



PM-1500-6A

2020-06

**Processes**



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

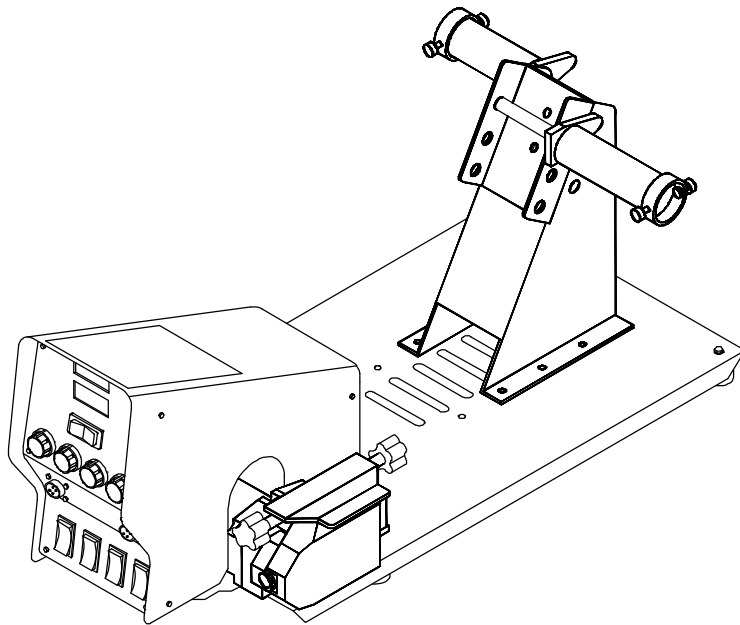
**Description**



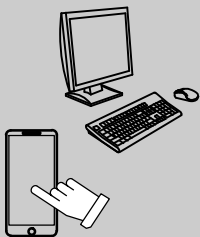
Wire Feeder

# D-74S, D-74D CE

Eff w/Serial No. LC085070 Thru LC682848



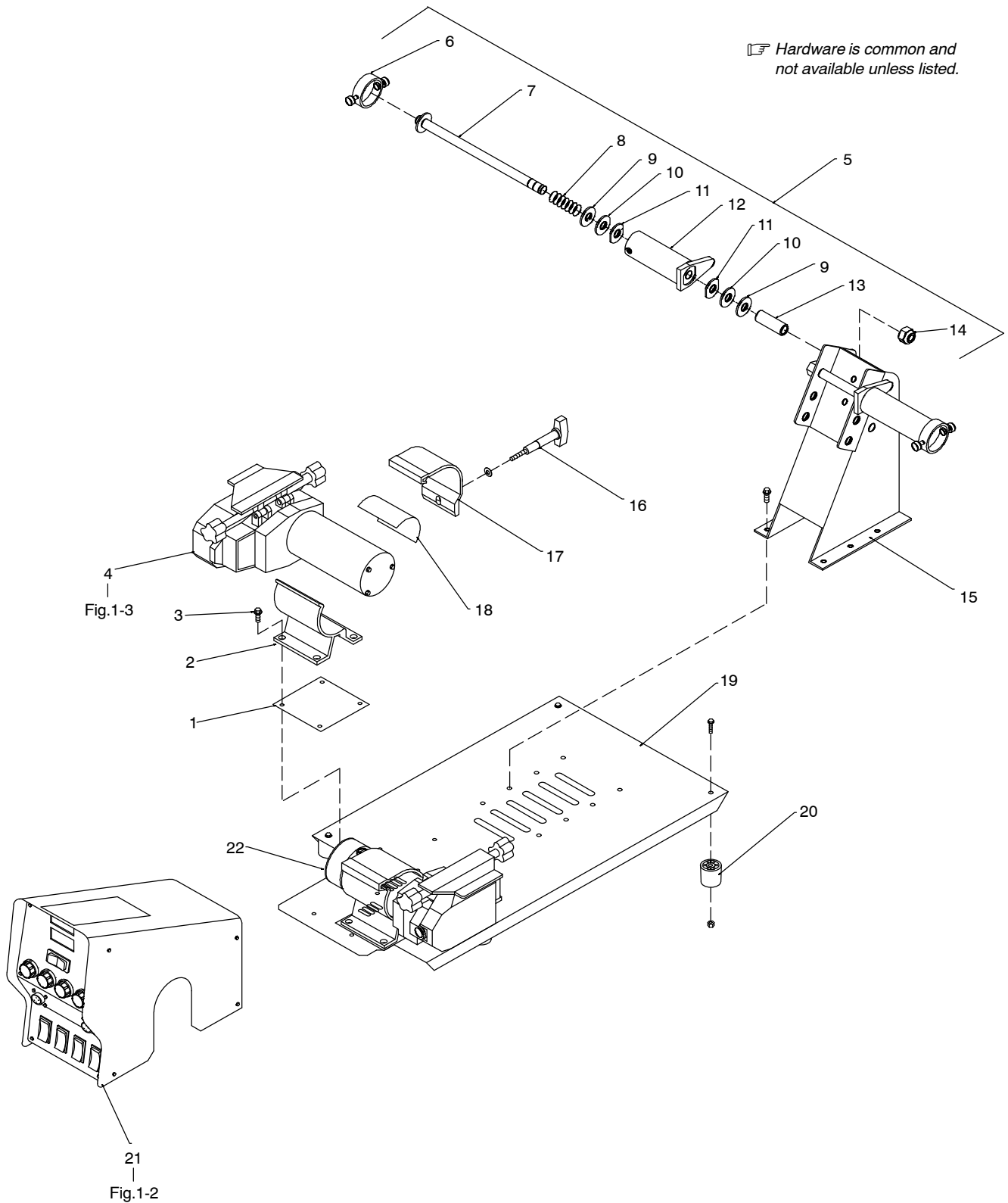
## PARTS MANUAL



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# SECTION 1 – PARTS LIST FOR SERIAL NO. LC085070 THRU LC682848



**Figure 1-1. Main Assembly**


803050-A

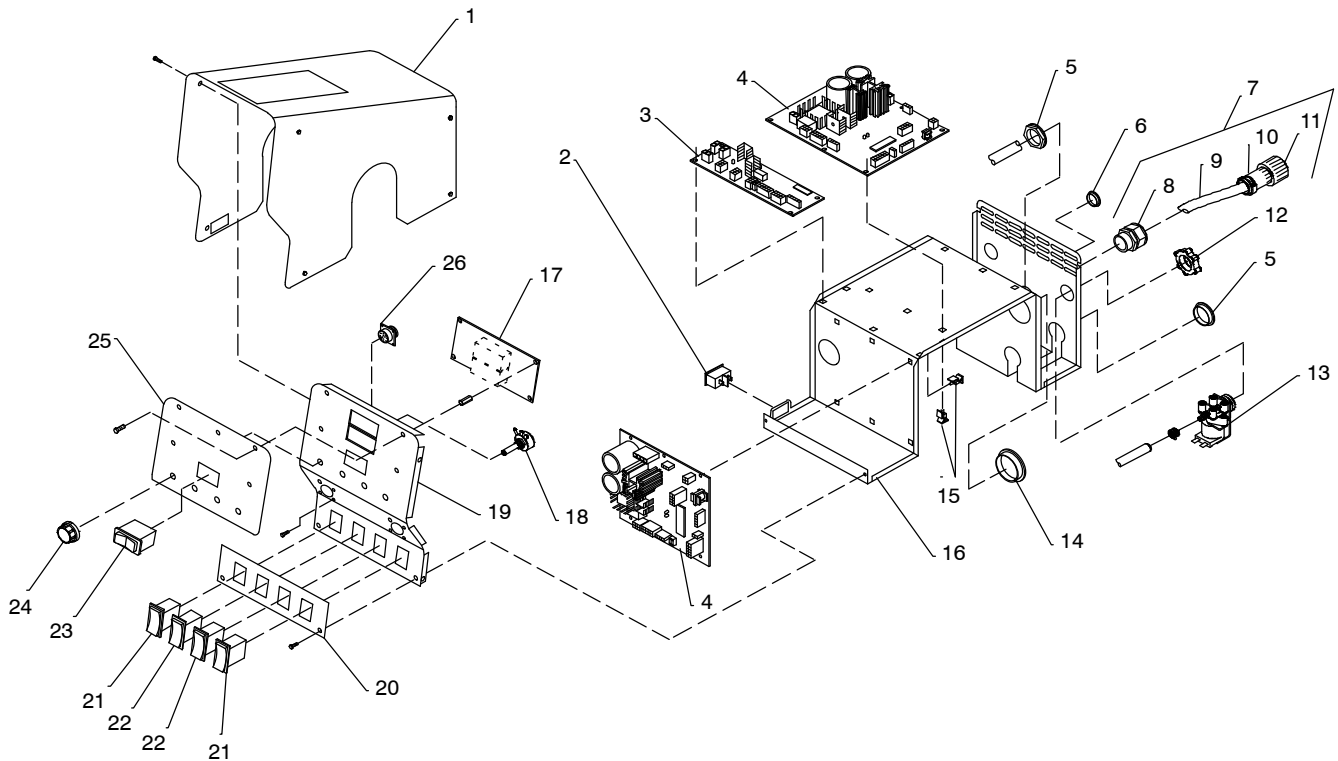
# Eff w/Serial No. LC085070 Thru LC682848

Item No.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly</b>			
... 1	159647	.. Insulator, Motor Clamp	2
... 2	159646	.. Clamp, Motor Base	2
... 3	159360	.. Insulator, Screw Machine	8
... 4	201761	.. Drive Assy, Wire S/L 4 Roll	1
... 4	201763	.. Drive Assy, Wire S/L 4 Roll Hi-Speed W/Tach	1
... 5	143160	.. Hub+Spindle Assy, (Consisting Of)	2
... 6	058427	.... Ring, Retaining Spool	1
... 7	180576	.... Shaft, Support Spool	1
... 8	010233	.... Spring, Cprsn .970 Od X .120 Wire X 1.250Pld	1
... 9	057971	.... Washer, Flat Stl Keyed 1.500 dia X .125Thk	2
... 10	010191	.... Washer, Fbr .656 Id X 1.500 Od X .125Thk	2
... 11	058628	.... Washer, Brake Stl	2
... 12	058428	.... Hub, Spool	1
... 13	071730	.... Tubing, STL .875 Od X 12Ga Wall X 2.250	2
... 14	135205	.... Nut, Stl Slfkg Hex Reg .625-11 W/Nylon Insert	1
... 15	141411	.. Support, Spool	1
... 16	208339	.. Extension, Dual Clamp L.H.	1
... 16	208338	.. Extension, Dual Clamp R.H.	1
... 17	156243	.. Clamp, Motor Top	2
... 18	145639	.. Strip, Buna-n .062 X 3.000 X 4.000 Compressed Sht	2
... 19	139226	.. Base	1
... 20	134306	.. Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
... 21		.. Control Box (Refer to Figure 1-2)	1
... 22	201767	.. Drive Assy, Wire R 4 Roll	1
... 22	201769	.. Drive Assy, Wire R 4 Roll Hi-Speed W/Tach	1
.....	164059	.. Hose, Gas	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

 Hardware is common and not available unless listed.



803049-A

**Figure 1-2. Control Box**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				D-74S	D-74D

**Figure 1-2. Control Box (Figure 1-1 Item 21)**

...	1	204722	Wrapper, feeder	1	1
...		134464	Label, Warning General Precautionary Static&wire Fe	1	1
...		178936	Label, Warning General Precautionary Wordless CE Wf	1	1
...	2	S1 111997	Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	1	1
...	3	PC70 207419	Circuit Card Assy, Dual W/Program	1	1
...	4	PC1, PC101 208185	Circuit Card Assy, Motor Control W/Program (Prior to LC105563)	2	2
...	4	PC1, PC101 210687	Circuit Card Assy, Motor Control W/Program (Eff w/LC105563)	2	2
...	5	030170	Bushing, Snap-in Nyl .750 Id X 1.000 Mtg Hole	2	2
...	6	000527	Blank, Snap-in Nyl .875 Mtg Hole Black	1	1
...	7	200196	Cable, Power 16.5Ft 8/C 2-14Ga 6-18Ga (Consisting Of)	1	1
...	8	139041	Strain Relief	1	1
...	9	163519	Cable, Port	16.5 ft (5.0 m)	
...	10	079739	Conn, Circ Cpc Clamp Str Rlf	1	1
...	11	PLG12 141162	Housing Plug+Pins, (Service Kit)	1	1
...		PLG52 174823	Housing Plug Pins+Skts, (Service Kit)	1	1
...		PLG74 115093	Housing Plug+Skts, (Service Kit)	1	1
...	12	605227	Nut, 750-14 Knurled 1.68Dia .41H Nyl	2	2
...	13	GS1, GS101 200333	Valve, 34VDC 2Way Custom Port 1/8 Orf W/Frict	2	2
...	14	010494	Bushing, Snap-in Nyl 1.375 Id X 1.750 Mtg Hole	2	2
...	15	134201	Stand-off Support, PC Card .312/.375w/Post&lock .43	17	17
...	16	204721	Enclosure, Control	1	1

# Eff w/Serial No. LC085070 Thru LC682848

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				D-74S	D-74D
<b>Figure 1-2. Control Box (Continued)</b>					
... 17	PC60	208190	Circuit Card Assy, Meter W/Program (Prior to LC105563)	0	1
... 17	PC60	210692	Circuit Card Assy, Meter W/Program (Eff w/LC105563)	0	1
... 17	PC40	208323	Circuit Card Assy, Master W/Program D-74	1	0
... 18	R1, R101	073562	Potentiometer, Cp Std Slot 1T 2. W 10K linear D-74S	2	0
... 18	R1, 101, 70, 170	603856	Potentiometer, ww SltD Sft 10/T 2W 10K Ohm D-74D	0	4
... 19		204723	Panel, Front	1	1
... 20		204724	Nameplate, Miller Lower	1	1
... 20		207428	Nameplate, Lower (CE Version)	1	1
... 21	S2, S102	200295	Switch, Rocker Spdt 15A 12V (On)-Off-(On)	2	2
... 22	S3, S103	201642	Switch, Rocker Spdt 15A 12V On-None-On	2	2
... 23	S100	201641	Switch, Rocker Spdt 15A 12V (On)-Off-(On) W/leds	1	1
... 24		193919	Knob, Pointer 1.250 Dia x .250 Id W/Two Set Screws	4	4
... 25		206513	Nameplate, Miller D-74S Upper	1	0
... 25		206511	Nameplate, Miller D-74D Upper	0	1
... 25		207431	Nameplate, Upper (CE Version) D-74S	1	0
... 25		207433	Nameplate, Upper (CE Version) D-74D	0	1
... 26	RC13, RC113	048282	RCPT W/Skts, (Service Kit)	2	2

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

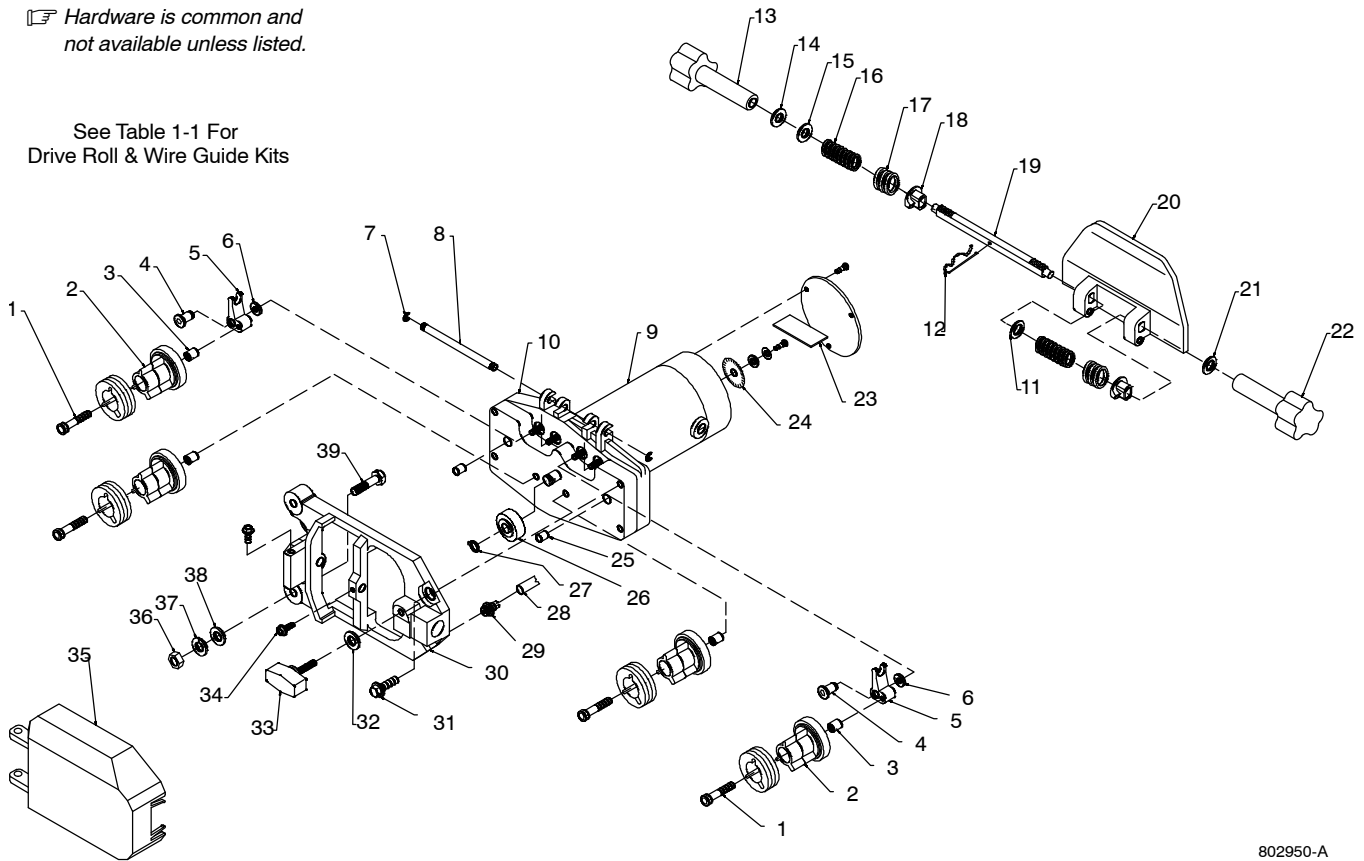
**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

	Dia. Mkgs.	Part No.	Description	Quantity
<b>Harness Connectors/Receptacles</b>				
.....	PLG6,106	115094	Housing Plug+Skts, (Service Kit)	1
.....	PLG4,104	136810	Housing Plug+Skts, (Service Kit)	1
.....	PLG72	115092	Housing Plug+Skts, (Service Kit)	1
.....	PLG9,109	201665	Housing Plug+Skts, (Service Kit)	1
.....	PLG11, 21,71,111	131055	Housing Rcpt+Skts, (Service Kit)	1
.....	PLG7,67,107	115091	Housing Plug+Skts, (Service Kit)	1
.....	PLG17,70	158719	Housing Plug+Skts, (Service Kit)	1
.....	PLG117	165404	Housing Rcpt+Skts, (Service Kit)	1
.....	PLG1,77,78,79,101	202592	Housing Plug+Skts, (Service Kit)	1
.....	PLG3,75,76,103	115093	Housing Plug+Skts, (Service Kit)	1
.....	PLG51	174824	Housing Plug Pins+Skts, (Service Kit)	1
.....	PLG8,108	131054	Housing Rcpt+Skts, (Service Kit)	1
.....	PLG10,110	130203	Housing Plug+Skts, (Service Kit)	1

# Eff w/Serial No. LC085070 Thru LC682848

☐ Hardware is common and not available unless listed.

See Table 1-1 For Drive Roll & Wire Guide Kits



802950-A

**Figure 1-3. Drive Assembly, Wire**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				D-74S	D-74D

**Figure 1-3. Drive Assembly, Wire (Figure 1-1 Item 4)**

...	1	010668	.. Screw, Cap Stl Sch .250-20 X 1.500	4	4
...	2	172075	.. Carrier, Drive Roll W/Components	4	4
...	3	149962	.. Spacer, Carrier Drive Roll	4	4
...	4	149486	.. Pin, Rotation Arm Rocker	2	2
...	5	132750	.. Arm, Pressure	2	2
...	6	150520	.. Spacer, Flat Stl .257 Id X .619 Od X .105	2	2
...	7	133493	.. Ring, Retaining Ext .250 Shaft X .025Thk	2	2
...	8	133350	.. Pin, Hinge	1	1
...	9	M1,101 201230	.. Motor, Gear 1/8HP 24VDC Standard Speed	1	1
...	9	M1,101 201231	.. Motor, Gear 1/8HP 24VDC High Speed	1	1
...		153491	.... Kit, Brush Replacement (Consisting Of)	1	1
...		153492	.... Cap, Brush	2	2
...		*153493	.... Brush, Carbon	2	2
...		184136	.... Kit, Brush Holder Replacement	1	2
...	10	155098	.. Kit, Cover Motor Gearbox (Consisting Of)	1	1
...		153550	.... Cover, Motor Gearbox (Consisting Of)	1	1
...		155099	.... Gasket, Cover	1	1
...		155100	.... Screw, Cover	5	5
...		154031	.... Spacer, Locating	2	2
...		133493	.... Ring, Rtngr Ext .250 Shaft Grv X .025Thk	1	1

# Eff w/Serial No. LC085070 Thru LC682848

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	Model
				D-74S	D-74D
<b>Figure 1-3. Drive Assembly, Wire (Continued)</b>					
.....		203642	.. Pressure Arm, R & Vert L 4 Roll (Consisting Of) .....	1	1
.....		203631	.. Pressure Arm, S/L & Vert S/R 4 Roll (Consisting Of) .....	1	1
.. 11		182414	.... Washer, Flat .....	1	1
.. 12		182415	.... Pin, Cotter Hair .....	1	1
.. 13		203640	.... Knob, W/Extension Short Pressure Arm .....	1	1
.. 14		602200	.... Washer, Lock Stl Split No. 8 .....	1	1
.. 15		604772	.... Washer, Flat Stl Sae No. 8 .....	1	1
.. 16		182156	.... Spring, Cprsn .....	4	4
.. 17		182155	.... Spring .....	2	2
.. 18		132746	.... Bushing, Spring .....	2	2
.. 19		203633	.... Shaft, Spring .....	1	1
.. 20		203632	.... Carrier, Shaft .....	1	1
.. 21		133739	.... Washer, Flat Buna .375 Id X .625 Od X .062Thk .....	1	1
.. 22		203637	.... Knob, W/Extension Long Pressure Arm .....	1	1
.. 23	.. PC51,151	201225	.. Circuit Card, Digital Tach (Consisting Of) .....	0	2
.....	.. PLG5	131204	.... Connector & Sockets .....	0	1
.....		604311	.... Grommet, Rbr .250 Id X .375Mtg Hole .062 Groove .....	0	1
.. 24		132611	.. Optical Encoder Disc .....	0	1
.....		603115	.. Weather Stripping, Adh .125 X .375 .....	0	1
.. 25		167387	.. Spacer, Locating .....	2	2
.. 26		168825	.. Drive, Pinion .....	1	2
.. 27		133308	.. Ring, Retaining Ext .375 Shaft X .025Thk .....	1	1
.. 28		134834	.. Hose, SAE .187 Id X .410 Od (Order By Ft) .....	2 Ft (0.6 m)	
.. 29		149959	.. Fitting, Brs Barbed M 3/16Tbg X .312-24 .....	1	1
.. 30		179265	.. Adapter, Gun/Feeder LH .....	1	1
.. 30		179264	.. Adapter, Gun/Feeder RH .....	1	1
.. 31		108940	.. Screw, Cap Stl Hexhd .250-20 X .750 .....	4	4
.. 32		604538	.. Washer, Flat Stl SAE .312 .....	1	1
.. 33		151437	.. Knob, Plstc T 1.125 Lg X .312-18 X 1.500 .....	1	1
.. 34		151290	.. Screw, Mach Stl Hexwhd 10-32 X .500 .....	2	2
.. 35		179277	.. Cover, Drive Roll (Consisting Of) .....	1	1
.....		178937	.... Label, Warning Electric Shock .....	1	1
.. 36		601872	.. Nut, Stl Hex Full Fnsh .375-16 .....	1	1
.. 37		602213	.. Washer, Lock Stl Split .375 .....	1	1
.. 38		602243	.. Washer, Flat Stl Std .375 .....	1	1
.. 39		601966	.. Screw, Cap Stl Hexhd .375-16 X 1.250 .....	1	1

\*Recommended Spare Parts.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Wire Size	Fraction	Metric	Inlet Guide	Intermediate Guide	V-GROOVE		U-GROOVE		VK-GROOVE		UC-GROOVE	
					4 Roll Kit	Drive Roll	4 Roll Kit	Drive Roll	4 Roll Kit	Drive Roll	4 Roll Kit	Drive Roll
.023-.025 in.	0.6 mm		150 993	149 518	151 024	087 130						
.030 in.	0.8 mm		150 993	149 518	151 025	053 695						
.035 in.	0.9 mm		150 993	149 518	151 026	053 700	151 036	072 000	151 052	132 958		
.040 in.	1.0 mm		150 993	149 518	161 190							
.045 in.	1.1/1.2 mm		150 994	149 519	151 027	053 697	151 037	053 701	151 053	132 957		083 489
.052 in.	1.3/1.4 mm		150 994	149 519	151 028	053 698	151 038	053 702	151 054	132 956		083 490
1/16 in. (.062 in.)	1.6 mm		150 995	149 520	151 029	053 699	151 039	053 706	151 055	132 955		053 708
.068-.072 in.	1.8 mm		150 995	149 520					151 056	132 959		
5/64 in. (.079 in.)	2.0 mm		150 995	149 520			151 040	053 704	151 057	132 960		053 710
3/32 in. (.094 in.)	2.4 mm		150 996	149 521			151 041	053 703	151 058	132 961		053 709
7/64 in. (.110 in.)	2.8 mm		150 996	149 521			151 042	053 705	151 059	132 962		053 711
1/8 in. (.125 in.)	3.2 mm		150 997	149 522			151 043	053 707	151 060	132 963		053 712

Ref. S-0527-C

Each Kit Contains An Inlet Guide, Intermediate Guide, And 045 233 Antiwear Guide w/604 612 Setscrew 8-32 x .125, along with 4 Drive Rolls.





PM-1500-6A

2020-06

**Processes**



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

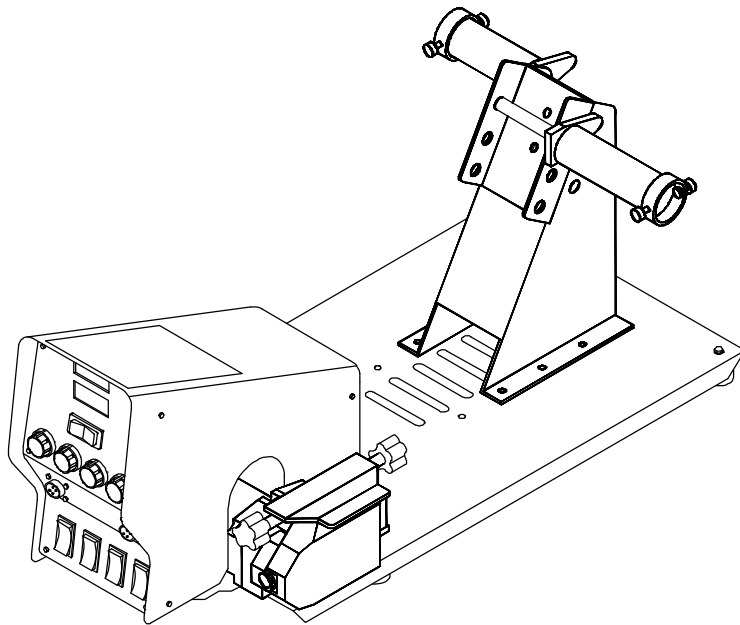
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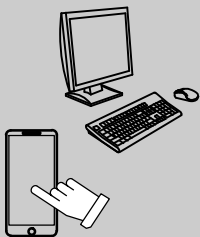
Wire Feeder

# D-74S, D-74D CE

Eff w/Serial No. LC682849 And Following



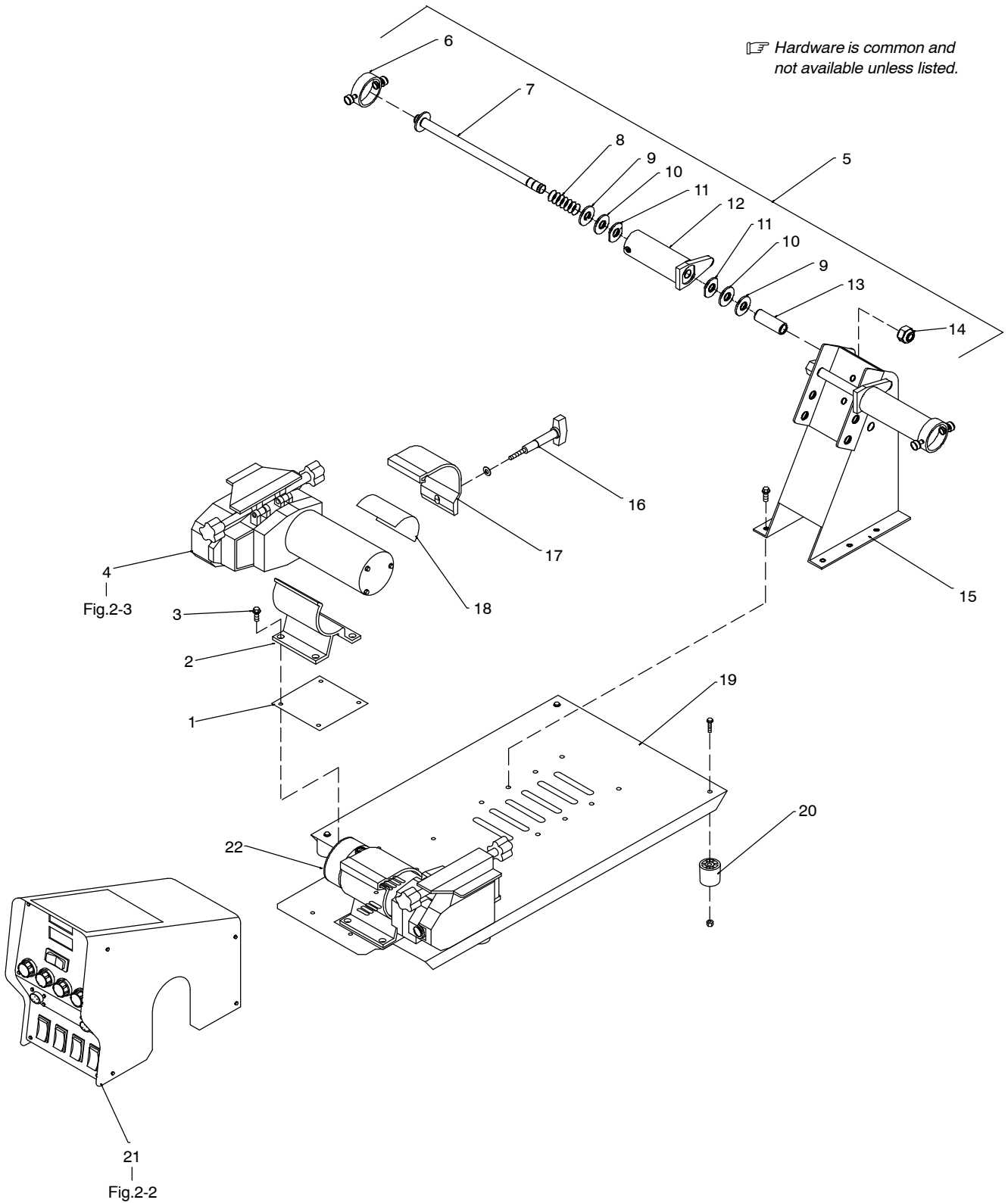
## PARTS MANUAL



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# SECTION 2 – PARTS LIST FOR SERIAL NO. LC682849 AND FOLLOWING



**Figure 2-1. Main Assembly**

803050-B


## Eff w/Serial No. LC682849 And Following

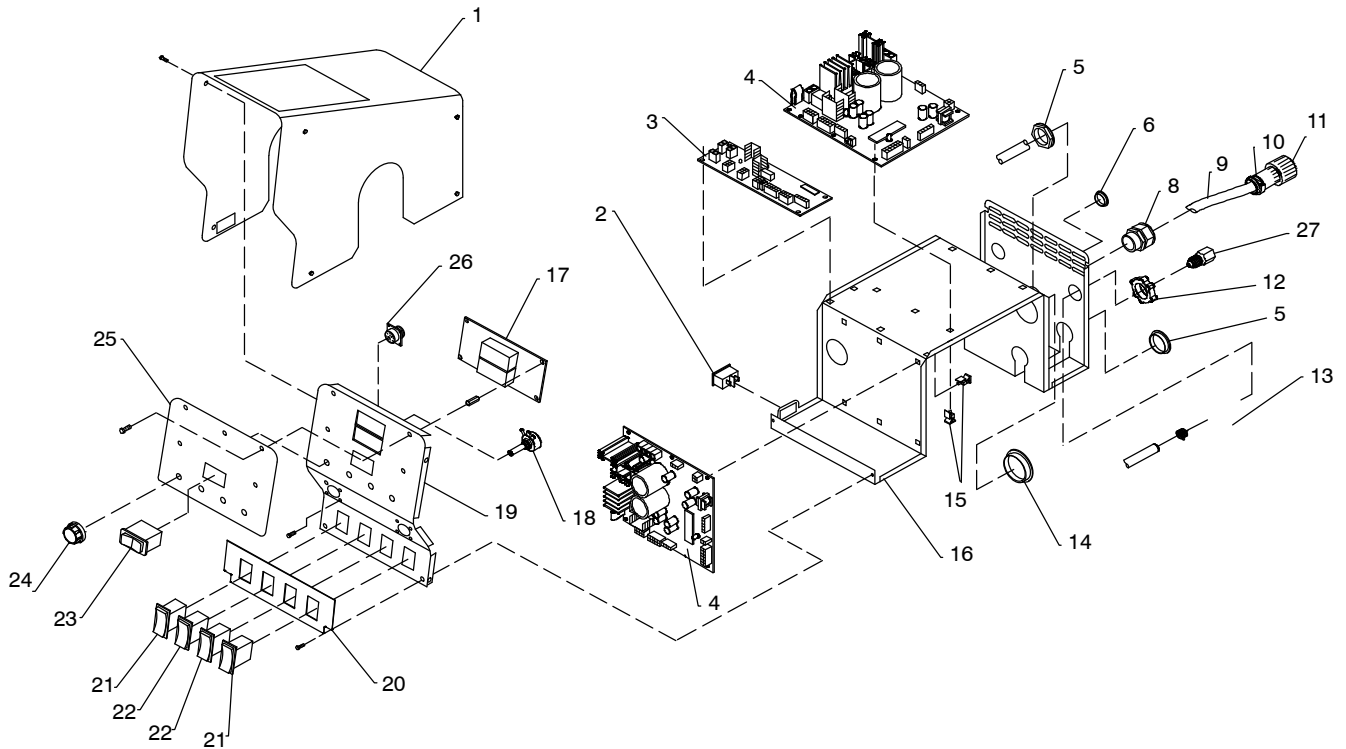
Item No.	Part No.	Description	Quantity
<b>Figure 2-1. Main Assembly</b>			
... 1	159647	.. Insulator, Motor Clamp	2
... 2	159646	.. Clamp, Motor Base	2
... 3	159360	.. Insulator, Screw Machine	8
...	278751	.. Washer, Fbr .281 Id X .625 Od X .065 Thk (Eff w/MH040002U)	8
... 4	201761	.. Drive Assy, Wire S/L 4 Roll	1
... 4	201763	.. Drive Assy, Wire S/L 4 Roll Hi-Speed W/Tach	1
... 5	143160	.. Hub+Spindle Assy, (Consisting Of)	2
... 6	058427	... Ring, Retaining Spool	1
... 7	180576	... Shaft, Support Spool	1
... 8	010233	... Spring, Cprsn .970 Od X .120 Wire X 1.250Pld	1
... 9	057971	... Washer, Flat Stl Keyed 1.500 Dia X .125Thk	2
... 10	010191	... Washer, Fbr .656 Id X 1.500 Od X .125Thk	2
... 11	058628	... Washer, Brake Stl	2
... 12	058428	... Hub, Spool	1
... 13	071730	... Tubing, STL .875 Od X 12Ga Wall X 2.250	2
... 14	135205	... Nut, Stl Slfkg Hex Reg .625-11 W/Nylon Insert	1
... 15	141411	.. Support, Spool	1
... 16	208339	.. Extension, Dual Clamp L.H.	1
... 16	208338	.. Extension, Dual Clamp R.H.	1
... 17	156243	.. Clamp, Motor Top	2
... 18	145639	.. Strip, Buna-n .062 X 3.000 X 4.000 Compressed Sht (Optional)	2
... 18	275686	.. Pad, Neoprene .250 X 3.000 X 4.000 Du70A	2
... 19	139226	.. Base	1
... 20	134306	.. Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
... 21	.....	Control Box (Refer to Figure 2-2)	1
... 22	201767	.. Drive Assy, Wire R 4 Roll	1
... 22	201769	.. Drive Assy, Wire R 4 Roll Hi-Speed W/Tach	1
...	164059	.. Hose, Gas	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

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# Eff w/Serial No. LC682849 And Following

 Hardware is common and not available unless listed.



805427-C

**Figure 2-2. Control Box**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				D-74S	D-74D

**Figure 2-2. Control Box (Figure 2-1 Item 21)**

...	1	204722	Wrapper, Feeder	1	1
...		134464	Label, Warning General Precautionary Static&Wire Fe	1	1
...		178936	Label, Warning General Precautionary Wordless CE Wf	1	1
...		238487	Label, Warning General Precautionary (CE/Domestic) (Eff w/LJ490634U thru MH345091U)	1	1
...		274964	Label, Warning General Precautionary (EN/FR/SP) (Eff w/MH345092U)	1	1
...	S1	111997	Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	1	1
...	PC70	207419	Circuit Card Assy, Dual W/Program (Prior to LE289214)	1	1
...	PC70	220903	Circuit Card Assy, Dual W/Program (Eff w/LE289214 Thru LJ490633U)	1	1
...	PC70	237752	Circuit Card Assy, Dual W/Program (Eff w/LJ490634U)	1	1
...	PC1, PC101	210687	Circuit Card Assy, Motor Control W/Program (Prior to LE224832)	2	2
...	PC1, PC101	217898	Circuit Card Assy, Motor Control W/Program (Eff w/LE224832 Thru LJ490633U)	2	2
...	PC1, PC101	238469	Circuit Card Assy, Motor Control W/Program (Eff w/LJ490634U)	2	2
...		030170	Bushing, Snap-In Nyl .750 Id X 1.000 Mtg Hole	2	2
...		000527	Blank, Snap-In Nyl .875 Mtg Hole Black	1	1
...		200196	Cable, Power 11.5Ft 8/C 2-14Ga 6-18Ga (Consisting Of)	1	1
...		139041	Strain Relief	1	1
...		163519	Cable, Port	11.5 Ft (3.5 m)	
...		079739	Conn, Circ Cpc Clamp Str Rlf	1	1

## Eff w/Serial No. LC682849 And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				D-74S	D-74D
<b>Figure 2-2. Control Box (Continued)</b>					
... 11	PLG12	141162	Housing Plug+Pins, (Service Kit)	1	1
.....	PLG52	174823	Housing Plug Pins+Skts, (Service Kit)	1	1
.....	PLG74	115093	Housing Plug+Skts, (Service Kit)	1	1
... 12		605227	Nut, 750-14 Knurled 1.68Dia .41H Nyl	2	2
... 13	GS1, GS101	200333	Valve, 34VDC 2Way (Prior to LE224832)	2	2
... 13	GS1, GS101	219062	Valve, Gas W/Fittings 34VDC (Eff w/LE224832 Thru LG190586W)	2	2
... 13	GS1, GS101	228035	Valve, 34VDC 1Way .750-14 Thd 2mm Orf 100PSI (Eff w/LG190586W)	2	2
... 14		010494	Bushing, Snap-in Nyl 1.375 Id X 1.750 Mtg Hole	2	2
... 15		134201	Stand-Off Support, PC Card .312/.375w/Post&lock .43	17	17
... 16		204721	Enclosure, Control	1	1
... 17	PC60	210692	Circuit Card Assy, Meter W/Program (Prior to LE289214)	0	1
... 17	PC60	220801	Circuit Card Assy, Meter W/Program (Eff w/LE289214 Thru LF313805)	0	1
... 17	PC60	224805	Circuit Card Assy, Meter W/Program D-74D (Eff w/LF313806 Thru LJ490633U)	0	1
... 17	PC60	239934	Circuit Card Assy, Meter W/Program D-74D (Eff w/LJ490634U)	0	1
... 17	PC40	208323	Circuit Card Assy, Master W/Program D-74 (Prior to LE289214)	1	0
... 17	PC40	220797	Circuit Card Assy, Master W/Program D-74 (Eff w/LE289214 Thru LJ490633U)	1	0
... 17	PC40	239937	Circuit Card Assy, Master W/Program D-74 (Eff w/LJ490634U)	1	0
... 18	R1, R101	073562	Potentiometer, Cp Std Slot 1T 2. W 10K Linear D-74S	2	0
... 18	R1, 101, 70, 170	603856	Potentiometer, ww Slted Sft 10/T 2W 10K Ohm D-74D (Prior to LF198762)	0	4
... 18	R1, 101, 70, 170	224597	Pot, Cermet Std Flat 3.75T 2. W 10K Ohm Linear D-74D (Eff w/LF198762)	0	4
... 19		204723	Panel, Front	1	1
... 20		204724	Nameplate, Miller Lower	1	1
... 20		207428	Nameplate, Lower (CE Version)	1	1
... 21	S2, S102	200295	Switch, Rocker Spdt 15A 12V (On)-Off-(On)	2	2
... 22	S3, S103	201642	Switch, Rocker Spdt 15A 12V On-None-On	2	2
... 23	S100	201641	Switch, Rocker Spdt 15A 12V (On)-Off-(On) W/Leds	1	1
... 24		193919	Knob, Pointer 1.250 Dia X .250 Id W/Two Set Screws (Prior to ME405021U)	4	4
... 24		245663	Knob, Pointer 1.250 Dia X .250 Id W/Two Set Screws (Eff w/ME405021U)	0	4
.....		266920	Nut, 375-32 .50 Hex .36H w/Blk Neoprene Pot Seal (Eff w/ME405021U)	0	4
.....		267129	Spacer, Nylon .745 Od X .387 Id X .187L (Eff w/ME405021U)	0	4
... 25		206513	Nameplate, Miller D-74S Upper	1	0
... 25		206511	Nameplate, Miller D-74D Upper	0	1
... 25		207431	Nameplate, Upper (CE Version) D-74S	1	0
... 25		207433	Nameplate, Upper (CE Version) D-74D	0	1
... 26	RC13, RC113	048282	RCPT w/Skts, (Service Kit)	2	2
... 27		211989	Fitting, w/Screen (Eff w/LC682849)	2	2

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

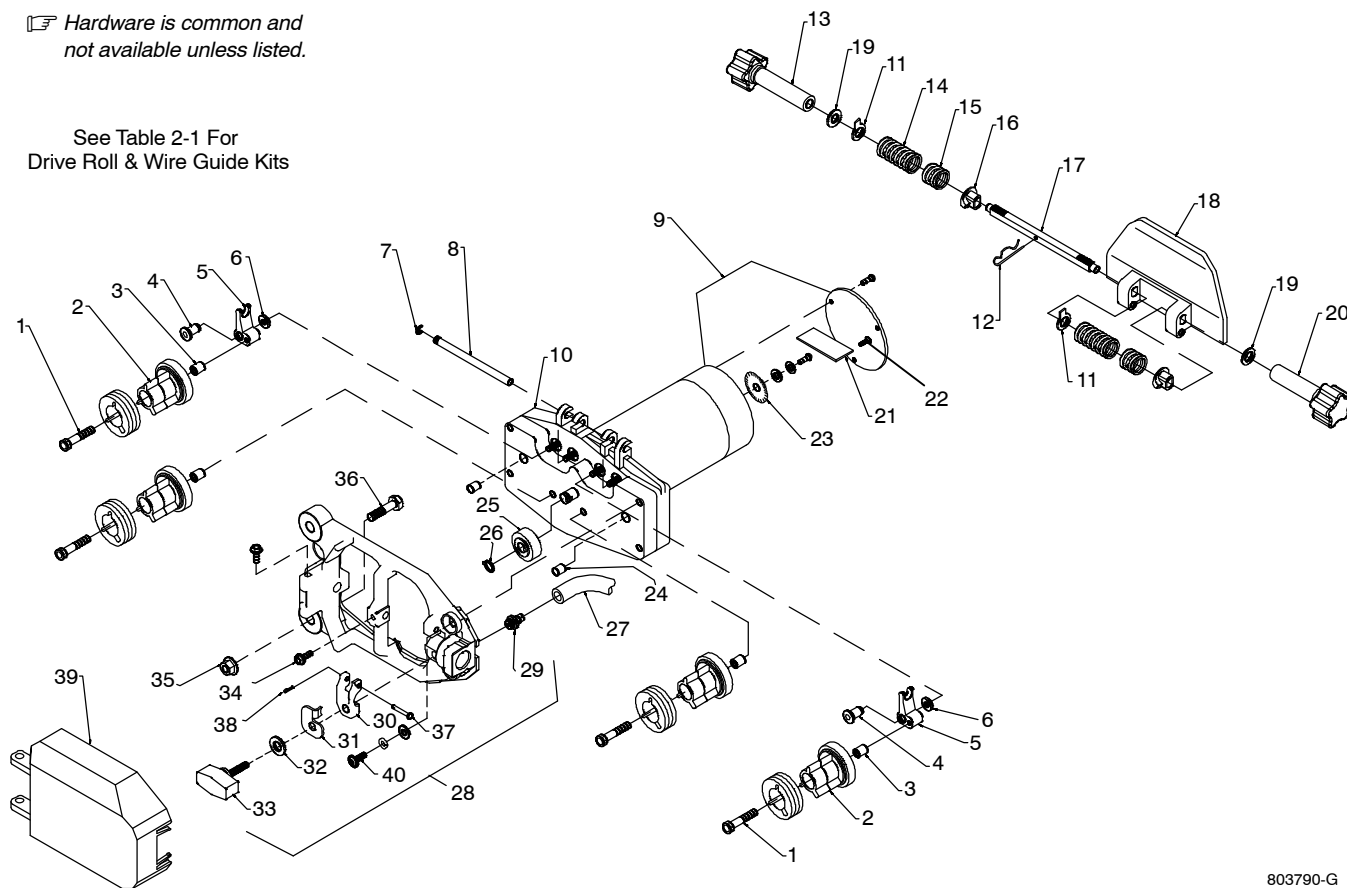
**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**



# Eff w/Serial No. LC682849 And Following

☞ Hardware is common and not available unless listed.

See Table 2-1 For Drive Roll & Wire Guide Kits



803790-G

**Figure 2-3. Drive Assembly, Wire**

Item No.	Diagram marking	Part No.	Description	Quantity	
				D-74S	D-74D

**Figure 2-3. Drive Assembly, Wire (Figure 2-1 Item 4)**

...	1	010668	.. Screw, Cap Stl Sch .250-20 X 1.500	4	4
...	2	172075	.. Carrier, Drive Roll W/Components	4	4
...	3	149962	.. Spacer, Carrier Drive Roll	4	4
...	4	149486	.. Pin, Rotation Arm Rocker	2	2
...	5	132750	.. Arm, Pressure	2	2
...	6	150520	.. Spacer, Flat Stl .257 Id X .619 Od X .105	2	2
...	7	133493	.. Ring, Retaining Ext .250 Shaft X .025thk	2	2
...	8	133350	.. Pin, Hinge	1	1
...	9	M1,101	.. Motor, Gear 1/8Hp 24VDC Low Speed (Eff w/MB310253U)	1	1
...	9	M1,101	.. Motor, Gear 1/8Hp 24VDC Standard Speed (Prior to MJ395009U)	1	1
...	9	M1,101	.. Motor, Gear 1/8Hp 24VDC Standard Speed (Eff w/MJ395009U)	1	1
...	9	M1,101	.. Motor, Gear 1/8Hp 24VDC High Speed (Optional)	1	1
...		153491	.... Kit, Brush Replacement (Consisting Of)	1	1
...		153492	.... Cap, Brush	2	2
...		*153493	.... Brush, Carbon	2	2
...		184136	.... Kit, Brush Holder Replacement	1	2
...	10	155098	.. Kit, Cover Motor Gearbox (Consisting Of)	1	1
...		153550	.... Cover, Motor Gearbox (Consisting Of)	1	1
...		155099	.... Gasket, Cover	1	1
...		155100	.... Screw, Cover	5	5
...		154031	.... Spacer, Locating	2	2
...		133493	.... Ring, Rtnng Ext .250 Shaft Grv X .025Thk	1	1
...		203642	.. Pressure Arm, R & Vert L 4 Roll (Consisting Of)	1	1
...		203631	.. Pressure Arm, S/L & Vert S/R 4 Roll (Consisting Of)	1	1
...	11	182414	.... Washer, Flat (Prior to LE224832)	2	2

# Eff w/Serial No. LC682849 And Following

Item No.	Diagram marking	Part No.	Description	Quantity	
				Model	
				D-74S	D-74D
<b>Figure 2-3. Drive Assembly, Wire (Continued)</b>					
11		203641	Washer, Flat Indicator Spring Tension (Eff w/LE224832)	2	2
12		182415	Pin, Cotter Hair	1	1
13		203640	Knob, W/Extension Short Pressure Arm	1	1
14		182156	Spring, Cprsn	2	2
15		182155	Spring	2	2
16		132746	Bushing, Spring	2	2
17		203633	Shaft, Spring	1	1
18		203632	Carrier, Shaft Dual Knob	1	1
19		133739	Washer, Flat Buna .375 Id X .625 Od X .062thk	2	2
20		203637	Knob, W/Extension Long Pressure Arm	1	1
21	PC51,151	201225	Circuit Card, Digital Tach (Consisting Of) (Prior to LJ490634U)	0	1
21	PC51,151	237048	Circuit Card, Digital Tach (Consisting Of) (Eff w/LJ490634U)	0	1
	PLG5	131204	Connector & Sockets	0	1
		604311	Grommet, Rbr .250 Id X .375mtg Hole .062 Groove	0	1
22		282892	Screw, 006-32X .25 Flathd-Slt Stl Pld (Eff w/MJ395009U)	1	1
23		132611	Optical Encoder Disc	0	1
		603115	Weather Stripping, Adh .125 X .375	0	1
24		167387	Spacer, Locating	2	2
25		168825	Drive, Pinion	1	2
26		133308	Ring, Retaining Ext .375 Shaft X .025thk	1	1
27		134834	Hose, Sae .187 Id X .410 Od (Order By Ft)	2 Ft (0.6 m)	
28		179265	Adapter Gun/Feeder Lh (Consisting Of) (Prior to MG035054U)	1	1
28		244579	Adapter Assy, Gun/Feeder Lh Accu-Mate (Consisting Of) (Eff w/MG035054U)	1	1
28		179264	Adapter, Gun/Feeder Rh (Consisting Of) (Prior to MG035054U)	1	1
28		244587	Adapter Assy, Gun/Feeder Rh Accu-Mate (Consisting Of) (Eff w/MG035054U)	1	1
28		281140	Kit, Adapter Assy Gun/Feeder LH ACCU-MATE (Includes) Eff w/MJ395009U)	1	1
28		281141	Kit, Adapter Assy Gun/Feeder RH ACCU-MATE (Includes) Eff w/MJ395009U)	1	1
		281132	Adapter Assy, LH (Includes)	1	1
		281131	Adapter Assy, RH (Includes)	1	1
29		149959	Fitting, Brs Barbed M 3/16Tbg X .312-24	1	1
30		278295	Clamp, Power Pin Cast	1	1
31		242261	Lock, Power Pin	1	1
32		604538	Washer, Flat Stl Sae .312 (Prior to MG035054U)	1	1
32		231232	Washer, Flat .344idx0.688odx.065T Stl Pld Ansi.312 (Eff w/MG035054U)	1	1
33		151437	Knob, Plstc T 1.125 Lg X .312-18 X 1.500	1	1
34		151290	Screw, Mach Stl Hexwhd 10-32 X .500	2	2
35		601872	Nut, Stl Hex Full Fnsh .375-16 (Prior to ME225013U)	1	1
35		167788	Nut, 375-16 .56Hex .34H Stl Pld Sem Cone Wshr.88D (Eff w/ME225013U)	1	1
36		601966	Screw, Cap Stl Hexhd .375-16 X 1.250	1	1
37		234073	Pin, Hinge	1	1
38		280558	Pin, Cotter Hair .047 X .625 Zinc Pld	1	1
39		179277	Cover, Drive Roll (Consisting Of)	1	1
		178937	Label, Warning Electric Shock (Prior to MG035054U)	1	1
		269731	Label, Warning Hot Surfaces And Moving Parts (Eff w/MG035054U thru MH345091U)	1	1
		275806	Label, Warning Hot Surfaces And Moving Parts (Eff w/MH345092U)	1	1
40		281490	Screw, 250-20X .75 Truswhd Soc Stl	4	4

\*Recommended Spare Parts.

**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**




	"V" GROOVE FOR HARD WIRE	"U" GROOVE FOR SOFT-SHELLED CORED WIRES	"V" KNURLED FOR HARD-SHELLED CORED WIRES	"U" COGGED FOR EXTREMELY SOFT WIRE OR SOFT-SHELLED CORED WIRES	POLISHED "U" GROOVE FOR ALUMINUM WIRES CONTAINS NYLON WIRE GUIDES
					
<b>WIRE SIZE</b>					
.023/.025 in. (0.6 mm)	151024				
.030 in. (0.8 mm)	151025				
.035 in. (0.9 mm)	151026		151052		265255
.040 in. (1.0 mm)	161190				
.045 in. (1.1/1.2 mm)	151027	151037*	151053	151070	265256*
.052 in. (1.3/1.4 mm)	151028	151038	151054	151071	
1/16 in. (1.6 mm)	151029	151039	151055	151072	265257
.068/.072 in. (1.8 mm)			151056		
5/64 in. (2.0 mm)		151040	151057	151073	
3/32 in. (2.4 mm)		151041	151058	151074	
7/64 in. (2.8 mm)		151042	151059	151075	
1/8 in. (3.2 mm)		151043**	151060**	151076**	
*Accommodates .045 and .047 (3/64 in) wire					
**Requires a low-speed wire feeder					
<b>Wire Guides</b>					
<b>Nylon Wire Guides for Feeding Aluminum Wire</b>					
Wire Sizes	Inlet Guide	Intermediate Guide	Wire Size	Inlet Guide	Intermediate Guide
.023 to .040 in. (0.6 to 1.0mm)	221030	149518	.035 in. (0.9mm)	221912	242417
.045 to .052 in. (1.1 to 1.4mm)	221030	149519	.047 in. (1.2mm)	221912	205936
1/16 to 5/64 in. (1.6 to 2mm)	221030	149520	1/16 in. (1.6mm)	221912	205937
3/32 to 7/64 in. (2.4 to 2.8mm)	229919	149521			
1/8 in. (3.2mm)	229919	149522			

Table 2-1. Drive Roll And Wire Guide Kits





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