

# Spoolmatic® Pro

## Air-Cooled Pistol-Grip Spool Gun

MIG Welding   
Spool Gun

### Quick Specs

#### Heavy Industrial Applications

Emergency vehicles Shipbuilding  
Recreational vehicles Tool boxes  
Trucks and trailers Railcars  
Boat/yacht building Fabrication  
Sign manufacturers Repair

#### Processes

MIG (GMAW)  
Pulsed MIG  
(GMAW-P)  
with pulsing  
power source

#### Wire Types

Aluminum  
Steel

#### Rated Output

200 A at 100% Duty Cycle

#### Net Weight

Gun only: 3.1 lb. (1.4 kg)  
Gun with 15 ft. cable: 10.4 lb. (4.7 kg)  
Gun with 30 ft. cable: 15.7 lb. (7.1 kg)

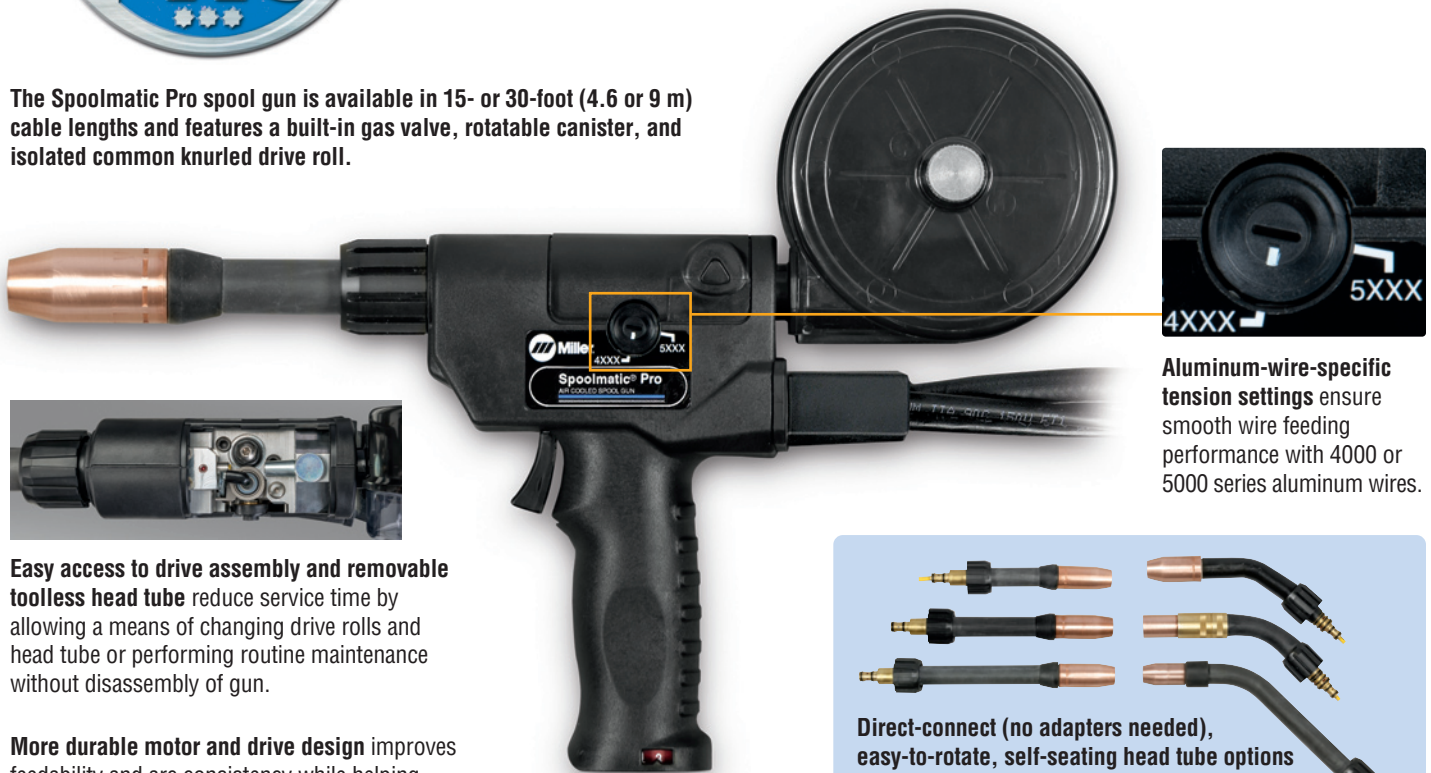


The industry's most reliable line of aluminum welding guns.

#### A complete system consists of the following:

- Spoolmatic Pro spool gun (Includes .035–1/16 in. knurled drive roll and two FasTip™ contact tips—.035 in. and 3/64 in.)
- WC-24 or WC-115 weld control (Required unless using a machine that allows direct hookup.)
- Recommended Miller 14-pin power source (See page 6.)

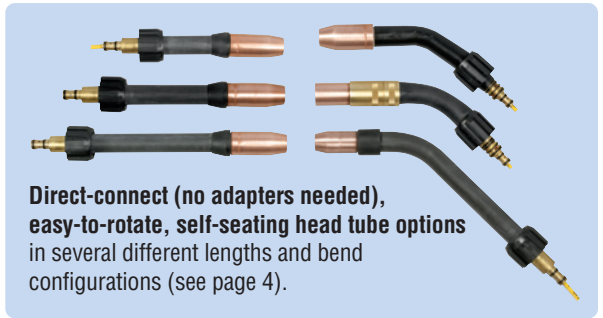
The Spoolmatic Pro spool gun is available in 15- or 30-foot (4.6 or 9 m) cable lengths and features a built-in gas valve, rotatable canister, and isolated common knurled drive roll.



Easy access to drive assembly and removable toolless head tube reduce service time by allowing a means of changing drive rolls and head tube or performing routine maintenance without disassembly of gun.

More durable motor and drive design improves feedability and arc consistency while helping reduce downtime and maintenance costs associated with complex drive systems.

Aluminum-wire-specific tension settings ensure smooth wire feeding performance with 4000 or 5000 series aluminum wires.



Direct-connect (no adapters needed), easy-to-rotate, self-seating head tube options in several different lengths and bend configurations (see page 4).



Guns are warrantied for one year, parts and labor.



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## Specifications (Subject to change without notice.)



Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Maximum Spool Size Capacity	Gun Dimensions	Net Weight
200 A at 100% duty cycle	70–900 ipm (1.8–23 m/min.) dependent on control box used	Aluminum*: .030–1/16 in. (0.8–1.6 mm) Hard wire: .030–.045 in. (0.8–1.1 mm)	4 in. (102 mm)	H: 10.75 in. (273 mm) W: 2.5 in. (64 mm) L: 15.375 in. (390 mm)	Gun only: 3.1 lb. (1.4 kg) Gun with 15 ft. cable: 10.4 lb. (4.7 kg) Gun with 30 ft. cable: 15.7 lb. (7.1 kg)

\*Wire kit **230708** required to run 1/16-inch (1.6 mm) wire.

## Standard Replacement Consumables

Aluminum Wire Size	FasTip™ Contact Tip (Qty. 25)	Drive Rolls	Idler Rolls	Head Tube Liner 4 in. (102 mm)
.030 in. (0.8 mm)	<b>206186</b> .041 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
.035 in. (0.9 mm)	<b>206187</b> .047 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
.040 in. (1.0 mm)	<b>206188</b> .053 in. ID	<b>227434</b>	<b>227439</b>	<b>M1272</b>
3/64 in. (1.2 mm)	<b>206189</b> .061 in. ID	<b>227434</b>	<b>227439</b>	<b>M1273</b>
1/16 in. (1.6 mm)	<b>206191</b> .071 in. ID	<b>227434</b>	<b>230710</b>	<b>M1273</b>

## Standard Consumables – FasTip™ Series

### Gas Diffusers



**229670** 1/8-inch tip recess (Standard)  
For heavy-duty FasTip contact tips.

**230678** 1/4-inch tip recess  
For heavy-duty FasTip contact tips.

**230679** Flush tip  
For heavy-duty FasTip contact tips.

### FasTip Contact Tips (25 per package)



#### Heavy-Duty (Aluminum Wire)

**206186** .030 in. (0.8 mm)  
**206187** .035 in. (0.9 mm)  
**206188** .040 in. (1.0 mm)  
**206189** 3/64 in. (1.2 mm)  
**206191** 1/16 in. (1.6 mm)

#### Tapered (Aluminum Wire)

**209026** .030 in. (0.8 mm)  
**209027** .035 in. (0.9 mm)  
**209029** 3/64 in. (1.2 mm)  
**206030** 1/16 in. (1.6 mm)

### Nozzles

#### Screw-On Brass

**199610** 1/2 in. orifice, tapered  
**199611** 3/4 in. orifice, straight  
**199612** 3/4 in. orifice, straight HD  
**199613** 5/8 in. orifice, tapered  
**199614** 5/8 in. orifice, tapered HD

#### Screw-On Copper

**199615** 1/2 in. orifice, tapered  
**199616** 3/4 in. orifice, straight  
**199617** 3/4 in. orifice, straight HD  
**198855** 5/8 in. orifice, tapered  
**199618** 5/8 in. orifice, tapered HD  
**207313** 5/8 in. orifice, tapered 15/16 O.D.  
**209035** 3/8 in. orifice, tapered  
**209036** 1/2 in. orifice, tapered

# Optional Consumables – Centerfire™ Series

**Insulator** 10012  
4323R

**Diffuser** D-1AP Large  
DS-1AP Small

### XR™-Pistol-Pro Diffuser Conversion Kits

for .035–1/16 in. aluminum

**230669** For D-1AP diffuser

**230670** For DS-1AP diffuser

Diffuser kits must be used to convert to Centerfire™ Series consumables. Kit includes diffuser and head tube liners.

### Aluminum-Specific T Series Contact Tips

**T-035AL** .035 in. (0.9 mm)

**T-047AL** .047 in. (1.2 mm)

**T-062AL** 1/16 in. (1.6 mm)

### Large Nozzles

**N-3414C** Copper, 3/4 in. I.D., 1/4 in. tip recess

**N-3418B** Brass, 3/4 in. I.D., 1/8 in. tip recess

**N-3414B** Brass, 3/4 in. I.D., 1/4 in. tip recess

**N-5814C** Copper, 5/8 in. I.D., 1/4 in. tip recess

**N-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess

**N-5814B** Brass, 5/8 in. I.D., 1/4 in. tip recess

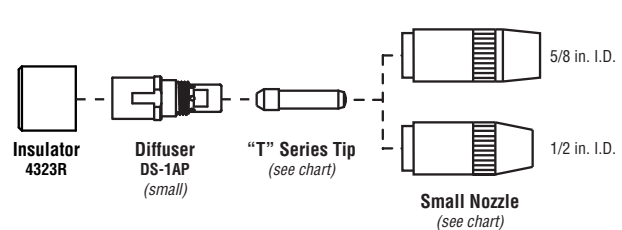
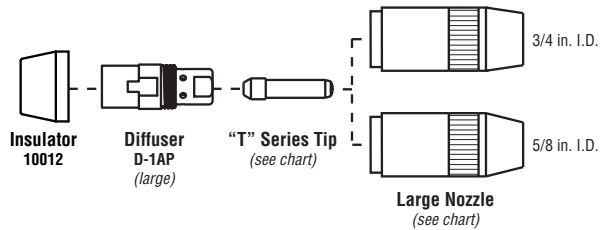
### Small Nozzles

**NS-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess

**NS-1218B** Brass, 1/2 in. I.D., 1/8 in. tip recess

**NS-1200B** Brass, 1/2 in. I.D., flush tip

**NST-3818B** Brass, 3/8 in. I.D., 1/8 in. tip recess



## Optional Head Tube Assemblies



**45 Degree/4 Inch**  
255037 Air-cooled



**180 Degree/4 Inch**  
(standard on Spoolmatic® Pro)  
255716 Air-cooled



**60 Degree/6 Inch**  
with Centerfire™  
246301 Air-cooled



**45 Degree/6 Inch**  
255040 Air-cooled



**180 Degree/6 Inch**  
258476 Air-cooled



**180 Degree/4 Inch with Centerfire™**  
258474 Air-cooled



**60 Degree/4 Inch**  
231519 Air-cooled



**180 Degree/8 Inch**  
255042 Air-cooled

### Heavy-Duty Head Tube Assemblies

For high-duty-cycle applications.



**60 Degree/6 Inch**  
231518 Air-cooled



**45 Degree/10 Inch**  
**Tight Access**  
258295 Air-cooled  
For hard-to-reach welds  
where a smaller nozzle  
and longer reach is needed.

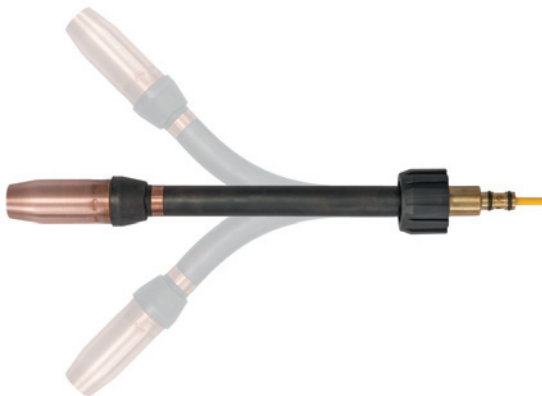


**45 Degree/6 Inch**  
**Heavy-Duty**  
262206 Air-cooled

**60 Degree/6 Inch Heavy-Duty**  
262207 Air-cooled



**180 Degree/6 Inch Heavy-Duty**  
262208 Air-Cooled



**Flex Neck/10 Inch**  
267517 Air-cooled  
Ideal for hard-to-reach welds.

## Liners for Optional Head Tube Assemblies

### Fastip™ Liners for Spoolmatic® Pro and XR™-Pistol-Pro

#### (4-inch assemblies)

**M1272** .030–.040 in. (0.8–1.0 mm)

**M1273** 3/64 and 1/16 in. (1.2 and 1.6 mm)

#### (6-inch assemblies)

**M1430** .030–.040 in. (0.8–1.0 mm)

**M1365** 3/64 and 1/16 in. (1.2 and 1.6 mm)

#### (8-inch assemblies)

**M1337** .030–.040 in. (0.8–1.0 mm)

**M1338** 3/64 and 1/16 in. (1.2 and 1.6 mm)

### Bernard™ Quik Tip™ Tight-Access Liners for Spoolmatic® Pro and XR™-Pistol-Pro

#### (10-inch assemblies)

**M1427** .030–.040 in. (0.8–1.0 mm)

**M1421** 3/64 and 1/16 in. (1.2 and 1.6 mm)



### Universal Teflon® Liner Kit

**262707** .030–.040 in. (0.8–1.0 mm)

black liners

**262705** 3/64 and 1/16 in. (1.2 and 1.6 mm)

yellow liners

Includes five 14-inch liners and cutter. Liners can be cut to correct length for any pistol or gooseneck-style gun. Cutter provides a straight, clean cut to reduce shaving and feeding problems.

**Teflon® Liner Cutter 258863**

## Genuine Miller® Accessories

### Hose and Cable Extension Kits

**132228** 25 ft. (7.6 m)

**132229** 50 ft. (15 m)

Extends Spoolmatic Pro away from the control box. Convenient plug-in connections. Includes gas hose, control cord, and weld power cable with International-style insulated connector.

### Leather Cable Cover

**241159** 15 ft. (4.6 m)

**241160** 30 ft. (9 m)

Protects gun hose and cable assembly from wear and abrasion. Features full-length hook-and-loop closure for ease of maintenance or replacement.



### One-Pound (0.5 kg) Spool Canister 132230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12-inch (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. Canister accommodates 4-inch (102 mm) spools of wire.



### 50-Degree Curved Nozzle Kit-A 264064

Directly attaches to Spoolmatic Pro, XR-Aluma-Pro or XR-Pistol-Pro for access to confined weld joint areas. Used with .030–1/16 inch (0.8–1.6 mm) wire. Kit includes two of each size contact tip to accommodate all wire sizes, nozzle adapter kit and curved nozzle. Uses standard straight head tube liner.

### Replacement Contact Tips for 50-Degree Curved Nozzle

**148155** .030 and .035 in. (0.8 and 0.9 mm) wire

**148154** .047 in. (1.2 mm) wire

**148156** 1/16 in. (1.6 mm) wire

### 50-Degree Curved Nozzle Insulator Kit 264066

Sleeve goes over center of curved nozzle to protect operator from heat. For use with 50-Degree Curved Nozzle Kit-A.

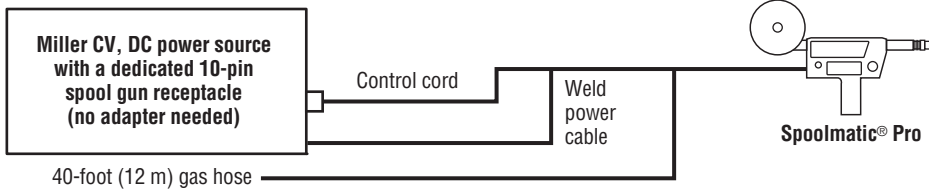
### 1/16-Inch (1.6 mm) Wire Kit 230708

Specially designed for 1/16-inch wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16-inch wires. Not included with standard Spoolmatic Pro gun.

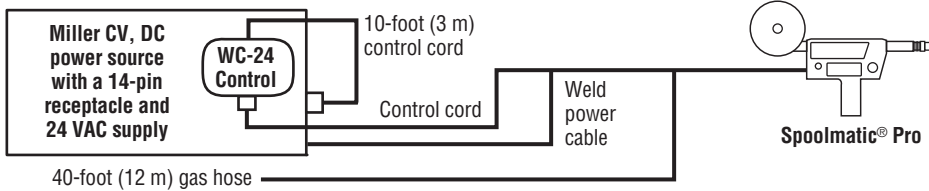
# Typical Installations

Note: Cords and cables are supplied unless noted otherwise on drawings below. Refer to Owner's Manual for complete installation instructions.

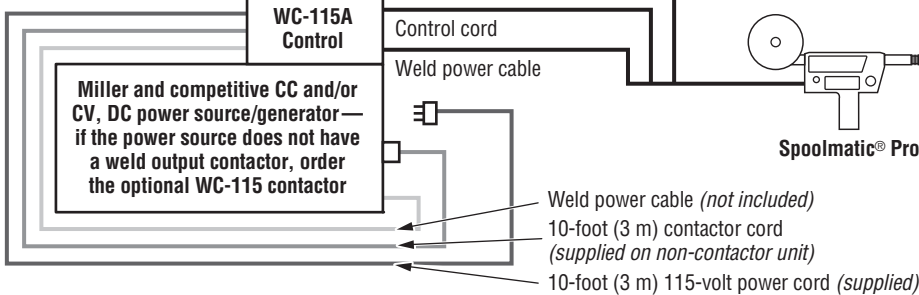
## Direct Hook-Up



## Hook-Up with WC-24



## Hook-Up with WC-115A



## Spoolmatic Pro Hook-Up Recommendations

CV Power Supply	Spoolmatic Pro
Bobcat™ 200 Air Pak Bobcat™ 265 Series Trailblazer® 330 Series	Direct hook-up
AlumaPower™ MPa XMT® Series Big Blue® Series (except Big Blue 450 Duo CST) CP Series* Deltaweld® Series* Dimension™ Series* Invision™ MPa* Regency® 250* Shopmaster™* PipePro® 304*	Need WC-24 <b>137549</b>
Bobcat™ 225*, 250*, 260* Miller Legend® 302*	Need WC-115A <b>137546011</b>

\*Discontinued product.



### WC-24 Weld Control 137549

Packaged in a compact, lightweight, non-metallic enclosure, the WC-24 easily mounts directly on the power source. Designed for use with Miller constant-voltage power sources with 14-pin receptacles and supplying 24 VAC. The control includes a board-mounted potentiometer which can alter the drive motor acceleration rate to optimize arc starting performance.

#### Important note:

To connect the Spoolmatic Pro gun and WC-24 control to older-style Miller or competitive CV power sources that do **NOT** have a 24 VAC supply, the PSA-2 Control **141604** is required.



### WC-115A Weld Control

**137546** Without contactor  
**137546011** With contactor  
Operates on 115-volt power and designed primarily for constant-current DC power sources. Can also be used with constant-voltage (CV) power sources or DC engine drives supplying 115 volts. Used with a constant-current (CC) source the control circuit functions

in a voltage-sensing mode, and with a CV source it functions as a constant-speed circuit. Includes wire run-in and drive motor acceleration controls which ensure optimum arc starting performance. Comes with a 10-foot (3 m), wall-type plug power cord.

#### Important notes:

To connect the WC-115A control to older-style Miller power sources having Hubbell or 5-pin contactor control receptacles, the appropriate connector must be ordered **separately**.

To connect to older-style Miller CC power sources having a two-socket Hubbell connector, order plug **039618**.

If power source has a Miller 5-pin receptacle, order **039273** and **039685**.

To connect to older-style Miller CV power sources having a two-prong Hubbell connector, order plug **039635**.

These connectors are to replace the 14-pin connector on the 10-foot interconnect contactor cord. Internal wiring changes may be necessary.



# Ordering Information

**Important notes:**

Spoolmatic Pro guns require a WC-24 or WC-115 weld control, unless used on a machine that allows direct hookup. Refer to chart on page 6.

## Recommended Power Sources

AlumaPower™ MPa  
See literature no. DC/34  
(For synergic use with AlumaFeed™)

XMT® Series  
See literature no. DC/18.93, DC/18.94, DC/18.96 and DC/18.98

Bobcat™ 200 Air Pak™  
See literature no. ED/4.36

Bobcat™ 265  
See literature no. ED/4.46

Trailblazer® 330 Series  
See literature no. ED/4.76 and ED/4.86

Big Blue® Series  
See literature no. ED/5.7, ED/5.8, ED/11.0, ED/11.5 and ED/14.0

*Note: Other power sources may be used.*

Equipment	Stock No.	Description	Qty.	Price
Spoolmatic® Pro Spool Gun	301147	15 ft. (4.6 m) cable		
	301148	30 ft. (9 m) cable		
WC-24 Weld Control	137549			
WC-115A Weld Control	137546	Without contactor		
	137546011	With contactor		
<b>Consumables and Accessories</b>				
Consumables		See pages 2–3		
Optional Head Tube Assemblies		See page 4		
Liners for Opt. Head Tube Assemblies		See page 5		
Hose and Cable Extension Kits	132228	25 ft. (7.6 m)		
	132229	50 ft. (15 m)		
Leather Cable Cover	241159	15 ft. (4.6 m)		
	241160	30 ft. (9 m)		
One-Pound Spool Canister	132230			
50-Degree Curved Nozzle Kit-A	264064			
Replacement Contact Tips for 50-Degree Curved Nozzle		See page 5		
50-Degree Curved Nozzle Insulator Kit	264066	For use with 50-Degree Curved Nozzle Kit-A		
1/16-Inch (1.6 mm) Wire Kit	230708	Required when running 1/16 in. wire		

Date:

**Total Quoted Price:**

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