

# Spoolmatic® Pro

## Air-Cooled Pistol-Grip Spool Gun

### Quick Specs

#### Heavy Industrial Applications

Emergency vehicles  
Recreational vehicles  
Trucks and trailers  
Boat/yacht building  
Sign manufacturers

Shipbuilding  
Tool boxes  
Railcars  
Fabrication  
Repair

#### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
with pulsing power source

#### Wire Types

Aluminum  
Steel

#### Rated Output

200 A at 100% Duty Cycle

#### Net Weight

Gun only: 3.1 lb. (1.4 kg)  
Gun with 15 ft. cable: 10.4 lb. (4.7 kg)  
Gun with 30 ft. cable: 15.7 lb. (7.1 kg)



The industry's  
most reliable  
line of aluminum  
welding guns.

#### A complete system consists of the following:

- **Spoolmatic Pro spool gun** (Includes .035–1/16 in. knurled drive roll and two FasTip™ contact tips — .035 in. and 3/64 in.)
- **WC-24 or WC-115 weld control** (Required unless using a machine that allows direct hookup.)
- **Recommended Miller 14-pin power source** (See page 6.)

The Spoolmatic Pro spool gun is available in 15- or 30-foot (4.6 or 9 m) cable lengths and features a built-in gas valve, rotatable canister, and isolated common knurled drive roll.



**Aluminum-wire-specific tension settings** ensure smooth wire feeding performance with 4000 or 5000 series aluminum wires.

**Easy access to drive assembly and removable toolless head tube** reduce service time by allowing a means of changing drive rolls and head tube or performing routine maintenance without disassembly of gun.

**More durable motor and drive design** improves feedability and arc consistency while helping reduce downtime and maintenance costs associated with complex drive systems.

**Direct-connect (no adapters needed), easy-to-rotate, self-seating head tube options** in several different lengths and bend configurations (see page 4).



Guns are warrantied for one year, parts and labor.



**Miller Electric Mfg. LLC**  
An ITW Welding Company  
1635 West Spencer Street  
P.O. Box 1079  
Appleton, WI 54912-1079 USA

**Equipment Sales US and Canada**  
Phone: 866-931-9730  
International Phone: 920-735-4554

**MillerWelds.com**



# Specifications (Subject to change without notice.)



Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Maximum Spool Size Capacity	Gun Dimensions	Net Weight
200 A at 100% duty cycle	70–900 ipm (1.8–23 m/min.) dependent on control box used	Aluminum*: .030–1/16 in. (0.8–1.6 mm) Hard wire: .030–.045 in. (0.8–1.1 mm)	4 in. (102 mm)	H: 10.75 in. (273 mm) W: 2.5 in. (64 mm) L: 15.375 in. (390 mm)	Gun only: 3.1 lb. (1.4 kg) Gun with 15 ft. cable: 10.4 lb. (4.7 kg) Gun with 30 ft. cable: 15.7 lb. (7.1 kg)

\*Wire kit **230708** required to run 1/16-inch (1.6 mm) wire.

## Standard Replacement Consumables

Aluminum Wire Size	FasTip™ Contact Tip (Qty. 25)	Drive Rolls	Idler Rolls	Head Tube Liner 4 in. (102 mm)
.030 in. (0.8 mm)	<b>206186</b> .041 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
.035 in. (0.9 mm)	<b>206187</b> .047 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
.040 in. (1.0 mm)	<b>206188</b> .053 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
3/64 in. (1.2 mm)	<b>206189</b> .061 in. ID	<b>227434</b>	<b>227439</b>	<b>M1273</b>
1/16 in. (1.6 mm)	<b>206191</b> .071 in. ID	<b>227434</b>	<b>230710</b>	<b>M1273</b>

## Standard Consumables–FasTip™ Series

### Gas Diffusers



**29670** 1/8-inch tip recess (Standard)  
For heavy-duty FasTip contact tips.

**230678** 1/4-inch tip recess  
For heavy-duty FasTip contact tips.

**230679** Flush tip  
For heavy-duty FasTip contact tips.

### FasTip Contact Tips (25 per package)



#### Heavy-Duty (Aluminum Wire)

**206186** .030 in. (0.8 mm)

**206187** .035 in. (0.9 mm)

**206188** .040 in. (1.0 mm)

**206189** 3/64 in. (1.2 mm)

**206191** 1/16 in. (1.6 mm)

#### Tapered (Aluminum Wire)

**209026** .030 in. (0.8 mm)

**209027** .035 in. (0.9 mm)

**209029** 3/64 in. (1.2 mm)

**206030** 1/16 in. (1.6 mm)

### Nozzles

#### Screw-On Brass

**199610** 1/2 in. orifice, tapered

**199611** 3/4 in. orifice, straight

**199612** 3/4 in. orifice, straight HD

**199613** 5/8 in. orifice, tapered

**199614** 5/8 in. orifice, tapered HD

#### Screw-On Copper

**199615** 1/2 in. orifice, tapered

**199616** 3/4 in. orifice, straight

**199617** 3/4 in. orifice, straight HD

**198855** 5/8 in. orifice, tapered

**199618** 5/8 in. orifice, tapered HD

**207313** 5/8 in. orifice, tapered 15/16 O.D.

**209035** 3/8 in. orifice, tapered

**209036** 1/2 in. orifice, tapered

## Optional Consumables—Centerfire™ Series

**Insulator** 10012  
4323R

**Diffuser** D-1AP Large  
DS-1AP Small

**XR™-Pistol-Pro Diffuser Conversion Kits**  
for .035–1/16 in. aluminum

**230669** For D-1AP diffuser

**230670** For DS-1AP diffuser

Diffuser kits must be used to convert to Centerfire™ Series consumables. Kit includes diffuser and head tube liners.

### Aluminum-Specific T Series Contact Tips

**T-035AL** .035 in. (0.9 mm)

**T-047AL** .047 in. (1.2 mm)

**T-062AL** 1/16 in. (1.6 mm)

### Large Nozzles

**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-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

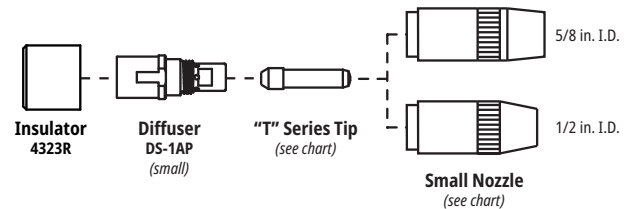
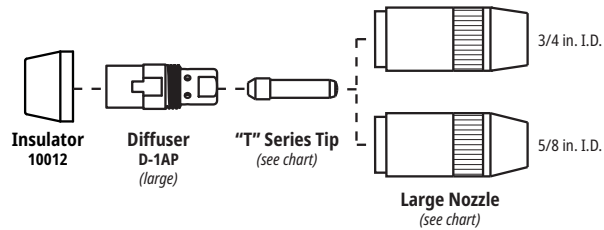
### Small Nozzles

**NS-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess

**NS-1218B** Brass, 1/2 in. I.D., 1/8 in. tip recess

**NS-1200B** Brass, 1/2 in. I.D., flush tip

**NST-3818B** Brass, 3/8 in. I.D., 1/8 in. tip recess



## Optional Head Tube Assemblies



**45 Degree/4 Inch**  
**255037** Air-cooled



**180 Degree/4 Inch**  
(standard on Spoolmatic® Pro)  
**255716** Air-cooled



**60 Degree/6 Inch**  
**with Centerfire™**  
**246301** Air-cooled



**45 Degree/6 Inch**  
**255040** Air-cooled



**180 Degree/6 Inch**  
**258476** Air-cooled



**180 Degree/4 Inch with Centerfire™**  
**258474** Air-cooled



**60 Degree/4 Inch**  
**231519** Air-cooled



**180 Degree/8 Inch**  
**255042** Air-cooled



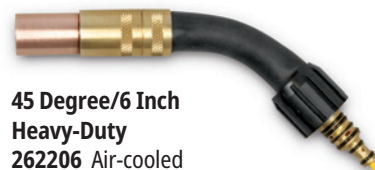
**60 Degree/6 Inch**  
**231518** Air-cooled



**45 Degree/10 Inch**  
**Tight Access**  
**258295** Air-cooled  
For hard-to-reach welds  
where a smaller nozzle  
and longer reach is needed.

### Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.



**45 Degree/6 Inch**  
**Heavy-Duty**  
**262206** Air-cooled



**60 Degree/6 Inch Heavy-Duty**  
**262207** Air-cooled



**180 Degree/6 Inch Heavy-Duty**  
**262208** Air-Cooled



**Flex Neck/10 Inch**  
**267517** Air-cooled  
Ideal for hard-to-reach welds.

## Liners for Optional Head Tube Assemblies

### Fastip™ Liners for Spoolmatic® Pro and XR™-Pistol-Pro

#### (4-inch assemblies)

**M1272** .030–.040 in. (0.8–1.0 mm)

**M1273** 3/64 and 1/16 in. (1.2 and 1.6 mm)

#### (6-inch assemblies)

**M1430** .030–.040 in. (0.8–1.0 mm)

**M1365** 3/64 and 1/16 in. (1.2 and 1.6 mm)

#### (8-inch assemblies)

**M1337** .030–.040 in. (0.8–1.0 mm)

**M1338** 3/64 and 1/16 in. (1.2 and 1.6 mm)

### Bernard™ Quik Tip™ Tight-Access Liners for Spoolmatic® Pro and XR™-Pistol-Pro

#### (10-inch assemblies)

**M1427** .030–.040 in. (0.8–1.0 mm)

**M1421** 3/64 and 1/16 in. (1.2 and 1.6 mm)



### Universal Teflon® Liner Kit

**262707** .030–.040 in. (0.8–1.0 mm)

black liners

**262705** 3/64 and 1/16 in. (1.2 and 1.6 mm)

yellow liners

Includes five 14-inch liners and cutter. Liners can be cut to correct length for any pistol or gooseneck-style gun. Cutter provides a straight, clean cut to reduce shaving and feeding problems.

**Teflon® Liner Cutter 258863**

## Genuine Miller® Accessories

### Hose and Cable Extension Kits

**132228** 25 ft. (7.6 m)

**132229** 50 ft. (15 m)

Extends Spoolmatic Pro away from the control box. Convenient plug-in connections. Includes gas hose, control cord, and weld power cable with International-style insulated connector.

### Leather Cable Cover

**241159** 15 ft. (4.6 m)

**241160** 30 ft. (9 m)

Protects gun hose and cable assembly from wear and abrasion. Features full-length hook-and-loop closure for ease of maintenance or replacement.



### One-Pound (0.5 kg) Spool Canister 132230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12-inch (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. Canister accommodates 4-inch (102 mm) spools of wire.



### 50-Degree Curved Nozzle Kit-A 264064

Directly attaches to Spoolmatic Pro, XR-Aluma-Pro or XR-Pistol-Pro for access to confined weld joint areas. Used with .030–1/16 inch (0.8–1.6 mm) wire. Kit includes two of each size contact tip to accommodate all wire sizes, nozzle adapter kit and curved nozzle. Uses standard straight head tube liner.

### Replacement Contact Tips for 50-Degree Curved Nozzle

**148155** .030 and .035 in. (0.8 and 0.9 mm) wire

**148154** .047 in. (1.2 mm) wire

**148156** 1/16 in. (1.6 mm) wire

### 50-Degree Curved Nozzle Insulator Kit 264066

Sleeve goes over center of curved nozzle to protect operator from heat. For use with 50-Degree Curved Nozzle Kit-A.

### 1/16-Inch (1.6 mm) Wire Kit 230708

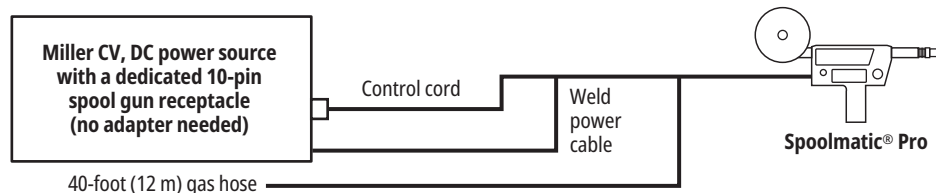
Specially designed for 1/16-inch wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16-inch wires. Not included with standard Spoolmatic Pro gun.



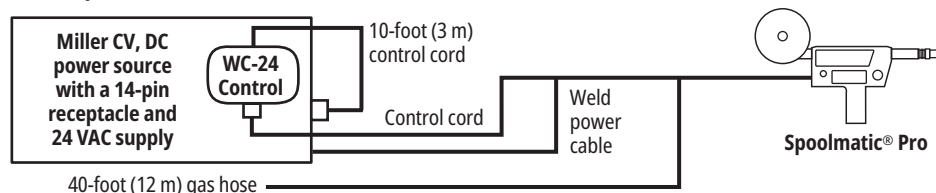
# Typical Installations

Note: Cords and cables are supplied unless noted otherwise on drawings below. Refer to Owner's Manual for complete installation instructions.

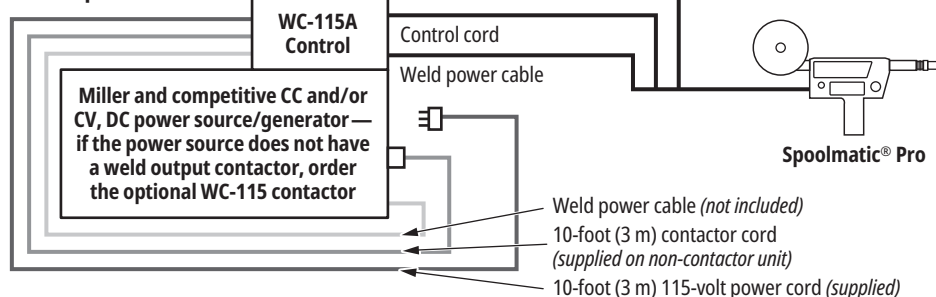
## Direct Hook-Up



## Hook-Up with WC-24



## Hook-Up with WC-115A



## Spoolmatic Pro Hook-Up Recommendations

CV Power Supply	Spoolmatic Pro
Bobcat™ 200 Air Pak Bobcat™ 265 Series Trailblazer® 330 Series	Direct hook-up
AlumaPower™ MPa XMT® Series Big Blue® Series (except Big Blue 450 Duo CST) CP Series* Deltaweld® Series* Dimension™ Series* Invision™ MPa* Regency® 250* Shopmaster™* PipePro® 304* Trailblazer® 275*, 275 DC*, 302*, 302 Air Pak™*, 325*	Need WC-24 <b>137549</b>
Bobcat™ 225*, 250*, 260* Miller Legend® 302*	Need WC-115A <b>137546011</b>

\*Discontinued product.



### WC-24 Weld Control 137549

Packaged in a compact, lightweight, non-metallic enclosure, the WC-24 easily mounts directly on the power source. Designed for use with Miller constant-voltage power sources with 14-pin receptacles and supplying 24 VAC. The control includes a board-mounted potentiometer which can alter the drive motor acceleration rate to optimize arc starting performance.

#### Important note:

To connect the Spoolmatic Pro gun and WC-24 control to older-style Miller or competitive CV power sources that do **NOT** have a 24 VAC supply, the PSA-2 Control **141604** is required.



### WC-115A Weld Control

**137546** Without contactor  
**137546011** With contactor

Operates on 115-volt power and designed primarily for constant-current DC power sources. Can also be used with constant-voltage (CV) power sources or DC engine drives supplying 115 volts. Used with a constant-current (CC) source the control circuit functions in a voltage-sensing mode, and with a CV source it functions as a constant-speed circuit. Includes wire run-in and drive motor acceleration controls which ensure optimum arc starting performance. Comes with a 10-foot (3 m), wall-type plug power cord.

#### Important notes:

To connect the WC-115A control to older-style Miller power sources having Hubbell or 5-pin contactor control receptacles, the appropriate connector must be ordered **separately**.

To connect to older-style Miller CC power sources having a two-socket Hubbell connector, order plug **039618**.

If power source has a Miller 5-pin receptacle, order **039273** and **039685**.

To connect to older-style Miller CV power sources having a two-prong Hubbell connector, order plug **039635**.

These connectors are to replace the 14-pin connector on the 10-foot interconnect contactor cord. Internal wiring changes may be necessary.



# Ordering Information

**Important notes:**  
*Spoolmatic Pro guns require a WC-24 or WC-115 weld control, unless used on a machine that allows direct hookup. Refer to chart on page 6.*

## Recommended Power Sources

- Direct Hookup**  
 Bobcat™ 200 Air Pak™  
 See literature no. ED/4.36  
 Bobcat™ 265  
 See literature no. ED/4.46  
 Trailblazer® 330 Series  
 See literature no. ED/4.76 and ED/4.86
- Requires WC-24 Weld Control**  
 AlumaPower™ MPa  
 See literature no. DC/34  
 (For synergic use with AlumaFeed™)  
 XMT® Series  
 See literature no. DC/18.93, DC/18.94, DC/18.96 and DC/18.98  
 Big Blue® Series  
 See literature no. ED/5.7, ED/5.8, ED/11.0, ED/11.5 and ED/14.0  
*Note: Other power sources may be used.*

Equipment	Stock No.	Description	Qty.	Price
Spoolmatic® Pro Spool Gun	301147	15 ft. (4.6 m) cable		
	301148	30 ft. (9 m) cable		
WC-24 Weld Control	137549			
WC-115A Weld Control	137546	Without contactor		
	137546011	With contactor		
Consumables and Accessories				
Consumables		See pages 2–3		
Optional Head Tube Assemblies		See page 4		
Liners for Opt. Head Tube Assemblies		See page 5		
Hose and Cable Extension Kits	132228	25 ft. (7.6 m)		
	132229	50 ft. (15 m)		
Leather Cable Cover	241159	15 ft. (4.6 m)		
	241160	30 ft. (9 m)		
One-Pound Spool Canister	132230			
50-Degree Curved Nozzle Kit-A	264064			
Replacement Contact Tips for 50-Degree Curved Nozzle		See page 5		
50-Degree Curved Nozzle Insulator Kit	264066	For use with 50-Degree Curved Nozzle Kit-A		
1/16-Inch (1.6 mm) Wire Kit	230708	Required when running 1/16 in. wire		

Date:

Total Quoted Price:

Distributed by:

