



PM-1327B

2021-09

Processes



MIG (GMAW) Welding



Flux Cored (FCAW) Welding

Description



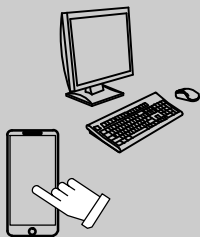
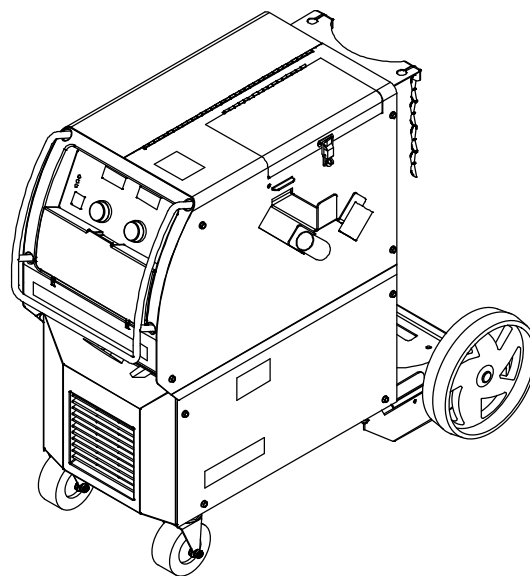
Arc Welding Power Source
and Wire Feeder

Millermatic[®] 350 And Millermatic[®] 350P

PARTS LIST

Eff w/LC447907 Thru LE443589

For OM-1327 (213 814) Revisions A Thru H



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

www.MillerWelds.com

File: MIG (GMAW)



SECTION 1 – PARTS LIST (Eff w/LC447907 Thru LE443589)

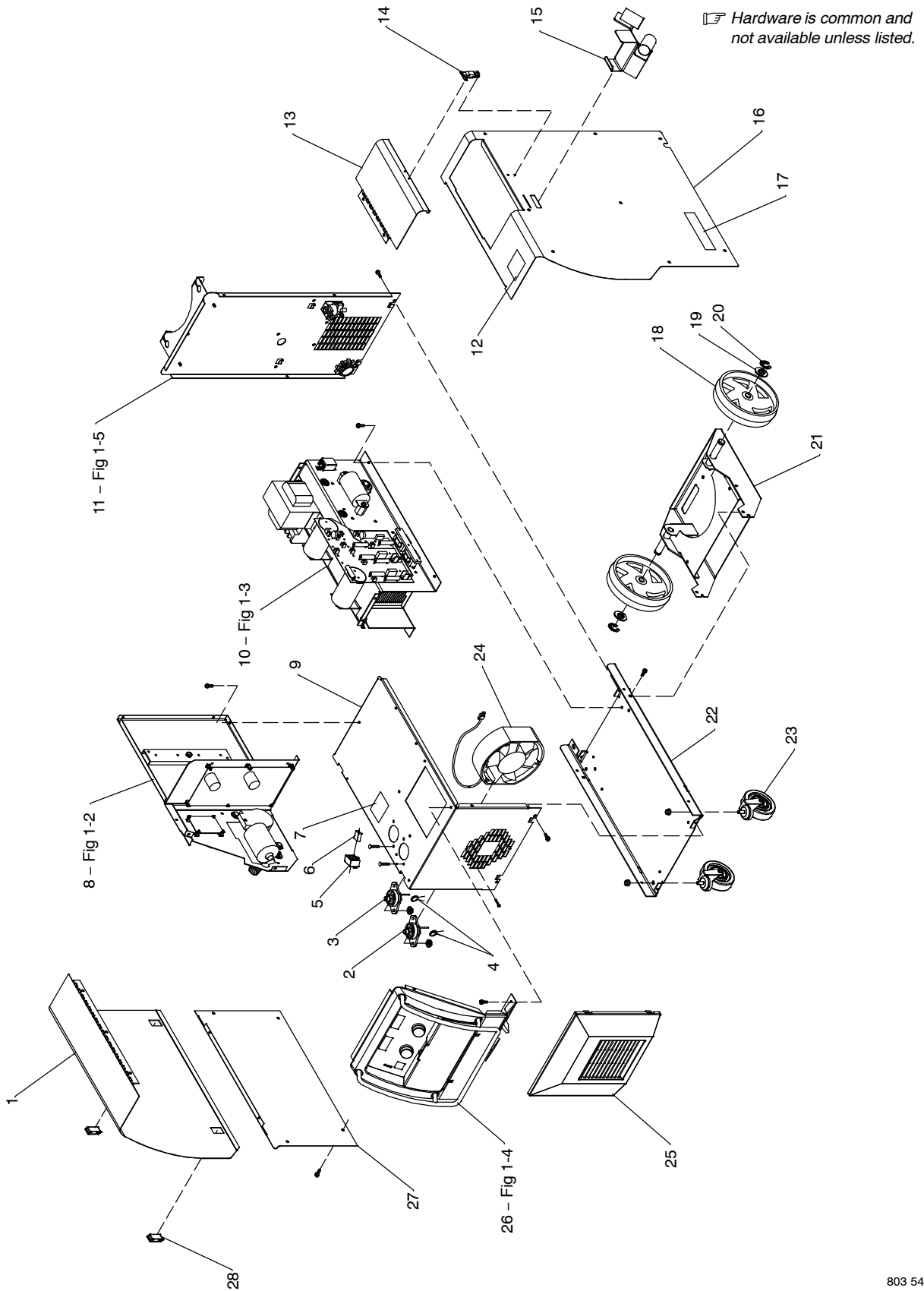


Figure 1-1. Main Assembly

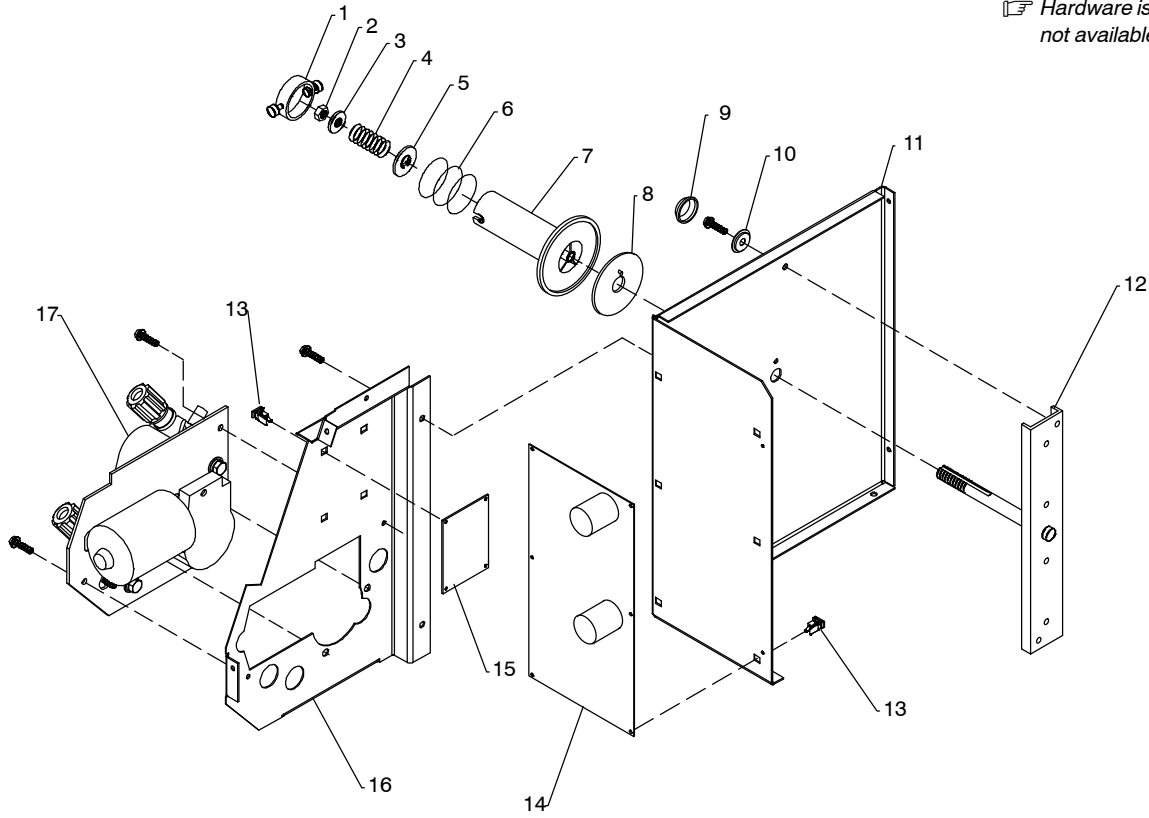
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-1. Main Assembly				
...	1	212829	.. DOOR,ACCESS WIRE COMPARTMENT	1
...	2	NEG . 097416	.. TERMINAL,PWR OUTPUT BLACK	1
...	3	POS . 097421	.. TERMINAL,PWR OUTPUT RED	1
...	4	C6,7 . 213038	.. CAPACITOR ASSY	2
...	5	HD1 . 189567	.. TRANSDUCER,CURRENT 400A MODULE SUPPLY V +/- 15V	1
...		183046	.. CABLE,LEM	1
...	6	213157	.. BUS BAR,CURRENT SENSOR (Prior to LE282543)	1
...	6	221326	.. BUS BAR,CURRENT SENSOR (Eff w/LE282543)	1
...	7	199824	.. LABEL,WARNING ELECTIC SHOCK AND PINCH POINTS	1
...	8	Fig 1-2	.. BAFFLE,CENTER	1
...	9	212821	.. PANEL,FRONT LOWER	1
...	10	Fig 1-3	.. INVERTER ASSY	1
...	11	+Fig 1-5	.. PANEL,REAR	1
...	12	134464	.. LABEL,WARNING GENERAL PRECAUTIONARY STATIC&WIRE	1
...	13	212826	.. DOOR,ACCESS TOOL COMPARTMENT	1
...	14	217829	.. LATCH,DOOR STRAIGHT LOOP CATCH	1
...	15	215061	.. GUN/CABLE HOLDER	1
...	16	+212823	.. WRAPPER	1
...	17	213939	.. LABEL,WARNING ELECTRIC SHOCK CAN KILL SIGNIFICANT	1
...	18	186758	.. WHEEL,POLYPROPYLENE 10 IN X 2.25 WIDE	2
...	19	602250	.. WASHER,FLAT .812IDX1.469ODX.134T STL PLD ANSI.750	2
...	20	121614	.. RING,RTNG EXT .750 SHAFT X .085 THK E STYLE PLD	2
...	21	213903	.. RACK,CYLINDER SINGLE	1
...	22	212833	.. BASE,	1
...	23	209870	.. CASTER,SWVL 4.00 IN X 1.250 IN POLY-OLEFIN	2
...	24	FM . 213043	.. FAN,MUFFIN 24VDC 3000 RPM W/20.500 IN LEADS	1
...	25	212846	.. BEZEL,LOWER	1
...	26	Fig 1-4	.. PANEL,FRONT	1
...	27	212822	.. PANEL,SIDE LH LOWER	1
...	28	151187	.. LATCH,SLIDE FLUSH MTG HOLE 1.000 WIDEX 1.500 LG	2
...		194755	.. ROUGHNECK C-4012 GUN	1
...		209123	.. REGULATOR/FLOWMETER,10-50 CFH ARGON/MIX (350 MODEL)	1
...		210925	.. REGULATOR/FLOWMETER,0-50 CFH AR/CO2 W/FLOWTUBE(350P MODEL)	1
...		144108	.. HOSE,GAS 5FT	1
...		196329	.. CABLE,WORK 10 FT NO1 W/CLAMP & BOOT (350 MODEL) (INCLUDING)	1
...		130750	.. CLAMP,WORK 300 AMP	1
...		196318	.. COVER,CABLE BTRY POST BLK .75 ID	1
...		213369	.. CABLE,WORK 10 FT 1/O W/CLAMP & BOOT (350P MODEL) (INCLUDING)	1
...		213619	.. CLAMP,WORK 300 AMP STL CHROME PLD W/COP CONTACTS	1
...		196318	.. COVER,CABLE BTRY POST BLK .75 ID	1
...		206186	.. TIP,FASTIP .312 OD .035 AND .030AL WIRES	5
...		206188	.. TIP,FASTIP .312 OD .045 AND .040AL WIRES	5
...		◆212492	.. REGULATOR/FLOWMETER, 0-50 CFH CO2	1

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

◆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.

☐ Hardware is common and not available unless listed.



803 546-A

Figure 1-2. Baffle, Center w/Components

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

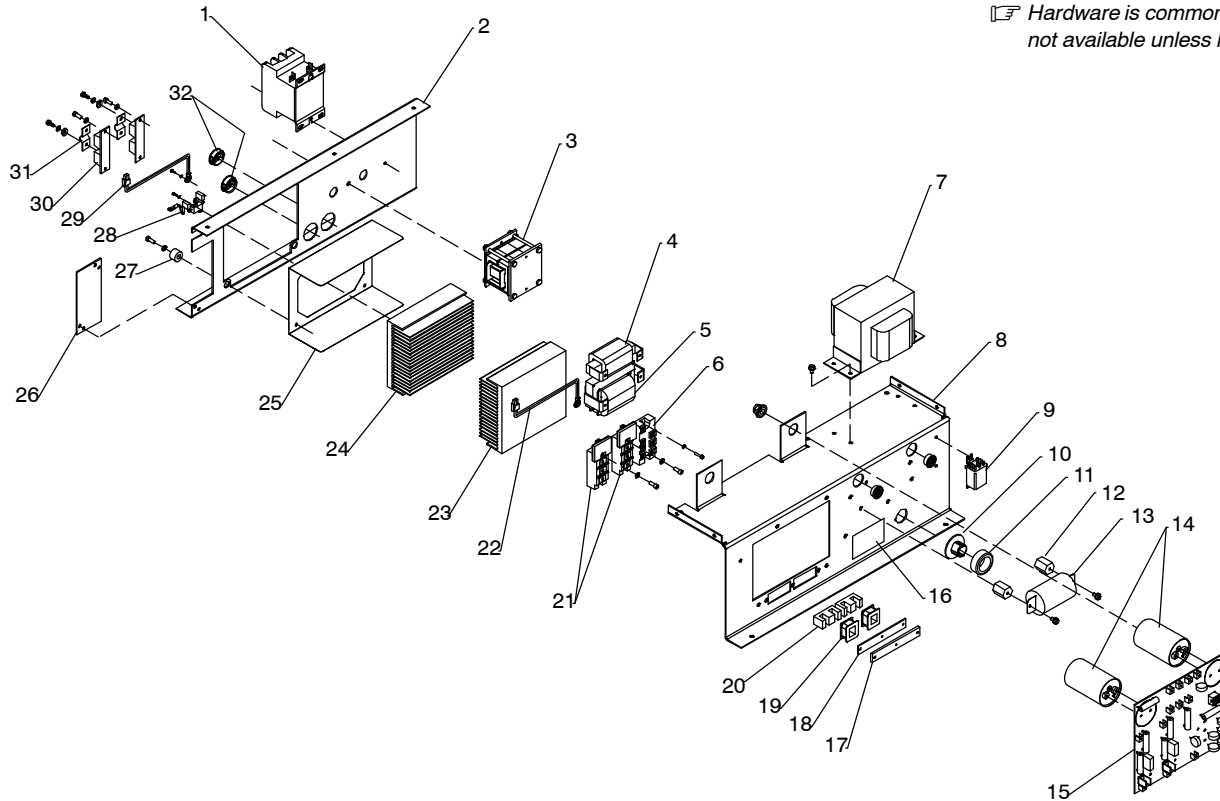
Figure 1-2. Baffle, Center w/Components (Fig 1-1 Item 7)

.. 1	058427	..	RING,RETAINING SPOOL	1
.. 2	085980	..	NUT,STL HEX FULL .625-11	1
.. 3	605941	..	WASHER,FLAT STL .640 ID X 1.000 OD X 14GA THK	1
.. 4	186437	..	SPRING,CPRSN .845 OD X .110 WIRE X 1.500	1
.. 5	057971	..	WASHER,FLAT STL KEYED 1.500DIA X .125THK	1
.. 6	057745	..	SPRING,CPRSN 2.305 OD X .090 WIRE X 2.500 PLD	1
.. 7	186435	..	HUB,SPOOL	1
.. 8	186436	..	WASHER,BRAKE PLASTIC	1
.. 9	198425	..	CAP,FINISHING 1.19 X .37	2
.. 10	198426	..	WASHER,CAP	2
.. 11	212824	..	BAFFLE,CENTER	1
.. 12	177307	..	REEL SUPPORT	1
.. 13	134201	..	STAND-OFF SUPPORT,PC CARD .312/.375W/POST&LOCK .43	10

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-2. Baffle, Center w/Components (Fig 1-1 Item 7) (Continued)				
. 14	PC1 ...	211055 .. CIRCUIT CARD ASSY,CONTROL W/PROGRAM (Prior to LE243469) 1
. 14	PC1 ..	220522 .. CIRCUIT CARD ASSY,CONTROL W/PROGRAM (200/230V model) (Eff w/LE243469) 1
. 14	PC1 ..	222676 .. CIRCUIT CARD ASSY,CONTROL W/PROGRAM (460/575V model) (Eff w/LE411272) 1
.....		PLG9 ..	115093 .. HOUSING PLUG+SKTS,(SERVICE KIT) 1
.....		PLG7 ..	115092 .. HOUSING PLUG+SKTS,(SERVICE KIT) 1
.....		PLG8 ..	131056 .. HOUSING RCPT+SKTS,(SERVICE KIT) 1
.....		PLG10,14	115091 .. HOUSING PLUG+SKTS,(SERVICE KIT) 2
.....		PLG11,12, 17 ..	131054 .. HOUSING PLUG+SKTS,(SERVICE KIT) 3
.....		PLG15,16	131204 .. HOUSING PLUG+SKTS,(SERVICE KIT) 2
.....			213404 .. CABLE,INTERCONNECTING RS 485 INTERFACE TO CONTROL 1
.....			213405 .. CABLE,INTERCONNECTING RS 485 INTERFACE TO PULSE OP 1
.....			168674 .. CABLE,RIBBON 24 POSN 14.000 IN SKTS BE INVERTED 1
. 15	PC6 ..	216342 .. CIRCUIT CARD ASSY,GMAW PULSE W/PROGRAM (PULSE MODEL ONLY) 1
.....		PLG29	131204 .. HOUSING PLUG+SKTS,(SERVICE KIT) 1
.....		PLG30	115091 .. HOUSING PLUG+SKTS,(SERVICE KIT) 1
. 16		212843 .. HOUSING,ADAPTER DRIVE MOTOR 1
. 17	Fig 1-6	.. DRIVE ASSY,WIRE 4 ROLL 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.

☞ Hardware is common and not available unless listed.



803 552-A

Figure 1-3. Inverter Assy

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

Figure 1-3. Inverter Assy (Fig 1-1 Item 9)

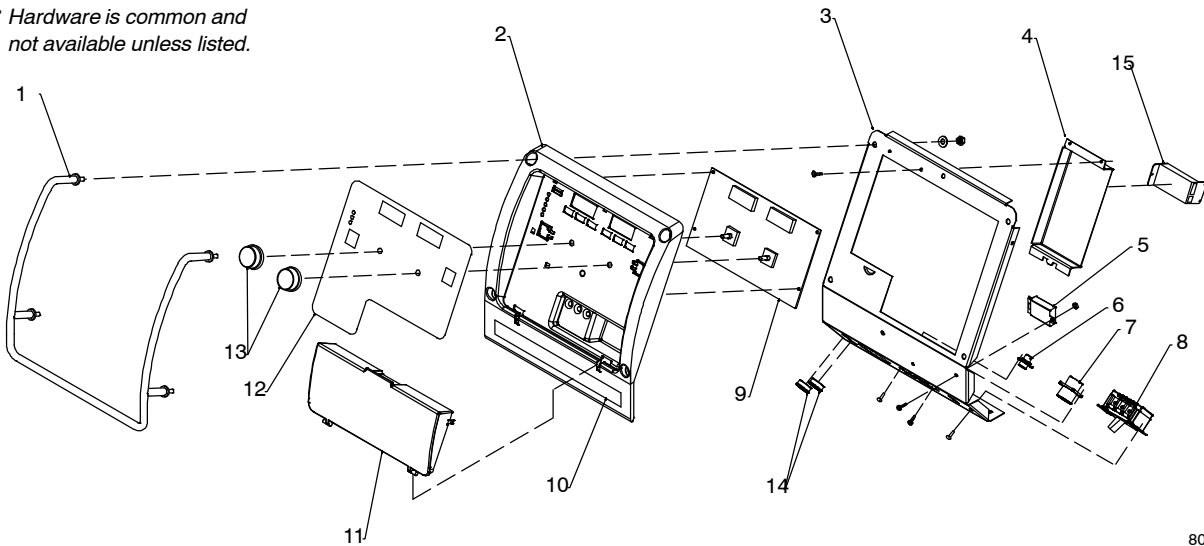
...	1	W	188634	.. CONTACTOR,DEF PRP 60A 3P 24VAC COIL W/COVER	1
.....				C11,12,	
			13	.. CAPACITOR,CER DISC .003 UF 2000 VAC W/TERMS	3
...	2		+212750	.. WINDTUNNEL,LH	1
.....				185835 .. LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS	1
...	3	T1	180952	.. XFMR,HF	1
...	4	L1	216006	.. INDUCTOR,INPUT	1
...	5	Z1	212756	.. STABILIZER,OUTPUT	1
...	6	SR1	212937	.. KIT,DIODE POWER MODULE	1
...	7	T2	213022	.. XFMR,CONTROL 200/230 PRI 48CT/36CT/16.7/20.0 SEC	1
...	7	T2	213024	.. XFMR,CONTROL 460/575 PRI 48CT/36CT/16.7/20.0 SEC	1
.....		PLG26	168071	.. HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
...	8		+212752	.. WINDTUNNEL,RH	1
...	9	CR1	106462	.. RELAY,ENCL 24VDC DPDT 20A/120VAC 8PIN FLANGE MTG	1
...	10		177547	.. BUSHING,SNAP-IN NYL CT-MOUNT 1.125 MTG HOLE	1
...	11	CT1	213032	.. XFMR,CURRENT	1
...	12		025248	.. STAND-OFF,INSUL .250-20 X 1.250 LG X .437 THD	2
...	13	C1	186015	.. CAPACITOR,POLYP FILM .34 UF 1000 VAC +8% -0% (200/230V model) .	1
...	13	C1	193858	.. CAPACITOR,POLYP FILM .27 UF 1000 VAC +8% -0% (460/575V model)	
.....				(Eff w/LE411272)	1
...	14	C3,4	192935	.. CAPACITOR,ELCTLT 2700 UF 450 VDC CAN 2.52 DIA	
.....				(200/230 MODELS)	2
...	14	C3,4	193738	.. CAPACITOR,ELCTLT 1800 UF 500 VDC CAN 2.52 DIA	
.....				(460/575 MODELS) (Prior to LE411272)	2
...	14	C3,4	217941	.. CAPACITOR,ELCTLT 1800 UF 500 VDC CAN 2.52 DIA	
.....				(460/575 MODELS) (Eff w/LE411272)	2
.....			217942	.. SPACER,NYLON CAPACITOR (Eff w/LE411272)	1
.....			217040	.. NUT,NYLON M12 THREAD CAPACITOR MOUNTING (Eff w/LE411272) ...	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 1-3. Inverter Assy (Fig 1-1 Item 9) (Continued)				
... 15 ...	PC2 ...	211125 ..	CIRCUIT CARD ASSY,INTERCONNECT (200/230)	1
... 15 ...	PC2 ..	219900 ..	CIRCUIT CARD ASSY,INTERCONNECT (460/575)	1
.....	PLG2 .	168071 ..	HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
... 16		185835 ..	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS	1
... 17		175140 ..	BRACKET,DI-DT	1
.....		178591 ..	LABEL,CONNECTION DI/DT	1
... 18		181197 ..	GASKET,DI-DT RUBBER	1
... 19 ...	L3,4 ..	175482 ..	COIL,DI/DT	2
... 20		109056 ..	CORE,FERRITE E 2.164 LG X 1.094 HIGH X .826 WIDE	2
... 21 ..	PM1,2 .	212936 ..	KIT,TRANSISTOR IGBT MODULE (KIT INCLUDES 2 IGBTs)	1
... 22 ...	RT2 ..	213029 ..	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 3P	1
... 23		212776 ..	HEAT SINK,POWER MODULE	1
... 24		212753 ..	HEAT SINK,RECT	1
... 25		175255 ..	INSULATOR,RECTIFIER	1
... 26		214537 ..	COVER,ACCESS FAN MOTOR	1
... 27		181853 ..	INSULATOR,SCREW	4
... 28 .	C2,R1,C5	175194 ..	RESISTOR/CAPACITOR,	1
... 29 ...	RT1 ..	213028 ..	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 2P	1
... 30 ...	D1,2 .	201531 ..	KIT,DIODE POWER MODULE	2
... 31		199840 ..	BUS BAR,DIODE	2
... 32		179276 ..	BUSHING,SNAP-IN NYL 1.000 ID X 1.375 MTG HOLE CENT	2

+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.

☞ Hardware is common and not available unless listed.



803 547-C

Figure 1-4. Panel, Front w/Components

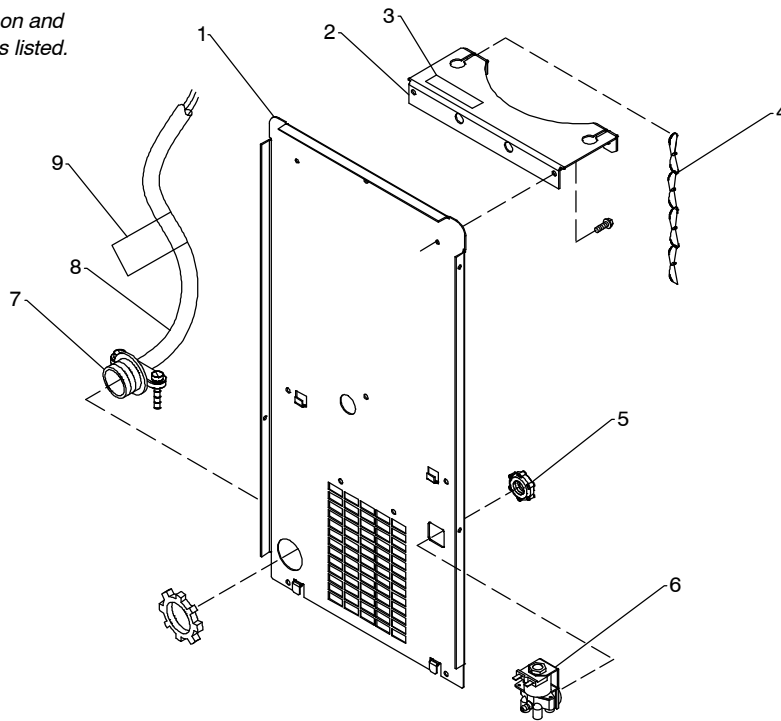
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
----------	------------	----------	-------------	----------

Figure 1-4. Panel, Front w/Components (Fig 1-1 Item 23)

...	1	212837	.. HANDLE,	1
...	2	212845	.. BEZEL,UPPER	1
...	3	212819	.. PANEL,FRONT	1
...	4	212825	.. ENCLOSURE,CIRCUIT CARD ASSY	1
...	5	C8 200953	.. MODULE,FILTER .1MF 500VDC 10 CKT	1
...	6	048282	.. RCPT W/SKTS,(SERVICE KIT)	1
...	C9,10	080894	.. CAPACITOR,CER DISC .01 UF 1000 VDC 20% NYLEZ	2
...	7	190363	.. RCPT W/SKTS,(SERVICE KIT)	1
...	8	S1 128756	.. SWITCH,TGL 3PST 40A 600VAC SCR TERM WIDE TGL	1
...	9	PC3 212979	.. CIRCUIT CARD ASSY,USER INTERFACE	1
...	PLG18	115094	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
...	PLG19	135560	.. HOUSING RCPT+SKTS,(SERVICE KIT)	1
...	PLG28	131055	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
...	10	213936	.. LABEL,POWER/MIG GUN/SPOOLGUN	1
...	11	212847	.. BEZEL,DOOR	1
...		218551	.. INSTRUCTION,FLIPCHART	1
...		215232	.. CLIP,COMPONENT .580H X .715W ADH BACK	2
...		213934	.. LABEL,NAMEPLATE MM350	1
...		213935	.. LABEL,NAMEPLATE MM350P	1
...	12	212955	.. LABEL,CONTROLS USER INTERFACE	1
...	13	213134	.. KNOB,ENCODER 1.670 DIA X .250 ID PUSH ON W/SPRING	2
...	14	210398	.. BUSHING,SNAP-IN	2
...	15	PC6 220524	.. MODULE, TACH (350 MODEL ONLY) (Eff w/LE132700)	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.

☞ Hardware is common and not available unless listed.



803 549-A

Figure 1-5. Panel, Rear w/Components

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


Figure 1-5. Panel, Rear w/Components (Fig 1-1 Item 10)

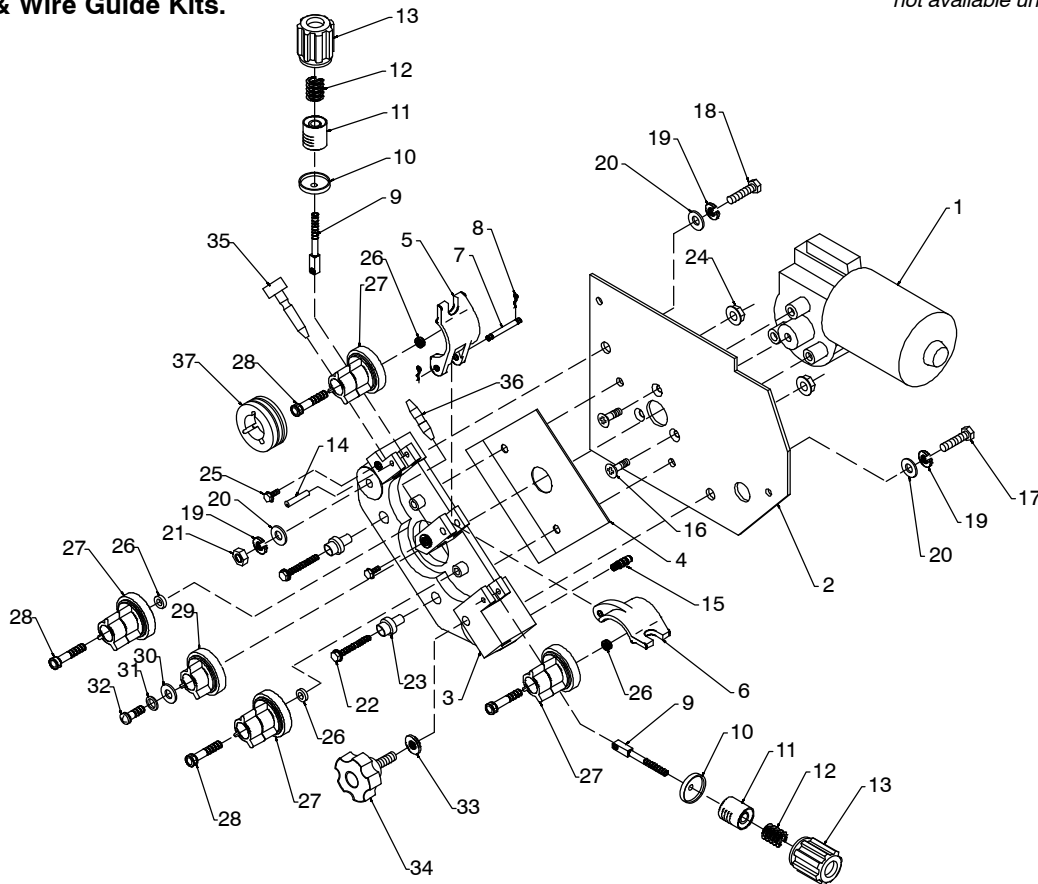
...	1	212820	.. PANEL,REAR	1
...	2	169654	.. BRACKET,SUPPORT TANK	1
...	3	200285	.. LABEL,WARNING CYLINDER MAY EXPLODE IF DAMAGED	1
...	4	188441	.. CHAIN,WELDLESS 2/0 X 31. BRIGHT ZINC PLD	1
...	5	137761	.. NUT, 750NPT 1.31HEX .27H NYL BLK	1
...	6	GS1 216395	.. VALVE, 34VDC 2WAY CUSTOM PORT 1/8 ORF W/FRICT	1
...	7	010467	.. CONN,CLAMP CABLE 1.250	1
...	8	212772	.. CABLE,POWER 10 FT 6IN 6GA 4C (200/230V)	1
...		◆213 380	.. PLUG,STR GRD 2P3W 50A 250VAC *6-50P	1
...	8	213018	.. CABLE,POWER 10 FT 6 IN 10GA 4C (460/575V)	1
...		213908	.. PLATE,ADAPTER POWER CORD (575 MODEL ONLY)	1
...	9	214654	.. LABEL,WARNING ELECTRIC SHOCK/INPUT POWER	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.

**See Table 10-1
Drive Roll & Wire Guide Kits.**

 Hardware is common and not available unless listed.



803 548-B

Figure 1-6. Wire Drive Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
213137 Figure 1-6. Wire Drive Assembly				
...	1	216409	MOTOR,GEAR 24VDC 150RPM 24:1 RATIO W/TACH	1
...	2	212844	INSULATOR,DRIVE HOUSING 4 ROLL	1
...	3	166337	HOUSING,ADAPTER GUN/FEEDER (SALABLE AS 046621)	1
...	4	194521	INSULATOR,DRIVE ASSY	1
...	5	166071	LEVER,MTG PRESSURE GEAR	1
...	6	166338	LEVER,MTG PRESSURE GEAR	1
...	7	079634	PIN,HINGE	1
...	8	151828	PIN,COTTER HAIR .042 X .750	2
...	9	085242	FASTENER,PINNED	2
...	10	085244	WASHER,CUPPED .328IDX .812ODX16GAX.125 LIP	2
...	11	196896	CUP,SPRING	2
...	12	196897	SPRING,CPRSN .695 OD X .095 WIRE X 1.500	2
...	13	196895	KNOB,TENSION	2
...	14	010224	PIN,SPRING CS .187 X 1.000	2
...	15	079633	FTG,HOSE BRS BARBED NIPPLE 3/16 TBG	1
...	16	195640	SCREW,M 6-1.0X 16 FLATHD-PHL STL PLD	3
...	17	079240	SCREW,375-16X1.75 HEX HD-PLN STL PLD FULL THRD	1
...	18	601966	SCREW,375-16X1.25 HEX HD-PLN GR5 PLD	1
...	19	602213	WASHER,LOCK .380IDX0.691ODX.115T STL PLD SPLIT.375	3
...	20	602242	WASHER,FLAT .375IDX0.875ODX.083T STL PLD	1
...	21	601872	NUT, 375-16 .56HEX .34H STL PLD	1
...	22	108943	SCREW,250-20X1.50 HEXWHD.61D GR5 PLD	2
...	23	168590	BUSHING,INSULATING (Prior to LE350335)	2
...	23	072010	WASHER,SHLDR.316ID 0.812ODX.187T .437ODX.578T NYL (Prior to LE350335)	2

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
213137 Figure 1-6. Wire Drive Assembly (Continued)				
23		221 654	WASHER,SHLDR INSULATING (Eff w/LE350335)	2
24		089800	NUT, 250-20 .44HEX .22H STL PLD .58D FLANGE DEFOR	2
25		602154	SCREW,250-20X .50 HEXWHD.50D STL PLD SLFFMG TAP-RW	2
26		166072	SPACER,GEAR	2
27		172075	CARRIER,DRIVE ROLL W/COMPONENTS 24 PITCH	4
28		602009	SCREW,250-20X1.25 SOC HD-HEX GR8 PLN	4
29		173618	CARRIER,DRIVE ROLL 10MM SHAFT	1
30		195802	WASHER,FLAT .175IDX0.590ODX.040T STL PLD	1
31		602241	WASHER,FLAT .281IDX0.625ODX.065T STL PLD ANSI.250	2
32		174609	SCREW,M 4- .7X 12 CHEESE HD BLK DIN 84	1
33		604538	WASHER,FLAT .344IDX0.688ODX.065T STL PLD ANSI.312	1
34		204585	KNOB,FLUTED 1.75 IN W/ .312-18 STUD 1.00 LG	1
35		045127	GUIDE,WIRE INLET ANTI-WEAR (Prior to LE425934)	1
35		602169	SCREW,SET # 8-32X .18 CUP PT SCH STL PLN (Prior to LE425934)	1
35		056193	GUIDE,WIRE INLET (Prior to LE425934)	1
35		221912	GUIDE,WIRE INLET NYLON .023 - .052 (Eff w/LE425934)	1
36		056207	GUIDE,WIRE INTERMEDIATE	1
37		189285	ROLL,DRIVE V GROOVE .035-.045 WIRE	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.

Table 10-1. Drive Roll And Wire Guide Kits

 Base selection of drive rolls upon the following recommended usages:

- 1 V-Grooved rolls for hard wire.
- 2 U-Grooved rolls for soft and soft shelled cored wires.
- 3 V-Knurled rolls for hard shelled cored wires.
- 4 Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Kit No.	Drive Roll		Wire Guide	
Fraction	Decimal	Metric		Part No.	Type	Inlet	Intermediate
.023/.025 in	.023/.025 in	0.6 mm	087 132	087 130	V-Grooved	056 192	056 206
.030 in	.030 in	0.8 mm	046 780	053 695	V-Grooved	056 192	056 206
.035 in	.035 in	0.9 mm	046 781	053 700	V-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 782	053 697	V-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 783	053 698	V-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 784	053 699	V-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	044 750	072 000	U-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 785	053 701	U-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 786	053 702	U-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 787	053 706	U-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	046 792	132 958	V-Knurled	056 192	056 206
.045 in	.045 in	1.2 mm	046 793	132 957	V-Knurled	056 193	056 207
.052 in	.052 in	1.3 mm	046 794	132 956	V-Knurled	056 193	056 207
1/16 in	.062 in	1.6 mm	046 795	132 955	V-Knurled	056 195	056 209

Ref. S-0025-D

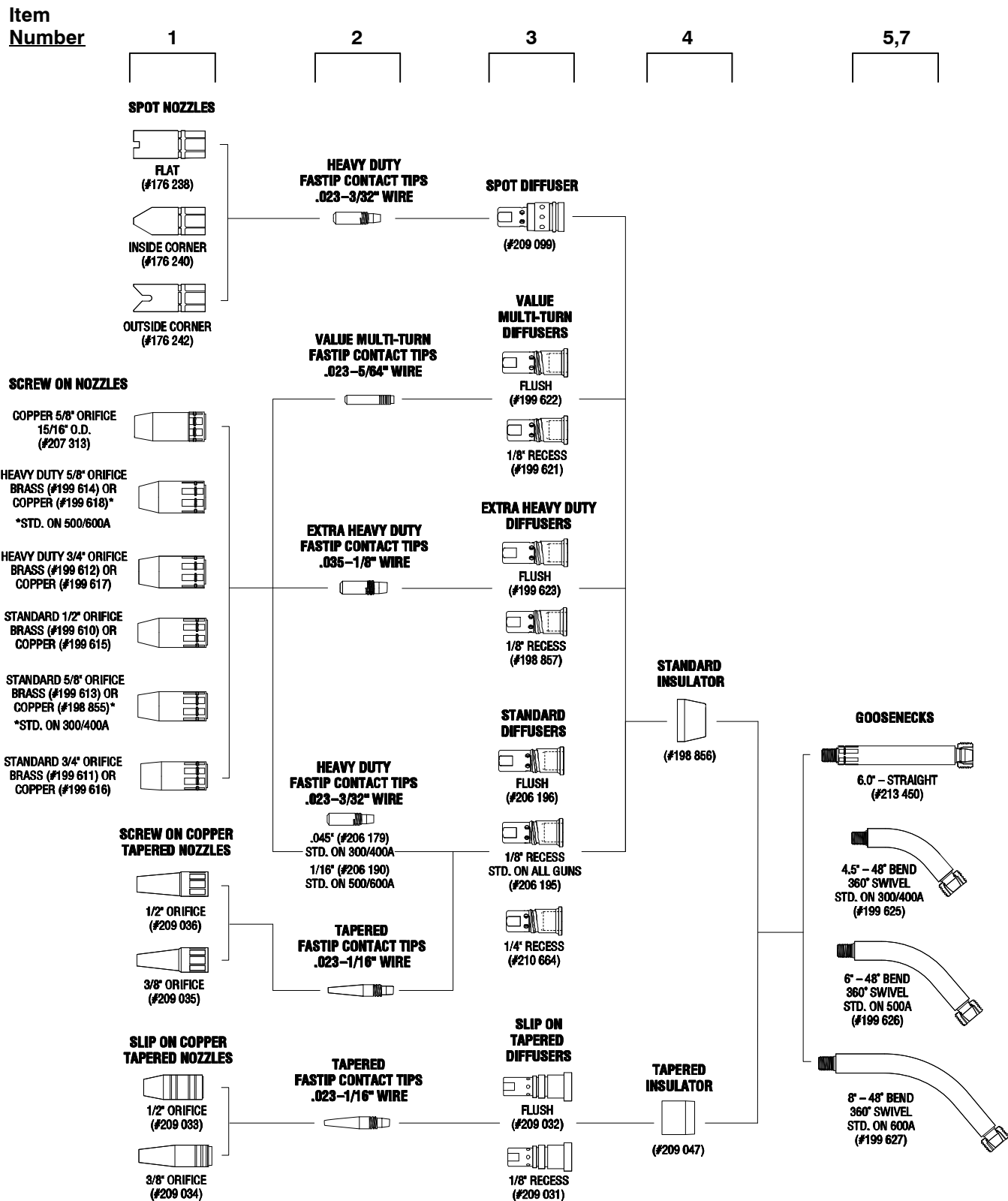


Figure 1-7. Consumables Flowchart

Item No.	Part No.	Description	Quantity
----------	----------	-------------	----------

Figure 1-7. Consumables Flowchart

Table 10-2. 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	◆199 610	.. NOZZLE, screw on brass 1/2 in orifice	1
...	1	◆199 611	.. NOZZLE, screw on brass 3/4 in orifice straight	1
...	1	◆199 612	.. NOZZLE, screw on brass 3/4 in orifice straight heavy duty	1
...	1	◆199 613	.. NOZZLE, screw on brass 5/8 in orifice	1
...	1	◆199 614	.. NOZZLE, screw on brass 5/8 in orifice heavy duty	1
...	1	◆199 615	.. NOZZLE, screw on copper 1/2 in orifice	1
...	1	◆199 616	.. NOZZLE, screw on copper 3/4 in orifice	1
...	1	◆199 617	.. NOZZLE, screw on copper 3/4 in orifice heavy duty	1
...	1	198 855	.. NOZZLE, screw on copper 5/8 in orifice (standard on 300 & 400 amp models)	1
...	1	199 618	.. NOZZLE, screw on copper 5/8 in orifice heavy duty (standard on 500 & 600 amp models)	1
...	1	◆207 313	.. NOZZLE, screw on copper 5/8 in orifice 15/16 OD	1
...	1	◆209 033	.. 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	◆209 034	.. 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	◆209 035	.. NOZZLE, screw on copper 3/8 in orifice tapered (requires diffuser 206195, 206196 or 210664, used with any tapered FasTip™ contact tip)	1
...	1	◆209 036	.. NOZZLE, screw on copper 1/2 in orifice tapered (requires diffuser 206195, 206196 or 210664, used with any tapered FasTip™ contact tip)	1

Table 10-3. Heavy Duty FasTip™ Contact Tips*

...	2	◆206 184	.. .023 in (0.6 mm)	1
...	2	◆206 185	.. .030 in (0.8 mm)	1
...	2	206 186	.. .035 in (0.9 mm)	1
...	2	◆206 187	.. .040 in (1.0 mm)	1
...	2	◆206 188	.. .045 in (1.2 mm)	1
...	2	◆206 189	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) aluminum wire	1
...	2	206 190	.. 1/16 in (1.6 mm)	1
...	2	◆206 191	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) aluminum wire	1
...	2	◆206 192	.. 5/64 in (2.0 mm)	1
...	2	◆206 193	.. 3/32 in (2.4 mm)	1

Table 10-4. Extra Heavy Duty FasTip™ Contact Tips*

...	2	◆199 605	.. .035 in (0.9 mm)	1
...	2	◆199 606	.. .040 in (1.0 mm)	1
...	2	◆198 851	.. .045 in (1.2 mm)	1
...	2	◆198 852	.. .052 in (1.3 mm) or 3/64 in (1.2 mm) aluminum wire	1
...	2	◆198 853	.. 1/16 in (1.6 mm)	1
...	2	◆198 854	.. .068 in (1.7 mm) or 1/16 in (1.6 mm) aluminum wire	1
...	2	◆199 607	.. 5/64 in (2.0 mm)	1
...	2	◆199 608	.. 3/32 in (2.4 mm)	1
...	2	◆199 609	.. 7/64–1/8 in (2.8 mm)	1

Item No.	Part No.	Description	Quantity
----------	----------	-------------	----------

Figure 1-7. Consumables Flowchart (Continued)

Table 10-5. Tapered FasTip™ Contact Tips*

...	2	◆209024	.. .023 in (0.6 mm)	1
...	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

Table 10-6. Value Multi-Turn Contact Tips*

...	2	◆087 300	.. .023 in (0.6 mm)	1
...	2	◆071 825	.. .030 in (0.9 mm)	1
...	2	◆054 202	.. .035 in (0.9 mm)	1
...	2	◆054 201	.. .045 in (1.2 mm)	1
...	2	◆199 593	.. 3/64 in (1.2 mm) aluminum wire	1
...	2	◆044 006	.. .052 in (1.3 mm)	1
...	2	◆047 566	.. 1/16 in (1.6 mm)	1
...	2	◆202 933	.. 1/16 in (1.6 mm) aluminum wire	1
...	2	◆199 594	.. .068 in (1.7 mm)	1
...	2	◆047 565	.. 5/64 in (2.0 mm)	1

Table 10-7. Gas Diffusers

...	3	◆198 857	.. 1/8 in tip recess – for extra heavy duty FasTip contact tips	1
...	3	◆199 623	.. Flush tip – for extra heavy duty FasTip contact tips	1
...	3	◆199 621	.. 1/8 in tip recess – for value multi-turn contact tips	1
...	3	◆199 622	.. Flush tip – for value multi-turn contact tips	1
...	3	206 195	.. 1/8 in tip recess – for heavy duty FasTip contact tips (standard on all guns)	1
...	3	◆210 664	.. 1/4 in tip recess – for heavy duty FasTip contact tips	1
...	3	◆206 196	.. Flush tip – for heavy duty FasTip contact tips	1
...	3	◆209 031	.. Slip on recessed diffuser (requires nozzle 209033 or 209034 and insulator 209047, used with any tapered FasTip contact tip)	1
...	3	◆209 032	.. Slip on flush diffuser (requires nozzle 209033 or 209034 and insulator 209047, used with any tapered FasTip contact tip)	1
...	3	◆209 099	.. Spot diffuser (requires spot nozzle 176238 or 176240 or 176242)	1

Table 10-8. Insulators

...	4	198 856	.. INSULATOR, Rubber	1
...	4	209 047	.. INSULATOR, Teflon (required when using diffuser 209031 or 209032 with nozzle 209033 or 209034)	1
...	5	202 292	.. COVER, nut	1

Table 10-9. Liners

...	6	◆202 889	.. LINER, monocoil .023-.030 wire x 16.5 ft round wound	1
...	6	202 890	.. LINER, monocoil .035-.045 wire x 16.5 ft round wound (standard on 300 & 400 amp models)	1
...	6	202 891	.. LINER, monocoil .052-1/16 wire x 16.5 ft round wound (standard on 500 & 600 amp models)	1
...	6	◆202 892	.. LINER, monocoil 1/16-.078 wire x 16.5 ft flat wound	1
...	6	◆202 893	.. LINER, monocoil 5/64-3/32 wire x 16.5 ft flat wound	1
...	6	◆202 894	.. LINER, monocoil 7/64-1/8 wire x 16.5 ft flat wound	1
...	6	◆202 895	.. LINER, monocoil 3/64-1/16 AL wire x 16.5 ft	1

Item No.	Part No.	Description	Quantity
----------	----------	-------------	----------

Figure 1-7. Consumables Flowchart (Continued)

Table 10-10. Goosenecks

... 7	+199 625	.. GOOSENECK, jacketed 4.5 in/50deg wrench swivel (standard on 300 & 400 amp models)	1
... 7	+199 626	.. GOOSENECK, jacketed 6 in/50deg wrench swivel (standard on 500 amp models)	1
... 7	+199 627	.. GOOSENECK, jacketed 8 in/50deg wrench swivel (standard on 600 amp models)	1
... 7	+♦213 450	.. GOOSENECK, jacketed 6.0" straight	1

♦OPTIONAL

+Includes nozzle insulator 198 856 and threaded nut cover 202 292.

*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.

Standard Consumables Chart	
Contact Tip	206 186
Nozzle	198 855
Diffuser	206 195
Liner	202 890
Gooseneck	199 625

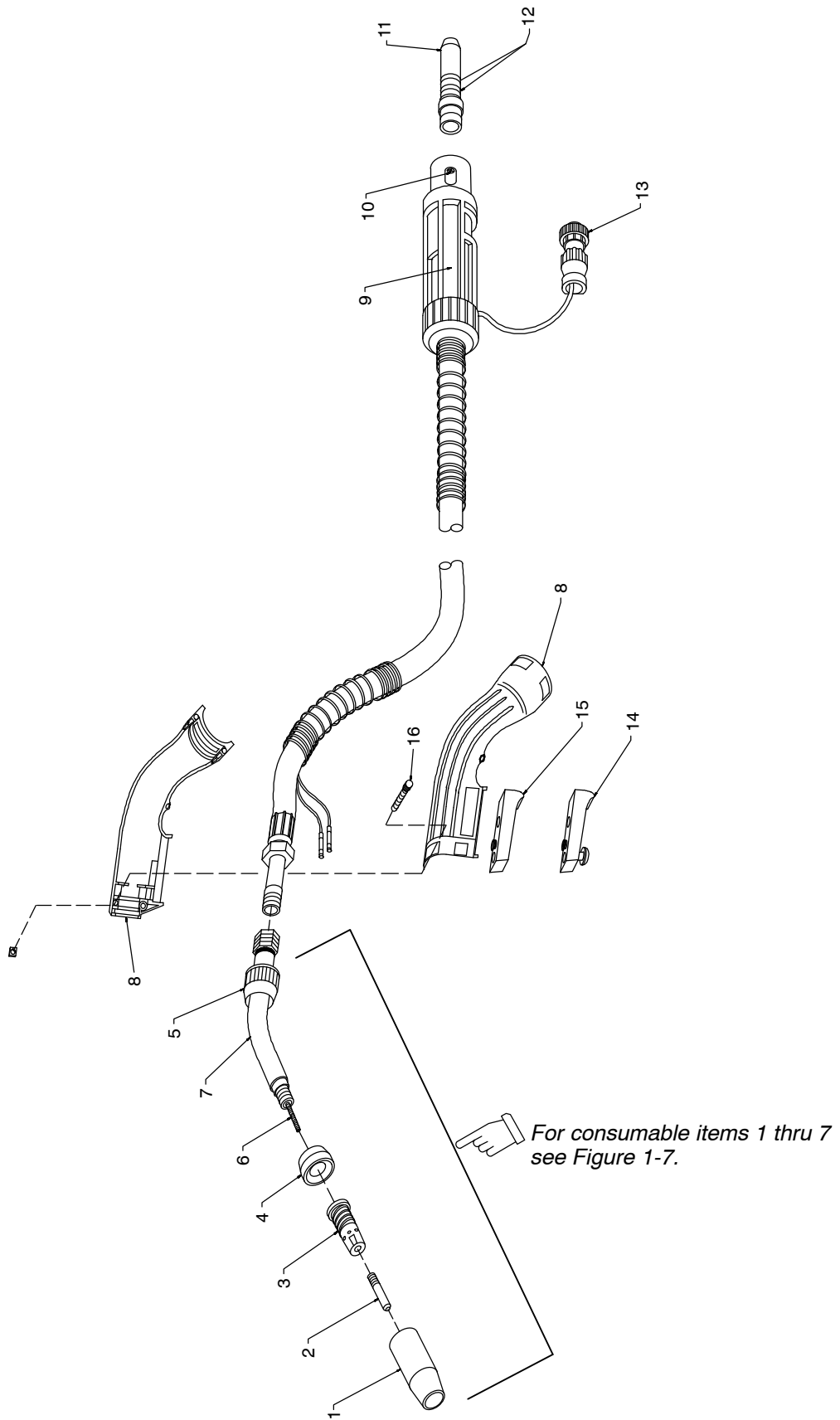


Figure 1-8. 4012 Gun

Item No.	Part No.	Description	Quantity
Figure 1-8. 4012 Gun			
...	8	199 630 .. HANDLE KIT, 300 & 400 amp models (includes)	1
.....		199 632 SCREW, M4 x 18	4
.....		199 633 NUT, M4	4
.....		199 634 SCREW, M3 x 11	1
.....		199 635 NUT, M3	1
.....		199 647 LABEL, gun handle Miller Roughneck	2
...	8	199 631 .. HANDLE KIT, 500 & 600 amp models (includes)	1
.....		199 632 SCREW, M4 x 18	4
.....		199 633 NUT, M4	4
.....		199 647 LABEL, gun handle Miller Roughneck	2
...	9	199 652 .. LABEL, back-end C-4012	1
...	10	199 637 .. SCREW, machine binding head	1
...	11	199 640 .. ADAPTER, Miller power pin (includes)	1
...	12	079 974 O-RING, Miller power pin	2
...	13	079 878 .. HOUSING, plug and pins (includes)	1
.....		079 531 CONN, circ cpc clamp str rlf size 11 .453 OD	1
...	14	◆199 661 .. SWITCH, locking trigger	1
...	15	199 628 .. SWITCH, trigger (standard on all guns)	1
...	16	199 629 .. SWITCH, contact pin	2
.....		◆199 662 .. HOOK, gun	1
.....		◆199 663 .. KIT, adapter Miller to old Hobart/Thermal/Tweco (includes)	1
.....		202 916 ADAPTER, Roughneck to old Hobart	1
.....		201 727 CONTROL LEADS, Hobart	1
.....		◆199 664 .. KIT, adapter Miller to Lincoln (includes)	1
.....		202 918 ADAPTER, Roughneck to Lincoln	1
.....		201 728 CONTROL LEADS, Lincoln	1

◆OPTIONAL

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.



PM-1327B

2021-09

Processes



MIG (GMAW) Welding



Flux Cored (FCAW) Welding

Description



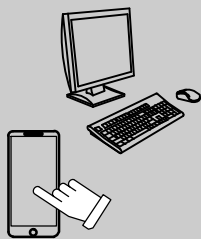
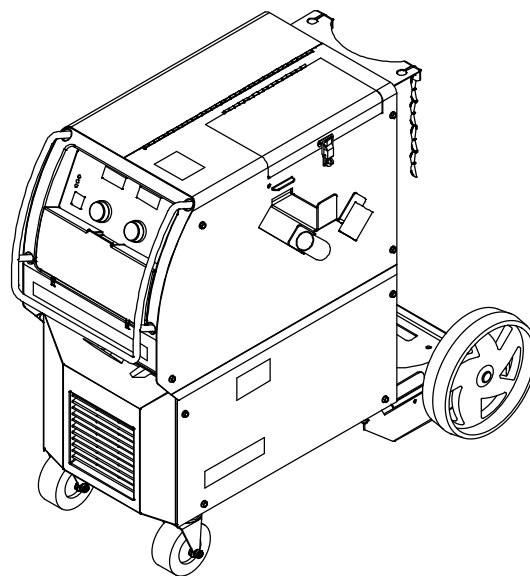
Arc Welding Power Source
and Wire Feeder

Millermatic[®] 350 And Millermatic[®] 350P

PARTS LIST

Eff w/LE443590 Thru LJ420782B

For OM-1327 (213 814) Revision J Thru Revision Y




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

www.MillerWelds.com

File: MIG (GMAW)



SECTION 2 – PARTS LIST (Eff w/LE443590 Thru LJ420783B)

 Hardware is common and not available unless listed.

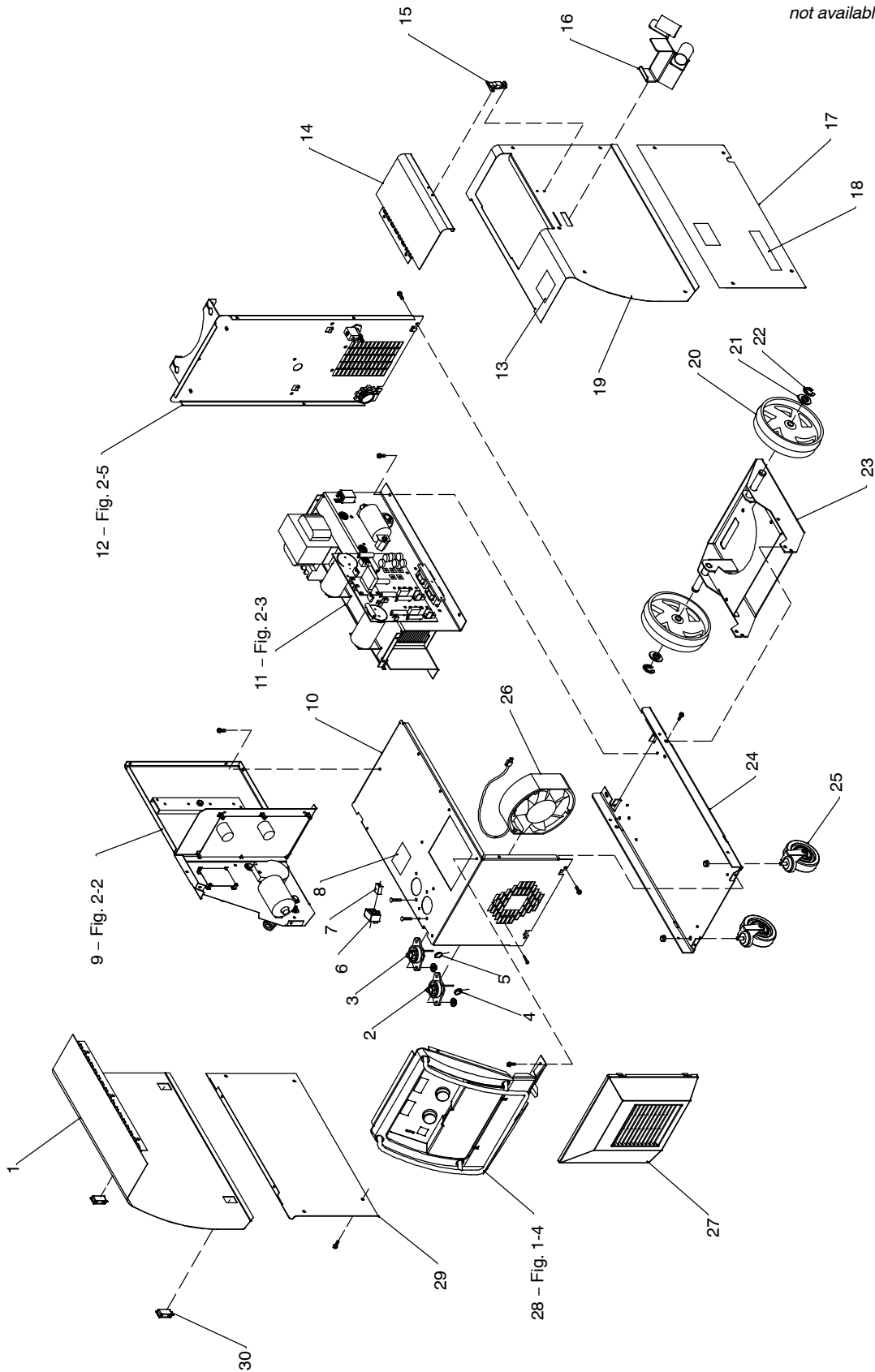


Figure 2-1. Main Assembly

803 545-C

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

Figure 2-1. Main Assembly

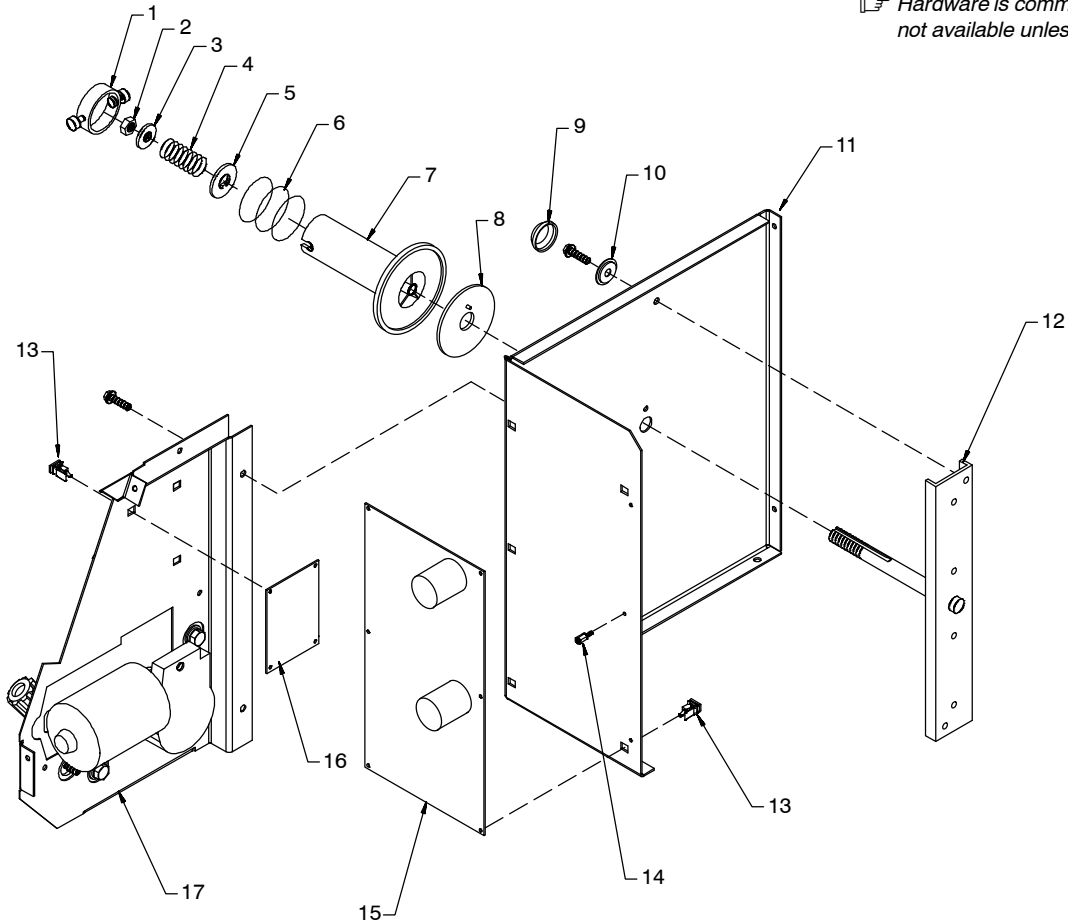
...	1	212829	DOOR,ACCESS WIRE COMPARTMENT	1
...	2	NEG 097416	TERMINAL,PWR OUTPUT BLACK	1
...	3	POS 097421	TERMINAL,PWR OUTPUT RED	1
...	4	C6 232049	CAPACITOR	1
...	5	C7 232050	CAPACITOR	1
...	6	HD1 189567	TRANSDUCER,CURRENT 400A MODULE SUPPLY V +/- 15V	1
...		183046	CABLE,LEM	1
...	7	221326	BUS BAR,CURRENT SENSOR	1
...	8	199824	LABEL,WARNING ELECTIC SHOCK AND PINCH POINTS (Prior to LH410225B)	1
...	8	231985	LABEL,WARNING ELECTRIC SHOCK AND PINCH (EN/SP) (Eff w/LH410225B)	1
...	9	Fig 2-2	BAFFLE,CENTER	1
...	10	212821	PANEL,FRONT LOWER	1
...	11	Fig 2-3	INVERTER ASSY	1
...	12	+Fig 2-5	PANEL,REAR	1
...	13	134464	LABEL,WARNING GENERAL PRECAUTIONARY STATIC&WIRE (Prior to LH410225B)	1
...	13	231983	LABEL,WARNING GENERAL PRECAUTIONARY (EN/SP) (Eff w/LH410225B)	1
...	14	212826	DOOR,ACCESS TOOL COMPARTMENT	1
...	15	217829	LATCH,DOOR STRAIGHT LOOP CATCH	1
...	16	215061	GUN/CABLE HOLDER	1
...	17	+222288	PANEL,SIDE RH LOWER (200/230/460V model)	1
...		180994	LABEL,WARNING MATCH INPUT POWER (200/230/460V model) (Prior to LH410225B)	1
...		235242	LABEL,WARNING MATCH INPUT POWER (200/230/460V model) (EN/SP) (Eff w/LH410225B)	1
...		222325	LABEL,WARNING INPUT POWER RELINK (200/230/460V model) (Prior to LH410225B)	1
...		235245	LABEL,WARNING INPUT POWER RELINK (EN/SP) (200/230/460V model) (Eff w/LH410225B)	1
...	18	213939	LABEL,WARNING ELECTRIC SHOCK CAN KILL SIGNIFICANT (Prior to LH410225B)	1
...	18	235244	LABEL,WARNING ELECTRIC SHOCK CAN KILL (EN/SP) (Eff w/LH410225B)	1
...	19	+222287	WRAPPER (200/230/460V model)	1
...	19	+212823	WRAPPER (460/575V model)	1
...	20	186758	WHEEL,POLYPROPYLENE 10 IN X 2.25 WIDE (Prior to LH430213B)	2
...	20	230799	WHEEL,POLYPROPYLENE 10 IN X 2.25 WIDE (Eff w/LH430213B)	2
...	21	602250	WASHER,FLAT .812IDX1.469ODX.134T STL PLD ANSI.750	2
...	22	121614	RING,RTNG EXT .750 SHAFT X .085 THK E STYLE PLD	2
...	23	213903	RACK,CYLINDER SINGLE	1
...	24	212833	BASE,	1
...	25	209870	CASTER,SWVL 4.00 IN X 1.250 IN POLY-OLEFIN (Prior to LH430213B)	2
...	25	235875	CASTER,SWVL 4.00 IN POLYOLEFIN X 1.250 IN WIDE (Eff w/LH430213B)	2
...	26	FM 213043	FAN,MUFFIN 24VDC 3000 RPM W/20.500 IN LEADS	1
...	27	212846	BEZEL,LOWER	1
...	28	Fig 1-4	PANEL,FRONT	1
...	29	212822	PANEL,SIDE LH LOWER	1
...	30	151187	LATCH,SLIDE FLUSH MTG HOLE 1.000 WIDEX 1.500 LG	2

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 2-1. Main Assembly (Continued)				
.....		210925	REGULATOR/FLOWMETER,0-50 CFH AR/CO2 W/FLOWTUBE(350P MODEL) (Prior to LH490000B)	1
.....		234263	REGULATOR/FLOWMETER, 0-50 CFH AR/CO2/MIX W/FILTER	1
.....		144108	HOSE,GAS 5FT	1
.....		196329	CABLE,WORK 10 FT NO1 W/CLAMP & BOOT (350 MODEL) (INCLUDING) (Prior to LH420001B)	1
.....		233452	CLAMP,WORK 300 AMP	1
.....		196318	COVER,CABLE BTRY POST BLK .75 ID	1
.....		213369	CABLE,WORK 10 FT 1/O W/CLAMP & BOOT (INCLUDING) (Eff w/LH420001B)	1
.....		213619	CLAMP,WORK 300 AMP STL CHROME PLD W/COP CONTACTS	1
.....		196318	COVER,CABLE BTRY POST BLK .75 ID	1
.....		†229 560	Q300 AMP GUN, 15FT .035 STL W/FLUSH COPPER NOZZLE	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.

☞ Hardware is common and not available unless listed.



803 546-C

Figure 2-2. Baffle, Center w/Components

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

Figure 2-2. Baffle, Center w/Components (Fig 2-1 Item 7)

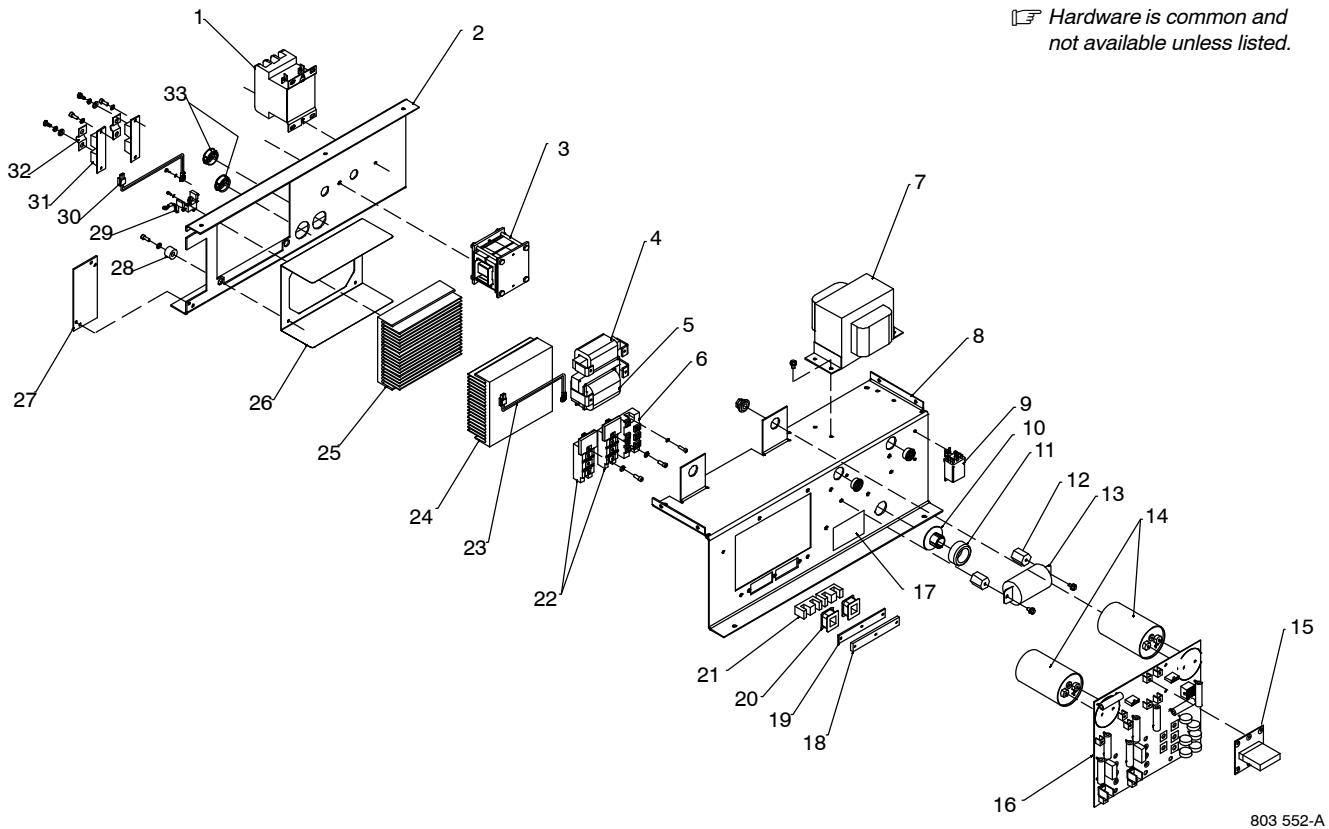
.. 1		058427	.. RING,RETAINING SPOOL	1
.. 2		085980	.. NUT,STL HEX FULL .625-11	1
.. 3		605941	.. WASHER,FLAT STL .640 ID X 1.000 OD X 14GA THK	1
.. 4		186437	.. SPRING,CPRSN .845 OD X .110 WIRE X 1.500	1
.. 5		057971	.. WASHER,FLAT STL KEYED 1.500DIA X .125THK	1
.. 6		057745	.. SPRING,CPRSN 2.305 OD X .090 WIRE X 2.500 PLD	1
.. 7		186435	.. HUB,SPOOL	1
.. 8		186436	.. WASHER,BRAKE PLASTIC	1
.. 9		198425	.. CAP,FINISHING 1.19 X .37	2
.. 10		198426	.. WASHER,CAP	2
.. 11		223921	.. BAFFLE,CENTER	1
.. 12		177307	.. REEL SUPPORT (Prior to LH440399B)	1
.. 12		235827	.. REEL SUPPORT (Eff w/LH440399B)	1
.. 13		134201	.. STAND-OFF SUPPORT,PC CARD .312/.375W/POST&LOCK .43	9

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
Figure 2-2. Baffle, Center w/Components (Fig 2-1 Item 7) (Continued)				
. 14		204310	.. STAND-OFF,NO 6-32 X .437 LG .250 HEX AL M&F	1
. 15	PC1	223542	.. KIT,MM350 CONTROL BD W/INSTRUCTIONS (Prior to LH170741B)	1
. 15	PC1	223670	.. KIT,MM350 CONTROL BD 460/575 W/INSTRUCTIONS (Prior to LH170741B)	1
. 15	PC1	233597	.. KIT,MM350 CONTROL BOARD W/ INSTRUCTIONS (200/230/460V model) (Eff w/LH170741B)	1
. 15	PC1	233598	.. KIT,MM350 CONTROL BOARD W/ INSTRUCTIONS (460/575V model) (Eff w/LH170741B)	1
.....	PLG9	115093	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
.....	PLG7	115092	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
.....	PLG8	131056	.. HOUSING RCPT+SKTS,(SERVICE KIT)	1
.....	PLG10,14	115091	.. HOUSING PLUG+SKTS,(SERVICE KIT)	2
.....	PLG11,12,			
.....	17	131054	.. HOUSING PLUG+SKTS,(SERVICE KIT)	3
.....	PLG15,16	131204	.. HOUSING PLUG+SKTS,(SERVICE KIT)	2
.....		213404	.. CABLE,INTERCONNECTING RS 485 INTERFACE TO CONTROL	1
.....		213405	.. CABLE,INTERCONNECTING RS 485 INTERFACE TO PULSE OP	1
.....		168674	.. CABLE,RIBBON 24 POSN 14.000 IN SKTS BE INVERTED (Prior to LJ2314678B)	1
. 16	PC6	216342	.. CIRCUIT CARD ASSY,GMAW PULSE W/PROGRAM (PULSE MODEL ONLY)	1
. 16	PC6	220250	.. CIRCUIT CARD ASSY,TACH W/PROGRAM (NON-PULSE MODEL ONLY) (Eff w/LJ231478B)	1
.....	PLG29	131204	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
.....	PLG30	115091	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
. 17		Fig 2-6	.. DRIVE ASSY,WIRE 4 ROLL	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.

☞ Hardware is common and not available unless listed.



803 552-A

Figure 2-3. Inverter Assy

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

Figure 2-3. Inverter Assy (Fig 2-1 Item 9)

...	1	W	188634	CONTACTOR,DEF PRP 60A 3P 24VAC COIL W/COVER	1
			C11,12,		
			13	CAPACITOR,CER DISC .003 UF 2000 VAC W/TERMS	3
...	2		+212750	WINDTUNNEL,LH	1
			185835	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (Prior to LH410225B)	1
			235243	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (EN/SP) (Eff w/LH410225B)	1
...	3	T1	180952	XFMR,HF	1
...	4	L1	222392	INDUCTOR,INPUT (200/230/460V model)	1
...	4	L1	216006	INDUCTOR,INPUT (460/575V model)	1
...	5	Z1	212756	STABILIZER,OUTPUT	1
...	6	SR1	212937	KIT,DIODE POWER MODULE	1
...	7	T2	224238	XFMR,CONTROL 200/230/460 PRI	1
...	7	T2	223922	XFMR,CONTROL 460/575 PRI	1
			PLG26	HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
...	8		+212752	WINDTUNNEL,RH	1
...	9	CR1	106462	RELAY,ENCL 24VDC DPDT 20A/120VAC 8PIN FLANGE MTG	1
...	10		177547	BUSHING,SNAP-IN NYL CT-MOUNT 1.125 MTG HOLE	1
...	11	CT1	213032	XFMR,CURRENT (Prior to LJ231478B)	1
...	11	CT1	237942	XFMR,CURRENT W/INTERLOCK (Eff w/LJ231478B)	1
...	12		025248	STAND-OFF,INSUL .250-20 X 1.250 LG X .437 THD	2
...	13	C1	186015	CAPACITOR,POLYP FILM .34 UF 1000 VAC +8% -0% (200/230/460V model)	1
...	13	C1	193858	CAPACITOR,POLYP FILM .27 UF 1000 VAC +8% -0% (460/575V model)	1

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

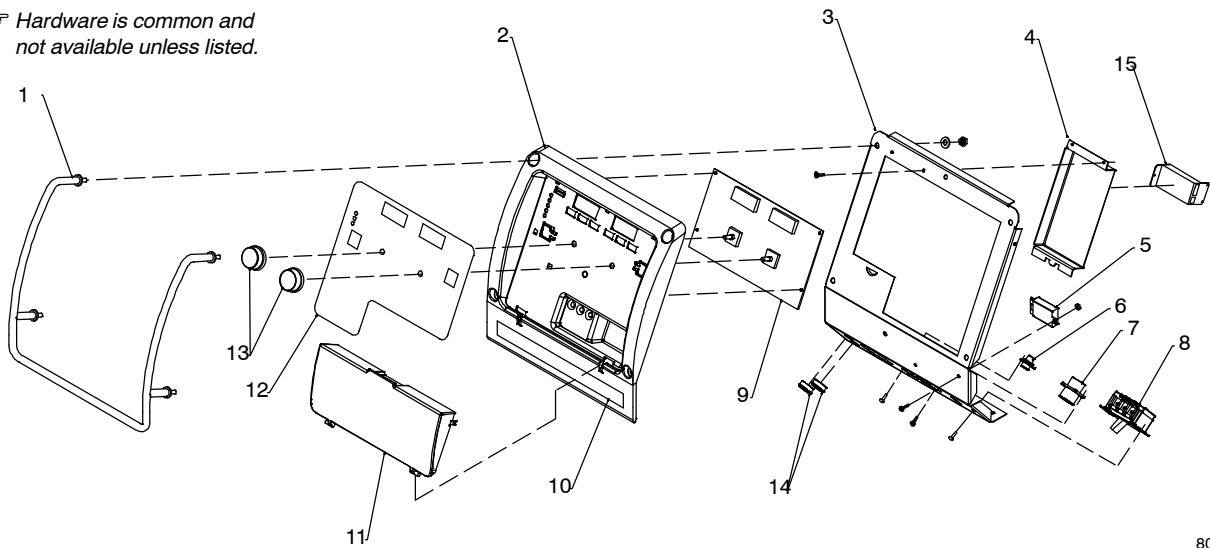
To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 2-3. Inverter Assy (Fig 2-1 Item 9) (Continued)				
... 14 ...	C3,4	192935	CAPACITOR,ELCTLT 2700 UF 450 VDC CAN 2.52 DIA (200/230/460 MODELS)	2
... 14 ...	C3,4	217941	CAPACITOR,ELCTLT 1800 UF 500 VDC CAN 2.52 DIA (460/575 MODELS)	2
		217942	SPACER,NYLON CAPACITOR	1
		217040	NUT,NYLON M12 THREAD CAPACITOR MOUNTING	1
... 15 ...	PC7	221047	CIRCUIT CARD ASSY,RELINK (200/230/460V model)	1
... 16 ...	PC2	221043	CIRCUIT CARD ASSY,INTERCONNECT (200/230/460V model)	1
... 16 ...	PC2	219900	CIRCUIT CARD ASSY,INTERCONNECT (460/575V model)	1
	PLG2	168071	HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
... 17		185835	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (Prior to LH410225B)	1
... 17		235243	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (EN/SP) (Eff w/LH410225B)	1
... 18		175140	BRACKET,DI-DT	1
		178591	LABEL,CONNECTION DI/DT	1
... 19		181197	GASKET,DI-DT RUBBER	1
... 20 ...	L3,4	175482	COIL,DI/DT	2
... 21		109056	CORE,FERRITE E 2.164 LG X 1.094 HIGH X .826 WIDE	2
... 22	PM1,2	212936	KIT,TRANSISTOR IGBT MODULE (KIT INCLUDES 2 IGBTs)	1
... 23 ...	RT2	213029	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 3P	1
... 24		212776	HEAT SINK,POWER MODULE	1
... 25		212753	HEAT SINK,RECT	1
... 26		175255	INSULATOR,RECTIFIER	1
... 27		214537	COVER,ACCESS FAN MOTOR	1
... 28		181853	INSULATOR,SCREW	4
... 29	C2,R1,C5	232296	RESISTOR/CAPACITOR,	1
... 30 ...	RT1	213028	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 2P	1
... 31 ...	D1,2	201531	KIT,DIODE POWER MODULE	2
... 32		199840	BUS BAR,DIODE	2
... 33		179276	BUSHING,SNAP-IN NYL 1.000 ID X 1.375 MTG HOLE CENT	2

+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.

☞ Hardware is common and not available unless listed.



803 547-C

Figure 2-4. Panel, Front w/Components

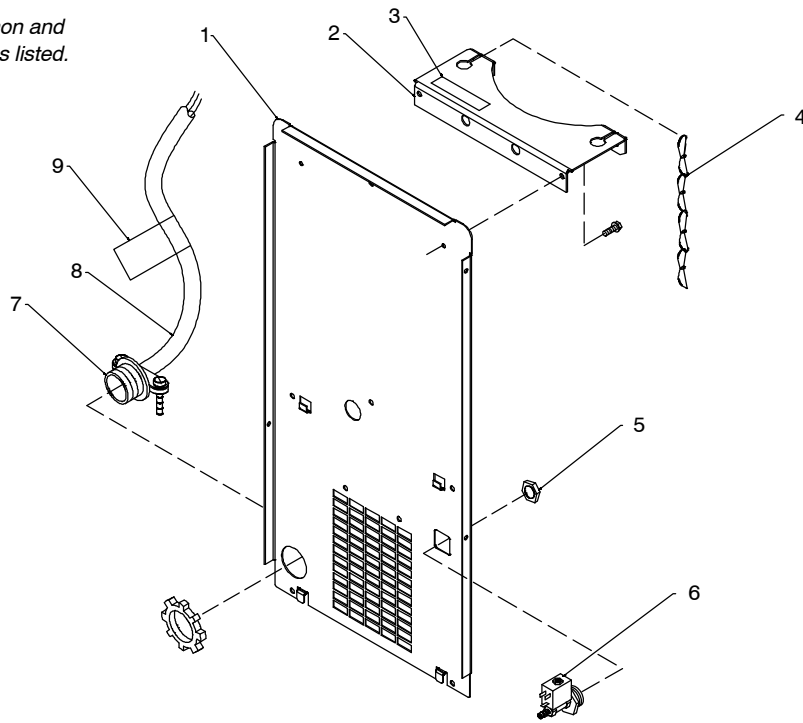
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
----------	------------	----------	-------------	----------

Figure 2-4. Panel, Front w/Components (Fig 2-1 Item 23)

...	1	212837	HANDLE,	1
...	2	212845	BEZEL,UPPER	1
...	3	212819	PANEL,FRONT	1
...	4	212825	ENCLOSURE,CIRCUIT CARD ASSY	1
...	5	C8 200953	MODULE,FILTER .1MF 500VDC 10 CKT(Prior to MA170021B)	1
...	6	048282	RCPT W/SKTS,(SERVICE KIT)	1
...	7	C9,10 080894	CAPACITOR,CER DISC .01 UF 1000 VDC 20% NYLEZ	2
...	7	190363	RCPT W/SKTS,(SERVICE KIT)	1
...	8	S1 128756	SWITCH,TGL 3PST 40A 600VAC SCR TERM WIDE TGL (Prior to LJ151087B)	1
...	8	S1 231191	SWITCH,TGL 3PST 50A 600VAC SCR TERM WIDE TGL (Eff w/LJ151087B)	1
...	9	PC3 212979	CIRCUIT CARD ASSY,USER INTERFACE (Prior to LH170741B)	1
...	9	PC3 233599	KIT,MM350 INTERFACE BD W/INSTRUCTIONS (Eff w/LH170741B)	1
...		PLG18 115094	HOUSING PLUG+SKTS,(SERVICE KIT)	1
...		PLG19 135560	HOUSING RCPT+SKTS,(SERVICE KIT)	1
...		PLG28 131055	HOUSING PLUG+SKTS,(SERVICE KIT)	1
...	10	213936	LABEL,POWER/MIG GUN/SPOOLGUN	1
...	11	212847	BEZEL,DOOR	1
...		218551	INSTRUCTION,FLIPCHART	1
...		215232	CLIP,COMPONENT .580H X .715W ADH BACK	2
...		213934	LABEL,NAMEPLATE MM350	1
...		213935	LABEL,NAMEPLATE MM350P	1
...	12	212955	LABEL,CONTROLS USER INTERFACE	1
...	13	213134	KNOB,ENCODER 1.670 DIA X .250 ID PUSH ON W/SPRING	2
...	14	210398	BUSHING,SNAP-IN	2
...	15	PC6 220524	MODULE, TACH (350 MODEL ONLY) (Prior to LJ041292B)	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.

☞ Hardware is common and not available unless listed.



803 549-B

Figure 2-5. Panel, Rear w/Components

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


Figure 2-5. Panel, Rear w/Components (Fig 2-1 Item 10)

...	1	212820	.. PANEL,REAR	1
...	2	169654	.. BRACKET,SUPPORT TANK	1
...	3	200285	.. LABEL,WARNING CYLINDER MAY EXPLODE IF DAMAGED (Prior to LH410225B)	1
...	3	231986	.. LABEL,WARNING CYL MAY EXPLODE IF DAMAGED (EN/SP) (Eff w/LH410225B)	1
...	4	188441	.. CHAIN,WELDLESS 2/0 X 31. BRIGHT ZINC PLD	1
...	5	220805	.. NUT, 750-14 NPS 1.48HEX .41H NYL	1
...	6	GS1 219062	.. VALVE, 34VDC 1WAY .750-14 THD 1/8 ORF 100PSI	1
...	7	010467	.. CONN,CLAMP CABLE 1.250	1
...	8	212772	.. CABLE,POWER 10 FT 6IN 6GA 4C (200/230/460V)	1
...		◆213 380	.. PLUG,STR GRD 2P3W 50A 250VAC *6-50P	1
...	8	213018	.. CABLE,POWER 10 FT 6 IN 10GA 4C (460/575V)	1
...		213908	.. PLATE,ADAPTER POWER CORD (575 MODEL ONLY)	1
...	9	214654	.. LABEL,WARNING ELECTRIC SHOCK/INPUT POWER (Prior to LH410225B)	1
...	9	235246	.. LABEL,WARNING ELECTRIC SHOCK/INPUT POWER (EN/SP) (Eff w/LH410225B)	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.

**See Table 11-1
Drive Roll & Wire Guide Kits.**

 Hardware is common and not available unless listed.

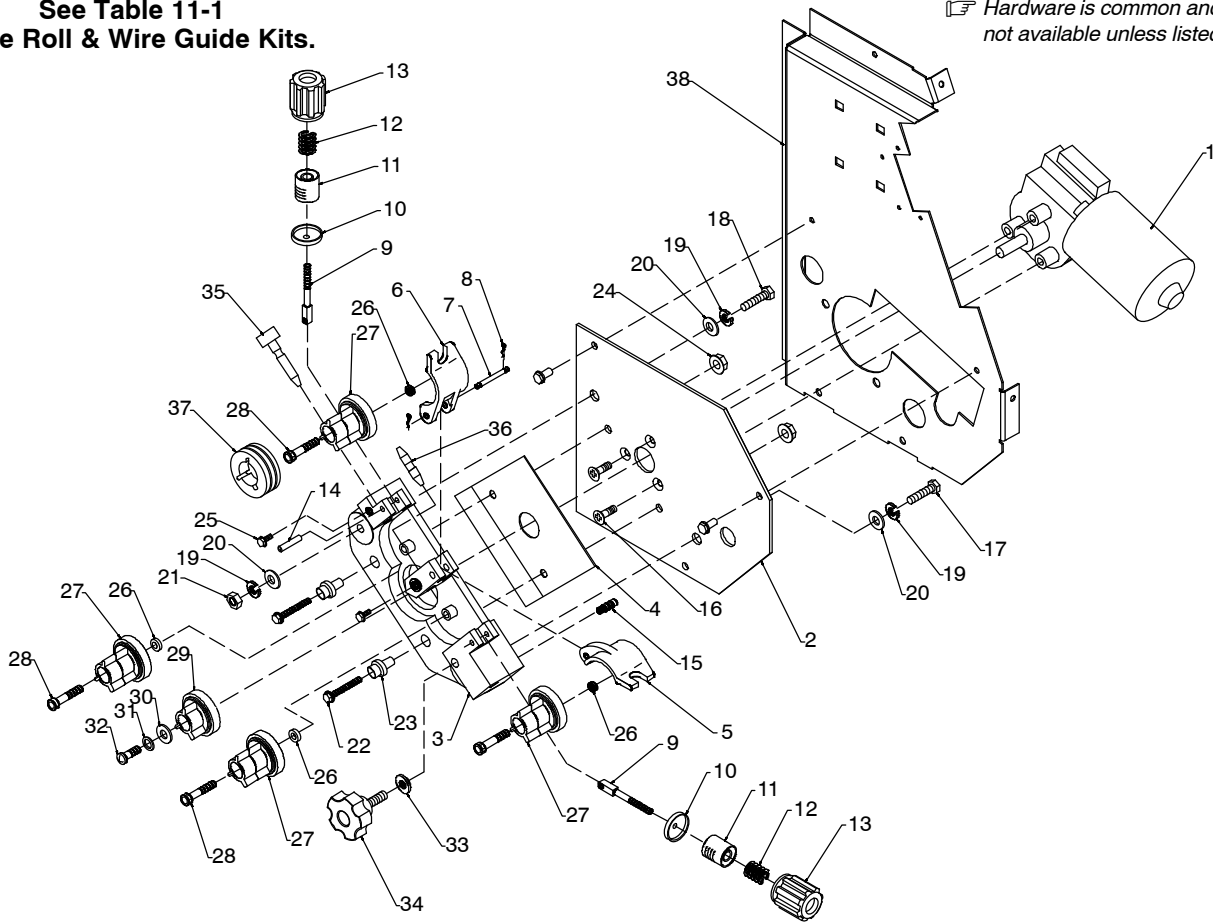


Figure 2-6. Wire Drive Assembly

803 548-C

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
213137 Figure 2-6. Wire Drive Assembly				
...	1	223541	KIT,MM350 DRIVE MOTOR W/ INSTRUCTIONS	1
...	2	212844	INSULATOR,DRIVE HOUSING 4 ROLL	1
...	3	166337	HOUSING,ADAPTER GUN/FEEDER (SALABLE AS 046621)	1
...	4	194521	INSULATOR,DRIVE ASSY (Prior to LJ041430B)	1
...	4	187325	INSULATOR,DRIVE ASSY (Eff w/LJ041430B)	1
...	5	166071	LEVER,MTG PRESSURE GEAR	1
...	6	166338	LEVER,MTG PRESSURE GEAR	1
...	7	079634	PIN,HINGE (Prior to LJ030811B)	1
...	7	234784	PIN,CLEVIS .250 OD X 1.751 LG W/GROOVE (Eff w/LJ030811B)	1
...	8	151828	PIN,COTTER HAIR .042 X .750 (Prior to LJ030811B)	2
...	8	151828	PIN,COTTER HAIR .042 X .750 (Eff w/LJ030811B)	1
...	9	225718	FASTENER,PINNED	2
...	10	085244	WASHER,CUPPED .328IDX .812ODX16GAX.125 LIP	2
...	11	196896	CUP,SPRING	2
...	12	196897	SPRING,CPRSN .695 OD X .095 WIRE X 1.500	2
...	13	196895	KNOB,TENSION	2
...	14	010224	PIN,SPRING CS .187 X 1.000	2
...	15	079633	FTG,HOSE BRS BARBED NIPPLE 3/16 TBG	1
...	16	195640	SCREW,M 6-1.0X 16 FLATHD-PHL STL PLD	3
...	17	079240	SCREW,375-16X1.75 HEX HD-PLN STL PLD FULL THRD	1
...	18	601966	SCREW,375-16X1.25 HEX HD-PLN GR5 PLD	1
...	19	602213	WASHER,LOCK .380IDX0.691ODX.115T STL PLD SPLIT.375	3
...	20	602242	WASHER,FLAT .375IDX0.875ODX.083T STL PLD	1
...	21	601872	NUT, 375-16 .56HEX .34H STL PLD	1
...	22	108943	SCREW,250-20X1.50 HEXWHD.61D GR5 PLD	2
...	23	221 654	WASHER,SHLDR INSULATING	2


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

213137 Figure 2-6. Wire Drive Assembly (Continued)

... 24	089800	NUT, 250-20 .44HEX .22H STL PLD .58D FLANGE DEFOR	2
... 25	602154	SCREW,250-20X .50 HEXWHD.50D STL PLD SLFFMG TAP-RW	2
... 26	166072	SPACER,GEAR	2
... 27	172075	CARRIER,DRIVE ROLL W/COMPONENTS 24 PITCH	4
... 28	602009	SCREW,250-20X1.25 SOC HD-HEX GR8 PLN	4
... 29	173618	CARRIER,DRIVE ROLL 10MM SHAFT	1
... 30	195802	WASHER,FLAT .175IDX0.590ODX.040T STL PLD	1
... 31	602241	WASHER,FLAT .281IDX0.625ODX.065T STL PLD ANSI.250	2
... 32	174609	SCREW,M 4- .7X 12 CHEESE HD BLK DIN 84	1
... 33	604538	WASHER,FLAT .344IDX0.688ODX.065T STL PLD ANSI.312	1
... 34	204585	KNOB,FLUTED 1.75 IN W/ .312-18 STUD 1.00 LG	1
... 35	221912	GUIDE,WIRE INLET NYLON .023 - .052	1
... 36	233843	GUIDE,WIRE INTERMEDIATE	1
... 37	189285	ROLL,DRIVE V GROOVE .035-.045 WIRE	4
... 37	232826	ROLL,DRIVE U GROOVE .035-3/64 WIRE FOR ALUM	4
... 38	212843	HOUSING,ADAPTER DRIVE MOTOR	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.

Table 11-1. Drive Roll And Wire Guide Kits

 Base selection of drive rolls upon the following recommended usages:

- 1 V-Grooved rolls for hard wire.
- 2 U-Grooved rolls for soft and soft shelled cored wires.
- 3 V-Knurled rolls for hard shelled cored wires.
- 4 Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Kit No.	Drive Roll		Wire Guide	
Fraction	Decimal	Metric		Part No.	Type	Inlet	Intermediate
.023/.025 in	.023/.025 in	0.6 mm	087 132	087 130	V-Grooved	056 192	056 206
.030 in	.030 in	0.8 mm	046 780	053 695	V-Grooved	056 192	056 206
.035 in	.035 in	0.9 mm	046 781	053 700	V-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 782	053 697	V-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 783	053 698	V-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 784	053 699	V-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	044 750	072 000	U-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 785	053 701	U-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 786	053 702	U-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 787	053 706	U-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	046 792	132 958	V-Knurled	056 192	056 206
.045 in	.045 in	1.2 mm	046 793	132 957	V-Knurled	056 193	056 207
.052 in	.052 in	1.3 mm	046 794	132 956	V-Knurled	056 193	056 207
1/16 in	.062 in	1.6 mm	046 795	132 955	V-Knurled	056 195	056 209

Ref. S-0025-D



PM-1327B

2021-09

Processes



MIG (GMAW) Welding



Flux Cored (FCAW) Welding

Description



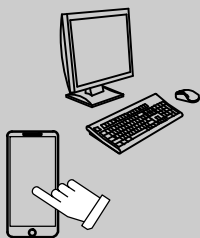
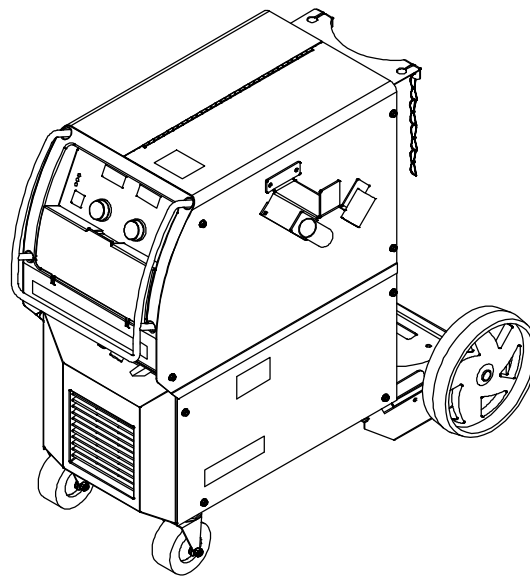
Arc Welding Power Source
and Wire Feeder

Millermatic[®] 350 And Millermatic[®] 350P

PARTS LIST

Eff w/LJ420783B And Following

For OM-1327 (213 814) Revision Z And Following



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

www.MillerWelds.com

File: MIG (GMAW)



SECTION 3 – PARTS LIST (Eff w/LJ420783B And Following)

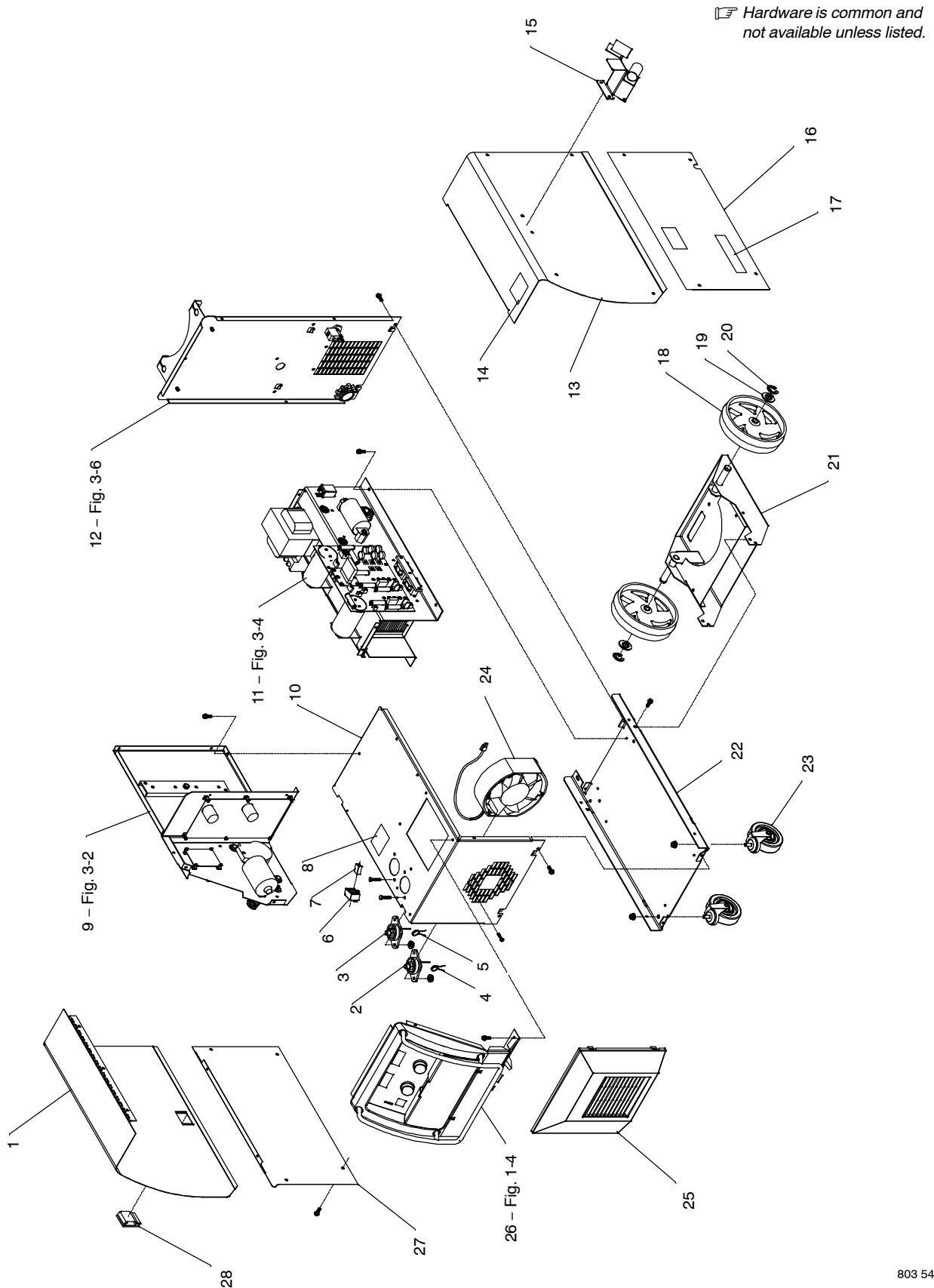


Figure 3-1. Main Assembly

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

Figure 3-1. Main Assembly

...	1	212829	DOOR,ACCESS WIRE COMPARTMENT	1
...	2	NEG 097416	TERMINAL,PWR OUTPUT BLACK	1
...	3	POS 097421	TERMINAL,PWR OUTPUT RED	1
...	4	C6 232049	CAPACITOR	1
...	5	C7 232050	CAPACITOR	1
...	6	HD1 189567	TRANSDUCER,CURRENT 400A MODULE SUPPLY V +/- 15V	1
...		183046	CABLE,LEM	1
...	7	221326	BUS BAR,CURRENT SENSOR	1
...	8	231985	LABEL,WARNING ELECTRIC SHOCK AND PINCH (EN/SP)	1
...	9	Fig 3-2	BAFFLE,CENTER (Prior to Serial No. NB263041N)	1
...	9	Fig 3-3	Baffle,Center (Eff. With Serial No. NB263041N))	1
...	10	212821	PANEL,FRONT LOWER	1
...	11	Fig 3-4	INVERTER ASSY	1
...	12	+Fig 3-6	PANEL,REAR	1
...	13	+238339	WRAPPER	1
...	14	231983	LABEL,WARNING GENERAL PRECAUTIONARY (EN/SP)	1
...	15	238346	GUN/CABLE HOLDER	1
...	16	+238345	PANEL,SIDE RH LOWER W/LINK HOLE (200/230/460V model)	1
...	16	+238367	PANEL,SIDE RH LOWER (460/575V model)	1
...		235242	LABEL,WARNING MATCH INPUT POWER (200/230/460V model) (EN/SP)	1
...		235245	LABEL,WARNING INPUT POWER RELINK (EN/SP) (200/230/460V model)	1
...	17	235244	LABEL,WARNING ELECTRIC SHOCK CAN KILL (EN/SP)	1
...	18	230799	WHEEL,POLYPROPYLENE 10 IN X 2.25 WIDE	2
...	19	602250	WASHER,FLAT .812IDX1.469ODX.134T STL PLD ANSI.750	2
...	20	121614	RING,RTNG EXT .750 SHAFT X .085 THK E STYLE PLD	2
...	21	213903	RACK,CYLINDER SINGLE	1
...	22	212833	BASE,	1
...	23	235875	CASTER,SWVL 4.00 IN POLYOLEFIN X 1.250 IN WIDE	2
...	24	FM 285694	FAN,MUFFIN 24VDC 3000 RPM W/20.500 IN LEADS	1
...	25	212846	BEZEL,LOWER	1
...	26	Fig 1-4	PANEL,FRONT	1
...	27	212822	PANEL,SIDE LH LOWER	1
...	28	230363	LATCH,SLIDE FLUSH MTG HOLE 1.750 WIDEX 1.500 LG	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-1. Main Assembly (Continued)				
.....		234263	.. REGULATOR/FLOWMETER, 0-50 CFH AR/CO2/MIX W/FILTER	1
.....		144108	.. HOSE,GAS 5FT	1
.....		213369	.. CABLE,WORK 10 FT 1/O W/CLAMP & BOOT (INCLUDING)	1
.....		213619 CLAMP,WORK 300 AMP STL CHROME PLD W/COP CONTACTS	1
.....		196318 COVER,CABLE BTRY POST BLK .75 ID	1
.....		†229 560	.. Q300 AMP GUN, 15FT .035 STL W/FLUSH COPPER NOZZLE	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.

☐ Hardware is common and not available unless listed.

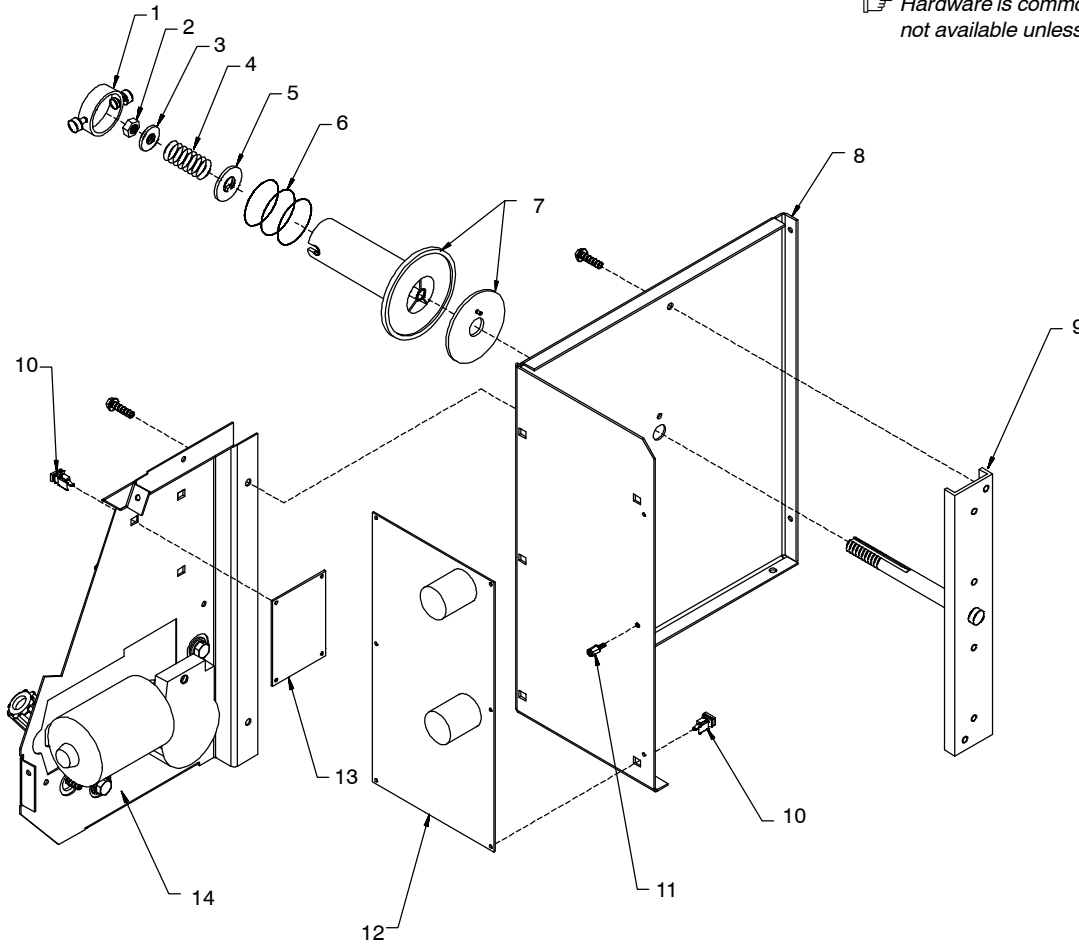


Figure 3-2. Baffle, Center w/Components

803 546-D

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-2. Baffle, Center w/Components (Prior to Serial No. NB263041N) (Fig 3-1 Item 7)				
.. 1		058427	.. RING,RETAINING SPOOL	1
.. 2		085980	.. NUT,STL HEX FULL .625-11	1
.. 3		605941	.. WASHER,FLAT STL .640 ID X 1.000 OD X 14GA THK	1
.. 4		186437	.. SPRING,CPRSN .845 OD X .110 WIRE X 1.500	1
.. 5		057971	.. WASHER,FLAT STL KEYED 1.500DIA X .125THK	1
.. 6		057745	.. SPRING,CPRSN 2.305 OD X .090 WIRE X 2.500 PLD	1
.. 7		238377	.. KIT,SPOOL HUB W/BRAKE WASHER	1
.. 8		223921	.. BAFFLE,CENTER	1
.. 9		235827	.. REEL SUPPORT (Eff w/LH440399B)	1
.. 10		134201	.. STAND-OFF SUPPORT,PC CARD .312/.375W/POST&LOCK .43	9

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
Figure 3-2. Baffle, Center w/Components (Fig 3-1 Item 7) (Continued)				
. 11		204310	.. STAND-OFF,NO 6-32 X .437 LG .250 HEX AL M&F	1
. 12	PC1	233597	.. KIT,MM350 CONTROL BOARD W/ INSTRUCTIONS (200/230/460V model)	1
. 12	PC1	233598	.. KIT,MM350 CONTROL BOARD W/ INSTRUCTIONS (460/575V model)	1
	PLG9	115093	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
	PLG7	115092	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
	PLG8	131056	.. HOUSING RCPT+SKTS,(SERVICE KIT)	1
	PLG10,14	115091	.. HOUSING PLUG+SKTS,(SERVICE KIT)	2
	PLG11,12, 17	131054	.. HOUSING PLUG+SKTS,(SERVICE KIT)	3
	PLG15,16	131204	.. HOUSING PLUG+SKTS,(SERVICE KIT)	2
		213404	.. CABLE,INTERCONNECTING RS 485 INTERFACE TO CONTROL	1
		213405	.. CABLE,INTERCONNECTING RS 485 INTERFACE TO PULSE OP	1
. 13	PC6	216342	.. CIRCUIT CARD ASSY,GMAW PULSE W/PROGRAM (PULSE MODEL ONLY)	1
. 13	PC6	220250	.. CIRCUIT CARD ASSY,TACH W/PROGRAM (NON-PULSE MODEL ONLY)	1
	PLG29	131204	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
	PLG30	115091	.. HOUSING PLUG+SKTS,(SERVICE KIT)	1
. 14		Fig 3-7	.. DRIVE ASSY,WIRE 4 ROLL	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.

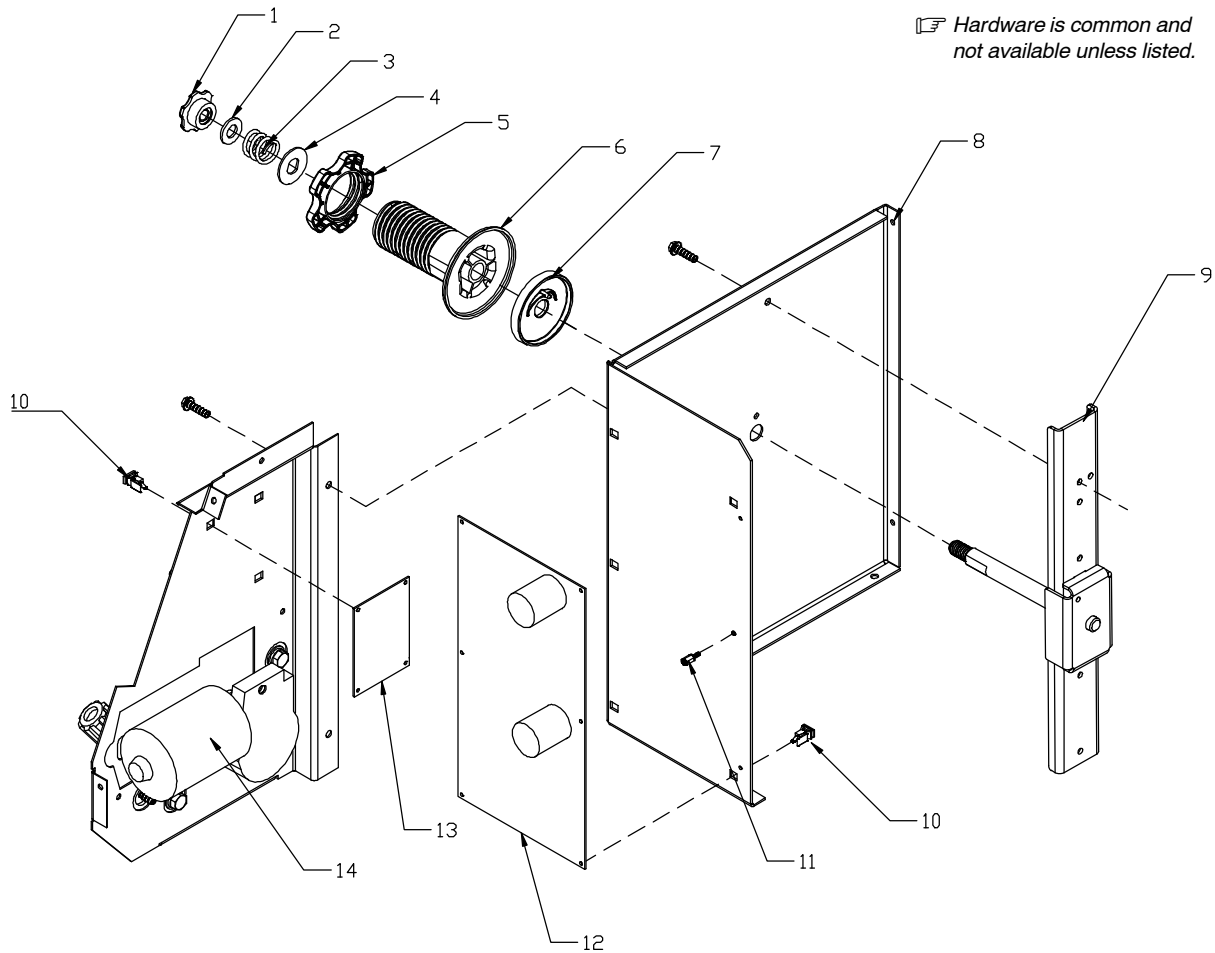


Figure 3-3. Baffle, Center w/Components

803 546-E

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-2. Baffle, Center w/Components (Eff. With Serial No. NB263041N) (Fig 3-1 Item 7)				
1		279504	Knob,Tensioner 1/2-13 Thread	1
2		602247	Washer, Flat .531 ID x 1.062 OD X .95T Stl Pld Ansi .500	1
3		172918	Spring,	1
4		231211	Washer, Anti-Turn	1
5		280091	Nut, Hub	1
6		279587	Hub, Spool 12 Inch	1
7		287119	Washer, Brake Plastic	1
8		223921	Baffle,Center	1
9		283924	Spool Support Assy,	1
10		134201	Stand-Off Support,PC Card .312/.375W/POST&LOCK .43	9
11		204310	Stand-Off,No 6-32 X .437 LG .250 Hex AL M&F	1
12	PC1	233597	Kit,MM350 Control Board W/ Instructions (200/230/460V model)	1
12	PC1	233598	Kit,MM350 Control Board W/ Instructions (460/575V model)	1
	PLG9	115093	Housing Plug+Skts,(Service Kit)	1
	PLG7	115092	Housing Plug+Skts,(Service Kit)	1
	PLG8	131056	Housing Rcpt+Skts,(Service Kit)	1
	PLG10,14	115091	Housing Plug+Skts,(Service Kit)	2
	PLG11,12,17	131054	Housing Plug+Skts, (Service Kit)	3
	PLG15,16	131204	Housing Plug+Skts, (Service Kit)	2
		213404	Cable,Interconnecting RS 485 Interface To Control	1
		213405	Cable,Interconnecting RS 485 Interface To Pulse Op	1
13	PC6	216342	Circuit Card Assy, Gmaw Pulse W/Program (Pulse Model Only)	1
13	PC6	220250	Circuit Card Assy, Tach W/Program (Non-Pulse Model Only)	1
	PLG29	131204	Housing Plug+Skts,(Service Kit)	1
	PLG30	115091	Housing Plug+Skts,(Service Kit)	1
14		Fig 3-7	Drive Assy,Wire 4 Roll	1

☞ Hardware is common and not available unless listed.

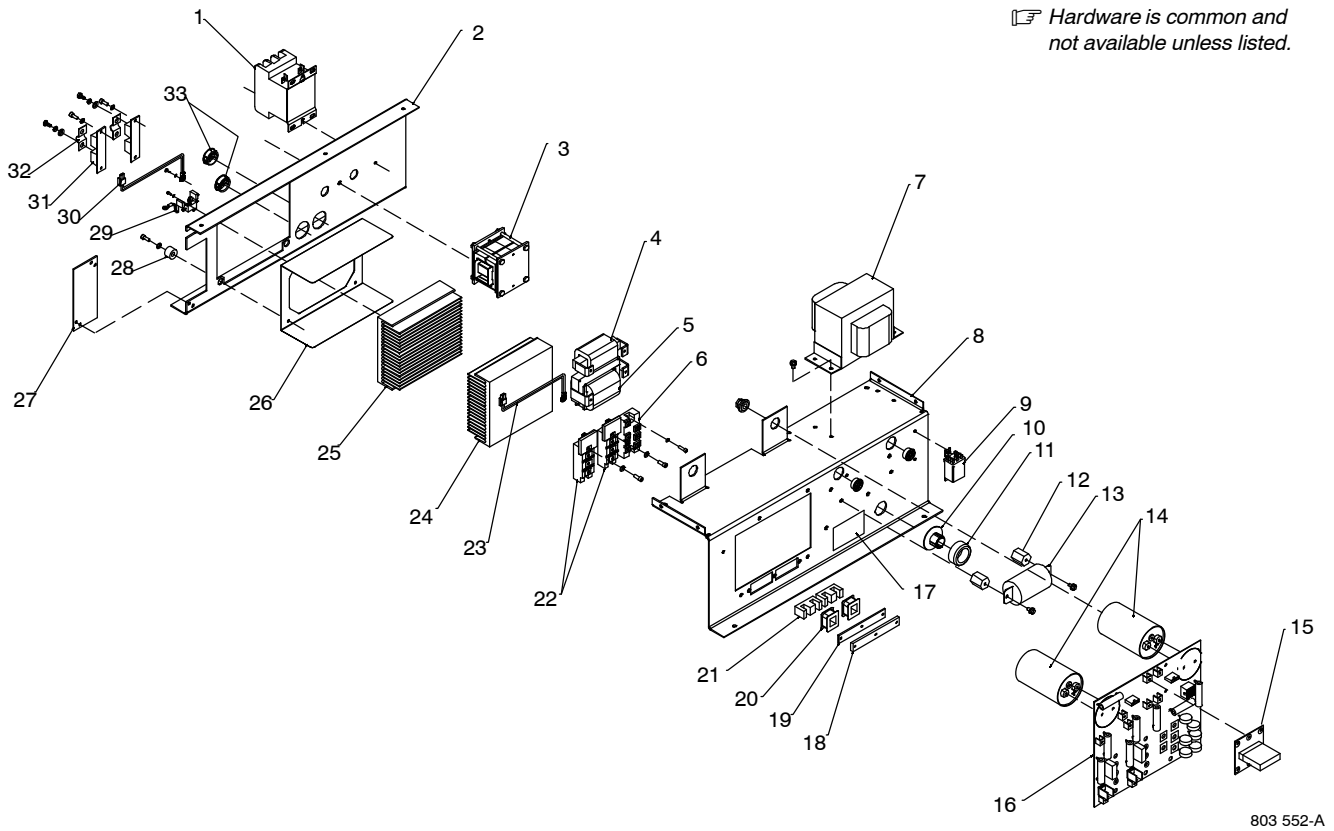


Figure 3-4. Inverter Assy

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

Figure 3-4. Inverter Assy (Fig 3-1 Item 9)

...	1	W	188634	CONTACTOR,DEF PRP 60A 3P 24VAC COIL W/COVER	1
			C11,12,		
			13	CAPACITOR,CER DISC .003 UF 2000 VAC W/TERMS	3
...	2		+212750	WINDTUNNEL,LH	1
			235243	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (EN/SP) (Eff w/LH410225B)	1
...	3	T1	180952	XFMR,HF	1
...	4	L1	222392	INDUCTOR,INPUT (200/230/460V model)	1
...	4	L1	216006	INDUCTOR,INPUT (460/575V model)	1
...	5	Z1	212756	STABILIZER,OUTPUT	1
...	6	SR1	212937	KIT,DIODE POWER MODULE	1
...	7	T2	224238	XFMR,CONTROL 200/230/460 PRI	1
...	7	T2	223922	XFMR,CONTROL 460/575 PRI	1
		PLG26	168071	HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
...	8		+212752	WINDTUNNEL,RH	1
...	9	CR1	106462	RELAY,ENCL 24VDC DPDT 20A/120VAC 8PIN FLANGE MTG	1
...	10		177547	BUSHING,SNAP-IN NYL CT-MOUNT 1.125 MTG HOLE	1
...	11	CT1	237942	XFMR,CURRENT W/INTERLOCK	1
...	12		025248	STAND-OFF,INSUL .250-20 X 1.250 LG X .437 THD	2
...	13	C1	280914	CAPACITOR,POLYP FILM .34 UF 1000 VAC +8% -0% (200/230/460V model)	1
...	13	C1	193858	CAPACITOR,POLYP FILM .27 UF 1000 VAC +8% -0% (460/575V model)	1

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

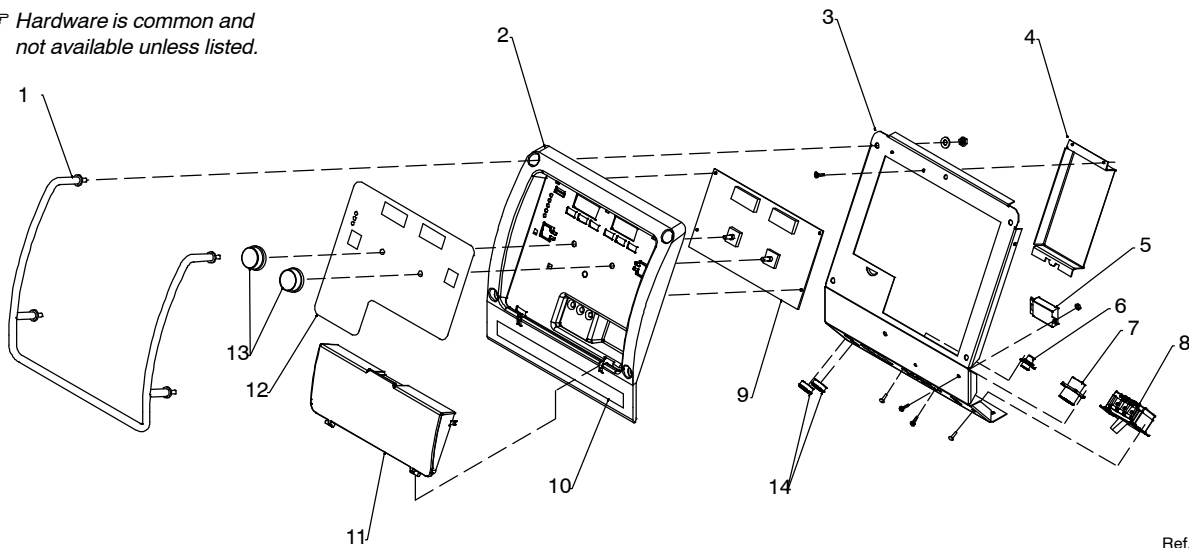
To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-4. Inverter Assy (Fig 3-1 Item 9) (Continued)				
... 14 ...	C3,4	192935	CAPACITOR,ELCTLT 2700 UF 450 VDC CAN 2.52 DIA (200/230/460 MODELS)	2
... 14 ...	C3,4	217941	CAPACITOR,ELCTLT 1800 UF 500 VDC CAN 2.52 DIA (460/575 MODELS)	2
		217942	SPACER,NYLON CAPACITOR	1
		217040	NUT,NYLON M12 THREAD CAPACITOR MOUNTING	1
... 15 ...	PC7	221047	CIRCUIT CARD ASSY,RELINK (200/230/460V model)	1
... 16 ...	PC2	221043	CIRCUIT CARD ASSY,INTERCONNECT (200/230/460V model)	1
... 16 ...	PC2	219900	CIRCUIT CARD ASSY,INTERCONNECT (460/575V model)	1
	PLG2	168071	HOUSING PLUG PINS+SKTS,(SERVICE KIT)	1
... 17		235243	LABEL,WARNING ELECTRIC SHOCK/EXPLODING PARTS (EN/SP) (Eff w/LH410225B)	1
... 18		175140	BRACKET,DI-DT	1
		178591	LABEL,CONNECTION DI/DT	1
... 19		181197	GASKET,DI-DT RUBBER	1
... 20 ...	L3,4	175482	COIL,DI/DT	2
... 21		109056	CORE,FERRITE E 2.164 LG X 1.094 HIGH X .826 WIDE	2
... 22 ...	PM1,2	212936	KIT,TRANSISTOR IGBT MODULE (KIT INCLUDES 2 IGBTs)	1
... 23 ...	RT2	213029	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 3P	1
... 24		212776	HEAT SINK,POWER MODULE	1
... 25		212753	HEAT SINK,RECT	1
... 26		175255	INSULATOR,RECTIFIER	1
... 27		214537	COVER,ACCESS FAN MOTOR	1
... 28		181853	INSULATOR,SCREW	4
... 29	C2,R1,C5	232296	RESISTOR/CAPACITOR,	1
... 30 ...	RT1	213028	THERMISTOR,NTC 30K OHM @ 25 DEG C 26IN LEAD 2P	1
... 31 ...	D1,2	201531	KIT,DIODE POWER MODULE	2
... 32		199840	BUS BAR,DIODE	2
... 33		179276	BUSHING,SNAP-IN NYL 1.000 ID X 1.375 MTG HOLE CENT	2

+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.

☞ Hardware is common and not available unless listed.



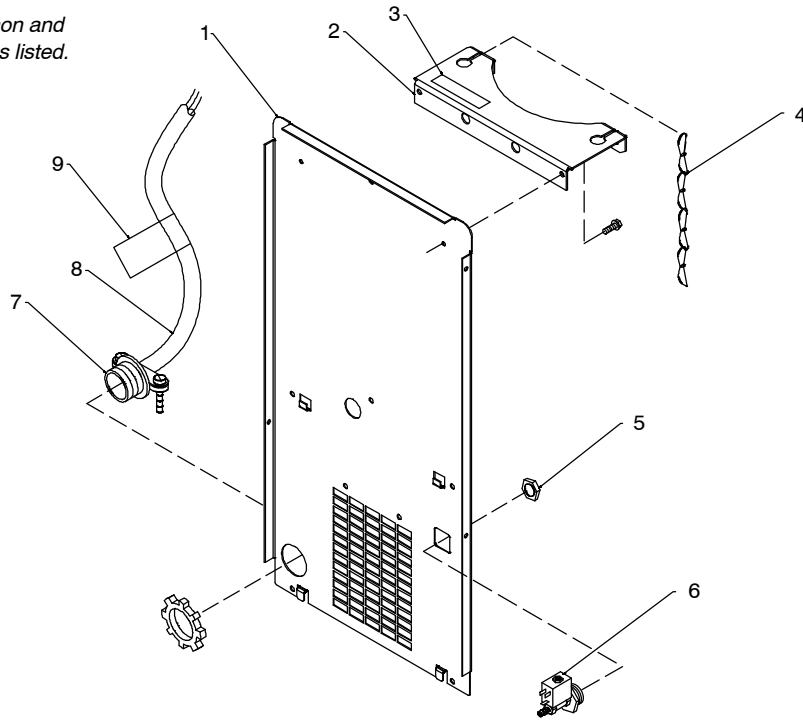
Ref. 803 547-C

Figure 3-5. Panel, Front w/Components

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-5. Panel, Front w/Components (Fig 3-1 Item 23)				
1		212837	HANDLE,	1
2		212845	BEZEL,UPPER	1
3		212819	PANEL,FRONT	1
4		212825	ENCLOSURE,CIRCUIT CARD ASSY	1
5	PC9	242590	CIRCUIT CARD ASSY,FILTER (Eff w/MA170021B thru MC061225N)	1
5	PC9	255459	CIRCUIT CARD ASSY,FILTER (Eff w/MC061226N)	1
6		048282	RCPT W/SKTS,(SERVICE KIT)	1
	C9,10	080894	CAPACITOR,CER DISC .01 UF 1000 VDC 20% NYLEZ	2
7		190363	RCPT W/SKTS,(SERVICE KIT)	1
8	S1	231191	SWITCH,TGL 3PST 50A 600VAC SCR TERM WIDE TGL	1
9	PC3	233599	KIT,MM350 INTERFACE BD W/INSTRUCTIONS	1
	PLG18	115094	HOUSING PLUG+SKTS,(SERVICE KIT)	1
	PLG19	135560	HOUSING RCPT+SKTS,(SERVICE KIT)	1
	PLG28	131055	HOUSING PLUG+SKTS,(SERVICE KIT)	1
10		213936	LABEL,POWER/MIG GUN/SPOOLGUN	1
11		212847	BEZEL,DOOR	1
		218551	INSTRUCTION,FLIPCHART	1
		237052	CLIP,COMPONENT .500 X 1.000 MTG X .052 DIA ADH BK	2
		213934	LABEL,NAMEPLATE MM350	1
		213935	LABEL,NAMEPLATE MM350P	1
12		212955	LABEL,CONTROLS USER INTERFACE	1
13		213134	KNOB,ENCODER 1.670 DIA X .250 ID PUSH ON W/SPRING	2
14		210398	BUSHING,SNAP-IN	2

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.

☞ Hardware is common and not available unless listed.



803 549-B


Figure 3-6. Panel, Rear w/Components

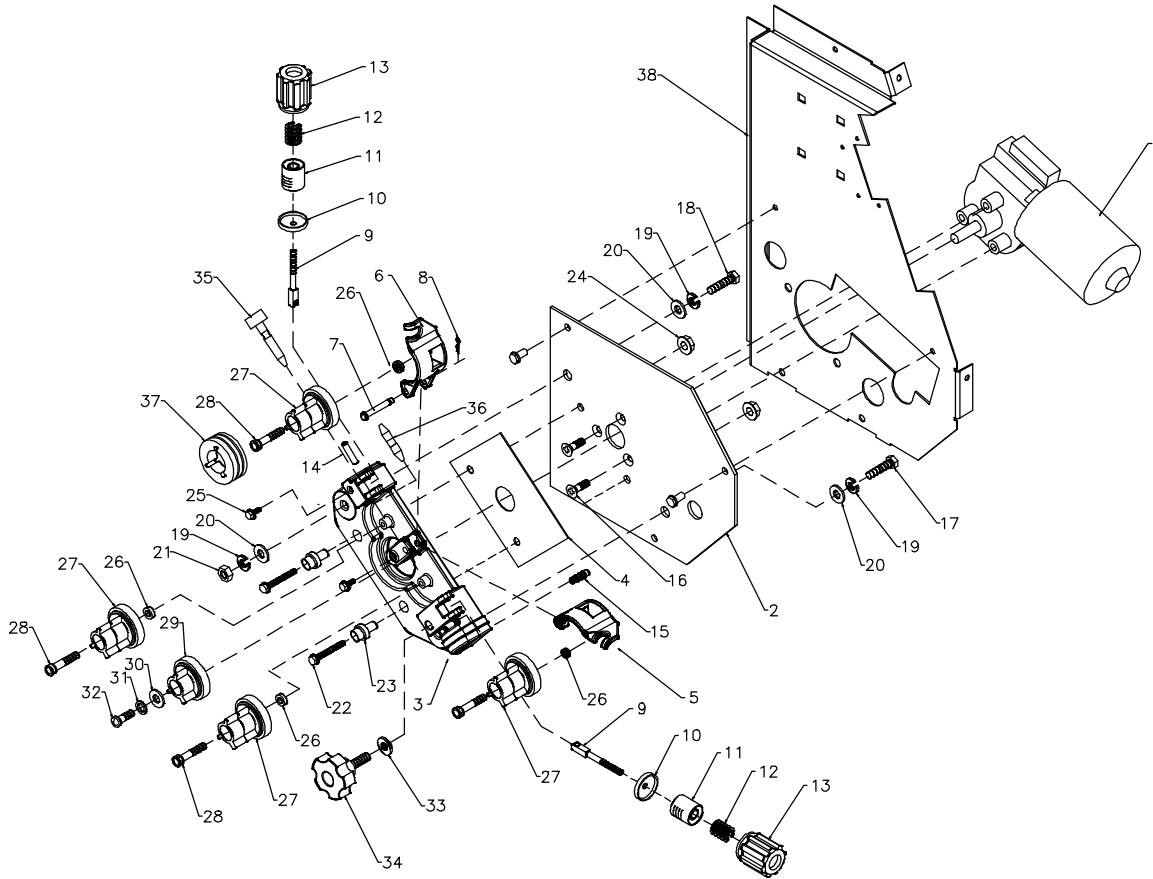
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 3-6. Panel, Rear w/Components (Fig 3-1 Item 10)				
...	1	212820	.. PANEL,REAR	1
...	2	169654	.. BRACKET,SUPPORT TANK	1
...	3	231986	.. LABEL,WARNING CYL MAY EXPLODE IF DAMAGED (EN/SP) (Eff w/LH410225B)	1
...	4	188441	.. CHAIN,WELDLESS 2/0 X 31. BRIGHT ZINC PLD	1
...	5	220805	.. NUT, 750-14 NPS 1.48HEX .41H NYL	1
...	6	GS1 219062	.. VALVE, 34VDC 1WAY .750-14 THD 1/8 ORF 100PSI	1
...	7	010467	.. CONN,CLAMP CABLE 1.250 (Prior to MA120032B)	1
...	7	247765	.. CONN,CLAMP CABLE 1.250 (Eff w/MA120032B)	1
...	8	212772	.. CABLE,POWER 10 FT 6IN 6GA 4C (200/230/460V)	1
...		◆213 380	.. PLUG,STR GRD 2P3W 50A 250VAC *6-50P	1
...	8	213018	.. CABLE,POWER 10 FT 6 IN 10GA 4C (460/575V)	1
...		213908	.. PLATE,ADAPTER POWER CORD (575 MODEL ONLY)	1
...	9	235246	.. LABEL,WARNING ELECTRIC SHOCK/INPUT POWER (EN/SP) (Eff w/LH410225B)	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.

**See Table 12-1
Drive Roll & Wire Guide Kits.**

 Hardware is common and not available unless listed.



803 548-G

Figure 3-7. Wire Drive Assembly

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

Figure 3-7. Wire Drive Assembly

...	1	223541	... KIT,MM350 DRIVE MOTOR W/ INSTRUCTIONS	1
...	2	212844	... INSULATOR,DRIVE HOUSING 4 ROLL	1
...	3	166337	... HOUSING,ADAPTER GUN/FEEDER (SALABLE AS 046621) (Prior to MA290020B)	1
...	3	238726	... HOUSING,ADAPTER GUN/FEEDER (Eff w/MA290020B)	1
...	4	187325	... INSULATOR,DRIVE ASSY	1
...	5	166071	... LEVER,MTG PRESSURE GEAR (Prior to MA290020B)	1
...	5	230691	... LEVER,MTG PRESSURE GEAR (Eff w/MA290020B)	1
...	6	166338	... LEVER,MTG PRESSURE GEAR (Prior to MA290020B)	1
...	6	238728	... LEVER,MTG PRESSURE GEAR (Eff w/MA290020B)	1
...	7	234784	... PIN,CLEVIS .250 OD X 1.751 LG W/GROOVE	1
...	8	151828	... PIN,COTTER HAIR .042 X .750	1
...	9	225718	... FASTENER,PINNED	2
...	10	085244	... WASHER,CUPPED .328IDX .812ODX16GAX.125 LIP	2
...	11	198080	... CUP,SPRING	2
...	12	196897	... SPRING,CPRSN .695 OD X .095 WIRE X 1.500	2
...	13	196895	... KNOB,TENSION	2
...	14	010224	... PIN,SPRING CS .187 X 1.000	2
...	15	079633	... FTG,HOSE BRS BARBED NIPPLE 3/16 TBG	1
...	16	195640	... SCREW,M 6-1.0X 16 FLATHD-PHL STL PLD	3
...	17	079240	... SCREW,375-16X1.75 HEX HD-PLN STL PLD FULL THRD	1
...	18	601966	... SCREW,375-16X1.25 HEX HD-PLN GR5 PLD	1
...	19	602213	... WASHER,LOCK .380IDX0.691ODX.115T STL PLD SPLIT.375	3
...	20	602242	... WASHER,FLAT .375IDX0.875ODX.083T STL PLD	1
...	21	601872	... NUT, 375-16 .56HEX .34H STL PLD	1


22	108943	SCREW,250-20X1.50 HEXWHD.61D GR5 PLD	2	
23	221 654	WASHER,SHLDR INSULATING	2	
Item No.	Dia. Mkgs.	Part No.	Description	Quantity

213137 Figure 3-7. Wire Drive Assembly (Continued)

24	089800	NUT, 250-20 .44HEX .22H STL PLD .58D FLANGE DEFOR	2
25	602154	SCREW,250-20X .50 HEXWHD.50D STL PLD SLFFMG TAP-RW	2
26	166072	SPACER,GEAR	2
27	172075	CARRIER,DRIVE ROLL W/COMPONENTS 24 PITCH	4
28	602009	SCREW,250-20X1.25 SOC HD-HEX GR8 PLN	4
29	173618	CARRIER,DRIVE ROLL 10MM SHAFT	1
30	195802	WASHER,FLAT .175IDX0.590ODX.040T STL PLD	1
31	602241	WASHER,FLAT .281IDX0.625ODX.065T STL PLD ANSI.250	2
32	174609	SCREW,M 4- .7X 12 CHEESE HD BLK DIN 84	1
33	604538	WASHER,FLAT .344IDX0.688ODX.065T STL PLD ANSI.312	1
34	204585	KNOB,FLUTED 1.75 IN W/ .312-18 STUD 1.00 LG	1
35	221912	GUIDE,WIRE INLET NYLON .023 - .052	1
36	233843	GUIDE,WIRE INTERMEDIATE	1
37	189285	ROLL,DRIVE V GROOVE .035-.045 WIRE	4
37	232826	ROLL,DRIVE U GROOVE .035-3/64 WIRE FOR ALUM	4
38	212843	HOUSING,ADAPTER DRIVE MOTOR	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.

Table 12-1. Drive Roll And Wire Guide Kits

 Base selection of drive rolls upon the following recommended usages:

- 1 V-Grooved rolls for hard wire.
- 2 U-Grooved rolls for soft and soft shelled cored wires.
- 3 V-Knurled rolls for hard shelled cored wires.
- 4 Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter			Kit No.	Drive Roll		Wire Guide	
Fraction	Decimal	Metric		Part No.	Type	Inlet	Intermediate
.023/.025 in	.023/.025 in	0.6 mm	087 132	087 130	V-Grooved	056 192	056 206
.030 in	.030 in	0.8 mm	046 780	053 695	V-Grooved	056 192	056 206
.035 in	.035 in	0.9 mm	046 781	053 700	V-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 782	053 697	V-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 783	053 698	V-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 784	053 699	V-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	044 750	072 000	U-Grooved	056 192	056 206
.045 in	.045 in	1.2 mm	046 785	053 701	U-Grooved	056 193	056 207
.052 in	.052 in	1.3 mm	046 786	053 702	U-Grooved	056 193	056 207
1/16 in	.062 in	1.6 mm	046 787	053 706	U-Grooved	056 195	056 209
.035 in	.035 in	0.9 mm	046 792	132 958	V-Knurled	056 192	056 206
.045 in	.045 in	1.2 mm	046 793	132 957	V-Knurled	056 193	056 207
.052 in	.052 in	1.3 mm	046 794	132 956	V-Knurled	056 193	056 207
1/16 in	.062 in	1.6 mm	046 795	132 955	V-Knurled	056 195	056 209

Ref. S-0025-D

Miller Electric Mfg. LLC

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

International Headquarters—USA

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

For International Locations Visit

www.MillerWelds.com

