Quick Specs

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<th>Manufacturing Applications</th>
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<td>Mining Machinery</td>
</tr>
</tbody>
</table>

Processes

- Multi-MIG®
  - Accu-Pulse® MIG (GMAW-P)
    - Accu-Curve™
    - Accu-Speed™ Optional
  - Pulsed MIG (GMAW-P)
  - MIG (GMAW)
  - Metal-Cored
  - RMD® Optional
  - Carbon Arc Gouging (CAC-A)
    can also be activated

FREE TRIAL! of Accu-Speed and RMD. See page 2 for details.

Flexible, Expandable and Upgradeable

Multi-MIG capable welding systems are precise, digitally controlled and software-driven. For additional information see page 2.

Axcess four-drive-roll wire drive feeder is combined with operator interface leaving no controls back at the power source.

Several different wire feeding and operator interface options are available and configurable to desired application.

Access the ability to accommodate welding data file exchange through downloadable upgrades and new hybrid welding processes using e-mail, or the Web and a PC or Palm™ handheld (PDA).


Rated Output

- 300: 300 A at 29 VDC, 60% Duty Cycle
  - (225 A at 25.3 VDC, 100% Duty Cycle)
- 450: 450 A at 36.5 VDC, 100% Duty Cycle
- 675: 675 A at 38 VDC, 100% Duty Cycle

Voltage Range: 10 – 44 V

Auxiliary Power: 120 VAC, 10 A Duplex

Net Weight

- 300: 112 lb. (50.8 kg)
- 450: 163 lb. (73.9 kg)
- 675: 215 lb. (97.5 kg)

Axcess MIGRunner™ Package shown.

Insight™ Core is a flexible, Internet-based industrial welding information management solution that can help your operation be more competitive and profitable by delivering accurate, decision-ready information about welding processes. See page 2 for more information.

Build your own system at MillerWelds.com/equiptoweld or see the Stationary and MiGRunner Packages on page 8.
Features and Benefits

SOFTWARE (Standard) — FREE 16 Hour Trial of Accu-Speed and RMD with Every New Axcess® Power Supply

Multi-MIG® capability
Includes common carbon steel, aluminum and stainless welding programs, including Accu-Pulse®, Accu-Curve™ and Accu-Speed™ (optional), standard or adaptive pulse, conventional MIG and metal core programs, and RMD® (optional) using the most popular wire diameters and gas combinations.

SureStart™
Provides consistent arc starts by electronically assuring a ball is not left on the wire when welding is stopped. This provides a predictable condition for the next arc start and combines this with precisely tuned arc starting routines.

Arc Control
Control offers a simple way to tailor factory pulse weld programs by adjusting the arc plasma cone to accommodate a variety of welding applications without the need for any reprogramming or changing any hardware.

Arc Adjust
Allows a simple method that controls arc length for pulse processes and wetting action for RMD.

Remote/trigger program select
Allows changing weld programs to take advantage of up to eight programs of Multi-MIG welding process capabilities.

Optional Axcess software
Accu-Speed and RMD, Axcess file management system, and WaveWriter™ pulse wave shaping.

Multi-MIG® Process Capability — Through Software-Based Programs

Access the ideal welding process for any weld joint at hand. Whether you need high travel speed combined with high deposition rates or require gaps to be filled, any combination of the available welding processes can accessed either at the start of a welding sequence or anywhere in the weld while actually welding by using trigger or remote program select.

For a given wire-feed speed, the chart below shows from left (hottest) to right (coolest) all the possible arc mode transfer ranges of accessible MIG and pulse processes. This shows compatible shielding gas combinations such as 90 Ar/10 CO₂ (90 percent argon and 10 percent carbon dioxide) on steel using the same wire-feed speed and also gives an indication of puddle control characteristics based on arc type selected.

<table>
<thead>
<tr>
<th>Process</th>
<th>Standard Spray</th>
<th>Pulsed Spray</th>
<th>Accu-Pulse®</th>
<th>Accu-Curve™</th>
<th>Standard Short Circuit</th>
<th>RMD® Regulated Metal Deposition (Optional)</th>
</tr>
</thead>
</table>
| Weld Puddle Control      | Flat/Horizontal| All Position Performance | Thin Materials/Gap Filling |}

Note: To achieve optimum performance, 4/0 welding power secondary cable is recommended and the supplied work-sense lead must be connected as close to arc as possible.
Accu-Speed™ STANDARD on all Axcess® models

Accu-Speed is a variation of the Accu-Pulse process and was developed for the type of arcs needed in automated welding applications. Accu-Speed has a tighter driving arc that can be directed into the joint, yet still remains stable at the higher travel speeds used in automated welding. In general, Accu-Speed has lower average voltage and amperage when compared to Accu-Pulse which makes it ideal when welding out of position in the manual mode.

Note: Serial number must be provided for field installation. Factory-installed software can be ordered as a combo-number option with power supply. See power source stock number listings on page 8. Field kits include cable for connecting to Axcess, but require PC Palm handheld or PC version of File Manager.

Benefits (Compared to conventional pulse)
- Shorter arc lengths possible
- Better puddle control
- More tolerant of contact tip to work variation
- Less audible noise
- No arc wandering in tight corners
- Narrow arc plasma column
- Allows weld to fill in at toes increasing travel speed and deposition
- More tolerant of poor fit up and gaps (compared to standard pulse)
- Ideal for robot seam tracking applications

Optional Software-Based Welding Processes

Accu-Speed™

Field #300 719 For Palm (Required Palm handheld with data card slot is NOT included.)
Field #300 720 For PC (PC-based emulator and cable are NOT included.)

Accu-Speed is a variation of the Accu-Pulse process and was developed for the type of arcs needed in automated welding applications. Accu-Speed has a tighter driving arc that can be directed into the joint, yet still remains stable at the higher travel speeds used in automated welding. In general, Accu-Speed has lower average voltage and amperage when compared to Accu-Pulse which makes it ideal when welding out of position in the manual mode.

Note: Serial number must be provided for field installation. Factory-installed software can be ordered as a combo-number option with power supply. See power source stock number listings on page 8. Field kits include cable for connecting to Axcess, but require PC Palm handheld or PC version of File Manager.

Benefits
- Up to 20% greater travel speed than Accu-Pulse
- Lower average voltage/amperage than Accu-Pulse
- Tight, driving arc
- Remains stable at higher travel speeds

RMD® (Regulated Metal Deposition)

Field #195 252 For Palm (Required Palm handheld with data card slot is NOT included.)
Field #300 721 For PC (PC-based emulator and cable are NOT included.)

The RMD process is a precisely controlled short-circuit transfer. It is a method of detecting when the short is going to clear and then rapidly reacting to this data changing the current (amperage) levels. Features proactive dynamic puddle control.

Note: Serial number must be provided for field installation. Factory-installed software can be ordered as a combo-number option with power supply. See power source stock number listings on page 8. Field kits include cable for connecting to Axcess, but require PC Palm handheld or PC version of File Manager.

Benefits
- Well suited to thin materials
- Can replace TIG process in some applications
- Gap filling
- Spatter reduction
- Provides less heat into work piece
- Excellent performance on stainless steel
- Can be combined with other Axcess™-related programs
- Minimize distortion
- Use larger diameter wire on thin materials
**Typical Installations** *(Semi-automatic Pulsed MIG or conventional MIG)*

The Axcess platform is designed to provide multiple wire feeding configurations suited to the unique needs of modern manufacturing applications and industries. It utilizes many common components to minimize both part and maintenance complexity. All motors operate on 40 VDC provided by the Axcess power supply and have a wire feed speed range of 50–1400 inches per minute. A common operator interface is used on all (see page 6).

**Standard Installation**

A typical bench/sled feeder installation. For use when the feeder is placed on the power supply, a bench or an optional cart.

**ROI Option Installation**

Allows feeder motor drive to be placed away from power supply and operator interface. Ideal for fixed automation applications and updating or replacing equipment on booms or other applications where separate location of power source, ROI, and wire drive motor is desirable.

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**Power Source Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Model</th>
<th>Amps/Volt Ranges</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 50/60 Hz, 3-Phase</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Axcess 300</td>
<td>5–400 A, 10–44 V</td>
<td>300 A at 29 VDC, 60% duty cycle (225 A at 25.3 VDC, 100% duty cycle)</td>
<td>33 29.7 16.9 14.6 11.6 11.7 11.2</td>
<td>80 VDC</td>
<td>300 H: 23 in. (584 mm) 450 H: 31 in. (787 mm) 675 H: 39 in. (991 mm) W: 17 in. (432 mm) D: 22.5 in. (572 mm)</td>
<td>112 lb. (50.8 kg)</td>
</tr>
<tr>
<td>Axcess 450</td>
<td>5–600 A, 10–44 V</td>
<td>450 A at 36.5 VDC, 100% duty cycle</td>
<td>— 60 33.7 28.8 22.8 23.8 22.9</td>
<td>80 VDC</td>
<td>— 60 33.7 28.8 22.8 23.8 22.9</td>
<td>163 lb. (73.9 kg)</td>
</tr>
<tr>
<td>Axcess 675</td>
<td>5–900 A, 10–44 V</td>
<td>675 A at 38 VDC, 100% duty cycle</td>
<td>— 89.7 — 43.7 34.8 35.7 34.4</td>
<td>80 VDC</td>
<td>— 89.7 — 43.7 34.8 35.7 34.4</td>
<td>215 lb. (97.5 kg)</td>
</tr>
</tbody>
</table>

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

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**Wire Feeder Options**

Feeder includes drive rolls and Bernard™ Q-Gun™ (one for single-wire models and two for dual-wire models). Required DeviceNet Interconnecting Feeder Control Cable must be ordered separately.

**Axcess Single Feeder**

*For available lengths visit MillerWelds.com/equiptoweld.**

---

*For available lengths visit MillerWelds.com/equiptoweld.*

**This is the wire feed speed range while using MIG. With Pulsed MIG, the wire feed speed range may be more limited.*
3 ROI (Remote Operator Interface) Options

ROI does NOT include AA-40GB wire drive motor assembly, motor control cable or DeviceNet interconnecting feeder control cable. These must be ordered separately.

Single ROI  #195 238
Dual ROI #195 433

The ROI allows the Axcess power supply, wire drive motor assembly and operator interface (ROI) to be located in three separate places. This is desirable for mounting to custom jibs, booms or other extended-reach applications. Since an ROI system can incorporate separate components providing the most flexibility for custom applications, it’s an ideal way to obtain the many benefits of the Axcess while retaining an existing automation system. Four programs are available per side.

Note: For non-Miller boom and jib mounting, see ROI installation diagram on page 4 and select desired cable lengths.

Auto ROI #195 239*

(Contact Applications for assistance at 920-954-3809 prior to any new installation.)
The Auto ROI is to be used with an Axcess power supply with the E-Stop option. Provides functionality of the ROI, but replaces sequence and trigger functions with two programmable inputs and outputs. To be used in simple dedicated/fixed/hard automation applications. Features are established output. Includes 30-foot cable for wiring to other external devices.

*Requires Axcess power supply with E-Stop option. E-Stop is not intended for continuous interruption applications. Axcess systems require approximately 30 seconds to reboot or come back online after recovering from an E-Stop condition.

Note: For non-Miller boom and jib mounting, see ROI installation diagram on page 4 and select desired cable lengths.

Axcess® ROI Swingarc™ Boom-Mounted Wire Feeders

<table>
<thead>
<tr>
<th>Model</th>
<th>Wire Feeder Options</th>
</tr>
</thead>
<tbody>
<tr>
<td>#951 383</td>
<td>8-ft. (2.4 m) Single-Wire</td>
</tr>
<tr>
<td>#951 384</td>
<td>12-ft. (3.7 m) Single-Wire</td>
</tr>
<tr>
<td>#951 385</td>
<td>16-ft. (4.9 m) Single-Wire</td>
</tr>
<tr>
<td>#951 386</td>
<td>8-ft. (2.4 m) Dual-Wire</td>
</tr>
<tr>
<td>#951 387</td>
<td>12-ft. (3.7 m) Dual-Wire</td>
</tr>
<tr>
<td>#951 388</td>
<td>16-ft. (4.9 m) Dual-Wire</td>
</tr>
</tbody>
</table>

Swingarc boom-mounted semi-automatic wire feeders bring an extra dimension of flexibility and efficiency to high-production MIG welding stations. You get an effective solution that maximizes output, especially when dealing with large weldments and hard-to-reach places.

Trigger Control Cable #300 129
21 ft. (6.4 m). Required when retrofitting non-Miller booms with an ROI option.

4 Wire Drive Motor Assembly Options (To be used with Remote Operator Interface.)

AA-40GB Wire Drive Motor Assembly

<table>
<thead>
<tr>
<th>Model</th>
<th>Wire Feed Motor Assembly Options</th>
</tr>
</thead>
<tbody>
<tr>
<td>#195 426</td>
<td>Left-Hand Drive</td>
</tr>
<tr>
<td>#195 515</td>
<td>Right-Hand Drive</td>
</tr>
</tbody>
</table>

The AA-40GB wire drive motor assembly with Over Current Protection (OCP) is an improved version of the AA-40G. The motor control cable now mounts directly to the gas box, reducing strain on the tachometer wires. OCP provides another layer of protection in the event a cable is damaged or shorted, reducing downtime and motor damage. Motors include a 50-foot (15.2 m) volt-sense cable.

Note: Wire drive motor assemblies do NOT include drive rolls or required Motor Control Cable. These must be ordered separately. Left- and right-hand drives are determined by facing the wire feed gun outlet.

<table>
<thead>
<tr>
<th>Model</th>
<th>Gas Valve</th>
<th>Type of Input Power</th>
<th>Connection to Power Source</th>
<th>Wire Feed Speed Range**</th>
<th>Wire Diameter Range</th>
<th>AA-40GB Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>AA-40GB</td>
<td>Included and enclosed</td>
<td>40 VDC (from Axcess)</td>
<td>Motor Control Cable* (order separately)</td>
<td>50 – 1400 IPM (1.3 – 35.56 MPM)</td>
<td>.035 – .3/32 in. (0.9 – 1.6 mm)</td>
<td>H: 8 in. (203 mm) W: 12 in. (305 mm) D: 10 in. (254 mm)</td>
<td>16.5 lb. (7.5 kg)</td>
</tr>
</tbody>
</table>

*For available lengths visit MillerWelds.com/equiptoweld.
**This is the wire feed speed range while using MIG. With Pulsed MIG, the wire feed speed range may be more limited.
Control Panels

Front Panel

1. Power Switch
2. Handheld RS-232 Port
3. PC-Communication RS-232 Port
4. 115 VAC, 10 A Duplex Receptacle
5. Circuit Breakers
6. Network Feeder Connector

Rear Panel

1. Voltage/Arc Adjust Display Meter
2. Program Display
3. Program # Select
4. Process Setup Button
5. Control Knob
6. Trigger Receptacle
7. On/Off Button
8. Voltage Setup Button
9. Wire Speed Setup Button
10. Wire Speed/Amperage Display Meter
11. Feeder Setup Button
12. Jog/Purge Switch

Capabilities

Dual Schedule — Toggle between two settings using a single wire.

4T — When trigger is released, output will operate at different ranges.

Trigger Program Select (TPS) — Provides the ability to access any of the Multi-MIG® processes or any of the eight active programs.

Trigger Dual Schedule (TDS) — When activated, allows selection between predetermined program pairs (e.g. 1,2 – 3,4 – 5,6 – 7,8).

Trigger Hold (TH) — When activated, allows gun trigger release and continuous welding until trigger is pulled again.

Carbon Arc Gouging (CAC-A) — Can be activated.

Sequence
- Preflow: 0.1– 5 seconds
- Start Power: 0.1– 5 seconds
- Crater: 0.1– 5 seconds
- Postflow: 0.1– 5 seconds

Arc Adjust — Arc length (Trim)

Arc Control — Arc force or focus (SharpArc®)

Process Selection — Accu-Pulse®, Pulsed MIG, MIG, Metal Core, RMD® (Optional)

Drive Roll Kits and Guides (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include four drive rolls, necessary guides and feature an anti-wear sleeve for inlet guide.

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>&quot;V&quot; groove for hard wire</th>
<th>&quot;U&quot; groove for soft wire or soft-shelled cored wires</th>
<th>&quot;V&quot; knurled for hard-shelled cored wires</th>
<th>&quot;U&quot; cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)</th>
<th>&quot;U&quot; groove for aluminum wires contains nylon guides</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>#151 026</td>
<td>—</td>
<td>#151 052</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>#151 190</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>.045 in. (1.1/1.2 mm)</td>
<td>#151 027</td>
<td>#151 037*</td>
<td>#151 053</td>
<td>#151 070</td>
<td>#243 234*</td>
</tr>
<tr>
<td>.052 in. (1.3/1.4 mm)</td>
<td>#151 028</td>
<td>—</td>
<td>#151 054</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>#151 029</td>
<td>#151 039</td>
<td>#151 055</td>
<td>#151 072</td>
<td>#243 235</td>
</tr>
<tr>
<td>.068/.072 in. (1.8 mm)</td>
<td>—</td>
<td>—</td>
<td>#151 056</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>3/32 in. (2.4 mm)</td>
<td>—</td>
<td>—</td>
<td>#151 057</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
</tbody>
</table>

*Nylon Wire Guides for Feeding Aluminum Wire*

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>Inlet Guide</th>
<th>Intermediate Guide</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>#221 912</td>
<td>#242 417</td>
</tr>
<tr>
<td>.047 in. (1.2 mm)</td>
<td>#221 912</td>
<td>#205 936</td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>#221 912</td>
<td>#205 937</td>
</tr>
</tbody>
</table>

Note: *U* groove drive rolls are recommended when feeding aluminum wire.
Genuine Miller® Services, Options and Accessories

Consulting Services

Field Application Support  #195 480
Axcess systems may require factory-trained technical support depending on the complexity of the application and the local availability and capability of qualified welding engineers or technology experts. Contact the factory with questions. Factory support is available at a flat rate of $1250.00 per day (plus expenses) when scheduled more than 10 days in advance. With less than 10-day notice, rates may be higher. Rates are based on a 10-hour day, including travel. One day minimum.

File Management Software

Axcess® File Management  #300 529  For PC
(Includes PC-based emulator, USB cable and USB flash drive with File Management software.)
Simply put, Axcess File Management software turns a standard Palm handheld (PDA) or PC into a remote pendant control for all Axcess Systems.

With Axcess File Management installed on your Palm OS handheld or PC you can:
- E-mail Axcess files anywhere worldwide
- Configure any Axcess system as desired
- Configure multiple Axcess systems exactly the same or any way you choose
- Save and store Axcess files
- Transfer Axcess files to computers
- Transfer Axcess files from machine to machine
- Backup Axcess files and programs
- Set-up and modify Axcess welding sequences
- Adjust and store welding program

Locks & Limits for restricting or limiting operator access to programs
- Enable Auto-Thread™ feature to program torch length into Axcess memory. When a combination of purge and jog (or jog and retract) are depressed, the Axcess feeding system delivers exact programmed length of wire. Great for troubleshooting wire feed speed and loading wire into the system.

DeviceNet Interconnecting Feeder

Control Cables*
#242 209 005 5 ft. (1.5 m)
#242 209 010 10 ft. (3 m)
#242 209 025 25 ft. (7.6 m)
#242 209 050 50 ft. (15.2 m)
These specially designed Electrical Magnetic Interference (EMI) protected and shielded feeder control cables are required, but not included with Axcess feeders or ROI. Determine length needed and order separately.
*For additional lengths visit MillerWelds.com/equiptoweld.

Motor Control Cables*
#242 395 020 20 ft. (6.1 m)
#242 395 030 30 ft. (9 m)
#242 395 050 50 ft. (15.2 m)
Includes overmolded connections on high-flex cables for optimal service life.
*For additional lengths visit MillerWelds.com/equiptoweld.

Volt-Sense Cable*
#242 212 050 50 ft. (15.2 m)
*For additional lengths visit MillerWelds.com/equiptoweld.

Running Gear Cylinder Rack  #300 408
For Axcess 300 and 450 models. Holds two large gas cylinders and has gun cable hangers and a consumable drawer in front for easy access. A convenient handle allows the cart to be pulled easily through doorways. System components including power source and single or dual feeders can be mounted to the cart and secured.

Industrial MIG 4/O Kit  #300 390
Consists of flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/O feeder weld cable with lugs, and 15-foot (4.6 m) work cable with 600-amp C-clamp.

Spool Cover  #057 607
For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.
Note: Spool Covers cannot be installed if the wire drive assembly is in a rotated position.

Turntable Assembly  #146 236
Allows rotation of the feeder as the operator changes work positions. Reduces strain and bending on the gun cable.

Wire Reel Assembly  #108 008

Reel Cover  #195 412
For 60-pound (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.

Hanging Bail (Electrically Isolated)  #058 435
Used for suspending feeder over work area.

Coolant Systems

For more information, see the Coolmate Series literature sheet, Index No. AY/7.2.

Coolmate™ 3
#043 007  115 VAC
#043 008  230 VAC
For use with water-cooled torches rated up to 500 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ 4  #042 288  115 VAC
For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Low Conductivity Coolant  #043 810
Sold in multiples of four one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and denitized water to protect against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C).
## Semi-Automatic Equipment Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>#907 150</td>
<td>Power source only</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 150-00-1</td>
<td>Power source with Accu-Speed software upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 150-01-1</td>
<td>Power source with RMD software upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 150-02-2</td>
<td>Power source with Insight Core upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 152</td>
<td>Power source only</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 152-00-1</td>
<td>Power source with Accu-Speed software upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 152-01-1</td>
<td>Power source with RMD software upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 152-02-2</td>
<td>Power source with Insight Core upgrade</td>
<td></td>
<td></td>
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<tr>
<td>#907 154</td>
<td>Power source</td>
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<td></td>
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<tr>
<td>#907 154-00-1</td>
<td>Power source with Accu-Speed software upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#907 154-00-2</td>
<td>Power source with Insight Core upgrade</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#301 081</td>
<td>Field. Adds Insight Core capabilities to Axcess power sources</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 227</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, and Industrial MIG 4/0 kit</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 226</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit and running gear/cylinder rack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 229</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 228</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit and running gear/cylinder rack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#301 081</td>
<td>Field. Adds Insight Core capabilities to Axcess power sources</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 227</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, and Industrial MIG 4/0 kit</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 226</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit and running gear/cylinder rack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 229</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit</td>
<td></td>
<td></td>
</tr>
<tr>
<td>#951 228</td>
<td>Power source, bench feeder, Bernard™ Q-Gun™, Industrial MIG 4/0 kit and running gear/cylinder rack</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Note: Other power sources are available. Consult factory at 1-920-954-3809 for power sources with E-Stop option.

## Wire Feed Options (see page 4 and 5)

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>#951 311</td>
<td>Single-wire feeder. Order DeviceNet Interconnecting Feeder Control Cable separately</td>
</tr>
<tr>
<td>#951 431</td>
<td>Dual-wire feeder. Order DeviceNet Interconnecting Feeder Control Cable separately</td>
</tr>
<tr>
<td>#195 238</td>
<td>Single-wire model</td>
</tr>
<tr>
<td>#195 433</td>
<td>Dual-wire model</td>
</tr>
<tr>
<td>#195 239</td>
<td>Requires power source with E-Stop option — consult factory at 1-920-954-3809</td>
</tr>
<tr>
<td>#195 426</td>
<td>Left-hand wire drive assembly</td>
</tr>
<tr>
<td>#195 515</td>
<td>Right-hand wire drive assembly</td>
</tr>
<tr>
<td>#242 212 050</td>
<td>Included with drive motor. See page 7</td>
</tr>
</tbody>
</table>

## Installation Cables

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>#300 129</td>
<td>See page 5. See page 4 for connection diagram</td>
</tr>
<tr>
<td>#300 129</td>
<td>See page 5. See page 4 for connection diagram</td>
</tr>
<tr>
<td>#300 129</td>
<td>See page 5. See page 4 for connection diagram</td>
</tr>
<tr>
<td>#300 212 050</td>
<td>See page 7. See page 4 for connection diagram</td>
</tr>
</tbody>
</table>

## Optional Software-Based Welding Processes

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>#300 719</td>
<td>For Palm. Field (required Palm™ handheld is NOT included)</td>
</tr>
<tr>
<td>#300 720</td>
<td>For PC. Field (required PC-based emulator and cable are NOT included)</td>
</tr>
<tr>
<td>#195 252</td>
<td>For Palm. Field (required Palm™ handheld is NOT included)</td>
</tr>
<tr>
<td>#300 721</td>
<td>For PC. Field (required PC-based emulator and cable are NOT included)</td>
</tr>
</tbody>
</table>

## Services and Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>#195 480</td>
<td>One day minimum, not subject to discount. See page 7</td>
</tr>
<tr>
<td>#300 529</td>
<td>For PC. Field management software (PC-based emulator is included)</td>
</tr>
<tr>
<td>Consult factory</td>
<td>For PC. File management software with wave shaping (PC-based emulator is included)</td>
</tr>
</tbody>
</table>

## Accessories

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>#300 408</td>
<td>For 300 and 450 models only. Holds two cylinders, cooler, machine and feeder</td>
</tr>
<tr>
<td>#300 390</td>
<td>Includes flowmeter regulator with 10-ft. (3 m) gas hose, 10-ft. (3 m) 4/0 feeder weld cable with lugs, and 15-ft. (4.6 m) work cable with 600-amp C-clamp</td>
</tr>
<tr>
<td>#195 369</td>
<td>Allows mounting of AA-40GB motor when using ROI option</td>
</tr>
<tr>
<td>#092 989</td>
<td>Additional Feeder Accessories See page 7</td>
</tr>
<tr>
<td>#072 094</td>
<td>Coolant Systems</td>
</tr>
</tbody>
</table>

## Date: Total Quoted Price

Distributed by: Miller Electric Mfg. Co.