

Magnum® SG Spool Gun

The Magnum® SG – a lightweight, well balanced semiautomatic spool gun designed for easy and reliable aluminum wire feeding with a variety of CV power sources and engine-driven welders. Rated 250 amps @ 60%, the Magnum® SG features a generous 25 ft (7.5 m) gun cable and integrated wire feed speed control in the handle to cut your trips back to the power source.

Easy to set up, operate and maintain. . . the Magnum® SG is a great addition to your welding tool set.

Processes

MIG



Output

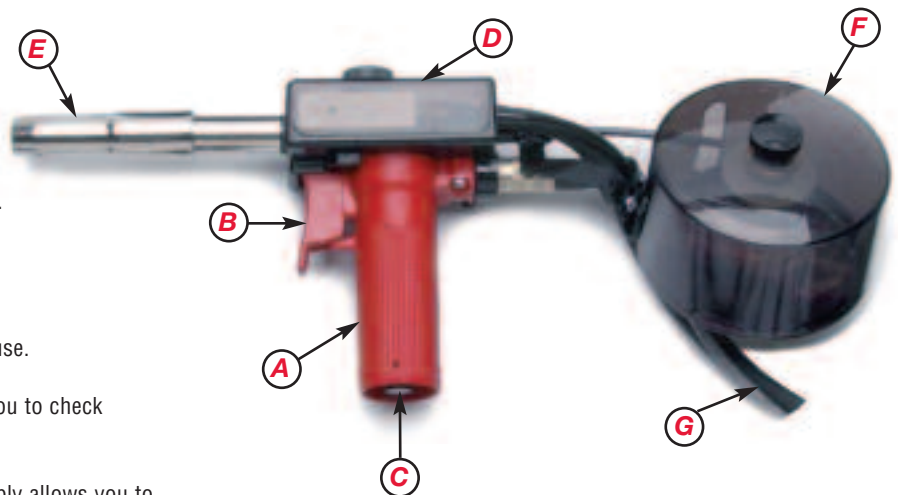


Input



Advantage Lincoln

- A** Large Easy-Grip Handle.
- B** Sizable Trigger is easy to use with gloved hands.
- C** Remote Wire Speed Control reduces trips to the welding power source.
- D** Clear Spool Gun Body Cover makes it easy to check the wire drive path.
- E** Gas Nozzle is built to stand up to rugged use.
- F** Clear electrode Wire Spool Cover allows you to check remaining wire at a glance.
- G** Generous 25 ft. (7.5 m) Gun Cable Assembly allows you to work a significant distance from your welding power source.



TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Wire Feed Speed Range ipm (m/min.)	Wire Size Range Solid Wire in. (mm)	Dimensions H x W x D inches (mm)	Net Weight lbs.(kg)
Magnum® SG Spool Gun	K487-25	24 VDC Requires Module	250A/60%	50-650 (1.3-16.5)	.023-3/64 (0.6-1.2)	6.5 x 3.5 x 16.5 (165 x 89 x 419)	2.7 (1.2)
Magnum® SG Spool Gun With Adapter	K1809-1						

A CLOSER LOOK

Superior Arc Performance:

- Eliminates many of the wire feeding issues associated with feeding soft aluminum wire electrode through a conventional push wire feeding system.
- Rated 250 amps @ 60% duty cycle.
- Capable of feeding .023-3/64" (0.6-1.2 mm) diameter wire electrode at wire feed speeds of 50-650 ipm (16.5 m/min).

Outstanding Features:

- Generous 25 ft. (7.5 m) gun cable.
- Handles 1 lb. (.45 kg) 4" (102 mm) diameter wire electrode spool.
- Integrated wire feed speed control in the handle reduces trips to the power source.
- Quick Release drive system makes it easy to load wire spools.
- Textured see-through spool and body covers enable the user to easily monitor wire supply and wire feed path.
- Easily converted to steel or stainless wire welding (.025" / 0.6 mm diameter) with the optional knurled drive roll and grooved idler roll.

Control Module Features:

- Wire Feed Speed Control.
- Built-in gas solenoid and gas preflow control.
- Mode switch matches spool gun operation to contactor circuit type in your power source.

Rugged Quality and Reliability:

- Spool Gun warranted for 90 days.
- K488 Spool Gun Module warranted for one year.

What's Included?

- K487-25 Magnum SG Spool Gun with 25 ft. (7.5 m) gun cable and .035" (0.9 mm) contact tip installed.
- Package of 6 contact tips – 2 each – .030" (0.8 mm), .035" (0.9 mm) and 3/64" (1.2 mm).
- 5/64" (2.0 mm) Allen Wrench
- Operating Manual

SYSTEM SELECTION

Power MIG® 215

- Includes Spool Gun, Adapter and Spool Gun Holder K1809-1

Power MIG® 255C

- Spool Gun K487-25
- 6-7 Pin Adapter Plug K2445-1
- Spool Gun Holder K1738-1

Power MIG® 255

- Spool Gun K487-25
- Adapter and Spool Gun Holder K2310-1

CV Power Sources & CV Engine Drives

- Spool Gun K487-25
- Spool Gun Control Module K488
- Control Module Input Cables
 - Terminal Strip and Lug Power Cable K492-10,
 - 14-pin MS-Type and Twist-Mate Power Cable K493-10,
 - 14-pin MS-Type, 115 Volt Plug and Lug Power Cable or K691-10

Engine Drives with Wire Feed Module for CV

- Wire Feed Module K623-1
- Spool Gun K487-25
- Spool Gun Control Module K488
- Control Module Input Cable K691-10



The Magnum® SG Spool Gun is an excellent choice for aluminum sheet metal welding.

GENERAL OPTIONS



SG Control Module
Provides control of wire speed and gas flow. For use with CV power sources and CV Engine Drives with output contactor.
Order K488



Magnum® SG Spool Gun Control Cable Adapter
Allows the K487-25 Magnum® SG Spool Gun's 6-pin control cable plug to connect to the Power MIG® 255C's 7-pin spool gun control cable receptacle.
Order K2445-1



Control Module Input Cable – Terminal Strip and Lug
Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® power sources having terminal strip and lug connections.
Order K492-10



SP-255/Wire-Matic™ Spool Gun Adapter Kit
Enables the SP-255 and Wire-Matic™ 255 wire feed welders to accept the K487-25 spool gun.
Order K672-1



Control Module Input Cable – 14-pin MS-type & Twist-Mate™
Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® power sources having 14-pin MS-type control connections and Twist-Mate™ power connections.
Order K493-10



Power MIG® 215 and Power MIG 200 Spool Gun and Adapter Kit
This kit includes the K487-25 spool gun, spool gun holder, gas hose kit and easy spool gun connection in the wire drive compartment of the Lincoln Power MIG 215 and Power MIG 200 wire feed welder.
Order K1809-1



Control Module Input Cable – 14-pin MS-type, 115 Volt Plug & Lug
Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® engine driven power sources with 14-pin MS-type connection, separate 115V NEMA receptacles and lug power connections.
Order K691-10



Power MIG® 255 Spool Gun Adapter Kit⁽¹⁾
Enables the Power MIG 255 wire feed welder to accept the K487-25 Magnum® SG Spool Gun or a Prince® XL Spool Gun. (Includes a spool gun holder).
Order K2310-1



Spool Gun Holder for Power MIG®
Provides neat storage of spool gun cable, and gas hose on power source. Also provides hardware for routing gas hose inside power source when using a Prince XL gun. *Note: Included in K1809-1 and K2310-1.*
Order K1738-1

*Note: Prince® XL Gun is a registered trademark of MK Products, Inc.
(1) Not required for Power MIG® 255C.*

EXPENDABLE PARTS

Description	Order Number	Description	Order Number
Teflon Liner	KP2010-1	Gas Diffuser	KP2010-6
Plastic Guide Tube	KP2010-2	Contact Tip .023-.025	KP2010-7B1
Contact Tip Notched .030"	KP2010-3B1	Drive Roll Smooth	KP2010-8
Contact Tip Notched .035"	KP2010-4B1	Drive Roll Knurled	KP2010-9
Contact Tip Notched 3/64"	KP2010-5B1		

MAGNUM® SG SPOOL GUN ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
Magnum SG Spool Gun			
Air-Cooled, 25 ft. (7.6 m)	K487-25		
Air-Cooled, 25 ft. (7.6 m) with Adapter for Power MIG® 215/200	K1809-1		
Recommended General Options			
SG Control Module	K488		
Control Module Input Cable – <i>Terminal Strip and Lug</i>	K492-10		
Control Module Input Cable – <i>14-pin MS-type & Twist-Mate™</i>	K493-10		
Control Module Input Cable – <i>14-pin MS-type & Lug</i>	K691-10		
Magnum® SG Spool Gun Control Cable Adapter	K2445-1		
SP-255/Wire-Matic Spool Gun Adapter Kit	K672-1		
Power MIG® 255 Spool Gun Adapter Kit	K2310-1		
Spool Gun Holder for Power MIG®	K1738-1		
Recommended Expendable Parts			
Teflon Liner	KP2010-1		
Plastic Guide Tube	KP2010-2		
Contact Tip Notched .030"	KP2010-3B1		
Contact Tip Notched .035"	KP2010-4B1		
Contact Tip Notched 3/64"	KP2010-5B1		
Gas Diffuser	KP2010-6		
Contact Tip .023-.025"	KP2010-7B1		
Drive Roll Smooth	KP2010-8		
Drive Roll Knurled	KP2010-9		
Recommended Power Sources			
<i>CV Power Sources:</i>			
Power MIG® 215	See publication E7.50		
Power MIG® 255C	See publication E7.54		
CV-305	See publication E4.22		
CV-400	See publication E4.30		
CV-655	See publication E4.40		
<i>CV Engine Drives:</i>			
Ranger® 250	See publication E6.103		
Ranger® 250 LPG	See publication E6.104		
Ranger® 305G	See publication E6.117		
Ranger® 305D	See publication E6.118		
Classic® 300G	See publication E6.156		
Classic® 300D	See publication E6.155		
Vantage® 300	See publication E6.206		
Vantage® 400	See publication E6.210		
Vantage® 500	See publication E6.216		
Air Vantage® 500	See publication E6.217		
	TOTAL:		

CUSTOMER ASSISTANCE POLICY

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