG Engine Driven Welder The Ranger 250 LPG is ready for a workout -- al ... r Kit Drive Roll and Guide Tube Kit for LN-25 For .035-.040 0.9-1.0 mm solid steel wire. Order **KP653-035S** Drive Roll and Wire Guide Kit for LN-15 For .035 0.9 mm solid steel wire. Order KP16...

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IM-202

June, 2002

LN-742 & LN-742H Wire Feeders

This manual contains important safety information which must be read and understood by all operators before attempting to install or operate this equipment.

Safety Depends on You

LINCOLN ELECTRIC is constantly working to improve its products and designs and will share with safety in mind. However, your overall safety will be determined by proper installation, and thoughtful and responsible operation on your part. DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT FIRST READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THEREIN. Always use caution, wear eye protection, lock-out/tag-out procedures and first aid kit.

Date of Purchase _____

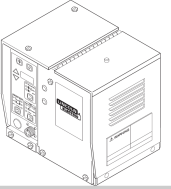
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OPERATOR'S MANUAL

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IM502-A LN-742 LN-742H

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Invertek STT II

and WELDERS

Featuring the Surface Transfer Transfer® (STT) Process

The new Invertek STT II provides more consistent and predictable arc starting with the Surface Transfer Transfer® (STT) process. STT provides superior arc control and stability. STT can be used to allow the heat input of the arc to be adjusted to suit the application. STT can be used to produce a smooth, clean weld bead with a high level of control. STT can be used to produce a smooth, clean weld bead with a high level of control. STT can be used to produce a smooth, clean weld bead with a high level of control.

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Control Heat Input, Spatter and Fume The revolutionary STT II power source
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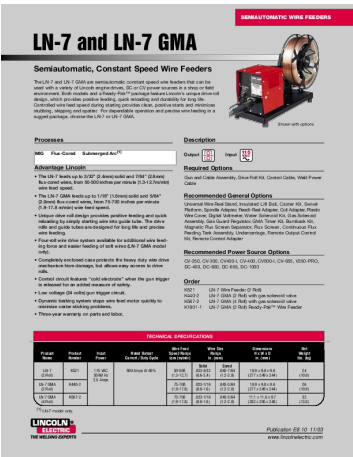
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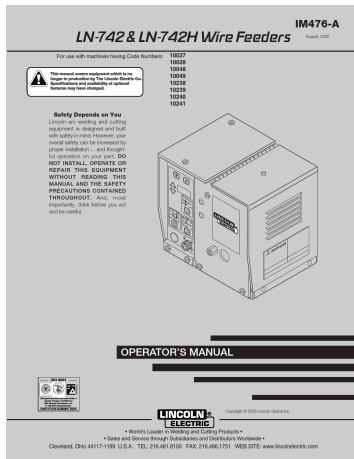
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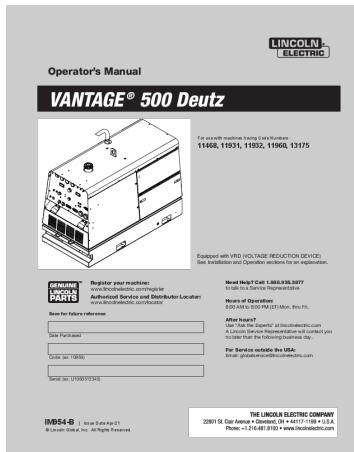
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IM476-A LN-742 LN-742H Wire Feeders August, 2005 For use with machines having Code Numbers: This ... 1.6 mm 3/64 in. 1.2 mm 0.035 in. 0.9 mm 2-Roll KP653-3/32C KP653-1/16 KP653-052S KP653-052C **KP653-035S** KP653-035C KP653-030S KP653-025S KP654-1/16A KP654-3/64A KP654-035A 4-Roll KP655-3/32C K...

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IM954 A Vantage 500 Deutz 11468 11931 11932 11960 The Lincoln Electric Company im954

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Operator s Manual VANTAGE 500 Deutz For use with machines having Code Numbers: 11468, 11931, 11932,035-.045 0.9-1.2mm gas shielded wire. Includes 15 ft. gun and cable assembly and connector kit. **KP653-035S** Drive Roll and Guide Tube Kit for LN-25 For .035-.040 0.9-1.0mm solid steel wire. K48...

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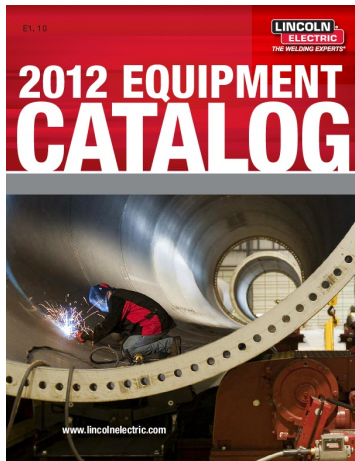


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Equipment Catalog e110 E1 10 welding equipment catalog welders weld gear lincoln electric the experts mig tig stick systems machines products product 2012 The Lincoln Electric Company E110 lincolnelectric assets en US Products literature

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Replaceable Head Only vertical horizontal positions of semi automatic fully welding applications The Note

Will not have remote wire speed voltage control Esab® Mig 2E 4HD 4AF |||

TELEPHONE: TEL: 281 485-6258 FAX: 281 485-8030 QUICK REFERENCE

ADDRESS: 1603 NORTH MAIN PEARL ... 42, LN-9GMA, LN-22, LN-23P, LN-25, LT-

7 KIT Size PXKP653-025S .023 .025 PXKP653-030S .030 **PXKP653-035S** .035 .040

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KP1507-1/16A KP1507-3/32A 0.6-0.9 0.8 0.9-1.0 1.2-1.4 0.9 1.2-1.4 KP653-025S

KP653-030S **KP653-035S** KP653-052S KP653-035C KP653-052C 2- NA-3S, NA-4,

NA-5 2.4-5.6 1.6, 2.0, 2.4 0.9, 1...

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