



TM-1213Q

2017-09

Eff. w/Serial No. KC248746

Processes



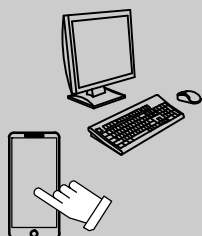
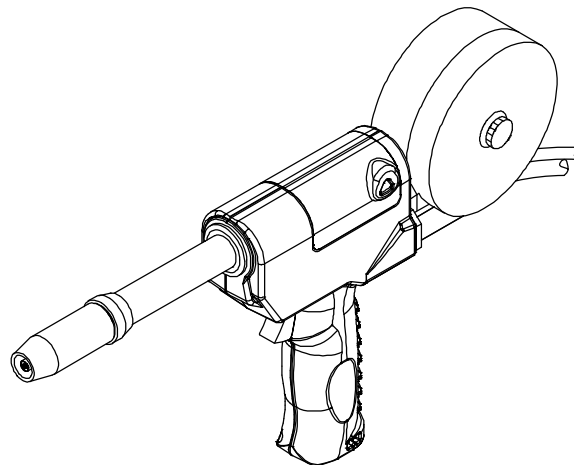
MIG (GMAW) Welding

Description



Feeder Gun

Spoolmatic[®] 15A And 30A



For product information,
Owner's Manual translations,
and more, visit
www.MillerWelds.com

TECHNICAL MANUAL

File: MIG (GMAW)



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SECTION 1 – SAFETY PRECAUTIONS FOR SERVICING

 **Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.**

1-1. Symbol Usage

OM-1213-AQ, safety_stm 2015-09



DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! **ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS** hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Servicing Hazards



The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard.



Only qualified persons should test, maintain, and repair this unit.



During servicing, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

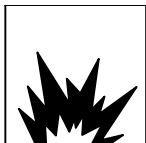
- Do not touch live electrical parts.
- Turn Off welding power source and wire feeder and disconnect and lockout input power using

line disconnect switch, circuit breakers, or by removing plug from receptacle, or stop engine before servicing unless the procedure specifically requires an energized unit.

- Insulate yourself from ground by standing or working on dry insulating mats big enough to prevent contact with the ground.
- Do not leave live unit unattended.
- If this procedure requires an energized unit, have only personnel familiar with and following standard safety practices do the job.
- When testing a live unit, use the one-hand method. Do not put both hands inside unit. Keep one hand free.
- Disconnect input power conductors from deenergized supply line **BEFORE** moving a welding power source.

SIGNIFICANT DC VOLTAGE exists in inverter welding power sources AFTER removal of input power.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Troubleshooting Section before touching any parts.

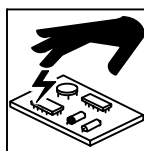


ARC FLASH can kill.

Arc flash is the rapid and violent release of energy that occurs when electric current leaves its intended path and arcs to other conductors or to ground. Arc flash can be caused by equipment failure (faulty insulation,

corrosion, dust) improper installation, human error (improper tool placement), and other factors. Conductive vapors can sustain the arc until over-current devices open the circuit. Individuals within the arc flash boundary are at risk.

- Do not work on energized equipment unless an assessment of arc flash risk from the electrical supply circuit has been conducted by a qualified person and you have been trained in safe work practices by your employer.
- Follow requirements in NFPA 70E for safe work practices and Personal Protective Equipment (PPE).



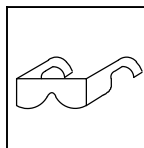
STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap **BEFORE** handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



FIRE OR EXPLOSION hazard.

- Do not place unit on, over, or near combustible surfaces.
- Do not service unit near flammables.



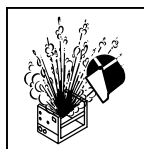
FLYING METAL or DIRT can injure eyes.

- Wear safety glasses with side shields or face shield during servicing.
- Be careful not to short metal tools, parts, or wires together during testing and servicing.



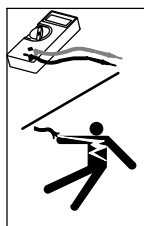
HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



EXPLODING PARTS can injure.

- Failed parts can explode or cause other parts to explode when power is applied to inverters.
- Always wear a face shield and long sleeves when servicing inverters.



SHOCK HAZARD from testing.

- Turn Off welding power source and wire feeder or stop engine before making or changing meter lead connections.
- Use at least one meter lead that has a self-retaining spring clip such as an alligator clip.
- Read instructions for test equipment.



FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment.



MOVING PARTS can injure.

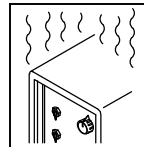


- Keep away from moving parts such as fans.
- Keep away from pinch points such as drive rolls.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Keep hands, hair, loose clothing, and tools away from moving parts.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before re-connecting input power.



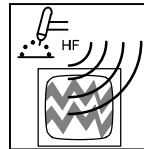
ELECTRIC AND MAGNETIC FIELDS (EMF) can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away from servicing areas until consulting their doctor and the device manufacturer.



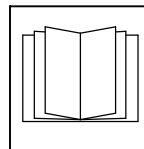
OVERUSE can cause OVERHEATING.

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment install, test, and service H.F. producing units.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



READ INSTRUCTIONS.

- Use Testing Booklet (Part No. 150 853) when servicing this unit.
- Consult the Owner's Manual for welding safety precautions.
- Use only genuine replacement parts from the manufacturer.
- Read and follow all labels and the Technical Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Perform installation, maintenance, and service according to the Technical Manual, industry standards, and national, state, and local codes.

1-3. California Proposition 65 Warnings



Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)



This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. *Wash hands after use.*

1-4. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). The current from arc welding (and allied processes including spot welding, gouging, plasma arc cutting, and induction heating operations) creates an EMF field around the welding circuit. EMF fields can interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passers-by or conduct individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.

3. Do not coil or drape cables around your body.
4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

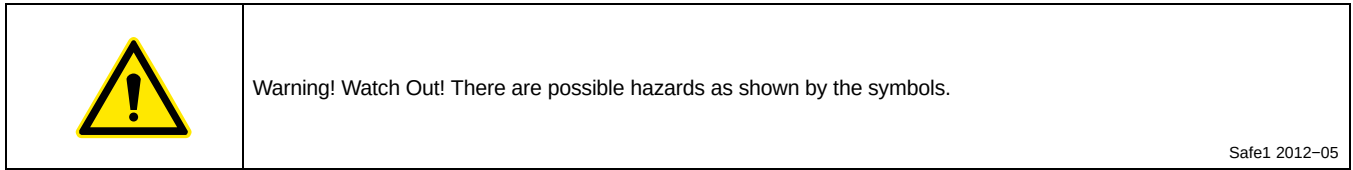
About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – DEFINITIONS

2-1. Additional Safety Symbols And Definitions

 Some symbols are found only on CE products.



	Warning! Watch Out! There are possible hazards as shown by the symbols.	Safe1 2012-05
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	Warning! Watch Out! There are possible hazards as shown by the symbols.	Safe1 2012-05
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2-2. Miscellaneous Symbols And Definitions

 Some symbols are found only on CE products.

A	Amperes
X	Duty Cycle
U₁	Primary Voltage

V	Volts
I₂	Rated Welding Current
U₂	Conventional Load Voltage

IP	Degree Of Protection
%	Percent
I₁	Primary Current

Notes

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

SECTION 3 – SPECIFICATIONS

3-1. Unit Specifications

Wire Diameter Range	Approximate Wire Feed Range	Cooling Method	Maximum Spool Size	Weld Circuit Rating	Overall Dimensions	Weight
.025 Thru 1/16 in. (0.6 Thru 1.6 mm) Aluminum Wire .025 Thru .045 in. (0.6 Thru 1.1 mm) Hard Or Cored Wire	70 To 875 ipm (1.7 To 22.2 mpm)	Air Cooled	4 in. (102 mm) Diameter	100 Volts, 200 Amperes, 100% Duty Cycle Using Argon Shielding Gas	Length: 15-3/8 in. (390 mm) Width: 2-1/2 in. (64 mm) Height: 10-3/4 in. (273 mm)	2.9 lb (1.3 kg) Gun Only 15A Model: 9 lb (4.1 kg) Gun With Cable 30A Model: 14 lb (6.4 kg) Gun With Cable

3-2. Environmental Specifications

A. IP Rating

IP Rating
IP23 This equipment is designed for outdoor use.

IP23 2017-02

B. Temperature Specifications

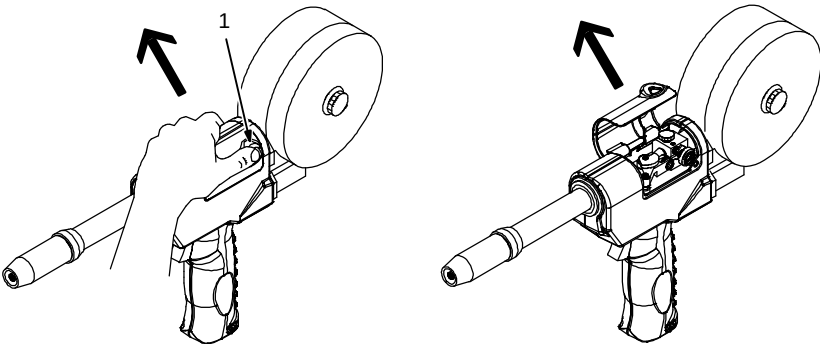
Operating Temperature Range*	Storage/Transportation Temperature Range
14 to 104°F (-10 to 40°C)	-4 to 131°F (-20 to 55°C)

Temp1_2016-08

SECTION 4 – INSTALLATION

 Use weld control or welding power source Owner's Manual during gun installation. If contact tip, liner, and drive roll groove are not correct for wire size and type, see Section 8 to change parts as needed. See Parts List for other available contact tips.

4-1. Removing Top Cover



1 Top Cover Triangular Boss

Push up on triangular boss to open door. Door hinges on handle.

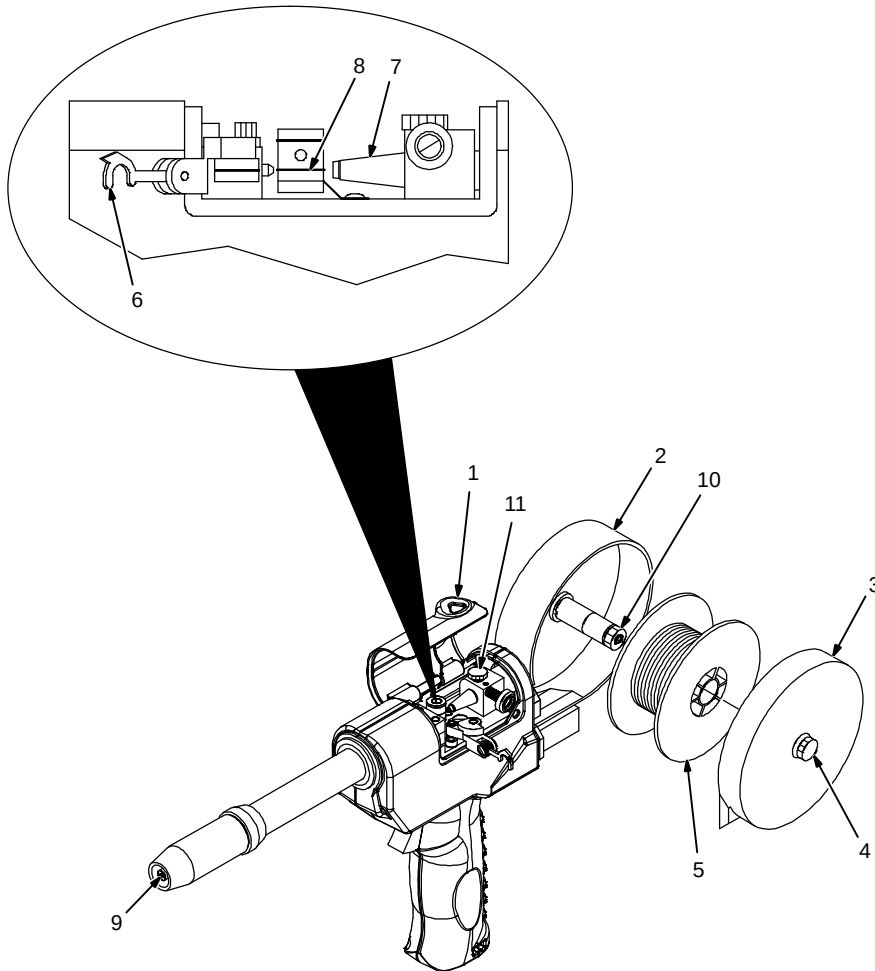
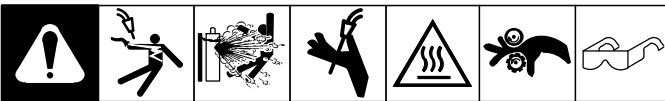
To open door fully, push up on door until it clicks into position.

 If door is pushed too far it will separate from handle. If this happens the door can be reinstalled.

Push door back into original position to close.

150 882-G

4-2. Installing Wire Spool And Threading Welding Wire



- 1 Top Cover
- 2 Canister
- 3 Canister Cover
- 4 Thumbscrew (Canister Cover)

Loosen thumbscrew and remove cover.

- 5 Wire Spool

Loosen wire from spool, cut off bent wire, and pull 6 in. (150 mm) of wire off spool.

- 6 Pressure Roll Assembly

Lift arm and open pressure roll assembly.

- 7 Canister Inlet Guide

- 8 Drive Roll Groove

For wire sizes .035 in. (0.9 mm) and smaller use small groove, and .047 in. (1.2 mm) and 1/16 in (1.6 mm) use large groove.

- 9 Contact Tip

Thread wire through canister inlet guide, along drive roll groove, and out contact tip.

Install spool so wire feeds off bottom.

- 10 Spool Brake Thumbnut

If necessary, turn thumbnut counterclockwise slightly to install spool.

- 11 Thumbscrew (Canister Rotation)

Loosen thumbscrew to rotate canister (see Section 4-3).

Close and secure pressure roll assembly.

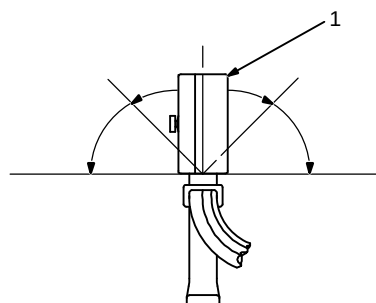
Reinstall top cover and canister cover.

Tools Needed:



150 436-F

4-3. Rotating Canister



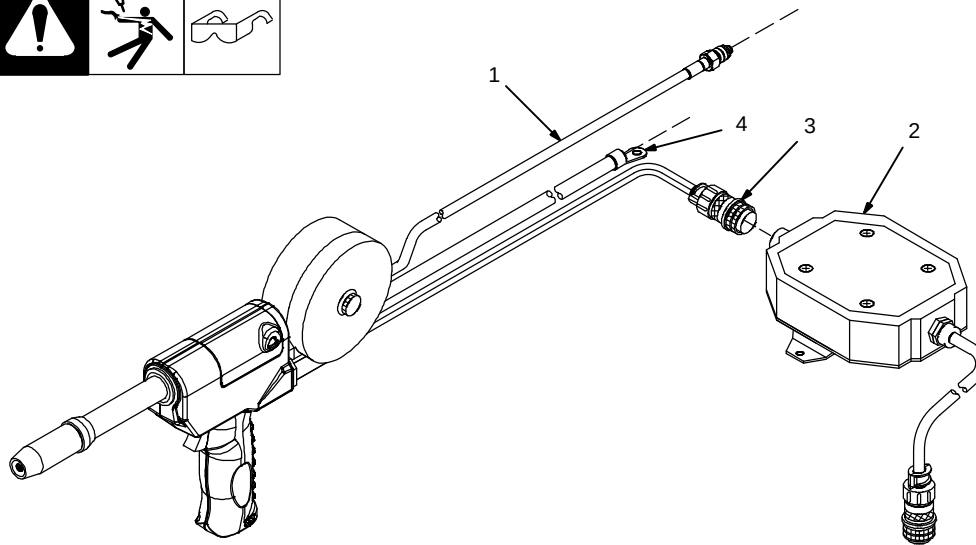
Rear View

- 1 Canister

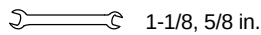
Loosen canister rotation thumbscrew (see Section 4-2). Move canister to desired position. Tighten thumbscrew.

150 433-A

4-4. Connecting To 24 Volt Weld Control



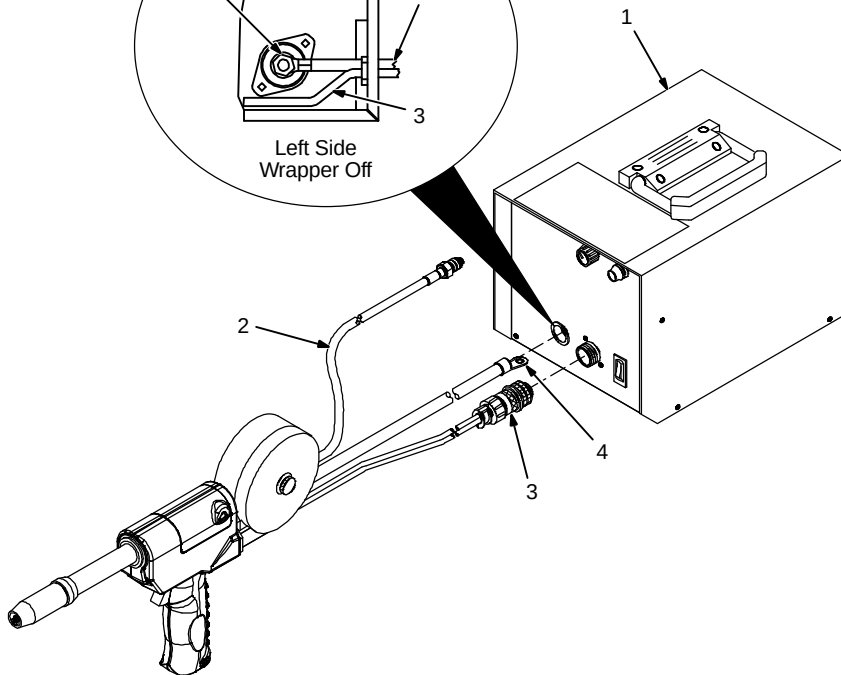
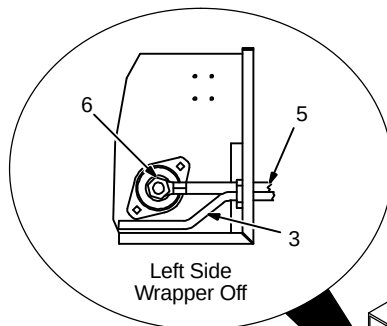
Tools Needed:



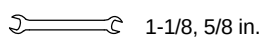
- 1 Gas Hose
Connect fitting to regulator/flowmeter (see Section 4-6).
- 2 24 Volt Weld Control
- 3 Trigger Control Cord
Insert plug into receptacle, and tighten threaded collar.
- 4 Weld Cable
Connect to positive (+) weld output terminal on welding power source according to its Owner's Manual.

150 917-G

4-5. Connecting To 115 Volt Weld Control



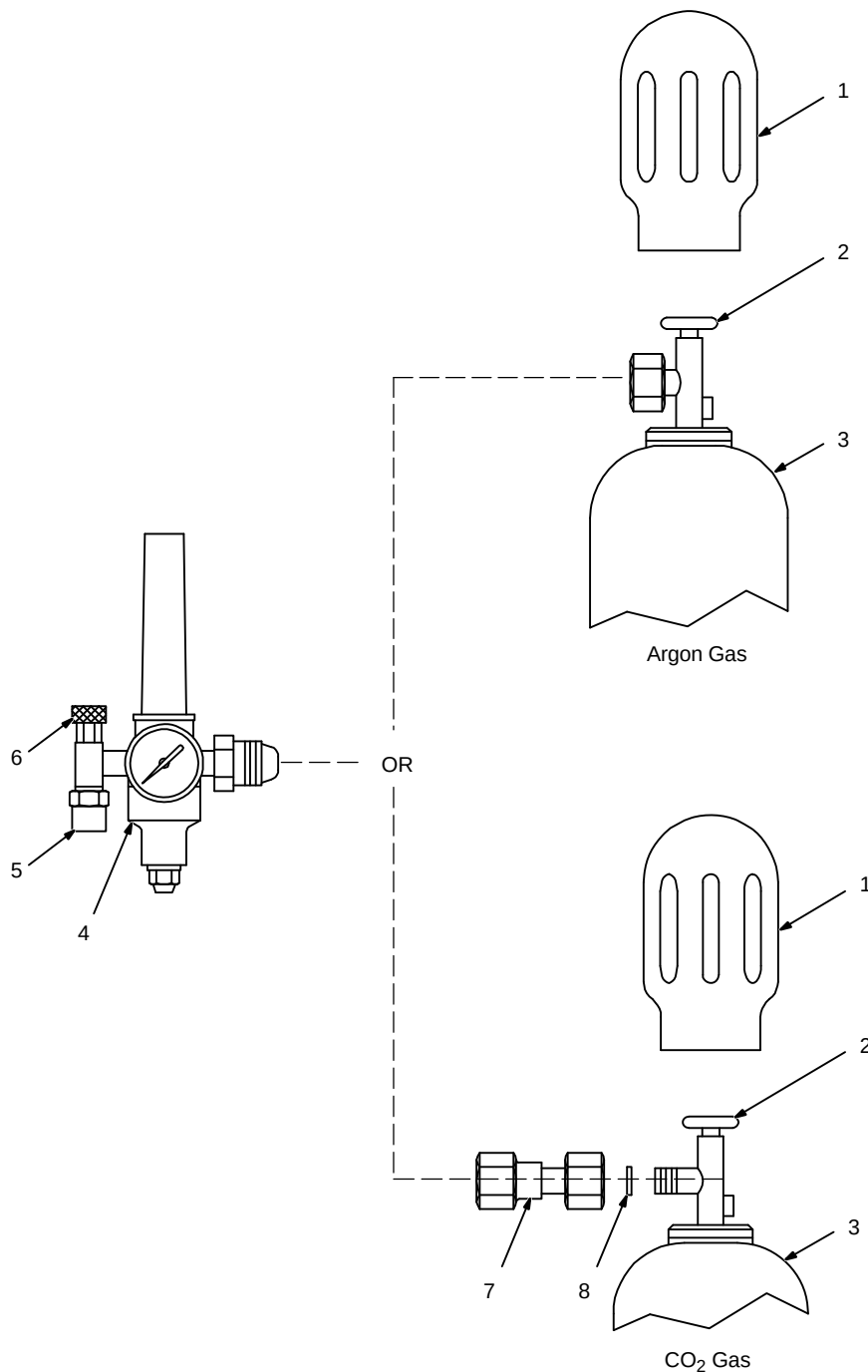
Tools Needed:



- 1 115 Volt Weld Control
- 2 Gas Hose
Connect to regulator/flowmeter.
- 3 Trigger Control Cord
Insert plug into receptacle, and tighten threaded collar.
- 4 Weld Cable
Connect weld cable to positive (+) weld output terminal in weld control. Reinstall weld control wrapper.
- 5 Positive (+) Weld Output Terminal In Control

Ref. 149 549-A / 149 966-J

4-6. Installing Gas Supply



Obtain gas cylinder and chain to running gear, wall, or other stationary support so cylinder cannot fall and break off valve.

- 1 Cap
- 2 Cylinder Valve

Remove cap, stand to side of valve, and open valve slightly. Gas flow blows dust and dirt from valve. Close valve.

- 3 Cylinder
 - 4 Regulator/Flowmeter
- Install so face is vertical.

Delivery pressure range must not exceed 60 psi.

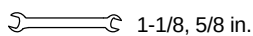
- 5 Gas Hose Connection
- Fitting has 5/8-18 right-hand threads.

- 6 Flow Adjust
- Typical flow rate is 20 cfh (cubic feet per hour). Check wire manufacturer's recommended flow rate.

Make sure flow adjust is closed when opening cylinder to avoid damage to the flowmeter.

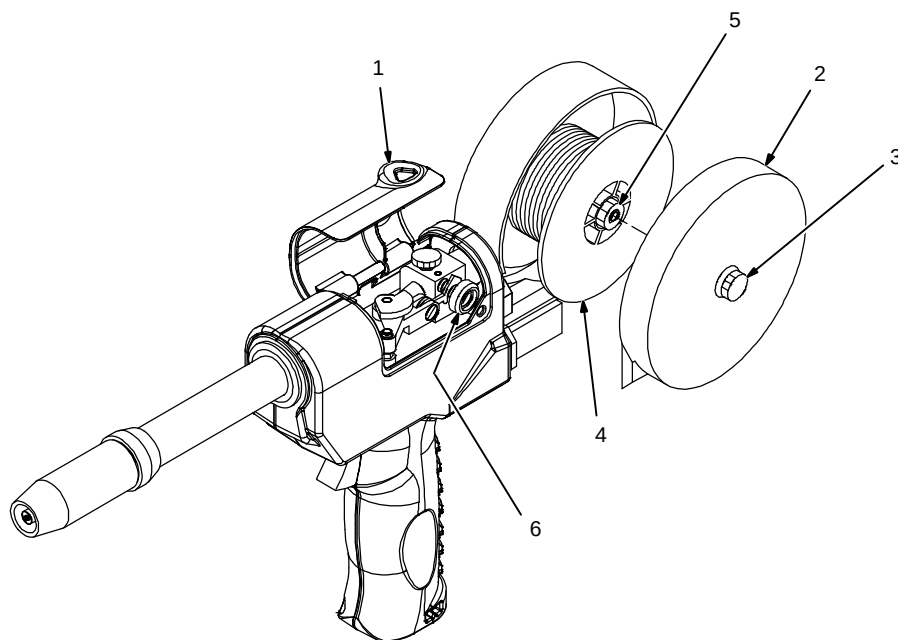
- 7 CO₂ Adapter
 - 8 O-Ring
- Install adapter with O-ring between regulator/flowmeter and CO₂ cylinder.

Tools Needed:



ssb3.1* 5/94 - 158 697-A

4-7. Adjusting Drive Roll And Spool Brake Pressure



- 1 Top Cover
- 2 Canister Cover
- 3 Thumbscrew

Loosen thumbscrew and remove cover.

- 4 Spool

Cut welding wire off at contact tip. Retract wire onto spool and secure.

- 5 Spool Brake Thumbnut

Grasp spool in one hand and turn while adjusting spool brake thumbnut. When a slight force is needed to turn spool, tension is set. Do not overtighten.

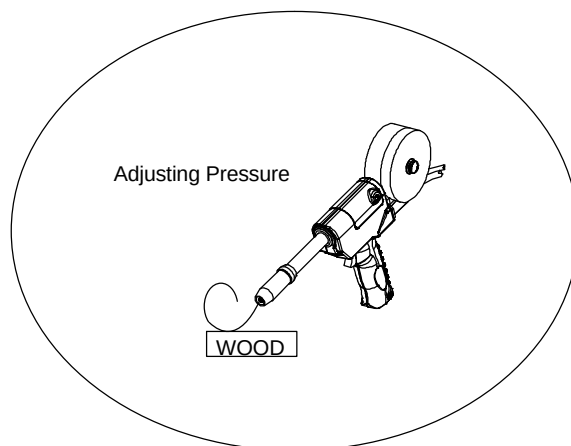
Reinstall canister cover. Thread welding wire (see Section 4-2).

- 6 Drive Roll Tension Thumbnut

Turn On unit and check drive roll pressure by feeding wire against a wood board or concrete surface; wire should feed steadily without slipping.

Adjust drive roll tension thumbnut if necessary. Do not overtighten.

Turn Off unit. Reinstall top cover.



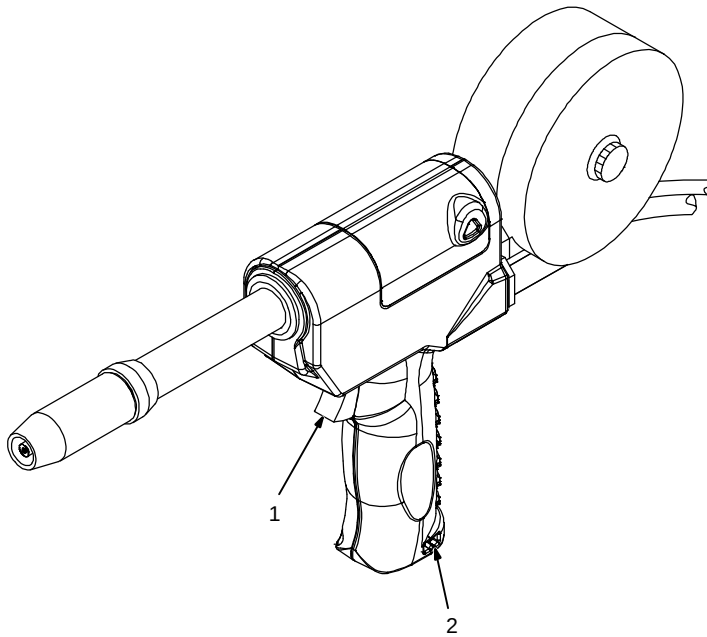
Tools Needed:



Ref. 151 112-F / 147 741-F

SECTION 5 – OPERATION

5-1. Controls



1 Trigger

Press trigger to energize welding power source contactor (if applicable), start shielding gas flow, and begin wire feed.

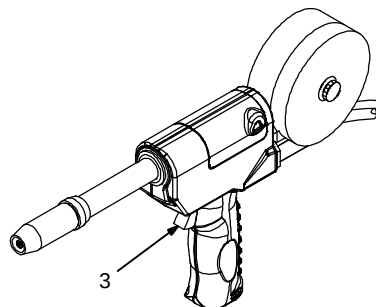
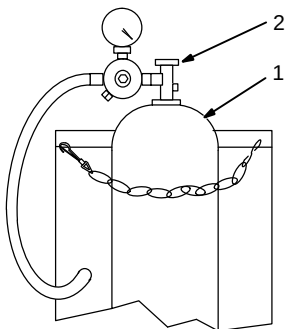
For shielding gas preflow and post-flow, lightly press trigger before and after welding.

2 Wire Speed Control

Use control to adjust wire feed speed. The numbers in the opening are not a wire feed speed and are for reference only.

Ref. 147 741-F

5-2. Shielding Gas



1 Shielding Gas Cylinder

2 Valve

3 Gun Trigger

Open valve on cylinder just before welding.

Gun trigger turns weld output and gas flow on and off. For shielding gas preflow and postflow, lightly press trigger before and after welding.

Close valve on cylinder when finished welding.

sb5.1* 6/92 – S-0621-C / Ref. 147 741-F

SECTION 6 – THEORY OF OPERATION

1 Gun Assembly

Connects to welding power source or weld control, and provides weld power to energized wire.

2 Trigger PB1

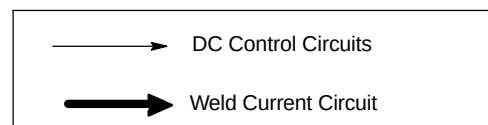
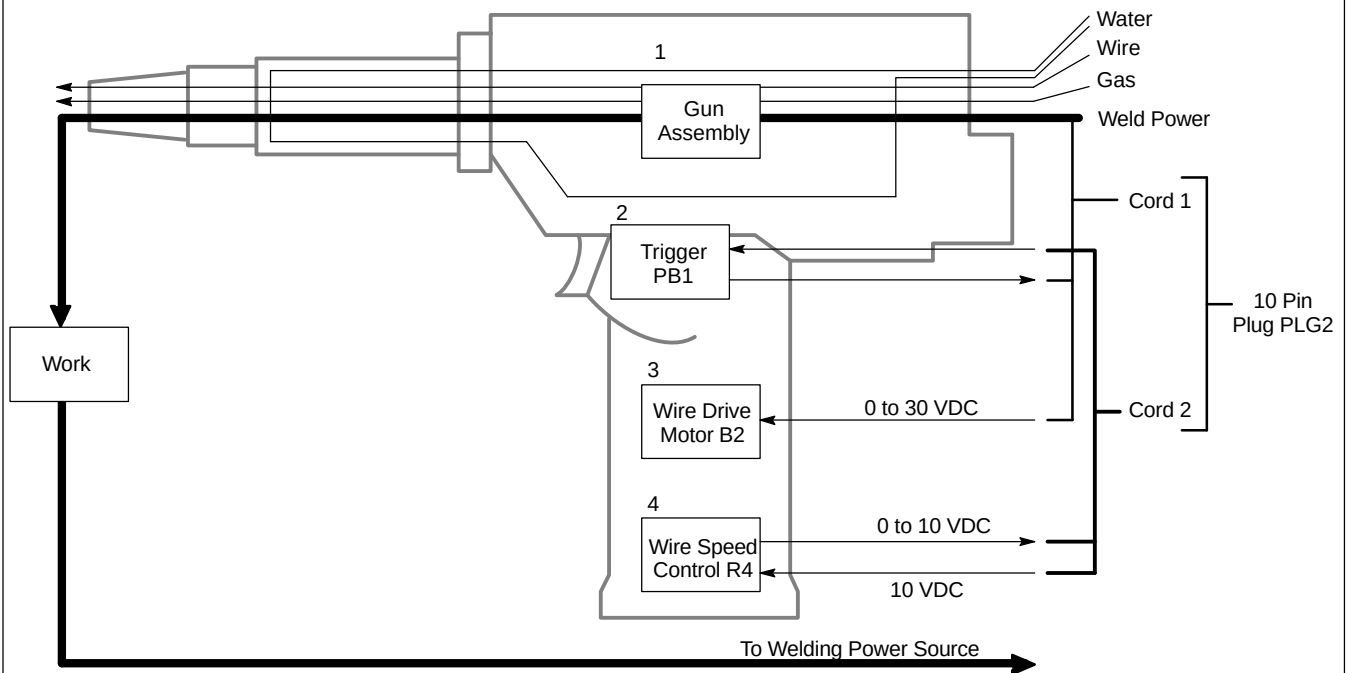
Provides contactor control of welding power source, starts shielding gas flow, starts wire feed.

3 Wire Drive Motor B2

Feeds wire at speed set by R4.

4 Wire Speed Control R4

Selects wire speed.



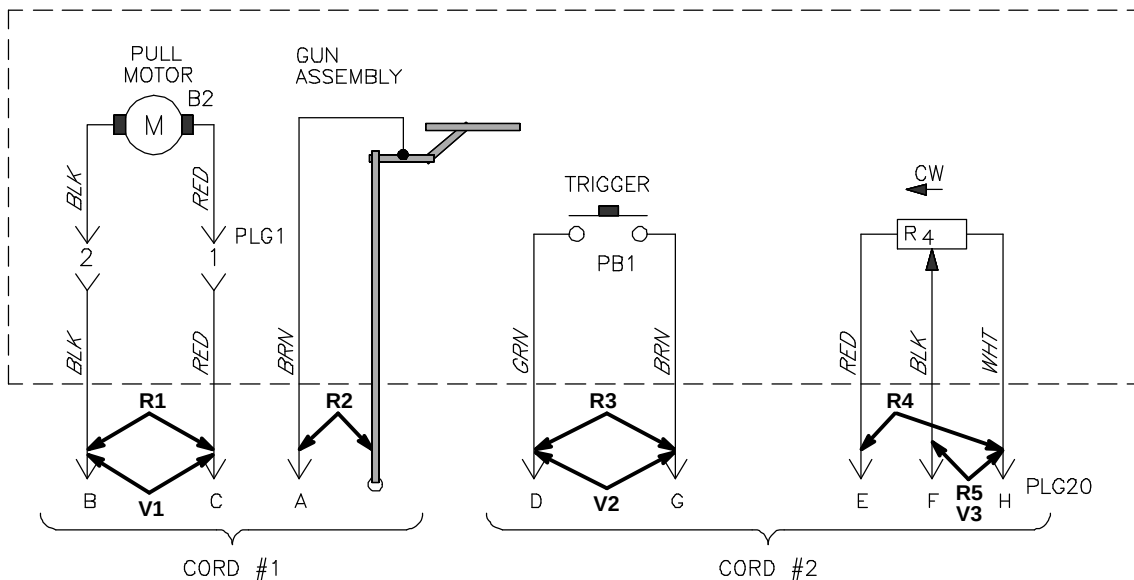
SECTION 7 – TROUBLESHOOTING

7-1. Troubleshooting Table

     						 See Section 7-2 for test points and values and Parts Sections for parts location.  Use MILLER Testing Booklet (Part No. 150 853) when servicing this unit.  See the Miller Extranet for service memos that may aid in the repair of this product.					
Trouble			Remedy								
Motor does not run; pressing gun trigger does not energize weld control/ welding power source.			Check connection of 10 pin plug PLG2 to weld control or welding power source. Repair if necessary (see Sections 4-4 and 4-5).								
			Check continuity of gun trigger switch and leads. Repair or replace if necessary (see Section 7-2).								
			Check control cords for continuity. Repair or replace if necessary (see Section 7-2).								
			Readjust drive roll pressure (see Section 4-7).								
			See Troubleshooting Section in weld control and/or welding power source Technical Manual.								
Wire feeds; welding wire is not energized.			Check switch positions on welding power source.								
			Check connection of 10 pin plug PLG2 to weld control. Repair if necessary (see Sections 4-4 and 4-5).								
			Check control cords for continuity. Repair or replace if necessary (see Section 7-2).								
			See Troubleshooting Section in weld control and/or welding power source Technical Manual.								
Wire does feed but is energized.			Check motor B2. Replace if necessary (see Section 7-2).								
			Check control cords for continuity. Repair or replace if necessary (see Section 7-2).								
			See Troubleshooting Section in weld control and/or welding power source Technical Manual.								
Wire feeds erratically and/or no control of wire speed by Wire Speed Control R4.			Change to correct size contact tip or liner (see Section 8-2).								
			Clear obstruction in contact tip or liner (see Section 8-2).								
			Readjust drive roll pressure (see Section 4-7).								
			Change to correct size drive roll (see Section 8-5 or 8-7).								
			Clean or replace dirty or worn drive roll (see Section 8-5 or 8-7).								
			Readjust spool brake pressure (see Section 4-7).								
			Check resistance and connections of Wire Speed control R4; R4 is 0 to 10,000 ohms $\pm 10\%$. Replace R4 if necessary (see Section 7-2).								
			Check resistance and connections of Wire Speed control R4; R4 is 0 to 10,000 ohms $\pm 10\%$. Replace R4 if necessary (see Section 7-2).								
			Check motor B2. Replace if necessary (see Section 7-2).								
			Check control cords for continuity. Repair or replace if necessary (see Section 7-2).								
			See Troubleshooting Section in weld control and/or welding power source Technical Manual.								
Erratic weld output.			Replace worn or damaged contact tip (see Section 8-2).								
			Repair loose or incorrect welding connections.								
			Check control cords for continuity. Repair or replace if necessary (see Section 7-2).								
			See Troubleshooting Section in weld control and/or welding power source Technical Manual.								

Trouble	Remedy
Wire feeds but burns back into contact tip.	Readjust voltage setting on welding power source.
	Repair ground cable connection.
	Readjust burnback time on weld control (see weld control Owner's Manual).
	Replace worn or damaged contact tip (see Section 8-2).
	Clean or replace current pickup tab [(located between bottom of drive roll and the gun housing) see Section 8-5 or 8-7].
	Readjust wire speed ramp up setting (see weld control Owner's Manual).
No gas flow.	Turn on gas cylinder.
	Check and repair or replace valve cap.
	Repair gas hose.
Continuous gas flow.	Reduce regulator pressure to below 50 PSI.
	Check and repair or replace valve cap.
	Check and repair or replace misaligned or missing spring.
	Check orifice in gun housing. Replace if necessary.

7-2. Troubleshooting Circuit Diagram For Spoolmatic 15A And 30A Guns



Voltage Readings: a) 10-pin plug PLG2 CONNECTED b) power applied c) Tolerance $\pm 10\%$ unless specified.

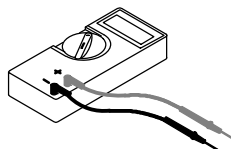
For Gun Using WC-24 Or Welding Power Source With Remote 10 Option		For Gun Using WC-115		For Gun Using XR Feeder	
V1	2 volts DC input, motor running, R4 totally CCW 30 volts DC input, motor running, R4 totally CW	V1	2 volts DC input, motor running, R4 totally CCW 30 volts DC input, motor running, R4 totally CW	V1	2 volts DC input, motor running, R4 totally CCW 30 volts DC input, motor running, R4 totally CW
V2	15 volts DC 0 volts DC with trigger pressed	V2	28 volts DC ($\pm 4V$) 0 volts DC with trigger pressed	V2	32 volts DC ($\pm 4V$) 0 volts DC with trigger pressed
V3	0 volts DC, R4 totally CCW 7.5 volts DC, R4 totally CW	V3	0 volts DC, R4 totally CCW, WC115 in Constant Speed Mode 6.8 volts DC, R4 totally CW, WC115 in Constant Speed Mode	V3	0 volts DC, R4 totally CCW 9 volts DC, R4 totally CW

Voltage Readings And Resistance Values:

- a) 10-pin plug PLG2 CONNECTED
b) Tolerance $\pm 10\%$ unless specified

V1	0.5 to 2.5 volts DC while slowly rotating motor by hand (use drive roll)
R1	10 to 100 ohms
R2	0 ohms
R3	0 ohms with trigger pressed
R4	10k ohms
R5	0 ohms totally CCW 10k ohms totally CW

Test Equipment Needed:



195712-B

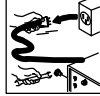
SECTION 8 – MAINTENANCE

8-1. Routine Maintenance



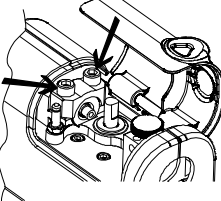
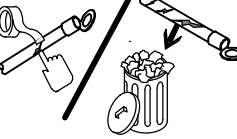
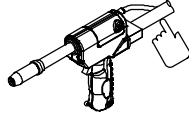
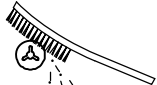
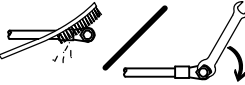
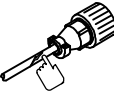
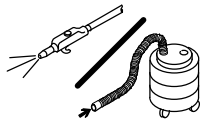




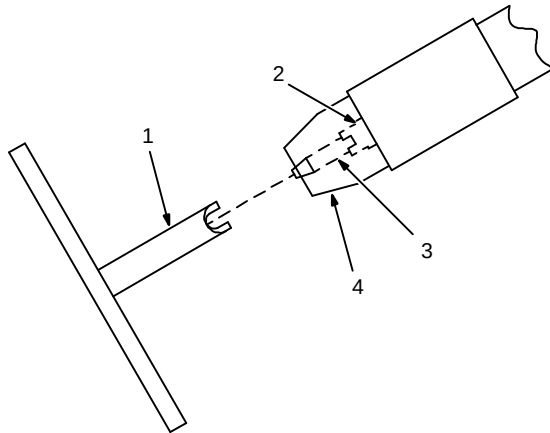



Disconnect power before maintaining.

 *Maintain more often during severe conditions.*

	✓ = Check ◇ = Change ● = Clean ☆ = Replace * To be done by Factory Authorized Service Agent				
Daily	 ✓ Check barrel clamp screws for tightness.	 ☆ Repair Or Replace Cracked Weld Cable			
Every Month	 ✓☆ Gun Cables	 ● Drive Rolls	 ● Clean and Tighten Weld Terminals		
Every 3 Months	 ☆ Damaged Or Unreadable Labels	 ☆ Damaged Gas Hose	 ✓☆ Cords		
Every 6 Months	 ● Blow out or Vacuum Inside Unit				

8-2. Changing Contact Tip And Liner (Effective With Serial No. KC248746 Thru LC478841)



Tools Needed:



Remove top cover and open pressure roll assembly.

1 Contact Tip Wrench

Insert wrench into nozzle over contact tip.

2 Compression Nut

Loosen nut. Pull out contact tip.

3 Contact Tip

4 Nozzle

Pull wire out nozzle and liner should slide out. If necessary, tilt nozzle down to remove liner.

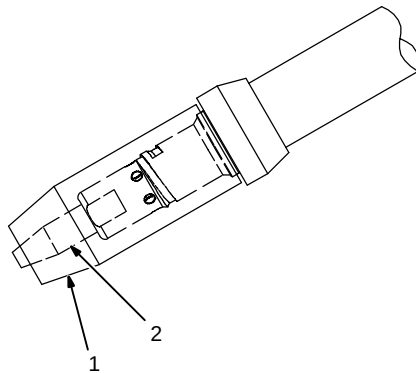
Close pressure roll assembly. Reinstall top cover.

Install new liner and contact tip over wire. Cut off wire at end of contact tip.

Tighten nut just until contact tip is secure. Overtightening nut will damage adapter.

150 437

8-3. Changing Gun Contact Tip (Effective With Serial No. LC478842 And Following)



Remove nozzle

1 Nozzle

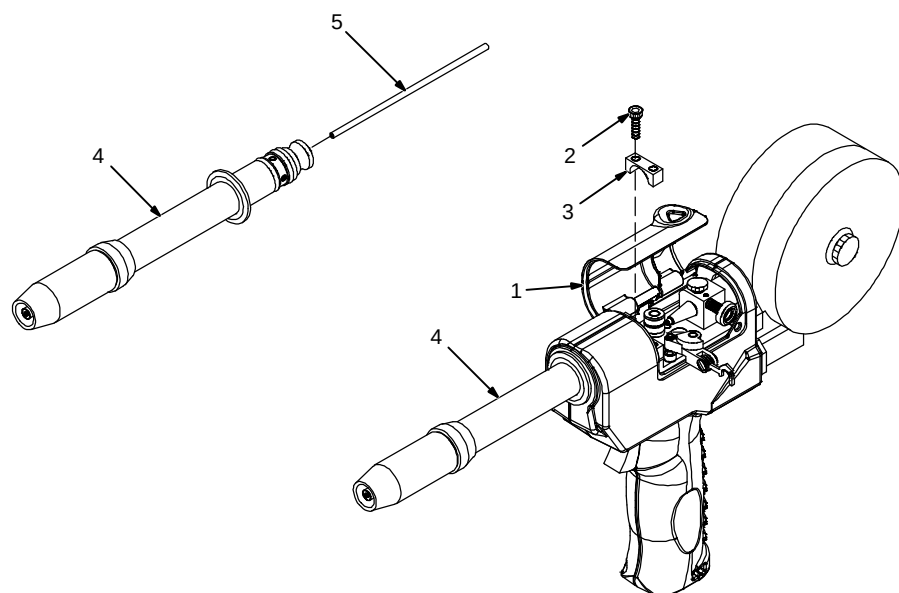
2 FasTip

Unscrew FasTip.

Install new FasTip.

Ref. 150 437-A

8-4. Replacing Head Tube Liner (Effective With Serial No. LC478842 And Following)



Tool Needed:



5/32 in.

The standard head tube liner will accommodate wire diameters from .030-1/16 wire size.

- 1 Cover
- 2 Screw
- 3 Clamp

Loosen clamp screws and remove clamp.

- 4 Head Tube

Remove head tube from gun.

- 5 Liner

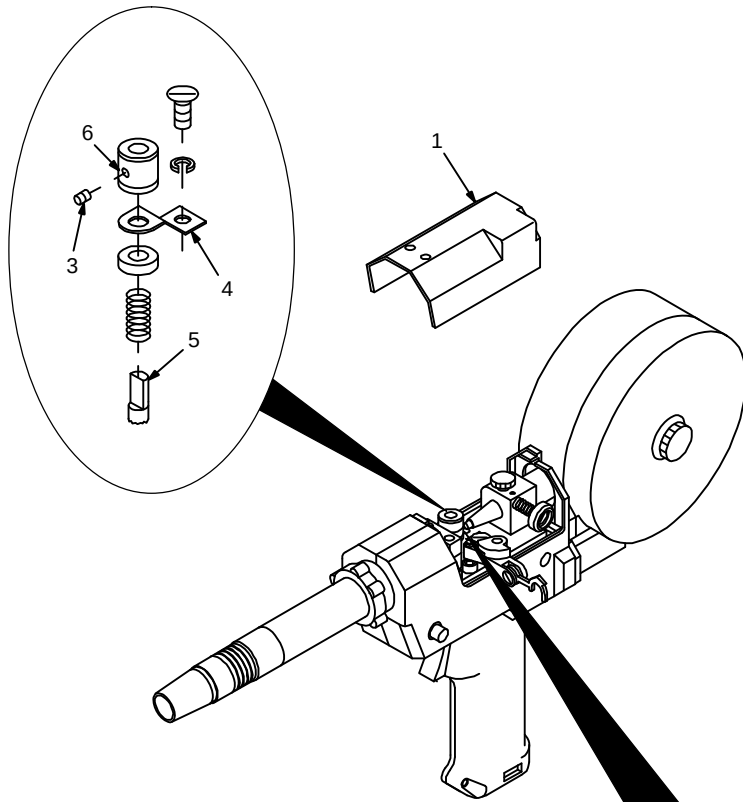
Pull liner out of head tube.

Insert liner into head tube and reinstall head tube onto gun.

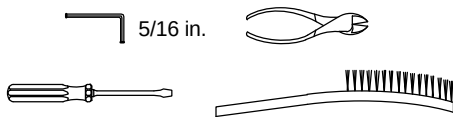
 A twisting motion may be needed to feed liner thru head tube.

Ref. 803 551-C

8-5. Changing Or Cleaning Drive Roll (Prior To Serial No. KD376404)



Tools Needed:



Turn Off weld control and welding power source.

- 1 Top Cover
- 2 Drive Roll Assembly
- 3 Setscrew
- 4 Current Pick-Up Tab

Cut off wire where it enters drive roll assembly area.

This tab helps prevent burnback caused by welding arcs inside the contact tip. This tab may be removed to provide an insulated drive roll. (If tab is removed, a smaller diameter contact tip is recommended. See options in Parts List.) Lightly grease top of tab before reinstalling.

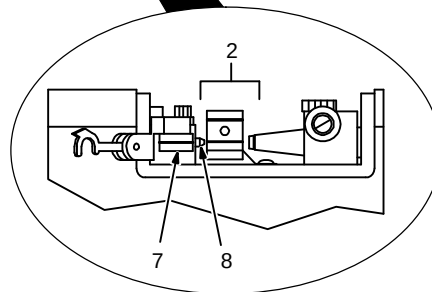
- 5 Motor Shaft
- 6 Drive Roll

Use wire brush to clean drive roll. Install drive roll with desired groove down, and turn drive roll so one setscrew faces flat side of shaft.

- 7 Bearing
- 8 Liner

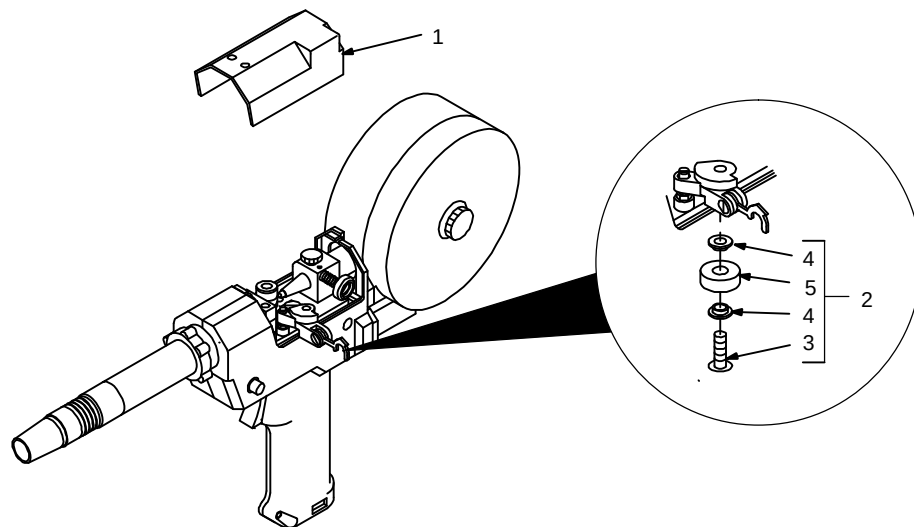
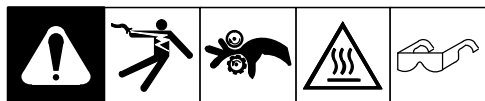
Line up drive roll groove with bearing groove and liner opening. Tighten setscrews.

Thread welding wire (see Section 4-2). Close and secure pressure roll assembly. Adjust drive roll pressure, if necessary (see Section 4-7). Reinstall top cover.



Ref. 149 967-B

8-6. Replacing Or Cleaning Drive Roll Bearing (Prior To Serial No. KG193179)



Turn Off weld control and welding power source.

- 1 Top Cover
- 2 Pressure Roll Assembly
- 3 Screw
- 4 Shoulder Washer
- 5 Drive Roll Bearing

Remove as shown.

Use a wire brush to clean bearing. Reinstall with washers, and tighten screw.

Close pressure roll assembly. Reinstall top cover.

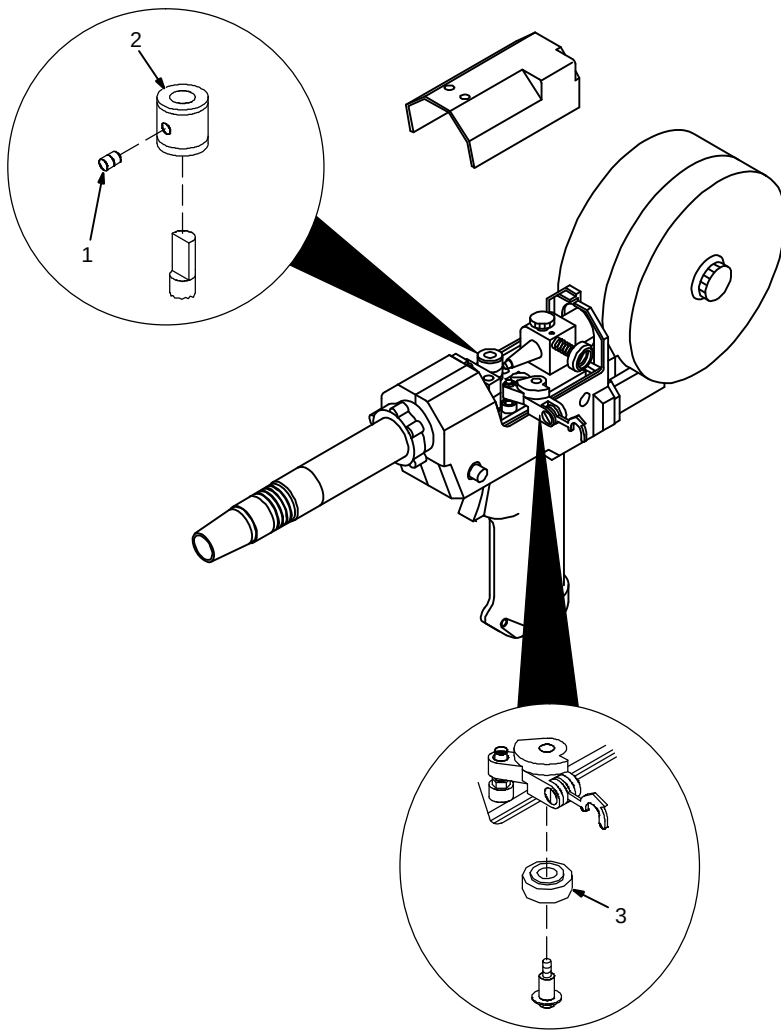
Tools Needed:



Ref. 149 967-B

Notes

8-7. Gun Drive Assembly Maintenance (Effective With Serial No. KG193179 Thru KJ260859)



Retract wire onto spool.

1 Setscrew

2 Drive Roll

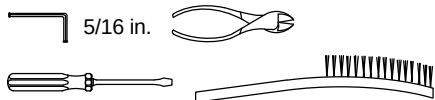
Use wire brush to clean drive roll. Install drive roll with desired groove down, and turn drive roll so one setscrew faces flat side of shaft.

3 Bearing

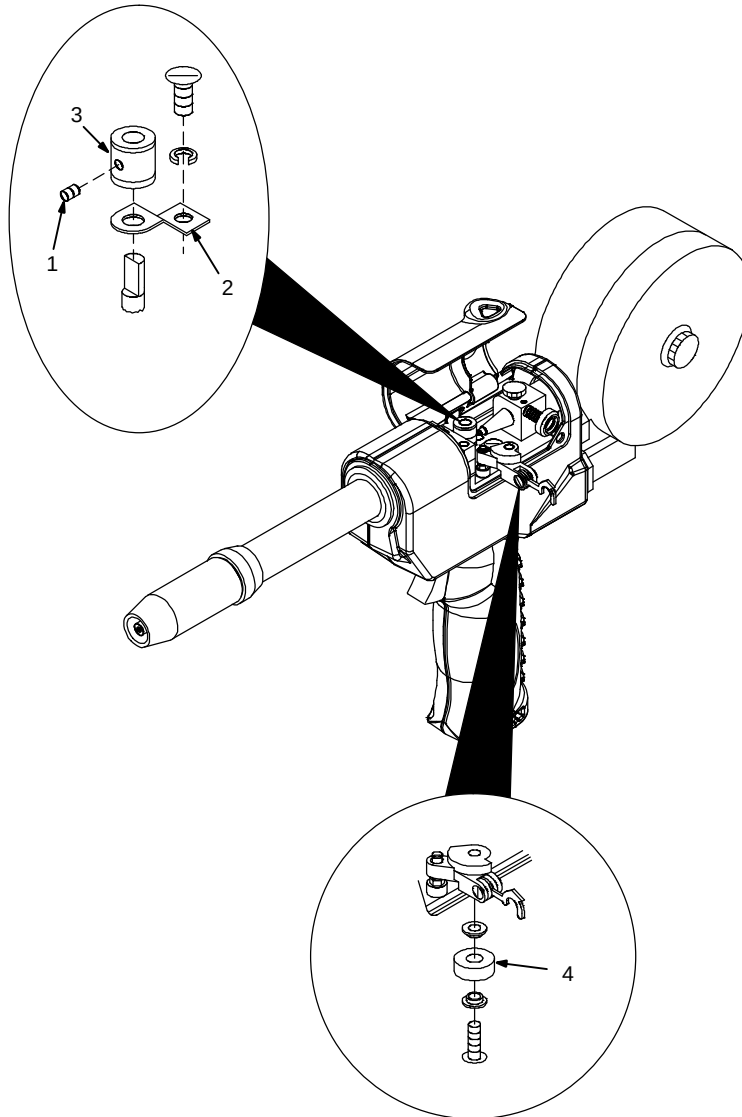
Use wire brush to clean bearing. Line up drive roll groove with bearing groove and liner opening. Tighten setscrews.

Thread welding wire through gun (see Section 4-2). Close and secure pressure roll assembly. Adjust drive roll pressure, if necessary (see Section 4-7). Reinstall top cover.

Tools Needed:



8-8. Gun Drive Assembly Maintenance (Effective With Serial No. KJ260860 And Following)



Retract wire onto spool.

- 1 Setscrew
- 2 Current Pick-Up Tab

This tab helps prevent burnback caused by welding arcs inside the contact tip. This tab may be removed to provide an insulated drive roll. (If tab is removed, a smaller diameter contact tip is recommended. See options in Parts List.) Lightly grease top of tab before reinstalling.

- 3 Drive Roll

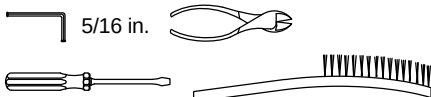
Use wire brush to clean drive roll. Install drive roll with desired groove down, and turn drive roll so one setscrew faces flat side of shaft.

- 4 Bearing

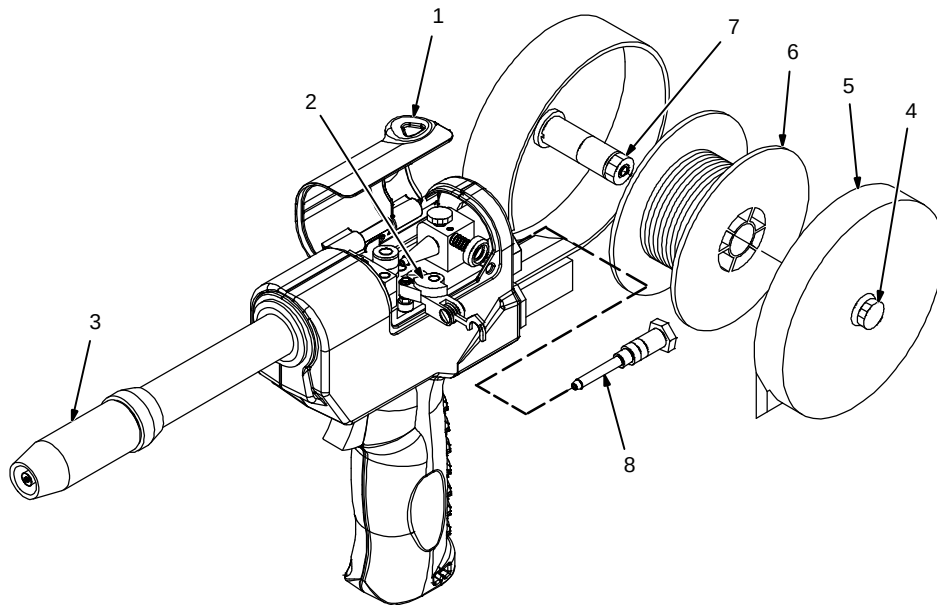
Use wire brush to clean bearing. Line up drive roll groove with bearing groove and liner opening. Tighten setscrews.

Thread welding wire through gun (see Section 4-2). Close and secure pressure roll assembly. Adjust drive roll pressure, if necessary (see Section 4-7). Reinstall top cover.

Tools Needed:



8-9. Replacing Canister Inlet Guide



- 1 Top Cover
- 2 Pressure Roll Assembly

Cut off welding wire where it enters pressure roll assembly area.

- 3 Nozzle

Pull wire out nozzle.

- 4 Thumbscrew

- 5 Canister Cover

Loosen thumbscrew and remove cover.

- 6 Wire Spool

- 7 Spool Brake Thumbnut

Loosen thumbnut, retract wire onto spool, secure, and remove spool.

- 8 Canister Inlet Guide

Turn counterclockwise to remove. Install new guide.

Reinstall spool and thread welding wire (see Section 4-2).

Close pressure roll assembly. Adjust spool brake pressure and drive roll pressure if necessary (see Section 4-7).

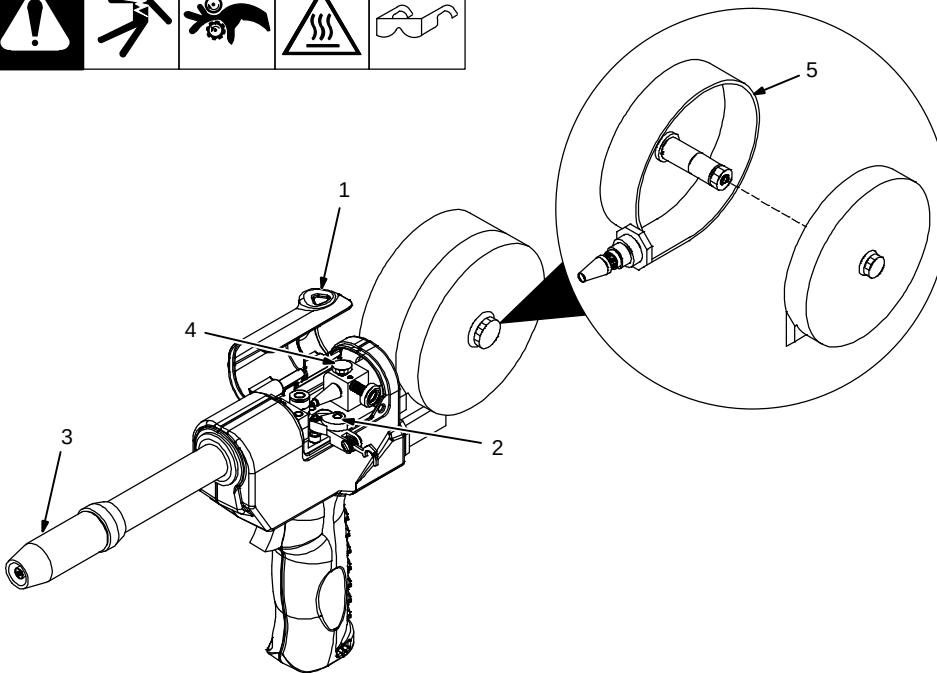
Reinstall covers.

Tools Needed:



Ref. 150 436-D / Ref. 149 967-H

8-10. Replacing Spool Canister



- 1 Top Cover
- 2 Pressure Roll Assembly

Cut off welding wire where it enters pressure roll assembly area.

- 3 Nozzle

Pull wire out nozzle.

- 4 Thumbscrew (Canister Rotation)

Turn thumbscrew counterclockwise three full turns.

- 5 Spool Canister

Remove as shown. Push new canister into wire drive housing until fully seated. Tighten thumbscrew.

Install spool and thread welding wire (see Section 4-2).

Close pressure roll assembly. Adjust spool brake pressure and drive roll pressure as necessary (see Section 4-7).

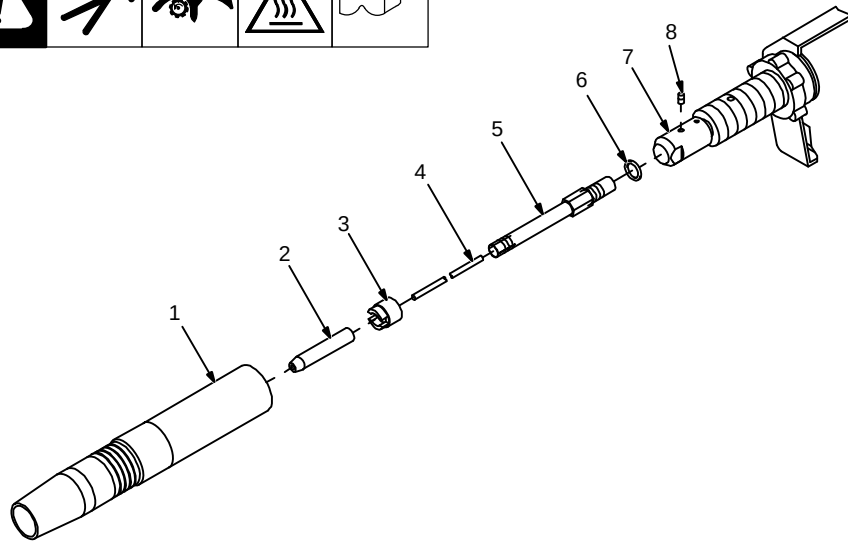
Reinstall covers.

Tools Needed:



Ref. 149 967-H

8-11. Replacing Contact Tip Adapter (Effective With Serial No. KC248746 Thru LC408323)



- 1 Barrel Extension
Remove as shown.
- 2 Contact Tip
- 3 Compression Nut
To remove, see Section 8-2.
- 4 Liner
- 5 Contact Tip Adapter
- 6 O-Ring
- 7 Head Tube
- 8 Head Tube Setscrew

Loosen setscrews and remove adapter.

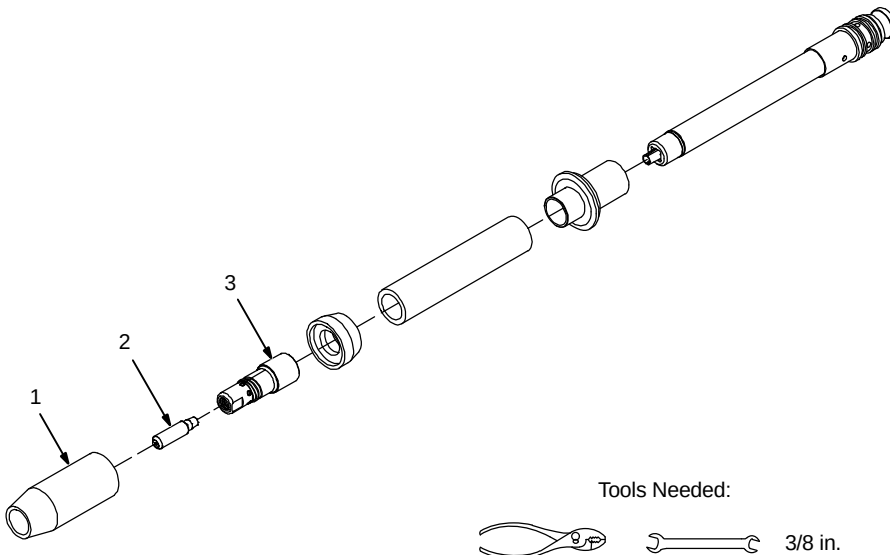
Install new o-ring and adapter, and tighten setscrews. Reinstall contact tip, compression nut, and nozzle.

Tools Needed:



150 430-B

8-12. Replacing Diffuser (Effective With Serial No. LC478842 And Following)



Turn Off welding power source.

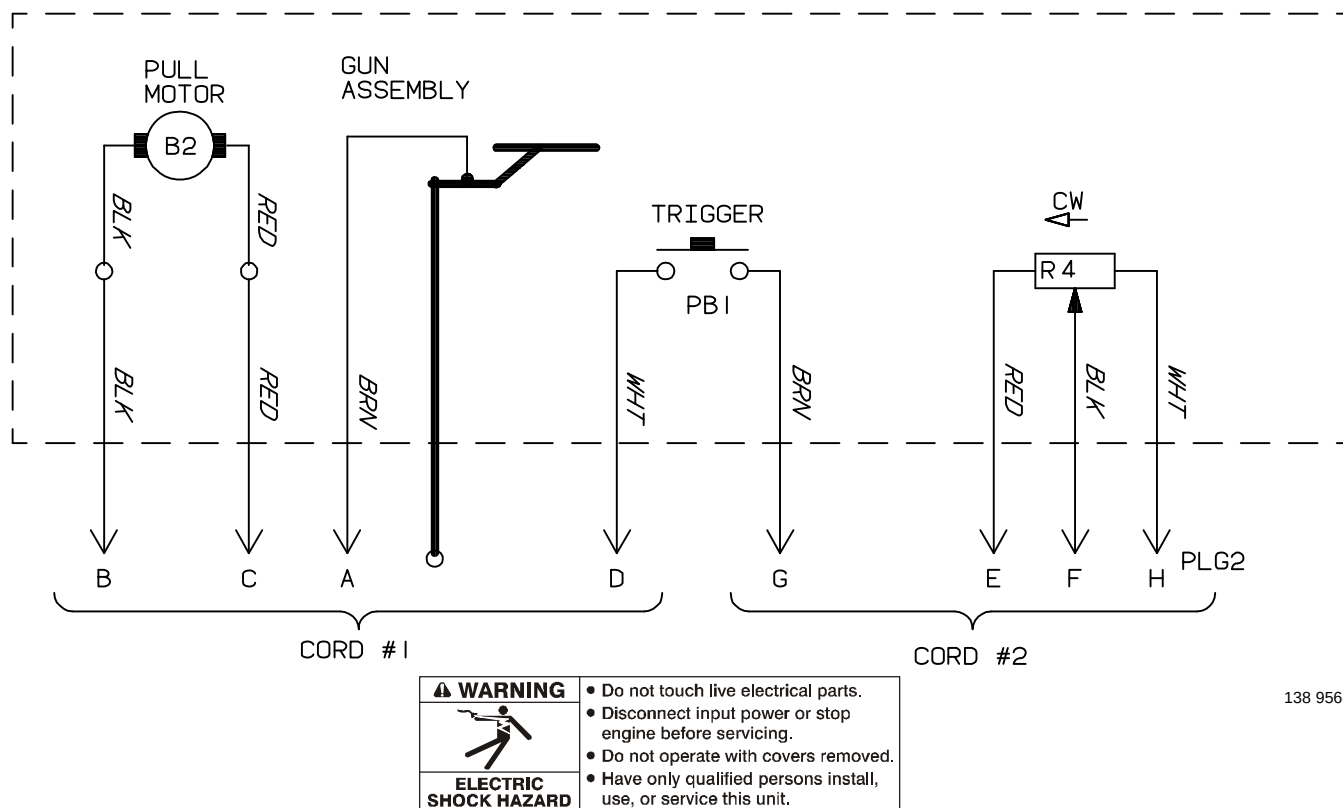
- 1 Nozzle
- 2 FasTip
To remove, see Section 8-3.
- 3 Diffuser
Remove diffuser and replace.

Tools Needed:



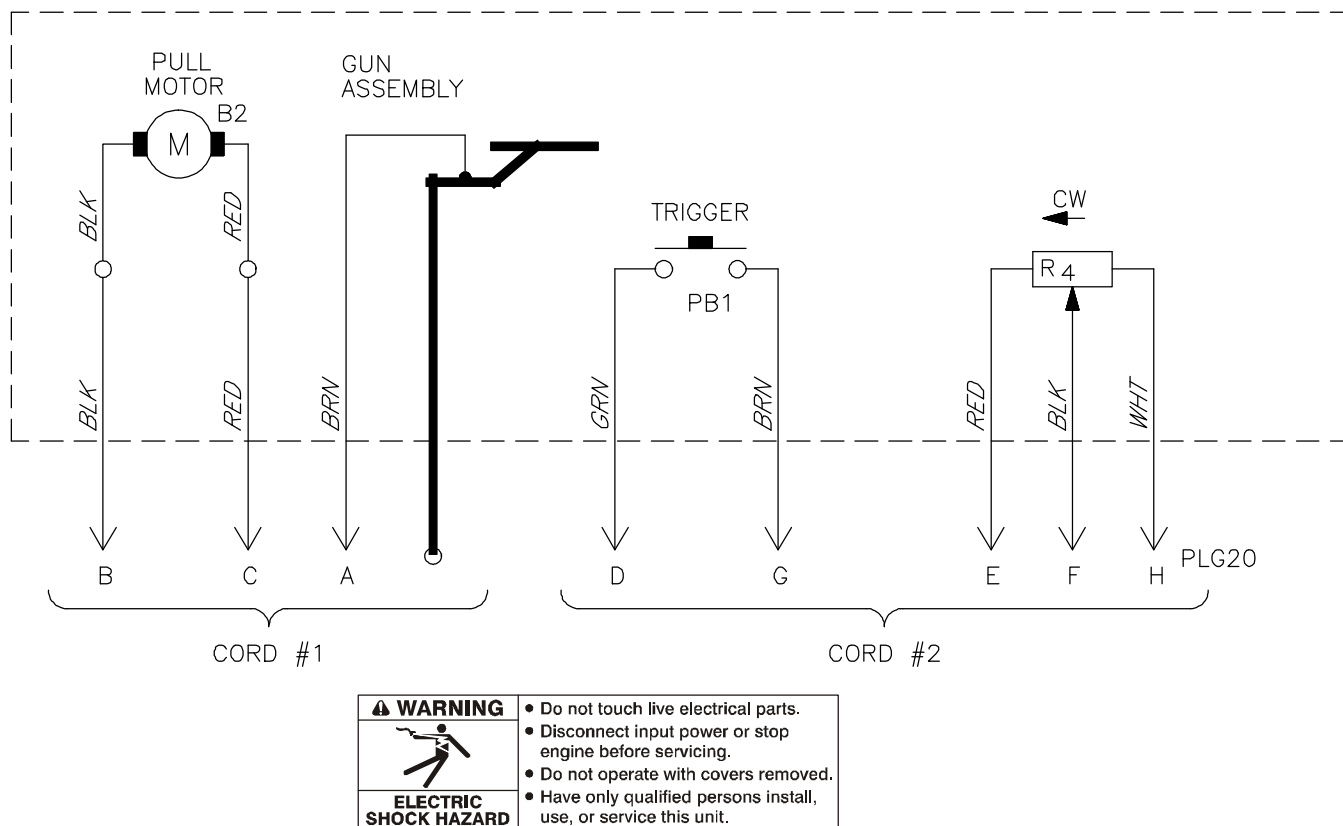
Ref. 803 348-G

SECTION 9 – ELECTRICAL DIAGRAMS



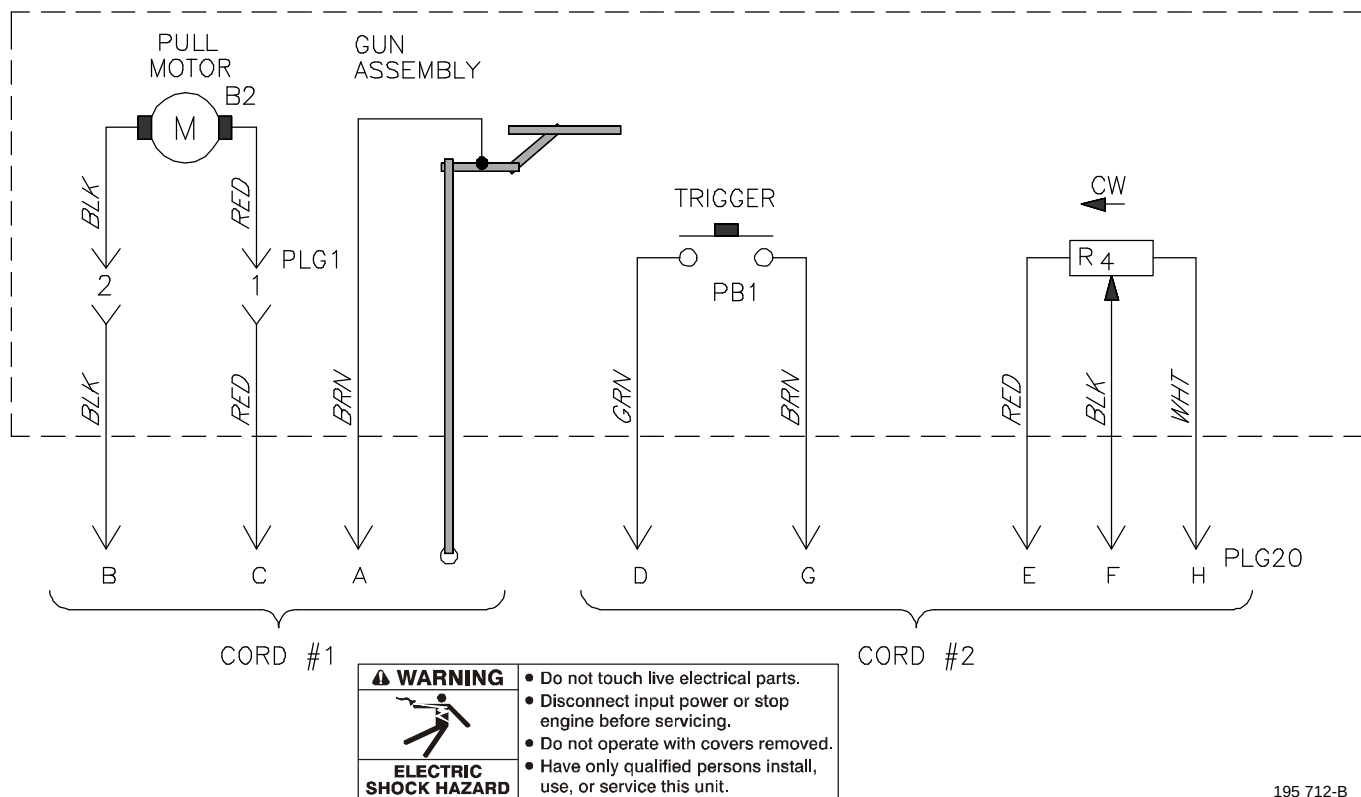
138 956-B

Figure 9-1. Circuit Diagram For Spoolmatic 30A Eff/w Serial No. KB087733 Thru LA062998



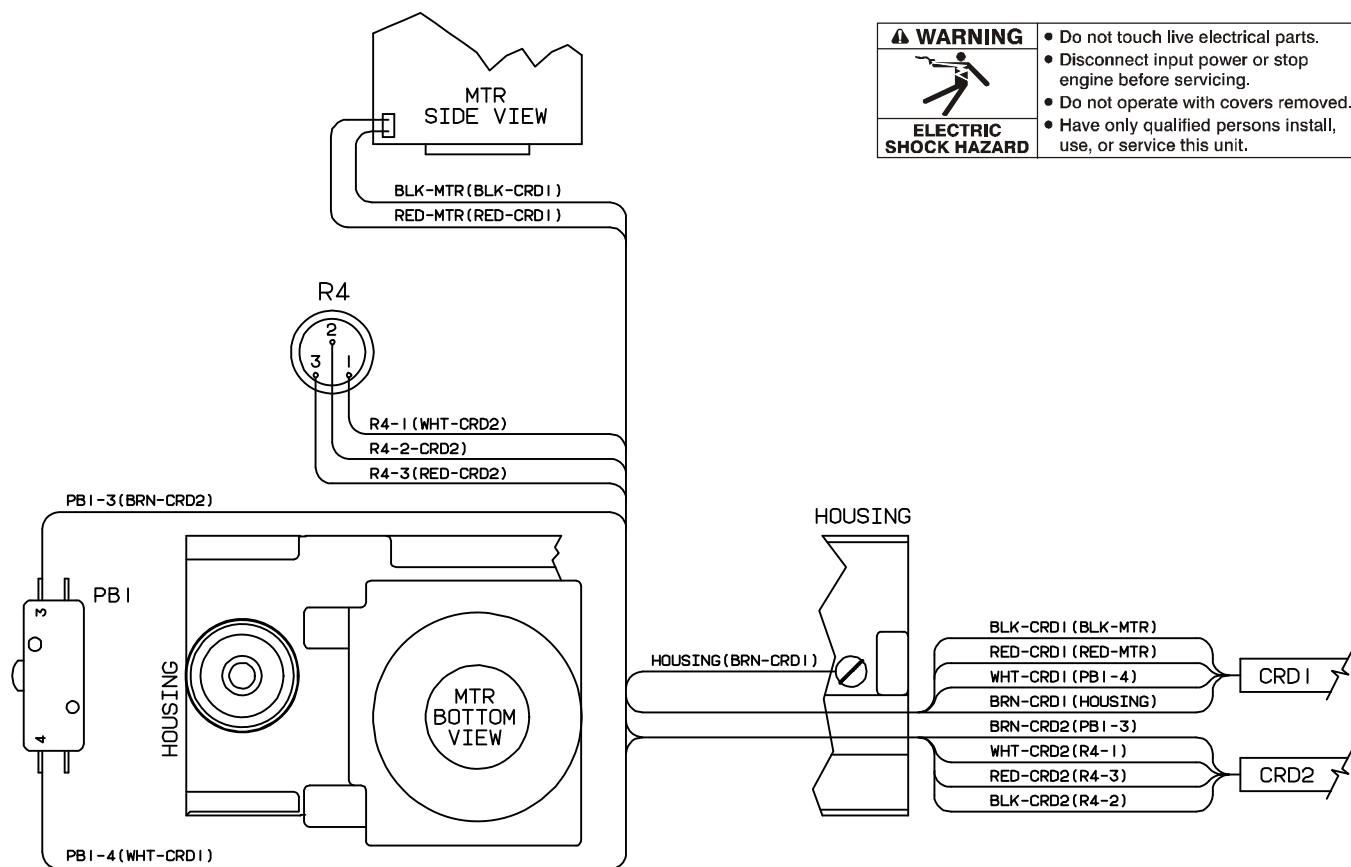
195 712-A

Figure 9-2. Circuit Diagram For Spoolmatic15A Eff/w Serial No. LC259178 Thru LH050050V
Circuit Diagram For Spoolmatic 30A Eff/w Serial No. LA062999 Thru LH050050V



195 712-B

Figure 9-3. Circuit Diagram For Spoolmatic15A And 30A Eff/w Serial No. LH050051V And Following



139 060-A

Figure 9-4. Wiring Diagram For Spoolmatic 30A Eff/w Serial No. KB087733 Thru LA062998



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description



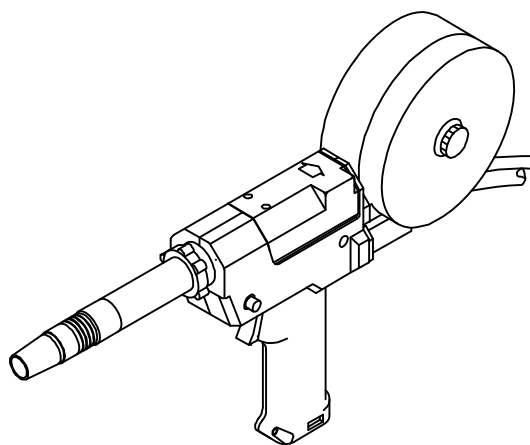
Feeder Gun

Spoolmatic® 30A

PARTS LIST

Prior To Serial No. KD376404

For OM-1213 (137531) Prior To Revision D



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

www.MillerWelds.com

File: MIG (GMAW)



SECTION 10 – PARTS LIST PRIOR TO SERIAL NO. KD376404

 Hardware is common and not available unless listed.

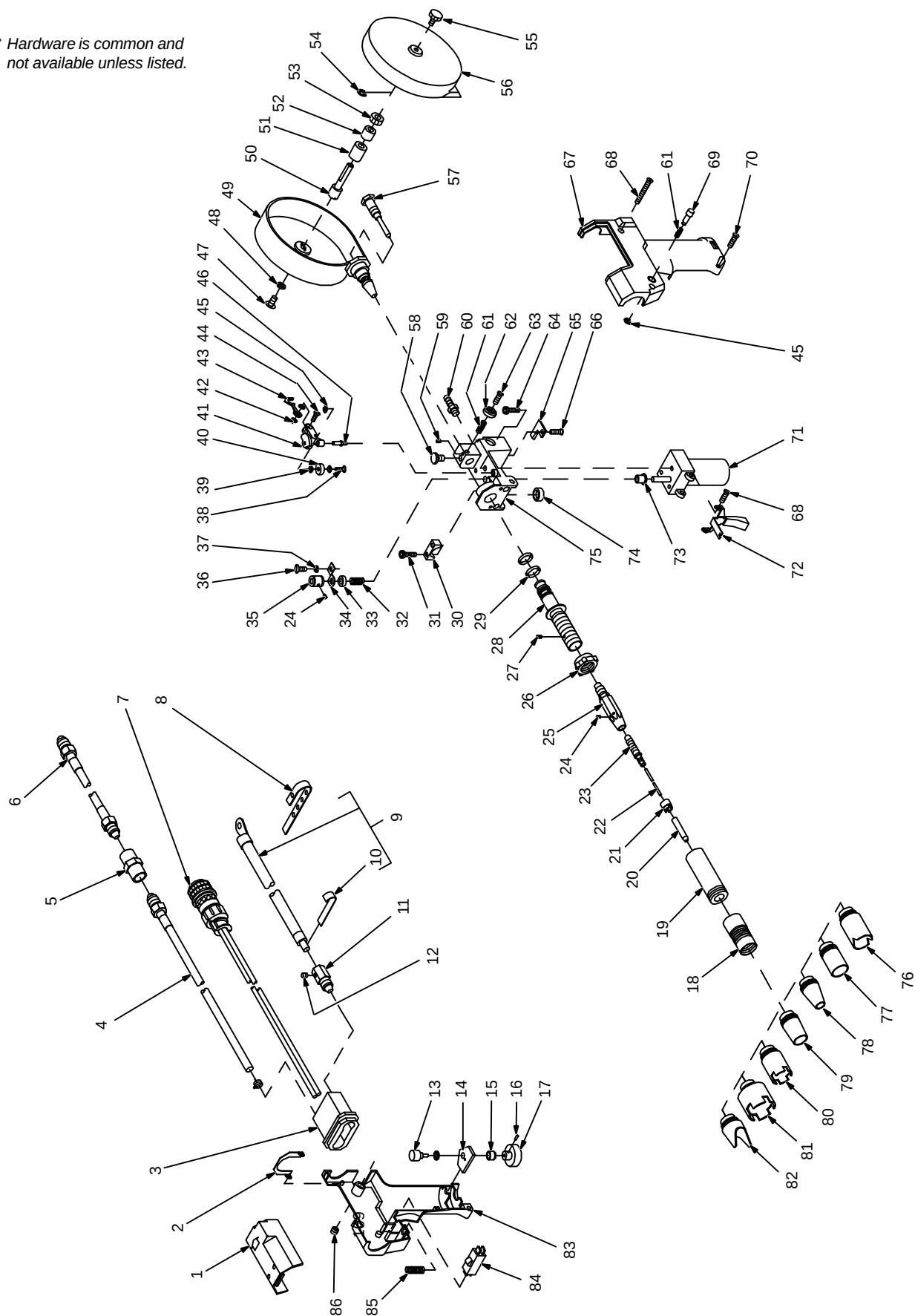


Figure 10-1. Main Assembly

Ref. 143 116-B

Prior To Serial No. KD376404

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 10-1. Main Assembly				
1		133479	Cover	1
2		135196	Spring, Closure Cover	1
3		133362	Strain Relief, Cable	1
4		137472	Hose, Gas In (Consisting Of)	1
		056851	Fitting, Hose Brs Barbed Nipple 3/16Tbg	1
		010606	Fitting, Hose Brs Nut .625-18Rh	1
		056108	Fitting, Hose Brs Ferrule .425 Id X .718 Lg	1
		134834	Hose, SAE .187 Id X .410 Od (Order By Ft)	31Ft
		089120	Clamp, Hose .375-.450Clp Dia Slftng	1
5		000950	Fitting, Hose Brs Coupler .625-18rh/.625-18rh	1
6		048837	Hose, Gas (Consisting Of)	1
		010603	Fitting, Hose Brs Barbed Nipple 1/4Tbg	2
		010606	Fitting, Hose Brs Nut .625-18Rh	2
		056112	Fitting, Hose Brs Ferrule .475 Id X .718 Lg	2
		603106	Hose, Nprn Brd No. 1 X .250 Id (Order By Ft)	10Ft
7		138459	Cable, Control (Consisting Of)	1
	PLG2	146212	Plug, 10 Pin Ms-3106A-18-1Px	1
		138033	Clamp, Cable 97-3057-1010	1
		053212	Cable, Port No. 18 4/C (Order By Ft)	63Ft
8		073476	Clamp, Strap Rbr 5 Holes .375 Wide X 4.625 Lg	13
9		137479	Cable, Power (Consisting Of)	1
		600722	Terminal, Ring Tng .500 Stud No. 4 Cable	1
		600318	Cable, Weld Cop Strd No.3 (Order By Ft)	31Ft
		127893	Ring, Crimp Cable	1
10		019833	Strip, Cop .010 X 2.500 X .750	1
11		137495	Fitting, Connection Power Weld	1
12		141694	Screw, Set Stl Sch .312-18 X .375 Cone Point	1
13	R4	137854	Potentiometer, C Sltd Sft 1/T .5W 10K Ohm	1
14		144861	Washer, Anti-Turn	1
15		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1
16		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1
17		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1
18		144862	Extension, Nozzle	1
19		053785	Extension, Barrel 2.875 Lg	1
20		136171	Tube, Contact .025/31 Wire	1
20		◆135427	Tube, Contact .030/36 Wire	1
20		135428	Tube, Contact .030/41 Wire	1
20		◆147314	Tube, Contact .035/41 Wire	1
20		135430	Tube, Contact .035/52 Wire	1
20		◆135429	Tube, Contact .047/52 Wire	1
20		135424	Tube, Contact .047/61 Wire	1
20		◆135426	Tube, Contact .062/73 Wire	1
20		135425	Tube, Contact .062/81 Wire	1
		136821	Wrench, Nut Tube Contact	1
21		136748	Nut, Compression .375-24	1
22		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg	1
22		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg	1
23		136680	Adapter, Contact Tube	1
24		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	4
25		136681	Tube, Head	1
26		058685	Nut, Jam Nozzle Extension	1
27		602172	Screw, Set Stl Sch 10-32 X .187 Cup Point	1
28		136730	Adapter, Tube Head	1
29		134800	O-Ring, .614 Id X .070 Cs	2
30		133365	Clamp, Head Tube	1
31		000417	Screw, Cap Stl Sch 10-24 X1.000	2
32		143836	Spring, Cprsn .445 Od X .023 Wire X .370	1
33		008033	Washer, Flat Felt .234 Id X .500 Od X .093Thk	1

Prior To Serial No. KD376404

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 10-1. Main Assembly (Continued)				
34		146558	Kit, Current Pick-Up Contact	1
35		136135	Roll, Drive Vlk Groove .023-1/16 Wire	1
36		602066	Screw, Mach Stl Trh 6-32 X .250	3
37		602198	Washer, Lock Stl Split No. 6	1
38		132270	Screw, Mach Stl Rdhph 6-32 X .500	1
39		134624	Bearing, Flg Nyl .140 Id X .187 Od X .375Fg X .031Thk	2
40		134623	Bearing	1
41		132852	Arm, Pressure	1
42		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2
43		133083	Spring, Tension Adj Drive Roll	1
44		144860	Screw, Mach Stl Flh 8-32 X .437	1
45		058968	Ring, Retainer E	2
46		135474	Pin, Hinge	1
47		132530	Screw, Mach Stl Phtrh .250-20 X .500	1
48		602209	Washer, Lock Stl Intl Tooth .250	1
49		132527	Canister, Spool	1
50		148488	Post, Support Spool	1
51		132529	Pad, Brake	1
52		148489	Washer, Anti-Turn	1
53		132524	Nut, Thumb Brake	1
54		000364	Ring, Retainer Ext .188 Shaft X .025Thk	1
55		132528	Screw, Thumb Canister	1
56		132526	Cover, Spool	1
57		132521	Guide, Inlet Canister	1
58		135498	Screw, Thumb Spring Plunger	1
59		135126	Screw, Set Stl Sch 6-32 X .125 Cup Point	1
60		135580	Fitting, Gas	1
61		112896	Spring, Cprsn .240 Od X .020 Wire X .437	2
62		135773	Nut, Thumb Tension Adjusting 8-32	1
63		602082	Screw, Mach Stl Rdh 8-32 X .500	1
64		604638	Screw, Cap Stl Sch 6-32 X .375	3
65		136679	Clamp, Strain Relief	1
66		132269	Screw, Mach Stl Rdhph 8-32 X .375	1
67		136128	Case, Gun Lh	1
68		135646	Screw, Mach Stl Rdhph 8-32 X 1.500	2
69		135896	Plunger, Trigger Hold	1
70		135645	Screw, Mach Stl Rdhph 8-32 X .875	1
71	B2	134248	Motor, Gear Pm 24VDC 420Rph 10.2:1 Ratio	1
72		133373	Trigger	1
73		135473	Bushing, Shaft Motor	1
74		058262	Cap	1
75		133363	Housing, Wire Drive Components	1
76		◆009925	Nozzle, Spot Outside Corner .937 Id x 2.375	1
77		◆050116	Nozzle, 13/16 Orf X 1-5/8 Lg	1
78		◆050115	Nozzle, 1/2 Orf X 1-5/8 Lg	1
79		050622	Nozzle, 5/8 Orf X 1-5/8 Lg	1
80		◆000442	Nozzle, Spot	1
81		◆004466	Nozzle, Spot	1
82		◆000443	Nozzle, Spot Inside Corner	1
83		136127	Case, Gun Rh	1
84	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
85		118774	Spring, Cprsn .240 Od X .024 Wire X 1.000	1
86		135647	Nut, Stl 8-32	3

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description



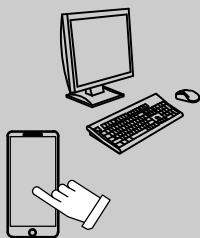
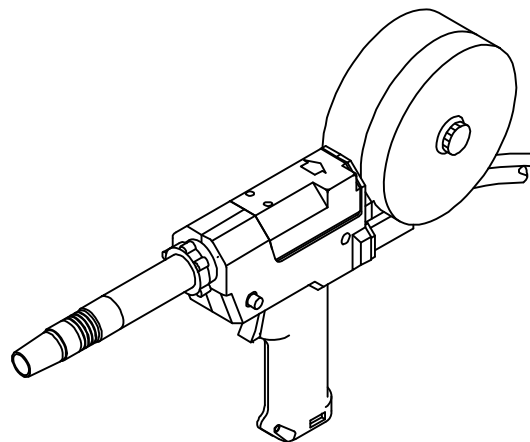
Feeder Gun

Spoolmatic® 30A

PARTS LIST

Eff w/Serial No.
KD376404 Thru KG193178

For OM-1213 (137531) Revisions D Thru H



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

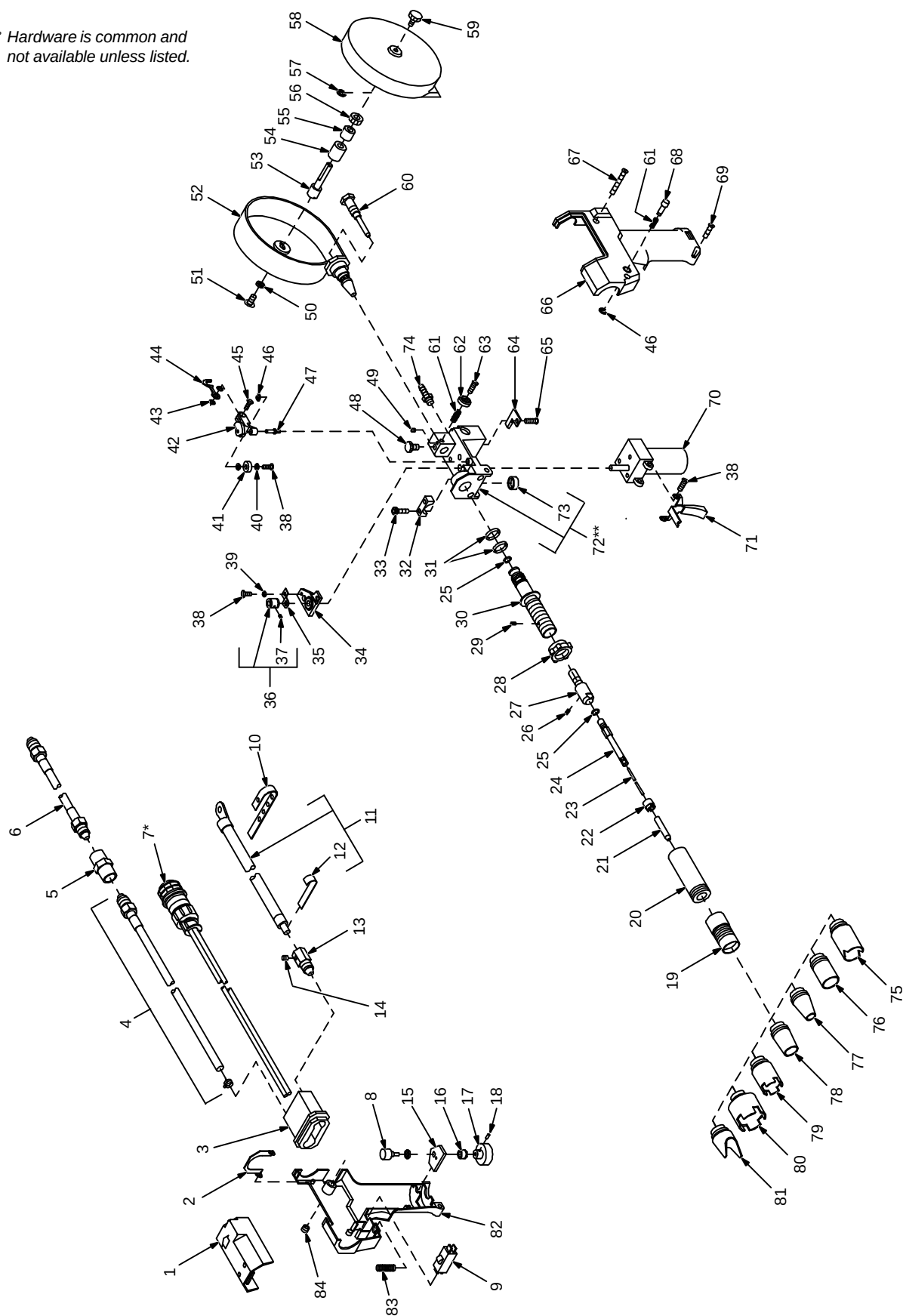
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File: MIG (GMAW)



SECTION 11 – PARTS LIST FOR SERIAL NO. KD376404 THRU KG193178

 Hardware is common and
not available unless listed.



*Includes Items 8 & 9
**Includes Item 74

Figure 11-1. Main Assembly

143 116-E

Eff w/Serial No. KD376404 Thru KG193178

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 11-1. Main Assembly				
1		133479	Cover	1
2		135196	Spring, Closure Cover	1
3		133362	Strain Relief, Cable	1
4		137472	Hose, Gas In	1
5		000950	Fitting, Hose Brs Coupler .625-18Rh/.625-18Rh	1
6		048837	Hose, Gas	1
7		138459	Cable, Control (Consisting Of)	1
8	R4	137854	Potentiometer, C Sltd Sft 1/T .5W 10K Ohm	1
9	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
10		073476	Clamp, Strap Rbr 5 Holes .375 Wide X 4.625 Lg	13
11		137479	Cable, Power	1
12		152577	Strip, Cop .010 X 2.000 X .750	1
13		137495	Fitting, Connection Power Weld	1
14		141694	Screw, Set .312-18 X .375Sch Stl	1
15		144861	Washer, Anti-Turn	1
16		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1
17		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1
18		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1
19		144862	Extension, Nozzle	1
20		156821	Extension, Barrel 2.875 Lg	1
21		◆136171	Tip, Contact .025/31 Wire	1
21		◆135427	Tip, Contact .030/36 Wire	1
21		◆135428	Tip, Contact .030/41 Wire	1
21		◆147314	Tip, Contact .035/41 Wire	1
21		135430	Tip, Contact .035/52 Wire	1
21		◆135429	Tip, Contact .047/52 Wire	1
21		135424	Tip, Contact .047/61 Wire	1
21		◆135426	Tip, Contact .062/73 Wire	1
21		◆135425	Tip, Contact .062/81 Wire	1
		136821	Wrench, Nut Tip Contact	1
		166575	Wrench, Hex .078 Across The Flat	1
22		136748	Nut, .375-24 .41Dia Stl	1
23		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg	1
23		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg	1
24		164421	Adapter, Contact Tip	1
25		164485	O-Ring .176 Id X .070Cs	2
26		604612	Screw, Set 8-32 X .125 Cup Pt Sch Stl	1
27		164422	Tube, Head	1
28		058685	Nut, 1.000-8 1.5Knrl Nyl	1
29		602172	Screw, Set 10-32 X .187 Cup Point Sch Stl	1
30		164423	Adapter, Tip Head	1
31		134800	O-Ring, .614 Id X .070Cs	2
32		133365	Clamp, Head Tube	1
33		000417	Screw, 10-24 X1.000Sochd Hex	2
34		162041	Bearing Block Assembly (Eff W/Kd464350)	1
		604638	Screw, 6-32 X .375Sochd Hex	3
		143480	Screw, 6-32 X .625Sochd Hex Stl	1
35		209342	Kit, Current Pick-Up (Units W/Bearing Block)	1
36		136135	Roll, Drive Vk Groove .023-1/16 Wire (Consisting Of)	1
36		183357	Roll, Drive Vk Groove .030/.035 Wire (Consisting Of)	1
36		183358	Roll, Drive Vk Groove .047/.062 Wire (Consisting Of)	1
37		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2
38		114045	Screw, 6-32 X .500Hexwhd Slit Stl Slfmg	3
39		602198	Washer, Lock .141 Id Stl Split	1
40		134624	Bearing, Flg Nyl .140 Id X .187 Od X .375Flg X .031Thk	2
41		134623	Bearing	1
42		132852	Arm, Pressure	1
43		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2
44		133083	Spring, Tension Adj Drive Roll	1

Eff w/Serial No. KD376404 Thru KG193178

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 11-1. Main Assembly (Continued)				
... 45		144860	.. Screw, 8-32 X .437Flatd Slit Stl	1
... 46		058968	.. Ring, Retainer E	2
... 47		135474	.. Pin, Hinge	1
... 48		155565	.. Screw, Thumb	1
...		134799	.. O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1
... 49		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1
... 50		602209	.. Washer, Tooth .256 Id Stl Intl	1
... 51		602154	.. Screw, .250-20 X .500Hexhd Stl Slffmg	1
... 52		132527	.. Canister, Spool	1
... 53		148488	.. Post, Support Spool	1
... 54		132529	.. Pad, Brake	1
... 55		148489	.. Washer, Anti-Turn .380 Id	1
... 56		132524	.. Nut, .375-24 .56Knrl Alum	1
... 57		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025Thk	1
... 58		132526	.. Cover, Spool	1
... 59		132528	.. Screw, Thumb Canister	1
... 60		132521	.. Guide, Inlet Canister	1
... 61		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	2
... 62		135773	.. Nut, 8-32 .56Knrl Stl	1
... 63		143360	.. Screw, 8-32 X .500Panhd Phl Stl	1
... 64		136679	.. Clamp, Strain Relief	1
... 65		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1
... 66		164591	.. Case, Gun Lh	1
... 67		173527	.. Screw, 8-32 X 1.500	2
... 68		135896	.. Plunger, Trigger Hold	1
... 69		173528	.. Screw, 8-32 X .875	1
... 70	B2	161813	.. Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1
... 71		164592	.. Trigger	1
... 72		164582	.. Housing, Wire Drive (Consisting Of)	1
... 73		058262	.. Cap, Valve	1
... 74		135580	.. Fitting, Gas	1
...		146555	.. Screw, Set 8-32 X .125 Cup Sch	2
... 75		◆009925	.. Nozzle, Spot Outside Corner .937 Id X 2.375	1
... 76		◆050116	.. Nozzle, 13/16 Orf X 1-5/8 Lg	1
... 77		◆050115	.. Nozzle, 1/2 Orf X 1-5/8 Lg	1
... 78		050622	.. Nozzle, 5/8 Orf X 1-5/8 Lg	1
... 79		◆000442	.. Nozzle, Spot	1
... 80		◆004466	.. Nozzle, Spot	1
... 81		◆000443	.. Nozzle, Spot Inside Corner	1
... 82		164590	.. Case, Gun Rh	1
... 83		057544	.. Spring, Cprsn .240 Od X .026 Wire x 1.000	1
... 84		135647	.. Nut, 8-32 .33Knrl Brs	3

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description



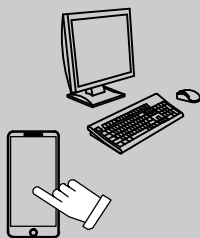
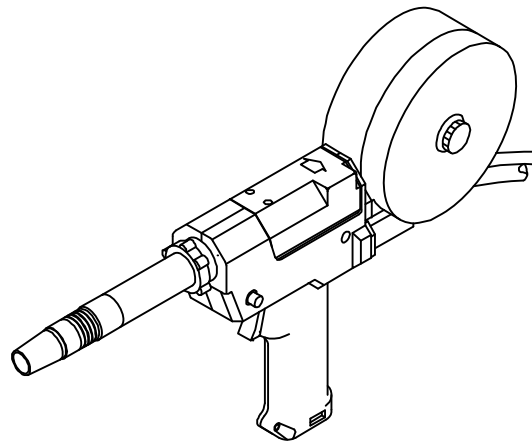
Feeder Gun

Spoolmatic® 30A

PARTS LIST

Eff w/Serial No.
KG193179 Thru KJ260859

For OM-1213 (137531) Revision J



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

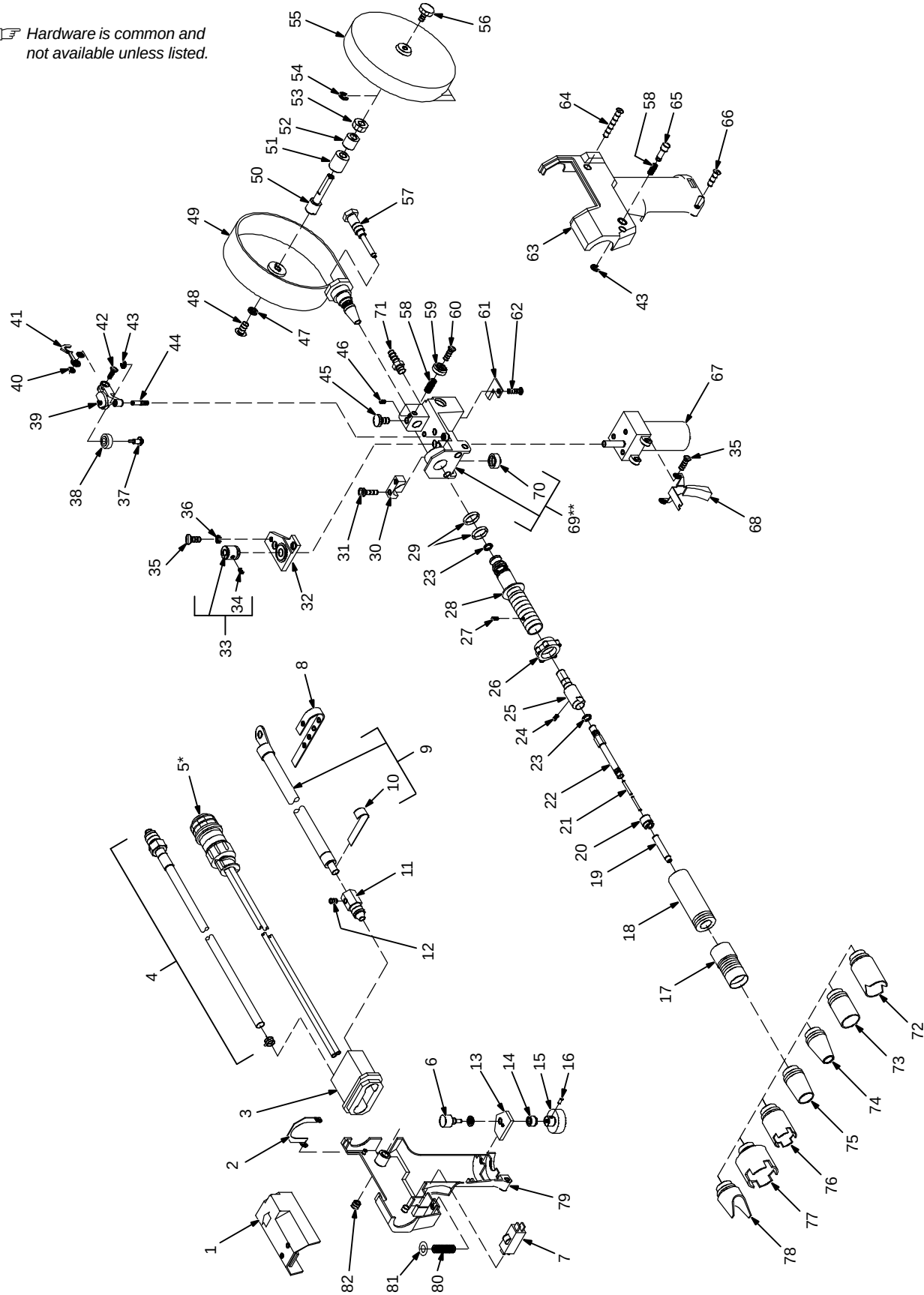
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File: MIG (GMAW)



SECTION 12 – PARTS LIST FOR SERIAL NO. KG193179 THRU KJ260859

 Hardware is common and not available unless listed.



*Includes Items 6 & 7
**Includes Item 71

Figure 12-1. Main Assembly

143 116-H

Eff w/Serial No. KG193179 Thru KJ260859

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 12-1. Main Assembly				
1		133479	Cover	1
2		135196	Spring, Closure Cover	1
3		133362	Strain Relief, Cable	1
4		182824	Hose, Gas In	1
5		138459	Cable, Control	1
6	R4	137854	Potentiometer, C Sltd Sft 1/T .5W 10K Ohm	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
8		073476	Clamp, Strap Rbr 5 Holes .375 Wide X 4.625 Lg	13
9		137479	Cable, Power	1
10		152577	Strip, Cop .010 X 2.000 X .750	1
11		137495	Fitting, Connection Power Weld	1
12		141694	Screw, Set .312-18 X .375Sch Stl	1
13		144861	Washer, Anti-Turn	1
14		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1
15		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1
16		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1
17		144862	Extension, Nozzle	1
18		156821	Extension, Barrel 2.875 Lg	1
19		◆136171	Tip, Contact .025/31 Wire	1
19		◆135427	Tip, Contact .030/36 Wire	1
19		◆135428	Tip, Contact .030/41 Wire	1
19		◆147314	Tip, Contact .035/41 Wire	1
19		135430	Tip, Contact .035/52 Wire	1
19		◆135429	Tip, Contact .047/52 Wire	1
19		135424	Tip, Contact .047/61 Wire	1
19		◆135426	Tip, Contact .062/73 Wire	1
19		◆135425	Tip, Contact .062/81 Wire	1
		136821	Wrench, Nut Tip Contact	1
		166575	Wrench, Hex .078 Across The Flat	1
20		136748	Nut, .375-24 .41Dia Stl	1
21		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg	1
21		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg	1
22		164421	Adapter, Contact Tip	1
23		164485	O-Ring .176 Id X .070Cs	2
24		604612	Screw, Set 8-32 X .125 Cup Pt Sch Stl	1
25		164422	Tube, Head	1
26		058685	Nut, 1.000-8 1.5Knrl Nyl	1
27		602172	Screw, Set 10-32 X .187 Cup Point Sch Stl	1
28		164423	Adapter, Tip Head	1
29		134800	O-Ring, .614 Id X .070Cs	2
30		133365	Clamp, Head Tube	1
31		000417	Screw, 10-24 X1.000 Sochd Hex	2
32		162041	Bearing Block Assembly	1
		604638	Screw, 6-32 X .375 Sochd Hex	3
		143480	Screw, 6-32 X .625 Sochd Hex Stl	1
33		136135	Roll, Drive Vk Groove .023-1/16 Wire (Consisting Of)	1
33		183357	Roll, Drive Vk Groove .030/.035 Wire (Consisting Of)	1
33		183358	Roll, Drive Vk Groove .047/.062 Wire (Consisting Of)	1
34		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2
35		114045	Screw, 6-32 X .500Hexwhd Slit Stl Slffmg	2
36		602198	Washer, Lock .141 Id Stl Split	1
37		182279	Shaft, Hot Idler	1
38		182948	Idler Roll Assembly	1
39		132852	Arm, Pressure	1
40		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2
41		133083	Spring, Tension Adj Drive Roll	1
42		144860	Screw, 8-32 X .437Flatd Slit Stl	1
43		058968	Ring, Retainer E	2

Eff w/Serial No. KG193179 Thru KJ260859

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 12-1. Main Assembly (Continued)				
... 44		135474	.. Pin, Hinge	1
... 45		155565	.. Screw, Thumb	1
...		134799	.. O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1
... 46		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1
... 47		602209	.. Washer, Tooth .256 Id Stl Intl	1
... 48		602154	.. Screw, .250-20 X .500Hexhd Stl Slffmg	1
... 49		132527	.. Canister, Spool	1
... 50		148488	.. Post, Support Spool	1
... 51		132529	.. Pad, Brake	1
... 52		148489	.. Washer, Anti-Turn .380 Id	1
... 53		132524	.. Nut, .375-24 .56Knrl Alum	1
... 54		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025Thk	1
... 55		132526	.. Cover, Spool	1
... 56		132528	.. Screw, Thumb Canister	1
... 57		132521	.. Guide, Inlet Canister	1
... 58		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	2
... 59		135773	.. Nut, 8-32 .56Knrl Stl	1
... 60		143360	.. Screw, 8-32 X .500Panhd Phl Stl	1
... 61		136679	.. Clamp, Strain Relief	1
... 62		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1
... 63		164591	.. Case, Gun Lh	1
... 64		173527	.. Screw, 8-32 X 1.500	2
... 65		135896	.. Plunger, Trigger Hold	1
... 66		173528	.. Screw, 8-32 X .875	1
... 67	B2	161813	.. Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1
... 68		164592	.. Trigger	1
... 69		164582	.. Housing, Wire Drive (Consisting Of)	1
... 70		058262	.. Cap, Valve	1
... 71		135580	.. Fitting, Gas	1
...		146555	.. Screw, Set 8-32 X .125 Cup Sch	2
... 72		◆009925	.. Nozzle, Spot Outside Corner .937 Id X 2.375	1
... 73		◆050116	.. Nozzle, 13/16 Orf X 1-5/8 Lg	1
... 74		◆050115	.. Nozzle, 1/2 Orf X 1-5/8 Lg	1
... 75		050622	.. Nozzle, 5/8 Orf X 1-5/8 Lg	1
... 76		◆000442	.. Nozzle, Spot	1
... 77		◆004466	.. Nozzle, Spot	1
... 78		◆000443	.. Nozzle, Spot Inside Corner	1
... 79		164590	.. Case, Gun Rh	1
... 80		183884	.. Spring, Cprsn .240 Od X .026 Wire X 1.000 (Eff W/KG241669)	1
... 81		184101	.. Washer, Shldr .140 Id X .250 Od (Eff W/KG241669)	1
... 82		135647	.. Nut, 8-32 .33Knrl Brs	3

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description



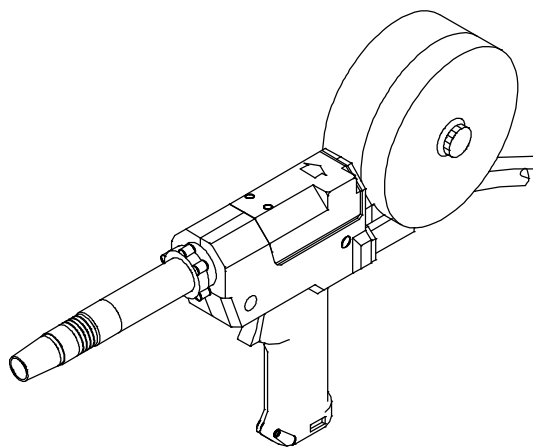
Feeder Gun

Spoolmatic[®] 30A

PARTS LIST

Eff w/Serial No. KJ260860 Thru LB071103

For OM-1213 (137531) Revisions K To M



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

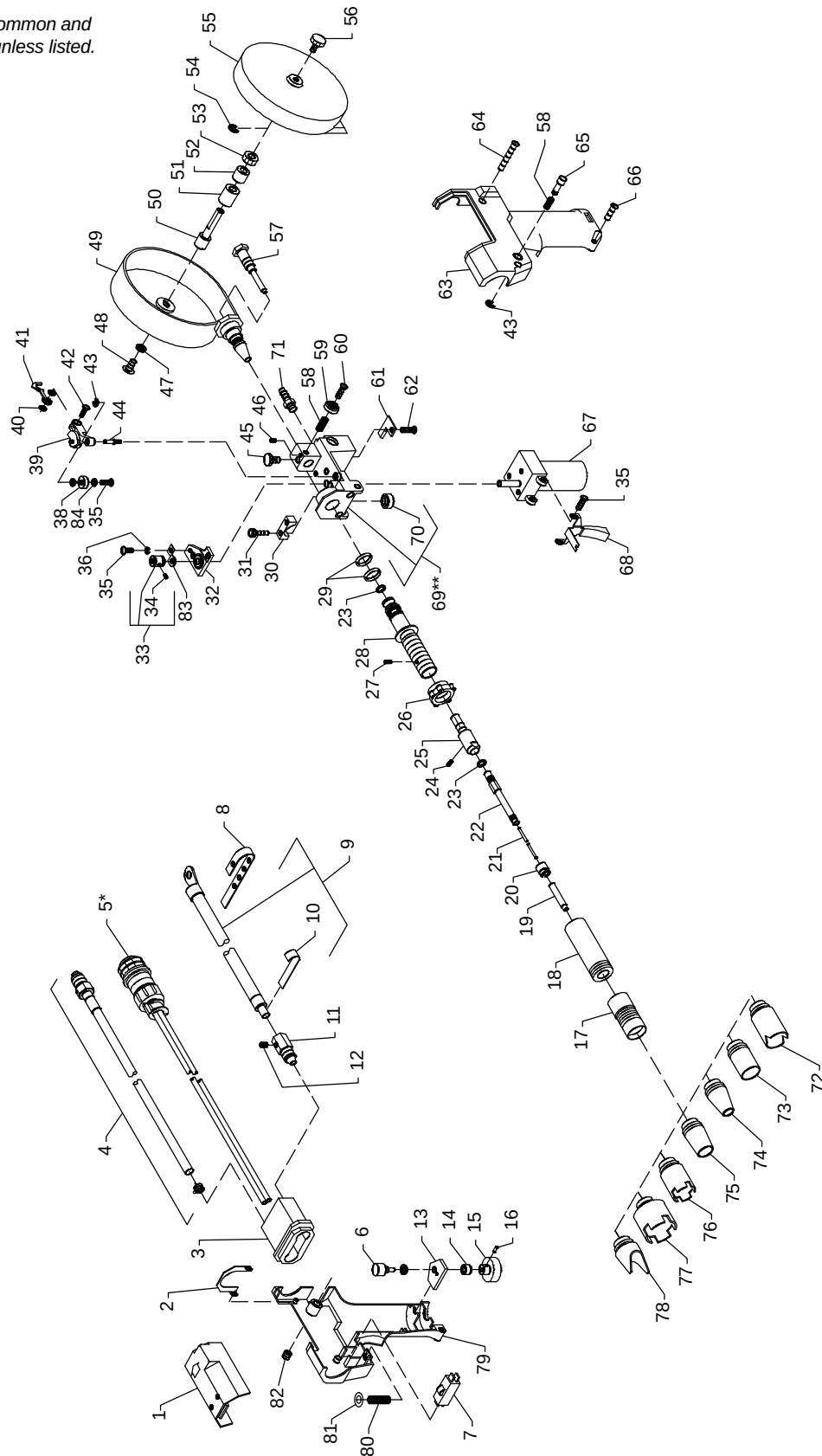
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File: MIG (GMAW)



SECTION 13 – PARTS LIST FOR SERIAL NO. KJ260860 THRU LB071103

 Hardware is common and
not available unless listed.



*Includes Items 6 & 7
**Includes Item 71

143 116-J

Figure 13-1. Main Assembly

Eff w/Serial No. KJ260860 Thru LB071103

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 13-1. Main Assembly				
1		133479	Cover	1
2		135196	Spring, Closure Cover	1
3		133362	Strain Relief, Cable	1
4		182824	Hose, Gas In	1
5		138459	Cable, Control (Prior to LA062999)	1
5		198810	Cable, Control 30 Ft (Eff w/LA062999)	1
6	R4	137854	Potentiometer, C Slt Sft 1/T .5W 10K Ohm (Prior to LA062999)	1
6	R4	200096	Potentiometer, C Slt Sft 1/T .5W 10K Ohm (Eff w/LA062999)	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
8		073476	Clamp, Strap Rbr 5 Holes .375 Wide X 4.625 Lg	13
9		137479	Cable, Power	1
10		152577	Strip, Cop .010 X 2.000 X .750	1
11		137495	Fitting, Connection Power Weld	1
12		141694	Screw, Set .312-18 X .375Sch Stl	1
13		144861	Washer, Anti-Turn	1
14		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1
15		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1
16		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1
17		144862	Extension, Nozzle	1
18		156821	Extension, Barrel 2.875 Lg	1
19		◆136171	Tip, Contact .025/31 Wire	1
19		◆135427	Tip, Contact .030/36 Wire	1
19		◆135428	Tip, Contact .030/41 Wire	1
19		◆147314	Tip, Contact .035/41 Wire	1
19		135430	Tip, Contact .035/52 Wire	1
19		◆135429	Tip, Contact .047/52 Wire	1
19		135424	Tip, Contact .047/61 Wire	1
19		◆135426	Tip, Contact .062/73 Wire	1
19		◆135425	Tip, Contact .062/81 Wire	1
		136821	Wrench, Nut Tip Contact	1
		166575	Wrench, Hex .078 Across The Flat	1
20		136748	Nut, .375-24 .41Dia Stl	1
21		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg	1
21		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg	1
22		164421	Adapter, Contact Tip	1
23		164485	O-Ring .176 Id X .070 Cs	2
24		604612	Screw, Set 8-32 X .125 Cup Pt Sch Stl	1
25		164422	Tube, Head	1
26		058685	Nut, 1.000-8 1.5Knrl Nyl	1
27		602172	Screw, Set 10-32 X .187 Cup Point Sch Stl	1
28		164423	Adapter, Tip Head	1
29		134800	O-Ring, .614 Id X .070Cs	2
30		133365	Clamp, Head Tube	1
31		000417	Screw, 10-24 X1.000 Sochd Hex	2
32		162041	Bearing Block Assembly	1
		604638	Screw, 6-32 X .375sochd Hex	3
		143480	Screw, 6-32 X .625sochd Hex Stl	1
33		136135	Roll, Drive Vk Groove .023-1/16 Wire (Consisting Of)	1
33		183357	Roll, Drive Vk Groove .030/.035 Wire (Consisting Of)	1
33		183358	Roll, Drive Vk Groove .047/.062 Wire (Consisting Of)	1
34		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2
35		114045	Screw, 6-32 X .500Hexwhd Slt Stl Slffmg	3
36		602198	Washer, Lock .141 Id Stl Split	1
38		134623	Bearing, Idler Roll	1
39		132852	Arm, Pressure	1
40		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2

Eff w/Serial No. KJ260860 Thru LB071103

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 13-1. Main Assembly (Continued)				
41		133083	.. Spring, Tension Adj Drive Roll	1
42		144860	.. Screw, 8-32 X .437Flatd Slit Stl	1
43		058968	.. Ring, Retainer E	2
44		135474	.. Pin, Hinge	1
45		155565	.. Screw, Thumb	1
		134799	.. O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1
46		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1
47		602209	.. Washer, Tooth .256 Id Stl Intl	1
48		602154	.. Screw, .250-20 X .500Hexhd Stl Slffmg	1
49		132527	.. Canister, Spool	1
50		148488	.. Post, Support Spool	1
51		132529	.. Pad, Brake	1
52		148489	.. Washer, Anti-Turn .380 Id	1
53		132524	.. Nut, .375-24 .56Knrl Alum	1
54		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025Thk	1
55		132526	.. Cover, Spool	1
56		132528	.. Screw, Thumb Canister	1
57		132521	.. Guide, Inlet Canister	1
58		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	2
59		135773	.. Nut, 8-32 .56Knrl Stl	1
60		143360	.. Screw, 8-32 X .500Panhd Phl Stl	1
61		136679	.. Clamp, Strain Relief	1
62		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1
63		164591	.. Case, Gun Lh	1
64		173527	.. Screw, 8-32 X 1.500	2
65		135896	.. Plunger, Trigger Hold (Prior To LA010441)	1
65		143397	.. Blank, Snap In Nylon (Eff W/LA010441)	1
66		173528	.. Screw, 8-32 X .875	1
67	B2	161813	.. Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1
68		164592	.. Trigger	1
69		164582	.. Housing, Wire Drive (Consisting Of)	1
70		058262	.. Cap, Valve	1
71		135580	.. Fitting, Gas	1
		146555	.. Screw, Set 8-32 X .125 Cup Sch	2
72		◆009925	.. Nozzle, Spot Outside Corner .937 Id x 2.375	1
73		◆050116	.. Nozzle, 13/16 Orf X 1-5/8 Lg	1
74		◆050115	.. Nozzle, 1/2 Orf X 1-5/8 Lg	1
75		050622	.. Nozzle, 5/8 Orf X 1-5/8 Lg	1
76		◆000442	.. Nozzle, Spot	1
77		◆004466	.. Nozzle, Spot	1
78		◆000443	.. Nozzle, Spot Inside Corner	1
79		164590	.. Case, Gun Rh	1
80		183884	.. Spring, Cprsn .240 Od X .026 Wire X 1.000	1
81		184101	.. Washer, Shldr .140 Id X .250 Od	1
82		135647	.. Nut, 8-32 .33Knrl Brs	3
83		162042	.. Contact, Current Pick-Up	1
84		134624	.. Bearing, Flg Nyl .140 Id X .187 Od X .375Flg X .031Thk	2

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

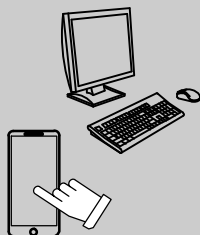
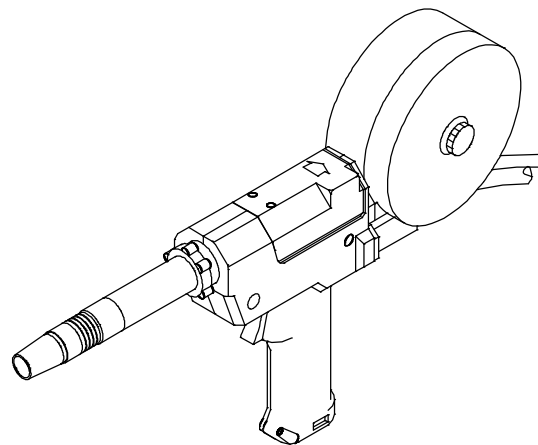


Feeder Gun

Spoolmatic® 30A

PARTS LIST

Eff w/Serial No.
LB071104 Thru LC259177
For OM-1213 (137531) Revisions N Thru P



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

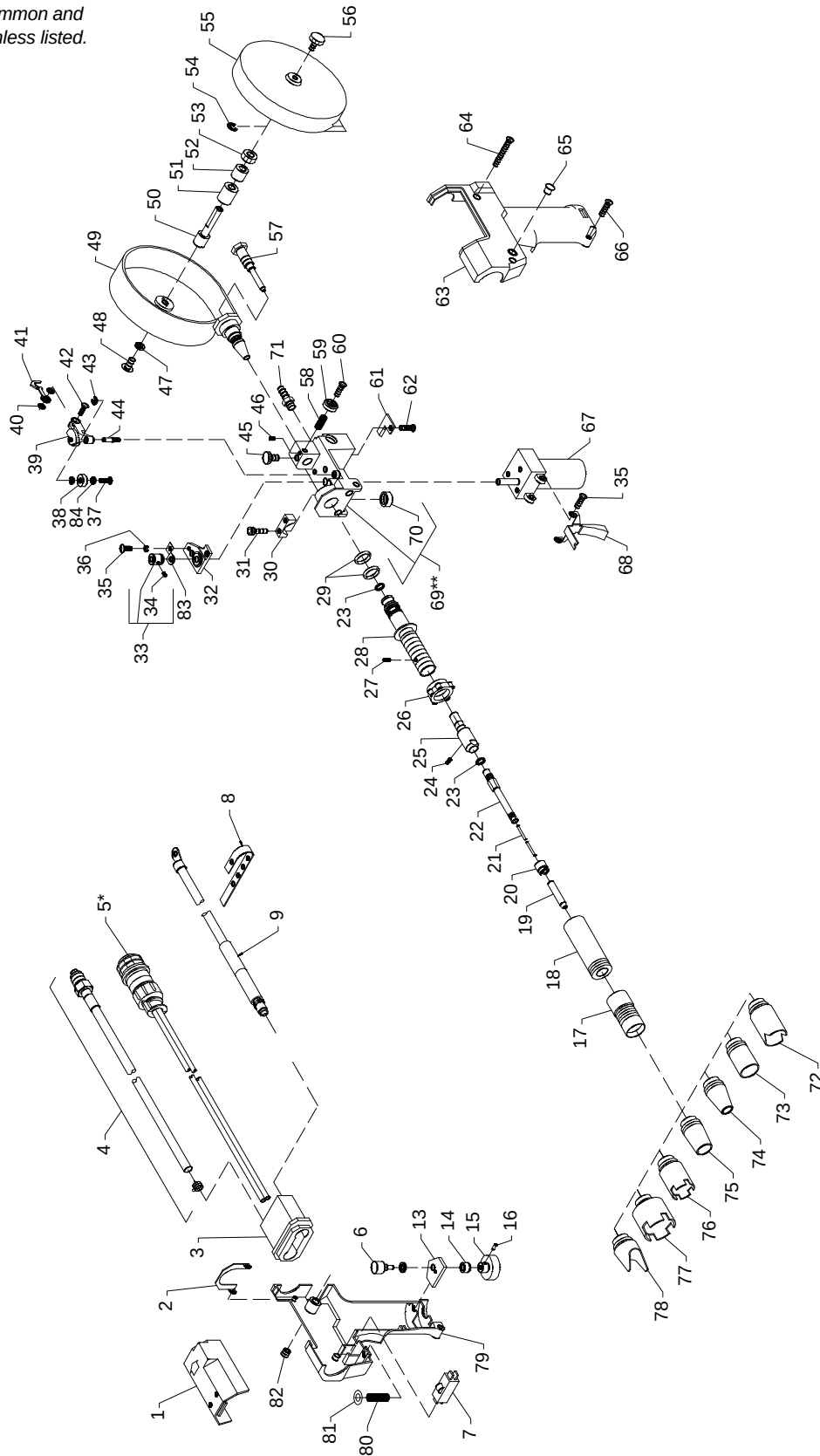
www.MillerWelds.com

File: MIG (GMAW)



SECTION 14 – PARTS LIST FOR SERIAL NO. LB071104 THRU LC259177

 Hardware is common and
not available unless listed.



*Includes Items 6 & 7
**Includes Item 71

143 116-L

Figure 14-1. Main Assembly

Eff w/Serial No. LB071104 Thru LC259177

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 14-1. Main Assembly				
1		133479	Cover	1
2		135196	Spring, Closure Cover	1
3		133362	Strain Relief, Cable	1
4		182824	Hose, Gas In	1
5		198810	Cable, Control 30 Ft (Prior to LB214251)	1
6	R4	200096	Potentiometer, C Sltd Sft 1/T .5W 10K Ohm	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
5		204605	Cable, Control 30 Ft (Consisting Of) (Eff w/LB214251)	1
6	R4	200096	Potentiometer, C Sltd Sft 1/T .5W 10K Ohm	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1
		190294	Conn, Circ Ms/Cpc 10 Pin (Eff W/LB214251)	1
		143922	Conn, Circ Cpc Clamp Str Rlf (Eff W/LB214251)	1
8		073476	Clamp, Strap Rbr 5 Holes .375 Wide X 4.625 Lg (Prior To LB214251)	13
8		174422	Cable Tie (Eff W/LB214251)	16
9		137479	Cable, Power	1
13		144861	Washer, Anti-Turn	1
14		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1
15		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1
16		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1
17		144862	Extension, Nozzle	1
18		156821	Extension, Barrel 2.875 Lg	1
19		◆136171	Tip, Contact .025/31 Wire	1
19		◆135427	Tip, Contact .030/36 Wire	1
19		◆135428	Tip, Contact .030/41 Wire	1
19		◆147314	Tip, Contact .035/41 Wire	1
19		135430	Tip, Contact .035/52 Wire	1
19		◆135429	Tip, Contact .047/52 Wire	1
19		135424	Tip, Contact .047/61 Wire	1
19		◆135426	Tip, Contact .062/73 Wire	1
19		◆135425	Tip, Contact .062/81 Wire	1
		136821	Wrench, Nut Tip Contact	1
		166575	Wrench, Hex .078 Across The Flat	1
20		136748	Nut, .375-24 .41Dia Stl	1
21		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg	1
21		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg	1
22		164421	Adapter, Contact Tip	1
23		164485	O-Ring .176 Id X .070Cs	2
24		604612	Screw, Set 8-32 X .125 Cup Pt Sch Stl	1
25		164422	Tube, Head	1
26		058685	Nut, 1.000-8 1.5Knrl Nyl	1
27		602172	Screw, Set 10-32 X .187 Cup Point Sch Stl	1
28		164423	Adapter, Tip Head	1
29		134800	O-Ring, .614 Id X .070Cs	2
30		133365	Clamp, Head Tube	1
31		000417	Screw, 10-24 X1.000sochd Hex	2
32		162041	Bearing Block Assembly	1
		604638	Screw, 6-32 X .375 Sochd Hex	3
		143480	Screw, 6-32 X .625 Sochd Hex Stl	1
33		136135	Roll, Drive Vk Groove .023-1/16 Wire (Consisting Of)	1
33		183357	Roll, Drive Vk Groove .030/.035 Wire (Consisting Of)	1
33		183358	Roll, Drive Vk Groove .047/.062 Wire (Consisting Of)	1
34		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2
35		114045	Screw, 6-32 X .500 Hexwhd Slit Stl Slffmg	3
36		602198	Washer, Lock .141 Id Stl Split	1
38		134623	Bearing, Idler Roll	1
39		132852	Arm, Pressure	1
40		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2

Eff w/Serial No. LB071104 Thru LC259177

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 14-1. Main Assembly (Continued)				
... 41		133083	.. Spring, Tension Adj Drive Roll	1
... 42		144860	.. Screw, 8-32 X .437 Flatd Slit Stl	1
... 43		058968	.. Ring, Retainer E	1
... 44		135474	.. Pin, Hinge	1
... 45		155565	.. Screw, Thumb	1
...		134799	.. O-Ring, .176 Id X .070 Cs (Used W/Thumbscrew)	1
... 46		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1
... 47		602209	.. Washer, Tooth .256 Id Stl Intl	1
... 48		602154	.. Screw, .250-20 X .500 Hexhd Stl Slffmg	1
... 49		132527	.. Canister, Spool	1
... 50		148488	.. Post, Support Spool	1
... 51		132529	.. Pad, Brake	1
... 52		148489	.. Washer, Anti-Turn .380 Id	1
... 53		132524	.. Nut, .375-24 .56 Knrl Alum	1
... 54		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025 Thk	1
... 55		132526	.. Cover, Spool	1
... 56		132528	.. Screw, Thumb Canister	1
... 57		132521	.. Guide, Inlet Canister	1
... 58		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	1
... 59		135773	.. Nut, 8-32 .56Knrl Stl	1
... 60		143360	.. Screw, 8-32 X .500 Panhd Phl Stl	1
... 61		136679	.. Clamp, Strain Relief	1
... 62		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1
... 63		164591	.. Case, Gun Lh	1
... 64		173527	.. Screw, 8-32 X 1.500	2
... 65		143397	.. Blank, Snap In Nylon	1
... 66		173528	.. Screw, 8-32 X .875	1
... 67	B2	161813	.. Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1
... 68		164592	.. Trigger	1
... 69		164582	.. Housing, Wire Drive (Consisting Of)	1
... 70		058262	.. Cap, Valve	1
... 71		135580	.. Fitting, Gas	1
...		146555	.. Screw, Set 8-32 X .125 Cup Sch	2
... 72		◆009925	.. Nozzle, Spot Outside Corner .937 ID x 2.375	1
... 73		◆050116	.. Nozzle, 13/16 Orf X 1-5/8 Lg	1
... 74		◆050115	.. Nozzle, 1/2 Orf X 1-5/8 Lg	1
... 75		050622	.. Nozzle, 5/8 Orf X 1-5/8 Lg	1
... 76		◆000442	.. Nozzle, Spot	1
... 77		◆004466	.. Nozzle, Spot	1
... 78		◆000443	.. Nozzle, Spot Inside Corner	1
... 79		164590	.. Case, Gun RH	1
... 80		183884	.. Spring, Cprsn .240 Od X .026 Wire X 1.000	1
... 81		184101	.. Washer, Shldr .140 Id X .250 Od	1
... 82		135647	.. Nut, 8-32 .33Knrl Brs	3
... 83		162042	.. Contact, Current Pick-Up	1
... 84		134624	.. Bearing, Flg Nyl .140 Id X .187 Od X .375Flg X .031Thk	2

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

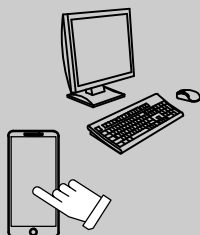
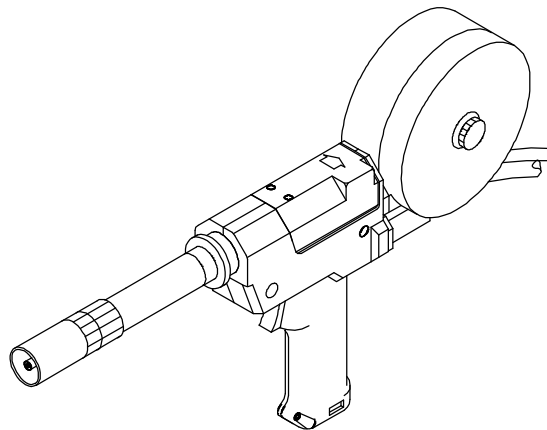


Feeder Gun

Spoolmatic[®] 15A And 30A

PARTS LIST

Eff w/Serial No.
LC259178 Thru LC344600
For OM-1213 (137531) Revisions Q Thru R



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

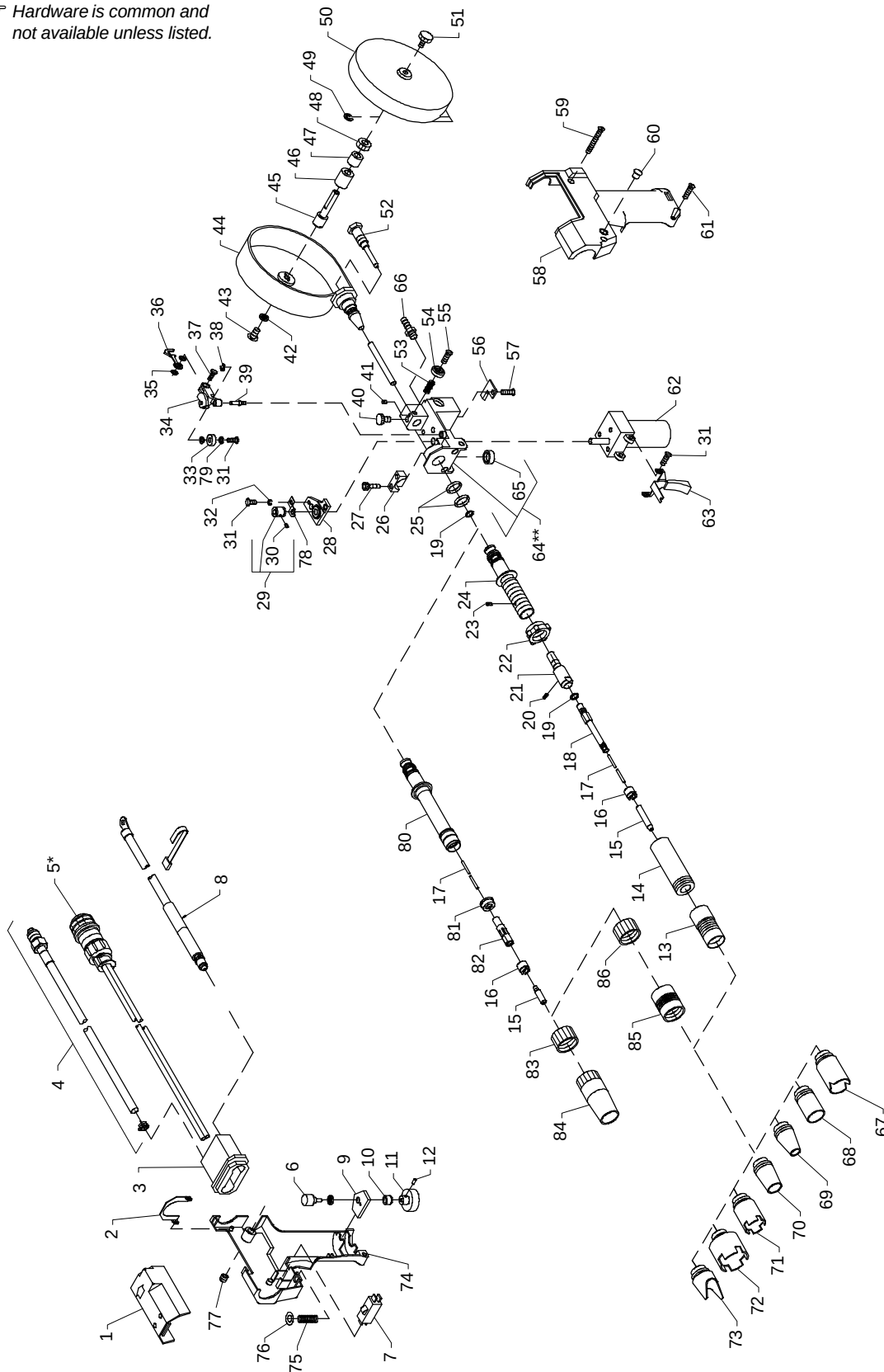
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File: MIG (GMAW)



SECTION 15 – PARTS LIST FOR SERIAL NO. LC259178 THRU LC344600

 Hardware is common and not available unless listed.



*Includes Items 6 & 7
**Includes Item 66

Figure 15-1. Complete Assembly

Ref. 803 348-A

Eff w/Serial No. LC259178 Thru LC344600

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 15-1. Complete Assembly					
1		133479	Cover	1	1
2		135196	Spring, Closure Cover	1	1
3		133362	Strain Relief, Cable	1	1
4		210417	Hose, Gas In	1	
4		182824	Hose, Gas In		1
5		210418	Cable, Control 15 Ft (Includes)	1	
5		204605	Cable, Control 30 Ft (Includes)		1
6	R4	200096	Potentiometer, C Slt'd Sft 1/T .5W 10K Ohm	1	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1	1
		190294	Conn, Circ Ms/Cpc 10 Pin	1	1
		143922	Conn, Circ Cpc Clamp Str Rlf	1	1
8		210416	Cable, Power	1	
8		137479	Cable, Power		1
9		144861	Washer, Anti-Turn	1	1
10		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1	1
11		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1	1
12		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1	1
13		144862	Extension, Nozzle		1
14		156821	Extension, Barrel 2.875 Lg		1
15		◆136171	Tip, Contact .025/31 Wire	1	1
15		◆135427	Tip, Contact .030/36 Wire	1	1
15		◆135428	Tip, Contact .030/41 Wire	1	1
15		◆147314	Tip, Contact .035/41 Wire	1	1
15		135430	Tip, Contact .035/52 Wire	1	1
15		◆135429	Tip, Contact .047/52 Wire	1	1
15		135424	Tip, Contact .047/61 Wire	1	1
15		◆135426	Tip, Contact .062/73 Wire	1	1
15		◆135425	Tip, Contact .062/81 Wire	1	1
		136821	Wrench, Nut Tip Contact	1	1
		166575	Wrench, Hex .078 Across The Flat	1	1
16		136748	Nut, .375-24 .41Dia Stl	1	1
17		136683	Liner, Teflon .045-1/16 Wire X 6.875 Lg		1
17		136682	Liner, Teflon .023-.035 Wire X 6.875 Lg		1
17		193793	Liner, Teflon .023-.040 Wire X 7.188 Lg	1	
17		◆193792	Liner, Teflon .045-1/16 Wire X 7.188 Lg	1	
18		164421	Adapter, Contact Tip		1
19		164485	O-Ring .176 Id X .070Cs	1	2
20		604612	Screw, Set 8-32 X .125 Cup Pt Sch Stl		1
21		164423	Adapter, Tip Head		1
22		058685	Nut, 1.000-8 1.5Knrl Nyl		1
23		602172	Screw, Set 10-32 X .187 Cup Point Sch Stl		1
24		164422	Tube, Head		1
25		134800	O-Ring, .614 Id X .070Cs	2	2
26		133365	Clamp, Head Tube	1	1
27		000417	Screw, 10-24 X1.000 Sochd Hex	2	2
28		162041	Bearing Block Assembly	1	1
		604638	Screw, 6-32 X .375 Sochd Hex	3	3
		143480	Screw, 6-32 X .625 Sochd Hex Stl	1	1
29		136135	Roll, Drive Vk Groove .023-1/16 Wire (Includes)	1	1
29		183357	Roll, Drive Vk Groove .030/.035 Wire (Includes)	1	1
29		183358	Roll, Drive Vk Groove .047/.062 Wire (Includes)	1	1
30		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2	2
31		114045	Screw, 6-32 X .500Hexwhd Slt Stl Slffmg	3	3
32		602198	Washer, Lock .141 Id Stl Split	1	1
33		134623	Bearing, Idler Roll	1	1
34		132852	Arm, Pressure	1	1
35		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2	2
36		133083	Spring, Tension Adj Drive Roll	1	1

Eff w/Serial No. LC259178 Thru LC344600

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 15-1. Complete Assembly (Continued)					
37		144860	Screw, 8-32 X .437Flatd Slit Stl	1	1
38		058968	Ring, Retainer E	1	1
39		135474	Pin, Hinge	1	1
40		155565	Screw, Thumb	1	1
		134799	O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1	1
41		135126	Screw, Set 6-32 X .125 Cup Point Sch Stl	1	1
42		602209	Washer, Tooth .256 Id Stl Intl	1	1
43		602154	Screw, .250-20 X .500Hexhd Stl Slffmg	1	1
44		132527	Canister, Spool	1	1
45		148488	Post, Support Spool	1	1
46		132529	Pad, Brake	1	1
47		148489	Washer, Anti-Turn .380 Id	1	1
48		132524	Nut, .375-24 .56Knrl Alum	1	1
49		000364	Ring, Retainer Ext .145 Shaft Grv X .025Thk	1	1
50		132526	Cover, Spool	1	1
51		132528	Screw, Thumb Canister	1	1
52		132521	Guide, Inlet Canister	1	1
53		112896	Spring, Cprsn .240 Od X .020 Wire X .437	1	1
54		135773	Nut, 8-32 .56Knrl Stl	1	1
55		143360	Screw, 8-32 X .500Panhd Phl Stl	1	1
56		136679	Clamp, Strain Relief	1	1
57		129351	Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1	1
58		164591	Case, Gun Lh	1	1
59		173527	Screw, 8-32 X 1.500	2	2
60		143397	Blank, Snap In Nylon	1	1
61		173528	Screw, 8-32 X .875	1	1
62	B2	161813	Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1	1
63		164592	Trigger	1	1
64		164582	Housing, Wire Drive (Consisting Of)	1	1
65		058262	Cap, Valve	1	1
66		135580	Fitting, Gas	1	1
		146555	Screw, Set 8-32 X .125 Cup Sch	2	2
67		◆009925	Nozzle, Spot Outside Corner .937 Id X 2.375	1	1
68		◆050116	Nozzle, 13/16 Orf X 1-5/8 Lg	1	1
69		◆050115	Nozzle, 1/2 Orf X 1-5/8 Lg	1	1
70		050622	Nozzle, 5/8 Orf X 1-5/8 Lg	1	1
71		◆000442	Nozzle, Spot	1	1
72		◆004466	Nozzle, Spot	1	1
73		◆000443	Nozzle, Spot Inside Corner	1	1
74		164590	Case, Gun Rh	1	1
75		183884	Spring, Cprsn .240 Od X .026 Wire X 1.000	1	1
76		184101	Washer, Shldr .140 Id X .250 Od	1	1
77		135647	Nut, 8-32 .33Knrl Brs	3	3
78		162042	Contact, Current Pick-Up	1	1
79		134624	Bearing, Flg Nyl .140 Id X .187 Od X .375Flg X .031Thk	2	2
80		210509	Head Tube	1	
81		210510	Insulator	1	
82		185110	Adapter, Quick Change	1	
83		185102	Nut, Nozzle Adapter Locking	1	
84		197728	Nozzle, 5/8 Orf X 2-1/2 Lg	1	
84		◆193790	Nozzle, 1/2 Orf X 2-1/2 Lg	1	
		◆193794	Kit, Nozzle Adapter (Includes)		
85		◆193796	Adapter, Nozzle	1	
86		◆193795	Nut, 875-14 1.12 Knrk	1	

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

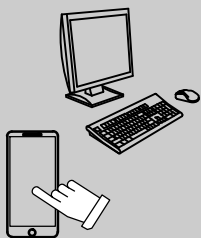
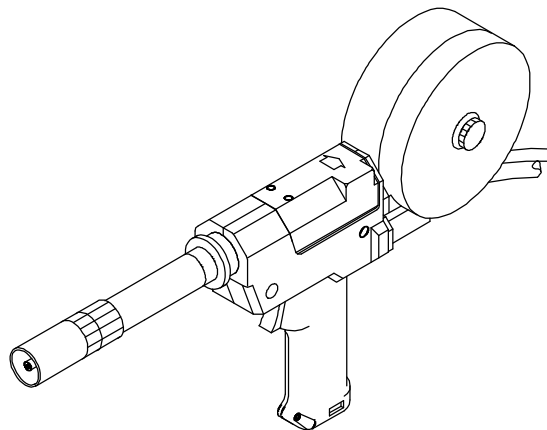


Feeder Gun

Spoolmatic[®] 15A And 30A

PARTS LIST

Eff w/Serial No.
LC344601 Thru LC478841
For OM-1213 (137531) Revisions S Thru T



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

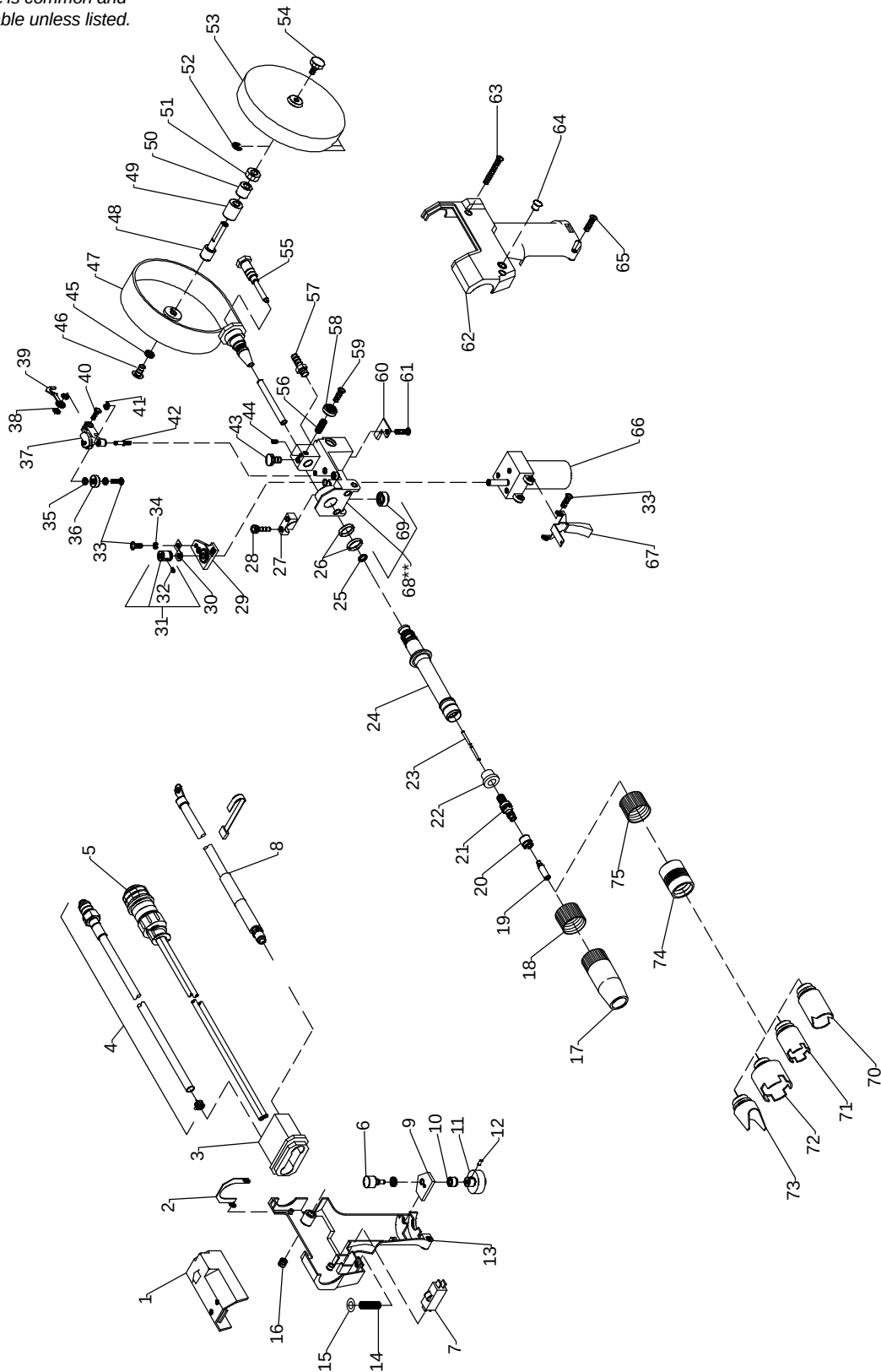
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File: MIG (GMAW)



SECTION 16 – PARTS LIST FOR SERIAL NO. LC344601 THRU LC478841

 Hardware is common and
not available unless listed.



*Includes Items 6 & 7
**Includes Item 57

Figure 16-1. Complete Assembly

Ref. 803 348-C

Eff w/Serial No. LC344601 Thru LC478841

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 16-1. Complete Assembly					
1		133479	Cover	1	1
2		135196	Spring, Closure Cover	1	1
3		133362	Strain Relief, Cable	1	1
4		210417	Hose, Gas In	1	
4		182824	Hose, Gas In		1
5		210418	Cable, Control 15 Ft (Includes)	1	
5		204605	Cable, Control 30 Ft (Includes)		1
6	R4	200096	Potentiometer, C Slt Sft 1/T .5W 10K Ohm	1	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1	1
		190294	Conn, Circ Ms/Cpc 10 Pin	1	1
		143922	Conn, Circ Cpc Clamp Str Rlf	1	1
8		210416	Cable, Power	1	
8		137479	Cable, Power		1
9		144861	Washer, Anti-Turn	1	1
10		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1	1
11		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1	1
12		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1	1
13		164590	Case, Gun Rh	1	1
14		183884	Spring, Cprsn .240 Od X .026 Wire X 1.000	1	1
15		184101	Washer, Shldr .140 Id X .250 Od	1	1
16		135647	Nut, 8-32 .33Knrl Brs	3	3
17		197728	Nozzle, 5/8 Orf X 2-1/2	1	1
17		◆193790	Nozzle, 1/2 Orf X 2-1/2	1	1
18		185102	Nut, Nozzle Adapter Locking	1	1
19		◆136171	Tip, Contact .025/31 Wire	1	1
19		◆135427	Tip, Contact .030/36 Wire	1	1
19		◆135428	Tip, Contact .030/41 Wire	1	1
19		◆147314	Tip, Contact .035/41 Wire	1	1
19		135430	Tip, Contact .035/52 Wire	1	1
19		◆135429	Tip, Contact .047/52 Wire	1	1
19		135424	Tip, Contact .047/61 Wire	1	1
19		◆135426	Tip, Contact .062/73 Wire	1	1
19		◆135425	Tip, Contact .062/81 Wire	1	1
		136821	Wrench, Nut Tip Contact	1	1
		166575	Wrench, Hex .078 Across The Flat	1	1
20		136748	Nut, .375-24 .41Dia Stl	1	1
21		185110	Adapter, Quick Change	1	1
22		210510	Insulator, Barrel Pistol (Prior to LC408323)	1	1
22		185097	Insulator, Contact Tip Adapter (Eff w/LC408323)	1	1
23		193793	Liner, Teflon .023-.040 Wire X 7.188 Lg	1	1
23		◆193792	Liner, Teflon .045-1/16 Wire X 7.188 Lg	1	1
24		210509	Head Tube	1	1
25		164485	O-Ring .176 Id X .070Cs	1	1
26		134800	O-Ring, .614 Id X .070Cs	2	2
27		133365	Clamp, Head Tube	1	1
28		000417	Screw, 10-24 X1.000 Sochd Hex	2	2
29		162041	Bearing Block Assembly	1	1
		604638	Screw, 6-32 X .375 Sochd Hex	3	3
		143480	Screw, 6-32 X .625 Sochd Hex Stl	1	1
30		162042	Contact, Current Pick-Up	1	1
31		136135	Roll, Drive Vk Groove .023-1/16 Wire (Includes)	1	1
31		183357	Roll, Drive Vk Groove .030/.035 Wire (Includes)	1	1
31		183358	Roll, Drive Vk Groove .047/.062 Wire (Includes)	1	1
32		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2	2
33		114045	Screw, 6-32 X .500Hexwhd Slt Stl Slffmg	3	3
34		602198	Washer, Lock .141 Id Stl Split	1	1
35		134624	Washer, Shldr.140id 0.187odx.094T .375odx.031T Nyl	2	2
36		134623	Bearing, Idler Roll	1	1

Eff w/Serial No. LC344601 Thru LC478841

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 16-1. Complete Assembly (Continued)				
... 37		132852	.. Arm, Pressure	1 1
... 38		605798	.. Washer, Shldr Nyl .375 Od X .168 Id X .080	2 2
... 39		133083	.. Spring, Tension Adj Drive Roll	1 1
... 40		144860	.. Screw, 8-32 X .437Flatd Slit Stl	1 1
... 41		058968	.. Ring, Retainer E	1 1
... 42		135474	.. Pin, Hinge	1 1
... 43		155565	.. Screw, Thumb	1 1
		134799	.. O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1 1
... 44		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1 1
... 45		602209	.. Washer, Tooth .256 Id Stl Intl	1 1
... 46		602154	.. Screw, .250-20 X .500Hexhd Stl Slffmg	1 1
... 47		132527	.. Canister, Spool	1 1
... 48		148488	.. Post, Support Spool	1 1
... 49		132529	.. Pad, Brake	1 1
... 50		148489	.. Washer, Anti-Turn .380 Id	1 1
... 51		132524	.. Nut, .375-24 .56Knrl Alum	1 1
... 52		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025Thk	1 1
... 53		132526	.. Cover, Spool	1 1
... 54		132528	.. Screw, Thumb Canister	1 1
... 55		132521	.. Guide, Inlet Canister	1 1
... 56		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	1 1
... 57		135580	.. Fitting, Gas	2 2
		146555	.. Screw, Set 8-32 X .125 Cup Sch	1 1
... 58		135773	.. Nut, 8-32 .56Knrl Stl	1 1
... 59		143360	.. Screw, 8-32 X .500Panhd Phl Stl	1 1
... 60		136679	.. Clamp, Strain Relief	1 1
... 61		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1 1
... 62		164591	.. Case, Gun Lh	1 1
... 63		173527	.. Screw, 8-32 X 1.500	2 2
... 64		143397	.. Blank, Snap In Nylon	1 1
... 65		173528	.. Screw, 8-32 X .875	1 1
... 66	B2	161813	.. Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1 1
... 67		164592	.. Trigger	1 1
... 68		164582	.. Housing, Wire Drive (Includes)	1 1
... 69		058262	.. Cap, Valve	1 1
... 70		◆009925	.. Nozzle, Spot Outside Corner .937 Id X 2.375	1 1
... 71		◆000442	.. Nozzle, Spot	1 1
... 72		◆004466	.. Nozzle, Spot	1 1
... 73		◆000443	.. Nozzle, Spot Inside Corner	1 1
		◆193794	.. Kit, Nozzle Adapter (Includes)	
... 74		◆193796	.. Adapter, Nozzle	1 1
... 75		◆193795	.. Nut, 875-14 1.12Knrl	1 1

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

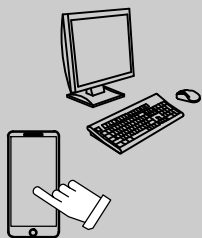
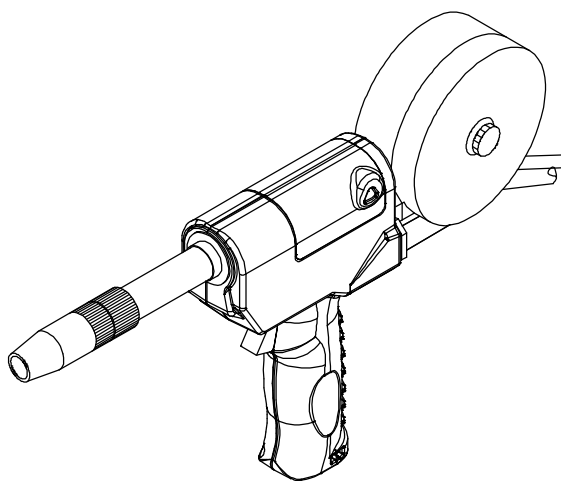


Feeder Gun

Spoolmatic[®] 15A And 30A

PARTS LIST

Eff w/Serial No.
LC478842 Thru LE239242
For OM-1213 (137531) Revisions U Thru V



For product information,
Owner's Manual translations,
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File: MIG (GMAW)



SECTION 17 – PARTS LIST FOR SERIAL NO. LC478842 THRU LE239242

 Hardware is common and
not available unless listed.

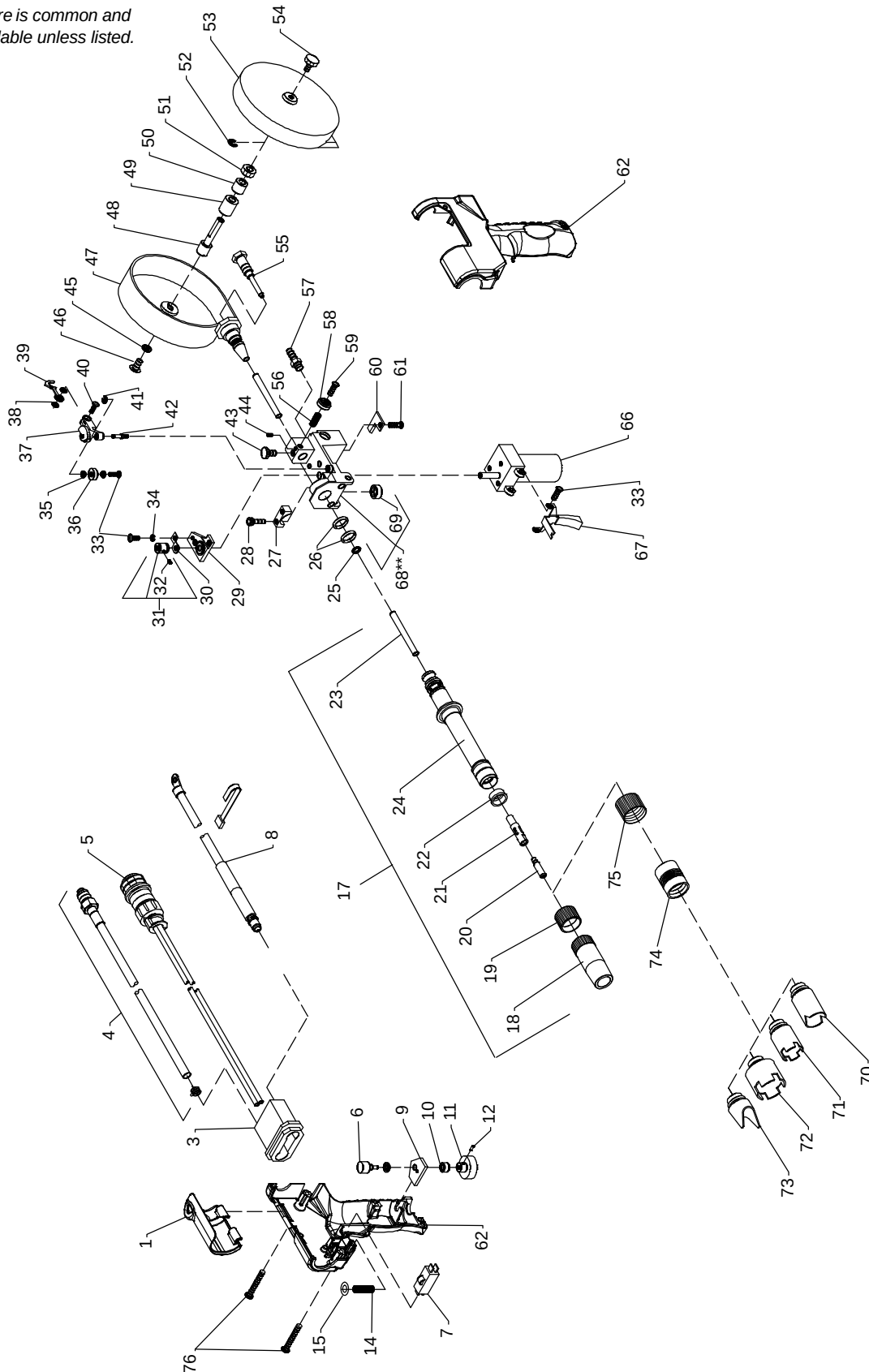


Figure 17-1. Complete Assembly

*Includes Items 6 & 7
**Includes Item 57

Ref. 803 348-D

Eff w/Serial No. LC478842 Thru LE239242

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 17-1. Complete Assembly					
... 1		133479	Cover (Prior To LE069022)	1	1
... 1		214745	Cover (Eff w/LE069022)	1	1
... 2		135196	Spring, Closure Cover	1	1
... 3		133362	Strain Relief, Cable	1	1
... 4		210417	Hose, Gas In	1	
... 4		182824	Hose, Gas In		1
... 5		210418	Cable, Control 15 Ft (Includes)	1	
... 5		204605	Cable, Control 30 Ft (Includes)		1
... 6	R4	200096	Potentiometer, C Slt'd Sft 1/T .5W 10K Ohm	1	1
... 7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1	1
		190294	Conn, Circ Ms/Cpc 10 Pin	1	1
		143922	Conn, Circ Cpc Clamp Str Rlf	1	1
... 8		210416	Cable, Power	1	
... 8		137479	Cable, Power		1
... 9		144861	Washer, Anti-Turn	1	1
... 10		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1	1
... 11		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1	1
... 12		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1	1
... 13		164590	Case, Gun Rh	1	1
... 14		183884	Spring, Cprsn .240 Od X .026 Wire X 1.000	1	1
... 15		184101	Washer, Shldr .140 Id X .250 Od	1	1
... 16		135647	Nut, 8-32 .33Knrl Brs	3	3
... 17		210646	Barrel Assy, Air Cooled Pistol (Eff W/LE069022)	1	1
... 18		197728	Nozzle, 5/8 Orf X 2-1/2	1	1
... 19		185102	Nut, Nozzle Adapter Locking	1	1
... 20		206176	Tip, Fastip .281 Od .030 Wire	1	1
... 20		206177	Tip, Fastip .281 Od .035 And .030Al Wires	1	1
... 20		206178	Tip, Fastip .281 Od .040 And .035Al Wires	1	1
... 20		206179	Tip, Fastip .281 Od .045 And .040Al Wires	1	1
... 20		206180	Tip, Fastip .281 Od .052 And 3/64Al Wires	1	1
... 20		206181	Tip, Fastip .281 Od 1/16 Wire	1	1
... 21		209875	Diffuser, Fastip Slotted	1	1
... 22		185097	Insulator, Contact Tip Adapter	1	1
... 23		212156	Liner, Phos Bronze .030-1/16 Wire X 7.313	1	1
... 24		210511	Head Tube	1	1
... 25		164485	O-Ring .176 Id X .070Cs	1	1
... 26		134800	O-Ring, .614 Id X .070Cs	2	2
... 27		133365	Clamp, Head Tube	1	1
... 28		000417	Screw, 10-24 X1.000 Sochd Hex	2	2
... 29		162041	Bearing Block Assembly	1	1
		604638	Screw, 6-32 X .375 Sochd Hex	3	3
		143480	Screw, 6-32 X .625 Sochd Hex Stl	1	1
... 30		162042	Contact, Current Pick-Up	1	1
... 31		136135	Roll, Drive Vk Groove .023-1/16 Wire (Includes)	1	1
... 31		183357	Roll, Drive Vk Groove .030/.035 Wire (Includes)	1	1
... 31		183358	Roll, Drive Vk Groove .047/.062 Wire (Includes)	1	1
... 32		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2	2
... 33		114045	Screw, 6-32 X .500Hexwhd Slt Stl Slffmg	3	3
... 34		602198	Washer, Lock .141 Id Stl Split	1	1
... 35		134624	Washer, Shldr.140id 0.187odx.094T .375odx.031T Nyl	2	2
... 36		134623	Bearing, Idler Roll	1	1
... 37		132852	Arm, Pressure	1	1

Eff w/Serial No. LC478842 Thru LE239242

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 17-1. Complete Assembly (Continued)				
... 38		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2 2
... 39		133083	Spring, Tension Adj Drive Roll	1 1
... 40		144860	Screw, 8-32 X .437Flatd Slit Stl	1 1
... 41		058968	Ring, Retainer E	1 1
... 42		135474	Pin, Hinge	1 1
... 43		155565	Screw, Thumb	1 1
...		134799	O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1 1
... 44		135126	Screw, Set 6-32 X .125 Cup Point Sch Stl	1 1
... 45		602209	Washer, Tooth .256 Id Stl Intl	1 1
... 46		602154	Screw, .250-20 X .500Hexhd Stl Slffmg	1 1
... 47		132527	Canister, Spool	1 1
... 48		148488	Post, Support Spool	1 1
... 49		132529	Pad, Brake	1 1
... 50		148489	Washer, Anti-Turn .380 Id	1 1
... 51		132524	Nut, .375-24 .56Knrl Alum	1 1
... 52		000364	Ring, Retainer Ext .145 Shaft Grv X .025Thk	1 1
... 53		132526	Cover, Spool	1 1
... 54		132528	Screw, Thumb Canister	1 1
... 55		132521	Guide, Inlet Canister	1 1
... 56		112896	Spring, Cprsn .240 Od X .020 Wire X .437	1 1
... 57		135580	Fitting, Gas	2 2
...		146555	Screw, Set 8-32 X .125 Cup Sch	1 1
... 58		135773	Nut, 8-32 .56Knrl Stl	1 1
... 59		143360	Screw, 8-32 X .500Panhd Phl Stl	1 1
... 60		136679	Clamp, Strain Relief	1 1
... 61		129351	Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1 1
... 62		164591	Case, Gun Lh (Prior To LE069022)	1 1
... 62		214743	Case, Gun Lh/Rh (Eff w/LE069022)	1 1
... 63		173527	Screw, 8-32 X 1.500	2 2
... 64		143397	Blank, Snap In Nylon	1 1
... 65		173528	Screw, 8-32 X .875	1 1
... 66	B2	161813	Motor, Gear Pm 24VDC 420RPM 10.2:1 Ratio	1 1
... 67		164592	Trigger	1 1
... 68		164582	Housing, Wire Drive (Includes)	1 1
... 69		058262	Cap, Valve	1 1
... 70		◆009925	Nozzle, Spot Outside Corner .937 Id X 2.375	1 1
... 71		◆000442	Nozzle, Spot	1 1
... 72		◆004466	Nozzle, Spot	1 1
... 73		◆000443	Nozzle, Spot Inside Corner	1 1
...		◆193794	Kit, Nozzle Adapter (Includes)	
... 74		◆193796	Adapter, Nozzle	1 1
... 75		◆193795	Nut, 875-14 1.12Knrl	1 1
... 76		217934	Screw, K40x 20 Pan Hd-trx Stl Pld Pt (Eff w/LE069022)	4 4

◆OPTIONAL

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.



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

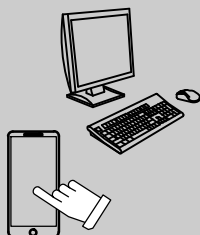
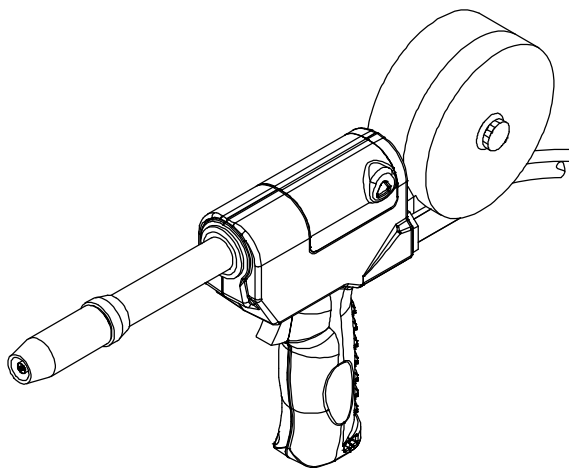


Feeder Gun

Spoolmatic[®] 15A And 30A

PARTS LIST

Eff w/Serial No.
LE239243 Thru LJ210300V
For OM-1213 (137531) Revisions W Thru AB



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File: MIG (GMAW)



SECTION 18 – PARTS LIST FOR SERIAL NO. LE239243 THRU LJ210300V

 Hardware is common and
not available unless listed.

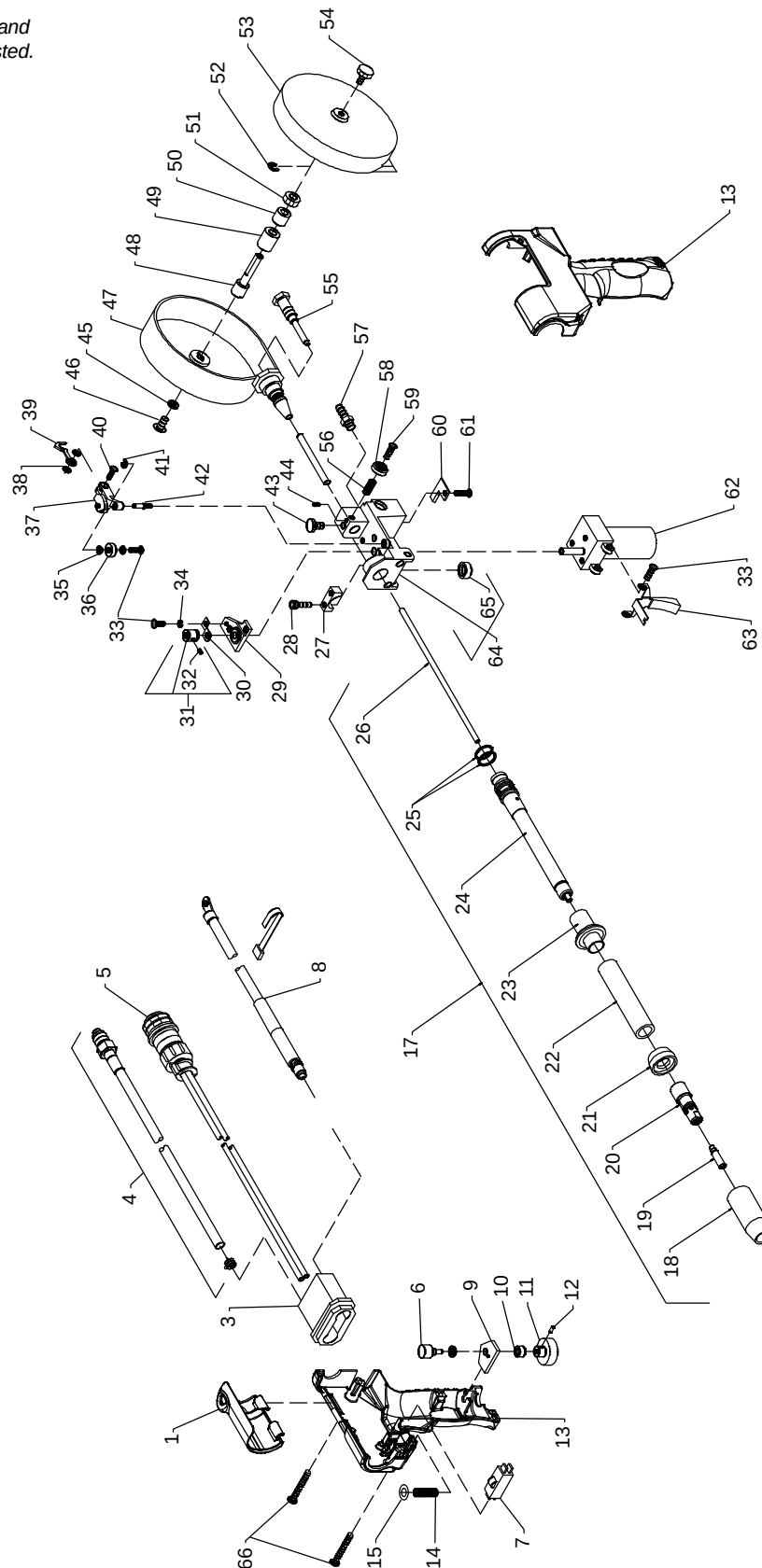


Figure 18-1. Complete Assembly

Ref. 803 348-G

Eff w/Serial No. LE239243 Thru LJ210300V

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 18-1. Complete Assembly					
1		214745	Cover (Included With Item 13)	1	1
2		Deleted			
3		133362	Strain Relief, Cable	1	1
4		210417	Hose, Gas In	1	
4		182824	Hose, Gas In		1
5		210418	Cable, Control 15 Ft (Includes)	1	
5		204605	Cable, Control 30 Ft (Includes)		1
6	R4	200096	Potentiometer, C Slt Sft 1/T .5W 10K Ohm	1	1
7	PB1	000369	Switch, Lim 10A 125/250VAC DPST Plgr	1	1
		190294	Conn, Circ Ms/Cpc 10 Pin	1	1
		143922	Conn, Circ Cpc Clamp Str Rlf	1	1
8		210416	Cable, Power	1	
8		137479	Cable, Power		1
9		144861	Washer, Anti-turn	1	1
10		135127	Lock, Shaft Pot .250-32 X .125 Dia Shaft	1	1
11		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1	1
12		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1	1
13		214743	Case, Gun Lh/Rh (Molded Halves) (Prior To LE265422)	1	1
13		220658	Case, Gun Lh/Rh (Molded Halves) (Eff W/LE265422)	1	1
14		183884	Spring, Cprsn .240 Od X .026 Wire X 1.000	1	1
15		184101	Washer, Shldr .140 Id X .250 Od	1	1
16		Deleted			
17		219793	Barrel Assy, Air Cooled Pistol (Includes) (Prior To LG442231W)	1	1
17		231531	Head Tube Assy, Air Cooled Pistol Hd (Includes) (Eff W/LG442231W)	1	1
18		199613	Nozzle, Brass 5/8 In Orifice Tapered	1	1
19			Tip, Fastip (See Section 19)	1	1
20		206195	Diffuser, .281/.312 Od Fastip 1/8 Tip Recess (Prior To LG442231W)	1	1
20		227749	Diffuser, .281/.312 Od Collar Fastip 1/8 Rec Edge/Spool (Eff W/LG442231W)	1	1
21		198856	Insulator, Nozzle (Prior To LG490001W)	1	1
21		232284	Insulator, Nozzle Collared Diffuser (Eff W/LG490001W)	1	1
22		219794	Jacket, Outer Insulating	1	1
23		219795	Insulator, Barrel Pistol	1	1
24		219796	Head Tube, Air Pistol (Brazed)	1	1
25		134800	O-Ring, .614 Id X .070Cs	2	2
26		212156	Liner, Phos Bronze .030-1/16 Wire X 7.313	1	1
27		133365	Clamp, Head Tube	1	1
28		000417	Screw, 10-24 X1.000Sochd Hex	2	2
29		162041	Bearing Block Assembly	1	1
		604638	Screw, 6-32 X .375Sochd Hex	3	3
		143480	Screw, 6-32 X .625Sochd Hex Stl	1	1
30		162042	Contact, Current Pick-up	1	1
31		136135	Roll, Drive VK Groove .023-1/16 Wire (Includes)	1	1
31		183357	Roll, Drive VK Groove .030/.035 Wire (Includes)	1	1
31		183358	Roll, Drive VK Groove .047/.062 Wire (Includes)	1	1
32		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2	2
33		114045	Screw, 6-32 X .500Hexwhd Slt Stl Slffmg	3	3
34		602198	Washer, Lock .141 Id Stl Split	1	1
35		134624	Washer, Shldr.140id 0.187odx.094T .375odx.031T Nyl	2	2
36		134623	Bearing, Idler Roll	1	1
37		132852	Arm, Pressure	1	1
38		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2	2
39		133083	Spring, Tension Adj Drive Roll	1	1
40		144860	Screw, 8-32 X .437Flatd Slt Stl	1	1

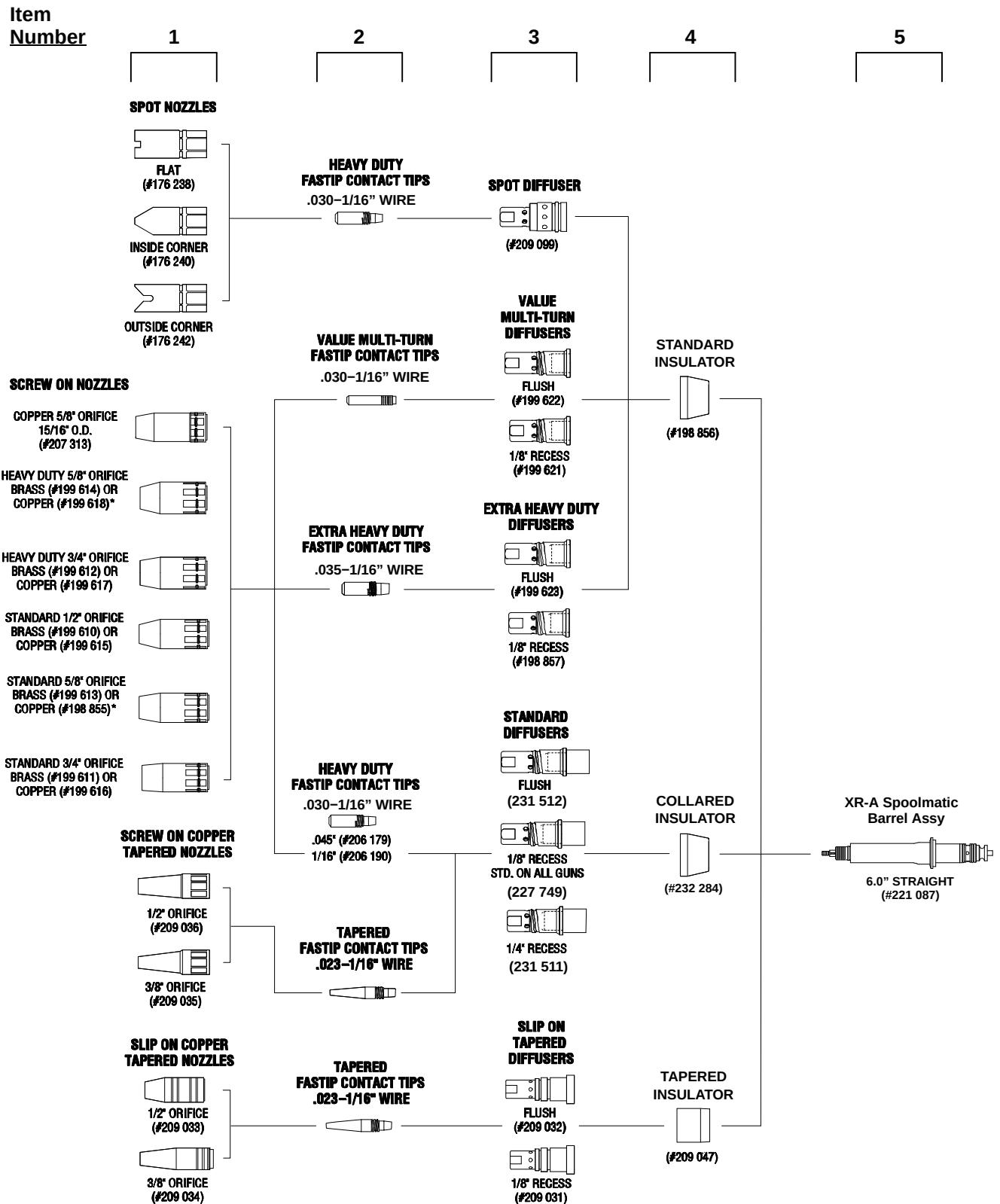
Eff w/Serial No. LE239243 Thru LJ210300V

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 18-1. Complete Assembly (Continued)				
... 41		058968	.. Ring, Retainer E	1 1
... 42		135474	.. Pin, Hinge	1 1
... 43		155565	.. Screw, Thumb	1 1
...		134799	.. O-Ring, .176 Id X .070Cs (Used W/Thumbscrew)	1 1
... 44		135126	.. Screw, Set 6-32 X .125 Cup Point Sch Stl	1 1
... 45		602209	.. Washer, Tooth .256 Id Stl Intl	1 1
... 46		602154	.. Screw, .250-20 X .500Hexhd Stl Slffmg	1 1
... 47		132527	.. Canister, Spool	1 1
... 48		148488	.. Post, Support Spool	1 1
... 49		132529	.. Pad, Brake	1 1
... 50		148489	.. Washer, Anti-Turn .380 Id	1 1
... 51		132524	.. Nut, .375-24 .56Knrl Alum	1 1
... 52		000364	.. Ring, Retainer Ext .145 Shaft Grv X .025Thk	1 1
... 53		132526	.. Cover, Spool	1 1
... 54		132528	.. Screw, Thumb Canister	1 1
... 55		132521	.. Guide, Inlet Canister	1 1
... 56		112896	.. Spring, Cprsn .240 Od X .020 Wire X .437	1 1
... 57		135580	.. Fitting, Gas	2 2
...		146555	.. Screw, Set 8-32 X .125 Cup Sch	1 1
... 58		135773	.. Nut, 8-32 .56Knrl Stl	1 1
... 59		143360	.. Screw, 8-32 X .500Pan Hd Phl Stl	1 1
... 60		136679	.. Clamp, Strain Relief	1 1
... 61		129351	.. Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1 1
... 62	B2	161813	.. Motor, Gear Pm 24 VDC 420 RPM 10.2:1 Ratio	
...			(Prior To LG360912W)	1 1
... 62	B2	230947	.. Motor, Gear PM 24 VDC 420 RPM 10.2:1 Ratio	
...			(Eff W/LG360912W)	1 1
... 63		164592	.. Trigger	1 1
... 64		164582	.. Housing, Wire Drive (Includes)	1 1
... 65		058262	.. Cap, Valve	1 1
... 66		217934	.. Screw, K40x 20 Pan Hd-Trx Stl Pld Pt Thread Forming	4 4

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. LE239243 Thru LJ210300V

SECTION 19 – PARTS LIST INCLUDING CONSUMABLES



Ref. 803 909-A / 803 932 / 803 933 / 803 934

Figure 19-1. Consumables Flowchart

Eff w/Serial No. LE239243 Thru LJ210300V

Item No.	Part No.	Description	Quantity
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Figure 19-1. Consumables Flowchart

Table 19-1. Nozzles

... 1	◆176238	.. Nozzle, Spot Flat (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆176240	.. Nozzle, Spot Inside Corner (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆176242	.. Nozzle, Spot Outside Corner (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆199610	.. Nozzle, Screw On Brass 1/2 in Orifice	1
... 1	◆199611	.. Nozzle, Screw On Brass 3/4 in Orifice Straight	1
... 1	◆199612	.. Nozzle, Screw On Brass 3/4 in Orifice Straight Heavy Duty	1
... 1	◆199613	.. Nozzle, Screw On Brass 5/8 in Orifice	1
... 1	◆199614	.. Nozzle, Screw On Brass 5/8 in Orifice Heavy Duty	1
... 1	◆199615	.. Nozzle, Screw On Copper 1/2 in Orifice	1
... 1	◆199616	.. Nozzle, Screw On Copper 3/4 in Orifice	1
... 1	◆199617	.. Nozzle, Screw On Copper 3/4 in Orifice Heavy Duty	1
... 1	198855	.. Nozzle, Screw On Copper 5/8 in Orifice	1
... 1	199618	.. Nozzle, Screw On Copper 5/8 in Orifice Heavy Duty	1
... 1	◆207313	.. Nozzle, Screw On Copper 5/8 in Orifice 15/16 OD	1
... 1	◆209033	.. Nozzle, Slip On Copper 1/2 in Orifice Tapered (Requires Diffuser 209031 Or 209032 And Insulator 209047, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209034	.. Nozzle, Slip On Copper 3/8 in Orifice Tapered (Requires Diffuser 209031 Or 209032 And Insulator 209047, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209035	.. Nozzle, Screw On Copper 3/8 in Orifice Tapered (Requires Diffuser 227 747, 231 511 Or 231 512, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209036	.. Nozzle, Screw On Copper 1/2 in Orifice Tapered (Requires Diffuser 227 747, 231 511 Or 231 512, Used With Any Tapered FasTip™ Contact Tip)	1

Table 19-2. Heavy Duty FasTip™ Contact Tips*

... 2	◆206185	.. .030 in (0.8 mm)	1
... 2	◆206186	.. .035 in (0.9 mm)	1
... 2	◆206187	.. .040 in (1.0 mm) or .035 in (0.9 mm) Aluminum Wire	1
... 2	206188	.. .045 in (1.2 mm)	1
... 2	◆206189	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) Aluminum Wire	1
... 2	206190	.. 1/16 in (1.6 mm)	1
... 2	◆206191	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) Aluminum Wire	1

Table 19-3. Extra Heavy Duty FasTip™ Contact Tips*

... 2	◆199605	.. .035 in (0.9 mm)	1
... 2	◆199606	.. .040 in (1.0 mm) or .035 in (0.9 mm) Aluminum	1
... 2	◆198851	.. .045 in (1.2 mm)	1
... 2	◆198852	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) Aluminum Wire	1
... 2	◆198853	.. 1/16 in (1.6 mm)	1
... 2	◆198854	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) Aluminum Wire	1

Table 19-4. Tapered FasTip™ Contact Tips*

... 2	◆209025	.. .030 in (0.8 mm)	1
... 2	◆209026	.. .035 in (0.9 mm)	1
... 2	◆209027	.. .045 in (1.2 mm)	1
... 2	◆209028	.. 3/64 in (1.2 mm)	1
... 2	◆209029	.. .052 in (1.3 mm)	1
... 2	◆209030	.. 1/16 in (1.6 mm)	1

Eff w/Serial No. LE239243 Thru LJ210300V

Item No.	Part No.	Description	Quantity
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Figure 19-1. Consumables Flowchart (Continued)

Table 19-5. Value Multi-Turn Contact Tips*

... 2	♦071825	.. .030 in (0.9 mm)	1
... 2	♦054202	.. .035 in (0.9 mm)	1
... 2	♦054201	.. .045 in (1.2 mm)	1
... 2	♦199593	.. .3/64 in (1.2 mm) Aluminum Wire	1
... 2	♦044006	.. .052 in (1.3 mm)	1
... 2	♦047566	.. 1/16 in (1.6 mm)	1
... 2	♦202933	.. 1/16 in (1.6 mm) Aluminum Wire	1

Table 19-6. Gas Diffusers

... 3	♦198857	.. 1/8 in Tip Recess – For Extra Heavy Duty FasTip Contact Tips	1
... 3	♦199623	.. Flush Tip – For Extra Heavy Duty FasTip Contact Tips	1
... 3	♦199621	.. 1/8 in Tip Recess – For Value Multi-Turn Contact Tips	1
... 3	♦199622	.. Flush Tip – For Value Multi-Turn Contact Tips	1
... 3	227749	.. 1/8 in Tip Recess – For Heavy Duty FasTip Contact Tips (Standard On All Guns)	1
... 3	♦231511	.. 1/4 in Tip Recess – For Heavy Duty FasTip Contact Tips	1
... 3	♦231512	.. Flush Tip – For Heavy Duty FasTip Contact Tips	1
... 3	♦209031	.. Slip On Recessed Diffuser (Requires Nozzle 209033 Or 209034 And Insulator 209047, Used With Any Tapered FasTip Contact Tip)	1
... 3	♦209032	.. Slip On Flush Diffuser (Requires Nozzle 209033 Or 209034 And Insulator 209047, Used With Any Tapered FasTip Contact Tip)	1
... 3	♦209099	.. Spot Diffuser (Requires Spot Nozzle 176238 Or 176240 Or 176242)	1

Table 19-7. Insulators

... 4	232284	.. Insulator, Nozzle Collared Diffuser	1
... 4	198856	.. Insulator, Rubber	1
... 4	209047	.. Insulator, Teflon (Required When Using Diffuser 209031 Or 209032 With Nozzle 209033 Or 209034)	1

Table 19-8. Barrel Assemblies

... 5	221087	.. Barrel Assy, Air Cooled Pistol	1
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Table 19-9. Head Tube Assemblies

...	231523	.. Kit, Head Tube Assy Air Cooled Pistol	1
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♦OPTIONAL

*All contact tips are packaged in bags of 25.

BE SURE TO PROVIDE MODEL WHEN ORDERING REPLACEMENT PARTS.

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



Spoolmatic 15A And 30A



TM-1213Q

2017-09

Processes



MIG (GMAW) Welding

Description

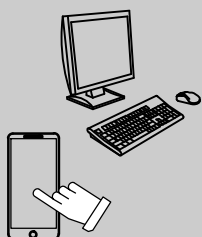
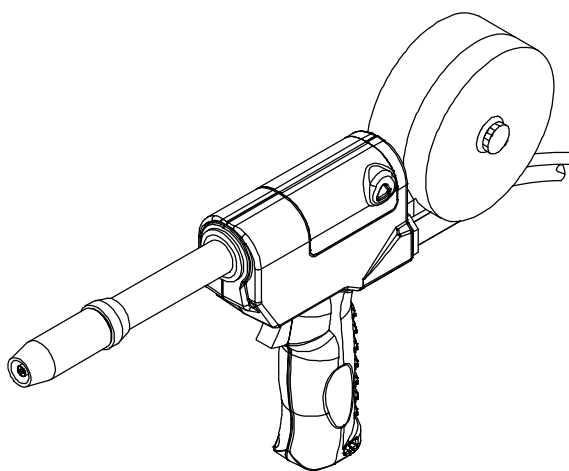


Feeder Gun

Spoolmatic[®] 15A And 30A

PARTS LIST

Eff w/Serial No.
LJ210301V And Following
For OM-1213 (137531) Revisions AC Thru AQ



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

www.MillerWelds.com

File: MIG (GMAW)



SECTION 20 – PARTS LIST FOR SERIAL NO. LJ210301V AND FOLLOWING

 Hardware is common and
not available unless listed.

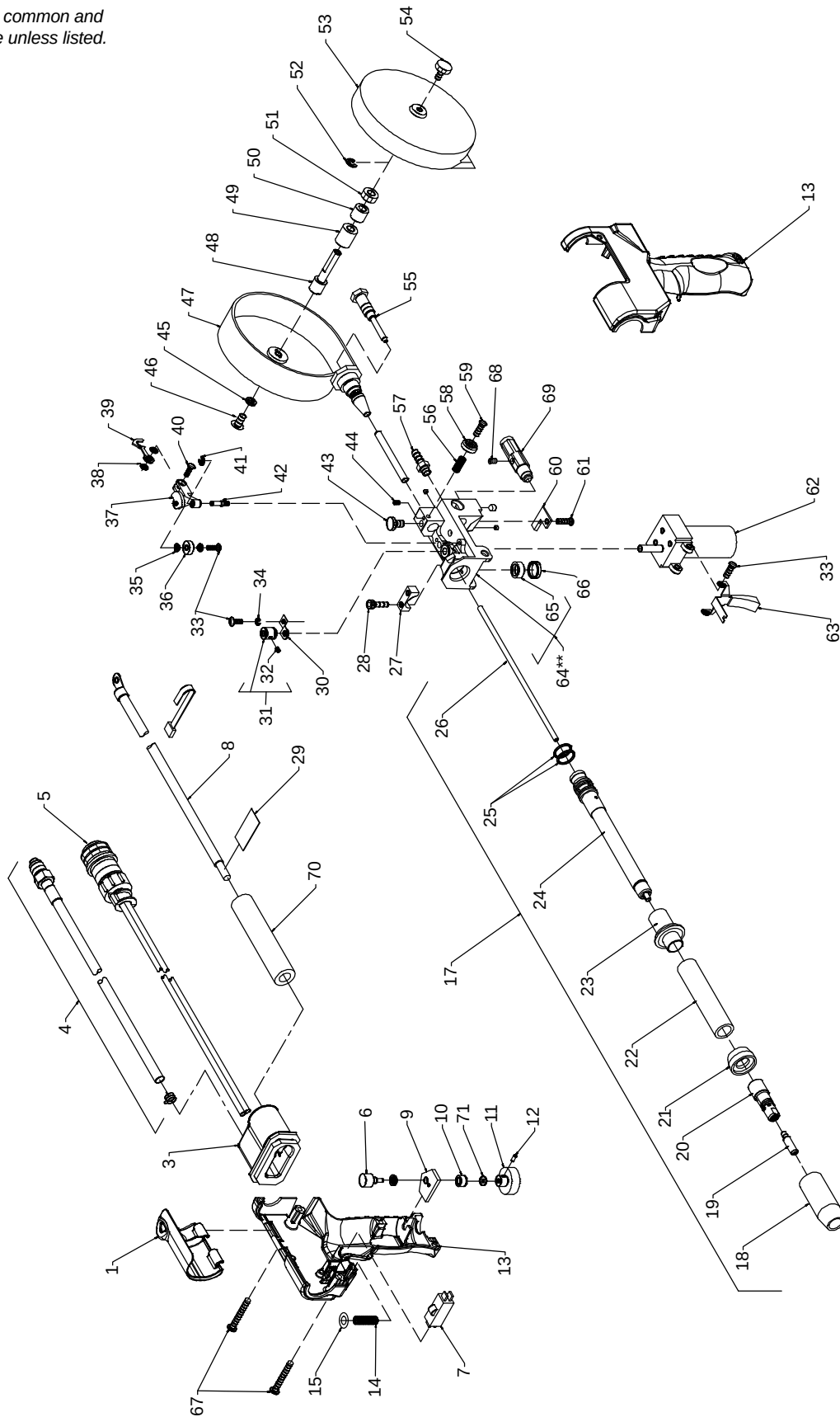


Figure 20-1. Complete Assembly

Ref. T0072-A

Eff w/Serial No. LJ210301V And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity	
				Model	
				15A	30A
Figure 20-1. Complete Assembly					
1		214745	Cover (Included With Item 13)	1	1
2		Deleted			
3		133362	Strain Relief, Cable (Prior to MF430268T)	1	1
3		M1570	Strain Relief, Cable (Eff w/MF430268T)	1	1
4		210417	Hose, Gas In	1	
4		182824	Hose, Gas In		1
5		210418	Cable, Control 15 Ft (Includes) (Prior to MF480197T)	1	
5		M1587	Cable, Control 15 Ft, No Ins. Sleeve (Includes) (Eff w/MF480197T)	1	
5		204605	Cable, Control 30 Ft (Includes) (Prior to MF480197T)		1
5		M1588	Cable, Control 30 Ft, No Ins. Sleeve (Includes) (Eff w/MF480197T)		1
6	R4	200096	Potentiometer, C Slted Sft 1/T .5W 10K Ohm	1	1
7	PB1	000369	Switch, Lim 10A 125/250VAC Dpst Plgr	1	1
		190294	Conn, Circ Ms/Cpc 10 Pin	1	1
		143922	Conn, Circ Cpc Clamp Str Rlf	1	1
8		235689	Cable, Power	1	
8		235690	Cable, Power		1
9		144861	Washer, Anti-turn	1	1
10		135127	Lock, Shaft Pot .250-32 X .125Dia Shaft	1	1
11		134856	Knob, Speed Control 1-10 .140 Shaft X 1.125 Od	1	1
12		602169	Screw, Set Stl Sch 8-32 X .187 Cup Pt	1	1
13		220658	Case, Gun Lh/Rh (Molded Halves)	1	1
14		183884	Spring, Cprsn .240 Od X .026 Wire X 1.000	1	1
15		184101	Washer, Shldr .140 Id X .250 Od	1	1
16		Deleted			
17		231531	Head Tube Assy, Air Cooled Pistol (Includes)	1	1
18		199613	Nozzle, Brass 5/8 In Orifice Tapered	1	1
19			Tip, Fastip (See Section 19)	1	1
20		227749	Diffuser, .281/.312 Od Collar Fastip 1/8 Rec	1	1
21		232284	Insulator, Nozzle Collared Diffuser	1	1
22		219794	Jacket, Outer Insulating	1	1
23		219795	Insulator, Barrel Pistol	1	1
24		219796	Head Tube, Air Pistol (Brazed)	1	1
25		134800	O-ring, .614 Id X .070Cs	2	2
26		212156	Liner, Phos Bronze .030-1/16 Wire X 7.313	1	1
27		133365	Clamp, Head Tube	1	1
28		000417	Screw, 10-24 X1.000Sochd Hex	2	2
29		235225	Strip, Cop .010 X 1.500 X .750	1	1
		604638	Screw, 6-32 X .375Sochd Hex	3	3
30		162042	Contact, Current Pick-up (Prior To LJ440805V)	1	1
30		209342	Kit, Current Pick-up (Eff w/LJ440805V)	1	1
31		136135	Roll, Drive Vk Groove .023-1/16 Wire (Includes)	1	1
31		183357	Roll, Drive Vk Groove .030/.035 Wire (Includes)	1	1
31		183358	Roll, Drive Vk Groove .047/.062 Wire (Includes)	1	1
32		604612	Screw, Set Stl Sch 8-32 X .125 Cup Point	2	2
33		206576	Screw, 006-32x .50 Btn Hd-Soc Stl Pld	3	3
34		602198	Washer, Lock .141 Id Stl Split	1	1
35		134624	Washer, Shldr.140Id 0.187odx.094T .375odx.031T Nyl	2	2
36		134623	Bearing, Idler Roll	1	1
37		132852	Arm, Pressure	1	1
38		605798	Washer, Shldr Nyl .375 Od X .168 Id X .080	2	2
39		133083	Spring, Tension Adj Drive Roll	1	1
40		144860	Screw, 8-32 X .437Flatd Slt Stl	1	1
41		058968	Ring, Retainer E	1	1
42		135474	Pin, Hinge	1	1

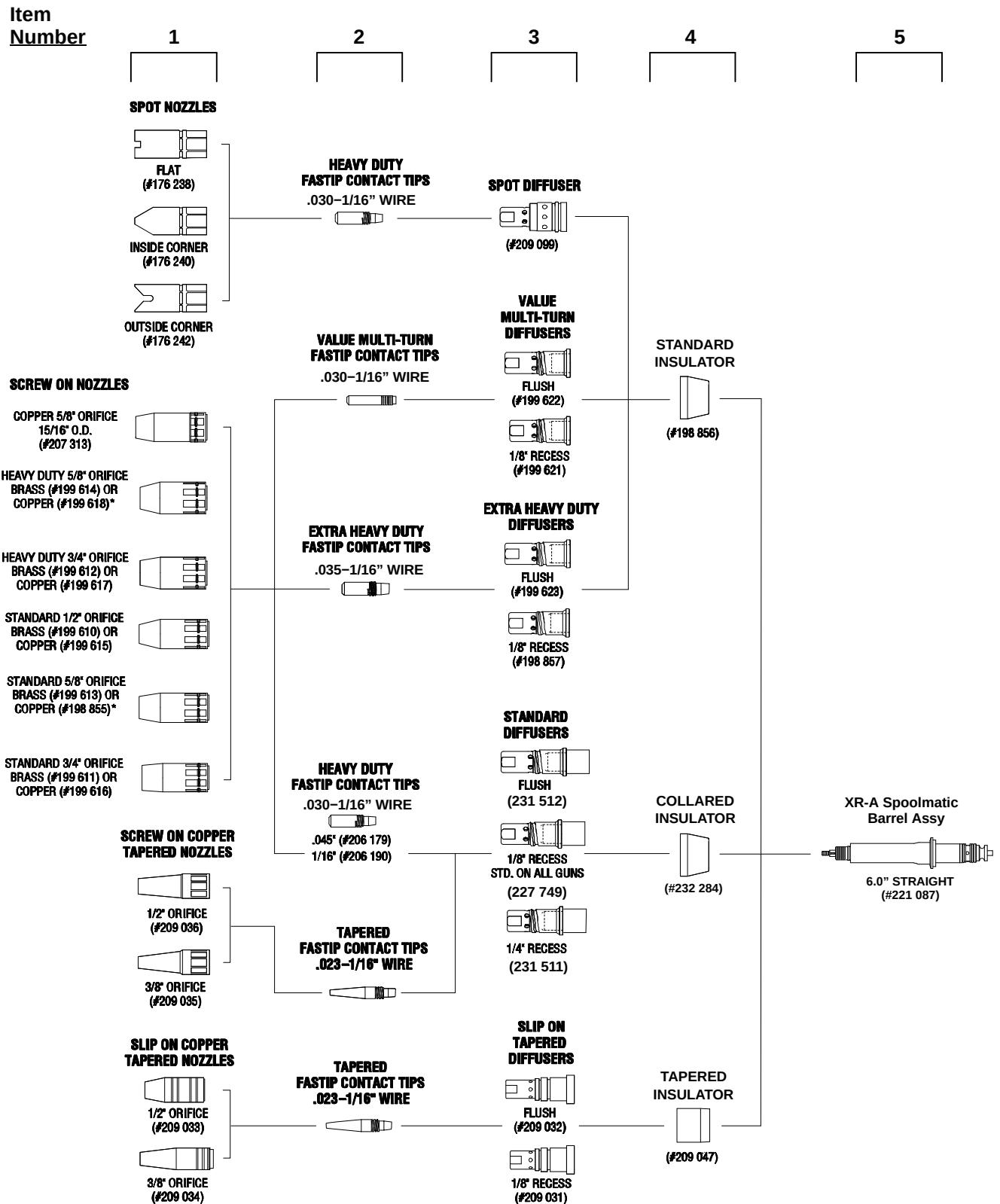
Eff w/Serial No. LJ210301V And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 20-1. Complete Assembly (Continued)				
43		155565	Screw, Thumb	1
		134799	O-ring, .176 Id X .070Cs (Used W/Thumbscrew)	1
44		135126	Screw, Set 6-32 X .125 Cup Point Sch Stl	1
45		602209	Washer, Tooth .256 Id Stl Intl	1
46		602154	Screw, .250-20 X .500Hexhd Stl Slffmg	1
47		132527	Canister, Spool	1
48		148488	Post, Support Spool	1
49		132529	Pad, Brake	1
50		148489	Washer, Anti-turn .380 Id	1
51		132524	Nut, .375-24 .56Knrl Alum	1
52		000364	Ring, Retainer Ext .145 Shaft Grv X .025Thk	1
53		132526	Cover, Spool	1
54		132528	Screw, Thumb Canister	1
55		132521	Guide, Inlet Canister (Prior to ME450221T)	1
55		269554	Guide, Inlet Canister (Eff w/ME450221T)	1
56		112896	Spring, Cprsn .240 Od X .020 Wire X .437	1
57		135580	Fitting, Gas	2
		146555	Screw, Set 8-32 X .125 Cup Sch	1
58		135773	Nut, 8-32 .56Knrl Stl	1
59		143360	Screw, 8-32 X .500Panhd Phl Stl	1
60		136679	Clamp, Strain Relief	1
61		129351	Screw, 8-32 X .500Hexwhd Slit Stl Slffmg	1
62	B2	230947	Motor, Gear Pm 24 VDC 420 RPM 10.2:1 Ratio W/Conn	1
63		164592	Trigger	1
64		236149	Kit, Replacement Drive Housing/Spool (Includes)	1
		162038	Bearing, Ball Rdl Sgl Row 8mm X 16mm X 5mm Wide Sh (Eff w/LK500173T)	1
		162039	Bushing, Nylatron .252 Id X .315 Od X .250 Lg .500 X (Eff w/LK500173T)	1
64		239754	Kit, Housing W/Handles (Includes) (Eff w/LK500173T)	1
		M1603	Kit, Incl 3-Valve Boot 3-Retainer Ring (Includes) (Eff w/MH170316T)	1
65		058262	Cap, Valve	1
66		M1602	Ring, Valve Boot Retainer (Eff w/MG460083T)	1
67		217934	Screw, K40x 20 Pan Hd-trx Stl Pld Pt Thread Forming	4
68		237515	Screw, Set 250-20x .37 Conept Sch Stl W/Nyl Patch (Prior To LK140799V)	1
68		005464	Screw, Set 250-20x .37 Ovl Pt Sch Stl Pln Nylok (Eff w/LK140799V)	1
69		235753	Ftg, Connection Power Weld	1
70		235751	Tubing, Silicone Rbr .500 Id X Spool Black	1
71		M1460	O-Ring, .143 Id X .349 Od X .103 Cs, Buna-N (Eff w/MC480762T)	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.

Eff w/Serial No. LJ210301V And Following

SECTION 21 – PARTS LIST INCLUDING CONSUMABLES



Ref. 803 909-A / 803 932 / 803 933 / 803 934

Figure 21-1. Consumables Flowchart

Eff w/Serial No. LJ210301V And Following

Item No.	Part No.	Description	Quantity
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Figure 21-1. Consumables Flowchart

Table 21-1. Nozzles

... 1	◆176238	.. Nozzle, Spot Flat (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆176240	.. Nozzle, Spot Inside Corner (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆176242	.. Nozzle, Spot Outside Corner (Requires Diffuser 209099, Used With Any Heavy Duty FasTip™ Contact Tip)	1
... 1	◆199610	.. Nozzle, Screw On Brass 1/2 in Orifice	1
... 1	◆199611	.. Nozzle, Screw On Brass 3/4 in Orifice Straight	1
... 1	◆199612	.. Nozzle, Screw On Brass 3/4 in Orifice Straight Heavy Duty	1
... 1	◆199613	.. Nozzle, Screw On Brass 5/8 in Orifice	1
... 1	◆199614	.. Nozzle, Screw On Brass 5/8 in Orifice Heavy Duty	1
... 1	◆199615	.. Nozzle, Screw On Copper 1/2 in Orifice	1
... 1	◆199616	.. Nozzle, Screw On Copper 3/4 in Orifice	1
... 1	◆199617	.. Nozzle, Screw On Copper 3/4 in Orifice Heavy Duty	1
... 1	198855	.. Nozzle, Screw On Copper 5/8 in Orifice	1
... 1	199618	.. Nozzle, Screw On Copper 5/8 in Orifice Heavy Duty	1
... 1	◆207313	.. Nozzle, Screw On Copper 5/8 in Orifice 15/16 OD	1
... 1	◆209033	.. Nozzle, Slip On Copper 1/2 in Orifice Tapered (Requires Diffuser 209031 Or 209032 And Insulator 209047, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209034	.. Nozzle, Slip On Copper 3/8 in Orifice Tapered (Requires Diffuser 209031 Or 209032 And Insulator 209047, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209035	.. Nozzle, Screw On Copper 3/8 in Orifice Tapered (Requires Diffuser 227 747, 231 511 Or 231 512, Used With Any Tapered FasTip™ Contact Tip)	1
... 1	◆209036	.. Nozzle, Screw On Copper 1/2 in Orifice Tapered (Requires Diffuser 227 747, 231 511 Or 231 512, Used With Any Tapered FasTip™ Contact Tip)	1

Table 21-2. Heavy Duty FasTip™ Contact Tips*

... 2	◆206185	.. .030 in (0.8 mm)	1
... 2	◆206186	.. .035 in (0.9 mm)	1
... 2	◆206187	.. .040 in (1.0 mm) or .035 in (0.9 mm) Aluminum Wire	1
... 2	206188	.. .045 in (1.2 mm)	1
... 2	◆206189	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) Aluminum Wire	1
... 2	206190	.. 1/16 in (1.6 mm)	1
... 2	◆206191	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) Aluminum Wire	1

Table 21-3. Extra Heavy Duty FasTip™ Contact Tips*

... 2	◆199605	.. .035 in (0.9 mm)	1
... 2	◆199606	.. .040 in (1.0 mm) or .035 in (0.9 mm) Aluminum	1
... 2	◆198851	.. .045 in (1.2 mm)	1
... 2	◆198852	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) Aluminum Wire	1
... 2	◆198853	.. 1/16 in (1.6 mm)	1
... 2	◆198854	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) Aluminum Wire	1

Table 21-4. Tapered FasTip™ Contact Tips*

... 2	◆209025	.. .030 in (0.8 mm)	1
... 2	◆209026	.. .035 in (0.9 mm)	1
... 2	◆209027	.. .045 in (1.2 mm)	1
... 2	◆209028	.. 3/64 in (1.2 mm)	1
... 2	◆209029	.. .052 in (1.3 mm)	1
... 2	◆209030	.. 1/16 in (1.6 mm)	1

Eff w/Serial No. LJ210301V And Following

Item No.	Part No.	Description	Quantity
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Figure 21-1. Consumables Flowchart (Continued)

Table 21-5. Value Multi-Turn Contact Tips*

... 2	♦071825	.. .030 in (0.9 mm)	1
... 2	♦054202	.. .035 in (0.9 mm)	1
... 2	♦054201	.. .045 in (1.2 mm)	1
... 2	♦199593	.. .3/64 in (1.2 mm) Aluminum Wire	1
... 2	♦044006	.. .052 in (1.3 mm)	1
... 2	♦047566	.. 1/16 in (1.6 mm)	1
... 2	♦202933	.. 1/16 in (1.6 mm) Aluminum Wire	1

Table 21-6. Gas Diffusers

... 3	♦198857	.. 1/8 in Tip Recess – For Extra Heavy Duty FasTip Contact Tips	1
... 3	♦199623	.. Flush Tip – For Extra Heavy Duty FasTip Contact Tips	1
... 3	♦199621	.. 1/8 in Tip Recess – For Value Multi-Turn Contact Tips	1
... 3	♦199622	.. Flush Tip – For Value Multi-Turn Contact Tips	1
... 3	227749	.. 1/8 in Tip Recess – For Heavy Duty FasTip Contact Tips (Standard On All Guns)	1
... 3	♦231511	.. 1/4 in Tip Recess – For Heavy Duty FasTip Contact Tips	1
... 3	♦231512	.. Flush Tip – For Heavy Duty FasTip Contact Tips	1
... 3	♦209031	.. Slip On Recessed Diffuser (Requires Nozzle 209033 Or 209034 And Insulator 209047, Used With Any Tapered FasTip Contact Tip)	1
... 3	♦209032	.. Slip On Flush Diffuser (Requires Nozzle 209033 Or 209034 And Insulator 209047, Used With Any Tapered FasTip Contact Tip)	1
... 3	♦209099	.. Spot Diffuser (Requires Spot Nozzle 176238 Or 176240 Or 176242)	1

Table 21-7. Insulators

... 4	232284	.. Insulator, Nozzle Collared Diffuser	1
... 4	198856	.. Insulator, Rubber	1
... 4	209047	.. Insulator, Teflon (Required When Using Diffuser 209031 Or 209032 With Nozzle 209033 Or 209034)	1

Table 21-8. Barrel Assemblies

... 5	221087	.. Barrel Assy, Air Cooled Pistol	1
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Table 21-9. Head Tube Assemblies

...	231523	.. Kit, Head Tube Assy Air Cooled Pistol	1
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♦OPTIONAL

*All contact tips are packaged in bags of 25.

BE SURE TO PROVIDE MODEL WHEN ORDERING REPLACEMENT PARTS.

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

Notes

Notes

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