

DRIVE ROLLS



Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. U-Grooved rolls for soft and soft shelled cored wires.
3. U-Cogged rolls for extremely soft shelled wires.
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirement (example: V-Knurled roll in combination with U-Grooved).

For a listing of special optional drive rolls:

see page 50

Drive Rolls

Millermatic® 200/210/212/250/251/252/DVI's/Pulser/Vintage (2 Drive Roll)
22/32/52 Series, SuitCase™ 8/12RC & 8/12VS, Reach Feeders (2 Drive Roll)

| Wire Diameter | | | Drive Rolls | | | |
|------------------|------------------|-----------------|-------------|----------------------|------------------------------|--------------------|
| Fraction | Decimal | Metric | Type | Kit # | Individual Drive Roll Part # | Inlet Wire Guide # |
| .023 – .025 in | .023 – .025 in | 0.6 mm | V-Grooved | 087 131 | 087 130 | 056 192 |
| .030 in | .030 in | 0.8 mm | V-Grooved | 079 594 | 053 695 | 056 192 |
| .030 and .035 in | .030 and .035 in | 0.8 and 0.9 mm | V-Grooved | 204 579 ¹ | 203 526 ¹ | 056 192 |
| .035 and .045 in | .035 and .045 in | 0.9 and 1.22 mm | V-Grooved | 239 895 | 189 285 | 056 193 |
| .035 in | .035 in | 0.9 mm | V-Grooved | 079 595 | 053 700 | 056 192 |
| .045 in | .045 in | 1.2 mm | V-Grooved | 079 596 | 053 697 | 056 193 |
| .052 in | .052 in | 1.3 mm | V-Grooved | 079 597 | 053 698 | 056 193 |
| 1/16 in | .062 in | 1.6 mm | V-Grooved | 079 598 | 053 699 | 056 195 |
| .035 in | .035 in | 0.9 mm | U-Grooved | 044 749 | 072 000 | 221 912 |
| 3/64 in | .047 in | 1.2 mm | U-Grooved | 079 599 | 053 701 | 221 912 |
| .052 in | .052 in | 1.3 mm | U-Grooved | 079 600 | 053 702 | 221 912 |
| 1/16 in | .062 in | 1.6 mm | U-Grooved | 079 601 | 053 706 | 056 195 |
| 5/64 in | .079 in | 2.0 mm | U-Grooved | 079 602 | 053 704 | 056 195 |
| 3/32 in | .094 in | 2.4 mm | U-Grooved | 079 603 | 053 703 | 056 196 |
| 7/64 in | .110 in | 2.8 mm | U-Grooved | 079 604 | 053 705 | 056 196 |
| 1/8 in | .126 in | 3.2 mm | U-Grooved | 079 605 | 053 707 | 056 197 |
| .035 in | .035 in | 0.9 mm | V-Knurled | 079 606 | 132 958 | 056 192 |
| .045 in | .045 in | 1.2 mm | V-Knurled | 079 607 | 132 957 | 056 193 |
| .045 and 1/16 in | .045 and 1/16 in | 1.22 and 1.6 mm | VK-Grooved | 238 687 | 238 688 | 221 030 |
| .052 in | .052 in | 1.3 mm | V-Knurled | 079 608 | 132 956 | 056 193 |
| 1/16 in | .062 in | 1.6 mm | V-Knurled | 079 609 | 132 955 | 056 195 |
| .068 – .072 in | .068 – .072 in | 1.8 mm | V-Knurled | 089 984 | 132 959 | 056 195 |
| 5/64 in | .079 in | 2.0 mm | V-Knurled | 079 610 | 132 960 | 056 195 |
| 3/32 in | .094 in | 2.4 mm | V-Knurled | 079 611 | 132 961 | 056 196 |
| 7/64 in | .110 in | 2.8 mm | V-Knurled | 079 612 | 132 962 | 056 196 |
| 1/8 in | .126 in | 3.2 mm | V-Knurled | 079 613 | 132 963 | 056 197 |
| .045 in | .045 in | 1.2 mm | U-Cogged | 083 318 | 083 489 | 056 193 |
| .052 in | .052 in | 1.3 mm | U-Cogged | 083 317 | 083 490 | 056 193 |
| 1/16 in | .062 in | 1.6 mm | U-Cogged | 079 614 | 053 708 | 056 195 |
| 5/64 in | .079 in | 2.0 mm | U-Cogged | 079 615 | 053 710 | 056 195 |
| 3/32 in | .094 in | 2.4 mm | U-Cogged | 079 616 | 053 709 | 056 196 |
| 7/64 in | .110 in | 2.8 mm | U-Cogged | 079 617 | 053 711 | 056 196 |
| 1/8 in | .126 in | 3.2 mm | U-Cogged | 079 618 (N/A) | 053 712 | 056 197 |

¹Dual-size reversible V-groove drive roll (one .030 and one .035 in groove)

22/24 Series & SuitCase Feeders Nylon Wire Guides (For Feeding Aluminum Wire)

| Wire Diameter | Inlet Guide # |
|------------------|---------------|
| .047 in (1.2 mm) | 151 203 |
| 1/16 in (1.6 mm) | 151 205 |
| 3/32 in (2.4 mm) | 194 264 |

Note: Each drive roll kit contains 2 Drive Rolls and an Inlet Guide.

Note: U-Groove drive rolls are recommended when feeding aluminum wire.



4 Roll Kit

Drive Rolls **Millermatic® 300/350/350P with Meters (4 Drive Roll)** **54 Series, 24A & R-115 Feeders (4 Drive Roll)**

| Wire Diameter | | | Drive Rolls | | | Wire Guide | |
|------------------|------------------|----------------|-------------|----------------------------|------------------------------|----------------|----------------|
| Fraction | Decimal | Metric | Type | Kit # | Individual Drive Roll Part # | Inlet # | Intermediate # |
| .023 – .025 in | .023 – .025 in | 0.6 mm | V-Grooved | 087 132 | 087 130 | 056 192 | 056 206 |
| .030 in | .030 in | 0.8 mm | V-Grooved | 046 780 | 053 695 | 056 192 | 056 206 |
| .035 in | .035 in | 0.9 mm | V-Grooved | 046 781 | 053 700 | 056 192 | 056 206 |
| .035 and 3/64 in | .035/.045 in | 0.9/1.2 mm | V-Grooved | 227 061¹ | 189 285¹ | 056 193 | 056 207 |
| 3/64 in | .045 in | 1.2 mm | V-Grooved | 046 782 | 053 697 | 056 193 | 056 207 |
| .052 in | .052 in | 1.3 mm | V-Grooved | 046 783 | 053 698 | 056 193 | 056 207 |
| 1/16 in | .062 in | 1.6 mm | V-Grooved | 046 784 | 053 699 | 056 195 | 056 209 |
| .035 in | .035 in | 0.9 mm | U-Grooved | 044 750 | 072 000 | 221 912 | 058 853 |
| 3/64 in | .047 in | 1.2 mm | U-Grooved | 046 785 | 053 701 | 221 912 | 058 853 |
| .035 and 3/64 in | .035 and .045 in | 1.9 and 1.2 mm | U-Grooved | 234 681 | 232 826 | 221 912 | 233 843 |
| .052 in | .052 in | 1.3 mm | U-Grooved | 046 786 | 053 702 | 221 912 | 058 837 |
| 1/16 in | .062 in | 1.6 mm | U-Grooved | 046 787 | 053 706 | 058 836 | 058 837 |
| 5/64 in | .079 in | 2.0 mm | U-Grooved | 046 788 | 053 704 | 056 195 | 056 209 |
| 3/32 in | .094 in | 2.4 mm | U-Grooved | 046 789 | 053 703 | 056 196 | 056 210 |
| 7/64 in | .110 in | 2.8 mm | U-Grooved | 046 790 | 053 705 | 056 196 | 056 210 |
| 1/8 in | .126 in | 3.2 mm | U-Grooved | 046 791 | 053 707 | 056 197 | 056 211 |
| .035 in | .035 in | 0.9 mm | V-Knurled | 046 792 | 132 958 | 056 192 | 056 206 |
| 3/64 in | .045 in | 1.2 mm | V-Knurled | 046 793 | 132 957 | 056 193 | 056 207 |
| .052 in | .052 in | 1.3 mm | V-Knurled | 046 794 | 132 956 | 056 193 | 056 207 |
| 1/16 in | .062 in | 1.6 mm | V-Knurled | 046 795 | 132 955 | 056 195 | 056 209 |
| 5/64 in | .079 in | 2.0 mm | V-Knurled | 046 796 | 132 960 | 056 195 | 056 209 |
| 3/32 in | .094 in | 2.4 mm | V-Knurled | 046 797 | 132 961 | 056 196 | 056 210 |
| 7/64 in | .110 in | 2.8 mm | V-Knurled | 046 798 | 132 962 | 056 196 | 056 210 |
| 1/8 in | .126 in | 3.2 mm | V-Knurled | 046 799 | 132 963 | 056 197 | 056 211 |
| 3/64 in | .045 in | 1.2 mm | U-Cogged | 083 319 | 083 489 | 056 193 | 056 207 |
| .052 in | .052 in | 1.3 mm | U-Cogged | 083 320 (N/A) | 083 490 | 056 193 | 056 207 |
| 1/16 in | .062 in | 1.6 mm | U-Cogged | 046 800 | 053 708 | 056 195 | 056 209 |
| 5/64 in | .079 in | 2.0 mm | U-Cogged | 046 801 | 053 710 | 056 195 | 056 209 |
| 3/32 in | .094 in | 2.4 mm | U-Cogged | 046 802 | 053 709 | 056 196 | 056 210 |
| 7/64 in | .110 in | 2.8 mm | U-Cogged | 046 803 | 053 711 | 056 196 | 056 210 |
| 1/8 in | .126 in | 3.2 mm | U-Cogged | 046 804 | 053 712 | 056 197 | 056 211 |

¹Dual-size reversible V-groove drive roll (one .035 and one .045 in groove)

52 & 54 Series Nylon Wire Guides (For Feeding Aluminum Wire)

| Wire Diameter | Inlet Guide # | Intermediate Guide # |
|-----------------------------|----------------------|----------------------|
| .035 – .047 in (0.9–1.2 mm) | 058 854 | 058 853 |
| 1/16 in (1.6 mm) | 058 836 | 058 837 |
| 3/32 in (2.4 mm) | 058 845 (N/A) | 058 841 (N/A) |

Note: Each drive roll kit contains 4 Drive Rolls, an Inlet Guide, and an Intermediate Guide.

Note: U-Groove drive rolls are recommended when feeding aluminum wire.

DRIVE ROLLS



Base selection of drive rolls upon the following recommended usages:

1. V-Grooved rolls for hard wire.
2. U-Grooved rolls for soft and soft shelled cored wires.
3. U-Cogged rolls for extremely soft shelled wires.
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirement (example: V-Knurled roll in combination with U-Grooved).

For a listing of special optional drive rolls:

see page 50

Drive Rolls

60 Series (2 & 4 Roll Kits) and 74 Series Feeders (4 Roll Kits)

| Wire Diameter | | | Drive Rolls | | | | Wire Guide | |
|------------------|--------------|------------|-------------|----------------------|----------------------|------------------------------|------------|----------------------------------|
| Fraction | Decimal | Metric | Type | 2 Roll Kit # | 4 Roll Kit # | Individual Drive Roll Part # | Inlet # | Intermediate # |
| .023-.025 in | .023-.025 in | 0.6 mm | V-Grooved | 151 030 | 151 024 | 087 130 | 150 993 | 149 518 |
| .030 in | .030 in | 0.8 mm | V-Grooved | 151 031 | 151 025 | 053 695 | 150 993 | 149 518 |
| .035 in | .035 in | 0.9 mm | V-Grooved | 151 032 | 151 026 | 053 700 | 150 993 | 149 518 |
| .035 and 3/64 in | .035/.045 in | 0.9/1.2 mm | V-Grooved | 190 300 ¹ | 209 533 ¹ | 189 285 ¹ | 150 994 | 149 519 |
| .040 in | .040 in | 1.0 mm | V-Grooved | 161 189 | 161 190 | — | 150 993 | 149 518 |
| 3/64 in | .045 in | 1.2 mm | V-Grooved | 151 033 | 151 027 | 053 697 | 150 994 | 149 519 |
| .052 in | .052 in | 1.3 mm | V-Grooved | 151 034 | 151 028 | 053 698 | 150 994 | 149 519 |
| 1/16 in | .062 in | 1.6 mm | V-Grooved | 151 035 | 151 029 | 053 699 | 150 995 | 149 520 |
| .035 in | .035 in | 0.9 mm | U-Grooved | 151 044 | 151 036 | 072 000 | 150 993 | 149 518 |
| .035 and 3/64 in | .035/.045 in | 1.9/1.2 mm | U-Grooved | — | 244 293 | 232 826 | 221 912 | 242 417 (.035) 205 936 (3/64) |
| 3/64 in | .045 in | 1.2 mm | U-Grooved | 151 045 | 151 037 | 053 701 | 150 994 | 149 519 |
| .047 in | .047 in | 1.2 mm | U-Grooved | — | 243 234 | 053 701 | 221 912 | 205 936 |
| .052 in | .052 in | 1.3 mm | U-Grooved | 151 046 | 151 038 | 053 702 | 150 994 | 149 519 |
| 1/16 in | .062 in | 1.6 mm | U-Grooved | 151 047 | 151 039 | 053 706 | 150 995 | 149 520 |
| 5/64 in | .079 in | 2.0 mm | U-Grooved | 151 048 | 151 040 | 053 704 | 150 995 | 149 520 |
| 3/32 in | .094 in | 2.4 mm | U-Grooved | 151 049 | 151 041 | 053 703 | 150 996 | 149 521 |
| 7/64 in | .110 in | 2.8 mm | U-Grooved | 151 050 (N/A) | 151 042 | 053 705 | 150 996 | 149 521 |
| 1/8 in | .126 in | 3.2 mm | U-Grooved | 151 051 | 151 043 | 053 707 | 150 997 | 149 522 |
| .035 in | .035 in | 0.9 mm | V-Knurled | 151 061 | 151 052 | 132 958 | 150 993 | 149 518 |
| 3/64 in | .045 in | 1.2 mm | V-Knurled | 151 062 | 151 053 | 132 957 | 150 994 | 149 519 |
| .052 in | .052 in | 1.3 mm | V-Knurled | 151 063 | 151 054 | 132 956 | 150 994 | 149 519 |
| 1/16 in | .062 in | 1.6 mm | V-Knurled | 151 064 | 151 055 | 132 955 | 150 995 | 149 520 |
| .068-.072 in | .068-.072 in | 1.8 mm | V-Knurled | 151 065 | 151 056 | 132 959 | 150 995 | 149 520 |
| 5/64 in | .079 in | 2.0 mm | V-Knurled | 151 066 | 151 057 | 132 960 | 150 995 | 149 520 |
| 3/32 in | .094 in | 2.4 mm | V-Knurled | 151 067 | 151 058 | 132 961 | 150 996 | 149 521 |
| 7/64 in | .110 in | 2.8 mm | V-Knurled | 151 068 | 151 059 | 132 962 | 150 996 | 149 521 |
| 1/8 in | .126 in | 3.2 mm | V-Knurled | 151 069 | 151 060 | 132 963 | 150 997 | 149 522 |
| 3/64 in | .045 in | 1.2 mm | U-Cogged | 151 077 | 151 070 | 083 489 | 150 994 | 149 519 |
| .052 in | .052 in | 1.3 mm | U-Cogged | 151 078 | 151 071 | 083 490 | 150 994 | 149 519 |
| 1/16 in | .062 in | 1.6 mm | U-Cogged | 151 079 | 151 072 | 053 708 | 150 995 | 149 520 |
| 5/64 in | .079 in | 2.0 mm | U-Cogged | — | 151 073 | 053 710 | 150 995 | 149 520 |
| 3/32 in | .094 in | 2.4 mm | U-Cogged | 151 081 | 151 074 | 053 709 | 150 996 | 149 521 |
| 7/64 in | .110 in | 2.8 mm | U-Cogged | 151 082 (N/A) | 151 075 | 053 711 | 150 996 | 149 521 |
| 1/8 in | .126 in | 3.2 mm | U-Cogged | 151 083 (N/A) | 151 076 | 053 712 | 150 997 | 149 522 |

¹Dual-size reversible V-groove drive roll (one .035 and one .045 in groove)

60 & 70 Series Nylon Wire Guides (For Feeding Aluminum Wire)

| Wire Diameter | 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: Each drive roll kit contains 2 or 4 Drive Rolls, an Inlet Guide, an Intermediate Guide, and #045 233 Antiwear Guide with #604 612 Setscrew 8-32 x .125.

Note: U-Groove drive rolls are recommended when feeding aluminum wire.