

70 Series

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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 .023–5/64 in (0.6–2 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

Bernard® Q-Gun™ and drive rolls included. One set of each .035 in (0.9 mm) and .045 in (1.1/1.2 mm) “V” groove drive rolls.

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.

10 ft, 14-pin interconnecting cord for the operator to hook up.

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
3YR. WARRANTY

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

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



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www.MillerWelds.com



Specifications (Subject to change without notice.)

CV (Use with CV Power Sources.)

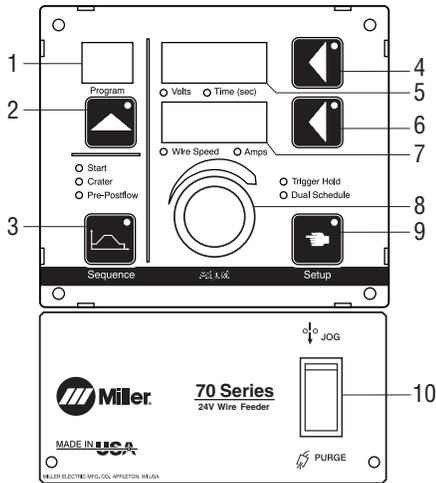
Input Power	Electrode Wire Diameter Capacity	Wire Speed*	Dimensions		Net Weight	
			S-74 (Single)	D-74 (Dual)	S-74 (Single)	D-74 (Dual)
24 VAC, 10 A, 50/60 Hz	.023–5/64 in (0.6–2 mm)	50–780 IPM (1.3–19.8 m/min) Optional High Speed Motor: 90–1440 IPM (2.3–36.6 m/min)	H: 14 in (356 mm) W: 12 in (305 mm) 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)

*Note: When using 3/32 – 1/8 in (2.4 – 3.2 mm) wires contact Miller Electric Mfg. Co. at 1-920-735-4505 for more information on Low Speed options.

Control Panel

S-74DX Model

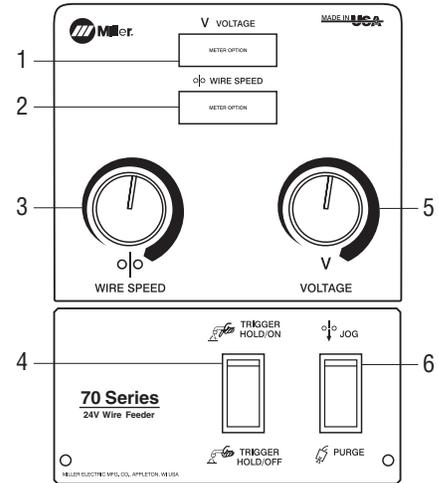
1. Program Display
2. Program # Select
3. Weld Sequence
4. Voltage/Time Select
5. Voltage/Time Display Meter
6. Wire Feed/Amperage Select
7. Wire Speed/Amperage Display Meter
8. Control Knob
9. Trigger Hold/Dual Schedule Control
10. Jog/Purge



S-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

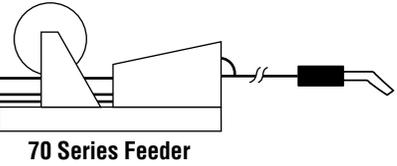
Swingarc boom-mounted semiautomatic wire feeders bring an extra dimension of flexibility and efficiency to high-production wire welding stations. You get an effective solution that maximizes output, especially when dealing with large weldments and hard-to-reach places. See Lit. Index No. M/13.11.

Typical Installation

Miller electrically controlled CV and CC/CV power source with a 14-pin receptacle and 24 VAC supply

10 ft (3 m) 24 VAC, Contactor and Voltage Control Cord (supplied with feeder)

Weld Power Cable and Gas Hose (not supplied with feeder)



Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
S-74S	#195 057	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 057-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
S-74D	#195 058	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 058-01-1	With high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 058-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 058-03-1	With CE, Euro, high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
S-74DX	#195 059	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 059-01-1	With high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 059-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 059-03-1	With CE, Euro, high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
D-74S	#195 060	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 060-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
D-74D	#195 061	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 061-01-1	With high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 061-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 061-03-1	With CE, Euro, high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
D-74DX	#195 062	15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 062-01-1	With high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 062-02-1	With CE, Euro, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
	#195 062-03-1	With CE, Euro, high-speed motor, 15 ft (4.6 m) Bernard Q400 gun and drive rolls		
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>)		
Replacement Gun and Consumables				
Bernard® Q400	#Q4015AE8EM	400 A, 15 ft (4.6 m)		
Centerfire™ consumables				
Power Sources				
CP-302		See Lit. Index No. 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		
Accessories				
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/O 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:

