Coolmate™ 4
CE And Non-CE

OWNER’S MANUAL

Visit our website at www.MillerWelds.com
From Miller to You

Thank you and congratulations on choosing Miller. Now you can get the job done and get it done right. We know you don’t have time to do it any other way.

That’s why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn’t afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They’re just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner’s Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

We’ve made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there’s a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at www.MillerWelds.com on the web.
<table>
<thead>
<tr>
<th>SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING</th>
<th>1</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-1. Symbol Usage</td>
<td>1</td>
</tr>
<tr>
<td>1-2. Cooling Equipment Hazards</td>
<td>1</td>
</tr>
<tr>
<td>1-3. Additional Symbols For Installation, Operation, And Maintenance</td>
<td>1</td>
</tr>
<tr>
<td>1-4. California Proposition 65 Warnings</td>
<td>2</td>
</tr>
<tr>
<td>1-5. Principal Safety Standards</td>
<td>2</td>
</tr>
<tr>
<td>1-6. EMF Information</td>
<td>2</td>
</tr>
<tr>
<td>SECTION 2 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION</td>
<td>3</td>
</tr>
<tr>
<td>2-1. Symboles utilisés</td>
<td>3</td>
</tr>
<tr>
<td>2-2. Dangers liés aux équipements de refroidissement</td>
<td>3</td>
</tr>
<tr>
<td>2-3. Dangers supplémentaires en relation avec l’installation, le fonctionnement et la maintenance</td>
<td>3</td>
</tr>
<tr>
<td>2-4. Proposition californienne 65 Avertissements</td>
<td>4</td>
</tr>
<tr>
<td>2-5. Principales normes de sécurité</td>
<td>4</td>
</tr>
<tr>
<td>2-6. Informations relatives aux CEM</td>
<td>4</td>
</tr>
<tr>
<td>SECTION 3 – DEFINITIONS</td>
<td>5</td>
</tr>
<tr>
<td>3-1. Additional Safety Symbols And Definitions</td>
<td>5</td>
</tr>
<tr>
<td>3-2. Miscellaneous Symbols And Definitions</td>
<td>6</td>
</tr>
<tr>
<td>SECTION 4 – SPECIFICATIONS</td>
<td>7</td>
</tr>
<tr>
<td>4-1. Important Information Regarding CE Products (Sold Within The EU)</td>
<td>7</td>
</tr>
<tr>
<td>4-2. Serial Number And Rating Label Location</td>
<td>7</td>
</tr>
<tr>
<td>4-3. Specifications</td>
<td>7</td>
</tr>
<tr>
<td>4-4. Coolant Chart</td>
<td>7</td>
</tr>
<tr>
<td>SECTION 5 – INSTALLATION</td>
<td>8</td>
</tr>
<tr>
<td>5-1. Connections</td>
<td>8</td>
</tr>
<tr>
<td>SECTION 6 – MAINTENANCE &amp; TROUBLESHOOTING</td>
<td>9</td>
</tr>
<tr>
<td>6-1. Routine Maintenance</td>
<td>9</td>
</tr>
<tr>
<td>6-2. Coolant Maintenance</td>
<td>9</td>
</tr>
<tr>
<td>6-3. Adjusting Relief Valve</td>
<td>10</td>
</tr>
<tr>
<td>6-4. Troubleshooting</td>
<td>10</td>
</tr>
<tr>
<td>SECTION 7 – ELECTRICAL DIAGRAM</td>
<td>11</td>
</tr>
<tr>
<td>SECTION 8 – PARTS LIST</td>
<td>11</td>
</tr>
<tr>
<td>8-1. Recommended Spare Parts</td>
<td>11</td>
</tr>
<tr>
<td>WARRANTY</td>
<td></td>
</tr>
</tbody>
</table>
DECLARATION OF CONFORMITY

for European Community (CE marked) products.

MILLER Electric Mfg. Co., 1635 Spencer Street, Appleton, WI 54914 U.S.A. declares that the product(s) identified in this declaration conform to the essential requirements and provisions of the stated Council Directive(s) and Standard(s).

Product/Apparatus Identification:

<table>
<thead>
<tr>
<th>Product</th>
<th>Stock Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coolmate 4 115 VAC W/CE Compliance</td>
<td>042288015</td>
</tr>
</tbody>
</table>

Council Directives:

- 2006/95/EC Low Voltage
- 2004/108/EC Electromagnetic Compatibility
- 2011/65/EU Restriction of the use of certain hazardous substances in electrical and electronic equipment

Standards:

- IEC 60974-1:2005 Arc welding equipment – Part 1: Welding power sources
- IEC 60974-10:2007 Arc Welding Equipment – Part 10: Electromagnetic compatibility (EMC) requirements
- EN 50445:2008 Product family standard to demonstrate compliance of equipment for resistance welding, arc welding and allied processes with the basic restrictions related to human exposure to electromagnetic fields (0 Hz – 300Hz)

Signatory:

David A. Werba
MANAGER, PRODUCT DESIGN COMPLIANCE

November 5, 2012
SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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

1-1. Symbol Usage

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.

1-2. Cooling Equipment 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. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.

Only qualified persons should install, operate, maintain, and repair this unit.

During operation, keep everybody, especially children, away.

ELECTRIC SHOCK can kill.

- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Keep all panels and covers securely in place.

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.

FLYING METAL or DIRT can injure eyes.

- Wear approved safety glasses with side shields even under your welding helmet.

1-3. Additional Symbols For Installation, Operation, And Maintenance

FALLING EQUIPMENT can injure.

- Use equipment of adequate capacity to lift and support unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- 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 all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.

OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Do not block or filter airflow to unit.

READ INSTRUCTIONS.

- Read and follow all labels and the Owner’s Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform maintenance and service according to the Owner’s Manuals, industry standards, and national, state, and local codes.
1-4. 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 or produces a chemical known to the state of California to cause cancer or birth defects (or other reproductive harm). (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.

1-5. Principal Safety Standards


1-6. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). Welding current creates an EMF field around the welding circuit and welding equipment. EMF fields may 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 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION

Pour écarté les risques de blessure pour vous–même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

2-1. Symboles utilisés

DANGER! – Indique une situation dangereuse qui si on l’évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

Indique une situation dangereuse qui si on l’évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

NOTE – Indique des déclarations pas en relation avec des blessures personnelles.

2-2. Dangers liés aux équipements de refroidissement

Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l’attention et identifier les dangers possibles. En présence de l’un de ces symboles, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les instructions en matière de sécurité indiquées ci-dessous ne constituent qu’un sommaire des instructions de sécurité plus complètes fournies dans les normes de sécurité énumérées dans la Section 2-5. Lire et observer toutes les normes de sécurité.

Seul un personnel qualifié est autorisé à installer, faire fonctionner, entretenir et réparer cet appareil.

Pendant le fonctionnement, maintenir à distance toutes les personnes, notamment les enfants de l’appareil.

UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort. Le contact d’organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit d’alimentation et les circuits internes de la machine sont également sous tension lorsque l’alimentation est sur Marche. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

- Ne pas toucher aux pièces électriques sous tension.
- Installez, mettez à la terre et utilisez correctement cet équipement conformément à son Manuel d’Utilisation et aux réglementations nationales, gouvernementales et locales.
- Toujours vérifier la terre du cordon d’alimentation. Vérifier et s’assurer que le fil de terre du cordon d’alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- Les câbles doivent être exempts d’humidité, d’huile et de graisse; protégez–les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d’alimentation afin de s’assurer qu’il n’est pas altéré ou à nu, le remplacer immédiatement s’il l’est. Un fil à nu peut entraîner la mort.
- L’équipement doit être hors tension lorsqu’il n’est pas utilisé.
- N’utiliser qu’un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l’appareil conformément à ce manuel.
- S’assurer que tous les panneaux et couvercles sont correctement en place.

LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher aux pièces chaudes.
- Prévoir une période de refroidissement avant de travailler à l’équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.

DES PIECES DE METAL ou DES SALETES peuvent provoquer des blessures dans les yeux.

- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.

2-3. Dangers supplémentaires en relation avec l’installation, le fonctionnement et la maintenance

LA CHUTE DE L’ÉQUIPEMENT peut provoquer des blessures.

- Utiliser un équipement de levage de capacité suffisante pour lever l’appareil.
- En utilisant des fourches de levage pour déplacer l’unité, s’assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l’appareil.
- Tenir l’équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.
- Suivre les consignes du Manuel des applications pour l’équation de levage NIOSH révisée (Publication N°94–110) lors du levage manuelle de pièces ou équipements lourds.
Les PIÈCES MOBILES peuvent causer des blessures.
- S’abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d’entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l’entretien est terminé et avant de rebrancher l’alimentation électrique.

2-4. Proposition californienne 65 Avertissements

⚠️ Les équipements de soudage et de coupage produisent des fumées et des gaz qui contiennent des produits chimiques dont l’État de Californie reconnaît qu’ils provoquent des malformations congénitales et, dans certains cas, des cancers. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)

⚠️ Ce produit contient ou forme un produit chimique reconnu par l’état de Californie de provoquer le cancer ou malformations de naissance (ou autres problèmes reproductifs. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)

⚠️ Ce produit contient des produits chimiques, notamment du plomb, dont l’État de Californie reconnaît qu’ils provoquent des cancers, des malformations congénitales ou d’autres problèmes de procréation. Se laver les mains après utilisation.

2-5. Principales normes de sécurité


2-6. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant de soudage créé un CEM autour du circuit et du matériel de soudage. Les CEM peuvent créer des interférences avec certains implants médicaux comme des stimulateurs cardiaques. Des mesures de protection pour les porteurs d’implants médicaux doivent être prises: Limiter par exemple tout accès aux passants ou procéder à une évaluation des risques individuels pour les soudeurs. Tous les soudeurs doivent appliquer les procédures suivantes pour minimiser l’exposition aux CEM provenant du circuit de soudage:
1. Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.
2. Ne pas se tenir au milieu des câbles de soudage. Disposer les câbles d’un côté et à distance de l’opérateur.
3. Ne pas courber et ne pas entourer les câbles autour de votre corps.
4. Maintenir la tête et le torse aussi loin que possible du matériel du circuit de soudage.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.
6. Ne pas travailler à proximité d’une source de soudage, ni s’asseoir ou se pencher dessus.
7. Ne pas souder tout en portant la source de soudage ou le dévidoir.

En ce qui concerne les implants médicaux :
Les porteurs d’implants doivent d’abord consulter leur médecin avant de s’approcher des opérations de soudage à l’arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.
### SECTION 3 – DEFINITIONS

#### 3-1. Additional Safety Symbols And Definitions

Some symbols are found only on CE products.

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>!</td>
<td>Warning! Watch Out! There are possible hazards as shown by the symbols.</td>
</tr>
<tr>
<td></td>
<td>Disconnect input plug or power before working on machine.</td>
</tr>
<tr>
<td></td>
<td>Do not discard product (where applicable) with general waste. Reuse or recycle Waste Electrical and Electronic Equipment (WEEE) by disposing at a designated collection facility. Contact your local recycling office or your local distributor for further information.</td>
</tr>
<tr>
<td></td>
<td>Read the Owner’s Manual before working on this machine.</td>
</tr>
<tr>
<td></td>
<td>Read the labels on the welding power source, wire feeder, or other major equipment for welding safety information.</td>
</tr>
<tr>
<td></td>
<td>Do not remove or paint over (cover) the label.</td>
</tr>
<tr>
<td></td>
<td>Plugged filter or hoses can cause overheating to the power source and torch.</td>
</tr>
<tr>
<td></td>
<td>Use coolant suggested by the manufacturer.</td>
</tr>
<tr>
<td></td>
<td>Every 100 hours, check and clean filter and check condition of hoses.</td>
</tr>
<tr>
<td></td>
<td>Recycle.</td>
</tr>
</tbody>
</table>
### 3-2. Miscellaneous Symbols and Definitions

Some symbols are found only on CE products.

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Description</th>
<th>Note</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>Amperes</td>
<td>Alternating Current</td>
</tr>
<tr>
<td>V</td>
<td>Volts</td>
<td>Water (Coolant) Input</td>
</tr>
<tr>
<td>Hz</td>
<td>Hertz</td>
<td>Degree Of Protection</td>
</tr>
<tr>
<td>U₁</td>
<td>Primary Voltage</td>
<td>Primary Current</td>
</tr>
<tr>
<td>1½</td>
<td>Single Phase</td>
<td>Line Connection</td>
</tr>
</tbody>
</table>

**Notes**

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SECTION 4 – SPECIFICATIONS

4-1. Important Information Regarding CE Products (Sold Within The EU)

⚠️ This equipment shall not be used by the general public as the EMF limits for the general public might be exceeded during welding.

This equipment is built in accordance with EN 60974–1 and is intended to be used only in an occupational environment (where the general public access is prohibited or regulated in such a way as to be similar to occupational use) by an expert or an instructed person.

Wire feeders and ancillary equipment (such as torches, liquid cooling systems and arc striking and stabilizing devices) as part of the welding circuit may not be a major contributor to the EMF. See the Owner’s Manuals for all components of the welding circuit for additional EMF exposure information.

- The EMF assessment on this equipment was conducted at 0.5 meter.
- At a distance of 1 meter the EMF exposure values were less than 20% of the permissible values.

4-2. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the lower right side. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on cover of this manual.

4-3. Specifications

<table>
<thead>
<tr>
<th>Recirculating Coolant System For Water-Cooled GTAW Torches And GMAW Guns</th>
</tr>
</thead>
<tbody>
<tr>
<td>Use With Guns/Torches Rated Up To 600 Amperes</td>
</tr>
<tr>
<td>IP Rating: 23 – Not Intended For Use In Heavy Rain, Or Near Splashing Water</td>
</tr>
<tr>
<td>4 gal (15 L) Coolant Tank Capacity;</td>
</tr>
<tr>
<td>Maximum Cooling Capacity: 5,500 W (18,000 BTU/hr) @ 5.9 qt/min (5.6 L/min)</td>
</tr>
<tr>
<td>IEC Cooling Capacity: 1,780 W (6,070 BTU/hr) @ 1.1 qt/min (1 L/min)</td>
</tr>
<tr>
<td>IEC Cooling Capacity States That The Water Inlet Temperature Can Not Exceed 40° C Above Ambient Temperature At A 1L/ Min Flow Rate. Ratings Developed At An Ambient Temperature Of 68° F to 77° F (20° C To 25° C). Operating Temperature Is 14° F To 104° F (−10° C To 40° C)</td>
</tr>
<tr>
<td>Dimensions: 18-3/4 in. (476 mm) Long, 15-1/4 in. (387 mm) Wide, 16-1/4 in. (413 mm) High</td>
</tr>
<tr>
<td>Weight: 44 lb (20 kg)</td>
</tr>
<tr>
<td>115 Volt, 5.9 Amperes 60 Hertz, 4.7 Amperes 50 Hertz, Single–Phase Input Power</td>
</tr>
</tbody>
</table>

4-4. Coolant Chart

<table>
<thead>
<tr>
<th>Application</th>
<th>GTAW Or Where HF* Is Used</th>
<th>GMAW Or Where HF* Is Not Used</th>
<th>Where Coolant Contacts Aluminum Parts</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coolant</td>
<td>Low Conductivity Coolant</td>
<td>Low Conductivity Coolant</td>
<td></td>
</tr>
<tr>
<td></td>
<td>No. 043 810**; Distilled</td>
<td>No. 043 810**; Or Aluminum Protecting Coolant</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Or Deionized Water</td>
<td>Distilled Or Deionized Water</td>
<td></td>
</tr>
<tr>
<td></td>
<td>OK Above 32° F (0° C)</td>
<td>OK Above 32° F (0° C)</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*HF: High Frequency Current

**Coolants 043 810 and 043 809 protect to -37° F (-38°C) and resist algae growth.

NOTICE – Use of any coolant other than those listed in the table voids the warranty on any parts that come in contact with the coolant (pump, radiator, etc.).
SECTION 5 – INSTALLATION

5-1. Connections

**GTAW Connections**

1. Filler Cover
2. Coolant Out
3. Coolant In

Fittings have 5/8-18 left-hand threads.

See Section 4-4 to select proper coolant, and fill tank. Maintain coolant level at approximately 1 in. (25 mm) from filler neck.

4. 115 Volt AC Grounded Receptacle

Unit turns On when plugged in.

An individual branch circuit capable of carrying 15 amperes and protected by fuses or circuit breakers is recommended. Recommended fuse or circuit breaker size is 15 amperes.

**Do not move or operate unit where it could tip.**

To prevent overheating, make sure cooling unit is positioned so airflow is not restricted.

**NOTICE** – If welding power source has a water valve, do not connect hoses to water valve. Connect hoses as shown.

1. Filler Cover
2. Coolant Out
3. Coolant In

Fittings have 5/8-18 left-hand threads.

See Section 4-4 to select proper coolant, and fill tank. Maintain coolant level at approximately 1 in. (25 mm) from filler neck.

4. 115 Volt AC Grounded Receptacle

Unit turns On when plugged in.

An individual branch circuit capable of carrying 15 amperes and protected by fuses or circuit breakers is recommended. Recommended fuse or circuit breaker size is 15 amperes.

**Tools Needed:**

- 5/8 in.
## SECTION 6 – MAINTENANCE & TROUBLESHOOTING

### 6-1. Routine Maintenance

<table>
<thead>
<tr>
<th>Schedule</th>
<th>Task</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Month</td>
<td>Blow Out Heat Exchanger Fins</td>
</tr>
<tr>
<td></td>
<td>NOTICE – Clean coolant strainer. Severe conditions may require more frequent cleaning (continuous use, high/low temperatures, dirty environment, etc.). Failure to properly clean coolant strainer voids pump warranty.</td>
</tr>
<tr>
<td>6 Months</td>
<td>Replace Cracked Hoses</td>
</tr>
<tr>
<td></td>
<td>Replace Unreadable Labels</td>
</tr>
<tr>
<td>12 Months</td>
<td>Change Coolant (If Using MILLER Coolant)</td>
</tr>
</tbody>
</table>

### 6-2. Coolant Maintenance

1 Coolant Filter

- Remove nut to remove filter. Clean filter and reinstall.

- Changing coolant: Drain coolant by tipping unit. Fill with clean water and run for 10 minutes. Drain and refill.

- If replacing hoses, use hoses compatible with ethylene glycol, such as Buna-n, Neoprene, or Hypalon.

- NOTICE – Oxy-acetylene hoses are not compatible with any product containing ethylene glycol.

![Coolant Filter Diagram](image)

**Tools Needed:**

- 15/16 in.
6-3. Adjusting Relief Valve

Relief valve is factory set at 60 psi (414 kPa), and normally needs no adjustment: Only adjust if replacing motor.

<table>
<thead>
<tr>
<th>Tools Needed:</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Pressure gauge</td>
</tr>
<tr>
<td>2 Relief Valve Adjustment Screw</td>
</tr>
</tbody>
</table>

Connect gauge to Coolant Out fitting as shown. Block or plug any output fitting on gauge.

Turn On power, and adjust pressure adjustment screw as needed.

Turn Off power. Disconnect gauge and reinstall nut.

6-4. Troubleshooting

<table>
<thead>
<tr>
<th>Trouble</th>
<th>Remedy</th>
</tr>
</thead>
</table>
| Coolant system does not work. | Be sure input power cord is plugged in to energized receptacle.  
Check line fuses or circuit breaker, and replace or reset if necessary.  
Motor overheated. Unit starts running when motor has cooled.  
Have Factory Authorized Service Agent check motor. |
| Decreased or no coolant flow. | Add coolant.  
Check for clogged hoses or coolant filter.  
Disconnect pump, and check for sheared coupling. Replace coupling if necessary. |
SECTION 7 – ELECTRICAL DIAGRAM

WARNING

- Do not touch live electrical parts.
- Disconnect input power or stop engine before servicing.
- Do not operate with covers removed.
- Have only qualified persons install, use, or service this unit.

SECTION 8 – PARTS LIST

8-1. Recommended Spare Parts

<table>
<thead>
<tr>
<th>Dia.</th>
<th>Part No.</th>
<th>Description</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>146249</td>
<td>Strainer, Screen 100x90 Mesh 2.125 Lg X .687 Dia</td>
<td>1</td>
<td></td>
</tr>
</tbody>
</table>
Warranty Questions?
Call 1-800-4-A-MILLER for your local Miller distributor.

Your distributor also gives you...
Service
You always get the fast, reliable response you need. Most replacement parts can be in your hands in 24 hours.
Support
Need fast answers to the tough welding questions? Contact your distributor. The expertise of the distributor and Miller is there to help you, every step of the way.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed one year after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an international distributor.

1. 5 Years Parts — 3 Years Labor
   * Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules

2. 3 Years — Parts and Labor
   * Engine Driven Welding Generators (NOTE: Engines are Warranted Separately by the Engine Manufacturer.)
   * Inverter Power Sources (Unless Otherwise Stated)
   * Plasma Arc Cutting Power Sources
   * Process Controllers
   * Semi-Automatic and Automatic Wire Feeders
   * Smith 30 Series Flowgauge and Flowmeter Regulators (No Labor)
   * Transformer/Rectifier Power Sources
   * Water Coolant Systems (Integrated)

3. 2 Years — Parts
   * Auto-Darkening Helmet Lenses (No Labor)

4. 1 Year — Parts and Labor Unless Specified
   * Automatic Motion Devices
   * CoolBelt and CoolBand Blower Unit (No Labor)
   * External Monitoring Equipment and Sensors
   * Field Options
   (NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
   * Flowgauge and Flowmeter Regulators (No Labor)
   * RFCS Foot Controls (Except RFCS-RJ45)
   * Fume Extractors
   * HF Units
   * ICE/XT Plasma Cutting Torches (No Labor)
   * Induction Heating Power Sources, Coolers
   (NOTE: Digital Recorders are Warranted Separately by the Manufacturer.)
   * Load Banks
   * Motor Driven Guns (with exception of Spoolmate Spoolguns)
   * PAPR Blower Unit (No Labor)
   * Positioners and Controllers
   * Ramp Guns
   * Running Gear/Trailers
   * Spot Welders
   * Subarc Wire Drive Assemblies
   * Water Coolant Systems (Non-Integrated)
   * Weldcraft-Branded TIG Torches (No Labor)
   * Wireless Remote Foot/Hand Controls and Receivers
   * Work Stations/Weld Tables (No Labor)

5. 6 Months — Parts
   * Batteries
   * Bernard Guns (No Labor)
   * Tregaskiss Guns (No Labor)

6. 90 Days — Parts
   * Accessory Kits
   * Canvas Covers
   * Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
   * M-Guns
   * MIG Guns and Subarc (SAW) Guns
   * Remote Controls and RFCS-RJ45
   * Replacement Parts (No labor)
   * Roughneck Guns
   * Spoolmate Spoolguns

Miller’s True Blue® Limited Warranty shall not apply to:
1. Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer’s warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller’s option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer’s risk and expense. Miller’s option of repair or replacement will be F.O.B. Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTEE OR REPRESENTATION AS TO PERFORMANCE AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MILLER IS EXCLUDED AND DISCLAIMED BY MILLER.

Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.
## Owner’s Record

Please complete and retain with your personal records.

<table>
<thead>
<tr>
<th>Model Name</th>
<th>Serial/Style Number</th>
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<table>
<thead>
<tr>
<th>Purchase Date</th>
<th>(Date which equipment was delivered to original customer.)</th>
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<tbody>
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<table>
<thead>
<tr>
<th>Distributor</th>
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<table>
<thead>
<tr>
<th>Address</th>
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<th>City</th>
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## For Service

*Contact a DISTRIBUTOR or SERVICE AGENCY near you.*

Always provide Model Name and Serial/Style Number.

<table>
<thead>
<tr>
<th>Contact your Distributor for:</th>
<th>Welding Supplies and Consumables</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Options and Accessories</td>
</tr>
<tr>
<td></td>
<td>Personal Safety Equipment</td>
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<td></td>
<td>Service and Repair</td>
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<td></td>
<td>Replacement Parts</td>
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<tr>
<td></td>
<td>Training (Schools, Videos, Books)</td>
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<tr>
<td></td>
<td>Technical Manuals (Servicing Information and Parts)</td>
</tr>
<tr>
<td></td>
<td>Circuit Diagrams</td>
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<td></td>
<td>Welding Process Handbooks</td>
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</table>

To locate a Distributor or Service Agency visit www.millerwelds.com or call 1-800-4-A-Miller

<table>
<thead>
<tr>
<th>Contact the Delivering Carrier to:</th>
<th>File a claim for loss or damage during shipment.</th>
</tr>
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<tbody>
<tr>
<td></td>
<td>For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.</td>
</tr>
</tbody>
</table>