





TM-1324D 2012-02

Millermatic 135 (907 019) Eff. w/Serial No. LB204281

Millermatic 175 (907 020) Eff. w/Serial No. LB204053

**Processes**

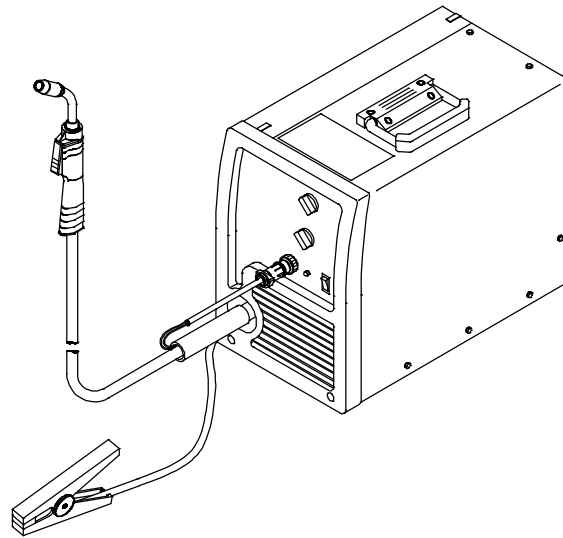
-  MIG (GMAW) Welding
-  Flux Cored (FCAW) Welding

**Description**



Arc Welding Power Source And Wire Feeder

# Millermatic<sup>®</sup> 135/175 And M-10 Gun



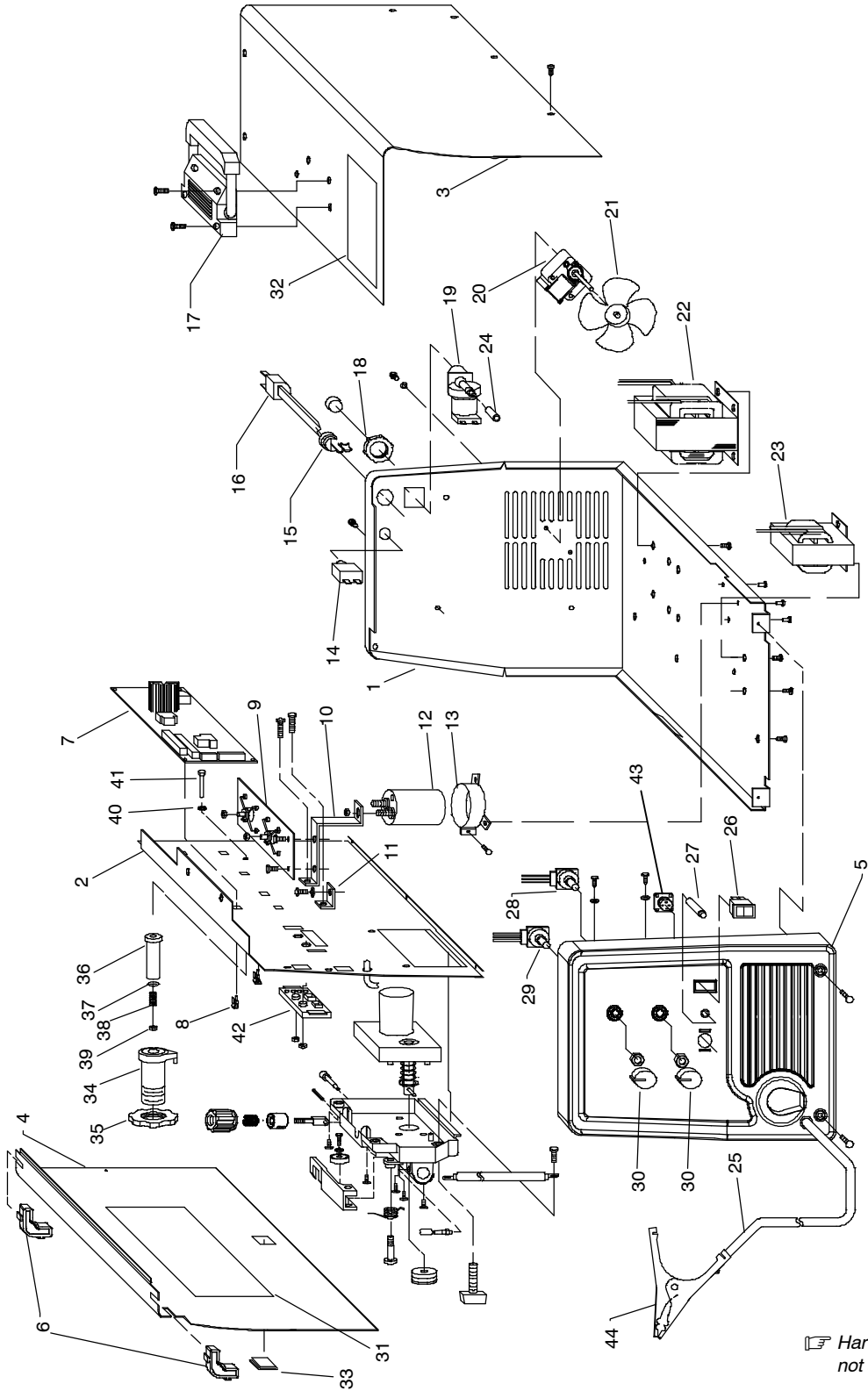
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## PARTS LIST

File: MIG (GMAW)



# SECTION 1 - PARTS LIST



 Hardware is common and not available unless listed.

803 614-A

Figure 1-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly</b>				
...	1	202 581	.. BASE, lower	1
...	2	202 582	.. BAFFLE, center	1
...	3	202 583	.. WRAPPER, cover	1
...	4	202 584	.. DOOR, access	1
...	5	202 411	.. PANEL, front	1
.....		203 498	.. LABEL, control panel (115 VAC model)	1
.....		203 499	.. LABEL, control panel (230 VAC model)	1
...	6	202 412	.. HINGE, door	2
...	7	PC1	199 820 .. CIRCUIT CARD ASSY, control (115 VAC model) (Prior to LC071291)	1
...	7	PC1	207 463 .. CIRCUIT CARD ASSY, control (115 VAC model) (Eff w/LC071291)	1
...	7	PC1	202 354 .. CIRCUIT CARD ASSY, control (230 VAC model) (Prior to LC038105)	1
...	7	PC1	207 466 .. CIRCUIT CARD ASSY, control (230 VAC model) (Eff w/LC038105)	1
...	8		134 201 .. STAND-OFF support PC board	8
...	9	SK1	193 191 .. RECTIFIER ASSY (115 VAC model)	1
...	9	SK1	193 316 .. RECTIFIER ASSY (230 VAC model)	1
...	10		204 215 .. BUS BAR (positive)	1
...	11		193 194 .. BUS BAR (negative)	1
...	12	C1	193 039 .. CAPACITOR, elctlt 53,000 uf (115 VAC model)	1
...	12	C1	193 040 .. CAPACITOR, elctlt 100,000 uf (230 VAC model)	1
...	13		203 491 .. CLAMP, capacitor	1
...	14	CB1	210 109 .. SUPPLEMENTARY PROTECTOR, 25 amp	1
...	15		111 443 .. BUSHING, strain relief	1
...	16		147 545 .. CORD SET, 125V 5-15P 14GA 3/C 7ft SPT-3 jkt (115 VAC model)	1
...	16		152 118 .. CORD SET, 250V 6-50P 12GA 3/C 7ft SPT-3 jkt (230 VAC model)	1
...	17		208 015 .. HANDLE, carrying	1
...	18		137 761 .. NUT	1
...	19	GS1	216 397 .. VALVE, 2 way (115 VAC model)	1
...	19	GS1	216 398 .. VALVE, 2 way (230 VAC model)	1
...	20	FM	196 063 .. MOTOR, fan (115 VAC model)	1
...	20	FM	196 064 .. MOTOR, fan (230 VAC model)	1
...	21		409 953-001 .. BLADE, fan cooling	1
...	22	T1	203 445 .. TRANSFORMER (115 VAC model)	1
...	22	T1	203 456 .. TRANSFORMER (230 VAC model)	1
...	23	Z1	221 100 .. STABILIZER, 90A (115 VAC model)	1
...	23	Z1	221 102 .. STABILIZER, 130A (230 VAC model)	1
...	24		196 467 .. TUBING, pvc	1
...	25		196 619 .. WORK CABLE	1
...	26	S1	196 575 .. SWITCH, rocker SPST (115 VAC model)	1
...	26	S1	196 574 .. SWITCH, rocker DPDT (230 VAC model)	1
...	27	PL1	202 661 .. LED, yellow	1
...	28	R1	202 663 .. POTENTIOMETER, cp flat 1T .50W 50k	1

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

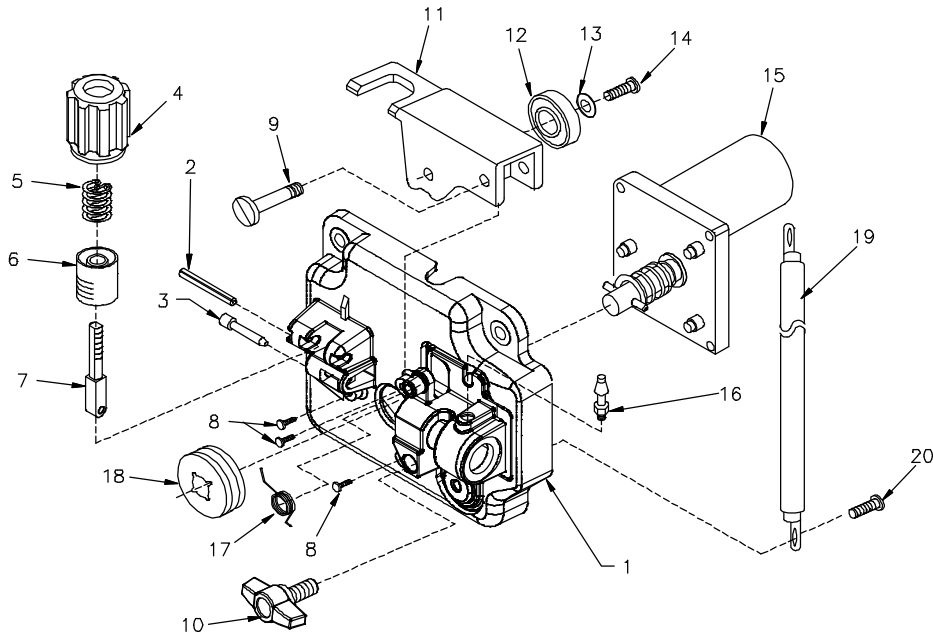
**To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.**

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>Figure 1-1. Main Assembly (Continued)</b>				
... 29	R2	202 662	.. POTENTIOMETER, cp flat 1T .50W 50k (wire speed control) [Prior to LC071291 (115 VAC model), LC038105 (230 VAC model)]	... 1
... 29	R2	207 415	.. POTENTIOMETER, cp flat 1T .50W 50k (wire speed control) [Eff w/LC071291 (115 VAC model), LC038105 (230 VAC model)]	... 1
... 30		205 882	.. KNOB, pointer (Prior to LC208191)	2
... 30		207 078	.. KNOB, pointer (Eff w/LC208191)	2
... 31		203 501	.. LABEL, weld guide (115 VAC model) (Prior to LC071291)	1
... 31		208 267	.. LABEL, weld guide (115 VAC model) (Eff w/LC071291)	1
... 31		203 764	.. LABEL, weld guide (230 VAC model) (Prior to LC038105)	1
... 31		208 268	.. LABEL, weld guide (230 VAC model) (Eff w/LC038105)	1
... 31		208 267	.. LABEL, weld guide (115 VAC model)	1
... 31		208 268	.. LABEL, weld guide (230 VAC model)	1
... 32		204 036	.. LABEL, precautionary static	1
... 33		204 711	.. LATCH, slide flush snap lock	1
... 34		202 725	.. HUB, spool (Prior to LC654442)	1
		207 305	.. SPACER, spool hub (Eff w/LC208191 thru LC654441)	1
... 34		211 339	.. HUB, spool (Eff w/LC654442)	1
... 35		058 427	.. RING, retaining spool (Prior to LC654442)	1
... 35		211 887	.. NUT, hub (Eff w/LC654442)	1
... 36		202 726	.. ADAPTER, spool hub	1
... 37		203 072	.. WASHER, flat	1
... 38		202 998	.. SPRING, cprsn (Prior to LF270412)	1
... 38		225 257	.. SPRING, cprsn (Eff w/LF270412)	1
... 39		204 608	.. NUT	1
... 40		602 211	.. WASHER, lock	1
... 41		203 071	.. SCREW	1
... 42	TE1	193 144	.. INSULATOR, output stud	1
... 43	RC1	048 282	.. RCPT W/SKTS (service kit)	1
... 44		208 820	.. CLAMP, work	1
		◆212 492	.. REGULATOR/FLOWMETER, 10-50 CFH CO <sub>2</sub>	1
		◆144 108	.. HOSE, gas 5ft	1

◆OPTIONAL

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

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804 095-A

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

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
<b>223 655      Figure 1-2. Wire Feed Drive Assembly</b>				
...	1	202 500	.. HOUSING, plastic drive motor	1
...	2	203 424	.. PIN, spring	1
...	3	058 549	.. GUIDE, wire inlet	1
...	4	196 895	.. KNOB, tension	1
...	5	090 415	.. SPRING, compression	1
...	6	198 080	.. CUP, spring tension	1
...	7	225 718	.. FASTENER, pinned	1
...	8	197 172	.. SCREW, motor	3
...	9	203 567	.. SCREW,shld	1
...	10	222 035	.. KNOB, tee	1
...	11	203 301	.. LEVER, pressure	1
...	12	189 915	.. BEARING, ball	1
...	13	602 238	.. WASHER, flat	1
...	14	122 210	.. SCREW, 010-32 x 0.62	1
...	15	DM 202 708	.. MOTOR, gear	1
...	16	196 009	.. FITTING, gas	1
...	17	203 418	.. SPRING, torsion	1
...	18	220 179	.. ROLL, feed .024, .030/.035	1
...	19	203 667	.. CABLE	1
...	20	053 300	.. SCREW, 250-20 x 0.62	1
...		225 717	.. DRIVE HEAD ASSY, w/o motor	1

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

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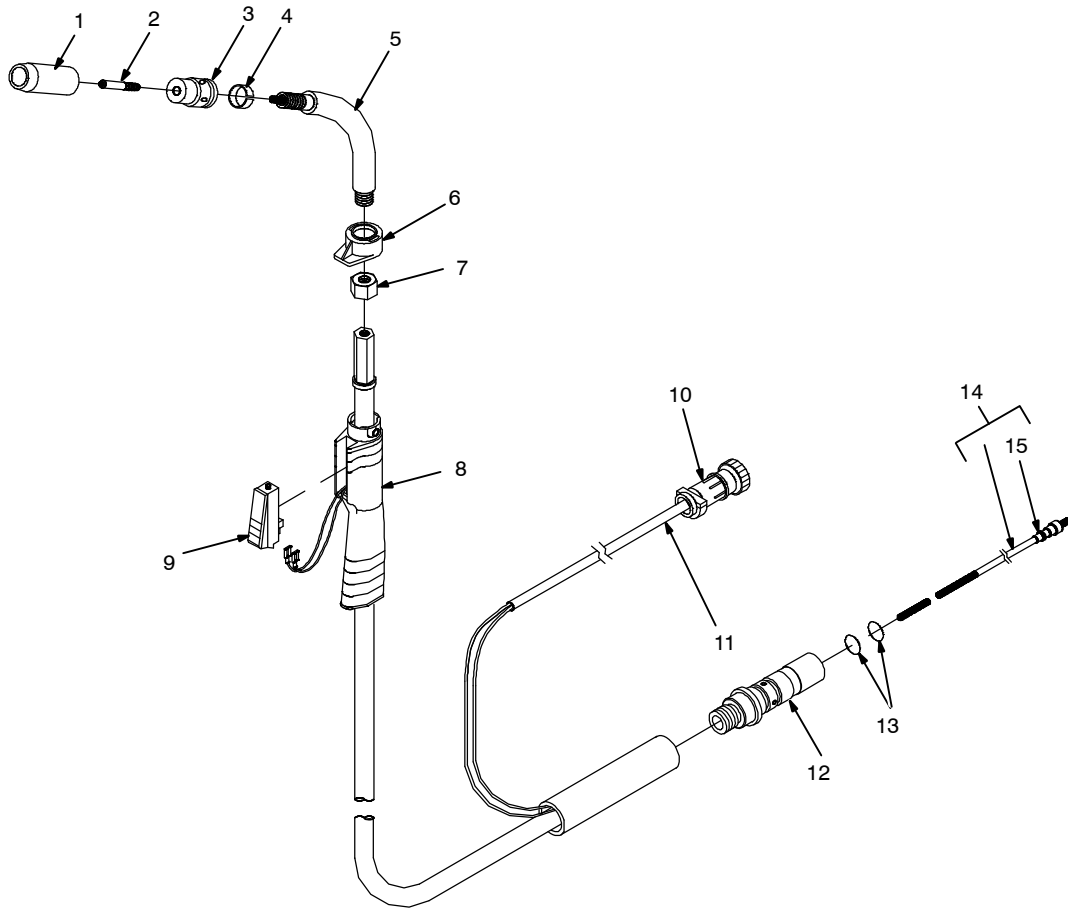


Figure 1-3. M-10 Gun

802 388-B

Item No.	Part No.	Description	Quantity
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**Figure 1-3. M-10 Gun**

...	1	169 715	.. NOZZLE, slip type .500 orf flush	1
...	2	◆087 299	.. TIP, contact scr .023 wire x 1.125	
...	2	◆000 067	.. TIP, contact scr .030 wire x 1.125	
...	2	◆000 068	.. TIP, contact scr .035 wire x 1.125	
...	2	◆000 069	.. TIP, contact scr .045 wire x 1.125	
...	3	169 716	.. ADAPTER, contact tip	1
...	4	170 470	.. RING, retaining	1
...	5	169 718	.. TUBE, head	1
...	6	169 738	.. NUT, locking handle	1
...	7	169 719	.. NUT, jam	1
...	8	169 737	.. HANDLE	1
...	9	227 798	.. SWITCH, trigger	1
...	10	079 878	.. HOUSING PLUG & PINS	1
...	11	227 800	.. CORD, trigger assembly	1
...	12	209 495	.. CONNECTOR, feeder	1
...	13	079 974	.. O-RING, .500 ID x .103CS rbr	2
...	14	◆194 010	.. LINER, monocoil .023/.025 wire x 15ft (consisting of)	1
...	14	◆194 011	.. LINER, monocoil .030/.035 wire x 15ft (consisting of)	1
...	14	◆194 012	.. LINER, monocoil .035/.045 wire x 15ft (consisting of)	1
...	15	079 975	... O-RING, .187 ID x .103CS rbr	1

◆OPTIONAL

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### 1-4. Drive Rolls

For All Feed Head Assemblies	
PART NO.	WIRE DIAMETER INCHES (mm)
220 179	.024 (.6) and .030/.035 (.8 and .9) (Standard)
202 926	.030/.035 (.8 and .9) and .045 (1.2 VK Groove)

### 1-5. Options

PART NO.	DESCRIPTION	REMARKS
770 187	Running Gear/Cylinder Rack	For One Small Gas Cylinder, 100 lb (45 kg)
194 776	Small Running Gear/Cylinder Rack	For One Small Gas Cylinder, 75 lb (34 kg)
195 605	M-10 Replacement Gun	10 ft length/.030-.035 wire size

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