

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).

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)
Multimatic™ 200, 215, 220 AC/DC and 255

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	087131	087130	056192
.030 in	.030 in	0.8 mm	V-Grooved	079594	053695	056192
.030 and .035 in	.030 and .035 in	0.8 and 0.9 mm	V-Grooved	204579 ¹	203526	056192
.035 and .045 in	.035 and .045 in	0.9 and 1.22 mm	V-Grooved	190300 ¹	189285	056193
.035 in	.035 in	0.9 mm	V-Grooved	079595	053700	056192
.045 in	.045 in	1.2 mm	V-Grooved	079596	053697	056193
.052 in	.052 in	1.3 mm	V-Grooved	079597	053698	056193
1/16 in	.062 in	1.6 mm	V-Grooved	079598	053699	056195
.035 in	.035 in	0.9 mm	U-Grooved	044749	072000	221912
3/64 in	.047 in	1.2 mm	U-Grooved	079599	053701	221912
.052 in	.052 in	1.3 mm	U-Grooved	—	053702	221912
1/16 in	.062 in	1.6 mm	U-Grooved	079601	053706	056195
5/64 in	.079 in	2.0 mm	U-Grooved	—	053704	056195
3/32 in	.094 in	2.4 mm	U-Grooved	—	053703	056196
7/64 in	.110 in	2.8 mm	U-Grooved	—	053705	056196
1/8 in	.126 in	3.2 mm	U-Grooved	—	053707	056197
.035 in	.035 in	0.9 mm	V-Knurled	079606	132958	056192
.045 in	.045 in	1.2 mm	V-Knurled	079607	132957	056193
.045 and 1/16 in	.045 and 1/16 in	1.22 and 1.6 mm	VK-Grooved	238687 ¹	238688	221030
.052 in	.052 in	1.3 mm	V-Knurled	079608	132956	056193
1/16 in	.062 in	1.6 mm	V-Knurled	079609	132955	056195
.068 – .072 in	.068 – .072 in	1.8 mm	V-Knurled	089984	132959	056195
5/64 in	.079 in	2.0 mm	V-Knurled	079610	132960	056195
3/32 in	.094 in	2.4 mm	V-Knurled	079611	132961	056196
7/64 in	.110 in	2.8 mm	V-Knurled	—	132962	056196
1/8 in	.126 in	3.2 mm	V-Knurled	—	132963	056197
.045 in	.045 in	1.2 mm	U-Cogged	083318	083489	056193
.052 in	.052 in	1.3 mm	U-Cogged	—	083490	056193
1/16 in	.062 in	1.6 mm	U-Cogged	079614	053708	056195
5/64 in	.079 in	2.0 mm	U-Cogged	—	053710	056195
3/32 in	.094 in	2.4 mm	U-Cogged	—	053709	056196
7/64 in	.110 in	2.8 mm	U-Cogged	—	053711	056196
1/8 in	.126 in	3.2 mm	U-Cogged	—	053712	056197

¹Dual-size reversible drive roll

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

Wire Diameter	Inlet Guide #
.047 in (1.2 mm)	151203
1/16 in (1.6 mm)	151205
3/32 in (2.4 mm)	194264

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

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

Miller Drive Rolls

	V-Groove	V-Groove	V-Groove	V-Groove	V-Knur1	V-Knur1	V-Knur1	Inlet Wire
Machine	.023/.024 (0.6 mm)	.030 (0.8 mm)	.035 (0.9 mm)	.045 (1.2 mm)	.030 (0.8 mm)	.035 (0.9 mm)	.045 (1.2 mm)	Guide
SideKick™/SideKick™ XL	090423	090423	090423	—	165603	165603	127229	058549
Cricket®/Cricket® XL	119028	119028	—	—	119028	119028	119028	058549
Millermatic® 35	—	057590 (2)	057590 (2)	—	—	—	—	058549
Millermatic® 90/130/Challenger	119028	119028	—	—	119028	119028	—	058549
Millermatic® 130 XP	090423	090423	090423	—	165603	165603	—	058549
Millermatic® 150/185	090423	090423	090423	—	165603	165603	127229	058549
Millermatic® Challenger™172	090423	090423	090423	—	165603	165603	127229	058549
Millermatic® Passport™/ Passport™ Plus 135/140/175/180/211	202925	202925	202925	—	202926	202926	202926	058549
Millermatic® 200/210/212/250/250x/251¹	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
Millermatic® 252/ 300 without meters¹	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
Millermatic® DVI™/Pulser/Vintage/Reach¹	087131 (kit)	079594 (kit)	079595 (kit)	079596 (kit)	—	079606	079607	Page 53
Millermatic® 300 with meters/350P	087132 (kit)	046780 (kit)	046781 (kit)	046782 (kit)	—	046792 (kit)	046793 (kit)	Page 54
Millermatic® 125 Hobby/141/190/211 standard drive²	261157	261157	261157	—	261157	261157	—	261151
Multimatic™ 200 standard drive rolls²	261157	261157	261157	—	261157	261157	261157	261151

¹Optional Drive Rolls V-Groove .030(0.8mm) and .035(0.9mm) 204579

²Optional Drive Rolls V-Groove .023/.024(0.6mm), .030(0.8mm) and .035(0.9mm) 220179; V-Knur1 .030(0.8mm), .035(0.9mm) and .045(1.2mm) 202926; Inlet Wire 261151

XR Controls Drive Rolls Polished U-Groove

Machine	268847	268847	268848	268849	268850
XR/XR-S/XR-D	.030 in. (.76 mm)	.035 in. (.89 mm)	.040 in. (1.02 mm)	.047 in. (1.19 mm)	.062 in. (1.58 mm)

Miller Spoolgun Drive Rolls

	V-Knur1	V-Knur1	V-Knur1	U-Knur1	Inlet Wire
Spoolguns	.030 in. (0.8 mm)	.035 in. (0.9 mm)	.045 in. (1.2 mm)	.062 in. (1.6 mm)	Guide
Spoolmate™ 100/185/3035	186414	186414	—	—	186410
Spoolmate™ 100/185/3035	186413	186413	—	—	186410
Spoolmate™ 200/3545	186414	186414	199397	—	186410
Spoolmate™ 200/3545	186413	186413	199396	—	186410
Spoolmate® 15A/30A	136135	136135	136135	136135	132521
Spoolmate® 15A/30A	183357	183357	183358	183358	132521
Spoolmate® 1, 2, 3	053131	053131	053131	053131	058549
XR™-15/XR™-30	053131	053131	053131	053131	on conduit
XR™-A /XR™-W Pistol	136135	136135	136135	136135	on conduit
XR™-A /XR™-W Pistol	183357	183357	183358	183358	on conduit
XR™-Edge	194114	194115	194116	194117	on conduit
XR™Aluma-Pro™	227434	227434	227434	227434	227408
XR™Aluma-Pro™ Lite	254756	254756	254756	254756	227408
XR™Aluma-Pro™ Plus	227434	227434	227434	227434	227408