Axcess® E Systems

With Insight™ Weld Data Monitoring System

Digital Semi-Automatic MIG Welding Systems

Quick Specs

Manufacturing Applications
Construction Equipment
Automotive Components
Recreational Vehicles
Farm Machinery
Office Furniture
Mining Machinery

Processes
Multi-MIG®
Accu-Pulse® MIG (GMAW-P)
Accu-Curve™ MIG (GMAW-P)
Pulsed MIG (GMAW-P)
MIG (GMAW)
Metal Core
Carbon Arc Gouging (CAC-A)
  can also be activated

Rated Output
300: 300 A at 32 VDC, 60% Duty Cycle
  (225 A at 29 VDC, 100% Duty Cycle)
450: 450 A at 36.5 VDC, 100% Duty Cycle

Voltage Range 10 – 44 V

Auxiliary Power 120 VAC, 10 A Duplex

Net Weight
300: 129 lb (58.5 kg)
450: 176 lb (79.8 kg)

The Power of Blue.®

Flexible, Expandable and Upgradeable

Multi-MIG capable welding systems are precise, digitally controlled and software-driven. For additional information see page 6.

Axcess E digital control technology combined with an inverter welding power source is designed to reduce the complexity of a semi-automatic Pulsed MIG welding system, simplify installation, and provide superior welding performance.

Configure the Axcess E via convenient web pages using virtually any web browser (see page 2).

Insight weld data monitoring system provides comprehensive feedback on welding activity and productivity (see pages 3 and 4).

Field Upgrade Module

Update a standard Axcess power source by installing an Axcess E Field Upgrade Module (see page 10).

Look for high-speed video clips of Accu-Pulse®, Accu-Curve™, and Front Panel Simulator at **MillerWelds.com/AMS/axcess**.

Axcess E four-drive-roll wire drive feeder is combined with an operator interface, leaving no controls back at the power source. Provides positive feeding for the appropriate preprogrammed wire diameters from 50 –1400 IPM, and operates from 40 VDC supplied by Axcess power source.

Axcess E 450 shown with Axcess E feeder

Axcess E 300 shown with Axcess E feeder

TRUE BLUE® 3YR. WARRANTY
Power source is warranted for 3 years, parts and labor.

DESIGNED AND BUILT IN USA

Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

Web Site
www.MillerWelds.com

**ISO 9001:2000 REGISTERED QUALITY SYSTEM**

Interface with Axcess® E Via Web Pages

With a browser and access to the company's factory network, authorized employees can interface with the Axcess E to change configurations, check settings, define programs, update firmware, monitor basic functions, troubleshoot the system, and much, much more. In addition, with external access to the factory network, the monitoring can be accomplished from anywhere in the world, using any compliant browser. The use of web pages is easy and intuitive, which means the learning curve is short.
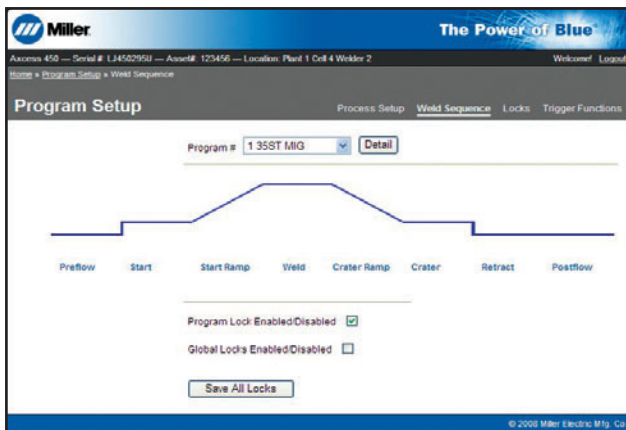
Web Page Examples
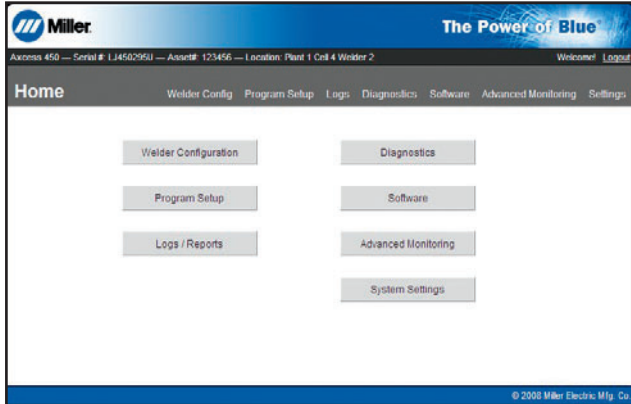
Home Page
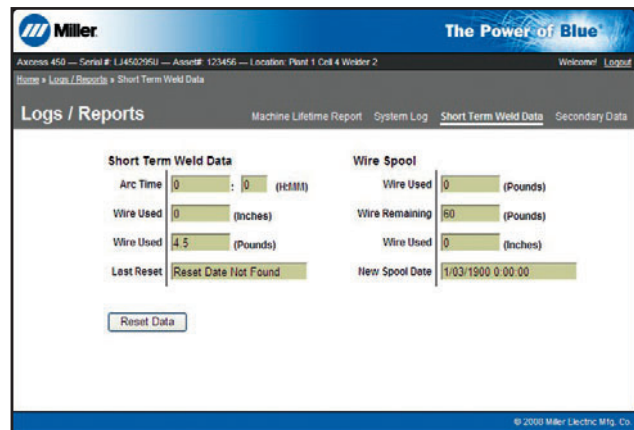Provides quick access to all Axcess E information and set-up screens.
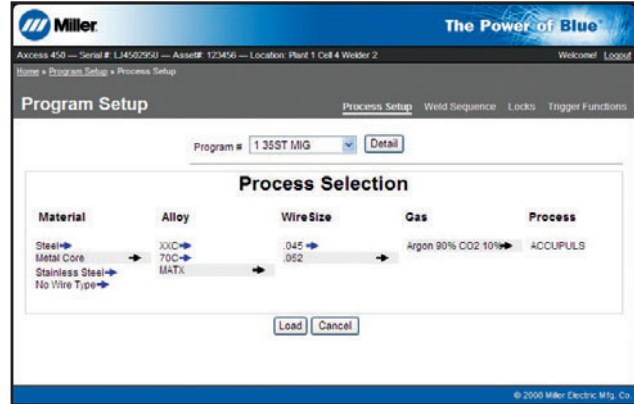
Process Setup Page
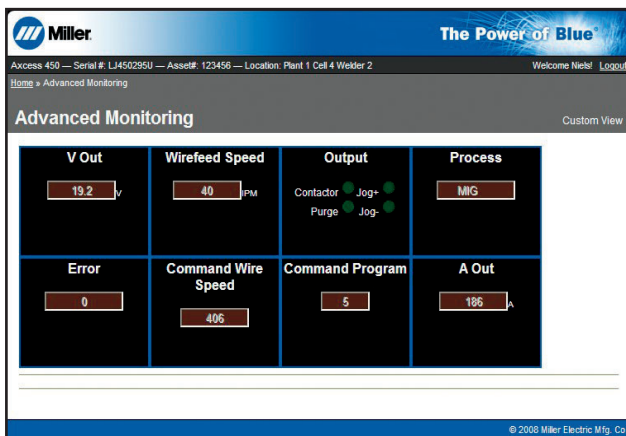Define each of the eight available Axcess E programs.

Weld Sequencer Page
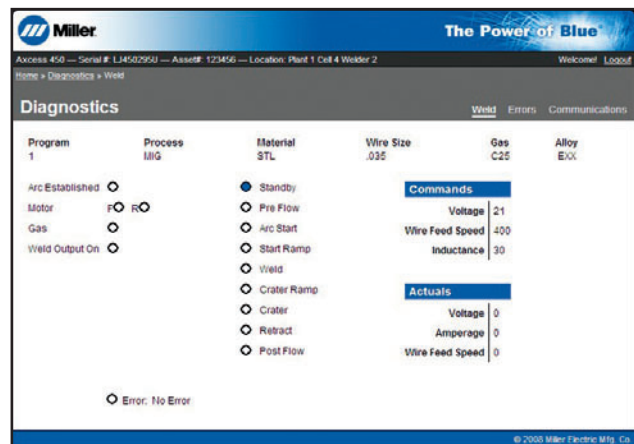Define each attribute of the weld sequence for each program.

Short Term Weld Data Page
Get a quick reading of arc time and wire usage since last reset.

Advanced Monitoring Page
Customized view of critical machine information.

Weld Diagnostics Page
Determine the status of internal component performance.

Insight™ Weld Process Management System

Don't just monitor production data, use Insight to provide the information that will create the knowledge you need to improve your welding operation on many levels. When combined with the power of Ethernet connectivity, Miller's Axcess E with Insight provides a comprehensive welding information system. *Insight is embedded into the operating system of the Axcess E,* eliminating the need for external monitoring devices. Simply stated, the Axcess E with Insight provides valuable information that can be used to reduce cost, increase productivity, and enhance quality.

**Axcess® E with Insight Centerpoint™**
- Streamlines operator training
- Helps the operator apply welds in the correct sequence
- Detects missing or incomplete welds
- Detects under and over welding
- Identifies and addresses recurring quality issues
- Monitors system information and trends to prompt preventative maintenance
- Monitors various welding inputs/outputs to ensure process conformance

- Provides Weld Signatures™ with detailed information on welds outside of predetermined limits
- Provides information on faults
- Provides information on wire consumption and gas consumption (optional)
- Provides information by time, by part, by work cell, by shift, and by operator
- Consolidates weld data information for an entire fleet of Axcess E systems via factory Ethernet network
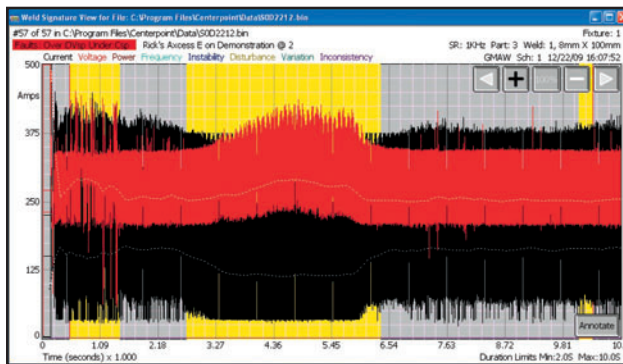
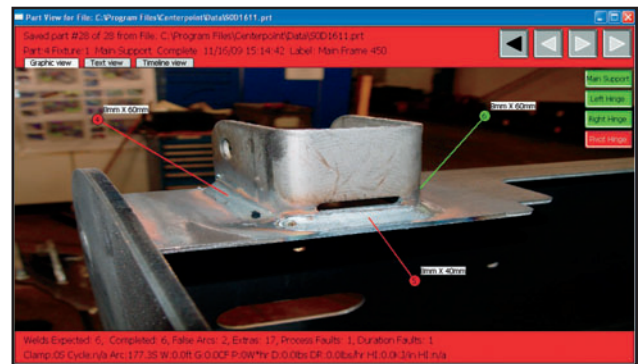## Insight Centerpoint Application — View Examples
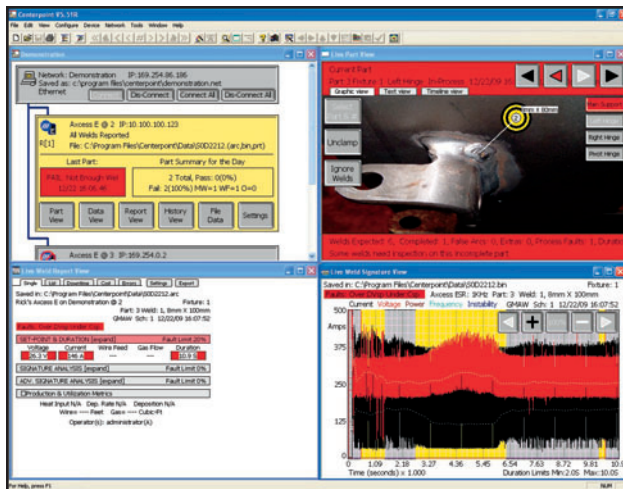
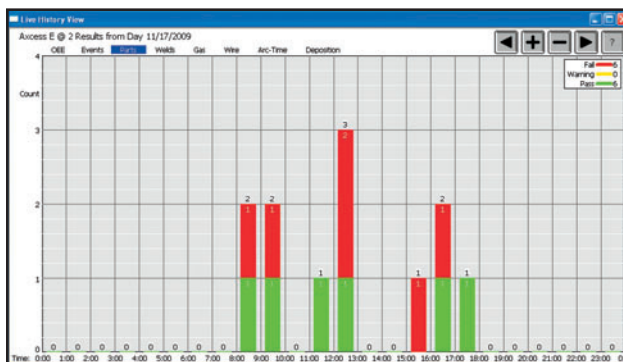**Administrative View**
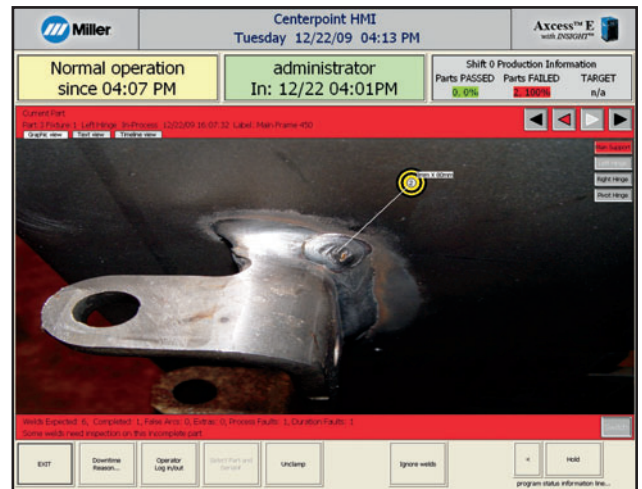
HMI View for Operator

Weld Signature™* View with Faults Highlighted

Part View with Failures

History View — Parts

History View — Parts, Welds, Downtime

*Part Tracking™ and Weld Signature™ are registered trademarks of IMPACT Engineering.

Miller.

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Insight Reporter™ Management Reporting System

Insight Reporter provides the type of enterprise weld production information that can be used to drive your business forward. Insight Reporter provides information via a wide range of preconfigured process, production, and management charts and reports. This information is stored in a SQL server database which contains data from multiple Axcess E and Insight Centerpoint™ sources.

There are two primary components to Insight Reporter: database software and client software. Any Axcess E networked to a PC running Insight Centerpoint can feed weld production process data to the Insight Reporter SQL database software.

The Insight Reporter client software is offered on a per-seat license and can be run from any PC on the network with access to the SQL Server. Examples of some of the standard reports include:

Weld Analysis Charts
• Weld summary
• Welds per time
• Sensor averages
• Process features
• Fault types

Part Analysis Charts
• Part summary
• Parts per time
• Part faults per time
• Faults on a single part
• Weld counts per part
• Parts with missing welds
• Single part report

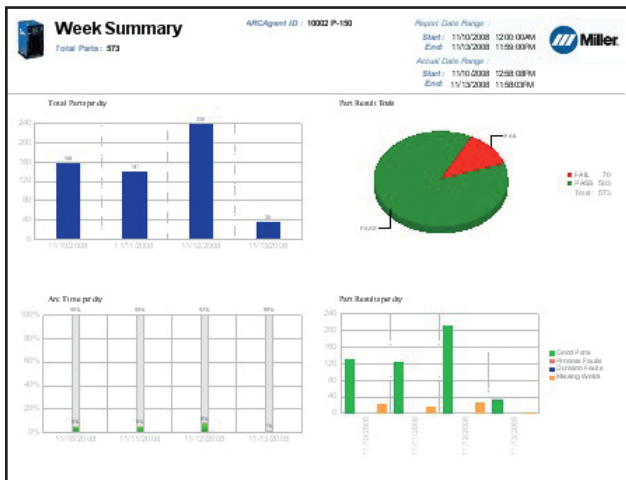**Productivity Charts**
• Arc-efficiency
• Parts per hour
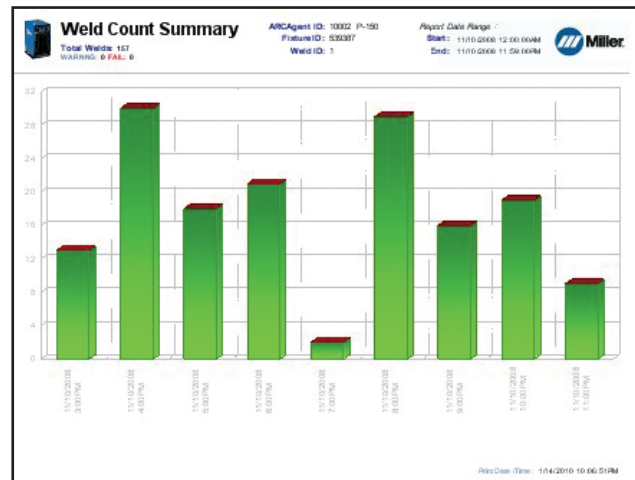• Welds per hour
• Downtime analysis
• Cycle time

Costing Analysis Charts
• Wire usage
• Gas usage
• Summary reports
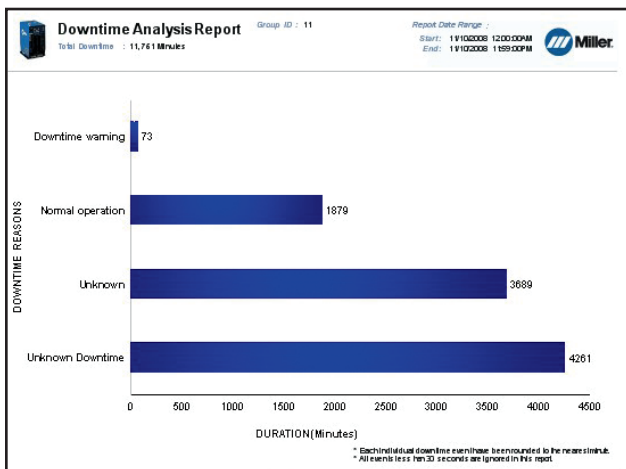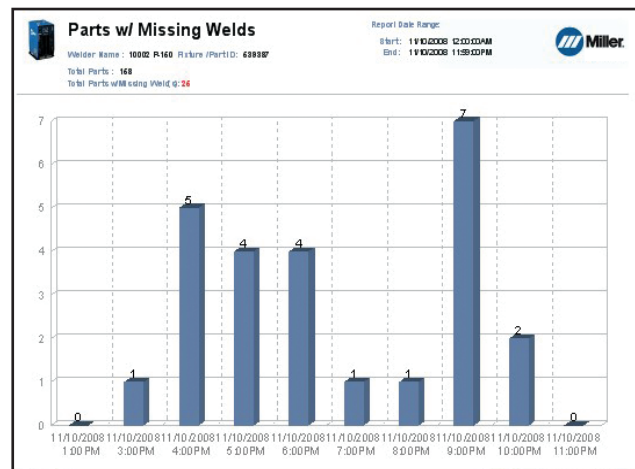• Available by shift, day, week, month, or year

Report Examples

Weekly Summary Report

Weld Count Summary by Hour Report

Downtime Analysis Report

Parts with Missing Welds Report

Miller®

Control Panels

Front Panel
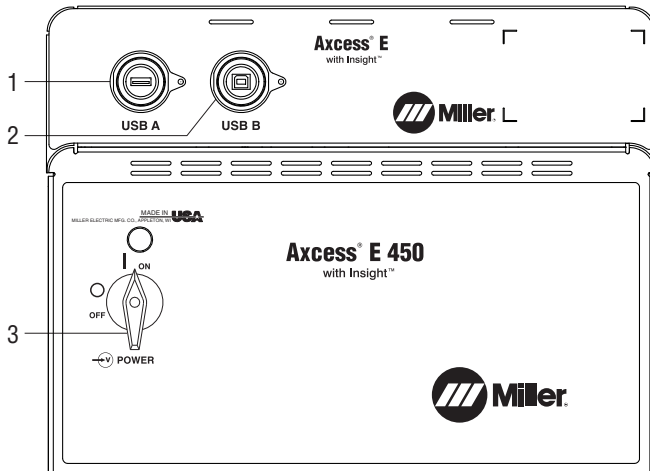
Rear Panel
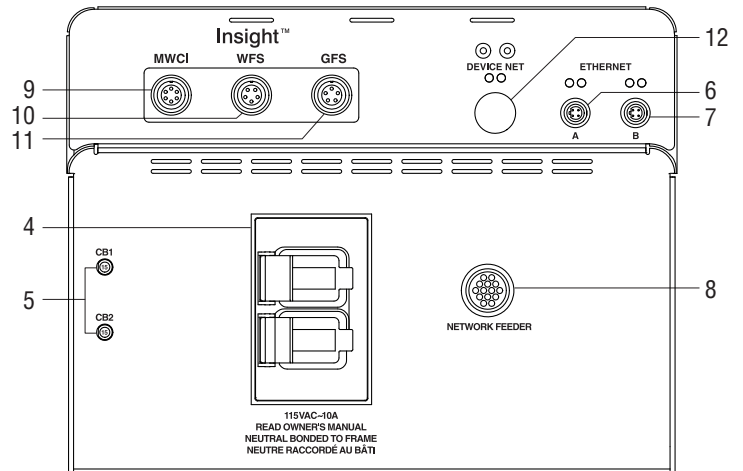
1. **USB Connection A (Host)**
2. **USB Connection B (Device)**
3. **Power Switch**
4. **115 VAC, 10 A Duplex Receptacle**

5. **Circuit Breakers**
6. **Ethernet Connector A**
7. **Ethernet Connector B**
8. **Network Feeder Connector**

9. **MWCI Connection (Optional)**
10. **Wire Feed Speed Sensor Conn. (Optional)**
11. **Gas Flow Sensor Connection (Optional)**
12. **DeviceNet Connector (Optional)**

**Axcess E Feeder and
Remote Operator Interface (ROI E)**
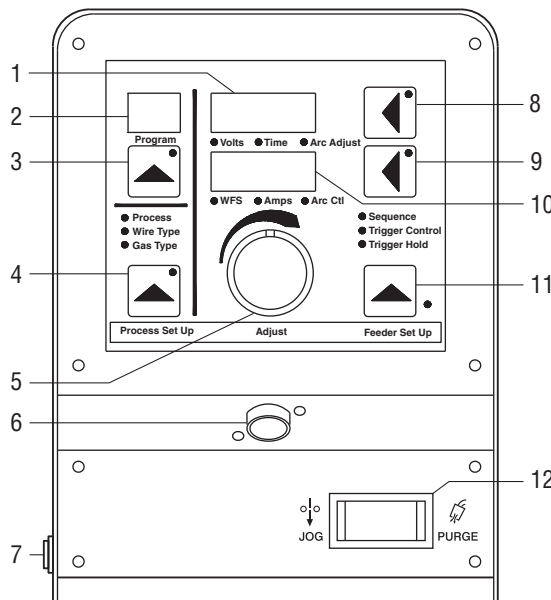
1. **Voltage/Arc Adjust Display Meter**
2. **Program Display**
3. **Program # Select**
4. **Process Setup Button**
5. **Control Knob**
6. **Trigger Receptacle**
7. **On/Off Switch**
8. **Voltage/Arc Adjust Button**
9. **Wire Feed Speed/Arc Control Setup Button**
10. **Wire Speed/Amperage Display Meter**
11. **Feeder Setup Button**
12. **Jog/Purge Switch**

Capabilities

Dual Schedule — Toggle between two program pairs (e.g. 1,2 – 3,4 – 5,6 – 7,8).

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

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

Trigger Dual Schedule (TDS) — When activated allow 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 (in seconds)
- Preflow: 0.1–10.0 s
- Start Power: 0.1–10.0 s
- Crater: 0.1–10.0 s
- Postflow: 0.1–10.0 s

Arc Adjust — Arc length (Trim)

Arc Control — Arc force or focus (SharpArc®)

Process Selection — Accu-Pulse®, Accu-Curve™, Pulsed MIG, MIG, Metal Core

Features and Benefits

HARDWARE (Standard)

AUTO-LINE Power Management Technology — Miller's patented technology allows for **any** input voltage hook-up (190 – 630 V, 50 or 60 Hz) with no manual linking. Assures rock-solid, consistent output on fluctuating primary lines.

Fan-On-Demand™ — Cooling system operates only when needed. Reduces amount of airborne contaminants pulled through the machine.

Wind Tunnel Technology™ — Circulates air over components that require cooling, not over electronic circuitry, which reduces contaminants and improves reliability in harsh welding environments.

1/4-turn steel connectors — Allow for faster installation of system and eliminates thread stripping.

115 VAC duplex receptacle — Provides 10 amp circuit-breaker-protected auxiliary power regardless of primary power.

Dual removable lifting eyes — For moving with overhead lifts. Removability allows for flat-top feeder or storage on top.

Forklift slots — Slots cut into the frame for forklift transportation.

Small footprint — All models feature a small footprint, designed to minimize floor space requirements.

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

Connections for Ethernet (2) — Interface with any Axcess E either directly or via the factory Ethernet network.

Connections for USB — USB flash drives can be used for executing code updates.

SOFTWARE (Standard)

Multi-MIG® capability — Includes common carbon steel and stainless welding programs, including patented **Accu-Pulse®** and **Accu-Curve™**, standard or adaptive pulse, conventional MIG and metal core programs using the most popular wire diameters and gas combinations.

Accu-Pulse®/Accu-Curve™ — MIG processes that deliver precise control of the arc even over tack welds and in tight corners. Provide optimum molten puddle control for out-of-position welding.

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.

Remote/trigger program select — Allows changing weld programs to take advantage of up to 8 programs of Multi-MIG welding process capabilities.

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

"Axcess®" 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 be "Axcess"-ed 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 "Axcess"-able MIG and pulse processes. This shows compatible shielding gas combinations such as 90 Ar/10 CO_2 (90% Argon and 10% Carbon Dioxide) on steel using the same wire-feed speed and also gives an indication of puddle control characteristics based on arc type selected.

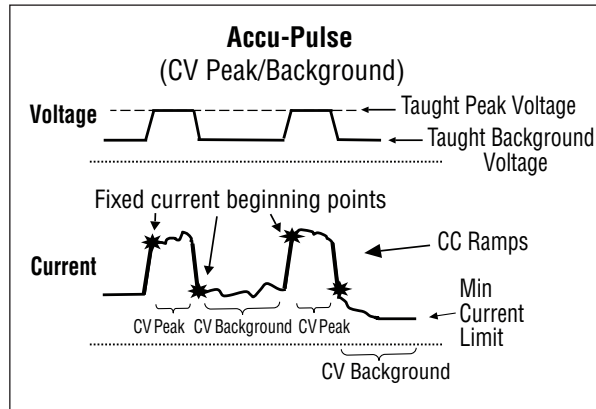| Process	Standard Spray	Pulsed Spray	Accu-Pulse® and Accu-Curve™	Standard Short Circuit
Weld Puddle Control	Flat/Horizontal		All Position Performance	Thin Materials/Gap Filling

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.

Miller®

Featured Welding Processes

Note: As new and improved software features are developed, they can be added to existing Axcess E systems for FREE by updating code online at Millerwelds.com/AMS/AxcessE. Code transfer is accomplished via Ethernet or USB connection from a PC/Network or via a USB memory stick directly into the Axcess E.

Accu-Pulse® *STANDARD* on all Axcess E models

The patented Accu-Pulse process allows for precise control of the pulse arc. Accu-Pulse provides optimum molten puddle control and has power to increase wire feed speeds and deposition 20 to 25% in many applications. In most cases, slightly different ratios of gas mixtures will perform well using a similar program and adjusting arc length or the appropriate arc control for the selected process. Contact Miller for more information on less common materials and gas combinations.

Accu-Pulse
(CV Peak/Background)

Voltage — Taught Peak Voltage
— Taught Background Voltage

Fixed current beginning points

Current
CC Ramps
Min Current Limit
CV Peak CV Background CV Peak
CV Background

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

Accu-Curve™ *STANDARD* on all Axcess E models *(see note below)*

Accu-Curve is a variation of the Accu-Pulse process. The transitions from peaks to background voltage are "curved". The curved transitions provide a "softer" feel without sacrificing the tight arc lengths that allow for better puddle control and have become the hallmark of the Accu-Pulse process.
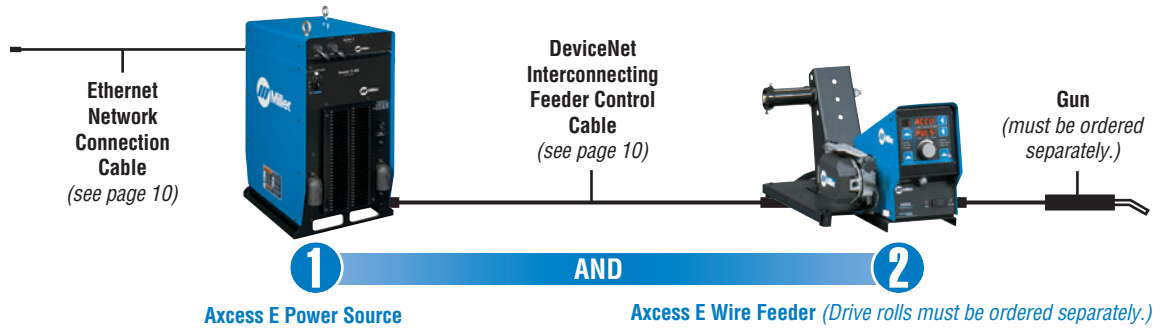
Benefits
- "Softer" feel than Accu-Pulse
- Maintains tight arc lengths
- Maintains better puddle control

Typical Installations (Semi-Automatic Pulsed MIG or Conventional MIG)

The Axcess E 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 E 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 5).
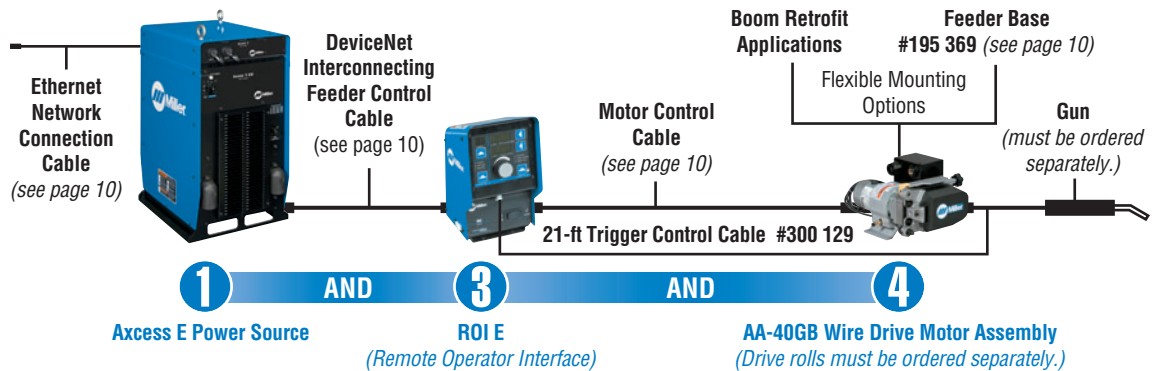
Standard Installation

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

Ethernet Network Connection Cable *(see page 10)*

DeviceNet Interconnecting Feeder Control Cable *(see page 10)*

Gun *(must be ordered separately.)*

① AND ②

Axcess E Power Source

Axcess E Wire Feeder *(Drive rolls must be ordered separately.)*

Remote Operator Interface 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.

Ethernet Network Connection Cable *(see page 10)*

DeviceNet Interconnecting Feeder Control Cable *(see page 10)*

Motor Control Cable *(see page 10)*

Boom Retrofit Applications

Feeder Base #195 369 *(see page 10)*

Flexible Mounting Options

Gun *(must be ordered separately.)*

21-ft Trigger Control Cable #300 129

① AND ③ AND ④

Axcess E Power Source

ROI E *(Remote Operator Interface)*

AA-40GB Wire Drive Motor Assembly *(Drive rolls must be ordered separately.)*

① Power Source Specifications (Subject to change without notice.)

CV · **DC** · **3 Phase**

Model	Rated Output	Voltage Range	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 50/60 Hz, 3-Phase								Dimensions	Net Weight
					208 V	230 V	380 V	400 V	460 V	575 V	KVA	KW		
Axcess 300	300 A at 32 VDC, 60% Duty Cycle (225 A at 29 VDC, 100% Duty Cycle)	10–44 V	5–400 A	80 VDC	33	29.7	16.9	—	14.6	11.6	11.7	11.2	300 H: 23 in (584 mm) 450 H: 33 in (838 mm) W: 17 in (432 mm) D: 22-1/2 in (572 mm)	129 lb (58.5 kg)
Axcess 450	450 A at 36.5 VDC, 100% Duty Cycle	10–44 V	5–600 A	80 VDC	54	49	29	28	24	19	19.9	19.2		176 lb (79.8 kg)

Certified to both the Canadian and U.S. Standards for welding equipment.

② Wire Feeder Options

Wire feeders do NOT include drive rolls or required DeviceNet Interconnecting Feeder Control Cable. These must be ordered separately.

Axcess E Feeder   #300 677
Feeder is designed specifically for Axcess E. Provides single-range control of 50–1400 inches per minute. Digitally communicates with Axcess E power source via DeviceNet Interconnecting Feeder Control Cable. Includes 50 ft volt-sense lead.

Model	Gas Valve	Type of Input Power	Connection to Power Source	Wire Feed Speed Range*	Wire Diameter Range	Dimensions	Ship Weight
Axcess E Bench/Sled Feeder	Included	40 VDC (from Axcess)	DeviceNet Interconnecting Feeder Control Cable — 5, 10, 25, or 50 ft (Order separately)	50–1400 IPM (1.3–35.56 MPM)	.035 – 3/32 in (0.9–1.6 mm)	H: 14-1/2 in (368 mm) W: 12-1/2 in (318 mm) D: 27 in (686 mm)	Single Feeder 49 lb (22 kg)

This is the wire feed speed range while using MIG. With Pulsed MIG, the wire feed speed range may be more limited.

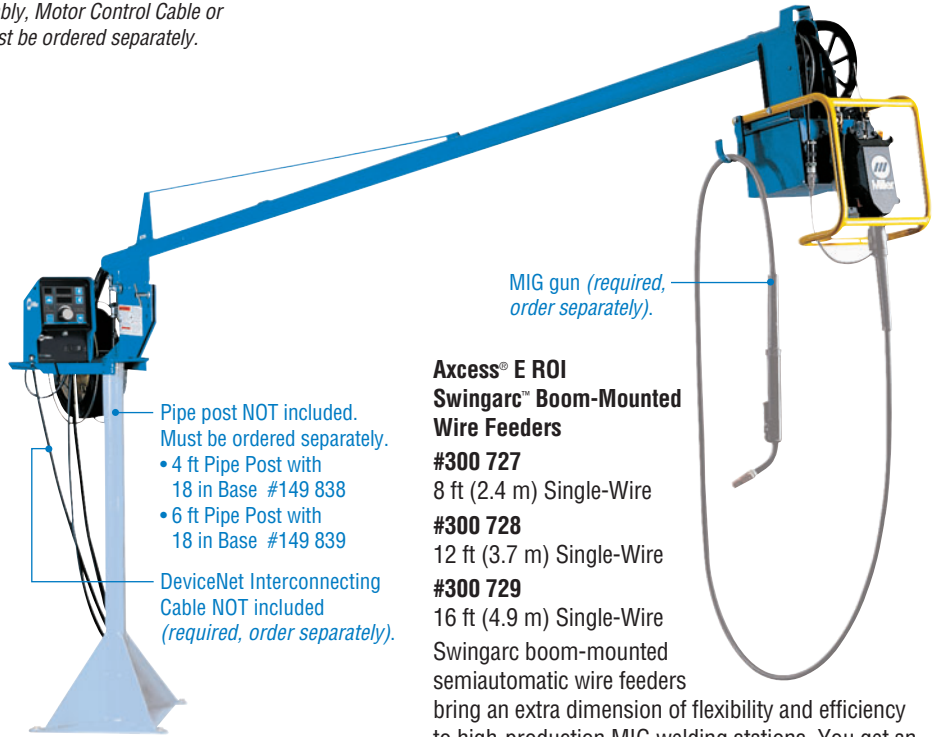**Miller.**

❸ ROI (Remote Operator Interface) Options

ROI E does NOT include AA-40GB Wire Drive Motor Assembly, Motor Control Cable or DeviceNet Interconnecting Feeder Control Cable. These must be ordered separately.

MIG gun *(required, order separately).*

ROI E   #300 726
The ROI E allows the Axcess E power supply, wire drive motor assembly and remote 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 E while retaining an existing boom or other structural asset.

Note: For non-Miller boom and jib mounting, see ROI E installation diagram on page 8 and select desired cable lengths.

Pipe post NOT included. Must be ordered separately.
• 4 ft Pipe Post with 18 in Base #149 838
• 6 ft Pipe Post with 18 in Base #149 839

DeviceNet Interconnecting Cable NOT included *(required, order separately).*

Axcess® E ROI Swingarc™ Boom-Mounted Wire Feeders
#300 727
8 ft (2.4 m) Single-Wire
#300 728
12 ft (3.7 m) Single-Wire
#300 729
16 ft (4.9 m) Single-Wire

Swingarc boom-mounted semiautomatic 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.

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

Model	Type of Input Power	Connection to Motor	Connection to Power Source	Dimensions	Ship Weight
ROI E	Supplied from power source — 40 VDC (motor), 24 VDC (interface)	Motor Control Cable — 20, 30, or 50 ft *(Order separately)*	DeviceNet Interconnecting Feeder Control Cable — 5, 10, 25, or 50 ft *(Order separately)*	H: 13 in (330 mm) W: 7 in (178 mm) D: 7 in (178 mm)	12 lb (5.4 kg)

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

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

AA-40GB Wire Drive Motor Assembly
#195 426 Left-Hand Drive
#195 515 Right-Hand Drive
The AA-40GB Wire Drive Motor Assembly with OCP (Over Current Protection) 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 ft volt-sense lead.

Model	Gas Valve	Type of Input Power	Connection to ROI E	Wire Feed Speed Range*	Wire Diameter Range	Dimensions	Ship Weight
AA-40GB	Included and enclosed	40 VDC (from Axcess E)	Motor Control Cable — 20, 30, or 50 ft (Order separately)	50 – 1400 IPM (1.3 – 35.56 MPM)	.035 – 3/32 in (0.9 – 1.6 mm)	H: 8 in (203 mm) W: 12 in (305 mm) D: 10 in (254 mm)	23 lb (10.4 kg)

*This is the wire feed speed range while using MIG. With Pulsed MIG, the wire feed speed range may be more limited.

Genuine Miller Accessories

Axcess® E Field Upgrade Module
#300 641 Field
Upgrade your investment in standard Axcess equipment. Standard Axcess power sources can be upgraded to Axcess E systems with the addition of the Axcess E field upgrade module. This module comes with everything you need for installation.

Ethernet Network Connection Cables
#300 734 9.8 ft (3 m)
#300 735 16.4 ft (5 m)
#300 736 32.8 ft (10 m)
Industrial-grade 360° shielded Cat 5 Ethernet cable with conventional RJ45 overmoulded 4-pole connector on one end to connect to factory network, and industrial M12 overmoulded connector on the other end to attach to Axcess E power source. Cable supports 10/100 Mbits-per-second transmission rate.

DeviceNet Interconnecting Feeder Control Cables
#195 240 5 ft (1.5 m)
#195 241 10 ft (3 m)
#195 242 25 ft (7.6 m)
#195 243 50 ft (15.2 m)
These specially designed EMI (Electrical Magnetic Interference) protected and shielded feeder control cables are required, but not included with Axcess feeders or ROI. Determine length needed and order separately.
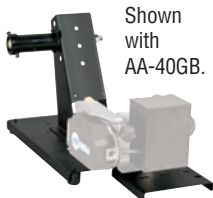
Motor Control Cables
#300 259 10 ft (3 m)
#300 097 20 ft (6.1 m)
#300 096 30 ft (9 m)
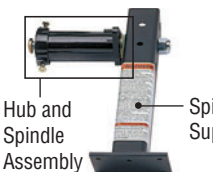**#300 098** 50 ft (15.2 m)
Includes overmolded connections on high-flex cables for optimal service life.

Shown with AA-40GB.

Axcess® E Feeder Base and Spool Support **#195 369**
Sheet metal construction. Allows mounting of AA-40GB motor (if desired) when using ROI option.

Hub and Spindle Assembly **#072 094**

Spindle Support **#092 989**

Hub and Spindle Assembly

Spindle Support

Volt-Sense Work Cable, 50 ft **#208 810**
Replacement cable. One cable supplied with every feeder or drive motor.

Industrial MIG 4/0 Kit **#300 390**
Consists of Smith® regulator/flowmeter 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.

MIGRunner™ XL Cart **#195 246**
Fits Axcess E 300 and 450 models.
Dimensions: 46-1/2" H x 42" W x 35" D. Wide cart with motorcycle-type handle grips. Holds two large gas cylinders and Coolmate™ 3 (when power source is mounted with face toward handles) for water-cooled torches. Power supply can be mounted in several directions while the feeder can be mounted on the top tray.

Running Gear Cylinder Rack **#300 408**
Fits Axcess E 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, single- or dual feeders, and Coolmate™ V3 can be mounted to the cart and secured.

Wire Reel Assembly **#108 008**

Spool Covers **#057 607**

Reel Covers **#058 256**
For 60 lb (27 kg) coil. Helps to protect the welding wire from dust and other contaminants.
Note: Reel and Spool Covers cannot be installed if the wire drive assembly is in a rotated position.
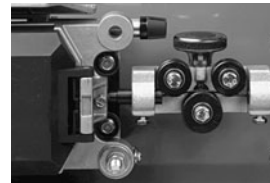
Turntable Assembly **#146 236**
Allows rotation of the feeder as the operator changes work positions. Reduces strain and bending on the gun cable.

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

Wire Straightener
#141 580
For .035 – .045 in (0.9 – 1.1 mm) diameter wire.
#141 581
For 1/16 – 1/8 in (1.6 – 3.2 mm) diameter wire.
Helps reduce the cast in wire to improve wire feeding performance and increase the service life of the gun liner and contact tip.

Dual Schedule Switches

DSS-8 **#079 693**
A 15 ft, two-position trigger switch which attaches to the gun handle and is used in place of the standard trigger for dual scheduling.

Adapter Cord **#157 364**
Required for use with DSS-8. 1ft, Y trigger cable that connects DSS switch and control box to the gun.

DSS-9M **#041 793**
A 15 ft, two-position slide switch which attaches to the gun handle and is used to select the desired welding condition for dual schedule purposes. The gun trigger operates as a standard trigger.

Miller®

Genuine Miller Accessories (continued)

Coolant Systems

For more information, see the Miller Coolant Systems 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 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ V3   #043 009 115 VAC
For use with water-cooled torches rated up to 500 amps. Vertical design conveniently mounts to Miller cylinder rack in place of one cylinder.

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 cases of four 1-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37°F (-38°C) or boiling to 227°F (108°C). Also contains a compound that resists algae growth.

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

Drive Roll Kits *Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include 4 drive rolls, the necessary guides and feature an anti-wear sleeve for inlet guide.*

Wire Size	"V" groove for hard wire	"U" groove for soft wire or soft-shelled cored wires	"V" knurled for hard-shelled cored wires	"U" cogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)
.023/.025 in (0.6 mm)	#151 024	—	—	—
.030 in (0.8 mm)	#151 025	—	—	—
.035 in (0.9 mm)	#151 026	#243 233	#151 052	—
.040 in (1.0 mm)	#161 190	—	—	—
.045 in (1.1/1.2 mm)	#151 027	#243 234*	#151 053	#151 070
.052 in (1.3/1.4 mm)	#151 028	#151 038	#151 054	#151 071
1/16 in (1.6 mm)	#151 029	#243 235	#151 055	#151 072
.068/.072 in (1.8 mm)	—	—	#151 056	—
5/64 in (2.0 mm)	—	#151 040	#151 057	#151 073
3/32 in (2.4 mm)	—	#151 041	#151 058	#151 074
7/64 in (2.8 mm)	—	#151 042	#151 059	#151 075
1/8 in (3.2 mm)	—	#151 043**	#151 060**	#151 076**

*Accommodates .045 and .047 (3/64 in) wire.   ** May require a low-speed, wire-feed drive-roll option.

Wire Guides

Wire Size	Inlet Guide	Intermediate Guide
.023 – .040 in (0.6 – 1.0 mm)	#150 993	#149 518
.045 – .052 in (1.1 – 1.4 mm)	#150 994	#149 519
1/16 – 5/64 in (1.6 – 2 mm)	#150 995	#149 520
3/32 – 7/64 in (2.4 – 2.8 mm)	#150 996	#149 521
1/8 in (3.2 mm)	#150 997	#149 522

Genuine Miller Services

Consulting Services

Field Application Support   #195 480
Axcess E 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.

Ordering Information

Semi-Automatic Equipment Options	Stock No.	Description	Qty.	Price
Axcess® E 300	**#907 440**	Power source only		
Axcess® E 450	**#907 439**	Power source only		
Axcess® E Field Upgrade Module	**#300 641**	Field. Upgrades standard semi-automatic power source to Axcess E		
Insight Centerpoint™	**#300 708**	Weld data monitoring system software		
Insight Reporter™	**#300 709**	Management reporting system client software		
Insight Reporter™ SQL Database	**#300 710**	Management reporting system database software		
Wire Feeder Options		See page 8 for connection diagram and required cables		
Axcess® E Single Feeder	**#300 677**	Bench/skid feeder — *order DeviceNet Interconnecting Feeder Control Cable separately*		
ROI Options		See page 8 for connection diagram and required cables		
Single ROI E	**#300 726**	Remote Operator Interface		
Axcess® E ROI Swingarc™ Boom	**#300 727** **#300 728** **#300 729**	8 ft (2.4 m) boom 12 ft (3.7 m) boom 16 ft (4.9 m) boom		
Wire Drive Motor Assembly Options		See page 8 for connection diagram and required cables		
AA-40GB Wire Drive Motor Assembly	**#195 426** **#195 515**	Left-hand wire drive assembly Right-hand wire drive assembly		
Installation Cables		See page 8 for connection diagram and required cables		
Ethernet Network Connection Cables	**#300 734** **#300 735** **#300 736**	9.8 ft (3 m) 16.4 ft (5 m) 32.8 ft (10 m)		
DeviceNet Interconnecting Feeder Control Cables	**#195 240** **#195 241** **#195 242** **#195 243**	5 ft (1.5 m) 10 ft (3 m) 25 ft (7.6 m) 50 ft (15.2 m)		
Motor Control Cables	**#300 259** **#300 097** **#300 096** **#300 098**	10 ft (3 m) 20 ft (6.1 m) 30 ft (9 m) 50 ft (15.2 m)		
Accessories				
Volt-Sense Work Cable	**#208 810**	Replacement 50 ft (15.2 m) cable. This cable is included with every feeder or drive motor		
Trigger Control Cable	**#300 129**	See page 8 for connection diagram		
Axcess® E Feeder Base/Spool Support	**#195 369**	Allows mounting of AA-40GB motor when using ROI option		
Hub and Spindle Assembly	**#072 094**			
Spindle Support	**#092 989**			
Industrial MIG 4/0 Kit	**#300 390**	Includes Smith regulator/flowmeter 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		
MIGRunner™ XL Cart	**#195 246**	Holds two cylinders, cooler, machine and feeder		
Running Gear Cylinder Rack	**#300 408**	Holds two cylinders, cooler, machine and feeder		
Wire Reel Assembly	**#108 008**			
Spool Covers	**#057 607**			
Reel Covers	**#058 256**			
Turntable Assembly	**#146 236**			
Hanging Bail (Electrically Isolated)	**#058 435**			
Wire Straightener		See page 10		
Dual Schedule Switches		See page 10		
Coolant Systems		See page 11		
Drive Roll Kit *(Required)*		See page 11		
Inlet/Intermediate Guides		See page 11		

Date:

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