



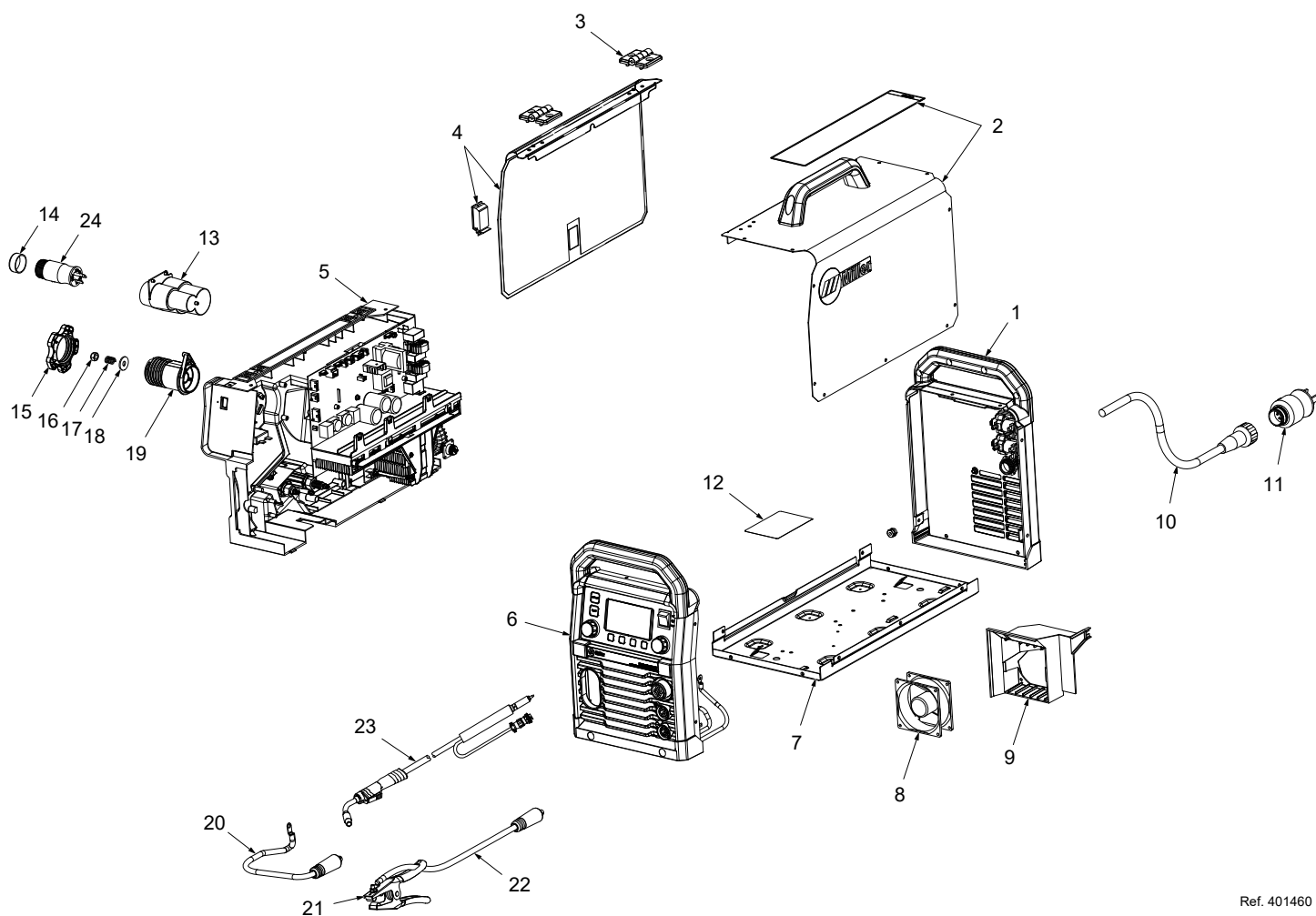
PM- 298868 A

Multimatic 215 PRO

Effective with Serial Number
NF431322N - ZZ222222R



PARTS MANUAL



Ref. 401460

Main Assembly

Main Assembly

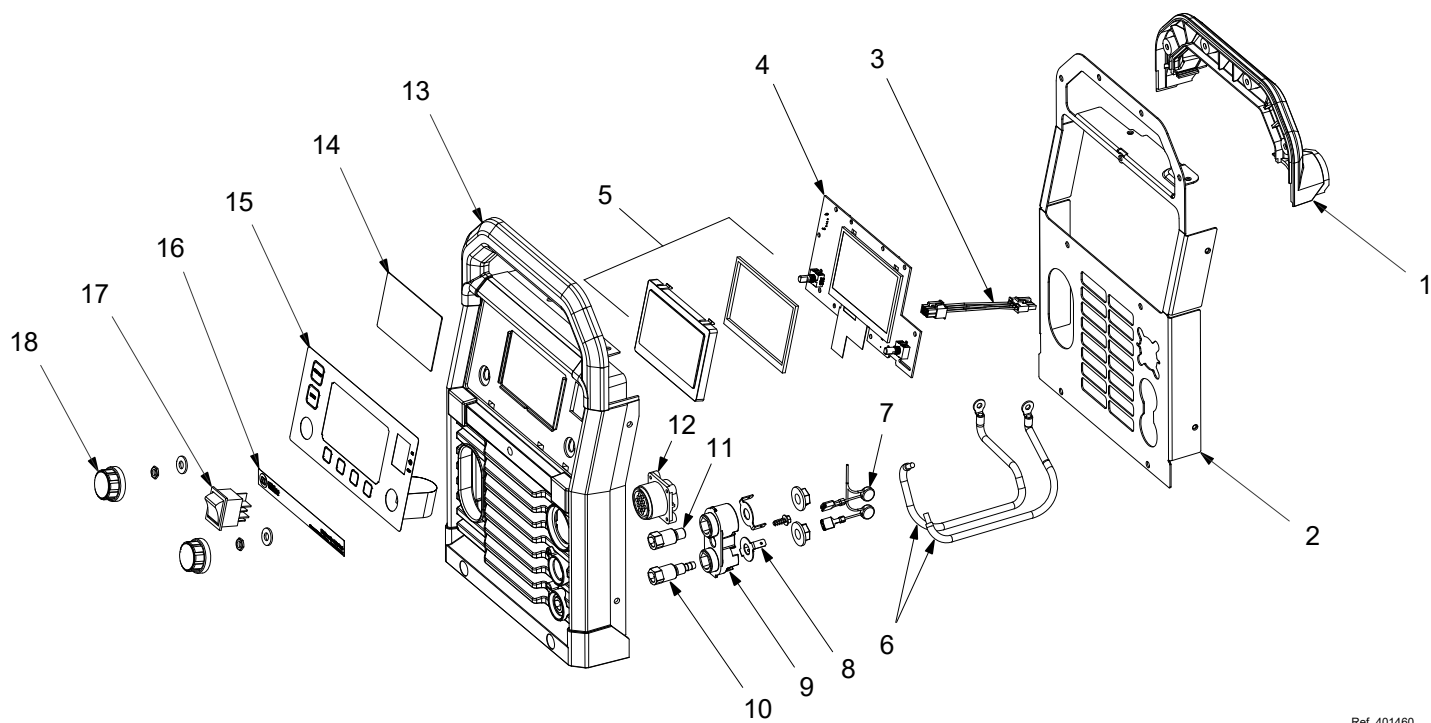
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1			Rear Panel Assembly (See following for subassembly information)	1
2		402060	↓ Kit, Wrapper w/Labels and Handle Multimatic 215 Pro	1
/			→ Wrapper	1
/		109844	→ Label, Miller 6.000 x 2.500 Horizontal	1
/		294219	→ Label, Side Multimatic 215	1
/		291550	→ Lbl, Warning Gnrl Precautionary (En/Sp/Fr)	1
/		292307	→ Handle Assy, Center	1
3		291606	↓ Kit, Hinges	1
/		286917	→ Hinge, Plastic	2
/		128237	→ Screw, 010-32 x .50 Hexwhd 40D Stl Pld Slffmg Tap-Rw	4
4		402061	↓ Kit, Door Access 215 Pro	1
/			→ Door, Access	1
/		109844	→ Label, Miller 6.000 x 2.500 Horizontal	1
/		294219	→ Label, Side Multimatic 215	1
/		204711	→ Latch, Slide Flush Snap Lock	1
/		400908	→ Label, Parameter/Consumable/Polarity MUM215 Pro	1
5			Baffle Assembly (See following for subassembly information)	1
6			Front Panel Assembly (See following for subassembly information)	1
7		289103	Base	1
8	FM	296928	Fan, Muffin 24 Vdc 92 x 38mm 5400 Rpm	1
9		289689	Bracket, Fan	1
10		220916	Cable, Power 10 Ft 14Ga 3C Soow w/Spl Plug	1
11		219258	Adapter, Power Cable 6-50P (230V/50A)	1
12		293351	Label, Warning Electric Shock And Pinch (En/Fr/Sp)	1
13		291393	Holder, Adapter Mvp	1
14		295779	Plug, Protective Vinyl Dipped Rnd 1.188 Id x .5H	1
15		280091	Nut, Hub	1
16		204608	Nut, 312-18 .50Hex .34H Stl Pld Elastic Stop Nut	1
17		225257	Spring, Cprsn .467 Od x .060 Wire x .700 Pld	1
18		203072	Washer, Flat .331 Id x 0.945 Od x .079T Stl Pld	1
19		265004	Hub, Spool	1
20		272921	Lead Assy, Drive Polarity	1
21		297399	Clamp, Work 200 Amp	1
22		295522	Work Cable w/25mm Dinse 6AWG-15Ft	1
23		1770029	MDX 100, 15 Ft	1
/		298761	AF-2 Holder, Electrode 200A-1 (Not Shown)	1
/		297655	Electrode Holder Cable w/25mm Dinse 6Awg-15Ft-1 (Not Shown)	1
/		WP1712RDI25	Tig Torch, A-150 12.5 Ft (Not Shown)	1
/		219259	Adapter, Power Cable 5-20P (115V/20A) (Not Shown)	1
24		219261	Adapter, Power Cable 5-15P (115V/15A)	1

*Recommended Spare Parts ~ Optional ↓ Item includes other parts. → Item is part of a subassembly.

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

Hardware is common and not available unless listed.

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Front Panel Assembly

Front Panel Assembly

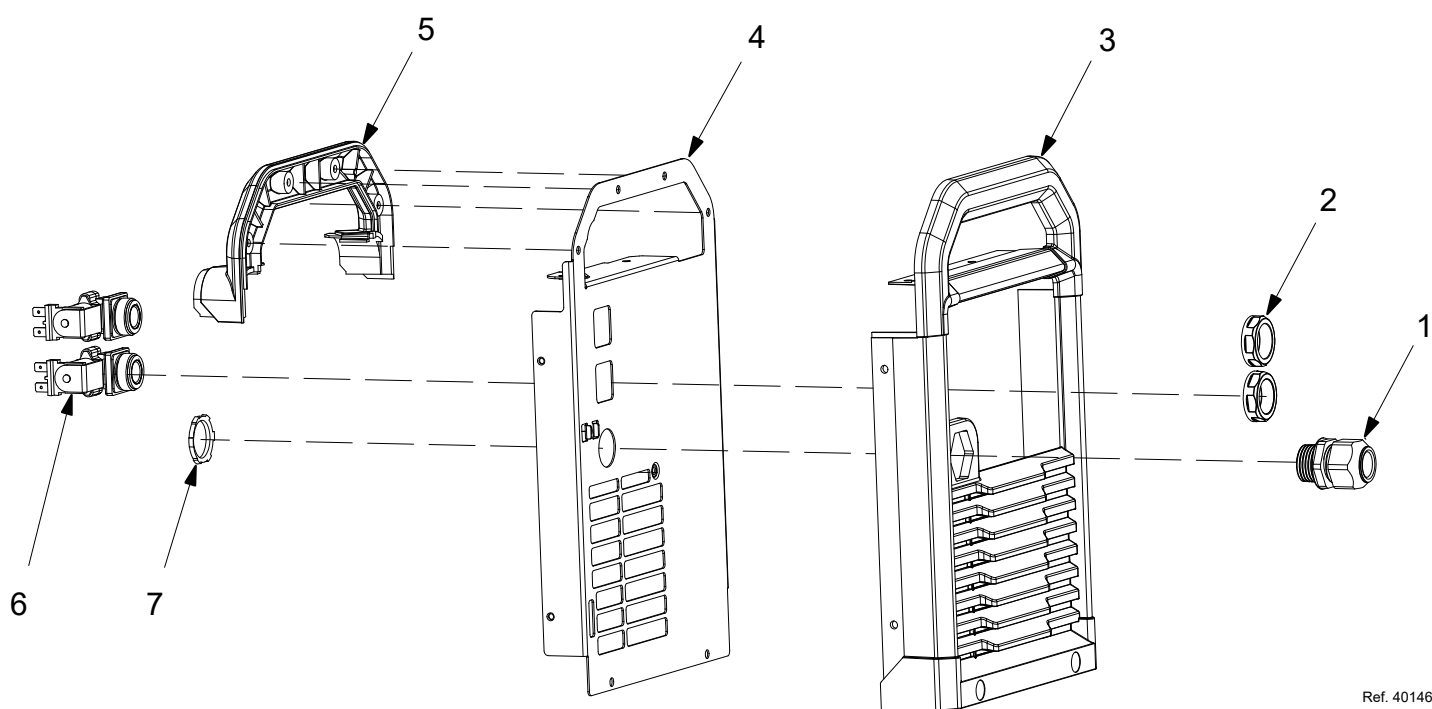
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		289170	Bezel, Handle Cover	1
2		289104	Panel, Front	1
3		296677	Harness, UI Wrg Unit Small Frame	1
4	PC2	400118	Kit, Millermatic 211 & 215 Pro UI Board	1
5		401813	Lens, Front Panel w/Gasket	1
6		272917	Lead List, Large (+/- Output)	2
7		296511	Capacitor, w/Lead	1
8		296456	Connector, Faston 1/4 Ring w/90 Deg Bend .406 Id	2
9		295464	Insulator, Bulkhead 25mm Double	1
10		272412	Rcpt, Tw Lk Brass Power/Gas Female w/Ring	1
11		272413	Rcpt, Tw Lk Brass Power Female	1
12		281402	Lead Assy, Process Control 14 Pin	1
13		289638	Bezel, Front 215	1
14		296643	Lens Cover, Replaceable 211/215 Pro	1
15		296003	Membrane, Switch Control 211/215 Pro	1
16		295461	Label, Beltline Nameplate Multimatic 215	1
17	S1	274191	Switch, Rocker Dpst 20A 250Vac On-Off Balk Panel Mtg	1
18		292399	Knob, 1.250 Dia x 6mm Id Push on w/Spring/Print	2

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Rear Panel Assembly

Rear Panel Assembly

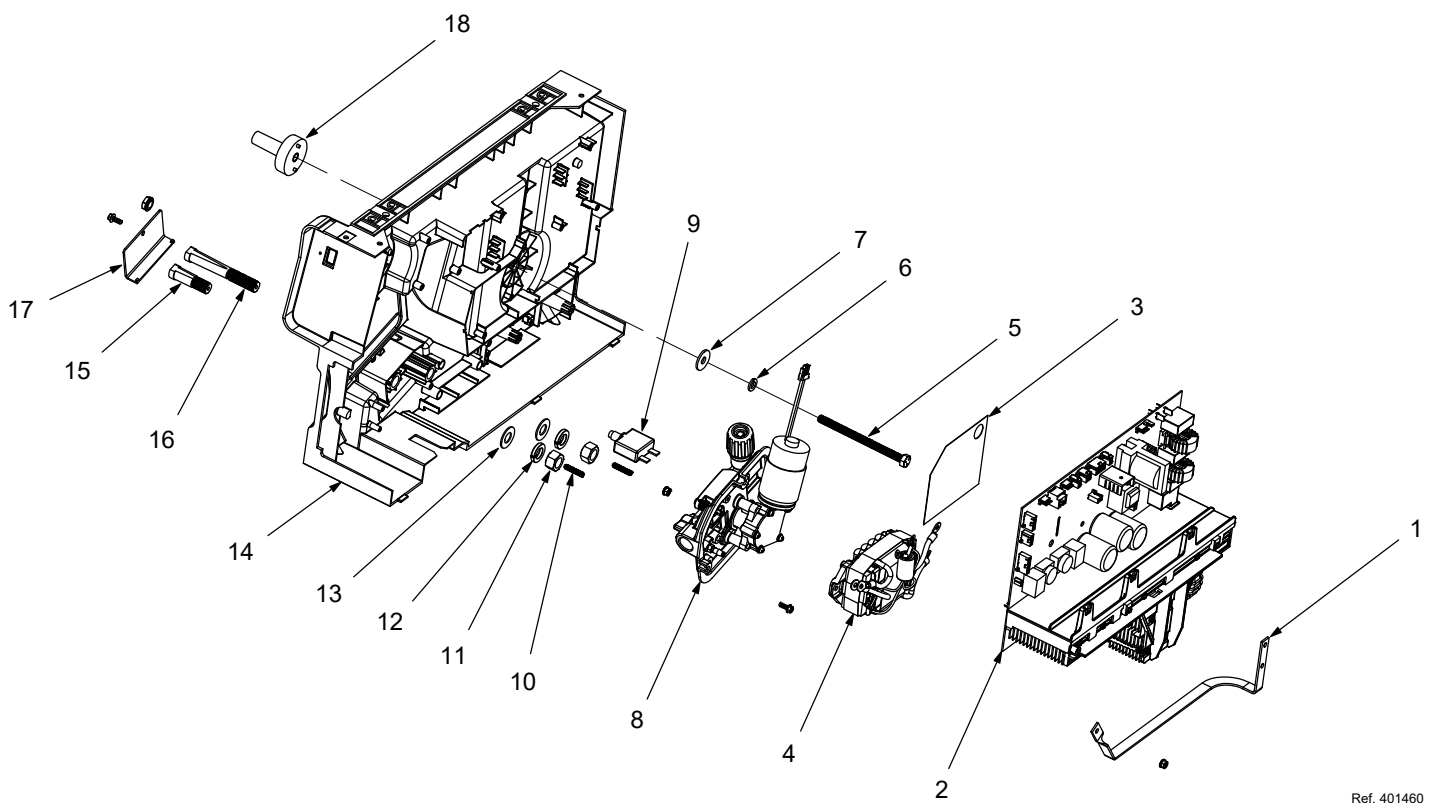
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		269219	Bushing, Strain Relief .435/.705 Id x 1.040 Mtg Hole	1
2		272186	Nut, .750-14 Nps 1.312Hex .413H Nyl	2
3		289169	Bezel, Rear	1
4		292073	Panel, Rear Sims 215	1
5		289170	Bezel, Handle Cover	1
6	GS1	296804	Valve, 24 Vdc 2 Way Port 1/8 Orf w/Pressure Switch	2
7		198245	Nut, Conduit .750 Npt Pld 1.388 Od x .150 Thk	1

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Baffle Assembly

Baffle Assembly

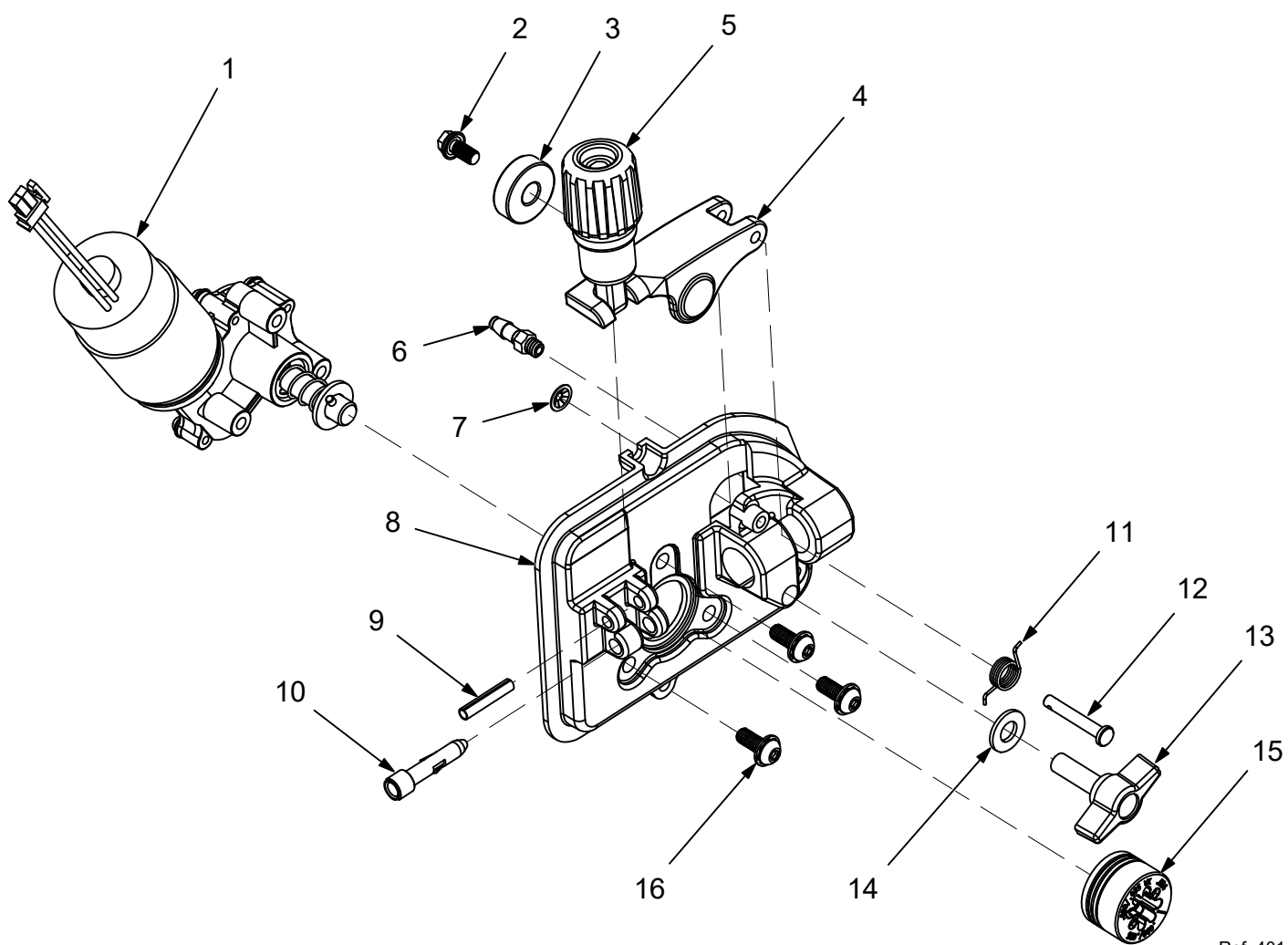
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		289159	Bus Bar, Output	1
2	PC1	400237	Circuit Card Assy, Control MUM215Pro w/Program	1
3		291616	Insulator, Mylar .014 x 3.5 x 4.0	1
4	T1	292340	Transformer, 120-240V Small Frame	1
5		261463	Screw, .312-18 x 4.50 Hex Hd-pln Stl Gr5 Pld Full	1
6		602211	Washer, Lock .318 Id x 0.586 Od x .078T Stl Pld Split .312	1
7		203072	Washer, Flat .331 Id x 0.945 Od x .079T Stl Pld	1
8		Drive Assembly (See following for subassembly information)		1
9	CB1	093997	Supplementary Protector, Man Reset 1p 30A 250 Vac	1
10		293439	Screw, Set 5mm x 25mm Alloy Steel Blk	2
11		601879	Nut, .500-12 .75 Hex .44H Stl Pld	2
12		602216	Washer, Lock .502 Id x 0.879 Od x .151T Stl Pld Split .500	2
13		292298	Washer, Flat .12mm Id x 24mm Od x 2.5T Stl Pld Zinc	2
14		289108	Center Baffle Plastic	1
15		289142	Stud, Brs Output Male Positive	1
16		289141	Stud, Brs Output Male Negative	1
17		289868	Cover, Output Studs	1
18		202726	Adapter, Spool Hub	1

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Drive Assembly

Drive Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Qty
1	M1	290571	Motor, Gear 24 Vdc w/Leads Dbl Needle Bearing	1
2		188846	Screw, 10-32 x .50 Hex Hd-Slt Zinc Sqcone Sems	1
3		189915	Bearing, Ball Rdl Sgl Row 9mm x 26mm x 8mm Wide Sh	1
4		290573	Lever Pressure Roll Machined Sims	1
5		221980	Knob, Tension Adjust Assy	1
6		263411	Fitting, Barbed Gas	1
7		604393	Nut, .187-00 Speed Design 2 Style	1
8		289151	Housing, Drive (Machined)	1
9		010224	Pin, Spring CS .187 x 1.000	1
10		261151	Guide, Wire Inlet 060	1
11		264715	Spring, Torsion	1
12		293437	Pin, Clevis .1875 Od x 1.25 L Zinc Pld	1
13		222035	Knob, T 1562 Bar w/312-18 Stud 1000 Lg Plstc	1
14		604538	Washer, Flat .344 Id x 0.688 Od x .065T Stl Pld Ansi .312	1
15		261157	Roll, Drive V Groove 024, .030-.035V Wire, .035VK Wire	1
16		282239	Screw, M6-1 x 16 Button Hd-Soc Stl Pld Zc Sq Cn Sems	3

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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	

Optional Drive Rolls