

# 70 Series

**New!**

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**Constant-Speed Wire Feeder**



## Quick Specs



### Heavy Industrial Applications

Heavy Manufacturing  
Metal Fabrication  
Construction  
Light Manufacturing

### Processes

MIG (GMAW)  
Flux Cored (FCAW)  
(Gas- and Self-Shielded)

**Input Power** 24 VAC, 10 A, 50/60 Hz

**Electrode Wire Diameter Capacity** .023–1/8 in (0.6–3.2 mm)

**Wire Speed** 50–780 IPM (1.3–19.8 m/min)

**Weight** 58 lb (26 kg)

## The Power of Blue.®



S-74D Model

S-74DX Model

Easy access on/off switch

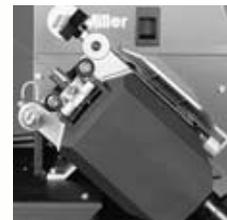
**Trigger receptacle** oriented in a downward position to reduce potential damage.

**Trigger hold** reduces operator fatigue by allowing the operator to make long welds without having to energize the trigger continuously.

**Automatic run-in control** significantly improves arc starting performance.

The next generation of industrial-class wire feeders. All the features of the 60 Series, plus enhanced flexibility and additional features.

**Models:** 74S: Standard, basic design  
74D: Digital meters  
74DX: Deluxe — digital, full-feature



**Toolless rotatable drive assembly** allows operator to rotate the drive

housing, eliminating severe bends in the wire feed path which reduce gun liner life. Also aids in feeding difficult wires.



**Dual tension control** adds flexibility for the

operator to fine-tune the pressure on the wire independently when feeding a variety of wires.

### Posifeed™ Wire Drive Assembly Features

- 24 VDC high-torque, permanent-magnet motor.
- Quick-change drive rolls.
- Quick-release, calibrated drive-roll pressure adjustment arm allows drive roll change without losing spring preload setting.
- **Four sealed ball bearing all-gear-driven drive-roll carriers** for smooth, positive and accurate wire feed with long uninterrupted service life.
- Easy loading and threading of welding wire without having to release the drive-roll pressure arm.
- **Solid-state speed control and brake circuit** eliminates the need for electrical/mechanical relays and increases service life.
- Uses Miller standard 1-5/8 in (41 mm) diameter drive rolls.
- Quick-connect for all Miller guns.
- Covered drive rolls — easy access, heavy-duty, molded composite cover over drive assembly.
- Floating positive drive systems provide trouble-free feeding on a variety of wires.

### DX Models Additional Features

- **Dual schedule** allows operator to switch between two welding parameters without readjusting machine, eliminating downtime and enhancing quality.
- **Adjustable weld sequence control** gives operator complete control of the welding parameters: preflow, run-in, weld time, crater, burnback and postflow.
- **Welding process range control** locks parameters at a set percentage of welding parameters to ensure welding procedures and quality standards are maintained on the shop floor.
- **Four weld programs** allow the operators to store four independent welding parameters reducing welding setup time. (Four programs available per side on dual model.)

**TRUE BLUE**  
3 YR. WARRANTY

Wire feeder is warranted for 3 years, parts and labor.

MADE IN **USA**  
APPLETON, WI **USA**



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# Specifications (Subject to change without notice.)

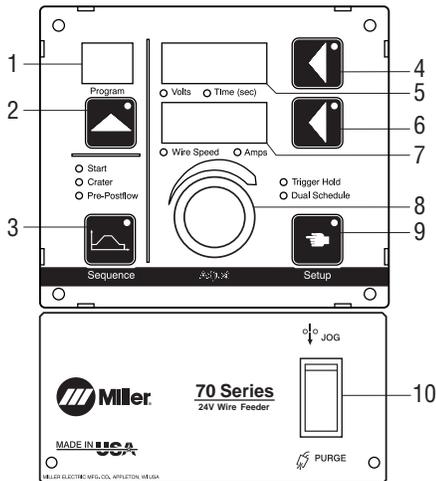
**CV** (Use with CV Power Sources.)

Input Power	Electrode Wire Diameter Capacity	Wire Speed	Dimensions		Net Weight	
			S-74 (Single)	D-74 (Dual)	S-74 (Single)	D-74 (Dual)
24 VAC, 10 A, 50/60 Hz	.023–1/8 in (0.6–3.2 mm) (1/8 in wires may require low-speed motor)	50–780 IPM (1.3–19.8 m/min) Optional High Speed Motor: 90–1440 IPM (2.3–36.6 m/min)	H: 14 in (356 mm) W: 12 in (305 mm) D: 26-1/2 in (673 mm)	H: 14 in (356 mm) W: 12-1/2 in (318 mm) D: 35 in (889 mm)	58 lb (26 kg)	87 lb (35.5 kg)

## Control Panel

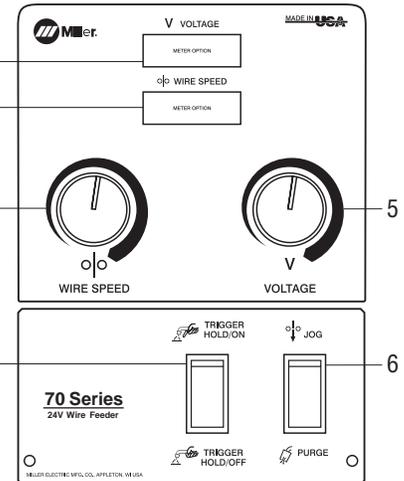
1. Program Display
2. Program # Select
3. Weld Sequence
4. Voltage/Time Select
5. Voltage/Time Display Meter
6. Wire Feed/Amperage Select
7. Wire Speed/Amperage Display Meter
8. Control Knob
9. Trigger Hold/Dual Schedule Control
10. Jog/Purge

**S-74DX Model**



**S-74S and S-74D Model**

1. Voltage Display Meter\*
  2. Wire Speed Display Meter\*
  3. Wire Feed Speed Select
  4. Trigger Hold
  5. Voltage Select\*\*
  6. Jog/Purge
- \*S-74D model only  
\*\*Optional on S-74S



## Drive Roll Kits and Guides (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include 4 drive rolls, the necessary guides and feature an anti-wear sleeve for inlet guide.

Wire Size	"V" groove for hard wire	"U" groove for soft wire or soft-shelled cored wires	"V" knurled for hard-shelled cored wires	"U" clogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)
.023/.025 in (0.6 mm)	#151 024	—	—	—
.030 in (0.8 mm)	#151 025	—	—	—
.035 in (0.9 mm)	#151 026	#151 036	#151 052	—
.040 in (1.0 mm)	#161 190	—	—	—
.045 in (1.1/1.2 mm)	#151 027	#151 037*	#151 053	#151 070
.052 in (1.3/1.4 mm)	#151 028	#151 038	#151 054	#151 071
1/16 in (1.6 mm)	#151 029	#151 039	#151 055	#151 072
.068/.072 in (1.8 mm)	—	—	#151 056	—
5/64 in (2.0 mm)	—	#151 040	#151 057	#151 073
3/32 in (2.4 mm)	—	#151 041	#151 058	#151 074
7/64 in (2.8 mm)	—	#151 042	#151 059	#151 075
1/8 in (3.2 mm)	—	#151 043**	#151 060**	#151 076**

\*Accommodates .045 and .047 (3/64 in) wire. \*\* May require a low-speed, wire-feed drive-roll option.

### Nylon Wire Guides for Feeding Aluminum Wire

Wire Size	Inlet Guide	Intermediate Guide
.047 in (1.2 mm)	#151 203	#151 204
1/16 in (1.6 mm)	#151 205	#151 206
3/32 in (2.4 mm)	#151 207	#151 208

Note: "U" groove drive rolls are recommended when feeding aluminum wire.

### Wire Guides

Wire Size	Inlet Guide	Intermediate Guide
.023–.040 in (0.6–1.0 mm)	#150 993	#149 518
.045–.052 in (1.1–1.4 mm)	#150 994	#149 519
1/16–5/64 in (1.6–2 mm)	#150 995	#149 520
3/32–7/64 in (2.4–2.8 mm)	#150 996	#149 521
1/8 in (3.2 mm)	#150 997	#149 522

# Genuine Miller Options and Accessories

## Remote Voltage Control

#194 988 Field Non-digital for S-74S

#194 991 Field Non-digital for D-74S

## Conversion Kit

#194 989 Field S-74S to S-74D

#194 992 Field D-74S to D-74D

#195 010 Field S-74S to S-74DX

#195 041 Field D-74S to D-74DX

## Control Detachment Kit

#194 914 Field 10 ft (3 m) for S-74

#194 913 Field 25 ft (7.6 m) for S-74

#194 995 Field 25 ft (7.6 m) for D-74

Allows separation of the control module from the wire drive assembly and base.

## Carrying Cart #056 301

A utility cart for the wire feeder and other miscellaneous welding supplies. Height: 34 in (863 mm). Lower tray height: 9 in (228 mm). Shipped disassembled.

## Feeder Cart #142 382

A low-profile, creeper cart which allows the operator to easily move the feeder around the work area. Shipped disassembled.

## Turntable Assembly #146 236

Allows rotation of the feeder as the operator changes work positions. Reduces strain and bending on the gun cable.

## Hanging Bail (Electrically Isolated)

#058 435

Used for suspending feeder over work area.



## Wire Straightener

#141 580 For .035–.045 in (0.9–1.1 mm) diameter wire.

#141 581 For 1/16–1/8 in (1.6–3.2 mm) diameter wire.

Helps reduce the cast in wire to improve wire feeding performance and increase the service life of the gun liner and contact tip.



## Spool Covers

#057 607 For S-74 and left side of D-74 models

#090 389 For right side of D-74 models  
For 12 in (305 mm) spool.



## Wire Reel Assembly #108 008

For 60 lb (27 kg) coil of wire.

## Reel Covers

#058 256 For S-74 and left side of D-74 models

#091 668 For right side of D-74 models  
For 60 lb (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.

*Note: Reel and Spool Covers cannot be installed if the wire drive assembly is in a rotated position.*

## Spool Adapter #047 141

For use with 14 lb (6.4 kg) spool of Lincoln self-shielding wire.

## 2/0 MIG Welding Accessory Kit #173 856

25 ft (7.6 m). Includes gas hose, weld cable and ground cable with clamp.

## Extension Cords

#122 973 25 ft (7.6 m)

#122 974 50 ft (15 m)

#122 975 75 ft (23 m)

Provides 14-pin, 24 VAC, contactor and voltage control. Add to the standard 10 ft (3 m) feeder cord to extend feeder farther from power source.

## Dual Schedule Switches



### DSS-8 #079 693

A two-position trigger switch which attaches to the gun handle and is used in place of the standard trigger for dual scheduling. **(For 74DX models only.)**



### DSS-9 #071 833

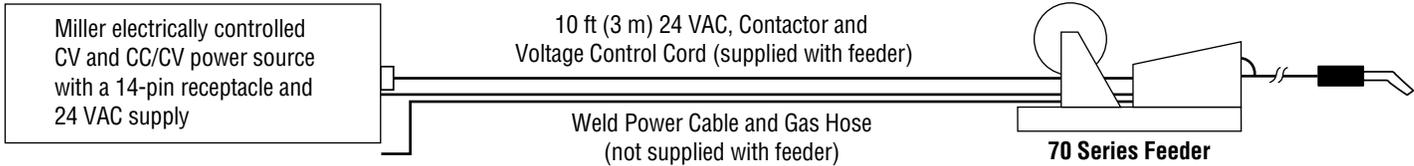
A two-position slide switch which attaches to the gun handle and is used to select the desired welding condition for dual schedule purposes. The gun trigger operates as a standard gun trigger. **(For 74DX models only.)**



## Swingarc™ Boom-Mounted Wire Feeders

Swingarc boom-mounted semiautomatic wire feeders bring an extra dimension of flexibility and efficiency to high-production wire welding stations. You get an effective solution that maximizes output, especially when dealing with large weldments and hard-to-reach places. See Lit. Index No. M/13.1.

# Typical Installation



# Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>S-74S</b>	#195 057			
	#195 057-02-1	With CE, Euro		
<b>S-74D</b>	#195 058			
	#195 058-01-1	With high-speed motor		
	#195 058-02-1	With CE, Euro		
	#195 058-03-1	With CE, Euro, high-speed motor		
<b>S-74DX</b>	#195 059			
	#195 059-01-1	With high-speed motor		
	#195 059-02-1	With CE, Euro		
	#195 059-03-1	With CE, Euro, high-speed motor		
<b>D-74S</b> (available January 2002)	#195 060			
	#195 060-02-1	With CE, Euro		
<b>D-74D</b> (available January 2002)	#195 061			
	#195 061-01-1	With high-speed motor		
	#195 061-02-1	With CE, Euro		
	#195 061-03-1	With CE, Euro, high-speed motor		
<b>D-74DX</b> (available January 2002)	#195 062			
	#195 062-01-1	With high-speed motor		
	#195 062-02-1	With CE, Euro		
	#195 062-03-1	With CE, Euro, high-speed motor		
Remote Voltage Control	#194 988	Field. Non-digital control ( <i>S-74S model only</i> )		
	#194 991	Field. Non-digital control ( <i>D-74S model only</i> )		
Conversion Kit	#194 989	Field. S-74S to S-74D		
	#194 992	Field. D-74S to D-74D		
	#195 010	Field. S-74S to S-74DX		
	#195 041	Field. D-74S to D-74DX		
Control Detachment Kit	#194 914	Field. 10 ft (3 m) ( <i>S-74S model only</i> )		
	#194 913	Field. 25 ft (7.6 m) ( <i>S-74S model only</i> )		
	#194 995	Field. 25 ft (7.6 m) ( <i>D-74S model only</i> )		
<b>Power Sources</b>				
CP-252TS and CP-302		See Lit. Index No. DC/31 and DC/13.0		
Invision™ 354 MP and 456MP, 456P		See Lit. Index No. DC/23, DC/20		
Deltaweld® Series		See Lit. Index No. DC/16.2		
XMT® Series		See Lit. Index No. DC/18.8		
Dimension™ Series		See Lit. Index No. DC/19.2		
<b>Accessories</b>				
Adapter Kit	#195 043	Makes 70 Series feeder compatible with older-style power sources		
Carrying Cart	#056 301			
Feeder Cart	#142 382			
Turntable Assembly	#146 236			
Hanging Bail	#058 435	Electrically isolated		
Wire Straightener		See page 3		
Spool Covers	#057 607	For S-74 and left side of D-74 models		
	#090 389	For right side of D-74 models		
Wire Reel Assembly	#108 008			
Reel Covers	#058 256	For S-74 and left side of D-74 models		
	#091 668	For right side of D-74 models		
Spool Adapter	#047 141			
2/0 MIG Welding Accessory Kit	#173 856			
Extension Cords		See page 3		
Dual Schedule Switches	#079 693	DSS-8 ( <i>74DX models only</i> )		
	#071 833	DSS-9 ( <i>74DX models only</i> )		

Date:

Total Quoted Price:

Distributed by:

