



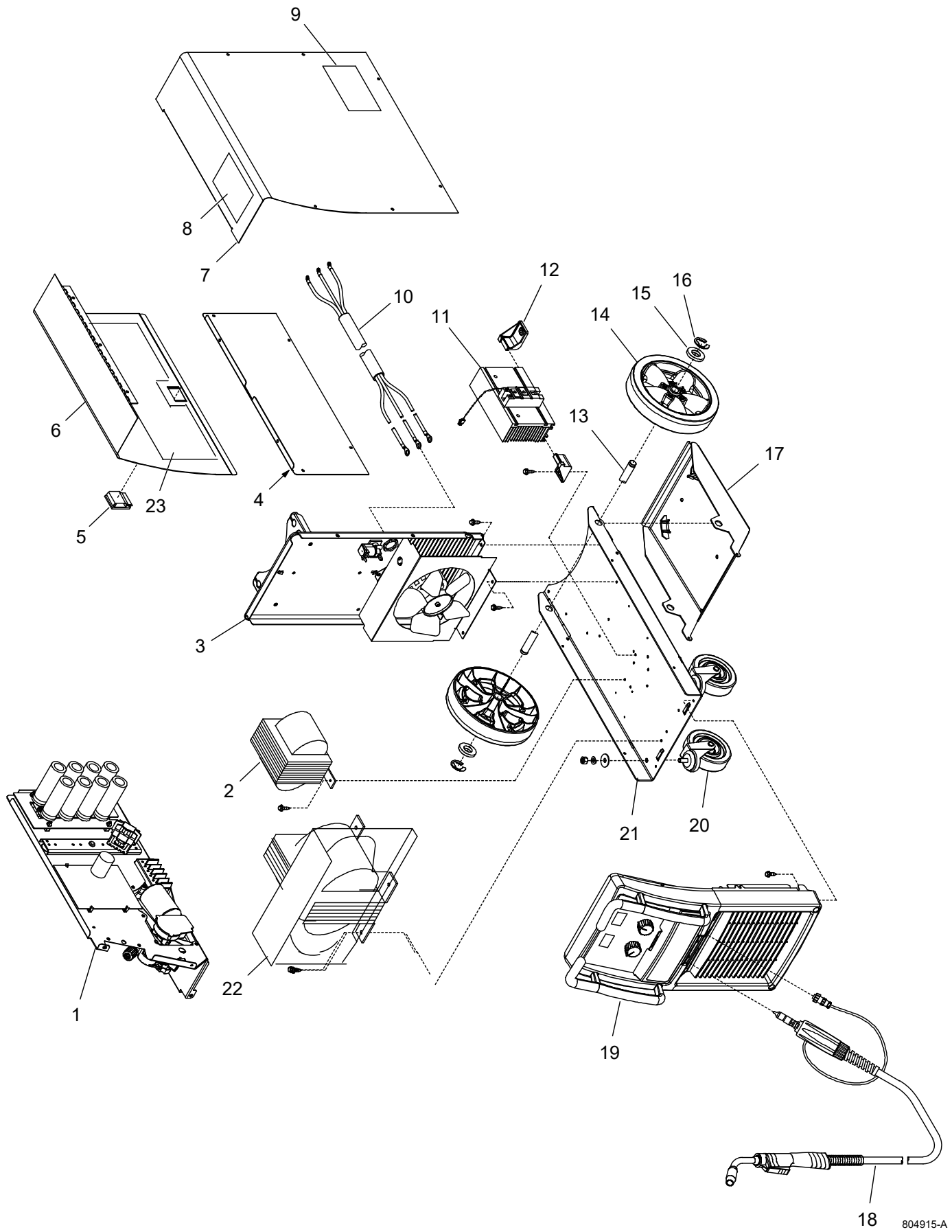
PM- 230694 D

Millermatic 252

Effective with Serial Number
LG290851B - ZZ222222



PARTS MANUAL



804915-A

Main Assembly

Main Assembly

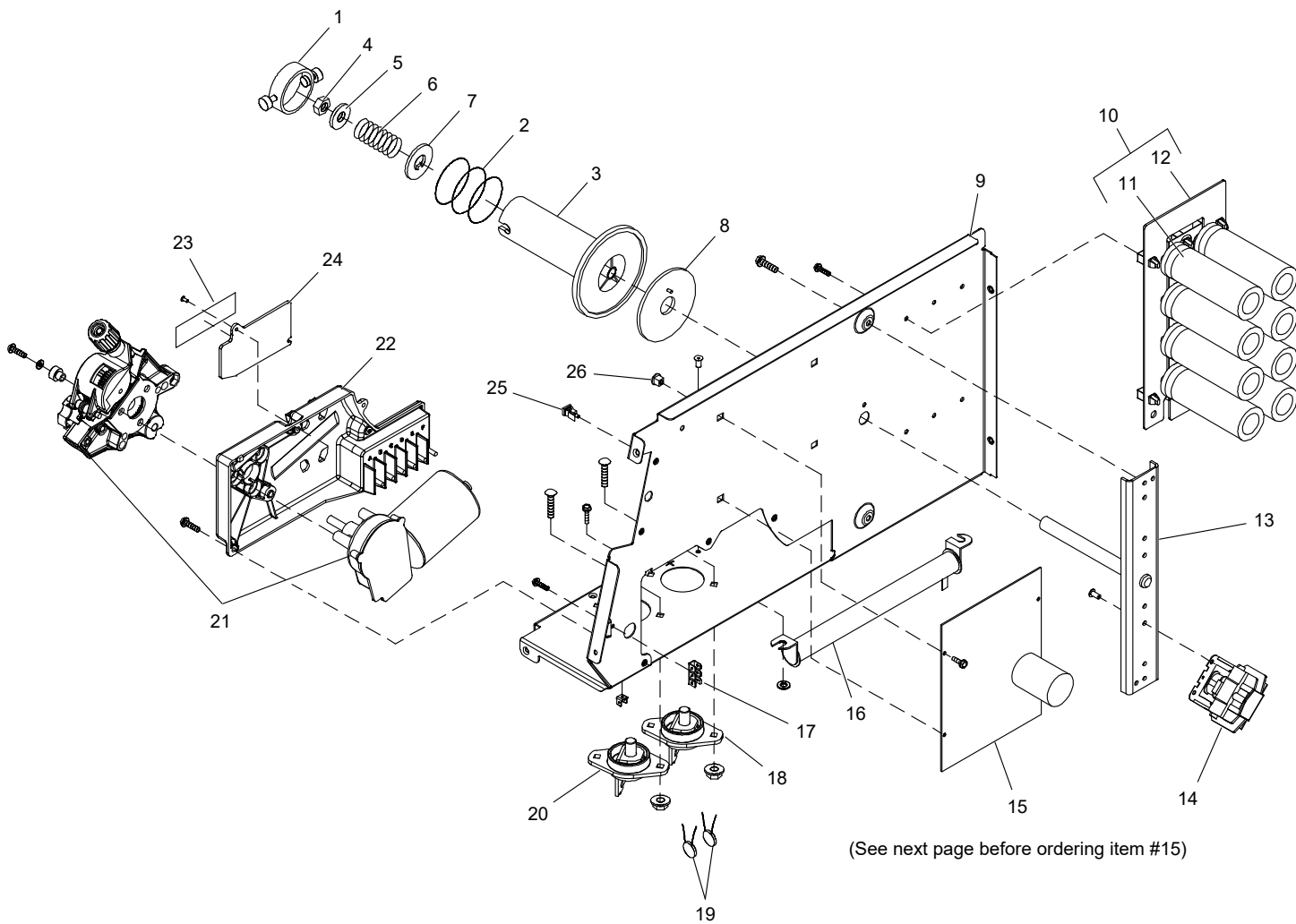
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1			Baffle, Center w/Components	1
2	Z1	231536	Stabilizer	1
3			Panel, Rear w/Components	1
4		229621	Panel, Side Lh Lower	1
5		230363	Latch, Slide Flush Mtg Hole 1.750 Wide x 1.500 Lg	1
6		229620	Door, Hinged	1
7		+ 229619	Wrapper	1
8		231983	Label, Warning General Precautionary (En/Sp)	1
9		275317	Label, Warning Electric Shock/Incorr Input (En/Fr/Sp)	1
10		269479	Cord Set, 250V 6-50P 8-10Ga 3/C 12ft st JKT (200/230V Models)	1
10		+ 269477	Cord Set, 250V T tng 8-10Ga 3/C 12ft st JKT (230/460/575V Models)	1
/		231988	Label, Warning Electric Shock Power Cord (En/Sp)	1
11		232262	↓ Rectifier Assy, SCR Main	1
12		205946	→ Foot, Mtg Rectifier	2
/		232260	→ ↓ Rectifier, SCR Main	1
/	PLG5	115094	→ → Housing Plug + Skts, (Service Kit)	1
/	SR1	197698	→ → Thyristor, SCR Module 300A 400V Common Anode	1
/		232261	→ → Heat Sink, Rectifier	1
/	C3,4	219460	→ → Capacitor, Cer Disc .01 uf 1000 Vdc w/Terms	2
/	RT1	173632	→ → Thermistor, Ntc 30K Ohm @ 25 Deg C 12.00 in Lead	1
13		230798	Axle, Running Gear .750 Dia x 18.000	1
14		230799	Wheel, Polypropylene 10 In x 2.25 Wide	2
15		602250	Washer, Flat .812 Id x 1.469 Od x .134T Stl Pld Ansi .750	2
16		121614	Ring, Rtnng Ext .750 Shaft x .085 Thk E Style Pld	2
17		229625	Tray, Cylinder Low	1
18		169598	M-25 Gun 15 FT .030-.035 Wire (See Gun Owner's Manual) → MK040035N	1
18		1770033	MDX-250 Gun, 15 ft 250A .030-.035 w/Acculock (See Gun Owner's Manual) MK040036N →	1
19			Panel, Front w/Components	1
20		235875	Caster, Swvl 4.00 In Polyolefin	2
21		229624	Base	1
22		296641	Kit, Xfmr Mm (252 200/230V Models)	1
22		296642	Kit, Xfmr Mm (252 230/460/575V Models)	1
23		293941	Label, Welding Guide Millermatic 252 ND390372N - ZZ222222	1
/		248426	Blank, Snap-In	2
/	PLG8	096530	Conn, Rect Comm 093 4P/S 1row Rcpt Cable Molex LKG	1
/		234263	Regulator/Flowgauge, 0-50 Cfh Argon/Co2/Mix w/Filler	1
/		233473	↓ Cable, Work 10 ft No 3 w/Clamp & Boot	1
/		233452	→ Clamp, Work 300 Amp	1
/		600318	→ Cable, Weld Cop Strd No 3 EPDM JKT (order by ft)	1
/		196318	→ Cover, Cable Btry Post Blk .75 Id	1
/		144108	Hose, Gas 5 ft (for use with regulator 212492)	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.

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.



Baffle, Center with Components Prior to MK230040N

Baffle, Center with Components Prior to MK230040N

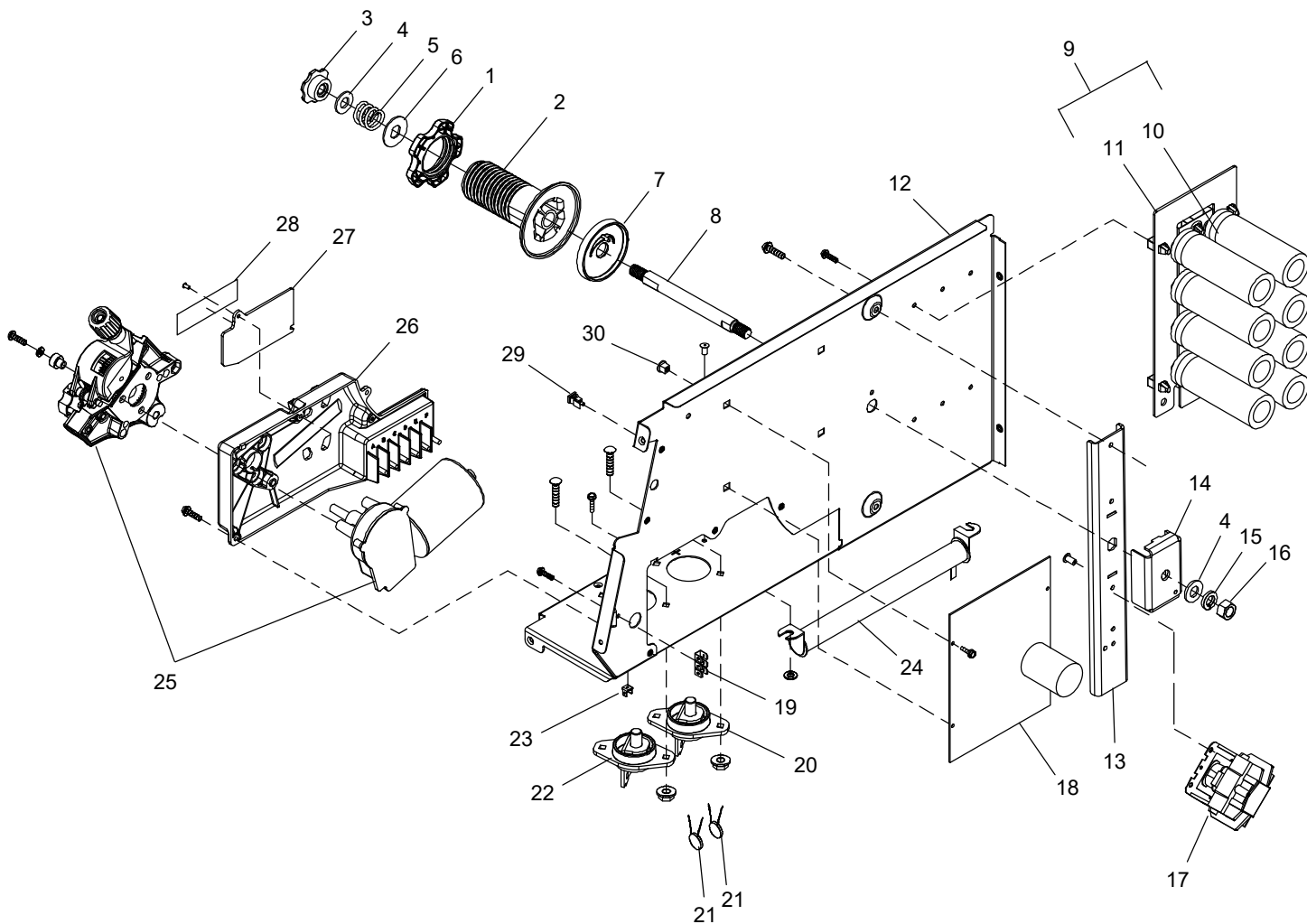
Item No.	Dia. Mkgs.	Part No.	Description	Qty
/		196001	↓ Spool Hub Assembly	1
1		058427	→ Ring, Retaining Spool	1
2		057745	→ Spring, Cprsn 2.305 Od x .090 Wire x 2.500 Pld	1
3		186435	→ Hub, Spool	1
4		085980	Nut, Stl Hex Full .625-11	1
5		605941	Washer, Flat Stl .640 Id x 1.000 Od x 14GA Thk	1
6		186437	Spring, Cprsn .845 Od x .110 Wire x 1.500	1
7		057971	Washer, Flat Stl Keyed 1.500 Dia x .125Thk	1
8		186436	Washer, Brake Plastic	1
9		229623	Baffle, Center	1
/		231985	Label, Warning Electric Shock	1
/		226658	Label, Polarity/Drive Rolls	1
/		153980	Label, Link Arr Pri V (200/230V Models)	1
/		144916	Label, Link Arr Pri V (230/460/575V Models)	1
10		185644	Capacitor Assy	1
11	C5	184584	Capacitor, Elctlt 15000 uf 45 Vdc Can 1.395	8
/		083147	Grommet, Scr No 8/10 Panel Hole .312 Sq .500 High	6
12		229801	Kit, Capacitor Buss Bar & Insulator	1
13		177307	Reel Support	LG290851B - LH420483B 1
13		235827	Reel Support	LH420484B - ZZ222222N 1
14	W	252908	Contact, Def Prp 25A 1P 36 Vdc Coil	1
15	PC1	298427	Kit, Field MM252 Through Hole Cntl Bd	(For Models Prior to Serial No. MK230040N) 1
/	PLG1	115094	Housing Plug + Skts, (Service Kit)	1
/	PLG5	130203	Housing Plug+Pins (Service Kit)	1
/	PLG3	115092	Housing Plug+Pins (Service Kit)	1
/	PLG6	115093	Housing Plug+Pins (Service Kit)	1
/	PLG7	202592	Housing Plug+Skts (Service Kit)	1
/	PLG8	201665	Housing Plug + Skts (Service Kit)	1
16	R1	119998	Resistor, WW Fxd 300W 5 Ohm	1
17		129524	Term, Frict .250 x .032 Uninsul Male .130 Stud Mtg 3pr	1
18	POS	097421	Terminal, Pwr Output Red	1
19	C1, C2	128750	Capacitor, Cer Disc .1 uF 500 Vdc w/Terms	2
20	NEG	097416	Terminal, Pwr Output Black	1
/		230687	↓ Drive Assy, Wire w/Pri Link 3V	1
/		230362	↓ Drive Assy, Wire w/Pri Link 2V	1
21			Wire Drive And Gears	1
22		229630	→ JHousing, Drive Assy/Pri Term Link 2 Voltage	1
22		229631	→ JHousing, Drive Assy/Pri Term Link 3 Voltage	1
23		231987	→ Label, Warning High Voltage (En/Sp)	1
24		229634	→ Door, Access Changeover	1
25		134201	Stand-Off Support, Pc Card No. 6 Screw	3
26		228165	Grommet, Scr No8	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.

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.



Baffle, Center with Components Eff with MK230040N

Baffle, Center with Components Eff with MK230040N

Item No.	Dia. Mkgs.	Part No.	Description	Qty
/		283969	↓ Kit, Spool Hub	1
1		280091	→ Nut, Hub	1
2		279587	→ Hub, Spool 12 Inch	1
3		279504	Knob, Tensioner 1/2-13 Thread	1
4		602247	Washer, Flat .531 Id x 1.062 Od x 0.95T Stl Pld Ansi .500	2
5		172918	Spring	1
6		231211	Washer, Anti-Turn	1
7		287119	Washer, Brake Plastic	1
8		271415	Shaft, Support Spool	1
9		185644	Capacitor Assy	1
10	C5	184584	Capacitor, Elctlt 15000 uf 45 Vdc Can 1.395	8
11		229801	Kit, Capacitor Buss Bar & Insulator	1
12		229623	Baffle, Center	1
/		231985	Label, Warning Electric Shock	1
/		226658	Label, Polarity/Drive Rolls	1
/		153980	Label, Link Arr Pri V (200/230V Models)	1
/		144916	Label, Link Arr Pri V (230/460/575V Models)	1
13		274304	Channel, Support Spool Hub	1
14		274305	Brace, Support Spool Shaft	1
15		602216	Washer, Lock .502 Id x 0.879 Od x .151T Stl Pld Split .500	1
16		601879	Nut, .500-12 .75 Hex .44H Stl Pld	1
17		252908	Contactactor, Def Prp 25A 1P 36 Vdc Coil	1
18	PC1	298427	Kit, Field MM252 Through Hole Cntl Bd (208/230V Models)	
			LG290851B - MK290195N	1
18	PC1	298427	Kit, Field MM252 Through Hole Cntl Bd (230/460/575V Models)	
			LG290851B - NA360094N	1
18	PC1	298428	Kit, Field MM252 Surface Mount Cntl Bd (208/230V Models)	
			MK290196N - ZZ222222N	1
18	PC1	280223	Circuit Card Assy, Control (230/460/575V Models)	
			NA360095N - ZZ222222N	1
/	PLG1	115094	Housing Plug + Skts, (Service Kit)	1
/	PLG5	130203	Housing Plug+Pins (Service Kit)	1
/	PLG3	115092	Housing Plug+Pins (Service Kit)	1
/	PLG6	115093	Housing Plug+Pins (Service Kit)	1
/	PLG7	202592	Housing Plug+Skts (Service Kit)	1
/	PLG8	201665	Housing Plug + Skts (Service Kit)	1
19		129524	Term, Frict .250 x .032 Uninsul Male .130 Stud Mtg 3pr	1
20	POS	097421	Terminal, Pwr Output Red	1
21	C1, C2	128750	Capacitor, Cer Disc .1 uF 500 Vdc w/Terms	2
22	NEG	097416	Terminal, Pwr Output Black	1
23		600760	Term, Frict .250 x .032 Uninsul Male .130 Stud Mtg 1pr	1
24	R1	119998	Resistor, WW Fxd 300W 5 Ohm	1
/		252663	↓ Drive Assy, Wire w/Pri Link 3V	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.

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.

Baffle, Center with Components Eff with MK230040N

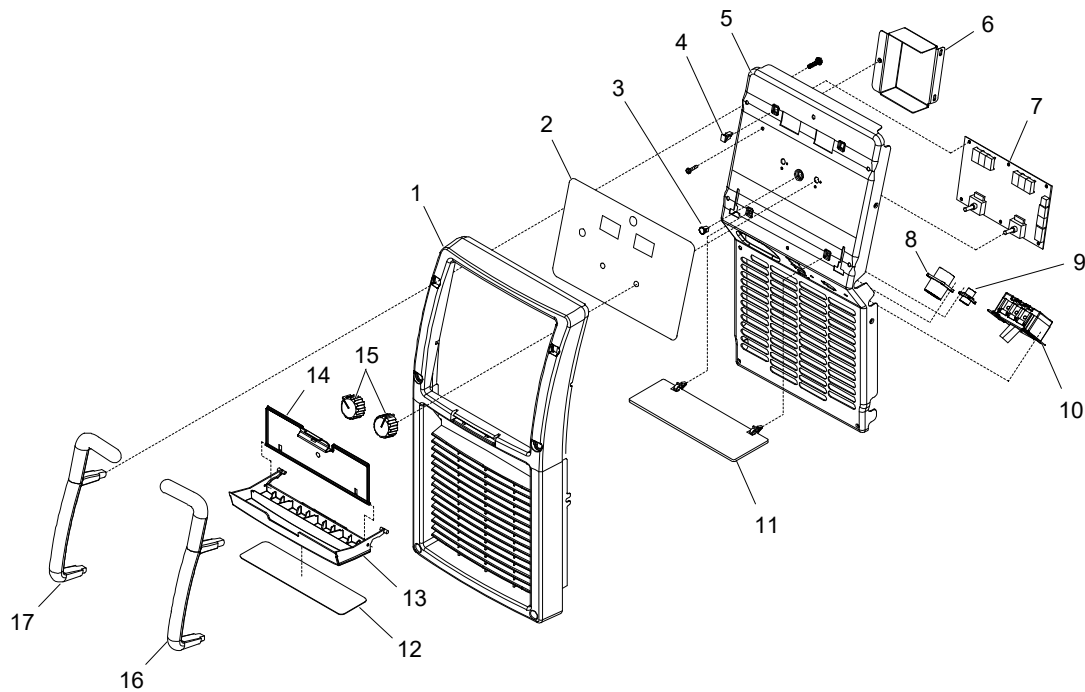
Item No.	Dia. Mkgs.	Part No.	Description	Qty
/		252662	↓ Drive Assy, Wire w/Pri Link 2V	1
25			Wire Drive And Gears	1
26		229630	→ ↓ Housing, Drive Assy/Pri Term Link 2 Voltage	1
26		229631	→ ↓ Housing, Drive Assy/Pri Term Link 3 Voltage	1
27		229634	→ → Door, Access Changeover	1
28		231987	→ → Label, Warning High Voltage (En/Sp)	1
29		134201	Stand-Off Support, Pc Card No. 6 Screw	3
30		228165	Grommet, Scr No8	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.

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.



Panel, Front with Components

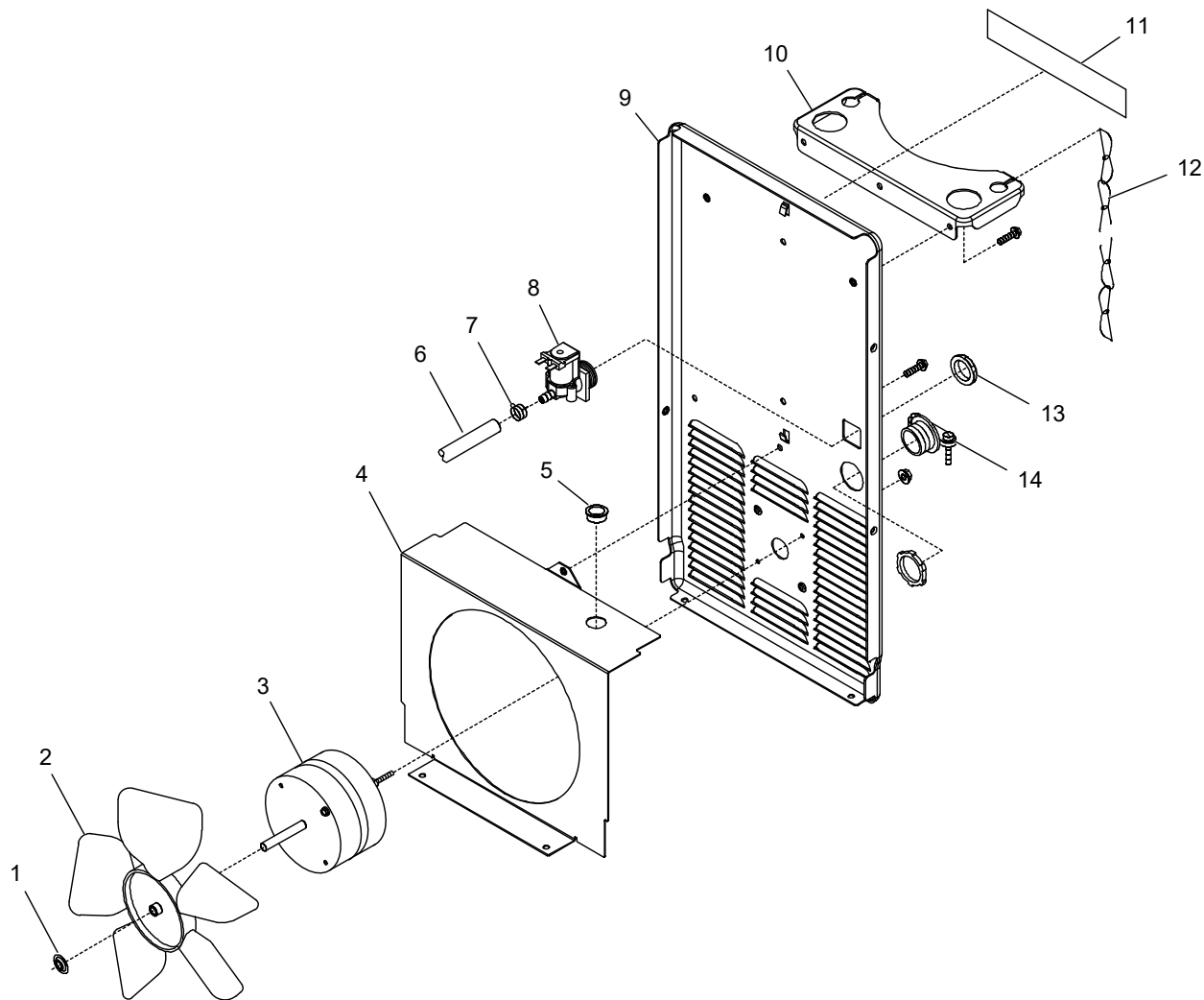
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		230304	Bezel, Front w/Consumable Tray	1
/		226660	Label, Power/Mig Gun/Spoolgun MM252	1
2		226647	Label, Controls Millermatic 252	1
3		228165	Grommet, Scr No8	1
4		134201	Stand-Off Support, Pc Card No. 6 Screw	2
5		225276	Panel, Front 252	1
6		238079	Enclosure, PC Board	1
7	PC2	273092	Circuit Card Assy, User IFC w/Program MM252 (R)	1
/	PLG12	131055	Housing Rcpt+Skts, (Service Kit)	1
/	PLG13	201665	Housing Plug + Skts (Service Kit)	1
/	PLG14	131204	Housing Plug + Skts, (Service Kit)	1
8	RC2	189238	Conn, Circ Ms/Cpc 10skt Size 18 Rcpt Panel Pushin	1
9	RC1	048282	Rcpt, w/Sockets (Service Kit)	1
10	S1	246667	Switch, Tgl Dpst 40A 600 Vac Scr Term Wide Tgl	1
10	S1	124511	Switch, Tgl Dpst 40A 600 Vac Scr Term	MA350615N - ZZ222222U 1
11		226650	Flip Chart, Millermatic 252 Para/Hlp/Timer	1
/		230365	Clip, Snap In .250 Id x .250 Mt Hole x .030 -.125 Pnl	2
12		226659	Label, Nameplate Millermatic 252	1
13		229617	Tray, Consumables	1
14		229618	Cover, Tray Consumables	1
/		284714	Label, Consumables MDX	1
15		218764	Knob, Pointer 1.625 Dia	2
16		231553	Handle, Rh	1
17		231554	Handle, Lh	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.

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.



Panel, Rear with Components

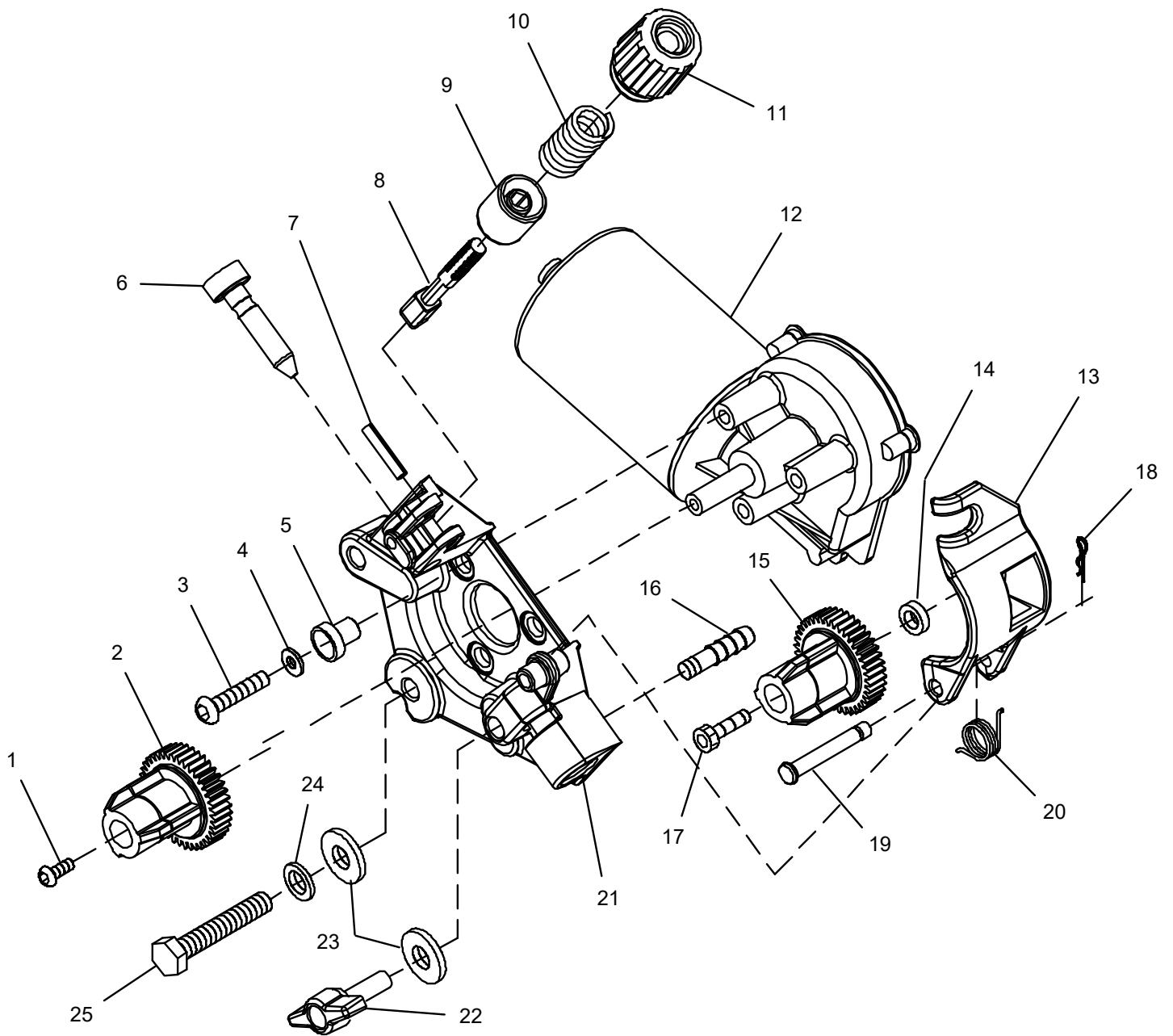
Item No.	Dia. Mkgs.	Part No.	Description	Qty
1		049399	Nut, .312-18 Push On .63d .07H Stl	1
2		148809	Blade, Fan 9.000 5Wg 34 Deg .312 Bore Ccw Plstc	1
3	FM	188706	Motor, Fan 230V 50/60Hz 1550 RPM .312 Dia Shaft	1
4		225669	Windtunnel	1
5		010493	Bushing, Snap-In Nyl .625 Id x .875 Mtg Hole	1
6		146524	Hose, SAE .187 Id x .410 Od x 27.000	1
7		149332	Clamp, Hose .405 - .485 Clip Dia Slftng Olive Dra	2
8	GS1	228035	Valve, 34Vdc 1way .750-14 Thd 2mm Orf 100Psi	1
9		225282	Panel, Rear 252	1
10		+ 229628	Bracket, Support Cylinder	1
11		231986	Label, Warning Cyl May Explode If Damaged (En/Sp)	1
12		188441	Chain, Weldless 2/0 X Bright Zinc Pld	1
13		272186	Nut, .750-14 Nps 1.312Hex .413H Nyl	1
14		604102	Conn, Clamp Cable 1000	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.

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.



Wire Drive and Gears

Wire Drive and Gears

Item No.	Dia. Mkgs.	Part No.	Description	Qty
/		203526	Drive Roll	2
/		221976	Knob, Tension Adjust Assy	1
/		230801	Spring, Torsion	1
1		174609	Screw, M 4- .7 x 12 Cheese Hd Blk Din 84	1
2		173619	Carrier, Drive Roll w/Components 24 Pitch 10mm Shaft	1
3		174610	Screw, M 6-1.0 x 20 Soc Hd Button Cap Blk	3
4		192029	Washer, Flat .250 Id x 0.437 Od x .015T Stl Pln	3
5		173620	Bushing, Motor Mtg	3
6		221912	Guide, Wire Inlet Nylon .023 - .052	1
7		010224	Pin, Spring CS .187 x 1.000	1
8		225718	Fastener, Pinned	1
9		196896	Cup, Spring	1
10		196897	Spring, Cprsn .695 Od x .095 Wire x 1.500	1
11		196895	Knob, Tension	1
12	M	225341	Motor, Gear 24 Vdc 150Rpm 24:1 Ratio MB030480N - MB200506N	1
12	M	225341	Motor, Gear 24 Vdc 150Rpm 24:1 Ratio LG290851B - MB030069N	1
12	M	249883	Motor, Gear 24 Vdc 150 Rpm (24:1 Ratio) MB030070N - MB030479N	1
12	M	249883	Motor, Gear 24 Vdc 150 Rpm (37:5 Ratio) MB200507N - ZZ222222N	1
13		230691	Lever, Mtg Pressure Gear	1
14		166072	Spacer, Gear	1
15		172075	Carrier, Drive Roll w/Components 24 Pitch	1
16		263411	Fitting, Barbed Gas	1
17		602009	Screw, .250-20 x 1.25 Soc Hd-Hex Gr8 Pln	1
18		151828	Pin, Cotter Hair .042 x .750	1
19		273112	Pin, Clevis .250 Od x 1.751 Lg w/Groove and Cham	1
20		230801	Spring, Torsion	1
21		230689	Housing, Adapter Drive Motor	1
22		222035	Knob, T 1562 Bar w/312-18 Stud 1000 Lg Plstc	1
23		604538	Washer, Flat .344 Id x 0.688 Od x .065T Stl Pld Ansi .312	3
24		602211	Washer, Lock .318 Id x 0.586 Od x .078T Stl Pld Split .312	2
25		604534	Screw, 312-18 x 1.25 Hex Hd-Pln Gr5 Pld	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.

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.

Wire Diameter			Kit No.	Drive Roll		Inlet Wire Guide
Fraction	Decimal	Metric		Part No.	Type	
.023/.025 in.	.023/.025 in.	0.6 mm	087 131	087 130	V-Grooved	056 192
.030/.035 in.	.030/.035 in.	0.8/0.9 mm	204 579	203 526	V-Grooved	056 192
.030 in.	.030 in.	0.8 mm	079 594	053 695	V-Grooved	056 192
.035 in.	.035 in.	0.9 mm	079 595	053 700	V-Grooved	056 192
.045 in.	.045 in.	1.2 mm	079 596	053 697	V-Grooved	056 193