



PM-273245B

2022-07

Processes



MIG (GMAW) Welding

MIG (GMAW-P) Welding

Flux Cored (FCAW) Welding
(Gas- And Self-Shielded)

Description

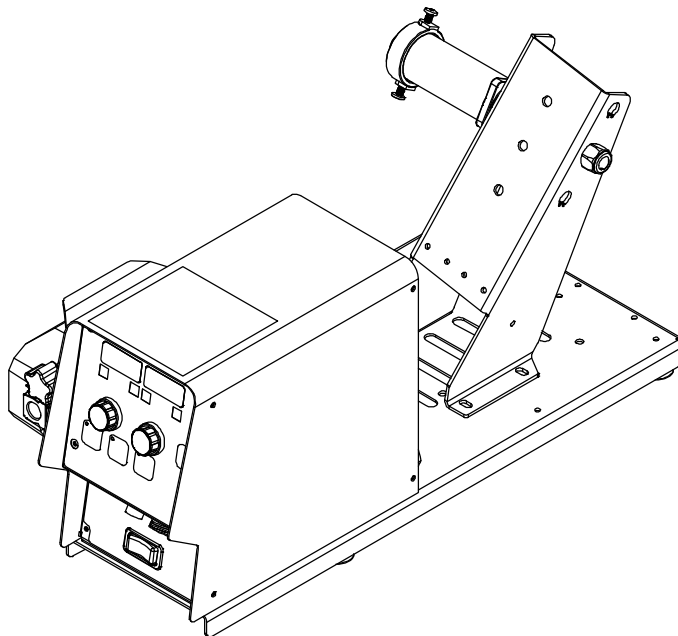


Wire Feeder

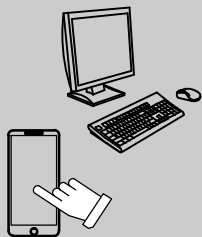
Aluminum Push/Pull Capable

S-74 MPa Plus

Eff w/Serial No.
MG135049U Thru MG245033U



PARTS MANUAL



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Owner's Manual translations,
and more, visit

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SECTION 1 – PARTS LIST FOR SERIAL NO. MG135049U THRU MG245033U

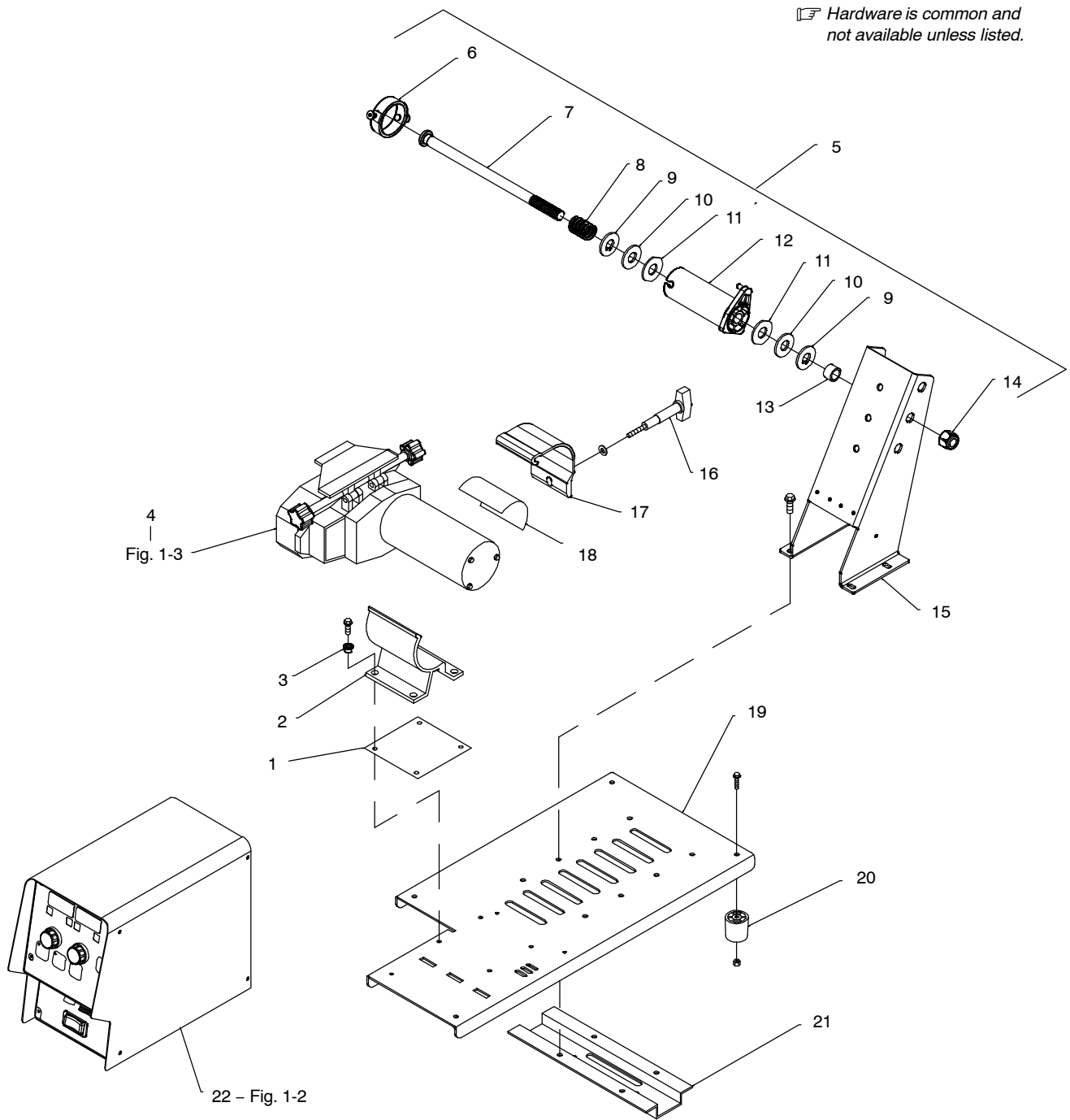


Figure 1-1. Main Assembly

246042-C

Eff w/Serial No. MG135049U Thru MG245033U

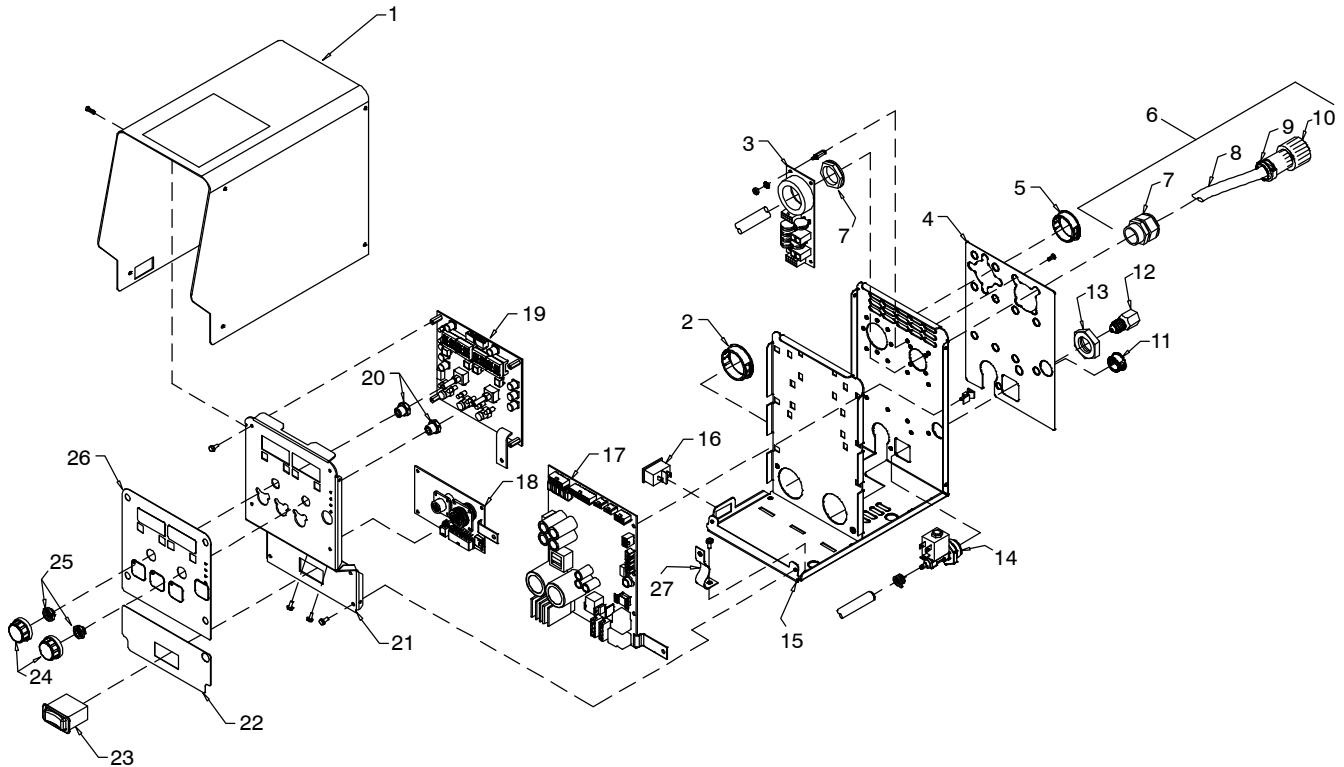
Item No.	Part No.	Description	Quantity
Figure 1-1. Main Assembly			
... 1	159647	.. Insulator, Motor Clamp	1
... 2	159646	.. Clamp, Motor Base	1
... 3	159360	.. Insulator, Screw Machine	4
... 4	Fig 1-3	.. Drive Assembly,	1
... 5	141753	.. Hub+Spindle Assy, (Includes)	1
... 6	058427	 Ring, Retaining Spool	1
... 7	180571	 Shaft, Support Spool	1
... 8	010233	 Spring, Cprsn .970 Od X .120 Wire X 1.250Pld	1
... 9	057971	 Washer, Flat Stl Keyed 1.500Dia X .125Thk	2
... 10	010191	 Washer, Fbr .656 Id X 1.500 Od X .125Thk	2
... 11	058628	 Washer, Brake Stl	2
... 12	058428	 Hub, Spool	1
... 13	248974	 Tubing, Stl .875 x 12 Ga Wall x .562	1
... 14	135205	 Nut, Stl Sflkg Hex Reg .625-11 W/Nylon Insert	1
... 15	200556	.. Support, Spool	1
... 16	201781	.. Knob, W/Extension Clamp	1
... 17	156243	.. Clamp, Motor Top	1
... 18	145639	.. Strip, Buna-n .062 X 3.000 X 4.000 Compressed Sht	1
... 19	200552	.. Base	1
... 20	134306	.. Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
... 21	200557	.. Stiffener, Base	1
... 22	Fig 1-2	.. Control Box	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.

Eff w/Serial No. MG135049U Thru MG245033U

 Hardware is common and
not available unless listed.



246043-D

Figure 1-2. Control Box

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 1-2. Control Box (Figure 1-1 Item 22)

...	1	...	235211	.. Wrapper, Feeder	1
...	2	...	010494	.. Bushing, Snap-in Nyl 1.375 Id X 1.750 Mtg Hole	2
...	3	PC5	244200	.. Circuit Card Assy, 14 Pin Filter	1
...	4	...	273799	.. Nameplate, Rear	1
...	5	...	006086	.. Blank, Snap-in Nyl 1.500 Mtg Hole Black	1
...	6	...	244581	.. Cable, Power (Includes)	1
...	7	...	139041	.. Bushing, Strain Relief .450/.709 Id X1.115 Mtg Hole	1
...	8	...	163520	.. Cable, Port No 18-14 11/C Type Awm 2-14 9-18 Cndct	1
...	9	...	079739	.. Conn, Circ Cpc Clamp Str Rlf	1
...	10	PLG12	141162	.. Housing Plug+Pins, (Service Kit)	1
...	...	PLG74	115092	.. Housing Plug+Sks, (Service Kit)	1
...	11	...	000527	.. Blank, Snap-in Nyl .875 Mtg Hole Black	1
...	12	...	211989	.. Fitting, W/Screen	1
...	13	...	220805	.. Nut, 750-14 Nps 1.48Hex .41H Nyl	1
...	14	GS1	228036	.. Valve, 24VAC 1Way .750-14 Thd 2.0mm Orf 100 psi	1
...	15	...	273846	.. Enclosure, Control/Motor	1
...	16	S1	111997	.. Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	1
...	17	PC1	242217	.. Circuit Card Assy, Motor Control W/Prgm (Used Prior to MG135001U)	1
...	17	PC1	272237	.. Circuit Card Assy, Motor Control W/Prgm	1
...	18	PC8	244207	.. Circuit Card Assy, Trigger Filter	1
...	19	PC2	272230	.. Circuit Card Assy, User Interface W/Prgm	1
...	20	...	231470	.. Nut, Adapter Encoder Shaft Mtg 375-32 To 500-28	2
...	21	...	271481	.. Panel, Front	1
...	22	...	243910	.. Nameplate, Lower	1

Eff w/Serial No. MG135049U Thru MG245033U

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-2. Control Box (Figure 1-1 Item 22) (Continued)				
... 23		200295 ..	Switch, Rocker Spdt 15A 12V (On)–Off–(On)	1
... 24		245663 ..	Knob, Encoder 1.250 Dia X .250 Id Push On W/Spring Clip	2
... 25		231469 ..	Nut, 500–28 .69Hex .28H Brs Conical Knurl	2
... 26			Nameplate, Upper (Order By Model And Serial Number)	1
... 27		246559 ..	Strap, Grounding 3.50 In Long	1

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

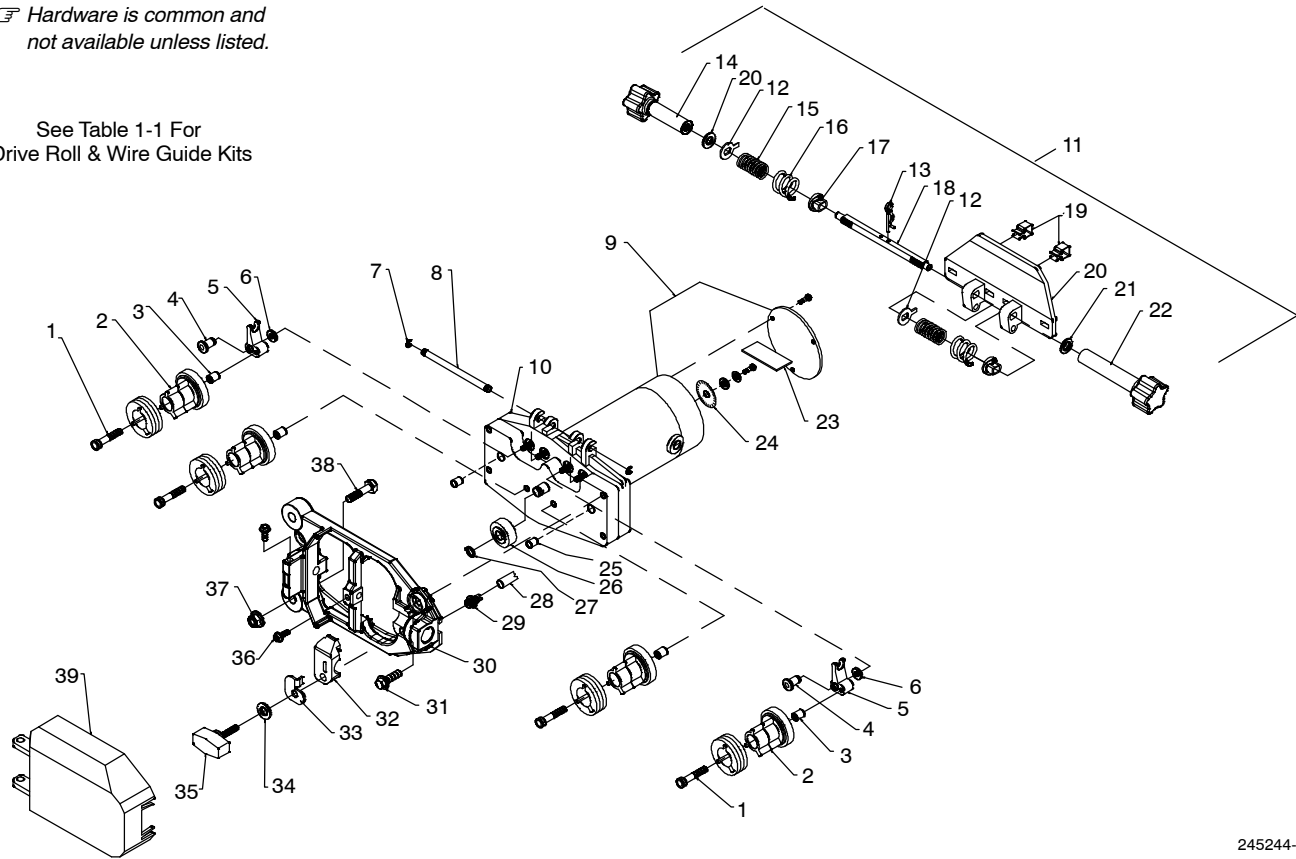
To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

	Dia. Mkgs.	Part No.	Description	Quantity
Harness Connectors/Receptacles				
..... PLG6,106		115094 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG10,110 ..		130203 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG72		115092 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG4,104		136810 ..	Housing Plug+Skts, (Service Kit)	1
.... PLG11, 21,71,111		131055 ..	Housing Rcpt+Skts, (Service Kit)	1
.. PLG1,77,78,79,101		202592 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG3,75,76,103		115093 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG51		174824 ..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG7,27,67,107		115091 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG73		148439 ..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG17,70		158719 ..	Housing Plug+Skts, (Service Kit)	1
..... PLG117		165404 ..	Housing Rcpt+Skts, (Service Kit)	1

Eff w/Serial No. MG135049U Thru MG245033U

 Hardware is common and not available unless listed.

See Table 1-1 For Drive Roll & Wire Guide Kits



245244-A

Figure 1-3. Drive Assembly, Wire

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 1-3. Drive Assembly, Wire (Figure 1-1 Item 4)

.....	244585	..	Drive Assy, Wire S/L 4 Roll W/Tach Accu-Mate (Items 1-38)	1
... 1	010668	..	Screw, Cap Stl Sch .250-20 X 1.500	4
... 2	172075	..	Carrier, Drive Roll W/Components	4
... 3	149962	..	Spacer, Carrier Drive Roll	4
... 4	149486	..	Pin, Rotation Arm Rocker	2
... 5	244584	..	Arm, Pressure LH Chamfered	2
... 6	150520	..	Spacer, Flat Stl .257 Id X .619 Od X .105	2
... 7	133493	..	Ring, Retaining Ext .250 Shaft X .025Thk	2
... 8	133350	..	Pin, Hinge	1
... 9 .. M1,101	201230	..	Motor, Gear 1/8HP 24VDC Standard Speed	1
.....	153491		Kit, Brush Replacement (Includes)	1
.....	153492		Cap, Brush	2
.....	*153493		Brush, Carbon	2
.....	184136		Kit, Brush Holder Replacement	1
... 10	155098	..	Kit, Cover Motor Gearbox (Includes)	1
.....	153550		Cover, Motor Gearbox (Includes)	1
.....	155099		Gasket, Cover	1
.....	155100		Screw, Cover	5
.....	154031		Spacer, Locating	2
.....	133493		Ring, Rtnng Ext .250 Shaft Grv X .025Thk	1
... 11	203642	..	Pressure Arm, R & Vert L 4 Roll (Includes)	1
... 11	203631	..	Pressure Arm, S/L & Vert S/R 4 Roll (Includes)	1
... 12	203641		Washer, Flat Indicator Spring Tension	2
... 13	182415		Pin, Cotter Hair	1
... 14	203640		Knob, W/Extension Short Pressure Arm	1

Eff w/Serial No. MG135049U Thru MG245033U

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-3. Drive Assembly, Wire (Continued)				
... 15		182156	... Spring, Cprsn	2
... 16		182155	... Spring	2
... 17		132746	... Bushing, Spring	2
... 18		203633	... Shaft, Spring	1
... 19		246098	... Clip, Spring Pressure Blocking	2
... 20		203632	... Shaft Carrier	1
... 21		133739	... Washer, Flat Buna .375 Id X .625 Od X .062Thk	2
... 22		203637	... Knob, W/Extension Long Pressure Arm	1
... 23	PC51,151	237048	.. Circuit Card, Digital Tach (Includes)	2
...	PLG5	131204	... Connector & Sockets	1
...		604311	... Grommet, Rbr .250 Id X .375Mtg Hole .062 Groove	1
... 24		132611	.. Optical Encoder Disc	1
...		603115	.. Weather Stripping, Adh .125 X .375	1
... 25		167387	.. Spacer, Locating	2
... 26		168825	.. Drive, Pinion	1
... 27		133308	.. Ring, Retaining Ext .375 Shaft X .025Thk	1
... 28		134834	.. Hose, Sae .187 Id X .410 Od (Order By Ft)	2Ft (0.6 m)
... 29		149959	.. Fitting, Brs Barbed M 3/16Tbg X .312-24	1
... 30		244579	.. Adapter, Gun/Feeder LH ACCU-MATE	1
... 30		244589	.. Adapter, Gun/Feeder RH ACCU-MATE	1
... 31		108940	.. Screw, Cap Stl Hexhd .250-20 X .750	4
... 32		242259	.. Clamp, Power Pin	1
... 33		242261	.. Lock, Power Pin	1
... 34		231232	.. Washer, Flat .344 ID X 0.688 OD X .065 T Stl Pld ANSI.312 Clr	1
... 35		151437	.. Knob, Plstc T 1.125 Lg X .312-18 X 1.500	1
... 36		151290	.. Screw, Mach Stl Hexwhd 10-32 X .500	2
... 37		167788	.. Nut, 375-16 .56 Hex .34H Stl Pld Sem Cone WSHR.88 D	1
... 38		601966	.. Screw, Cap Stl Hexhd .375-16 X 1.250	1
... 39		179277	.. Cover, Drive Roll (Includes)	1
...		269731	... Label, Warning Hot Surfaces And Moving Parts	1

*Recommended Spare Parts.

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.

	"V" GROOVE FOR HARD WIRE	"U" GROOVE FOR SOFT-SHELLED CORED WIRES	"V" KNURLED FOR HARD-SHELLED CORED WIRES	"U" COGGED FOR EXTREMELY SOFT WIRE OR SOFT – SHELLED CORED WIRES	POLISHED "U" GROOVE FOR ALUMINUM WIRES CONTAINS NYLON WIRE GUIDES
					
WIRE SIZE					
.023/.025 in. (0.6 mm)	151024				
.030 in. (0.8 mm)	151025				
.035 in. (0.9 mm)	151026		151052		265255
.040 in. (1.0 mm)	161190				
.045 in. (1.1/1.2 mm)	151027	151037*	151053	151070	265256*
.052 in. (1.3/1.4 mm)	151028	151038	151054	151071	
1/16 in. (1.6 mm)	151029	151039	151055	151072	265257
.068/.072 in. (1.8 mm)			151056		
5/64 in. (2.0 mm)		151040	151057	151073	
3/32 in. (2.4 mm)		151041	151058	151074	
7/64 in. (2.8 mm)		151042	151059	151075	
1/8 in. (3.2 mm)		151043**	151060**	151076**	
*Accommodates .045 and .047 (3/64 in) wire **Requires a low-speed wire feeder					
Nylon Wire Guides for Feeding Aluminum Wire					
Wire Sizes	Inlet Guide	Intermediate Guide	Wire Size	Inlet Guide	Intermediate Guide
.023 to .040 in. (0.6 to 1.0mm)	221030	149518	.035 in. (0.9mm)	221912	242417
.045 to .052 in. (1.1 to 1.4mm)	221030	149519	.047 in. (1.2mm)	221912	205936
1/16 to 5/64 in. (1.6 to 2mm)	221030	149520	1/16 in. (1.6mm)	221912	205937
3/32 to 7/64 in. (2.4 to 2.8mm)	229919	149521			
1/8 in. (3.2mm)	229919	149522			

Table 1-1. Drive Roll And Wire Guide Kits



PM-273245B

2022-07

Processes



MIG (GMAW) Welding

MIG (GMAW-P) Welding

Flux Cored (FCAW) Welding
(Gas- And Self-Shielded)

Description

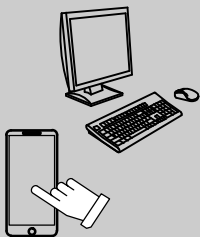
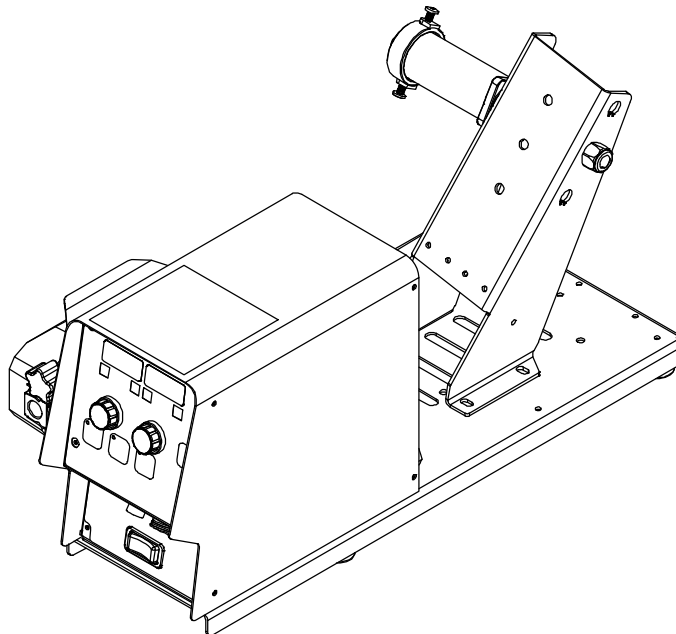


Wire Feeder

Aluminum Push/Pull Capable

S-74 MPa Plus

Eff w/Serial No.
MG245034U Thru MH295504U



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Owner's Manual translations,
and more, visit

www.MillerWelds.com

PARTS MANUAL

SECTION 2 – PARTS LIST FOR SERIAL NO. MG245034U THRU MH295504U

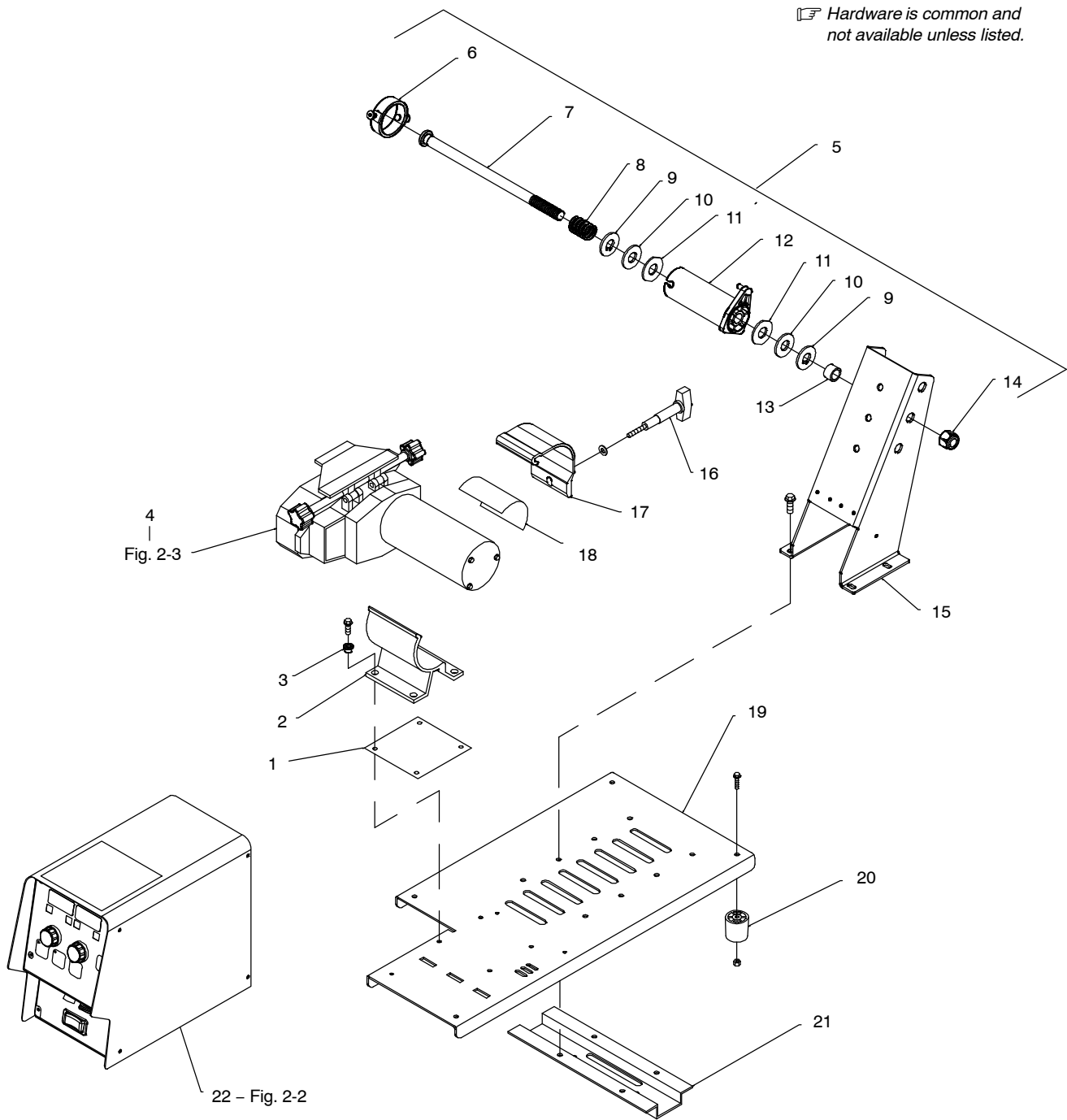


Figure 2-1. Main Assembly

246042-D

Eff w/Serial No. MG245034U THRU MH295504U

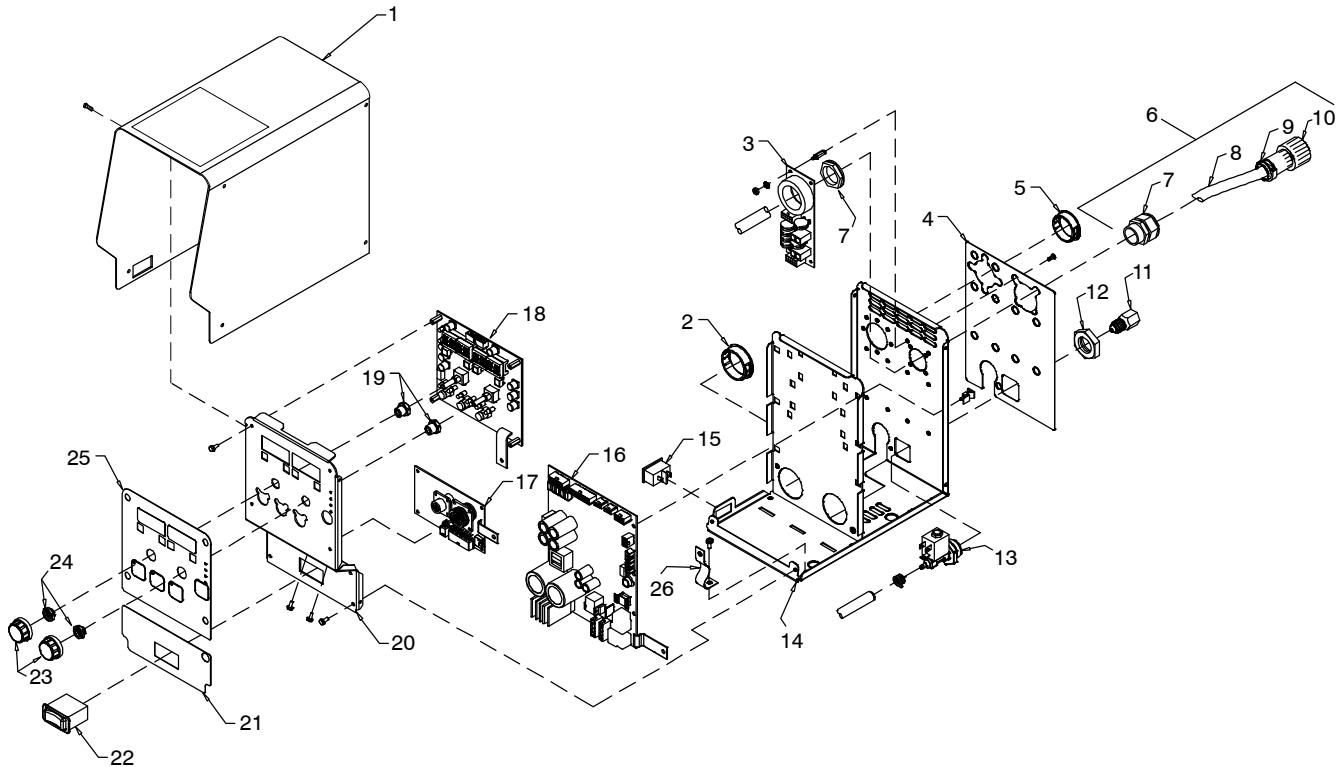
Item No.	Part No.	Description	Quantity
Figure 2-1. Main Assembly			
... 1	159647	.. Insulator, Motor Clamp	1
... 2	159646	.. Clamp, Motor Base	1
... 3	159360	.. Insulator, Screw Machine	4
...	278751	.. Washer, Fbr .281 Id X .625 Od X .065 Thk (Eff w/MH040002U)	4
... 4	Fig 2-3	.. Drive Assembly,	1
... 5	141753	.. Hub+Spindle Assy, (Includes)	1
... 6	058427	 Ring, Retaining Spool	1
... 7	180571	 Shaft, Support Spool	1
... 8	010233	 Spring, Cprsn .970 Od X .120 Wire X 1.250Pld	1
... 9	057971	 Washer, Flat Stl Keyed 1.500Dia X .125Thk	2
... 10	010191	 Washer, Fbr .656 Id X 1.500 Od X .125Thk	2
... 11	058628	 Washer, Brake Stl	2
... 12	058428	 Hub, Spool	1
... 13	248974	 Tubing, Stl .875 x 12 Ga Wall x .562	1
... 14	135205	 Nut, Stl Sflkg Hex Reg .625-11 W/Nylon Insert	1
... 15	200556	.. Support, Spool	1
... 16	201781	.. Knob, W/Extension Clamp	1
... 17	156243	.. Clamp, Motor Top	1
... 18	145639	.. Strip, Buna-n .062 X 3.000 X 4.000 Compressed Sht	1
... 19	200552	.. Base	1
... 20	134306	.. Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
... 21	200557	.. Stiffener, Base	1
... 22	Fig 2-2	.. Control Box	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.

Eff w/Serial No. MG245034U THRU MH295504U

 Hardware is common and
not available unless listed.



246043-F

Figure 2-2. Control Box

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 2-2. Control Box (Figure 2-1 Item 22)

...	1	...	235211	.. Wrapper, Feeder (Includes)	...	1
...		...	274964	... Label, Warning General Precautionary (EN/FR/SP) (Eff w/MH345113U)	...	1
...	2	...	010494	.. Bushing, Snap-in Nyl 1.375 Id X 1.750 Mtg Hole	...	2
...	3	PC5	244200	.. Circuit Card Assy, 14 Pin Filter	...	1
...	4	...	273799	.. Nameplate, Rear	...	1
...	5	...	006086	.. Blank, Snap-in Nyl 1.500 Mtg Hole Black	...	1
...	6	...	244581	.. Cable, Power (Includes)	...	1
...	7	...	139041	... Bushing, Strain Relief .450/.709 Id X1.115 Mtg Hole	...	1
...	8	...	163520	... Cable, Port No 18-14 11/C Type Awm 2-14 9-18 Cndct	...	1
...	9	...	079739	... Conn, Circ Cpc Clamp Str Rlf	...	1
...	10	PLG12	141162	... Housing Plug+Pins, (Service Kit)	...	1
...		PLG74	115092	... Housing Plug+Sks, (Service Kit)	...	1
...	11	...	211989	.. Fitting, W/Screen	...	1
...	12	...	220805	.. Nut, 750-14 Nps 1.48Hex .41H Nyl	...	1
...	13	GS1	228036	.. Valve, 24VAC 1Way .750-14 Thd 2.0mm Orf 100 psi	...	1
...	14	...	273846	.. Enclosure, Control/Motor	...	1
...	15	S1	111997	.. Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	...	1
...	16	PC1	242217	.. Circuit Card Assy, Motor Control W/Prgm (Used Prior to MG135001U)	...	1
...	16	PC1	272237	.. Circuit Card Assy, Motor Control W/Prgm	...	1
...	17	PC6	244207	.. Circuit Card Assy, Trigger Filter	...	1
...	18	PC2	272230	.. Circuit Card Assy, User Interface W/Prgm	...	1
...	19	...	231470	.. Nut, Adapter Encoder Shaft Mtg 375-32 To 500-28	...	2
...	20	...	271481	.. Panel, Front	...	1
...	21	...	243910	.. Nameplate, Lower	...	1

Eff w/Serial No. MG245034U THRU MH295504U

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 2-2. Control Box (Figure 2-1 Item 22) (Continued)

... 22	200295	..	Switch, Rocker Spdt 15A 12V (On)–Off–(On)	1
... 23	245663	..	Knob, Encoder 1.250 Dia X .250 Id Push On W/Spring Clip	2
... 24	231469	..	Nut, 500–28 .69Hex .28H Brs Conical Knurl	2
... 25		..	Nameplate, Upper (Order By Model And Serial Number)	1
... 26	246559	..	Strap, Grounding 3.50 In Long	1

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

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Dia. Mkgs.	Part No.	Description	Quantity
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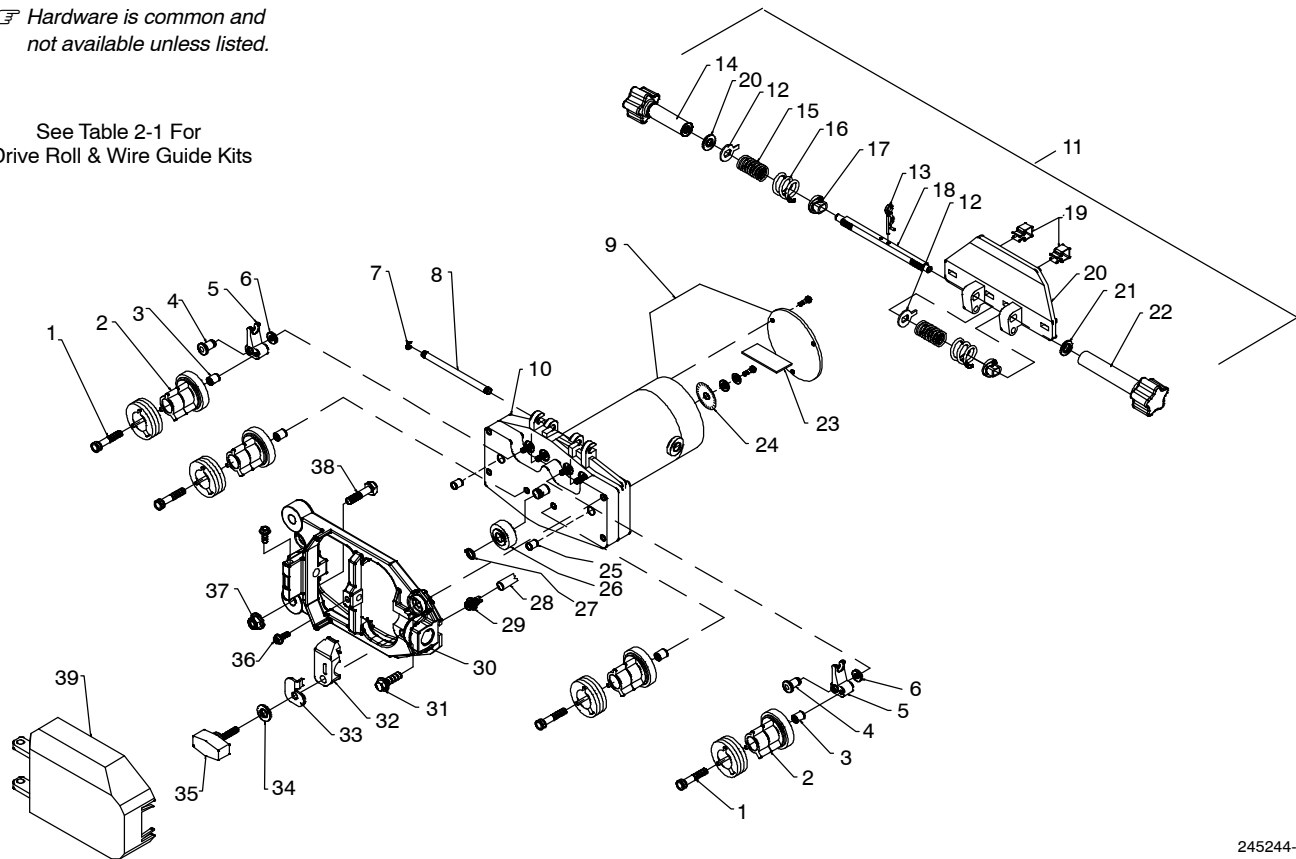
Harness Connectors/Receptacles

..... PLG6,106	115094	..	Housing Plug+Skts, (Service Kit)	1
..... PLG10,110	130203	..	Housing Plug+Skts, (Service Kit)	1
..... PLG72	115092	..	Housing Plug+Skts, (Service Kit)	1
..... PLG4,104	136810	..	Housing Plug+Skts, (Service Kit)	1
.... PLG11, 21,71,111	131055	..	Housing Rcpt+Skts, (Service Kit)	1
.. PLG1,77,78,79,101	202592	..	Housing Plug+Skts, (Service Kit)	1
.... PLG3,75,76,103	115093	..	Housing Plug+Skts, (Service Kit)	1
..... PLG51	174824	..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG7,27,67,107	115091	..	Housing Plug+Skts, (Service Kit)	1
..... PLG73	148439	..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG17,70	158719	..	Housing Plug+Skts, (Service Kit)	1
..... PLG117	165404	..	Housing Rcpt+Skts, (Service Kit)	1

Eff w/Serial No. MG245034U THRU MH295504U

 Hardware is common and not available unless listed.

See Table 2-1 For Drive Roll & Wire Guide Kits



245244-B

Figure 2-3. Drive Assembly, Wire

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 2-3. Drive Assembly, Wire (Figure 2-1 Item 4)

.....	244585	..	Drive Assy, Wire S/L 4 Roll W/Tach Accu-Mate (Items 1-38)	1
... 1	010668	..	Screw, Cap Stl Sch .250-20 X 1.500	4
... 2	172075	..	Carrier, Drive Roll W/Components	4
... 3	149962	..	Spacer, Carrier Drive Roll	4
... 4	149486	..	Pin, Rotation Arm Rocker	2
... 5	244584	..	Arm, Pressure LH Chamfered	2
... 6	150520	..	Spacer, Flat Stl .257 Id X .619 Od X .105	2
... 7	133493	..	Ring, Retaining Ext .250 Shaft X .025Thk	1
... 8	133350	..	Pin, Hinge	1
... 9 ... M101	201230	..	Motor, Gear 1/8HP 24VDC Standard Speed	1
.....	153491		Kit, Brush Replacement (Includes)	1
.....	153492		Cap, Brush	2
.....	*153493		Brush, Carbon	2
.....	184136		Kit, Brush Holder Replacement	1
... 10	155098	..	Kit, Cover Motor Gearbox (Includes)	1
.....	153550		Cover, Motor Gearbox (Includes)	1
.....	155099		Gasket, Cover	1
.....	155100		Screw, Cover	5
.....	154031		Spacer, Locating	2
.....	133493		Ring, Rtnng Ext .250 Shaft Grv X .025Thk	1
... 11	203642	..	Pressure Arm, R & Vert L 4 Roll (Includes)	1
... 11	203631	..	Pressure Arm, S/L & Vert S/R 4 Roll (Includes)	1
... 12	203641		Washer, Flat Indicator Spring Tension	2
... 13	182415		Pin, Cotter Hair	1
... 14	203640		Knob, W/Extension Short Pressure Arm	1

Eff w/Serial No. MG245034U THRU MH295504U

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 2-3. Drive Assembly, Wire (Continued)				
... 15		182156	 Spring, Cprsn	2
... 16		182155	 Spring	2
... 17		132746	 Bushing, Spring	2
... 18		203633	 Shaft, Spring	1
... 19		246098	 Clip, Spring Pressure Blocking	2
... 20		203632	 Shaft Carrier	1
... 21		133739	 Washer, Flat Buna .375 Id X .625 Od X .062Thk	2
... 22		203637	 Knob, W/Extension Long Pressure Arm	1
... 23	PC151	237048	.. Circuit Card, Digital Tach (Includes)	1
.....	PLG5	131204	 Connector & Sockets	1
.....		604311	 Grommet, Rbr .250 Id X .375Mtg Hole .062 Groove	1
... 24		132611	.. Optical Encoder Disc	1
.....		279896	.. Weather Stripping, Adh .125 Thk 2.4375 Dia (Eff w/MH345113U)	1
... 25		167387	.. Spacer, Locating	2
... 26		168825	.. Drive, Pinion	1
... 27		133308	.. Ring, Retaining Ext .375 Shaft X .025Thk	1
... 28		134834	.. Hose, SAE .187 Id X .410 Od (Order By Ft)	2Ft (0.6 m)
... 29		149959	.. Fitting, Brs Barbed M 3/16Tbg X .312-24	1
... 30		244579	.. Adapter, Gun/Feeder LH ACCU-MATE	1
... 30		244589	.. Adapter, Gun/Feeder RH ACCU-MATE	1
... 31		108940	.. Screw, Cap Stl Hexhd .250-20 X .750	4
... 32		242259	.. Clamp, Power Pin	1
... 33		242261	.. Lock, Power Pin	1
... 34		231232	.. Washer, Flat .344 ID X 0.688 OD X .065 T Stl Pld ANSI.312 Clr	1
... 35		151437	.. Knob, Plstc T 1.125 Lg X .312-18 X 1.500	1
... 36		151290	.. Screw, Mach Stl Hexwhd 10-32 X .500	2
... 37		167788	.. Nut, 375-16 .56 Hex .34H Stl Pld Sem Cone WSHR.88 D	1
... 38		601966	.. Screw, Cap Stl Hexhd .375-16 X 1.250	1
... 39		179277	.. Cover, Drive Roll (Includes)	1
.....		275806	 Label, Warning Hot Surfaces And Moving Parts (Eff w/MH345113U)	1

*Recommended Spare Parts.

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.

	"V" GROOVE FOR HARD WIRE	"U" GROOVE FOR SOFT-SHELLED CORED WIRES	"V" KNURLED FOR HARD-SHELLED CORED WIRES	"U" COGGED FOR EXTREMELY SOFT WIRE OR SOFT-SHELLED CORED WIRES	POLISHED "U" GROOVE FOR ALUMINUM WIRES CONTAINS NYLON WIRE GUIDES
					
WIRE SIZE					
.023/.025 in. (0.6 mm)	151024				
.030 in. (0.8 mm)	151025				
.035 in. (0.9 mm)	151026		151052		265255
.040 in. (1.0 mm)	161190				
.045 in. (1.1/1.2 mm)	151027	151037*	151053	151070	265256*
.052 in. (1.3/1.4 mm)	151028	151038	151054	151071	
1/16 in. (1.6 mm)	151029	151039	151055	151072	265257
.068/.072 in. (1.8 mm)			151056		
5/64 in. (2.0 mm)		151040	151057	151073	
3/32 in. (2.4 mm)		151041	151058	151074	
7/64 in. (2.8 mm)		151042	151059	151075	
1/8 in. (3.2 mm)		151043**	151060**	151076**	
*Accommodates .045 and .047 (3/64 in) wire **Requires a low-speed wire feeder					
Nylon Wire Guides for Feeding Aluminum Wire					
Wire Sizes	Inlet Guide	Intermediate Guide	Wire Size	Inlet Guide	Intermediate Guide
.023 to .040 in. (0.6 to 1.0mm)	221030	149518	.035 in. (0.9mm)	221912	242417
.045 to .052 in. (1.1 to 1.4mm)	221030	149519	.047 in. (1.2mm)	221912	205936
1/16 to 5/64 in. (1.6 to 2mm)	221030	149520	1/16 in. (1.6mm)	221912	205937
3/32 to 7/64 in. (2.4 to 2.8mm)	229919	149521			
1/8 in. (3.2mm)	229919	149522			

Table 2-1. Drive Roll And Wire Guide Kits



PM-273245B

2022-07

Processes



MIG (GMAW) Welding

MIG (GMAW-P) Welding

Flux Cored (FCAW) Welding
(Gas- And Self-Shielded)

Description

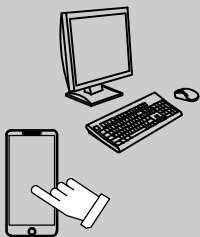
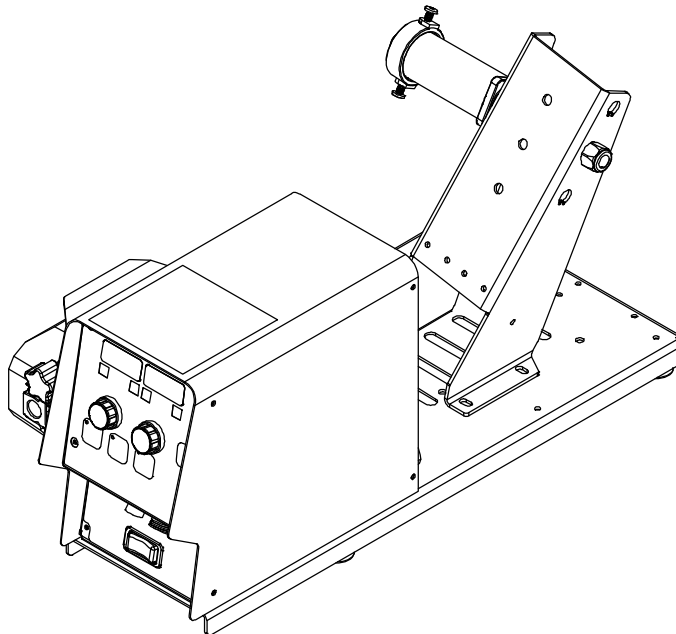


Wire Feeder

Aluminum Push/Pull Capable

S-74 MPa Plus

Eff w/Serial No.
MH295505U And Following



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

www.MillerWelds.com

PARTS MANUAL

SECTION 3 – PARTS LIST FOR SERIAL NO. MH295505U AND FOLLOWING

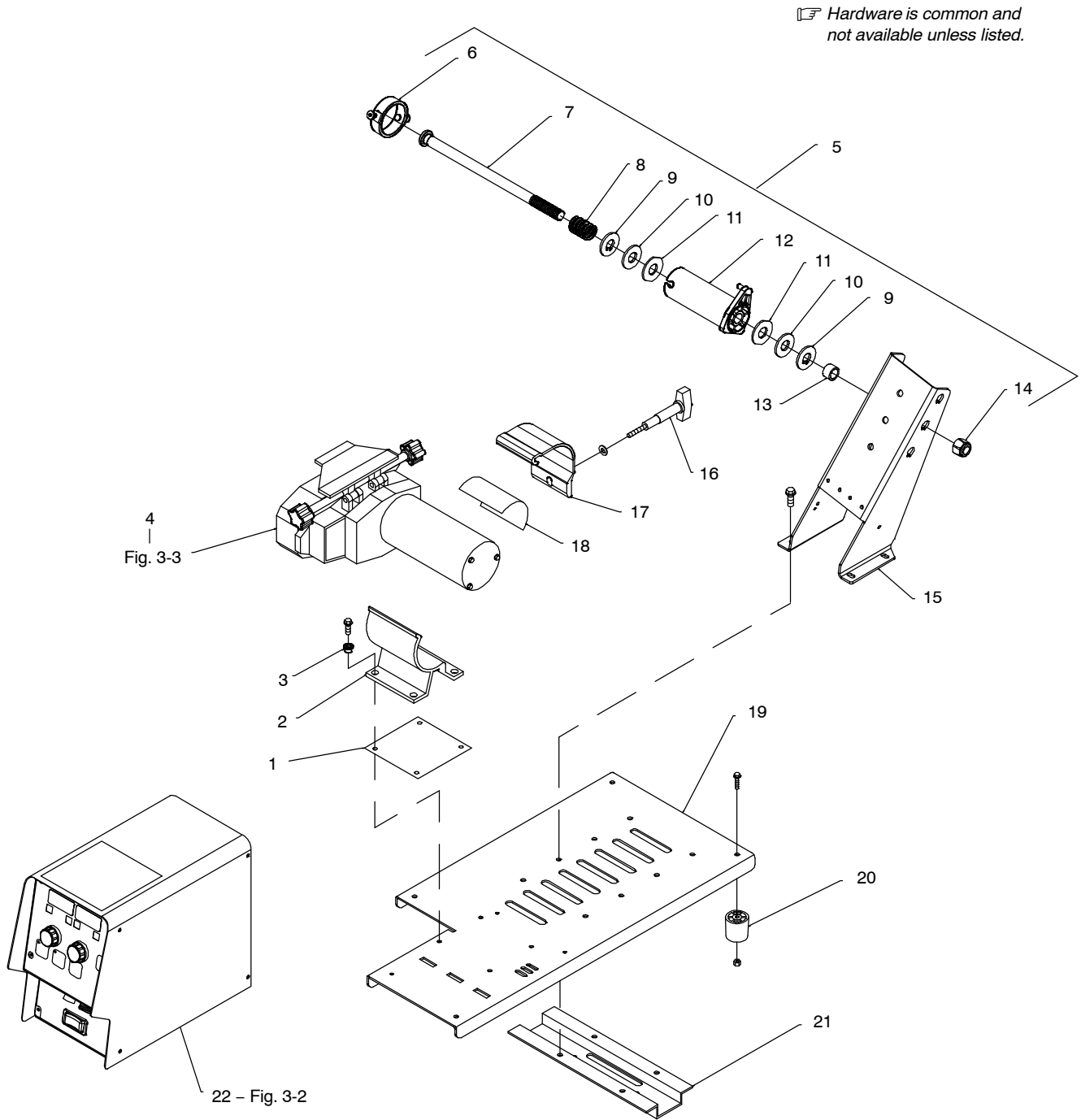


Figure 3-1. Main Assembly

246042-E

Eff w/Serial No. MH295505U And Following

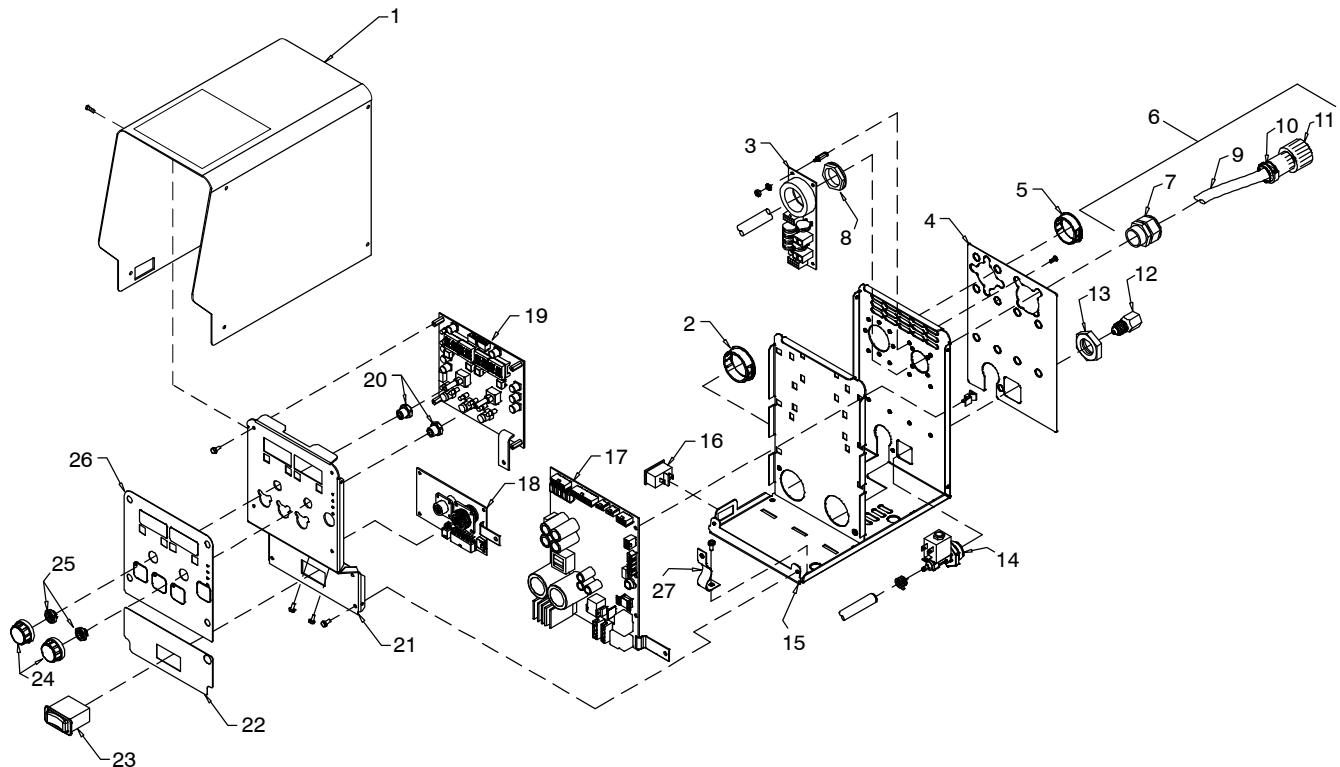
Item No.	Part No.	Description	Quantity
Figure 3-1. Main Assembly			
... 1	159647	.. Insulator, Motor Clamp	1
... 2	159646	.. Clamp, Motor Base	1
... 3	159360	.. Insulator, Screw Machine	4
...	278751	.. Washer, Fbr .281 Id X .625 Od X .065 Thk	4
... 4	Fig 3-3	.. Drive Assembly,	1
... 5	141753	.. Hub+Spindle Assy, (Includes)	1
... 6	058427	 Ring, Retaining Spool	1
... 7	180571	 Shaft, Support Spool	1
... 8	010233	 Spring, Cprsn .970 Od X .120 Wire X 1.250Pld	1
... 9	057971	 Washer, Flat Stl Keyed 1.500Dia X .125Thk	2
... 10	010191	 Washer, Fbr .656 Id X 1.500 Od X .125Thk	2
... 11	058628	 Washer, Brake Stl	2
... 12	058428	 Hub, Spool	1
... 13	248974	 Tubing, Stl .875 x 12 Ga Wall x .562	1
... 14	135205	 Nut, Stl Sflkg Hex Reg .625-11 W/Nylon Insert	1
... 15	200556	.. Support, Spool (Prior to NC290108U)	1
... 15	279240	.. Support, Spool Tilted (Eff w/NC290108U)	1
... 16	201781	.. Knob, W/Extension Clamp	1
... 17	156243	.. Clamp, Motor Top	1
... 18	145639	.. Strip, Buna-n .062 X 3.000 X 4.000 Compressed Sht	1
... 19	200552	.. Base	1
... 20	134306	.. Foot, Rubber 1.250 Dia X 1.375 High No 10 Screw	4
... 21	200557	.. Stiffener, Base	1
... 22	Fig 3-2	.. Control Box	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.

Eff w/Serial No. MH295505U And Following

 Hardware is common and not available unless listed.



246043-F

Figure 3-2. Control Box

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
----------	------------	----------	-------------	----------

Figure 3-2. Control Box (Figure 3-1 Item 22)

...	1	...	235211	.. Wrapper, Feeder (Includes)	1
...		...	274964	... Label, Warning General Precautionary (EN/FR/SP)	1
...	2	...	010494	.. Bushing, Snap-in Nyl 1.375 Id X 1.750 Mtg Hole	2
...	3	PC5	244200	.. Circuit Card Assy, 14 Pin Filter	1
...	4	...	273799	.. Nameplate, Rear	1
...	5	...	006086	.. Blank, Snap-in Nyl 1.500 Mtg Hole Black	1
...	6	...	244581	.. Cable, Power (Includes)	1
...	7	...	139041	... Bushing, Strain Relief .450/.709 Id X1.115 Mtg Hole	1
...	8	...	280203	... Nut, Pg21 1.406 Hex X .281 Thk Nylon Black (Eff w/MH295505U)	1
...	9	...	163520	... Cable, Port No 18-14 11/C Type Awm 2-14 9-18 Cndct	1
...	10	...	079739	... Conn, Circ Cpc Clamp Str Rlf	1
...	11	PLG12	141162	... Housing Plug+Pins, (Service Kit)	1
...		PLG74	115092	... Housing Plug+Sks, (Service Kit)	1
...	12	...	211989	.. Fitting, W/Screen	1
...	13	...	220805	.. Nut, 750-14 Nps 1.48Hex .41H Nyl	1
...	14	GS1	228036	.. Valve, 24VAC 1Way .750-14 Thd 2.0mm Orf 100 psi	1
...	15	...	273846	.. Enclosure, Control/Motor	1
...	16	S1	111997	.. Switch, Rocker Spst 10A 250VAC On-Off Visi Red Rock	1
...	17	PC1	242217	.. Circuit Card Assy, Motor Control W/Prgm (Used Prior to MG135001U)	1
...	17	PC1	272237	.. Circuit Card Assy, Motor Control W/Prgm	1
...	18	PC6	244207	.. Circuit Card Assy, Trigger Filter	1
...	19	PC2	272230	.. Circuit Card Assy, User Interface W/Prgm	1
...	20	...	231470	.. Nut, Adapter Encoder Shaft Mtg 375-32 To 500-28	2
...	21	...	271481	.. Panel, Front	1
...	22	...	243910	.. Nameplate, Lower	1

Eff w/Serial No. MH295505U And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
----------	------------	----------	-------------	----------

Figure 3-2. Control Box (Figure 3-1 Item 22) (Continued)

... 23	200295	..	Switch, Rocker Spdt 15A 12V (On)–Off–(On)	1
... 24	245663	..	Knob, Encoder 1.250 Dia X .250 Id Push On W/Spring Clip	2
... 25	231469	..	Nut, 500–28 .69Hex .28H Brs Conical Knurl	2
... 26			Nameplate, Upper (Order By Model And Serial Number)	1
... 27	246559	..	Strap, Grounding 3.50 In Long	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.

Dia. Mkgs.	Part No.	Description	Quantity
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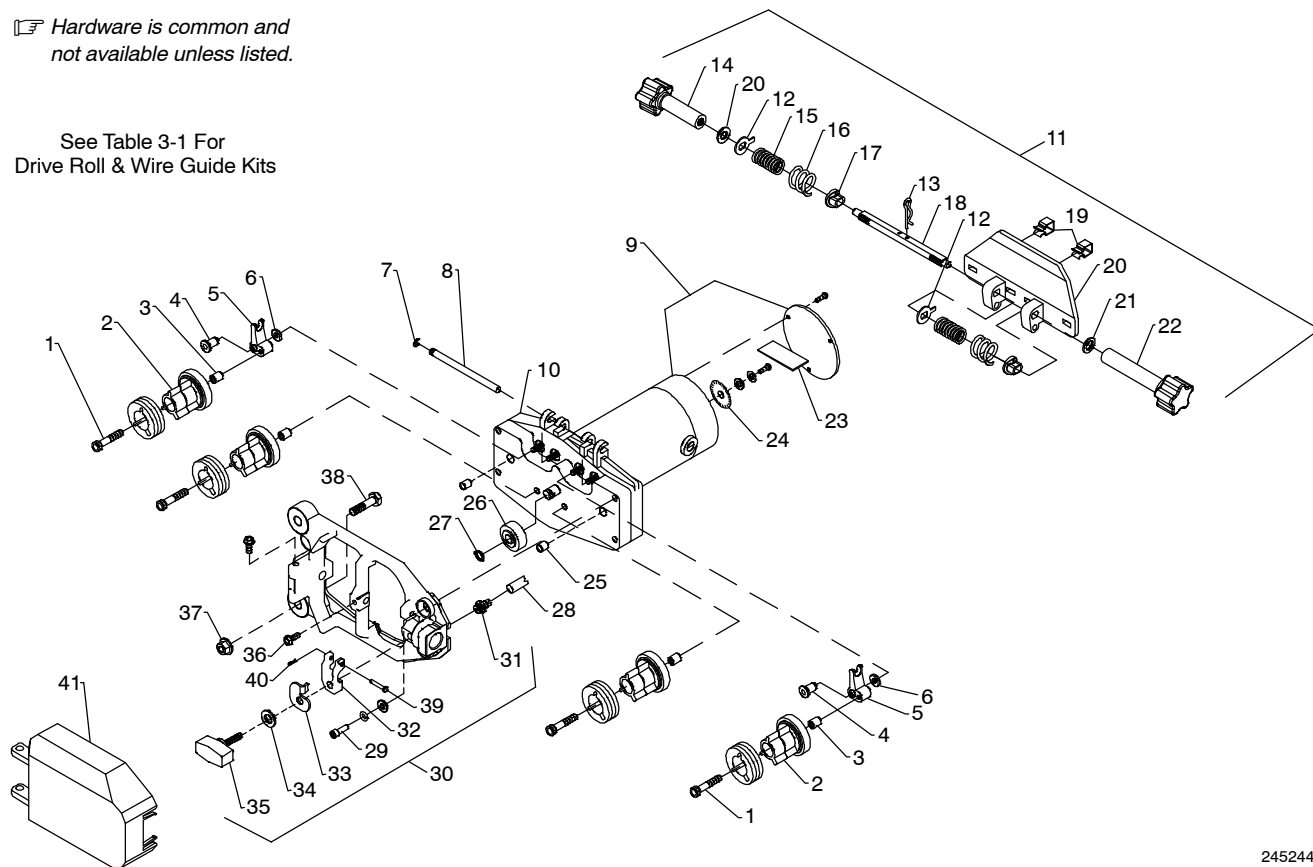
Harness Connectors/Receptacles

..... PLG6,106	115094	..	Housing Plug+Skts, (Service Kit)	1
..... PLG10,110 ..	130203	..	Housing Plug+Skts, (Service Kit)	1
..... PLG72	115092	..	Housing Plug+Skts, (Service Kit)	1
..... PLG4,104 ...	136810	..	Housing Plug+Skts, (Service Kit)	1
.... PLG11, 21,71,111	131055	..	Housing Rcpt+Skts, (Service Kit)	1
.. PLG1,77,78,79,101	202592	..	Housing Plug+Skts, (Service Kit)	1
.... PLG3,75,76,103	115093	..	Housing Plug+Skts, (Service Kit)	1
..... PLG51	174824	..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG7,27,67,107	115091	..	Housing Plug+Skts, (Service Kit)	1
..... PLG73	148439	..	Housing Plug Pins+Skts, (Service Kit)	1
..... PLG17,70 ...	158719	..	Housing Plug+Skts, (Service Kit)	1
..... PLG117 ...	165404	..	Housing Rcpt+Skts, (Service Kit)	1

Eff w/Serial No. MH295505U And Following

 Hardware is common and not available unless listed.

See Table 3-1 For Drive Roll & Wire Guide Kits



245244-C

Figure 3-3. Drive Assembly, Wire

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 3-3. Drive Assembly, Wire (Figure 3-1 Item 4)

.....	244585	..	Drive Assy, Wire S/L 4 Roll W/Tach Accu-Mate (Items 1-38)	1
... 1	010668	..	Screw, Cap Stl Sch .250-20 X 1.500	4
... 2	172075	..	Carrier, Drive Roll W/Components	4
... 3	149962	..	Spacer, Carrier Drive Roll	4
... 4	149486	..	Pin, Rotation Arm Rocker	2
... 5	244584	..	Arm, Pressure LH Chamfered	2
... 6	150520	..	Spacer, Flat Stl .257 Id X .619 Od X .105	2
... 7	133493	..	Ring, Retaining Ext .250 Shaft X .025Thk	1
... 8	133350	..	Pin, Hinge	1
... 9 ... M101	201230	..	Motor, Gear 1/8HP 24VDC Standard Speed	1
.....	153491		Kit, Brush Replacement (Includes)	1
.....	153492		Cap, Brush	2
.....	*153493		Brush, Carbon	2
.....	184136		Kit, Brush Holder Replacement	1
... 10	155098	..	Kit, Cover Motor Gearbox (Includes)	1
.....	153550		Cover, Motor Gearbox (Includes)	1
.....	155099		Gasket, Cover	1
.....	155100		Screw, Cover	5
.....	154031		Spacer, Locating	2
.....	133493		Ring, Rtnng Ext .250 Shaft Grv X .025Thk	1
... 11	203642	..	Pressure Arm, R & Vert L 4 Roll (Includes)	1
... 11	203631	..	Pressure Arm, S/L & Vert S/R 4 Roll (Includes)	1
... 12	203641		Washer, Flat Indicator Spring Tension	2
... 13	182415		Pin, Cotter Hair	1
... 14	203640		Knob, W/Extension Short Pressure Arm	1

Eff w/Serial No. MH295505U And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-3. Drive Assembly, Wire (Continued)				
... 15		182156	... Spring, Cprsn	2
... 16		182155	... Spring	2
... 17		132746	... Bushing, Spring	2
... 18		203633	... Shaft, Spring	1
... 19		246098	... Clip, Spring Pressure Blocking	2
... 20		203632	... Shaft Carrier	1
... 21		133739	... Washer, Flat Buna .375 Id X .625 Od X .062Thk	2
... 22		203637	... Knob, W/Extension Long Pressure Arm	1
... 23	PC151	237048	.. Circuit Card, Digital Tach (Includes)	1
... PLG5		131204	... Connector & Sockets	1
		604311	... Grommet, Rbr .250 Id X .375Mtg Hole .062 Groove	1
... 24		132611	.. Optical Encoder Disc	1
		279896	.. Weather Stripping, Adh .125 Thk 2.4375 Dia	1
... 25		167387	.. Spacer, Locating	2
... 26		168825	.. Drive, Pinion	1
... 27		133308	.. Ring, Retaining Ext .375 Shaft X .025Thk	1
... 28		134834	.. Hose, Sae .187 Id X .410 Od (Order By Ft)	2Ft (0.6 m)
... 29		108940	.. Screw, Cap Stl Hexhd .250-20 X .750	4
... 30		281140	.. Kit, Adapter Assy Gun/Feeder LH ACCU-MATE (Includes)	1
... 30		281141	.. Kit, Adapter Assy Gun/Feeder RH ACCU-MATE (Includes)	1
		281132	... Adapter Assy, LH (Includes)	1
		281131	... Adapter Assy, RH (Includes)	1
... 31		149959	... Fitting, Brs Barbed M 3/16Tbg X .312-24	1
... 32		278295	... Clamp, Power Pin Cast (Eff w/MH295505U)	1
... 33		242261	... Lock, Power Pin	1
... 34		231232	... Washer, Flat .344 ID X 0.688 OD X .065 T Stl Pld ANSI.312 Clr	1
... 35		151437	... Knob, Plstc T 1.125 Lg X .312-18 X 1.500	1
... 36		151290	... Screw, Mach Stl Hexwhd 10-32 X .500	2
... 37		167788	... Nut, 375-16 .56 Hex .34H Stl Pld Sem Cone WSHR.88 D	1
... 38		601966	... Screw, Cap Stl Hexhd .375-16 X 1.250	1
... 39		234073	.. Pin, Hinge (Eff w/MH295505U)	1
... 40		280558	.. Pin, Cotter Hair .047 X .625 Zinc Pld (Eff w/MH295505U)	1
... 41		179277	.. Cover, Drive Roll (Includes)	1
		275806	... Label, Warning Hot Surfaces And Moving Parts	1

*Recommended Spare Parts.

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.

	"V" GROOVE FOR HARD WIRE	"U" GROOVE FOR SOFT-SHELLED CORED WIRES	"V" KNURLED FOR HARD-SHELLED CORED WIRES	"U" COGGED FOR EXTREMELY SOFT WIRE OR SOFT – SHELLED CORED WIRES	POLISHED "U" GROOVE FOR ALUMINUM WIRES CONTAINS NYLON WIRE GUIDES
					
WIRE SIZE					
.023/.025 in. (0.6 mm)	151024				
.030 in. (0.8 mm)	151025				
.035 in. (0.9 mm)	151026		151052		265255
.040 in. (1.0 mm)	161190				
.045 in. (1.1/1.2 mm)	151027	151037*	151053	151070	265256*
.052 in. (1.3/1.4 mm)	151028	151038	151054	151071	
1/16 in. (1.6 mm)	151029	151039	151055	151072	265257
.068/.072 in. (1.8 mm)			151056		
5/64 in. (2.0 mm)		151040	151057	151073	
3/32 in. (2.4 mm)		151041	151058	151074	
7/64 in. (2.8 mm)		151042	151059	151075	
1/8 in. (3.2 mm)		151043**	151060**	151076**	
*Accommodates .045 and .047 (3/64 in) wire **Requires a low-speed wire feeder					
Nylon Wire Guides for Feeding Aluminum Wire					
Wire Sizes	Inlet Guide	Intermediate Guide	Wire Size	Inlet Guide	Intermediate Guide
.023 to .040 in. (0.6 to 1.0mm)	221030	149518	.035 in. (0.9mm)	221912	242417
.045 to .052 in. (1.1 to 1.4mm)	221030	149519	.047 in. (1.2mm)	221912	205936
1/16 to 5/64 in. (1.6 to 2mm)	221030	149520	1/16 in. (1.6mm)	221912	205937
3/32 to 7/64 in. (2.4 to 2.8mm)	229919	149521			
1/8 in. (3.2mm)	229919	149522			

Table 3-1. Drive Roll And Wire Guide Kits

Notes

Notes

Notes

Miller Electric Mfg. LLC

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters-USA

USA Phone: 920-735-4505 Auto-Attended
USA & Canada FAX: 920-735-4134
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www.MillerWelds.com

