



Miller Drive Rolls

Machine	V-Groove .023/.024 (0.6 mm)	V-Groove .030 (0.8 mm)	V-Groove .035 (0.9 mm)	V-Groove .045 (1.2 mm)	V-Knurl .030 (0.8 mm)	V-Knurl .035 (0.9 mm)	V-Knurl .045 (1.2 mm)	V-Knurl .062 (1.6 mm)	Inlet Wire Guide
SideKick™/SideKick™ XL	090 423	090 423	090 423	—	165 603	165 603	127 229	—	058 549 ⁶
Cricket®/Cricket® XL	119 028	119 028	—	—	119 028	119 028	119 028	—	058 549
Millermatic® 35	058 553 & 057 590	057 590 (2)	057 590 (2)	—	—	—	—	—	058 549 ⁷
Millermatic® 90/130/Challenger™	119 028	119 028	—	—	119 028	119 028	119 028	—	058 549
Millermatic® 130 XP/150/185/ Challenger™ 172	090 423	090 423	090 423	—	165 603	165 603	127 229	—	058 549
Millermatic® 135/175/180s/140s/211/ Passport™/Passport™ Plus	202 925	202 925	202 925	—	202 926	202 926	202 926	—	058 549
Millermatic® ¹ 200/210/212s /250/250X/251/ 252/300 without Meters/DVI™/ Pulser/Vintage/Reach	087 131 (kit)	079 594 (kit)	079 595 (kit)	079 596 (kit)	—	079 606	079 607	—	Page 46
Millermatic® 300 with Meters/350P	087 132	046 780	046 781	046 782	—	046 792	046 793	—	Page 47
Spoolmate™ 100/185/3035	—	—	—	—	186 414 186 413	186 414 186 413	—	—	186 410
Spoolmate™ 250/3545	—	—	—	—	186 414 186 413	186 414 186 413	199 397 199 396	—	186 410
Spoolmatic® 15A/30A	—	—	—	—	136 135 ³ 183 357 ⁴	136 135 ³ 183 357 ⁴	136 135 ³ 183 358 ⁴	136 135 ³ 183 358 ⁴	132 521
Spoolmatic® 1, 2, 3	—	—	—	—	053 131	053 131	053 131	053 131	058 549
XR™-15/XR™-30 ²	—	—	—	—	053 131	053 131	053 131	053 131	On Conduit
XR™-A/XR™-W Pistol	—	—	—	—	136 135 ³ 183 357 ⁴	136 135 ³ 183 357 ⁴	136 135 ³ 183 358 ⁴	136 135 ³ 183 358 ⁴	On Conduit
XR™-Edge	—	—	—	—	194 114 198 434 ⁵	194 115 198 435 ⁵	194 116 198 437 ⁵	194 117 198 438 ⁵	On Conduit
XR™-Python/XR™	—	—	—	—	215 672 215 677 ⁵ (N/A)	215 672 215 678 ⁵	215 672 215 681 ⁵	215 672 215 684 ⁵	On Conduit
XR™-Auma-Pro™	—	—	—	—	227 434	227 434	227 434	224 434	227 408 ⁸ 230 711 ⁹

¹Dual V-Groove .030 & .035 (0.8 & 0.9 mm) drive roll kit also available #204 579

²Prior to serial number KC171637

³Dual-groove drive roll, large and small covering all wire sizes

⁴Dual-groove drive roll covering two sizes

⁵Optional — see pages 43-44 for additional drive rolls and information

⁶Prior to serial number JJ497360 - #056 081

⁷Prior to serial number JJ389988 - #056 081

⁸#227 408 compatible with .030, .035 & .045 in wire

⁹#230 711 compatible with 1/16 in wire

Hobart Drive Rolls

Machine	Hard Wire (Steel)			Soft Wire (Aluminum)	HT Wire (Hard Tubular)			Inlet Wire Guide
	V-Groove .024 (0.6 mm)	V-Groove .030-.035 (0.8-0.9 mm)	V-Groove .045 (1.2 mm)	Urethane .035 (0.9 mm)	V-Knurl .030-.035 & .045 (0.8-0.9 & 1.2 mm)	Rev. Knurl .030 & .035 (0.8 & 0.9 mm)	Rev. Knurl .039-.045 (0.8-1.2 mm)	
Handler® 120/130XL/ 135/140/150/170/175/ 180/187/210	202 925 or 407230-004	202 925	407230-004	203 568 (N/A)	202 926	193 330	193 331	197 309 ¹⁰
IronMan™ 210/250	—	202 925	407230-004	203 568 (N/A)	202 926	193 330	193 331	197 309 ¹⁰
IronMan™ 275	All Sizes — See drive rolls for 52 Series Feeders on page 46							
Handler® 125, 125EZ	#212 379 — 2-sided combination roll (.024 V-groove) (.030/.035 VK-groove)							212 368

Note: For all Beta-MIG drive rolls, contact Miller Service Parts

¹⁰Available for Handler 120 and IronMan 210

Conversion Kits

Part #	Description	Part #	Description
155 454	2 Roll Conversion Kit	155 455	4 Roll Conversion Kit

Quick-Change Drive Roll Carrier Kits... Save Time... Save Money!

Changing drive rolls on the older series Miller wire feeders is a snap with the quick-change drive roll carrier kits listed below. Once converted, the old routine of removing the drive rolls screw-by-screw (3-per drive roll) is history! Now, all that's required to change a drive roll is a turn of the wrist and off comes the old drive roll and on with the new! Customers will save time, money and frustration. Also, installations with both the old series feeders and our 60 and 70 Series feeders will appreciate being able to update their older equipment and standardize procedures. Kits are available for feeders manufactured prior to serial number KF876252 outlined below.

For 2 Drive Roll Feeders

- S-22A, S-22P8, S-22P12
- S-32S, S-32SL
- S-32P8, S-32P12
- S-32SC8, S-32SC12
- S-52A, S-52D, S-52E, S-52M
- D-52A, D-52D, D-52M
(Two kits required on these models)
- 50 Series style Swingarc™
- Porta-MIG
- Millermatic® 200
- Millermatic® 250 and 250MP
(Prior to serial number KF785867)

For 4 Drive Roll Feeders

- S-54A, S-54D, S-54E, S-54M
- D-54A, D-54D, D-54M
(Two kits required for Dual Feeders)

For Automatic Wire Drive Assemblies

- A1-2, A1D-2
- A2-2L, A2-2H
- A1-4, A1D-4
- A2-4L, A2-4H



2 Roll Conversion Kit
#155 454



4 Roll Conversion Kit
#155 455

Special Optional Drive Rolls

For 22/32/52/54/60/70 Series Feeders

Part #	Description
#203 526	Dual V-Groove (one .030 and one .035 in groove)
#189 285	Dual V-Groove (one .035 and one .045 in groove)
#239 895	Dual V-Groove (2 drive rolls each with one .035 and one .045 in groove plus inlet guide)
#209 533	Dual V-Groove 4 Roll Kit (4 drive rolls each with one .035 and one .045 in groove plus guides and setscrew)
#198 078	No-Groove, Universal Quick-Change (Steel)
#088 402	No-Groove, Non-Quick-Change (Hard Urethane — Green)
#0537160010890	No-Groove (Soft Urethane — Blue)