70 Series Swingarc™

Quick Specs

<table>
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<tr>
<th>Heavy Industrial Applications</th>
<th>Processes</th>
<th>Input Power</th>
<th>Wire Diameter Capacity</th>
<th>Wire Feed Speed</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heavy manufacturing</td>
<td>MIG (GMAW)</td>
<td>24 VAC, 10 A, 50/60 Hz</td>
<td>.023–5/64 in. (0.6–2.0 mm)</td>
<td>50–780 ipm (1.3–19.8 m/min.)</td>
<td>110–280 lb. (50–127 kg)</td>
</tr>
<tr>
<td>Metal fabrication</td>
<td>Flux-cored (FCAW)</td>
<td>(gas- and self-shielded)</td>
<td>Submerged arc (SAW)</td>
<td>Pulsed MIG (GMAW) with MPa Plus feeder and optional MPa power source</td>
<td>depending upon feeder and boom</td>
</tr>
<tr>
<td>Construction</td>
<td></td>
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<tr>
<td>Light manufacturing</td>
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</tr>
</tbody>
</table>

Also Available! MPa Plus Swingars. Provides synergic pulsed MIG with any MPa power source.

Available in single- and dual-wire models with 8-, 12- or 16-foot booms to accommodate a wide variety of semiautomatic wire feed applications, including large weldments and hard to reach areas.

360-degree rotation and 60-degree lift angle maximizes your work area (16-, 24- or 32-foot diameter work area).

Unique counterbalanced boom makes it easy to raise and lower boom and automatically holds its position.

Includes 10-foot 14-pin interconnecting cord, 10-foot gas hose and 10-foot weld cable for the operator to hook up.

Control features on page 2.

In-boom cable routing organizes hoses and cables, preventing damage and maintaining an orderly work cell.

Models include Bernard™ BTB gun 400 A (two with D-74 models), .035/.045-inch drive rolls and Centerfire™ contact tips! For more options, visit MillerWelds.com/equiptoweld.

One of the following is required for mounting the boom:
- Swingpak base and pipe post with base plate (for 8-, 12- or 16-foot Swingarcs).
- 4- or 6-foot (1.2 or 1.8 m) pipe post with base plate (for 8-, 12- or 16-foot Swingarcs). Pipe post base plates allow post to be bolted to Swingpak base or floor. See page 4 for details.

Single-wire Swingarc shown with pipe post, power source, welding gun, and optional Swingpak™ base.

Wire feeder and boom are warranted for three years, parts and labor.
## Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Wire Feed Speed</th>
<th>Electrode Wire Diameter Capacity</th>
<th>8 ft. Boom Net Weight</th>
<th>12 ft. Boom Net Weight</th>
<th>16 ft. Boom Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>SS-74</td>
<td>24 VAC, 10 A, 50/60 Hz</td>
<td>50–780 ipm (1.3–19.8 m/min.)</td>
<td>.023–5/64 in. (0.6–2.0 mm)</td>
<td>110 lb. (50 kg)</td>
<td>160 lb. (73 kg)</td>
<td>210 lb. (95 kg)</td>
</tr>
<tr>
<td>DS-74</td>
<td>24 VAC, 10 A, 50/60 Hz</td>
<td>50–780 ipm (1.3–19.8 m/min.)</td>
<td>.023–5/64 in. (0.6–2.0 mm)</td>
<td>134 lb. (61 kg)</td>
<td>207 lb. (94 kg)</td>
<td>280 lb. (127 kg)</td>
</tr>
<tr>
<td>SS-74 MPa Plus</td>
<td>24 VAC, 10 A, 50/60 Hz</td>
<td>50–780 ipm (1.3–19.8 m/min.)</td>
<td>.035–1/16 in. (0.9–1.6 mm) aluminum</td>
<td>110 lb. (50 kg)</td>
<td>160 lb. (73 kg)</td>
<td>210 lb. (95 kg)</td>
</tr>
<tr>
<td>DS-74 MPa Plus</td>
<td>24 VAC, 10 A, 50/60 Hz</td>
<td>50–780 ipm (1.3–19.8 m/min.)</td>
<td>.035–1/16 in. (0.9–1.6 mm) aluminum</td>
<td>134 lb. (61 kg)</td>
<td>207 lb. (94 kg)</td>
<td>280 lb. (127 kg)</td>
</tr>
</tbody>
</table>

*Contact Miller Electric Mfg. Co. at 1-920-735-4505 for more information on optional low- and high-speed motor options.

## S models (basic 70 Series feeders)
- Wire speed control.
- Factory-set run-in control for improved arc starts.
- 24 VDC high-torque, permanent-magnet motor.
- Quick-change drive rolls.
- Quick-release, drive-roll pressure adjustment arm allows drive roll change without losing spring preload setting.
- Solid-state speed control and brake circuit for increased service life.
- Floating positive drive systems provide trouble-free feeding on a variety of wires.

## D models additional features
- Digital meters for easy viewing of the wire feed speed and voltage.
- Remote voltage control allows operator to set voltage at the wire feeder without having to go back to the power source.
- Tachometer feedback to help keep wire feed speed accurate.

## DX models additional features
- Four weld programs allow the operators to store four independent welding parameters reducing welding setup time. (Four programs available per side on dual feeder.)
- Adjustable run-in control for improved arc starts.
- 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.
- Dual schedule, trigger dual schedule and trigger program select allows operator to switch welding parameters without readjusting machine, eliminating downtime and enhancing quality.

## MPA Plus models additional features
Alumination™ technology allows you to use the extended reach of a push-pull system for consistent, versatile and dependable aluminum wire feeding. Alumination gives you the versatility to handle whatever aluminum welding job you want to tackle.

Synergic pulsed MIG operation with MPA power supplies. Provides communication between the power source, feeder and gun. As wire speed increases/decreases, the pulse parameters also increase/decrease to match the right amount of power needed.

Trigger schedule select allows the operator to select the alternative schedule by quickly tapping the gun trigger when not welding. When optimized with MPA power supplies the operator can also switch from MIG to pulsed MIG.

Profile Pulse™ provides TIG appearance with MIG simplicity and productivity. Achieve “stacked dime” weld bead appearance without back-stepping. Profile Pulse frequency can be changed to increase or decrease the spacing between the ripple pattern to achieve the desired weld appearance.

Accu-Mate® properly seats the power pin for best feeding performance and prevents Accu-Mate grooved MIG guns from sliding in the casting.

Note: 70 Series feeders are shown, but front panels are the same for both feeders and controls.
**Control Panels**

**SS-74S and SS-74D**
1. Voltage Display Meter (S-74D model only)
2. Wire Speed Display Meter (S-74D model only)
3. Wire Feed Speed Select
4. Trigger Hold
5. Voltage Select
6. Jog/Purge

**SS-74DX**
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

**DS-74 MPa Plus**
1. Left Dual Schedule Indicator
2. Voltage/Arc Length Display Meter
3. Left Adjust Knob
4. Setup Button
5. Start Button
6. Right Dual Schedule Indicator
7. Amperage/Wire Speed Display Meter
8. Right Adjust Knob
9. Left/Right Select Button
10. Crater Button
11. Jog/Purge
Swingpak™ Base

For use with 8-, 12- or 16-foot (2.4, 3.7 or 4.9 m) Swingarcs. Each base accommodates a power source, Swingarc feeder system, coolant system, and gas cylinder. The base plate is solid to help better organize components and cables. The entire unit can be moved with a forklift truck.

Note: Base must be mounted to floor with 16-foot Swingarc.
**Genuine Miller® Options and Accessories**

### Remote Voltage Control
- **194988** Field. Non-digital for S-74S
- **194991** Field. Non-digital for D-74S

### Conversion Kit
- **194989** Field. S-74S to S-74D
- **194992** Field. D-74S to D-74D

### Single/Dual Spool Carrier
- **300353** For 4 ft. post
- **300352** For 6 ft. post

### Industrial MIG 4/0 Kit with Dinse Connectors
- **300405** Includes regulator flowmeter with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable with Dinse-style connector on one end and a lug on the other, 15-foot (4.6 m) work cable with Dinse-style connector on one end and 600-amp C-clamp on the other.

### Industrial MIG 4/0 Kit
- **300390** Includes the same as the kit above, except weld and work cables have lugs instead of Dinse-style connectors.

### Spool Covers
- **057607** For S-74 and left side of D-74 models
- **090389** For right side of D-74 models

- For 12-inch (305 mm) spool. *Note: Spool covers cannot be installed if the wire drive assembly is in a rotated position.*

### Spool Adapter
- **047141** For use with 14-pound (6.4 kg) spool of Lincoln self-shielding wire.

### Wire Reel Assembly
- **108008** For 60-pound (27 kg) coil of wire.

### Reel Covers
- **195412** For S-74 and left side of D-74 models
- **091668** For right side of D-74 models

- For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants. *Note: Reel covers cannot be installed if the wire drive assembly is in a rotated position.*

### Extension Cables for 14-Pin Plugs to 14-Pin Sockets*
- **242208025** 25 ft. (7.6 m)
- **242208050** 50 ft. (15.2 m)
- **242208080** 80 ft. (24.4 m)

- Provides 14-pin, 24 VAC, contactor and voltage control. Add to the standard 10-foot (3 m) feeder cable to extend feeder farther from power source. *For additional lengths visit MillerWelds.com/equiptoweld.*

### XR-Aluma-Pro™ Plus Gun
- **300000001** 15 ft. (4.6 m), air-cooled
- **300001001** 25 ft. (7.6 m), air-cooled
- **300004001** 25 ft. (7.6 m), water-cooled

- This easy-to-use and easy-to-maintain gooseneck-style MIG gun is designed for push-pull wire feed systems. Available in air- or water-cooled versions. Gun design allows for better access into tight spots.

### 1/16-inch (1.6 mm) Wire Kit
- **230708** Specially designed for 1/16-inch wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16-inch wires. Not included with standard XR-Aluma-Pro Plus gun.

### Hardware Liner Kit for Steel and Stainless
- **198377** For 15-, 25-, or 35-foot (4.6, 7.6 or 10.6 m) guns. Kit consists of gun head tube liner and feed cable liner. Recommend using .030–.045 inch mild steel or stainless steel electrode wire (.052- and 1/16-inch wire not recommended).

### Phosphorous Bronze Liner (Optional)
- **233999** Long head tube (air or water)
- **233998** Short head tube (air only)

### Steel Liner (Optional)
- **242191** Short head tube (air only)

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*For additional lengths visit MillerWelds.com/equiptoweld.*
**Bernard™ BTB MIG Guns and Centerfire™ Consumables**

**BTB MIG guns** increase productivity, reduce downtime, and lower maintenance and inventory costs.

**Centerfire consumables** improve weld quality, reduce downtime and boost gun performance.

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**Power Pin Tips**

- **2200105** Plastic, .030–.035 in. (0.8–0.9 mm), for aluminum (red)
- **2200106** Plastic, .040–.045 in. (1.02–1.2 mm), for aluminum (white)
- **2200107** Plastic, .052–.062 in. (1.4–1.6 mm), for aluminum (blue)

- **4477** Brass, .023–.045 in. (0.6–1.2 mm), for steel

**Liners**

- **44115** 15 ft. (4.6 m), .035–.045 in. (0.9–1.2 mm), steel
- **44215** 15 ft. (4.6 m), .045–.062 in. (1.2–1.6 mm), steel

**T Series Centerfire**

- **Contact Tips** 1.5 in. (38.1 mm)
  - T-023 .023 in. (0.6 mm)
  - T-030 .030 in. (0.8 mm)
  - T-035 .035 in. (0.9 mm)
  - T-039 .039 in. (1.0 mm)
  - T-045 .045 in. (1.2 mm)
  - T-052 .052 in. (1.4 mm)
  - T-062 1/16 in. (1.6 mm)

**TT Series Centerfire**

- **Contact Tips** 2 in. (50.8 mm)
  - TT-023 .023 in. (0.6 mm)
  - TT-030 .030 in. (0.8 mm)
  - TT-035 .035 in. (0.9 mm)
  - TT-039 .039 in. (1.0 mm)
  - TT-045 .045 in. (1.2 mm)
  - TT-052 .052 in. (1.4 mm)
  - TT-062 1/16 in. (1.6 mm)

**Centerfire Large Nozzles**

- **N-3400C** Copper, 3/4 in. I.D., flush tip
- **N-3418C** Copper, 3/4 in. I.D., 1/8 in. tip recess
- **N-3414C** Copper, 3/4 in. I.D., 1/4 in. tip recess
- **N-3418B** Brass, 3/4 in. I.D., 1/8 in. tip recess
- **N-3414B** Brass, 3/4 in. I.D., 1/4 in. tip recess
- **N-5800C** Copper, 5/8 in. I.D., flush tip
- **N-5818C** Copper, 5/8 in. I.D., 1/8 in. tip recess
- **N-5814C** Copper, 5/8 in. I.D., 1/4 in. tip recess
- **N-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess
- **N-5814B** Brass, 5/8 in. I.D., 1/4 in. tip recess

**Centerfire Small Nozzles**

- **NS-5818C** Copper, 5/8 in. I.D., 1/8 in. tip recess
- **NS-5800B** Brass, 5/8 in. I.D., flush tip
- **NS-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess
- **NS-1218C** Copper, 1/2 in. I.D., 1/8 in. tip recess
- **NS-1200B** Brass, 1/2 in. I.D., flush tip
- **NS-1218B** Brass, 1/2 in. I.D., 1/8 in. tip recess

**Centerfire**

- **Large Nozzles**
  - NST-3800B Brass, tapered, 3/8 in. I.D., flush tip
  - NST-3818B Brass, tapered, 3/8 in. I.D., 1/8 in. tip recess
  - NST-38XTB Brass, tapered, 3/8 in. I.D., 1/8 in. tip extension

**Diffuser**

- **DS-1**

**Insulator**

- **10012**
- **4323R**

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*Comes standard with 15 ft. BTB Gun 400 A for steel.
Typical Installations

Models
74S: Standard
74D: Digital meters and remote voltage control
74DX: Deluxe — digital full feature
74 MPa Plus: Digital full feature with Alumination™ technology

Miller® CV power source equipped with a 14-pin receptacle, 24 VAC supply, and voltage and current feedback

10-foot (3 m) 24 VAC, contactor, and voltage control cord (supplied with feeder)
10-foot (3 m) weld power cable (supplied with feeder)

Miller® electrically controlled CV and CC/CV power source with a 14-pin receptacle, 24 VAC supply, and voltage and current feedback

10-foot (3 m) 24 VAC, contactor, and voltage control cord (supplied with feeder)
10-foot (3 m) weld power cable (supplied with feeder)

10-foot (3 m) gas hose (supplied with feeder)

10-foot (3 m) interconnecting cord included with PSA-2 control. Includes a 4-pin connector for connecting to PSA-2 control and Hubbell connectors on older-style Miller® CV power sources.

Miller® CV power source with only 115 VAC power requiring contact closure for contactor control

10-foot (3 m) weld power cable (supplied with feeder)

10-foot (3 m) gas hose (supplied with feeder)

Optional PSA-2 control***

*If using the 70 Series feeders with a power source having only 115 VAC supply, the PSA-2 (power source adapter) is required. When using the PSA control, optional remote voltage is not functional. See Operator’s Manual for operating instructions.

**When using the D model with Miller® power sources that DO NOT have remote voltage control capabilities, i.e., CP type, the voltage control in the feeder IS NOT functional. See Operator’s Manual for operating instructions.

Note: D, DX and MPa Plus models are not compatible with CP Series power sources.
### Ordering Information

<table>
<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Single-Wire Models (includes one 15 ft. (4.6 m) Bernard BTB Gun 400 A and drive rolls)</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>SS-74S8</td>
<td>951522</td>
<td>8 ft. (2.4 m) boom with S-74S wire feeder</td>
<td></td>
<td></td>
</tr>
<tr>
<td>SS-74S12</td>
<td>951523</td>
<td>12 ft. (3.7 m) boom with S-74S wire feeder</td>
<td></td>
<td></td>
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<tr>
<td>SS-74S16</td>
<td>951524</td>
<td>16 ft. (4.9 m) boom with S-74S wire feeder</td>
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<tr>
<td>SS-74D8</td>
<td>951525</td>
<td>8 ft. (2.4 m) boom with S-74D wire feeder</td>
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<tr>
<td>SS-74D12</td>
<td>951526</td>
<td>12 ft. (3.7 m) boom with S-74D wire feeder</td>
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<tr>
<td>SS-74D16</td>
<td>951527</td>
<td>16 ft. (4.9 m) boom with S-74D wire feeder</td>
<td></td>
<td></td>
</tr>
<tr>
<td>SS-74DX8</td>
<td>951528</td>
<td>8 ft. (2.4 m) boom with S-74DX wire feeder</td>
<td></td>
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<tr>
<td>SS-74DX12</td>
<td>951529</td>
<td>12 ft. (3.7 m) boom with S-74DX wire feeder</td>
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<tr>
<td>SS-74DX16</td>
<td>951530</td>
<td>16 ft. (4.9 m) boom with S-74DX wire feeder</td>
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<tr>
<td>SS-74MPa Plus-8</td>
<td>951437</td>
<td>8 ft. (2.4 m) boom with S-74 MPa Plus wire feeder</td>
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<tr>
<td>SS-74MPa Plus-12</td>
<td>951438</td>
<td>12 ft. (3.7 m) boom with S-74 MPa Plus wire feeder</td>
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<tr>
<td>SS-74MPa Plus-16</td>
<td>951439</td>
<td>16 ft. (4.9 m) boom with S-74 MPa Plus wire feeder</td>
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<tr>
<td><strong>Dual-Wire Models (includes two 15 ft. (4.6 m) Bernard BTB Gun 400 A and drive rolls)</strong></td>
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<tr>
<td>DS-74S8</td>
<td>951531</td>
<td>8 ft. (2.4 m) boom with D-74S wire feeder</td>
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<tr>
<td>DS-74S12</td>
<td>951532</td>
<td>12 ft. (3.7 m) boom with D-74S wire feeder</td>
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<tr>
<td>DS-74S16</td>
<td>951533</td>
<td>16 ft. (4.9 m) boom with D-74S wire feeder</td>
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<tr>
<td>DS-74D8</td>
<td>951534</td>
<td>8 ft. (2.4 m) boom with D-74D wire feeder</td>
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<tr>
<td>DS-74D12</td>
<td>951535</td>
<td>12 ft. (3.7 m) boom with D-74D wire feeder</td>
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<tr>
<td>DS-74D16</td>
<td>951536</td>
<td>16 ft. (4.9 m) boom with D-74D wire feeder</td>
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<tr>
<td>DS-74DX8</td>
<td>951537</td>
<td>8 ft. (2.4 m) boom with D-74DX wire feeder</td>
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<tr>
<td>DS-74DX12</td>
<td>951538</td>
<td>12 ft. (3.7 m) boom with D-74DX wire feeder</td>
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<tr>
<td>DS-74DX16</td>
<td>951539</td>
<td>16 ft. (4.9 m) boom with D-74DX wire feeder</td>
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<tr>
<td>SS-74MPa Plus-8</td>
<td>951440</td>
<td>8 ft. (2.4 m) boom with D-74 MPa Plus wire feeder</td>
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<tr>
<td>SS-74MPa Plus-12</td>
<td>951441</td>
<td>12 ft. (3.7 m) boom with D-74 MPa Plus wire feeder</td>
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<tr>
<td>SS-74MPa Plus-16</td>
<td>951442</td>
<td>16 ft. (4.9 m) boom with D-74 MPa Plus wire feeder</td>
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#### Control Options

<table>
<thead>
<tr>
<th>Option</th>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Remote Voltage Control</td>
<td>194988</td>
<td>Field. Non-digital control (S-74S model only)</td>
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<tr>
<td></td>
<td>194991</td>
<td>Field. Non-digital control (D-74S model only)</td>
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#### Conversion Kit

<table>
<thead>
<tr>
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<th>Description</th>
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<tbody>
<tr>
<td>Field. S-74S to S-74D</td>
<td>194989</td>
<td>Field. S-74S to S-74D</td>
</tr>
<tr>
<td>Field. D-74S to D-74D</td>
<td>194992</td>
<td>Field. D-74S to D-74D</td>
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</tbody>
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#### Replacement Gun and Consumables

<table>
<thead>
<tr>
<th>Option</th>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bernard™ BTB Gun 400 A</td>
<td>Q4015AE8EMC</td>
<td>400 A, 15 ft. (4.6 m)</td>
</tr>
<tr>
<td>XR-Aluma-Pro™ Plus</td>
<td></td>
<td>For MPa Plus wire feeders only. See page 5</td>
</tr>
<tr>
<td>Centerfire™ Consumables</td>
<td></td>
<td>See page 6</td>
</tr>
</tbody>
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#### Power Sources

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<thead>
<tr>
<th>Option</th>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Invision™ 352 MPa and 450 MPa</td>
<td></td>
<td>See literature DC/23.6</td>
</tr>
<tr>
<td>XMT® 304/350/450</td>
<td></td>
<td>See literature DC/18.8, DC/18.93 and DC/18.94</td>
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<tr>
<td>Deltaweld® Series</td>
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<td>See literature DC/16.2</td>
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<tr>
<td>Dimension™ 302 and 452 and Dimension™ 650</td>
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<td>See literature DC/19.2 and DC/19.3</td>
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#### Mounting Equipment

<table>
<thead>
<tr>
<th>Option</th>
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<th>Description</th>
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<tr>
<td>Swingpak™ Base</td>
<td>183997</td>
<td>For 8, 12 or 16 ft. booms</td>
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<td>Pipe Posts</td>
<td>149838</td>
<td>4 ft. with base for 8, 12 or 16 ft. boom</td>
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<td>149839</td>
<td>6 ft. with base for 8, 12 or 16 ft. boom</td>
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#### Accessories

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<th>Stock No.</th>
<th>Description</th>
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<tr>
<td>Industrial MIG 4/0 Kits</td>
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<tr>
<td>Spool Covers</td>
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<td>Spool Adapter</td>
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<td>Wire Reel Assembly</td>
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<td>Reel Covers</td>
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<td>Extension Cables</td>
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<tr>
<td>DSS-9 Dual Schedule Switch</td>
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**Date:**

**Total Quoted Price:**

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