FLEX FEED® 74 HT



Pictured:
K3883-11 Flex Feed® 74 HT with basic user interface

Pictured:
K3883-12 Flex Feed® 74 HT with digital user interface

SEMIAUTOMATIC WIRE FEEDER

The Flex Feed® 74 HT (High Torque) is a heavy duty industrial semiautomatic wire feeder for general and structural fabrication. The Flex Feed wire feeder is designed to be customized for each application.

- Simple – Basic and digital user interface streamlines operator setup
- Rugged – Improved isolation and environmental protection – Robust connection points allow for reliable operation in tough conditions
- Modular –Modularity allows for customizable configurations

Processes »
MIG, Flux-Cored, Submerged Arc (hand-held) and Gouging

Applications »
Fabrication, Structural, Heavy Equipment, Construction

Product Numbers »
K3883-XX
4 Product Variations

* See back for details

PARTS AND LABOR
PARTES Y MANO DE OBRA
PIÈCES ET MAIN D'OEUVRE
STANDARD OPTIONAL
3/5
YEAR WARRANTY
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RECOMMENDED POWER SOURCES

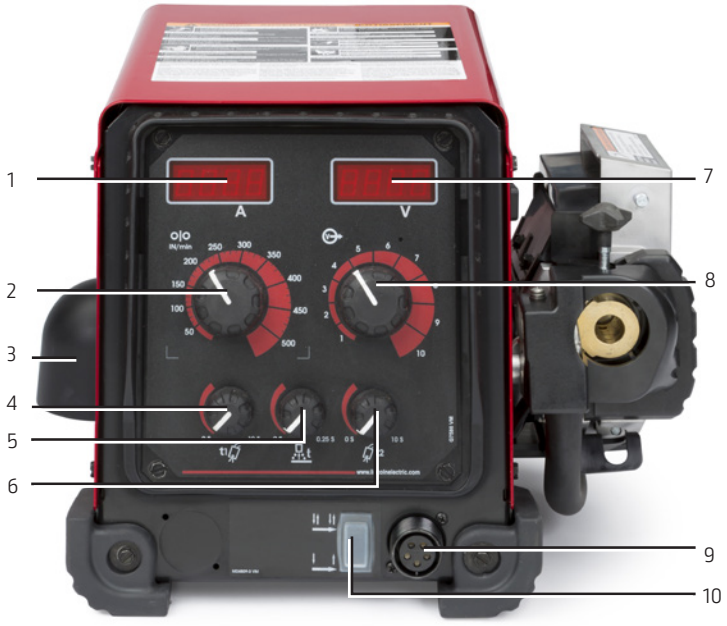
- Flextec® 350X Standard
- Flextec 500
- Flextec 650X
- Invertec® V350 PRO
- CV-305
- CV-400
- DC-400, 600 and 1000
- Ranger® 250 GXT
- Ranger 305 G, D, LPG
- Vantage® Engine Drives
- Air Vantage® Engine Drives

WHAT'S INCLUDED

- Models with wire reel stands include a 10 foot control cable
- All models include a standard #4 gun adapter
- Models with the Heavy Duty Wire Reel stand include a lift bail
- Models without a wire reel stand include K3929-1 quick disconnect inlet bushing

KEY CONTROLS

1. Digital display meter for AMPS
2. Wire Feed Speed Knob to increase or decrease feed speed
3. Optional gouge stud shown
4. Preflow Knob
5. Burnback Knob
6. Postflow Knob
7. Digital display meter for voltage
8. Voltage control to adjust the output of the power source
9. Gun Trigger Connector
10. 2/4-Step/Trigger Interlock Switch to enhance operator comfort for long welds





Pictured: Flex Feed 74 HT with basic user interface

REQUIRED OPTIONS

4-Roll Wire Drive Systems

Product Number	Description/Wire Size inches (mm)
Solid Wire, Smooth V Groove	
KP1505-030S	.023-.030 (0.6-0.8)
KP1505-035S	.035 (0.9)
KP1505-045S	.045 (1.2)
KP1505-052S	.052 (1.4)
KP1505-1/16S	1/16 (1.6)
KP1505-1	.035, .045 (0.9, 1.2)
KP1505-2	.040 (1.0)
Cored Steel Wire, Knurled V Groove	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C[3]	.052 (1.4)
KP1505-1/16C[3]	1/16 (1.6)
KP1505-7/64H[2][3]	7/64 (2.8) Hardfacing (Knurled V Groove with matching Smooth U Groove)
Cored or Solid Steel Wire, Knurled V Groove	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C	.052 (1.4)
KP1505-1/16C	1/16 (1.6)
KP1505-068	.068 -.072 (1.8)
KP1505-5/64	5/64 (2.0)
KP1505-3/32	3/32 (2.4)
KP1505-7/64	7/64 (2.8)
KP1505-120	.120 (3.2)
Hardfacing Wires, Knurled, Smooth V Groove	
KP1505-7/64C	7/64 (2.8)
KP1505-7/64H	7/64 (2.8) Hardfacing
Aluminum Wire, Smooth U Groove	
KP1507-035A	.035 (0.9)
KP1507-040A	.040 (1.0)
KP1507-3/64A	3/64 (1.2)
KP1507-1/16A	1/16 (1.6)
KP1507-3/32A	3/32 (2.4)

MAGNUM® PRO GUN READY PAK®

Product Name	Product Number	Cable Length
Magnum® PRO Curve 200 Ready-Pak (with K466-10 Gun Connector)	K2950-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-6 Gun Connector)	K2951-2-6-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-116	15 (3.0)
Magnum PRO Curve 400 Ready-Pak (with K466-10 Gun Connector)	K2952-2-10-45	15 (3.0)
Magnum PRO 250 (Barrel) Ready-Pak (with K466-6 Gun Connector)	K2651-2-6-45	15 (3.0)
Magnum PRO 350 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2652-2-10-45	15 (3.0)
Magnum PRO 450 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2653-2-10-45	15 (3.0)

FEED PLATE GUN ADAPTERS

K3344-1	K3345-1 (Installed as Standard in Flex Feed® 74 HT)	K3346-1	K3347-1	K3348-1	K3349-1
Lincoln Electric Compatible gun connector kit K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4 Compatible gun connector kit K466-10 K466-2 K466-6	Tweco® #5 Compatible gun connector kit K613-7 K613-2	Miller® guns Compatible gun connector kit K466-3 K613-3	OXO® guns Also requires K3345-1 Lincoln Adapter	Magnum® Fast-Mate™ Compatible with single and dual procedure guns. Also requires K3345-1 Lincoln Adapter

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Miller® is a registered trademark of Miller Electric Mfg. Co.
Oxo® is a registered trademark of Miller Electric Mfg. Co.

CONTROL CABLES AND ADAPTERS

Product Number	Description	Connection	Use	Length ft. (m)
K1797-10	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder.	10 (3.1)
K1797-25	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		25 (7.6)
K1797-50	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		50 (15.2)
K1797-100	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		100 (30.4)

RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Inlet Bushing, quick connect style
Included with Flex Feed 74 HT feeders without a wire reel stand.
Order K3929-1



Wire Straightener
Straightens wire for the better, smoother feeding.
Order K1733-1



Wire Reel Stands – Standard Duty
Use for spools up to 44 lbs. (20 kg) max.
Order K3342-1



Wire Reel Stands - Heavy Duty
For Spools up to 44 lbs. (20 kg) and coils up to 60 lbs. (27 kg). Includes K3341-1 lift bail.
Order K3343-1



Lift Bail
Insulated lift bail for suspending the wire feeder. Requires either standard duty or heavy duty wire reel stand.
Order K3341-1



Spool Cover
Order K1634-4 for use with 30-40 lb. spools.
K3340-1 for use with 50-60 lb coils.



Shielding Gas Filter
Protects the gas solenoid and gun from contaminants.
Order KP3103-1

Inverter Cart Mounting Kit
Use for mounting feeder to a K3059-xx inverter cart
Order K4068-1



Undercarriage
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stands.
Order K163-1

PRODUCT SPECIFICATIONS

Product Name	Product Number	User Interface		Reel Stand		Gouge Kit	Control Cable	Input Power	Output Capacity Current/Duty Cycle	Wire Size Range in. (mm)	Wire Feed Speed	H x W x D inches (mm)	Net Weight lbs. (kg)	Availability
		Basic	Digital	Standard	Heavy Duty									
Flex Feed 74 HT	K3883-1	•						24-42 VAC 50/60 Hz	600A/60% (wire drive only)	Solid[3] .025-3/32 (0.6-2.4) Cored[3]: .035-.120 (0.9-3.0)	50-700 (1.3-19.0)[1][2]	13.3 x 15.5 x 23.6 (338 x 394 x 599) wire drive only	36 (16.3)	S
	K3883-2		•										55 (24.9)	P
	K3883-11	•			•		•						36 (16.3)	S
	K3883-12		•		•		•						55 (24.9)	P

S - In-stock; normally in-stock for immediate shipment

P - One-Pak® of stocked items; normally in-stock for immediate shipment

[1] 20 tooth pinion gear installed in the wire drive as equipped from the factory

[2] To achieve wire feed speed of 700, the feeder is configured with a 30 pinion gear

[3] Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion

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