



PM-265810A

2020-08

**Processes**



MIG (GMAW) Welding

Flux Cored (FCAW) Welding

**Description**

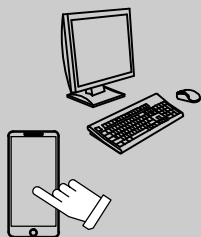
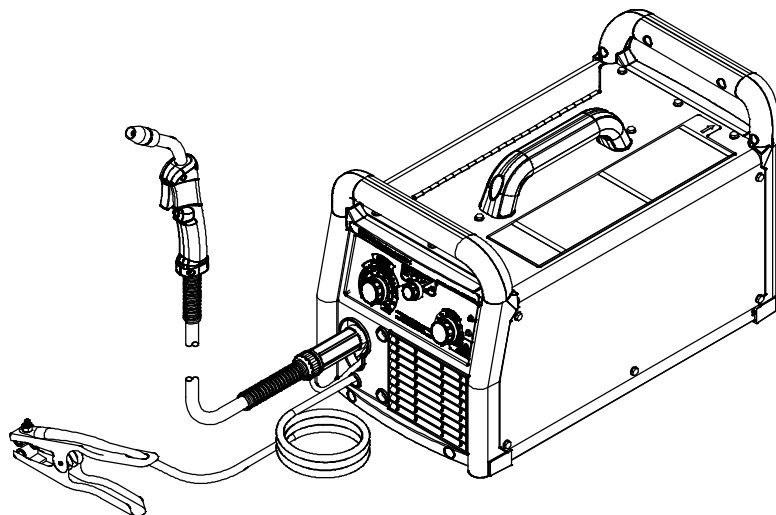


Arc Welding Power Source And Wire Feeder

# Millermatic<sup>®</sup> 211

## Eff. w/Serial No. MF322545N

For OM265809 Revision A And Following




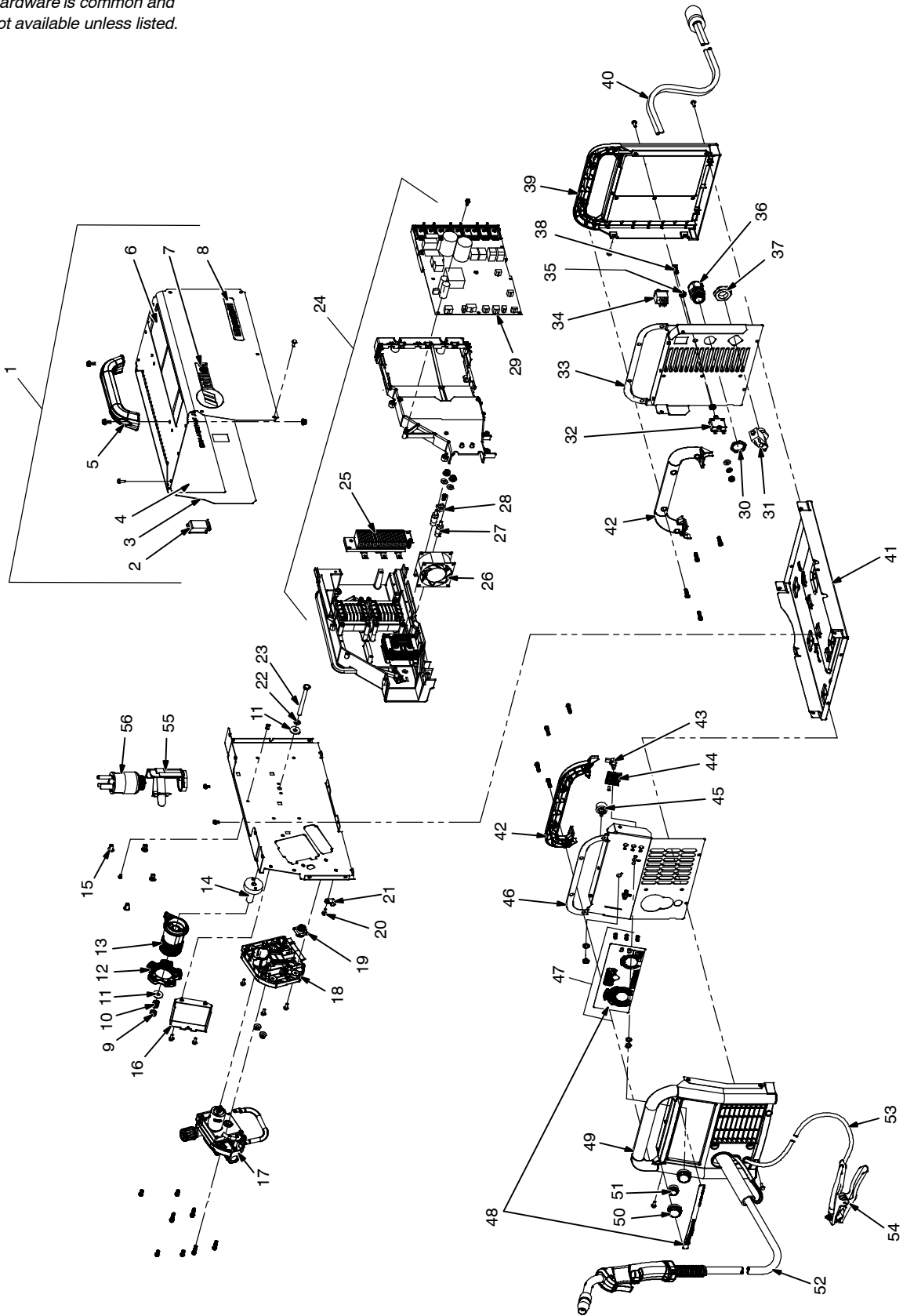
For product information,  
Owner's Manual translations,  
and more, visit

[www.MillerWelds.com](http://www.MillerWelds.com)

# PARTS MANUAL

# SECTION 1 - PARTS LIST

 Hardware is common and not available unless listed.



272271-C

Figure 1-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly</b>				
...		274488	.. Kit, Wrapper w/Labels & Handle (Includes)	1
...		204711	... Latch, Slide Flush Snap Lock	1
...		+263784	... Wrapper Assy	1
...		267705	... Label, Parameter/Consumable/Polarity	1
...		265650	... Handle Assy, Center	1
...		266758	... Label, Warning General Precautionary (En/Sp) w O/I	1
...		109844	... Label, Miller 6.000 x 2.500 Horizontal	2
...		267704	... Label, Side Millermatic 211	2
...		204608	.. Nut, 312-18 .50hex .34h Stl Pld Elastic Stop Nut	1
...		225257	.. Spring, Cprsn .467 Od X .060 Wire X .700 Pld	1
...		203072	.. Washer, Flat .331 ID x 0.945 OD x.079T Stl Pld	2
...		235607	.. Nut, Hub	1
...		265004	.. Hub, Spool	1
...		202726	.. Adapter, Spool Hub	1
...		228165	.. Grommet, SCR No 8 Panel Hole	5
...		263788	.. Enclosure, Electronics	1
...		Figure 1-2	.. Drive Assy, Wire	1
...		273838	.. Insulator, Drive Housing	1
...	RC3	048282	.. Rcpt, w/Sockets (Service Kit)	1
...		010142	.. Clamp, Nyl .312 Clamp Dia x.500 Wide .203 Mtg Hole	1
...		263455	.. Baffle, Center	1
...		602211	.. Washer, Lock .318 ID x 0.586 OD x .078T Stl Pld Split.312	1
...		203071	.. Screw, 312-18x3.50 Hex Hd-Pln Gr5 Pld Full Thread	1
...		272276	.. Kit, MM211 Windtunnel and Pcb Replacement (Includes)	1
...	SR1	272278	... Kit, Output Rectifier Replacement 211	1
...	FM	263000	... Fan Motor	1
...		271579	... Kit, Replacement Output Stud MM190/MM211	2
...		265407	... Square Spacer	1
...	PC1	275367	... Kit, MM211 Control Bd W/Pgm Replacement	1
...		198245	.. Nut, Conduit .750 Npt Pld 1.388 OD x .150 Thk	1
...	GS1	262572	.. Valve, 24Vdc 1way 750 Npt Pld 388 OD x 150 Thk	1
...	CB1	093997	.. Supplementary Protector, Man Reset 1P 30A 250 VAC Fr	1
...		263955	.. Panel, Rear	1
...	S1	274191	.. Switch, Rocker DPST 20A 277 VAC On-Off Blk Panel Mtg	1
...		147195	.. Nut, 375-27 .54hex .25h Nyl Flange .62d	1
...		269219	.. Bushing, Strain Relief .450/.709 ID x 1.068 Mtg Hole	1
...		272186	.. Nut, 750-14 NPS 1.312hex .41h Nyl	1
...		265409	.. Bolt, Mach Stl Sqhd .250-20 x .750	1
...		263750	.. Bezel, Rear	1
...		265471	.. Cable, Power 7 Ft 5 In 14Ga 3C 500W	1
...		263457	.. Base	1
...		263752	.. Bezel, Handle	2
...	R1, R2	263475	.. Pot Assy, w/Leads & Connector	1
...		265404	.. Spacer, Potentiometer Mtg	2
...	S2	265779	.. Switch, Selector 5 Position	1
...		263743	.. Panel, Front	1
...		272280	.. Kit, Replacement LED Assy(3), w/Control Label MM211	1
...		274604	.. Nameplate/Control Label, Millermatic 211	1
...		263748	.. Bezel, Front	1
...		263478	.. Knob, Pointer 1.250 Dia W/Recess	2
...		269904	.. Knob, Pointer 0.875 Dia W/Recess	1

◆ OPTIONAL

+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 1-1. Main Assembly (Continued)**

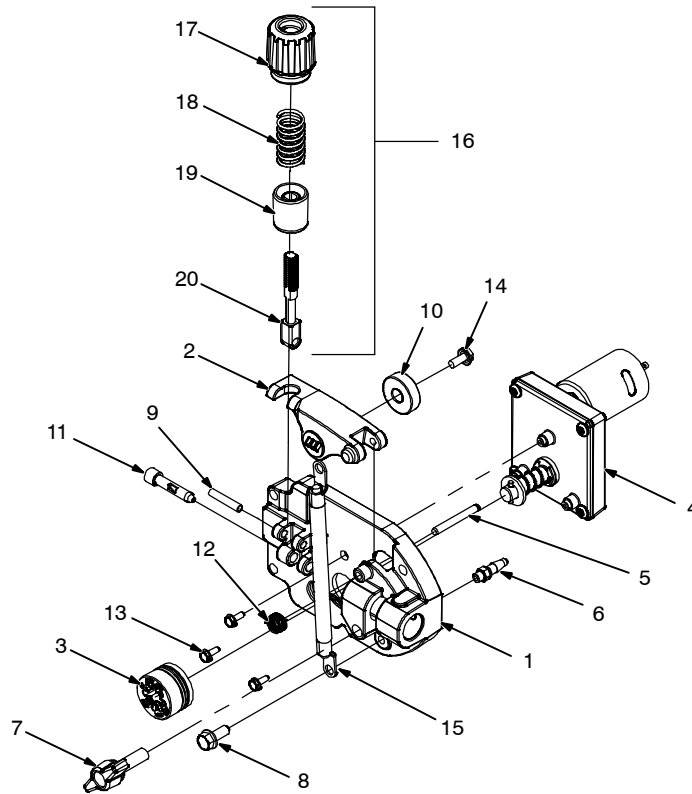
... 52	.....	1770027	.. MDX-100 Gun 10 ft .030-.035 w/Acculock	1
... 53	.....	196619	.. Work Lead	1
... 54	.....	240697	.. Clamp, Work 200 Amp	1
... 55	.....	271430	.. Holder, Power cord Adapter w/Strap	1
... 56	.....	219261	.. Adapter, Power Cable 5-15P	1
... 56	.....	219258	.. Adapter, Power Cable 6-50P	1
.....	.....	◆219259	.. Adapter, Power Cable 5-20P	1
.....	.....	267834	.. Regulator/Flowmeter, 10-50 CFH Argon/Mix AL Body	1
.....	.....	269815	.. Hose, Gas 5 ft	1
.....	.....	◆212492	.. Regulator/Flowmeter 0-50 CFH CO <sub>2</sub>	1
.....	.....	◆269816	.. Hose, Gas 5 ft (for use with regulator 212 492)	1

◆OPTIONAL

+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. 268 186-A

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

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>263454 Figure 1-2. Wire Feed Drive Assembly</b>				
...		1	274147 .. Housing, Drive (Machined)	1
...		2	274149 .. Lever, Pressure Roll	1
...		3	261157 .. Roll, Drive .024, .030-.035V Wire, .035VK Wire	1
...	DM	4	261150 .. Motor, Gear 16 VDC w/Leads Dbl Needle Bearing	1
...		5	608058 .. Pin, Dowel Hrd .187 x 1.500 Lg	1
...		6	263411 .. Fitting, Barbed Gas	1
...		7	222035 .. Knob, T 1.562 Bar w/.312-18 Stud 1.000 Lg Plstc	1
...		8	053300 .. Screw, 250-20 x .62 Hex Hd .50d Gr5 Pld Conical Washer	1
...		9	010224 .. Pin, Spring CS .187 x 1.000	1
...		10	189915 .. Bearing, Ball Rdl Sgl Row 9mm x 26mm x 8mm Wide Sh	1
...		11	261151 .. Guide, Wire Inlet .060	1
...		12	264715 .. Spring, Torsion	1
...		13	197172 .. Screw, 006-32 x .37 Hexwhd-Pln Silver Tri-Lobe	3
...		14	188846 .. Screw, 010-32 x .50 Hex Hd-Slt Stl Zinc Sqcone Sems	1
...		15	203667 .. Lead List, Large	1
...		16	221980 .. Knob, Tension Adjust Assy (Includes)	1
...		17	196895 .. Knob, Tension	1
...		18	234200 .. Spring, Cprsn .696 OD x .086 Wire x 1.500	1
...		19	198080 .. Cup, Spring 185	1
...		20	225718 .. Fastener, Pinned	1
...			269353 .. Tubing, PVC .187 ID x .312 OD x 20.000 Clear	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.**

### 1-3. Optional Drive Rolls

For All Feed Head Assemblies	
PART NO.	WIRE DIAMETER INCHES (mm)
261157	0.024 (.6) and 0.030/0.035 (0.8 and 0.9) and 0.030/0.035 (0.8 and 0.9) (VK Groove)
◆220179	0.024 (0.6) and 0.030/0.035 (0.8 and 0.9) (Standard)
◆202926	0.030/0.035 (0.8 and 0.9) and 0.045 (1.2 VK Groove)
◆Optional	

### 1-4. M-100 Welding Gun Consumables (Prior To Serial No. MK171201N)

Item No.	Part No.	Description	Quantity
.....	246372	.. Nozzle, Slip Type .500 Orf Flush .....	1
.....	◆087299	.. Tip, Contact Scr .023 Wire X 1.125	
.....	◆000067	.. Tip, Contact Scr .030 Wire X 1.125	
.....	◆000068	.. Tip, Contact Scr .035 Wire X 1.125	
.....	◆000069	.. Tip, Contact Scr .045 Wire X 1.125	
.....	◆194010	.. Liner, Monocoil .023/.025 Wire X 15ft (Consisting Of) .....	1
.....	◆194011	.. Liner, Monocoil .030/.035 Wire X 15ft (Consisting Of) .....	1
.....	◆194012	.. Liner, Monocoil .035/.045 Wire X 15ft (Consisting Of) .....	1
.....	079975	.... O-Ring, .187 Id X .103cs Rbr .....	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.

### 1-5. MDX Welding Consumables (Eff With Serial No. MK171201N)

See OM-282976 (shipped with this product) for information on replacement consumables for the MDX welding gun.



**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](http://www.MillerWelds.com)

