



OM-231313R

2017-02

**Processes**



TIG (GTAW) Welding



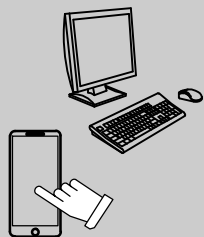
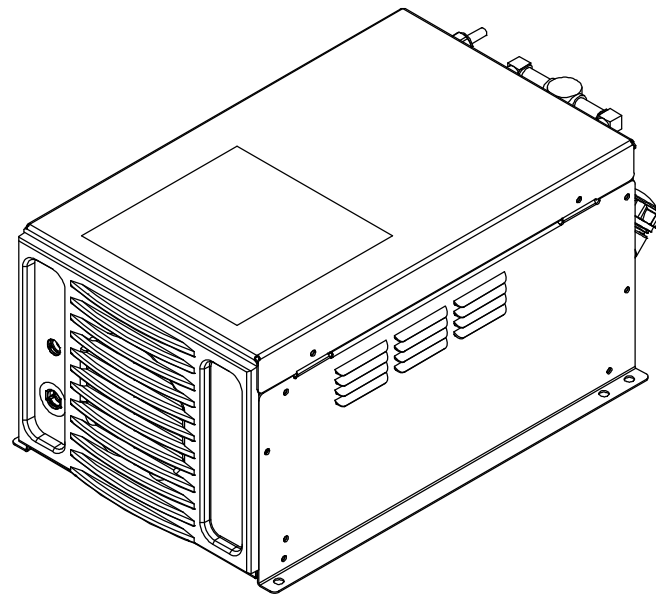
MIG (GMAW) Welding

**Description**



# Coolmate™ 3.5

## CE and Non-CE



For product information,  
Owner's Manual translations,  
and more, visit  
[www.MillerWelds.com](http://www.MillerWelds.com)

# OWNER'S MANUAL

File: TIG (GTAW)



# From Miller to You

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*Thank you and congratulations* on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

We've made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001 Quality System Standard.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at [www.MillerWelds.com](http://www.MillerWelds.com) on the web.**



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.



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# DECLARATION OF CONFORMITY

for European Community (CE marked) products.

**MILLER Electric Mfg. Co., 1635 Spencer Street, Appleton, WI 54914 U.S.A. declares that the product(s) identified in this declaration conform to the essential requirements and provisions of the stated Council Directive(s) and Standard(s).**

Product/Apparatus Identification:

| Product      | Stock Number   |
|--------------|----------------|
| Coolmate 3   | 043007, 043008 |
| Coolmate 3.5 | 300245         |
| Coolmate 4   | 042288015      |

Council Directives:

- 2014/35/EU Low Voltage
- 2014/30/EU Electromagnetic Compatibility
- 2011/65/EU Restriction of the use of certain hazardous substances in electrical and electronic equipment

Standards:

- IEC 60974-2:2013 Arc welding equipment – Part 2: Liquid cooling systems
- IEC 60974-10:2007 Arc Welding Equipment – Part 10: Electromagnetic compatibility (EMC) requirements

Signatory:

December 02, 2015

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**David A. Werba**

MANAGER, PRODUCT DESIGN COMPLIANCE

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Date of Declaration

# SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

coolers 2016-08

 Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.

## 1-1. Symbol Usage



**DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

**NOTICE** – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

## 1-2. Cooling Equipment Hazards



The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.



Only qualified persons should install, operate, maintain, and repair this unit.

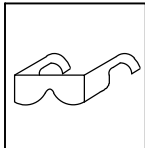


During operation, keep everybody, especially children, away.



### HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



### FLYING METAL or DIRT can injure eyes.

- Wear approved safety glasses with side shields even under your welding helmet.



### ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The input power circuit and machine internal circuits are also live when power is on. Incorrectly installed or improperly grounded equipment is a hazard.

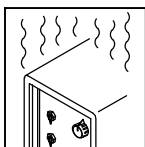
- Do not touch live electrical parts.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install, ground, and operate this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord and ground conductor for damage or bare wiring – replace immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Keep all panels and covers securely in place.

## 1-3. Additional Symbols For Installation, Operation, And Maintenance



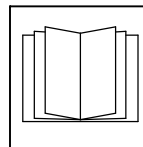
### FALLING EQUIPMENT can injure.

- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment.



### OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Do not block or filter airflow to unit.



### READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



### STEAM AND HOT COOLANT can burn.

Hose may rupture if coolant overheats.

- Visually inspect condition of hoses before each use. Do not use damaged hoses.
- Allow cooling period before working on equipment.



### HIGH PRESSURE FLUIDS can injure or kill.

- Coolant can be under high pressure.
- Release pressure before working on cooler.
- If ANY fluid is injected into the skin or body seek medical help immediately.



### MOVING PARTS can injure.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.

## 1-4. California Proposition 65 Warnings

**⚠** Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

**⚠** This product contains or produces a chemical known to the state of California to cause cancer or birth defects (or other reproductive harm). (California Health & Safety Code Section 25249.5 et seq.)

**⚠** This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. *Wash hands after use.*

## 1-5. Principal Safety Standards

*Safety in Welding, Cutting, and Allied Processes*, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: [www.global.ihs.com](http://www.global.ihs.com)).

*Safe Practices for the Preparation of Containers and Piping for Welding and Cutting*, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: [www.global.ihs.com](http://www.global.ihs.com)).

*Safe Practices for Welding and Cutting Containers that have Held Combustibles*, American Welding Society Standard AWS A6.0, from Global Engineering Documents (phone: 1-877-413-5184, website: [www.global.ihs.com](http://www.global.ihs.com)).

*National Electrical Code*, NFPA Standard 70, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: [www.nfpa.org](http://www.nfpa.org) and [www.sparky.org](http://www.sparky.org)).

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, from Compressed Gas Association, 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (phone: 703-788-2700, website: [www.cganet.com](http://www.cganet.com)).

*Safety in Welding, Cutting, and Allied Processes*, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060 Spectrum Way, Suite 100, Mississauga, Ontario, Canada L4W 5N5 (phone: 800-463-6727, website: [www.csagroup.org](http://www.csagroup.org)).

*Safe Practice For Occupational And Educational Eye And Face Protection*, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: [www.ansi.org](http://www.ansi.org)).

*Standard for Fire Prevention During Welding, Cutting, and Other Hot Work*, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: [www.nfpa.org](http://www.nfpa.org)).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: [www.osha.gov](http://www.osha.gov)).

*Applications Manual for the Revised NIOSH Lifting Equation*, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30329-4027 (phone: 1-800-232-4636, website: [www.cdc.gov/NIOSH](http://www.cdc.gov/NIOSH)).

# SECTION 2 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION

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**⚠** Pour écarter les risques de blessure pour vous-même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

## 2-1. Symboles utilisés



**DANGER!** – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.



Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

**AVIS** – Indique des déclarations pas en relation avec des blessures personnelles.

 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Consulter les symboles et les instructions ci-dessous y afférant pour les actions nécessaires afin d'éviter le danger.

## 2-2. Dangers liés aux équipements de refroidissement



Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l'attention et identifier les dangers possibles. En présence de l'un de ces symboles, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les instructions en matière de sécurité indiquées ci-dessous ne constituent qu'un sommaire des instructions de sécurité plus complètes fournies dans les normes de sécurité énumérées dans la Section 2-5. Lire et observer toutes les normes de sécurité.



Seul un personnel qualifié est autorisé à installer, faire fonctionner, entretenir et réparer cet appareil.

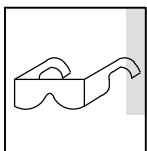


Pendant le fonctionnement, maintenir à distance toutes les personnes, notamment les enfants de l'appareil.



**LES PIÈCES CHAUDES** peuvent provoquer des brûlures.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



**DES PIÈCES DE METAL** ou **DES SALETES** peuvent provoquer des blessures dans les yeux.

- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



**UNE DÉCHARGE ÉLECTRIQUE** peut entraîner la mort.

Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur Marche. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

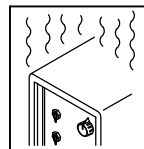
- Ne pas toucher aux pièces électriques sous tension.
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installez, mettez à la terre et utilisez correctement cet équipement conformément à son Manuel d'Utilisation et aux réglementations nationales, gouvernementales et locales.
- Toujours vérifier la terre du cordon d'alimentation. Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez-les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation afin de s'assurer qu'il n'est pas altéré ou à nu, le remplacer immédiatement s'il l'est. Un fil à nu peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément à ce manuel.
- S'assurer que tous les panneaux et couvercles sont correctement en place.

## 2-3. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



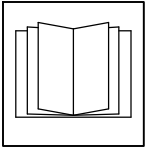
**LA CHUTE DE L'ÉQUIPEMENT** peut provoquer des blessures.

- Utiliser un équipement de levage de capacité suffisante pour lever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.
- Tenir l'équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.
- Suivre les consignes du Manuel des applications pour l'équation de levage NIOSH révisée (Publication N°94-110) lors du levage manuel de pièces ou équipements lourds.



**L'EMPLOI EXCESSIF** peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Ne pas obstruer les passages d'air du poste.



### LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque section.
- N'utiliser que les pièces de rechange recommandées par le constructeur.
- Effectuer l'installation, l'entretien et toute intervention selon les manuels d'utilisateurs, les normes nationales, provinciales et de l'industrie, ainsi que les codes municipaux.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyeurs, les consommables, les produits de refroidissement, les dégraissants, les flux et les métaux.



### Les PIÈCES MOBILES peuvent causer des blessures.

- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.



### LA VAPEUR ET LE LIQUIDE DE REFROIDISSEMENT CHAUD peuvent provoquer des brûlures.

Un tuyau peut se rompre lorsque le liquide de refroidissement surchauffe.

- Vérifiez visuellement l'état des tuyaux avant chaque utilisation. N'utilisez pas de tuyaux endommagés.
- Laissez refroidir avant d'intervenir sur l'équipement.



### LES LIQUIDES SOUS HAUTE PRESSION peuvent provoquer des blessures ou la mort.

- Liquide de refroidissement sous haute pression.
- Libérez la pression avant d'intervenir sur le refroidisseur.
- En cas d'injection d'un liquide QUELCONQUE dans la peau ou le corps, consultez immédiatement un médecin.

## 2-4. Proposition californienne 65 Avertissements

**⚠ Les équipements de soudage et de coupage produisent des fumées et des gaz qui contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des malformations congénitales et, dans certains cas, des cancers. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)**

**⚠ Ce produit contient ou forme un produit chimique reconnu par l'état de Californie de provoquer le cancer ou**

**malformations de naissance (ou autre problèmes reproductifs. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants).**

**⚠ Ce produit contient des produits chimiques, notamment du plomb, dont l'État de Californie reconnaît qu'ils provoquent des cancers, des malformations congénitales ou d'autres problèmes de procréation. Se laver les mains après utilisation.**

## 2-5. Principales normes de sécurité

*Safety in Welding, Cutting, and Allied Processes*, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: [www.global.ihs.com](http://www.global.ihs.com)).

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OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: [www.osha.gov](http://www.osha.gov)).



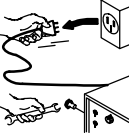


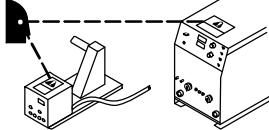
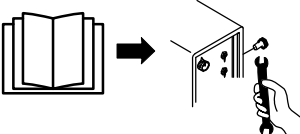
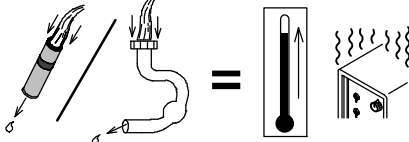
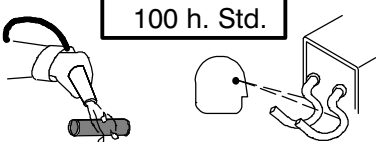
*Applications Manual for the Revised NIOSH Lifting Equation*, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30329-4027 (phone: 1-800-232-4636, website: [www.cdc.gov/NIOSH](http://www.cdc.gov/NIOSH)).



## SECTION 3 – DEFINITIONS

### 3-1. Additional Safety Symbols And Definitions

☞ Some symbols are found only on CE products.

|   |  |
|---|--|
|    | <p>Warning! Watch Out! There are possible hazards as shown by the symbols.</p> <p style="text-align: right;">Safe1 2012-05</p>   |
|    | <p>Do not remove or paint over (cover) the label.</p> <p style="text-align: right;">Safe20 2012-05</p>   |
|    | <p>Disconnect input plug or power before working on machine.</p> <p style="text-align: right;">Safe30 2012-05</p>  |
|    | <p>Do not discard product (where applicable) with general waste.<br/>Reuse or recycle Waste Electrical and Electronic Equipment (WEEE) by disposing at a designated collection facility.<br/>Contact your local recycling office or your local distributor for further information.</p> <p style="text-align: right;">Safe37 2012-05</p> |
|   | <p>Use coolant suggested by the manufacturer: 043810 (HF), 043809 (AI).</p> <p style="text-align: right;">Safe52 2012-05</p>   |
|  | <p>Read the labels on the welding power source, wire feeder, or other major equipment for welding safety information.</p> <p style="text-align: right;">Safe71 2012-06</p>   |
|  | <p>Read the Owner's Manual before working on this machine.</p> <p style="text-align: right;">Safe70 2012-06</p>  |
|  | <p>Plugged filter or hoses can cause overheating to the power source and torch.</p> <p style="text-align: right;">Safe50 2012-05</p>   |
|  | <p>Every 100 hours, check and clean filter and check condition of hoses.</p> <p style="text-align: right;">Safe51 2012-05</p>  |



## SECTION 4 – SPECIFICATIONS

### 4-1. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the front panel. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on cover of this manual.

### 4-2. Specifications

☞ The correction factor on the cooling power at an ambient temperature of 104 °F (40 °C) is 0.625.

|   |  |
|---|--|
| Recirculating Coolant System For Water-Cooled GTAW Torches And GMAW Guns. |  |
| Use With Guns/Torches Rated Up To 600 Amperes.                            |  |
| Coolant Tank Capacity   | 3.5 gal (13.2 L)   |
| Rated Cooling Power   | 1.66 kW at 1.1 qt/min at 77°F (5600 BTU/hr at 1 L/min at 25°C)     |
| Maximum Cooling Power   | 4.14 kW at 5.0 qt/min at 77°F (14,000 BTU/hr at 4.7 L/min at 25°C) |
| Dimensions (Length x Width x Height)                                      | 26 x 15.75 x 11.75 in. (660 x 400 x 298 mm)                        |
| Weight  | 60 lb (27 kg)  |
| Input Voltage   | 115 VAC, Single Phase, 50 or 60 Hz                                 |
| Input Amperage  | 5.9A 60Hz<br>4.7A 50Hz   |

### 4-3. Coolant Specifications

 Do not use conductive coolant.

| Application   | Coolant   |
|---|---|
| <b>GTAW Or Where High Frequency Current Is Used</b>     | Low Conductivity Coolant 043810*<br>Distilled Or Deionized Water Okay Above 32°F (0°C)  |
| <b>GMAW Or Where High Frequency Current Is Not Used</b> | Low Conductivity Coolant 043810*<br>Aluminum Protecting Coolant 043809*<br>Distilled Or Deionized Water Okay Above 32°F (0°C) |
| <b>Where Coolant Contacts Aluminum Parts</b>            | Aluminum Protecting Coolant 043809*   |

\*Coolants 043810 and 043809 protect to -37°F (-38°C) and resist algae growth.

**NOTICE** – Use of any coolant other than those listed in the table voids the warranty on any parts that come in contact with the coolant (pump, radiator, etc.).


### 4-4. Environmental Specifications

#### A. IP Rating

| IP Rating   |
|---|
| IP23S   |
| This equipment is designed for outdoor use. It may be stored, but is not intended to be used for welding outside during precipitation unless sheltered. |

IP23 2014-06

#### B. Information On Electromagnetic Compatibility (EMC)

|   |
|---|
| <p> This Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There can be potential difficulties in ensuring electromagnetic compatibility in those locations, due to conducted as well as radiated disturbances.</p> <p>This equipment complies with IEC 61000-3-11 and IEC 61000-3-12.</p> <p style="text-align: right;">ce-emc 4 2014-07</p> |
|---|

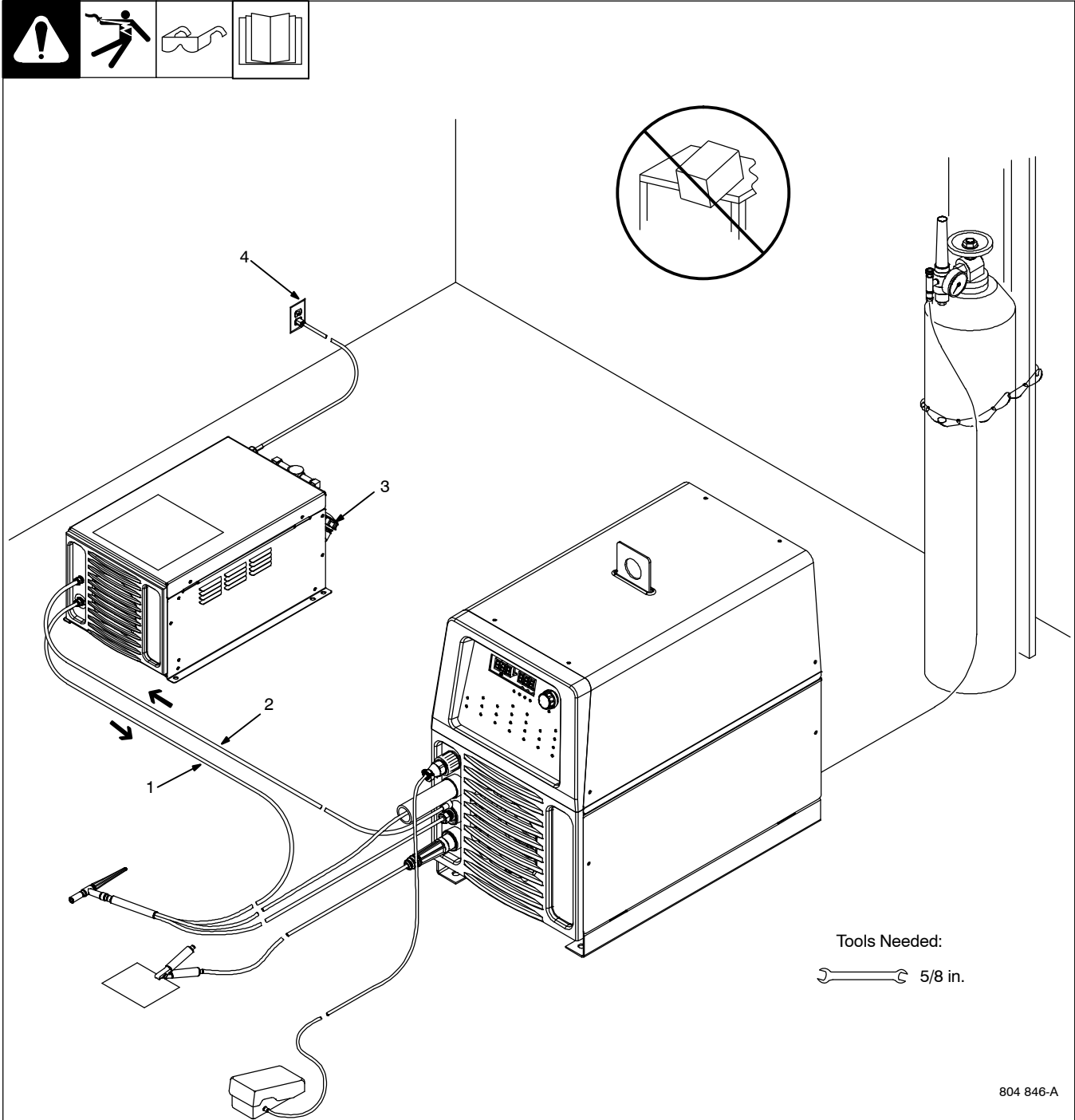
#### C. Temperature Specifications

| Operating Temperature Range | Storage/Transportation Temperature Range |
|-----------------------------|--|
| 14 to 104 °F (-10 to 40°C)  | -4 to 131 °F (-20 to 55°C)               |

Temp1\_016-08

## SECTION 5 – INSTALLATION

### 5-1. GTAW Connections



**⚠ Do not move or operate unit where it could tip.**

To prevent overheating, make sure cooling unit is positioned so airflow is not restricted.

**NOTICE** – If welding power source has a water valve, do not connect hoses to water valve. Connect hoses as shown.

- 1 Coolant Out Hose
- 2 Coolant In Hose

Fittings have 5/8-18 left-hand threads. Connect hoses with proper fittings as shown. Some power sources may require a TIG block.

- 3 Coolant Tank Cap
- 4 115 Volt AC Grounded Receptacle

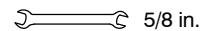
An individual branch circuit capable of carrying 15 amperes and protected by fuses or circuit breakers is recommended. Rec-

ommended fuse or circuit breaker size is 15 amperes.

**Operation:**

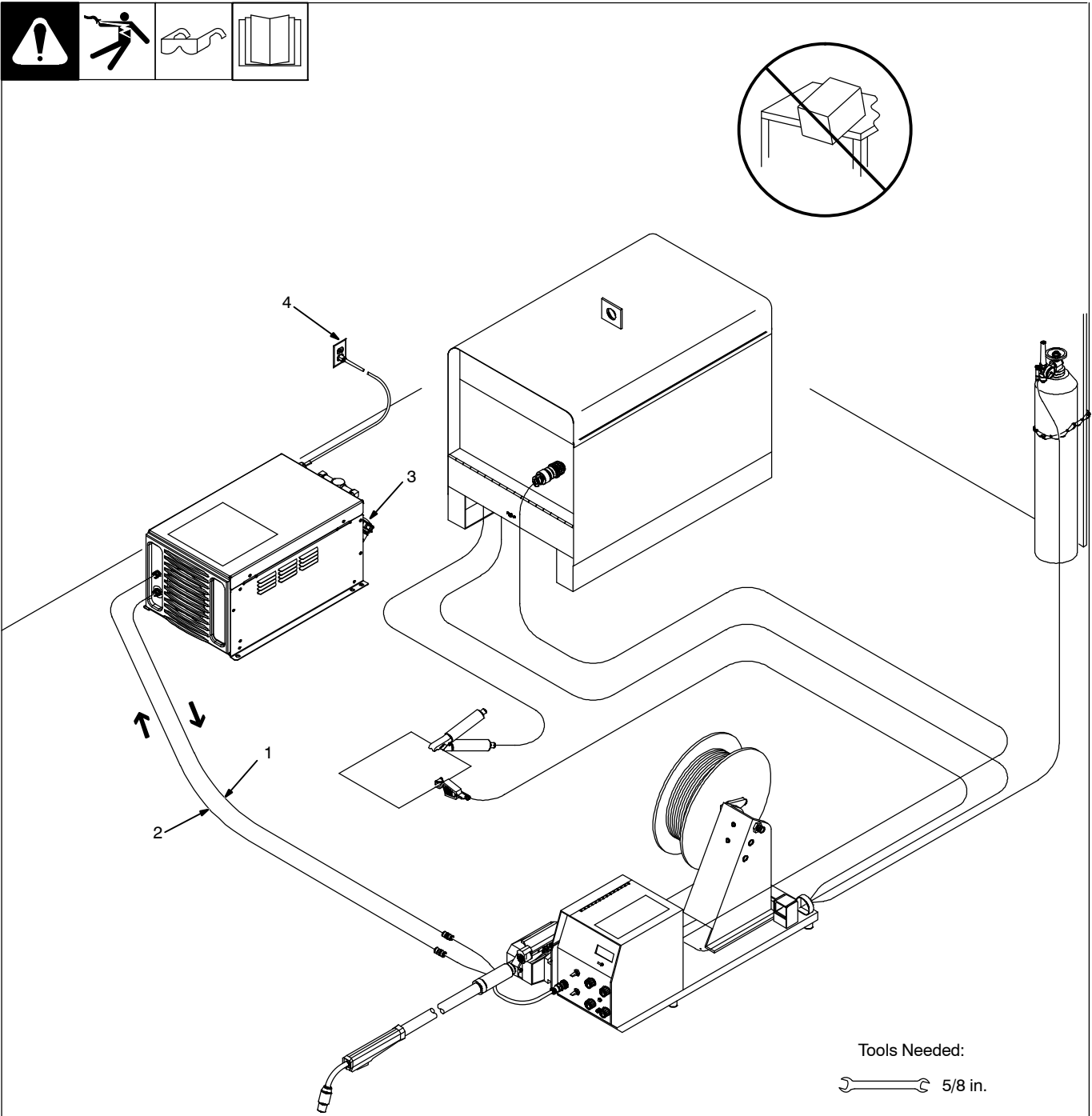
Fill tank with proper coolant. Use table in Section 4-3 to select proper coolant. Maintain coolant level at approximately 1 in (25 mm) below top of filler neck. Connect hoses as shown. Unit turns on when plugged in.

Tools Needed:




804 846-A

## 5-2. GMAW Connections



Tools Needed:

 5/8 in.

804 845-A

**⚠ Do not move or operate unit where it could tip.**

To prevent overheating, make sure cooling unit is positioned so airflow is not restricted.

**NOTICE** – If welding power source has a water valve, do not connect hoses to water valve. Connect hoses as shown.

- 1 Coolant Out Hose
- 2 Coolant In Hose

Fittings have 5/8-18 left-hand threads. Connect hoses with proper fittings as shown.

- 3 Coolant Tank Cap
- 4 115 Volt AC Grounded Receptacle

An individual branch circuit capable of carrying 15 amperes and protected by fuses or circuit breakers is recommended. Rec-

ommended fuse or circuit breaker size is 15 amperes.

**Operation:**

Fill tank with proper coolant. Use table in Section 4-3 to select proper coolant. Maintain coolant level at approximately 1 in (25 mm) below top of filler neck. Connect hoses as shown. Unit turns on when plugged in.

# SECTION 6 – MAINTENANCE & TROUBLESHOOTING

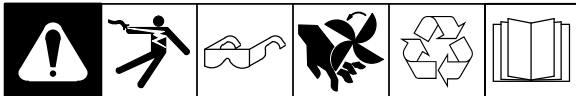
## 6-1. Routine Maintenance



**⚠** Disconnect power before maintaining.

| ⌚              | ✓ = Check<br>* To be done by Factory Authorized Service Agent    | ◇ = Change | ● = Clean   | △ = Repair | ☆ = Replace |
|----------------|--|------------|---|------------|-------------|
| Every 3 Months | ● Coolant Strainer, during heavy service, clean more frequently. |            | ● Blow out heat exchanger fins.<br>✓ Check coolant level. Top off with distilled or deionized water if necessary. |            |             |
| Every 6 Months | ✓☆ Hoses   | ✓☆ Labels  | ◇ Replace coolant.  |            |             |

## 6-2. Coolant Maintenance



**⚠** Disconnect cooler plug from welding power source receptacle before maintaining.

**⚠** Dispose of used coolant according to national, state, and local codes. Do not pour down drain.

1 Coolant Filter

Unscrew housing to clean filter.

### Changing Coolant

Drain coolant by tipping unit to rear, or use suction pump. Fill with clean water and run for 10 minutes. Drain and refill with coolant (see section 4-3).

**NOTICE** – If replacing hoses, use hoses compatible with ethylene glycol, such as Buna-n, Neoprene, or Hypalon. Oxy-acetylene hoses are not compatible with any product containing ethylene glycol.

Install cover if removed.

Tools Needed:



m30 Torx

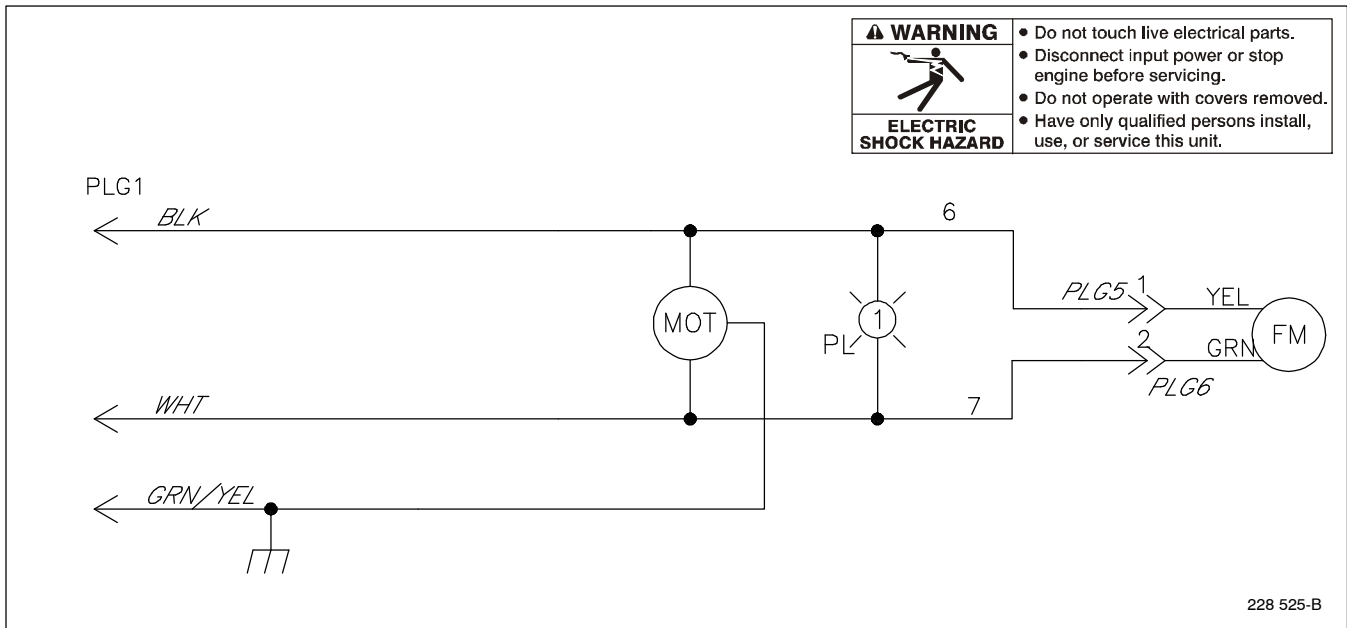
804 649-A

### 6-3. Troubleshooting

| Trouble                       | Remedy   |
|-------------------------------|--|
| Coolant system does not work. | Be sure input power cord is plugged in to energized receptacle.                                |
|                               | Check line fuses or circuit breaker, and replace or reset if necessary.                        |
|                               | Motor overheated. Unit starts running when motor has cooled.                                   |
|                               | Have Factory Authorized Service Agent check Power switch S1 and motor (Mot).                   |
| Decreased or no coolant flow. | Add coolant.   |
|                               | Check for clogged hoses or coolant filter. Clean filter or clean / replace hoses if necessary. |
|                               | Disconnect pump, and check for sheared coupling. Replace coupling if necessary.                |

## SECTION 7 – ELECTRICAL DIAGRAM

### 7-1. Circuit Diagram For Cooler



## SECTION 8 – PARTS LIST

### 8-1. Recommended Spare Parts

| Dia.<br>Mkgs.                  | Part<br>No. | Description                | Quantity |
|--------------------------------|-------------|----------------------------|----------|
| <b>Recommended Spare Parts</b> |             |                            |          |
| .....                          | 257415      | ..... Screen, Filter ..... | 1        |









# TRUE BLUE<sup>®</sup>

## WARRANTY

Effective January 1, 2017

(Equipment with a serial number preface of MH or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

### Warranty Questions?

Call  
1-800-4-A-MILLER  
for your local  
Miller distributor.

Your distributor also gives  
you ...

### Service

You always get the fast,  
reliable response you  
need. Most replacement  
parts can be in your  
hands in 24 hours.

### Support

Need fast answers to the  
tough welding questions?  
Contact your distributor.  
The expertise of the  
distributor and Miller is  
there to help you, every  
step of the way.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed. If notification is submitted as an online warranty claim, the claim must include a detailed description of the fault and the troubleshooting steps taken to identify failed components and the cause of their failure.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed twelve months after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an International distributor.

1. 5 Years Parts — 3 Years Labor
  - \* Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules
2. 3 Years — Parts and Labor
  - \* Auto-Darkening Helmet Lenses (Except Classic Series) (No Labor)
  - \* Engine Driven Welder/Generators  
**(NOTE: Engines are Warranted Separately by the Engine Manufacturer.)**
  - \* Inverter Power Sources (Unless Otherwise Stated)
  - \* Plasma Arc Cutting Power Sources
  - \* Process Controllers
  - \* Semi-Automatic and Automatic Wire Feeders
  - \* Transformer/Rectifier Power Sources
3. 2 Years — Parts and Labor
  - \* Auto-Darkening Helmet Lenses – Classic Series Only (No Labor)
  - \* Fume Extractors – Capture 5, Filtair 400 and Industrial Collector Series
4. 1 Year — Parts and Labor Unless Specified
  - \* AugmentedArc and LiveArc Welding Systems
  - \* Automatic Motion Devices
  - \* Bernard BTB Air-Cooled MIG Guns (No Labor)
  - \* CoolBelt and CoolBand Blower Unit (No Labor)
  - \* Desiccant Air Dryer System
  - \* External Monitoring Equipment and Sensors
  - \* Field Options  
**(NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)**
  - \* RFCS Foot Controls (Except RFCS-RJ45)
  - \* Fume Extractors – Filtair 130, MWX and SWX Series
  - \* HF Units
  - \* ICE/XT Plasma Cutting Torches (No Labor)
  - \* Induction Heating Power Sources, Coolers  
**(NOTE: Digital Recorders are Warranted Separately by the Manufacturer.)**
  - \* Load Banks
  - \* Motor-Driven Guns (except Spoolmate Spoolguns)
  - \* PAPR Blower Unit (No Labor)
  - \* Positioners and Controllers
  - \* Racks
  - \* Running Gear/Trailers
  - \* Spot Welders
  - \* Subarc Wire Drive Assemblies
  - \* TIG Torches (No Labor)
  - \* Tregaskiss Guns (No Labor)
  - \* Water Cooling Systems
  - \* Wireless Remote Foot/Hand Controls and Receivers
  - \* Work Stations/Weld Tables (No Labor)

5. 6 Months — Parts
  - \* Batteries
6. 90 Days — Parts
  - \* Accessory (Kits)
  - \* Canvas Covers
  - \* Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
  - \* M-Guns
  - \* MIG Guns, Subarc (SAW) Torches, and External Cladding Heads
  - \* Remote Controls and RFCS-RJ45
  - \* Replacement Parts (No labor)
  - \* Spoolmate Spoolguns

Miller's True Blue<sup>®</sup> Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MILLER IS EXCLUDED AND DISCLAIMED BY MILLER.

Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.





# Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



## For Service

**Contact a DISTRIBUTOR or SERVICE AGENCY near you.**

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information and Parts)

Circuit Diagrams

Welding Process Handbooks

To locate a Distributor or Service Agency visit [www.millerwelds.com](http://www.millerwelds.com) or call 1-800-4-A-Miller

Contact the Delivering Carrier to:

File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

### Miller Electric Mfg. Co.

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)

