



TM-225 716J

2014-08

**Processes**



MIG (GMAW) Welding

Flux Cored (FCAW) Welding

**Description**



Arc Welding Power Source And  
Wire Feeder

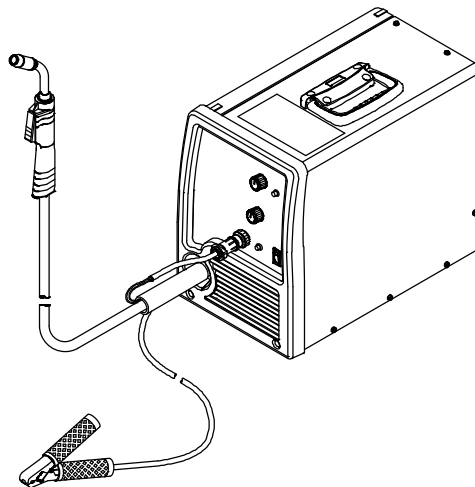
# Millermatic<sup>®</sup> 140 Auto-Set<sup>™</sup> And 180 Auto-Set<sup>™</sup>

**Millermatic 140 Auto-Set<sup>™</sup>  
Eff w/LG320643N And Following**

For OM-225 311 Revision A Thru L

**Millermatic 180 Auto-Set<sup>™</sup>  
Eff w/LH440001N And Following**

For OM-225 311 Revision E Thru L



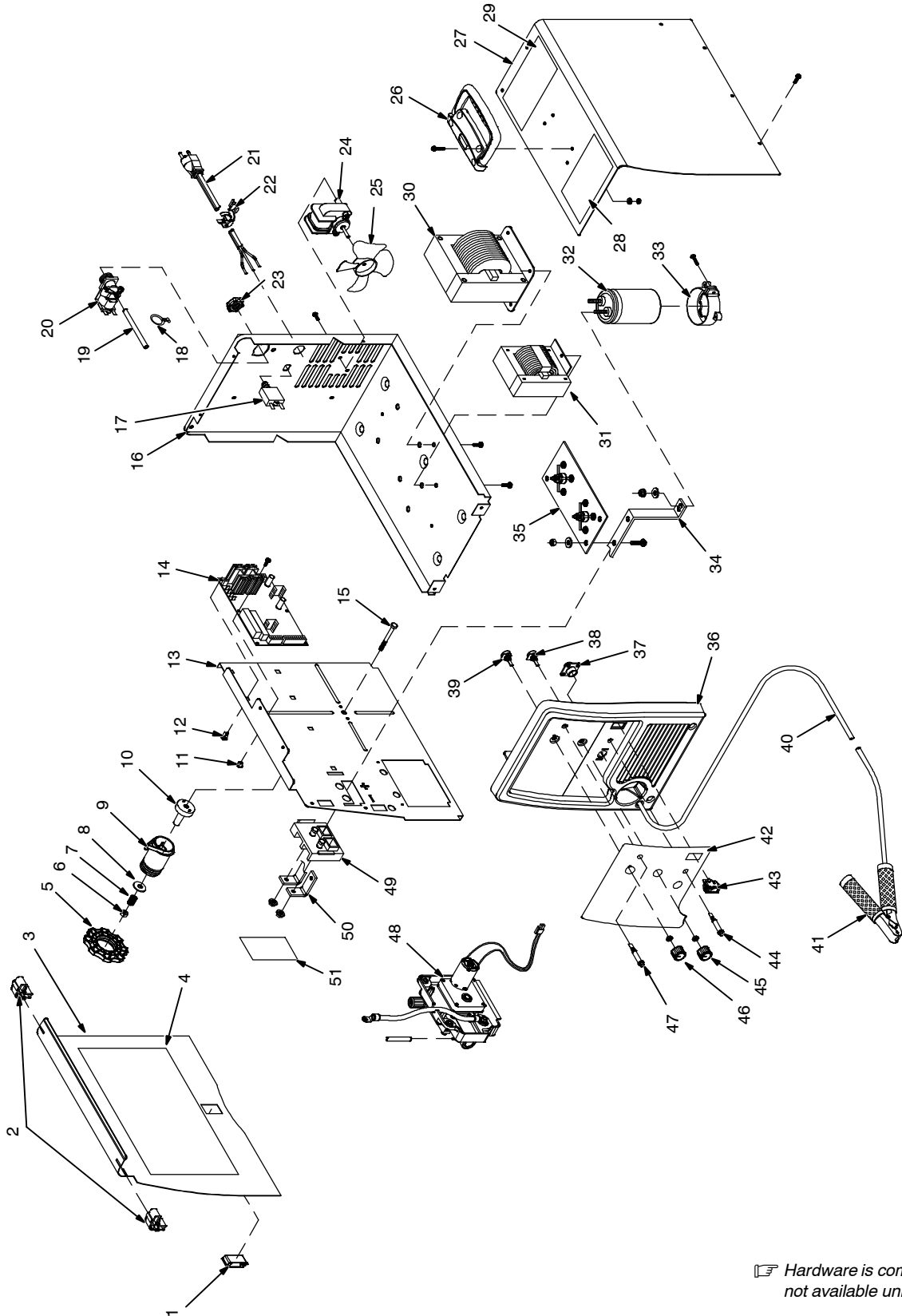
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## PARTS LIST

File: MIG (GMAW)



# SECTION 1 - PARTS LIST



 Hardware is common and not available unless listed.

804 683-C

Figure 1-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly</b>				
1		204 711	Latch, Slide Flush Snap Lock	1
2		202 412	Hinge, Door	2
3		202 584	Door, Access	1
4		227 931	Label, Parameter (Millermatic 140 Auto-Set [115 VAC])	1
4		233 622	Label, Parameter (Millermatic 180 Auto-Set [230 VAC])	1
5		211 887	Nut, Hub	1
6		204 608	Nut	1
7		225 257	Spring, Cprsn	1
8		203 072	Washer, Flat	1
9		211 339	Hub, Spool	1
10		202 726	Adapter, Spool Hub	1
11		228 165	Grommet, Scr No.8	1
12		134 201	Stand-Off Support PC Board	7
13		202 582	Baffle, Center	1
14	PC1	238 907	Circuit Card Assy, Control (Millermatic 140 Auto-Set [115 VAC])	1
14	PC1	238 912	Circuit Card Assy, Control (Millermatic 180 Auto-Set [230 VAC])	1
15		203 071	Screw	1
16		202 581	Base, Lower (Prior To LJ440170N)	1
16		239 579	Base, Lower (Eff w/LJ440170N)	1
17	CB1	210 109	Supplementary Protector, 25 Amp	1
18		197 198	Cable Tie	2
19		196 467	Tubing, PVC	1
20	GS1	216 397	Valve, 2 Way (Millermatic 140 Auto-Set [115 VAC])	1
20	GS1	216 398	Valve, 2 Way (Millermatic 180 Auto-Set [230 VAC])	1
21		147 545	Cord Set, 125V 5-15p 14ga 3/C 7ft Spt-3 Jkt (Millermatic 140 Auto-Set (115 VAC))	1
21		152 118	Cord Set, 250V 6-50p 12ga 3/C 7ft Spt-3 Jkt (Millermatic 180 Auto-Set (230 VAC))	1
22		111 443	Bushing, Strain Relief	1
23		137 761	Nut	1
24	FM	196 063	Motor, Fan (Millermatic 140 Auto-Set [115 VAC])	1
24	FM	196 064	Motor, Fan (Millermatic 180 Auto-Set [230 VAC])	1
25		409 953-001	Blade, Fan Cooling	1
26		208 015	Handle, Carrying	1
27		202 583	Wrapper, Cover	1
28		226 510	Label, Warning General Precautionary	1
29		235 247	Label, Warning General Precautionary (Sp) (Eff w/LH351002N)	1
30	T1	203 445	Transformer (Millermatic 140 Auto-Set [115 VAC])	1
30	T1	222 848	Transformer (Millermatic 180 Auto-Set [230 VAC])	1
	TP1	196 685	Thermostat, NC Open 140c, Close 100c	1
31	Z1	221 100	Stabilizer, 90A (Millermatic 140 Auto-Set [115 VAC])	1
31	Z1	221 102	Stabilizer, 130A (Millermatic 180 Auto-Set [230 VAC]) (Prior To MA220944N)	1
31	Z1	239 591	Stabilizer, 150A (Millermatic 180 Auto-Set [230 VAC]) (Eff w/MA220944N)	1
32	C1	228 176	Capacitor, Elctlt 100,000 Uf	1
33		203 491	Clamp, Capacitor	1
34		204 215	Bus Bar (Positive)	1

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

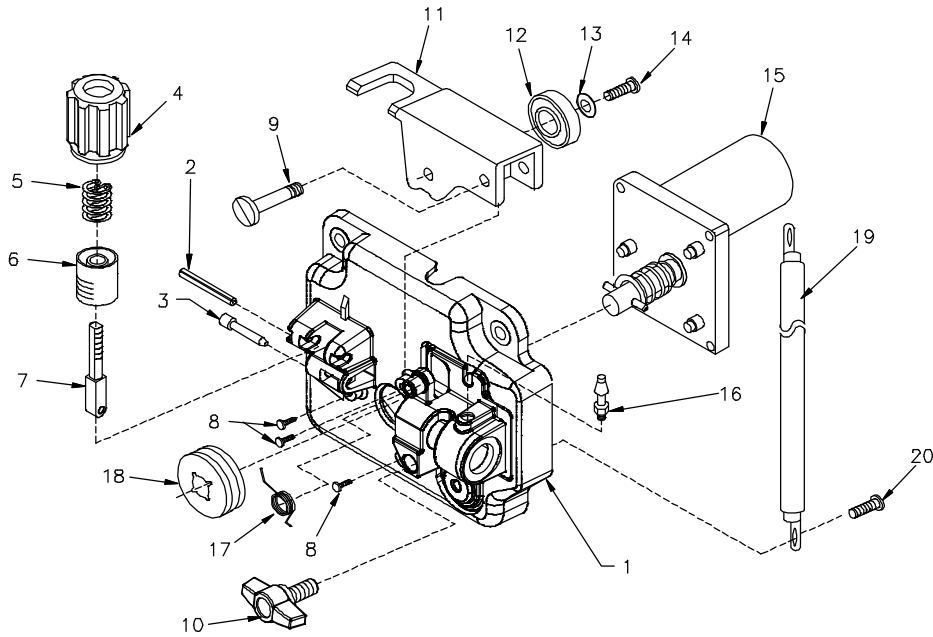
**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly (Continued)</b>				
... 35	SR1	193 191	.. Rectifier Assy (Milleromatic 140 Auto-Set [115 VAC])	1
... 35	SR1	193 316	.. Rectifier Assy (Milleromatic 180 Auto-Set [230 VAC])	
			(Prior To LJ440170N)	1
... 35	SR1	243 242	.. Rectifier Assy (Milleromatic 180 Auto-Set [230 VAC])	
			(Eff w/LJ440170N)	1
... 36		228 172	.. Panel, Front (Prior To LJ440170N)	1
... 36		239 580	.. Panel, Front (Eff w/LJ440170N)	1
... 37	RC1	048 282	.. Rcpt W/Skts (Service Kit)	1
... 38	R1	202 663	.. Potentiometer, Cp Flat 1t .50w 50k (Voltage Control)	1
... 39	R2	207 415	.. Potentiometer, Cp Flat 1t .50w 50k (Wire Speed Control)	1
		229 955	.. Cable, Work 11 Ft W/Clamp (Including)	1
... 40		196 619	.. Work Cable	1
... 41		208 820	.. Clamp, Work	1
... 42		227 748	.. Label, Nameplate (Milleromatic 140 Auto-Set [115 VAC])	1
... 42		233 619	.. Label, Nameplate (Milleromatic 180 Auto-Set [230 VAC])	1
... 43	S1	196 575	.. Switch, Rocker SPST (Milleromatic 140 Auto-Set [115 VAC])	1
... 43	S1	196 574	.. Switch, Rocker DPDT (Milleromatic 180 Auto-Set [230 VAC])	1
... 44	LED1	202 661	.. Led, Yellow	1
... 45		228 230	.. Knob, Pointer W/Detent	2
		229 929	.. Ball Plunger, Push Fit	1
... 46		207 078	.. Knob, Pointer	2
... 47	LED2	228 223	.. LED, Blue	1
... 48		Fig. 1-2	.. Wire Feed Drive Assy	1
... 49		193 144	.. Insulator, Output Stud	1
... 50		193 194	.. Bus Bar (Negative)	1
... 51		231 985	.. Label, Warning Electric Shock	1
		221 037	.. Regulator/Flowmeter, 10-50 Cfh Argon/Co <sub>2</sub>	1
		183 581	.. Hose, Gas 5ft	1
		◆268 546	.. Kit, Al Body Regulator/Flwmeter w/Cartron & Manual	1
		◆183 581	.. Hose, Gas 5ft	1

◆OPTIONAL

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

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804 095-A

**Figure 1-2. Wire Feed Drive Assembly**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>223 655      Figure 1-2. Wire Feed Drive Assembly</b>				
.....		225 717	.. Drive Head Assy (does not include motor)	1
... 1		202 500	.. Housing, plastic drive motor	1
... 2		203 424	.. Pin, spring	1
... 3		058 549	.. Guide, wire inlet	1
... 4		196 895	.. Knob, tension	1
... 5		090 415	.. Spring, compression	1
... 6		198 080	.. Cup, spring tension	1
... 7		225 718	.. Fastener, pinned	1
... 8		197 172	.. Screw, motor	3
... 9		203 567	.. Screw,shld	1
... 10		222 035	.. Knob, tee	1
... 11		203 301	.. Lever, pressure	1
... 12		189 915	.. Bearing, ball	1
... 13		602 238	.. Washer, flat	1
... 14		122 210	.. Screw, 010-32 x 0.62	1
... 15	DM	202 708	.. Motor, gear	1
... 16		196 009	.. Fitting, gas	1
... 17		203 418	.. Spring, torsion	1
... 18		220 179	.. Roll, feed .024, .030/.035	1
... 19		203 667	.. Cable	1
... 20		053 300	.. Screw, 250-20 x 0.62	1

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

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**Miller Electric Mfg. Co.**

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

**International Headquarters-USA**

USA Phone: 920-735-4505 Auto-Attended  
USA & Canada FAX: 920-735-4134  
International FAX: 920-735-4125

For International Locations Visit  
[www.MillerWelds.com](http://www.MillerWelds.com)

