



PM263704B

2023-05

Eff. w/Serial Number MD250001G And Following

Processes



MIG (GMAW) Welding

Flux Cored (FCAW) Welding

Description



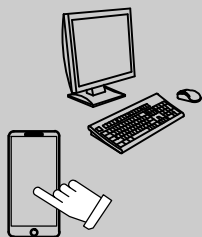
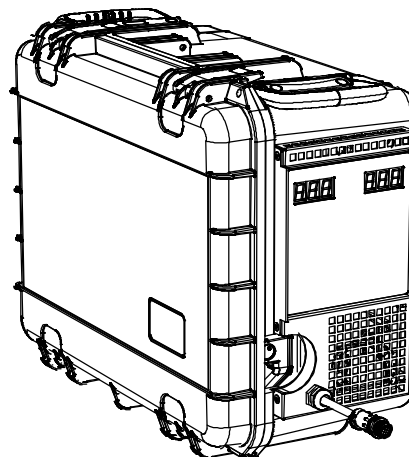
Wire Feeder

FieldProTM Smart Feeder

PARTS LIST

Eff w/MD250001G And Following

For OM262657 Revision A And Following



For product information,
Owner's Manual translations,
and more, visit

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☞ *Hardware is common and not available unless listed.*

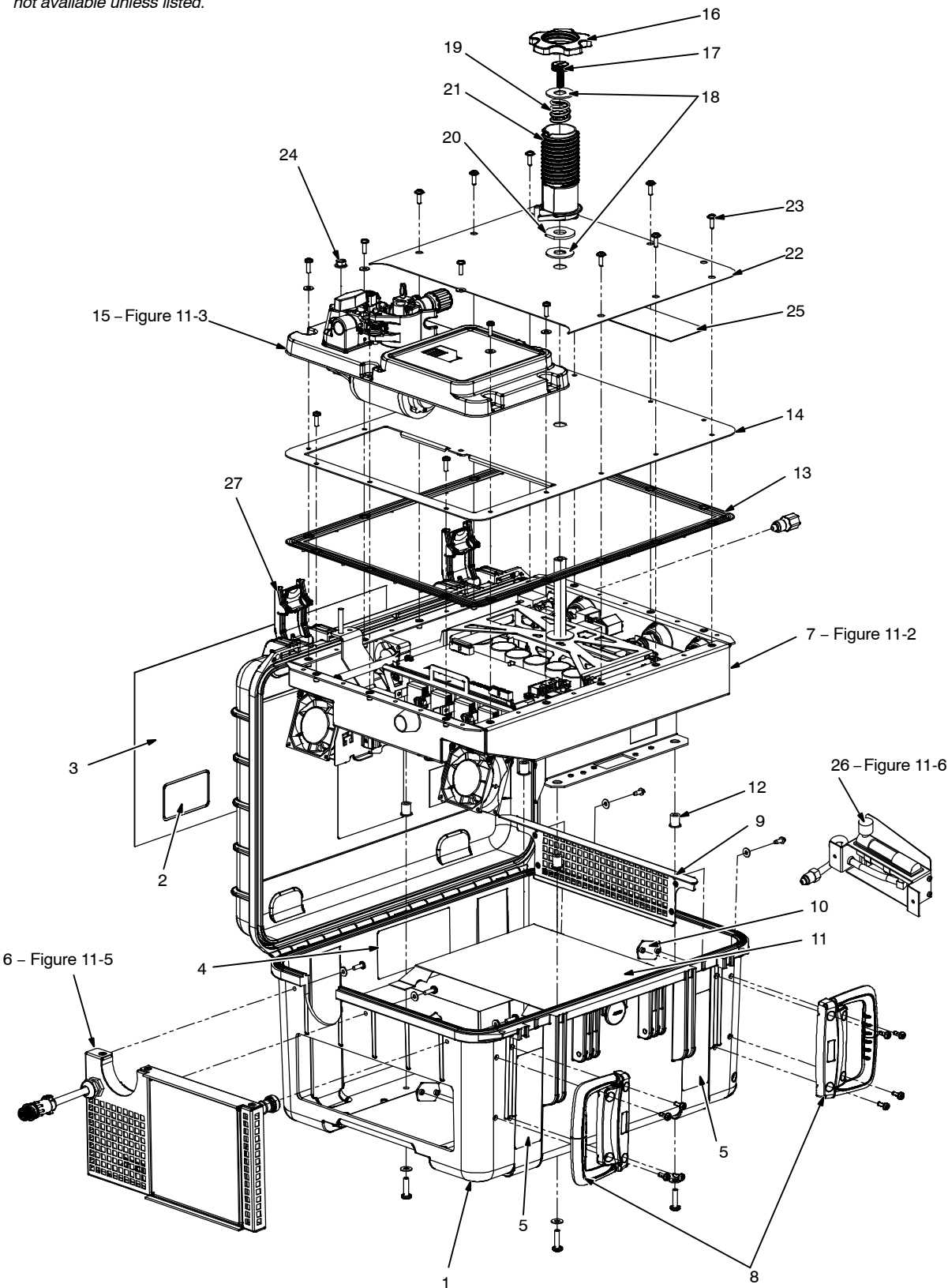


Figure 11-1. Exploded View Of Smart Feeder

264 190-E

Item No.	Diagram marking	Part No.	Description	Quantity
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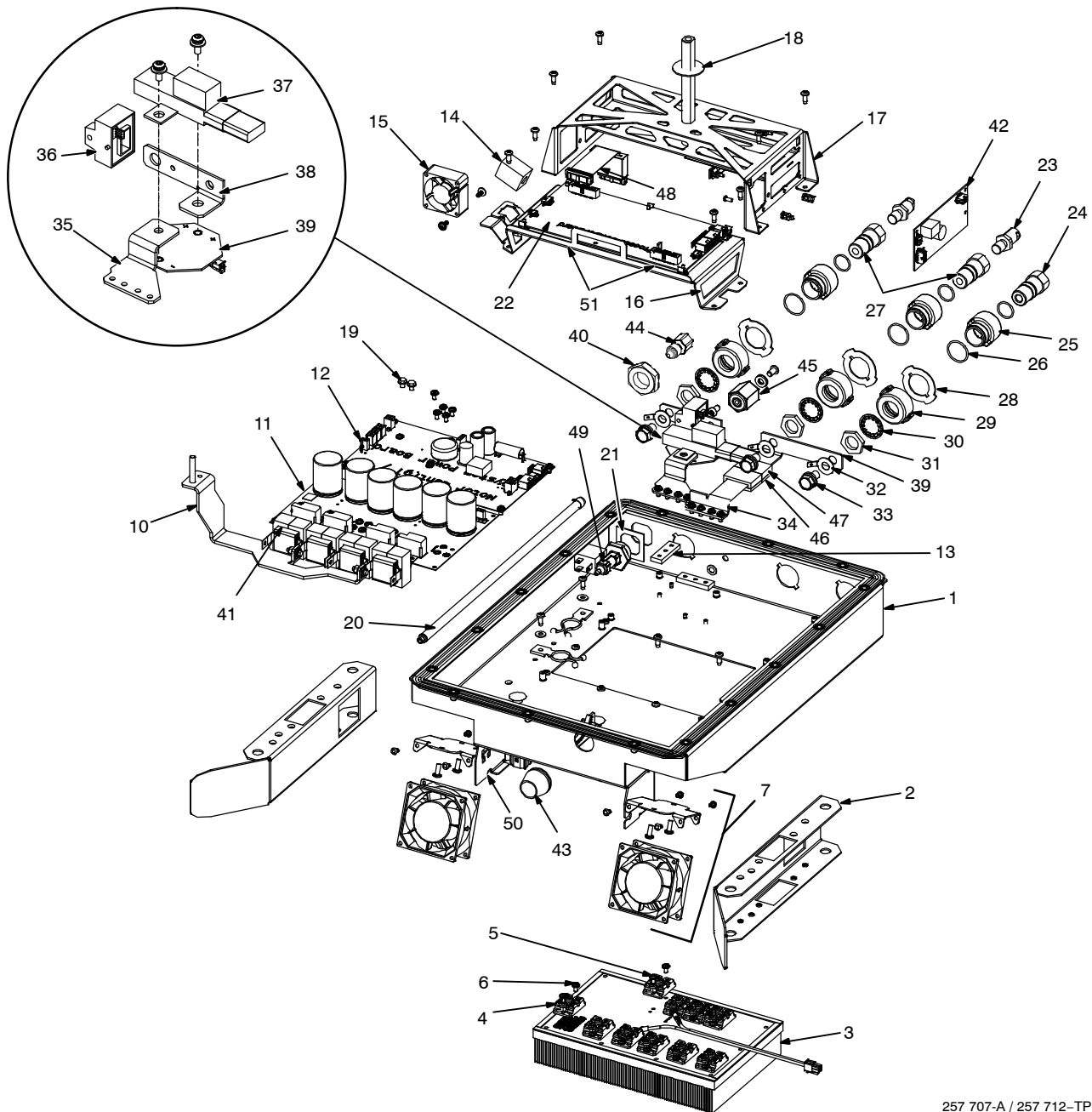
Figure 11-1. Exploded View Of Smart Feeder

.. 1	272424	..	Kit, Field Smart Feeder Case w/Labels (Eff w/MF060165G and Following) Includes	1
.. 2	270420		Label, Notice FieldPro Smart Feeder	1
.. 3	270418		Label, Warning/Miller/FieldPro Smart Feeder	1
.. 4	270642		Label, Warning Electric Shock and Pinch FDR (EN/FR)	1
.. 5	270679		Label, Warning Falling Equipment Can Injure (EN/FR)	2
.. 1	272424	..	Kit, Field Upgrade to New Smart Feeder Case w/Labels (Prior to MF060165G)	1
.. 6	257771	..	Assy, User Interface External (see Figure 11-5)	1
.. 7	257707	..	Lower Chassis Assy (see Figure 11-2)	1
.. 8	276345	..	Handle, Rubberized Carrying	2
.. 9	270179	..	Panel, Rear Smart Feeder (Eff w/MF060165G and Following)	1
.. 9	259380	..	Panel, Rear Apf (Prior to MF060165G)	1
.. 10	260987	..	Bracket, Handle Support w/Pems	4
.. 11	270177	..	Baffle, Case Lower Smart Feeder (Eff w/MF060165G and Following)	1
.. 11	259294	..	Baffle, Case Lower Apf (Prior to MF060165G)	1
.. 12	262630	..	Nut, 250-20 Rubber .50dia .63l Insert In .50 Hole	4
.. 13	259378	..	Gasket, Housing Smart Feeder	1
.. 14	261715	..	Panel, Electronics Cover	1
.. 15	257742	..	Assy, Center Smart Feeder (see Figure 11-3)	1
.. 16	235607	..	Nut, Hub	1
.. 17	237843	..	Knob, Brake Adjust (Diecast)	1
.. 18	201309	..	Washer, Anti-turn	2
.. 19	172918	..	Spring	1
.. 20	058424	..	Washer, Fbr (Brake)	1
.. 21	235608	..	Hub, Spool 12 Inch	1
.. 22	261780	..	Insulator, Cover	1
.. 23	263770	..	Screw, 010-32x .63 Pan Hd-Torx Machine Stl Pld Shld	9
.. 24	152461	..	Nut, 250-20 .44hex .23h Stl Pld Sem Cone Wshr.65d	1
.. 25	270750	..	Insulator, Smart Feeder Input (Eff w/MF060165G and Following)	1
.. 25	263928	..	Insulator, Smart Feeder Input (Prior to MF060165G)	2
.. 26	301306	..	Fieldpro Feeder, Gas Flow Meter, Kit (see Figure 11-6)	1
.. 27	294792	..	Latch, Cover W/Pin	2

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

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 Hardware is common and not available unless listed.



257 707-A / 257 712-TP1

Figure 11-2. Exploded View Of Lower Chassis Assembly

Item No.	Diagram marking	Part No.	Description	Quantity
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Figure 11-2. Exploded View Of Lower Chassis Assembly

.. 1	259291 ..	Panel, Lower Smart Feeder	1
.. 2	270180 ..	Bracket, Case Mounting (Eff w/MF060165G And Following)	2
.. 2	253830 ..	Bracket, Case Mounting (Prior to MF060165G)	2
.. 3	257710 ..	Heat Sink	1
.. 4	289877 ..	Kit, Transistor MOSFET N Chan	6
.. 5	289878 ..	Kit, Diode Ultra-Fast Recovery	4
.. 6	259295 ..	Screw, M 4- .7x 8 Pan Hd-torx Sl/6l T20 Sems Zinc	20

Item No.	Diagram marking	Part No.	Description	Quantity
----------	-----------------	----------	-------------	----------

Figure 11-2. Exploded View Of Lower Chassis Assembly

.. 7	FM	252715	Fan, Muffin 24 VDC 9000 rpm 132 CFM 80mm (Includes)	2
		259296	Bracket, Fan Mounting Smart Feeder	2
		134107	Rivet, Nyl .161 Dia Hole x .177-.217 Grip Push	8
.. 10		261713	Bus Bar, Inductor Smart Feeder	1
.. 11	PC3	246467	Circuit Card Assy, Apm Power Interconnect	1
.. 12	PC2	267508	Kit, Circuit Card Assy System Supply w/Progm	1
.. 13		260607	Block, Heat Sink	2
.. 14		255736	Core, Ferrite Emi Snap-on .393 ID x .877 OD x 1.250 thk	1
.. 15	FM	262612	Fan, Muffin 24 VDC 4000 rpm 20mm	1
.. 16		255272	Bracket, Control	1
.. 17		255275	Bracket, Spool Inner	1
.. 18		261663	Gasket, Spool Shaft	1
.. 19		111630	Screw, 010-32 x .25 Hexwhd-slt Stl Pld	5
.. 20		260794	Hose Assy, SAE .187 ID X .410 OD X 15.000 w/Clamp	1
.. 21		261662	Gasket, Gas Valve	1
.. 22	PC1	257776	Circuit Card Assy, Smart Feeder Process Control w/Prgm	1
.. 23		261697	Conn, Tw Lk Uninsul Male (Tweco/Lenco) (For Stock No. 300935)	2
.. 23		264193	Conn, Tw Lk Male Threaded (Dinse) (For Stock No. 300935001)	2
.. 24		267366	Receptacle, Twist Lock Tweco w/O-Ring (For Stock No. 300935)	1
.. 24		257995	Rcpt, Tw Lk Insul w/O-Rings (For Stock No. 300935001)	1
.. 25		250037	Insulator, Bulkhead Front .890 OD	3
.. 26		185718	O-ring, 0.989 ID x 0.070 H	3
.. 27		260804	Receptacle, Fm Threaded	2
.. 28		255271	Gasket, Receptacle	3
.. 29		250039	Insulator, Bulkhead Rear .890 OD	3
.. 30		185714	Washer, Tooth 22mmid x 31.5mm OD 1.310-1mm T Intern	3
.. 31		185717	Nut, M20-1.5 1.00 hex .19h Brs Locking	3
.. 32		253430	Terminal, Connector Friction 0.406 ID	3
.. 33		229333	Screw, M10-1.5 x 20 Hex Hd-pln 8.8 Pld Sems	3
.. 34		255266	Bus Bar, Smart Feeder Work	1
.. 35		255270	Bus Bar, Smart Feeder Mid	1
.. 36	HD1	191941	Transducer, Current 200A Module	1
.. 37	CR1	257410	Contact, 12vDC 1Pst Latching	1
.. 38		255262	Bus Bar, Smart Feeder Electrode In	1
.. 39	PC6	252707	Circuit Card Assy, Gruner Bypass	1
.. 40		220805	Nut, 750-14 NPS 1.48 hex .41h Nyl	1
.. 41	L1, L2, L3, L4	251827	Inductor, 75 Amp 8 Uh Copper Foil	4
.. 42	PC5	258825	Circuit Card Assy, WCC Interface Smart Feeder w/Prgm	1
.. 43		260803	Grommet, Rbr Wire Pass Thru	1
.. 44		211989	Fitting, w/Screen	2
.. 45		025248	Stand-Off, Insul .250-20 X 1.250 Lg X .437 Thd	1
.. 46		257503	Core, Ferrite I38 x 25 Plate	2
.. 47		257504	Core, Ferrite E38 X 8 X 25 Cntr Leg Removed	2
.. 48		261174	Cable, Ribbon 24 Posn 4.750 In w/Ferrite	1
.. 49	GS1	226819	Valve, 12VDC 1Way .750-14 TH	1
.. 50		270178	Baffle, Fan (Eff w/MF060165G And Following)	1
.. 50		259297	Baffle, Fan (Prior to MF060165G)	1
.. 51		272463	Foam, Rubber 0.312 X 0.625 X 1.625 In W/Adh (Eff w/MF180230G)	2
.. 51		273747	Kit, Field Smart Feeder Foam Pads (Prior to MF180230G)	1

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

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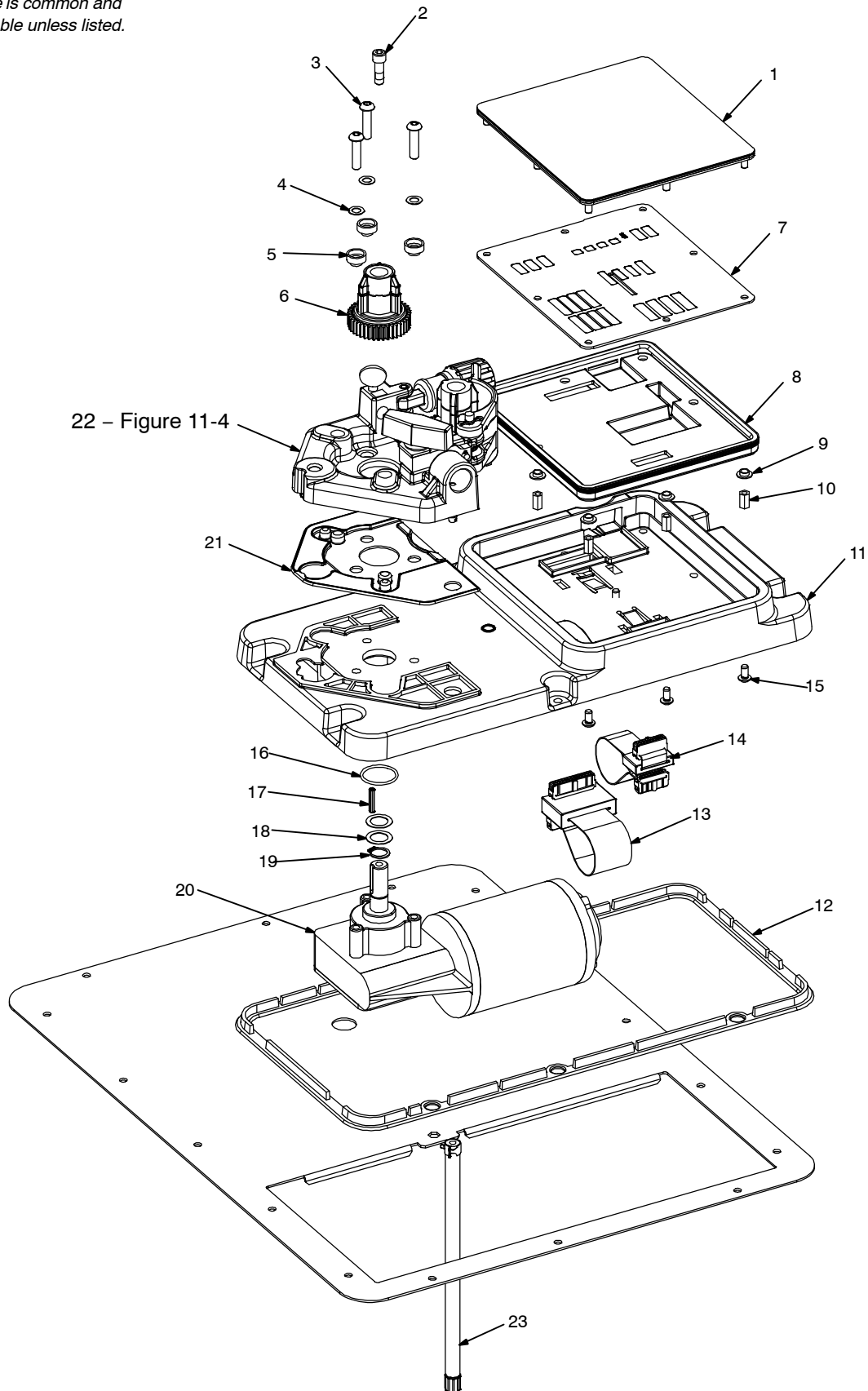


Figure 11-3. Exploded View Of Center Assembly

257 742-A

Item No.	Diagram marking	Part No.	Description	Quantity
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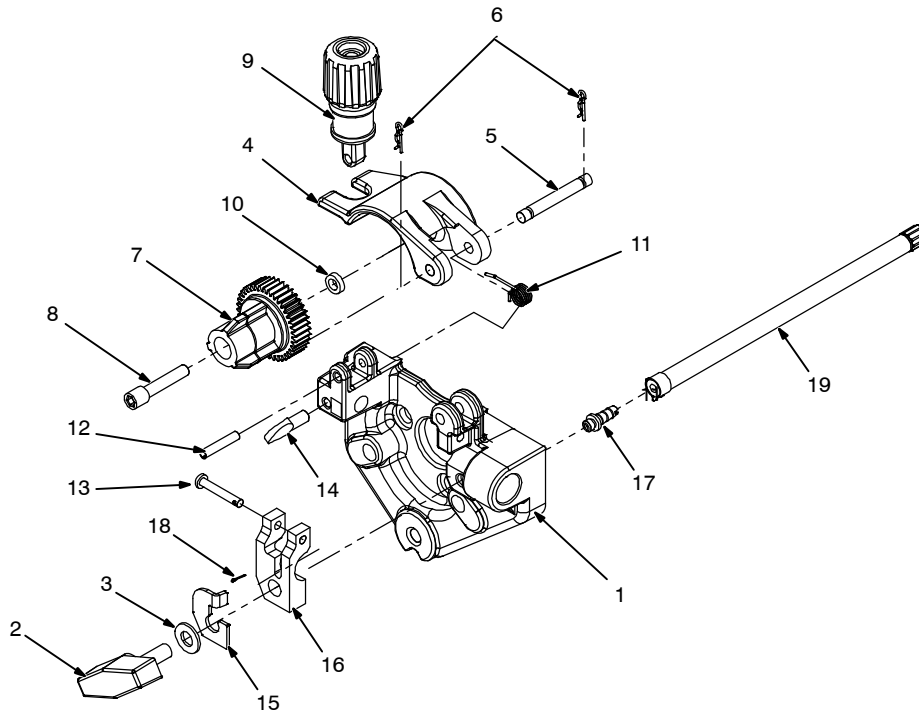
Figure 11-3. Exploded View Of Center Assembly

.. 1		252134 ..	Nameplate, Assy Apf Setup Panel	1
.. 2		254945 ..	Screw, 250-20 x .75 Soc Hd-hex Gr8 Pln Lkg Patch	1
.. 3		259384 ..	Screw, M 6-1.0 x 25 Button Hd-soc Stl Pld Blk	3
.. 4		192029 ..	Washer, Flat .250 ID x 0.437 OD x .020T Stl Pln	3
.. 5		173620 ..	Bushing, Mtg Motor	3
.. 6		172076 ..	Carrier, Drive Roll w/Cmpnts Keyed 24 Pitch	2
.. 7	PC4	252129 ..	Circuit Card Assy, Setup Panel Apf	1
.. 8		259468 ..	Gasket, Setup UI Apf	1
.. 9		261219 ..	Washer, Shldr .203 ID 0.438 OD x .031T .267 OD x.093T Nyl	8
.. 10		261743 ..	Stand-off, No 10-32 x .438 Lg .250 Hex Al Fem	8
.. 11		254881 ..	Bezel, Pwxfld Apf	1
.. 12		259379 ..	Gasket, Mount UI/Wire Drive Apf	1
.. 13		261175 ..	Cable, Ribbon 24 Posn 7.000 In w/Ferrite	1
.....		272463 ..	Foam, Rubber 0.312 X 0.625 X 1.625 In W/Adh (Eff w/MF180230G) ...	2
.....		273747 ..	Kit, Field Smart Feeder Foam Pads (Prior to MF180230G)	1
.. 14		273852 ..	Cable, Ribbon 16 Posn 11.2500 In w/Ferrite Locking (Eff w/MF310000G)	1
.. 14		261437 ..	Cable, Ribbon 16 Posn 11.2500 In w/Ferrite (Prior to MF310000G)	1
.. 15		257167 ..	Screw, 010-32 x .37 Pan Hd-torx Blk Zinc Pld	3
.. 16		180966 ..	O-ring, .926 ID x .070 Cs 70 Duro Quadring	1
.. 17		092865 ..	Key, Stl .1215/.1230 x .750	1
.. 18		079625 ..	Washer, Wave .500 ID x 0.750 OD x .015T Stl	2
.. 19		605308 ..	Ring, Rtnng Ext .500 Shaft x .035 Thk	1
.. 20	M1	257748 ..	Motor, Gear 24 VDC 152 rpm Right Angle	1
.. 21		260805 ..	Gasket, Rubber Wire Drive	1
.. 22	Figure 11-4	..	Housing Assy, Wire Drive (Includes)	1
.. 23		260793	Hose Assy, SAE .187 ID x .410 OD x 7.500 w/Clamps	1

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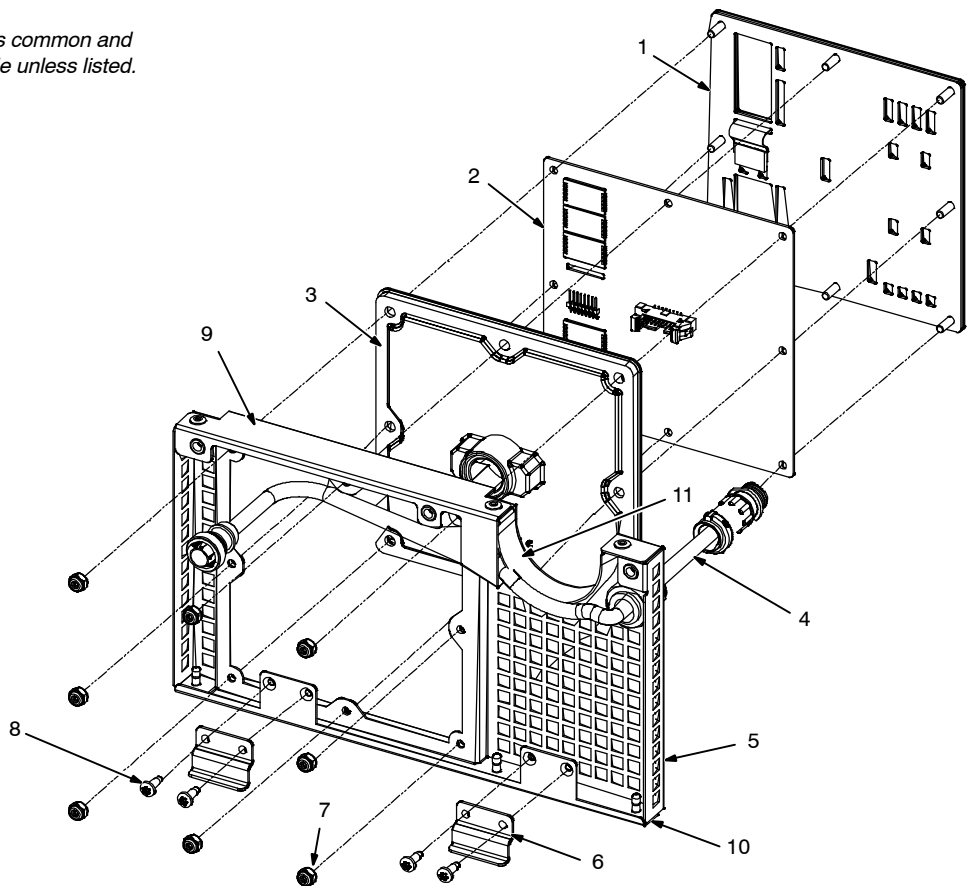
260 792-B

Figure 11-4. Exploded View Of Wire Drive Housing Assembly

Item No.	Dia. Mkgs	Part No.	Description	Quantity
260792 Figure 11-4. Exploded View Of Wire Drive Housing Assembly				
1		233319	Housing, Adapter Gun/Feeder (Machined – Die)	1
2		024778	Knob, T 2.000 Bar W/.312–18 Stud 1.000 Lg	1
3		231232	Washer, Flat .344idx0.688odx.065t Stl Pld Ansi.312	1
4		166071	Lever, Mtg Pressure Gear	1
5		079634	Pin, Hinge	1
6		151828	Pin, Cotter Hair .042 X .750	2
7		172075	Carrier, Drive Roll W/Cmpnts 24 Pitch	1
8		602009	Screw, 250–20x1.25 Soc Hd–Hex Gr8 Pln	1
9		222100	Knob, Tension Adjust Assy W/Cupped Washer	1
10		166072	Spacer, Gear	1
11		222159	Spring, Torsion	1
12		010224	Pin, Spring Cs .187 X 1.000	1
13		234073	Pin, Hinge	1
14		054263	Screw, Thumb Stl .250–20 X .500 Pld Type P	1
15		237188	Lock, Pin Power	1
16		278295	Clamp, Power Pin Cast	1
17		144172	Ftg, Hose Brs Barbed M 3/16 Tbg X .250–20	1
18		254959	Pin, Cotter .062 X .375lg	1
19		260793	Hose Assy, Sae .187 Id X .410 Od X 5.500 W/Clamp	1

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Figure 11-5. Exploded View Of User Interface External Assembly

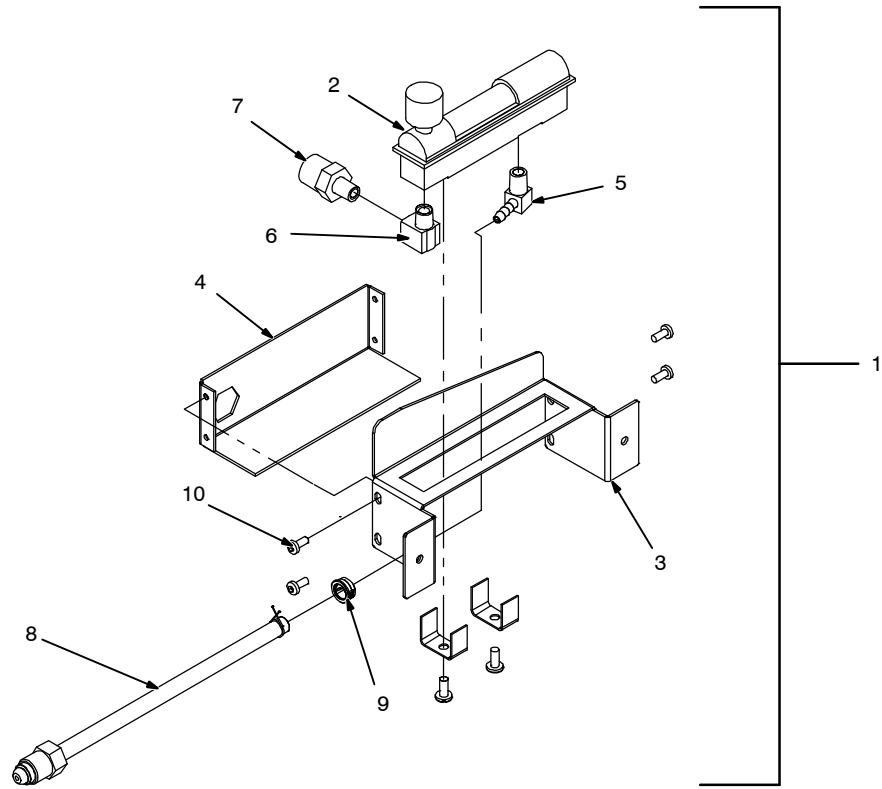
Item No.	Dia. Mkgs	Part No.	Description	Quantity
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Figure 11-5. Exploded View Of User Interface External Assembly

.. 1	252128 ..	Nameplate, Assy Apf Front Panel UI	1
.. 2 PC7	273228 ..	Circuit Card Assy, Front Panel Smart Feeder Locking (Eff. w/MF310000G)1	1
.. 2 PC7	252124 ..	Circuit Card Assy, Front Panel Apf (Prior to MF310000G)	1
.. 3	259467 ..	Gasket, Front UI Apf	1
.. 4	259492 ..	Cable, Trigger 24 In. Apf Feeder Dual Schedule	1
.. 5	257772 ..	Bracket, Front Panel	1
.. 6	259383 ..	Bracket, Mtg Front Panel Apf	2
.. 7	601847 ..	Nut, 010-32 .38hex .24h Stl Pld Elastic Stop Nut Blk	8
.. 8	195666 ..	Screw, 010-32 x .50 Pan Hd-torx w/Gndrng Stl Pld Tap-r	4
.. 9	259381 ..	Bracket, Front Panel Upper Apf	1
.. 10	259382 ..	Bracket, Front Panel Lower	1
.. 11	259469 ..	Bracket, Front Panel Support	1

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.

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271 599-B

Figure 11-6. Optional Gas Flow Meter Kit

Item No.	Dia. Mkgs	Part No.	Description	Quantity
301 306 Figure 11-6. Optional Gas Flow Meter Kit				
.. 1		271 599 ..	Meter, Flow w/Fittings And Guard (Includes)	1
.. 2		244 371	Meter, Flow 6–60 SCFH Of Co2/Argon Scale	1
.. 3		271 600	Guard, Flow Meter	1
.. 4		271 601	Guard, Support Flow Meter	1
.. 5		112 090	Ftg, Pipe Brs Elbow 1/8 Npt x 3/16 Host	1
.. 6		272 683	Ftg, Pipe Brs Elbow St 1/8 Npt	1
.. 7		271 604	Ftg, Adapter Iner Arc 1/8 Npt Male	1
.. 8		271 603	Hose Assy, Gas 10 in.	1
.. 9		010 546	Bushing, Snap-In Nyl .375 Id x .5 Mtg Hole	1
.. 10		267 441	Screw, 008-32 x .37 Pan HdTorx	4
.....		235 065 ..	Screw, 010–32x.75 Pan Hd–Torx	2
.....		601 847 ..	Nut, 010–32 .38Hex .24H Elastic Stop Nut	2
.....		249 127 ..	Washer, Insulating Nylon Cup .194 x .410 x .470	2

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.

Table 9-1. Drive Roll & Inlet Guide

 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 (usually hard surfacing types).
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Drive Roll (2 Required)		Inlet Wire
Fraction	Decimal	Metric	Part No.	Type	Guide
.023 / .025 in.	.023 / .025 in.	0.6 mm	087130	V-Grooved	221030
.030 in.	.030 in.	0.8 mm	053695	V-Grooved	221030
.035 in.	.035 in.	0.9 mm	053700	V-Grooved	221030
.040 in.	.040 in.	1.0 mm	053696	V-Grooved	221030
.045 in.	.045 in.	1.2 mm	053697	V-Grooved	221030
0.52 in.	.052 in.	1.3 mm	053698	V-Grooved	221030
1/16 in.	.062 in.	1.6 mm	053699	V-Grooved	221030
.035 in.	.035 in.	0.9 mm	072000	U-Grooved	221030
.045 in.	.045 in.	1.2 mm	053701	U-Grooved	221030
.052 in.	.052 in.	1.3 mm	053702	U-Grooved	221030
1/16 in.	.062 in.	1.6 mm	053706	U-Grooved	221030
5/64 in.	.079 in.	2.0 mm	053704	U-Grooved	221030
.035 in.	.035 in.	0.9 mm	132958	V-Knurled	221030
.045 in.	.045 in.	1.2 mm	132957	V-Knurled	221030
0.52 in.	.052 in.	1.3 mm	132956	V-Knurled	221030
1/16 in.	.062 in.	1.6 mm	132955	V-Knurled	221030
.068-.072 in.	.068-.072 in.	1.8 mm	132959	V-Knurled	221030
5/64 in.	.079 in.	2.0 mm	132960	V-Knurled	221030
.045 in.	.045 in.	1.2 mm	083489	U-Cogged	221030
.052 in.	.052 in.	1.3 mm	083490	U-Cogged	221030
1/16 in.	.062 in.	1.6 mm	053708	U-Cogged	221030
5/64 in.	.079 in.	2.0 mm	053710	U-Cogged	221030

S-0859

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2023-05

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Flux Cored (FCAW) Welding

Description



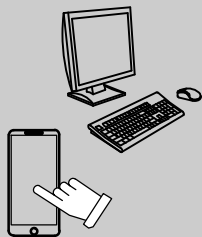
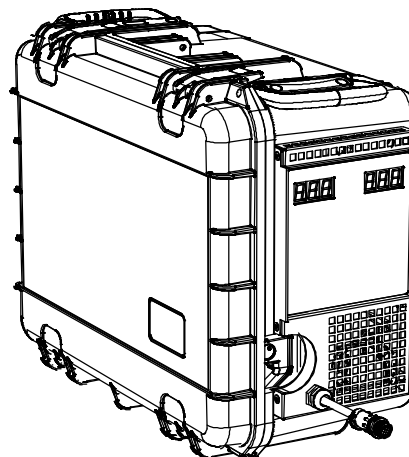
Wire Feeder

FieldProTM Smart Feeder CE

PARTS LIST

Eff w/ME320190G And Following

For OM264234 Revision A And Following

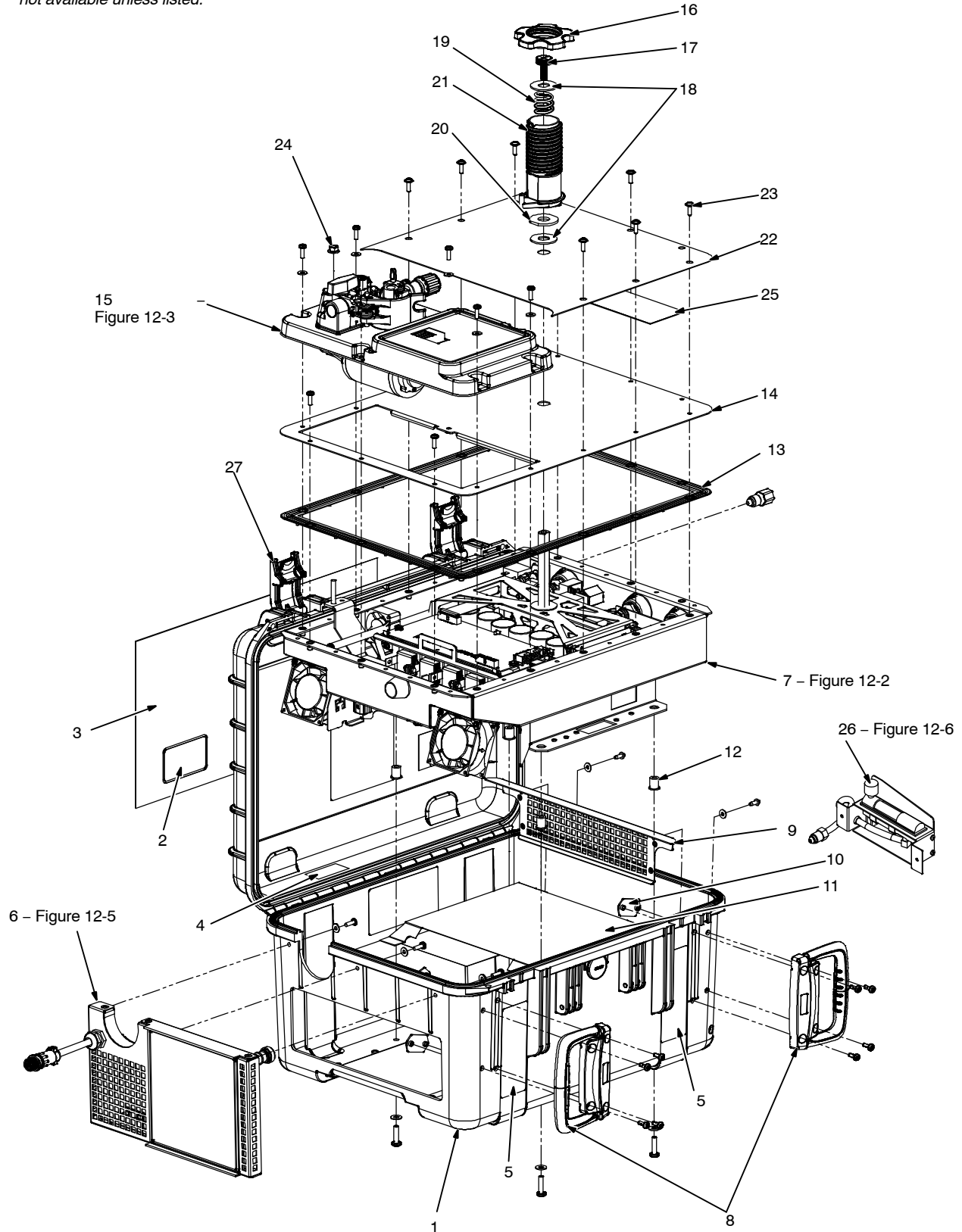


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SECTION 2 – PARTS LIST – CE MODELS

 Hardware is common and not available unless listed.



264 190-E

Figure 12-1. Exploded View Of Smart Feeder

Item No.	Diagram marking	Part No.	Description	Quantity
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Figure 12-1. Exploded View Of Smart Feeder

.. 1	272424	..	Kit, Field Smart Feeder Case w/Labels (Eff w/MF060165G and Following) Includes	1
.. 2	270420		Label, Notice FieldPro Smart Feeder	1
.. 3	270418		Label, Warning/Miller/FieldPro Smart Feeder Side	1
.. 4	270642		Label, Warning Electric Shock and Pinch FDR (EN/FR)	1
.. 5	270679		Label, Warning Falling Equipment Can Injure	2
.. 1	272424	..	Kit, Field Upgrade to New Smart Feeder Case w/Labels (Prior to MF060165G)	1
.. 6	257771	..	Assy, User Interface External (see Figure 12-5)	1
.. 7	257707	..	Lower Chassis Assy (see Figure 12-2)	1
.. 8	276345	..	Handle, Rubberized Carrying	2
.. 9	270179	..	Panel, Rear Smart Feeder (Eff w/MF060165G and Following)	1
.. 9	259380	..	Panel, Rear Apf (Prior to MF060165G)	1
.. 10	260987	..	Bracket, Handle Support w/Pems	4
.. 11	270177	..	Baffle, Case Lower Smart Feeder (Eff w/MF060165G and Following)	1
.. 11	259294	..	Baffle, Case Lower Apf (Prior to MF060165G)	1
.. 12	262630	..	Nut, 250-20 Rubber .50dia .63l Insert In .50 Hole	4
.. 13	259378	..	Gasket, Housing Smart Feeder	1
.. 14	261715	..	Panel, Electronics Cover	1
.. 15	257742	..	Assy, Center Smart Feeder (see Figure 12-3)	1
.. 16	235607	..	Nut, Hub	1
.. 17	237843	..	Knob, Brake Adjust (Diecast)	1
.. 18	201309	..	Washer, Anti-turn	2
.. 19	172918	..	Spring	1
.. 20	058424	..	Washer, Fbr (Brake)	1
.. 21	235608	..	Hub, Spool 12 Inch	1
.. 22	261780	..	Insulator, Cover	1
.. 23	263770	..	Screw, 010-32x .63 Pan Hd-Torx Machine Stl Pld Shld	9
.. 24	152461	..	Nut, 250-20 .44hex .23h Stl Pld Sem Cone Wshr.65d	1
.. 25	270750	..	Insulator, Smart Feeder Input (Eff w/MF060165G and Following)	1
.. 25	263928	..	Insulator, Smart Feeder Input (Prior to MF060165G)	2
.. 26	301306	..	Fieldpro Feeder, Gas Flow Meter, Kit (see Figure 12-6)	1
.. 27	294792	..	Latch, Cover w/Pin	2

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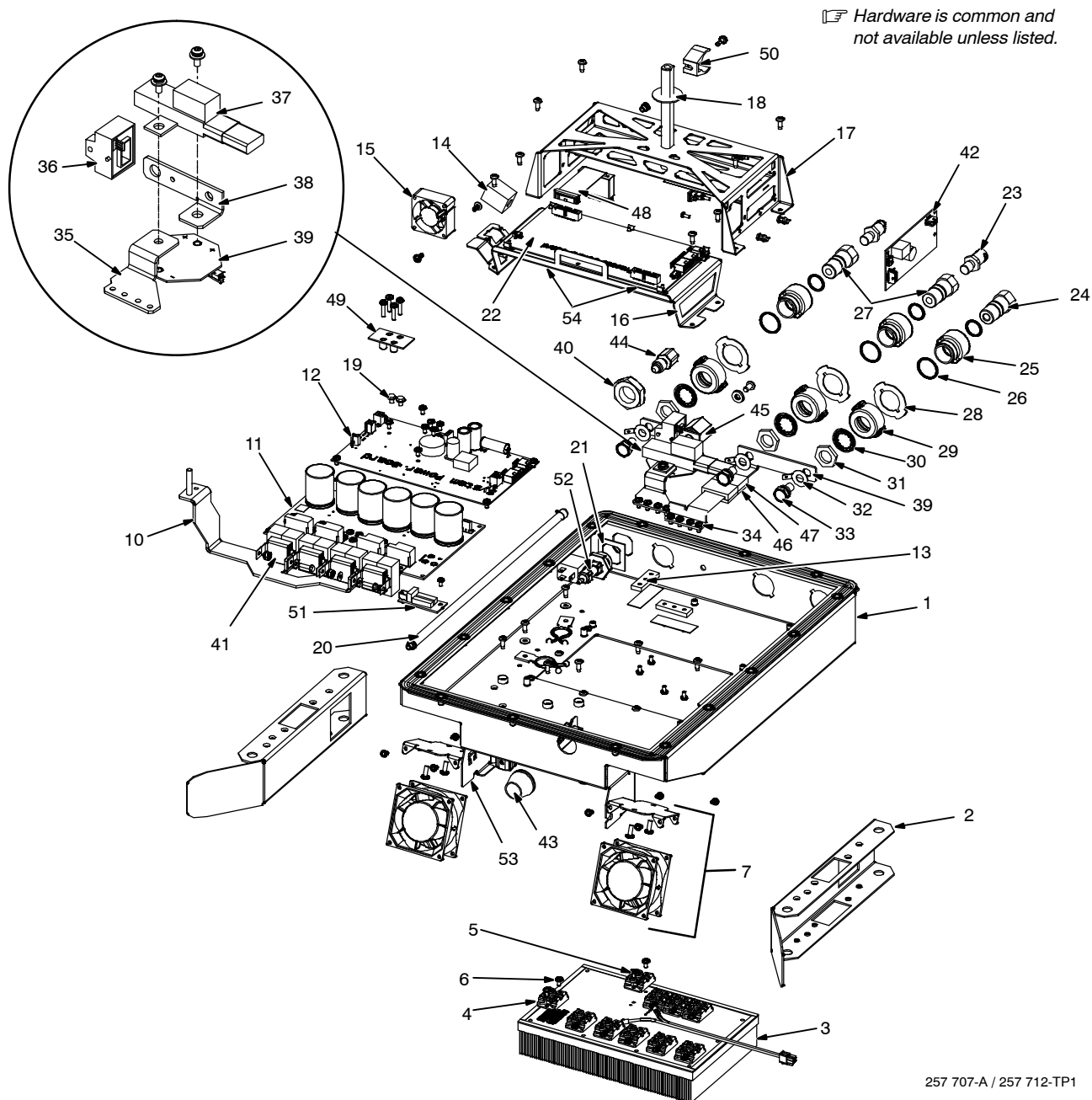


Figure 12-2. Exploded View Of Lower Chassis Assembly

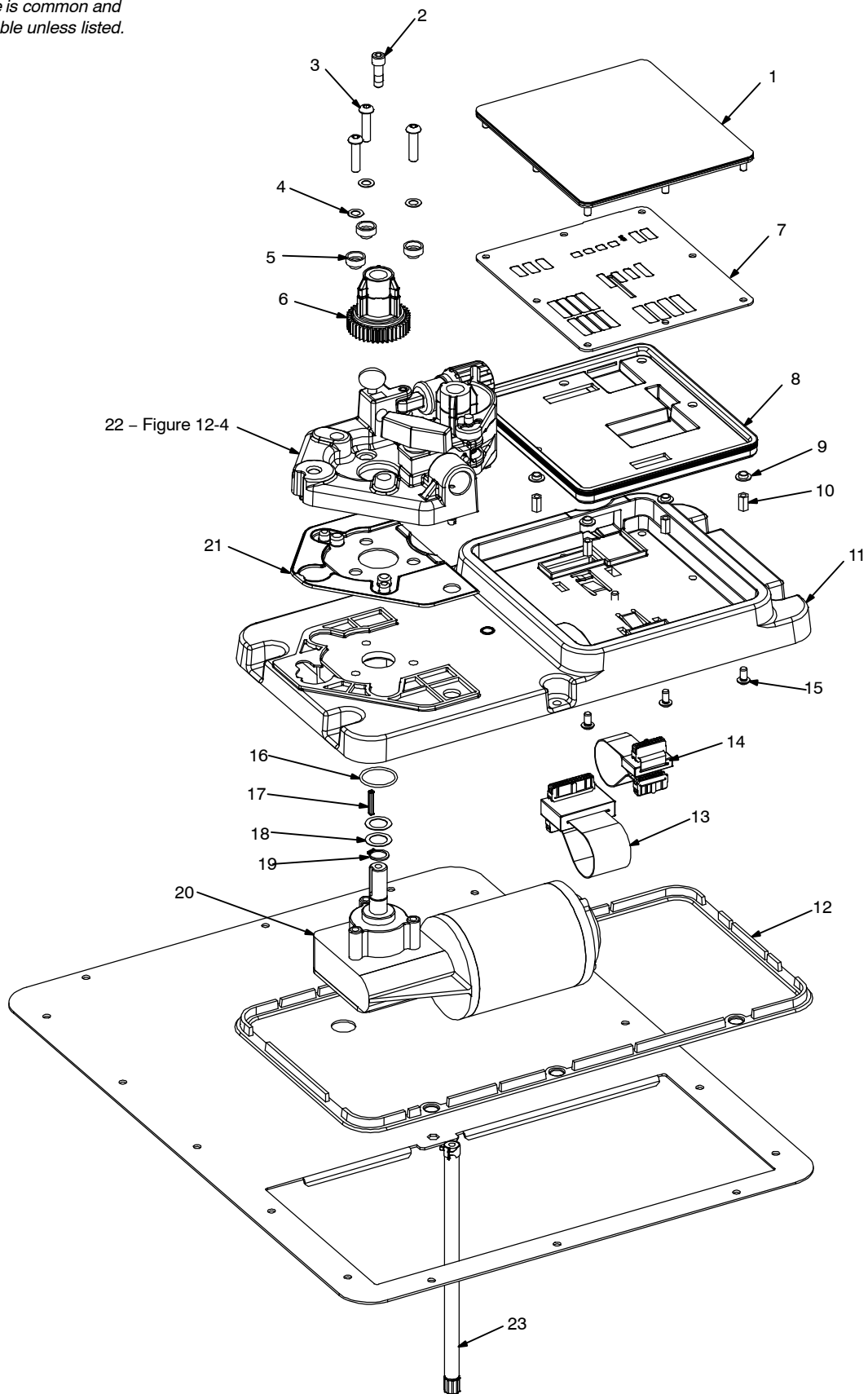
Item No.	Diagram marking	Part No.	Description	Quantity
Figure 12-2. Exploded View Of Lower Chassis Assembly				
1		259291	Panel, Lower Smart Feeder	1
2		270180	Bracket, Case Mounting (Eff w/MF060165G And Following)	2
2		253830	Bracket, Case Mounting (Prior to MF060165G)	2
3		257710	Heat Sink	1
4		289877	Kit, Transistor MOSFET N Chan	6
5		289878	Kit, Diode Ultra-Fast Recovery	4
6		259295	Screw, M 4- .7x 8 Pan Hd-torx SI/6I T20 Sems Zinc	20

Item No.	Diagram marking	Part No.	Description	Quantity
Figure 12-2. Exploded View Of Lower Chassis Assembly				
7	FM	252715	Fan, Muffin 24 VDC 9000 rpm 132 CFM 80mm (Includes)	2
		259296	Bracket, Fan Mounting Smart Feeder	2
		134107	Rivet, Nyl .161 Dia Hole x .177-.217 Grip Push	8
10		261713	Bus Bar, Inductor Smart Feeder	1
11	PC3	246467	Circuit Card Assy, Apm Power Interconnect	1
12	PC2	265778	Circuit Card Assy, Smart Feeder System Supply w/Prgm (CE)	1
13		260607	Block, Heat Sink	2
14		255736	Core, Ferrite Emi Snap-on .393 ID x .877 OD x 1.250 thk	1
15	FM	262612	Fan, Muffin 24VDC 7000 RPM 18 CFM 50mm	1
16		255272	Bracket, Control	1
17		255275	Bracket, Spool Inner	1
18		261663	Gasket, Spool Shaft	1
19		111630	Screw, 010-32 x .25 Hexwhd-slt Stl Pld	5
20		260794	Hose Assy, SAE .187 ID X .410 OD X 15.000 w/Clamp	1
21		261662	Gasket, Gas Valve	1
22	PC1	257776	Circuit Card Assy, Smart Feeder Process Control w/Prgm	1
23		264193	Conn, Tw Lk Male Threaded (Dinse Type)	2
24		257995	Rcpt, Tw Lk Insul W/O-Rings	1
25		250037	Insulator, Bulkhead Front .890 OD	3
26		185718	O-ring, 0.989 ID x 0.070 H	3
27		260804	Receptacle, Fm Threaded	2
28		255271	Gasket, Receptacle	3
29		250039	Insulator, Bulkhead Rear .890 OD	3
30		185714	Washer, Tooth 22mmid x 31.5mm OD 1.310-1mm T Intern	3
31		185717	Nut, M20-1.5 1.00 hex .19h Brs Locking	3
32		253430	Terminal, Connector Friction 0.406 ID	3
33		229333	Screw, M10-1.5 x 20 Hex Hd-pln 8.8 Pld Sems	3
34		255266	Bus Bar, Smart Feeder Work	1
35		255270	Bus Bar, Smart Feeder Mid	1
36	HD1	191941	Transducer, Current 200A Module	1
37	CR1	257410	Contactor, 12vDC 1Pst Latching	1
38		255262	Bus Bar, Smart Feeder Electrode In	1
39	PC6	252707	Circuit Card Assy, Gruner Bypass	1
40		220805	Nut, 750-14 NPS 1.48 hex .41h Nyl	1
41	L1, L2, L3, L4	251827	Inductor, 75 Amp 8 Uh Copper Foil	4
42	PC5	258825	Circuit Card Assy, WCC Interface Smart Feeder w/Prgm	1
43		260803	Grommet, Rbr Wire Pass Thru	1
44		211989	Fitting, w/Screen	1
45		025248	Stand-off, Insul .250-20 x 1.250 Lg x .437 Thd	1
46		257503	Core, Ferrite I38 x 25 Plate	2
47		257504	Core, Ferrite E38 X 8 X 25 Cntr Leg Removed	2
48		261174	Cable, Ribbon 24 Posn 4.750 In w/Ferrite	1
		272463	Foam, Rubber 0.312 X 0.625 X 1.625 In W/Adh	4
49	PC8	265193	Circuit Card Assy, Diode Input Snubber	1
50		269404	Bracket, Mtg Nyl 3/4 Conduit	1
51	PC9	265544	Circuit Card Assy, Output Snubber	1
52	GS1	226819	Valve, 12VDC 1Way .750-14 TH	1
53		270178	Baffle, Fan (Eff w/MF060165G And Following)	1
53		259297	Baffle, Fan (Prior to MF060165G)	1
54		272463	Foam, Rubber 0.312 X 0.625 X 1.625 In W/Adh (Eff w/MF180230G)	2
54		273747	Kit, Field Smart Feeder Foam Pads (Prior to MF180230G)	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.



257 742-A

Figure 12-3. Exploded View Of Center Assembly

Item No.	Diagram marking	Part No.	Description	Quantity
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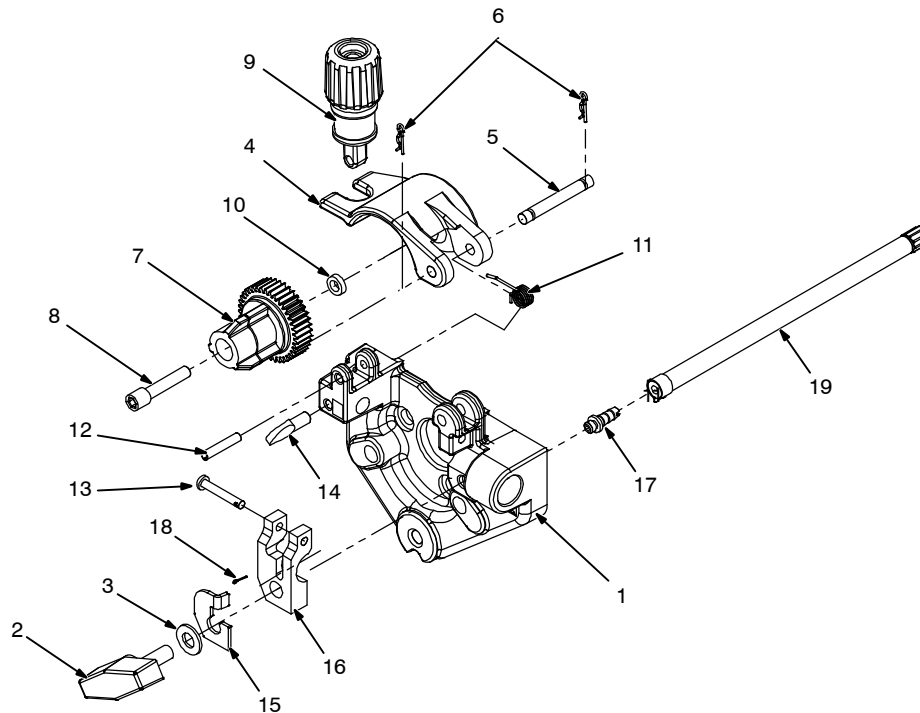
Figure 12-3. Exploded View Of Center Assembly

.. 1		265464	.. Nameplate, Assy Smart Feeder Setup Panel (CE)	1
.. 2		254945	.. Screw, 250-20 x .75 Soc Hd-hex Gr8 Pln Lkg Patch	1
.. 3		259384	.. Screw, M 6-1.0 x 25 Button Hd-soc Stl Pld Blk	3
.. 4		192029	.. Washer, Flat .250 ID x 0.437 OD x .020T Stl Pln	3
.. 5		173620	.. Bushing, Mtg Motor	3
.. 6		172076	.. Carrier, Drive Roll w/Cmpnts Keyed 24 Pitch	2
.. 7	PC4	252129	.. Circuit Card Assy, Setup Panel Smart Feeder w/Program	1
.. 8		259468	.. Gasket, Setup UI Smart Feeder	1
.. 9		261219	.. Washer, Shldr .203 ID 0.438 OD x .031T .267 OD x.093T Nyl	8
.. 10		261743	.. Stand-off, No 10-32 x .438 Lg .250 Hex Al Fem	8
.. 11		254881	.. Bezel, Pwxfld Smart Feeder	1
.. 12		259379	.. Gasket, Mount UI/Wire Drive Smart Feeder	1
.. 13		261175	.. Cable, Ribbon 24 Posn 7.000 In w/Ferrite	1
		272463	.. Foam, Rubber 0.312 X 0.625 X 1.625 In W/Adh (Eff w/MF180230G)	2
		273747	.. Kit, Field Smart Feeder Foam Pads (Prior to MF180230G)	1
.. 14		273852	.. Cable, Ribbon 16 Posn 11.2500 In w/Ferrite Locking (Eff w/MF310000G)	1
.. 14		261437	.. Cable, Ribbon 16 Posn 11.2500 In w/Ferrite (Prior to MF310000G)	1
.. 15		257167	.. Screw, 010-32 x .37 Pan Hd-torx Blk Zinc Pld	3
.. 16		180966	.. O-ring, .926 ID x .070 Cs 70 Duro Quadring	1
.. 17		092865	.. Key, Stl .1215/.1230 x .750	1
.. 18		079625	.. Washer, Wave .500 ID x 0.750 OD x .015T Stl	2
.. 19		605308	.. Ring, Rtng Ext .500 Shaft x .035 Thk	1
.. 20	M1	257748	.. Motor, Gear 24 VDC 152 rpm Right Angle	1
.. 21		260805	.. Gasket, Rubber Wire Drive	1
.. 22		Figure 12-4	.. Housing Assy, Wire Drive (includes)	1
.. 23		260793	.. Hose Assy, SAE .187 ID x .410 OD x 7.500 w/Clamps	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.



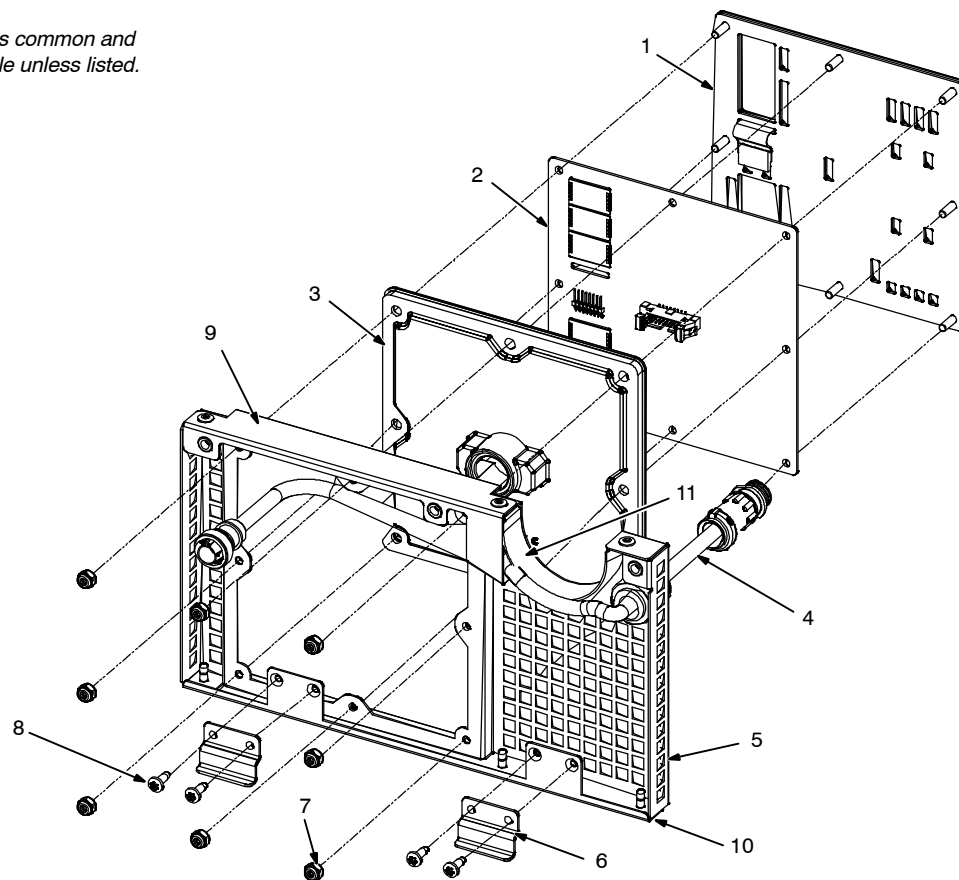
260 792-B

Figure 12-4. Exploded View Of Wire Drive Housing Assembly

Item No.	Dia. Mkgs	Part No.	Description	Quantity
260792 Figure 12-4. Exploded View Of Wire Drive Housing Assembly				
1		233319	Housing, Adapter Gun/Feeder (Machined – Die)	1
2		024778	Knob, T 2.000 Bar W/.312–18 Stud 1.000 Lg	1
3		231232	Washer, Flat .344idx0.688odx.065t Stl Pld Ansi.312	1
4		166071	Lever, Mtg Pressure Gear	1
5		079634	Pin, Hinge	1
6		151828	Pin, Cotter Hair .042 X .750	2
7		172075	Carrier, Drive Roll W/Cmpnts 24 Pitch	1
8		602009	Screw, 250–20x1.25 Soc Hd–Hex Gr8 Pln	1
9		222100	Knob, Tension Adjust Assy W/Cupped Washer	1
10		166072	Spacer, Gear	1
11		222159	Spring, Torsion	1
12		010224	Pin, Spring Cs .187 X 1.000	1
13		234073	Pin, Hinge	1
14		054263	Screw, Thumb Stl .250–20 X .500 Pld Type P	1
15		237188	Lock, Pin Power	1
16		278295	Clamp, Power Pin Cast	1
17		144172	Ftg, Hose Brs Barbed M 3/16 Tbg X .250–20	1
18		254959	Pin, Cotter .062 X .375lg	1
19		260793	Hose Assy, Sae .187 Id X .410 Od X 5.500 W/Clamp	1

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.



257 771-B

Figure 12-5. Exploded View Of User Interface External Assembly

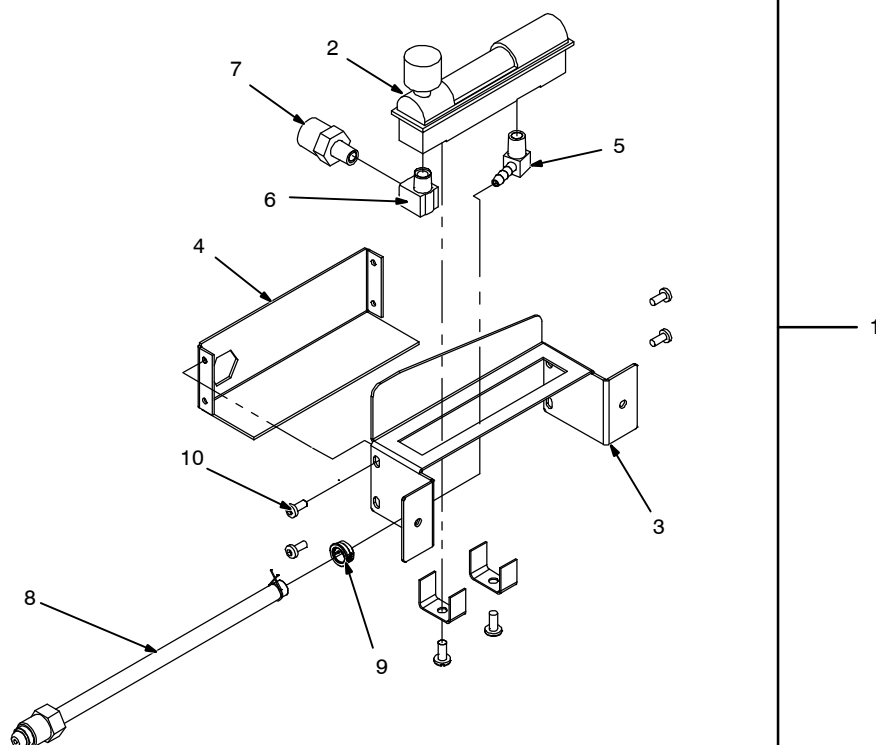
Item No.	Dia. Mkgs	Part No.	Description	Quantity
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Figure 12-5. Exploded View Of User Interface External Assembly

.. 1	265466 ..	Nameplate, Assy FieldPro Smart Feeder Frnt Pnl (CE)	1
.. 2	PC7	273228 .. Circuit Card Assy, Front Panel Smart Feeder Locking (Eff. w/MF310000G)1	1
.. 2	PC7	252124 .. Circuit Card Assy, Front Panel Apf (Prior to MF310000G)	1
.. 3	259467 ..	Gasket, Front UI Smart Feeder	1
.. 4	259492 ..	Cable, Trigger 24 In. Smart Feeder Feeder Dual Schedule	1
.. 5	257772 ..	Bracket, Front Panel	1
.. 6	259383 ..	Bracket, Mtg Front Panel Smart Feeder	2
.. 7	601847 ..	Nut, 010-32 .38hex .24h Stl Pld Elastic Stop Nut Blk	8
.. 8	195666 ..	Screw, 010-32 x .50 Pan Hd-torx w/Gndrng Stl Pld Tap-r	4
.. 9	259381 ..	Bracket, Front Panel Upper Smart Feeder	1
.. 10	259382 ..	Bracket, Front Panel Lower	1
.. 11	259469 ..	Bracket, Front Panel Support	1

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.



271 599-B

Figure 12-6. Optional Gas Flow Meter Kit

Item No.	Dia. Mkgs	Part No.	Description	Quantity
301 306 Figure 12-6. Optional Gas Flow Meter Kit				
.. 1		271 599 ..	Meter, Flow w/Fittings And Guard (Includes)	1
.. 2		244 371	Meter, Flow 6–60 SCFH Of Co2/Argon Scale	1
.. 3		271 600	Guard, Flow Meter	1
.. 4		271 601	Guard, Support Flow Meter	1
.. 5		112 090	Ftg, Pipe Brs Elbow 1/8 Npt x 3/16 Host	1
.. 6		272 683	Ftg, Pipe Brs Elbow St 1/8 Npt	1
.. 7		271 604	Ftg, Adapter Iner Arc 1/8 Npt Male	1
.. 8		271 603	Hose Assy, Gas 10 in.	1
.. 9		010 546	Bushing, Snap-In Nyl .375 Id x .5 Mtg Hole	1
.. 10		267 441	Screw, 008-32 x .37 Pan HdTorx	4
.....		235 065 ..	Screw, 010–32x.75 Pan Hd–Torx	2
.....		601 847 ..	Nut, 010–32 .38Hex .24H Elastic Stop Nut	2
.....		249 127 ..	Washer, Insulating Nylon Cup .194 x .410 x .470	2

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.

Table 9-1. Drive Roll & Inlet Guide

☞ 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 (usually hard surfacing types).
4. V-Knurled rolls for hard shelled cored wires.
5. Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Drive Roll (2 Required)		Inlet Wire
Fraction	Decimal	Metric	Part No.	Type	Guide
.023 / .025 in.	.023 / .025 in.	0.6 mm	087130	V-Grooved	221030
.030 in.	.030 in.	0.8 mm	053695	V-Grooved	221030
.035 in.	.035 in.	0.9 mm	053700	V-Grooved	221030
.040 in.	.040 in.	1.0 mm	053696	V-Grooved	221030
.045 in.	.045 in.	1.2 mm	053697	V-Grooved	221030
0.52 in.	.052 in.	1.3 mm	053698	V-Grooved	221030
1/16 in.	.062 in.	1.6 mm	053699	V-Grooved	221030
.035 in.	.035 in.	0.9 mm	072000	U-Grooved	221030
.045 in.	.045 in.	1.2 mm	053701	U-Grooved	221030
.052 in.	.052 in.	1.3 mm	053702	U-Grooved	221030
1/16 in.	.062 in.	1.6 mm	053706	U-Grooved	221030
5/64 in.	.079 in.	2.0 mm	053704	U-Grooved	221030
.035 in.	.035 in.	0.9 mm	132958	V-Knurled	221030
.045 in.	.045 in.	1.2 mm	132957	V-Knurled	221030
0.52 in.	.052 in.	1.3 mm	132956	V-Knurled	221030
1/16 in.	.062 in.	1.6 mm	132955	V-Knurled	221030
.068-.072 in.	.068-.072 in.	1.8 mm	132959	V-Knurled	221030
5/64 in.	.079 in.	2.0 mm	132960	V-Knurled	221030
.045 in.	.045 in.	1.2 mm	083489	U-Cogged	221030
.052 in.	.052 in.	1.3 mm	083490	U-Cogged	221030
1/16 in.	.062 in.	1.6 mm	053708	U-Cogged	221030
5/64 in.	.079 in.	2.0 mm	053710	U-Cogged	221030

S-0859

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