**Quick Specs**

- **Light Industrial Applications**
  - Light Fabrication
  - Maintenance and Repair
  - Auto Body
  - Farm/Home

- **Processes**
  - MIG (GMAW)
  - Flux Cored (FCAW)

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**The Power of Blue.**

**Auto-Set™**

- The right settings automatically.
  - Set the wire diameter, a blue light shows that Auto-Set™ is activated.
  - Dial in the thickness of what you're welding
  - Start welding with the exact parameters you need!

**Infinite voltage control** gives you the flexibility to manually set the machine when welding aluminum, stainless steel, or anytime you want to set your own parameters on mild steel.

**Smooth-Start™** provides a smooth, spatter-free start. It's the best-starting machine in the small MIG machine category. No pop gun starts and no spatter to clean up.

**Durable cast-aluminum drive system** incorporates dual-groove quick-change drive roll and spring-loaded tension arm with calibrated tension knob, all designed to make set up easier and faster.

**Thermal overload protection** shuts down unit and activates the over temperature light if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.

**Miller’s “Tip Saver” short circuit protection** shuts down output when tip is shorted to the work. Extends contact tip life and protects internal components from damage.

**Trigger reset** permits quick reset at torch rather than unit.

**Self-resetting motor protection circuit** eliminates the need to find and replace fuses.

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**Inputs Power**

- 115 V, 20 A, 60 Hz, Single-Phase

**Rated Output**

- 90 A at 18 VDC, 20% Duty Cycle
- 63 A at 21 VDC, 20% Duty Cycle, CSA

**Amperage Range**

- 30 – 140 A

**Max. Open-Circuit Voltage**

- 28

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**Welder is warranted for 3 years, parts and labor. Original main power rectified parts are warranted for 5 years. Gun warranted for 90 days, parts and labor.**

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**TRUE BLUE® 5 YEAR WARRANTY**

Welder is warranted for 3 years, parts and labor. Original main power rectified parts are warranted for 5 years. Gun warranted for 90 days, parts and labor.
**Auto-Set™ Feature**

The Millermatic® 140 Auto-Set™ offers all the benefits of a standard MIG machine, but adds Auto-Set to eliminate the guesswork. Use Auto-Set when you want the speed, convenience and confidence of pre-set controls. Simply set the wire diameter, set the material thickness, and go! The Auto-Set control automatically sets your welder to the proper parameters. It is available when welding mild steel with solid wire and only works with .024 and .030 solid wires and C25 shielding gas (75% Argon, 25% CO₂).

When not within the Auto-Set profiles, use the manual mode to set the weld parameters you desire. The parameter door chart lists voltage and wire feed speed settings options.

**Auto-Set Mode**

- Turn wire speed control fully clockwise to select Auto-Set mode. Set the wire diameter to either .024 or .030 in.
- Light indicates Auto-Set mode is activated.
- Set the material thickness within Auto-Set range for 24 gauge through 3/16 in mild steel. The welder automatically sets itself to proper parameters, and is ready to weld!

**Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Rated Output</th>
<th>Amperage Range</th>
<th>Max. Open-Circuit Voltage</th>
<th>Amperes Input at Rated Output, 60 Hz</th>
<th>Wire Feed Speed</th>
<th>Dimensions</th>
<th>Net Weight</th>
<th>Ship Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>90 A, 18 VDC at 20% Duty Cycle</td>
<td>30 – 140 A</td>
<td>28</td>
<td>20</td>
<td>2.8</td>
<td>2.4</td>
<td>15 – 390 IPM (0.4 – 9.9 m/min); 35 – 420 IPM at no load (0.9 – 10.7 m/min)</td>
<td>H: 15-3/4 in (400 mm)</td>
</tr>
<tr>
<td>63 A, 21 VDC at 20% Duty Cycle, CSA</td>
<td></td>
<td></td>
<td>15</td>
<td>2.1</td>
<td>1.8</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

**Control Panel**

1. Wire Feed/Wire Diameter Speed Control
2. Auto-Set Light
3. Voltage Control/Material Thickness
4. Over Temperature Light
5. Power Switch
6. Trigger Lead Switch Connection
7. Plastic Hub with Retaining Ring for 8 in Spools (shaft also accepts 4 in spools)
8. Storage Holes for Spare Tips
9. Polarity Changeover Terminals
10. Calibrated Tension Knob
11. Springloaded Tension Arm
12. T-Knob (secures torch)
13. Dual-Groove Quick-Change Drive Roll

**Performance Data**

**DUTY CYCLE CHART**

**VOLT/AMP CURVES**
**Genuine Miller Accessories**

**Spoolmate™ 100 Series Spool Gun**

#300 371
Direct connect spool gun for all Millermatic 140, 180, 211 and Passport Plus models. Handles .030 – .035 in (0.8 – 0.9 mm) aluminum and .023 – .035 in (0.6 – 0.9 mm) steel/stainless steel wires. Rated at 135 amps, 30% duty cycle. Includes 12 ft (3.7 m) cable assembly and custom carrying case.

**M-100 Replacement Gun**

#248 282
10 ft (3 m). Shipped with liner #194 011.

**Millermatic Protective Cover**

#195 149

**Running Gear/ Cylinder Rack**

#770 187
Heavy-duty construction. Convenient handle on front with cable holders. For gas cylinders no larger than 7 in (178 mm) diameter, maximum weight 100 lb (45 kg).

**Small Running Gear/ Cylinder Rack**

#300 425
Durable construction. For gas cylinders no larger than 7 in (178 mm) diameter, maximum weight 75 lb (34 kg).

**Purchase the Millermatic 140 Auto-Set package (#907 335-01-1) and receive the Millermatic 140 Auto-Set and Small Running Gear/Cylinder Rack (#300 425) packaged together!**

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**Consumables**  *(Order from Miller Service Parts.)*

### For M-100 Gun

- **Contact Tips**
  - #087 299 .024 in (0.6 mm)
  - #000 067 .030 in (0.8 mm)
  - #000 068 .035 in (0.9 mm)
  - #000 069 .045 in (1.2 mm)

- **Contact Tip Adapter**
  - #169 716

- **Replacement Liners**
  - #194 010 .024 in
  - #194 011 .030 – .035 in (standard)
  - #194 012 .035 – .045 in

- **Nozzle**
  - #169 715
  - 1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip (standard).

- **Gasless Flux Cored Nozzle**
  - #226 190
  - For use with self-shielding flux cored wires. Improves visibility, eases access in tight corners, protects tip adapter/gas diffuser from spatter and from shorting to the work piece. For use with the M-100 gun.

- **Drive Rolls — Quick Change**
  - **Dual Groove, V-Smooth**
    - #220 179
    - For .024, .030 and .035 in (0.6, 0.8 and 0.9 mm) wire.
  - **Dual Groove, V-Knurled**
    - #202 926
    - For .030/.035 in (0.8/0.9 mm) or .045 in (1.2 mm) flux cored wire.

### For Spoolmate™ 100 Series

- **Contact Tips (5 per package)**
  - #199 730 For .024 in (0.6 mm) wire.
  - #186 419 For .030 in (0.8 mm) wire.
  - #186 406 For .035 in (0.9 mm) wire.

- **Nozzle**
  - #186 405

- **Drive Roll (1)**
  - #186 413
  - For .030/.035 in (0.8/0.9 mm) wire.

- **Push Roll (1)**
  - #186 414
  - For .030/.035 in (0.8/0.9 mm) wire.

### M-Series Gun Consumable Kits

- #234 607 .024 in (0.6 mm)
- #234 608 .030 in (0.8 mm)
- #234 609 .035 in (0.9 mm)
Each kit contains 10 contact tips, 1 nozzle, and 1 contact tip adapter.

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**Spoolmate™ 100 Series Spool Gun**

#300 371

**Contact Tips**

#087 299 .024 in (0.6 mm)
#000 067 .030 in (0.8 mm)
#000 068 .035 in (0.9 mm)
#000 069 .045 in (1.2 mm)

**Contact Tip Adapter**

#169 716

**Replacement Liners**

#194 010 .024 in
#194 011 .030 – .035 in (standard)
#194 012 .035 – .045 in

**Nozzle**

#169 715
1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip (standard).

**Millermatic Protective Cover**

#195 149

**Running Gear/ Cylinder Rack**

#770 187

**Small Running Gear/ Cylinder Rack**

#300 425

**Purchase the Millermatic 140 Auto-Set package (#907 335-01-1) and receive the Millermatic 140 Auto-Set and Small Running Gear/Cylinder Rack (#300 425) packaged together!**
### Typical Installations

- **MIG (GMAW) or Flux Cored (FCAW) Basic Equipment**
  - MIG Gun
  - Shielding Gas Cylinder

- **Aluminum MIG (GMAW) Basic Equipment**
  - MIG Gun
  - Shielding Gas Cylinder
  - Optional Spool Gun

### Ordering Information

<table>
<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>Millermatic® 140 Auto-Set™</td>
<td>#907 335</td>
<td>115 V, 60 Hz</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Millermatic® 140 Auto-Set™ with Small Running Gear</td>
<td>#907 335-01-1</td>
<td>Power source packaged with #194 776 Sm Running Gear/Cyl Rack</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

- **Guns**
  - Spoolmate™ 100 Series Spool Gun | #300 371 | Includes 12 ft (3.7 m) cable and custom carrying case | | |
  - M-100 Gun | #248 282 | 10 ft (3 m), .030 – .035 in (0.8 – 0.9 mm) | | |

- **Consumables (Order from Miller Service Parts.)**
  - Contact Tips
    - See page 3
  - Contact Tip Adapter
    - See page 3
  - Replacement Liners
    - See page 3
  - Nozzles
    - See page 3
  - Gasless Flux Cored Nozzle | #226 190 | .024 in (0.6 mm) | | |
  - M-Series Gun Consumable Kits
    - #234 607 | .030 in (0.8 mm) |
    - #234 608 | .035 in (0.9 mm) |

- **Drive Rolls**
  - See page 3

- **Accessories**
  - Running Gear/Cylinder Rack | #770 187 |
  - Small Running Gear/Cylinder Rack | #300 425 |
  - Protective Cover | #195 149 |
  - CO2 Regulator/Flow Gauge | #212 492 | Required if using 100% CO2 Gas. Order from Miller Service Parts |
  - Material Thickness Gauge | #229 895 |
  - Flux Cored Wire |
  - Solid Wire |
  - Shielding Gas Cylinder |
  - Helmet/Gloves/Scratch Brush |

| Date: | Total Quoted Price: |

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