

22A and 24A

Issued March 2006 • Index No. M/11.0

**24 Volt Constant-Speed
Wire Feeder** 

Quick Specs

Industrial Applications

Heavy- or Light-Duty
Fabrication Shops
Trailer Manufacturers
Furniture Manufacturers
Automotive Products
Educational Institutions

Processes

MIG (GMAW)
Flux Cored (FCAW)
Gas- and Self-Shielded

For use with CV power sources

Input Power 24 VAC, 7 A, 50/60 Hz

Electrode Wire Diameter Capacity

22A: .023–5/64 (0.6–2.0 mm)
24A: .023–3/32 (0.6–2.4 mm)

Wire Speed 75–750 IPM (1.9–19 m/min)

Weight **22A:** 36 lb (15.4 kg) **24A:** 40 lb (18 kg)

The Power of Blue.®

Wire feed speed range is 75–750!

This offers a wider operating range than the competition.

Trigger hold control

allows operator to make long extended welds without having to hold gun trigger.

Gear-driven drive rolls

offer smooth, positive and accurate wire feed with long, uninterrupted service life. 24A has four drive rolls for larger wire diameters.

On-board burnback and motor ramp control

offers unmatched starting and stopping performance on a variety of power sources. This helps to ensure positive arc starting performance.



16 gauge sheet metal housing is robust in rough service applications and less prone to damage.

Run-in standard on 24A for better arc-starting performance on a variety of wires. Optional for 22A.

Remote voltage control is standard on 24A. Parameter adjustments can be made in weld cell or at a remote location. Optional for 22A.

Both include performance-matched Bernard® Q-400 MIG gun, .035/.045 in drive roll and Centerfire™ contact tips.

Specifications (Subject to change without notice.)

CV

| Model | Input Power | Electrode Wire Diameter Capacity | Wire Speed | Dimensions | Net Weight |
|-------|--------------------------|----------------------------------|---------------------------|---|-----------------|
| 22A | 24 VAC, 7 A, 50/60 Hz | .023–5/64 in (0.6–2.0 mm) | 75–750 IPM (1.9–19 m/min) | H: 11 in (279 mm) W: 10-3/4 in (273 mm) D: 23-1/2 in (597 mm) | 36 lb (15.4 kg) |
| 24A | | .023–3/32 in (0.6–2.4 mm) | | | 40 lb (18 kg) |

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

TRUE BLUE
3YR. WARRANTY

Wire feeder is warranted for 3 years, parts and labor.

MADE IN **USA**
APPLETON, WI **USA**



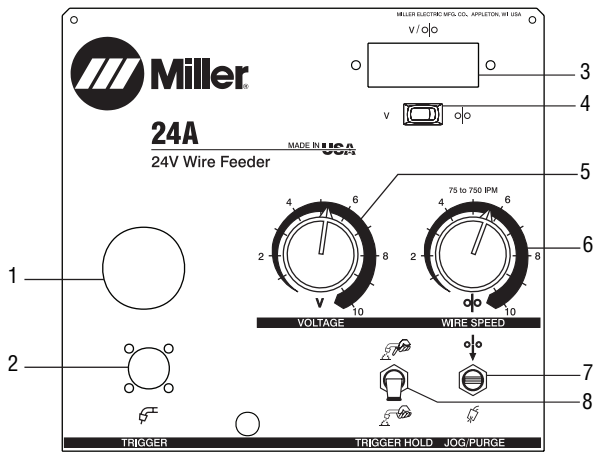
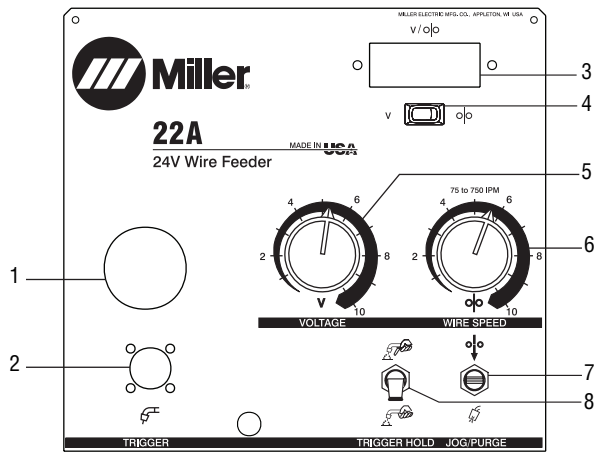
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Control Panel



- 1. Gun Connection
- 2. Trigger Receptacle
- 3. Voltage/Wire Speed Meter*
- 4. Meter Selection Switch*
- 5. Remote Voltage Control**

- 6. Wire Speed Control
 - 7. Jog/Purge
 - 8. Trigger Hold (On/Off)
- Power On/Off (on rear panel)

*Optional

**Optional on 22A, standard on 24A

Drive Roll Kits (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include 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) | |
|-----------------------|--------------------------|----------------|--|----------------|--|----------------|--|----------------|
| | 22A 2-Roll Kit | 24A 4-Roll Kit | 22A 2-Roll Kit | 24A 4-Roll Kit | 22A 2-Roll Kit | 24A 4-Roll Kit | 22A 2-Roll Kit | 24A 4-Roll Kit |
| .023/.025 in (0.6 mm) | #087 131 | — | — | — | — | — | — | — |
| .030 in (0.8 mm) | #079 594 | #046 780 | — | — | — | — | — | — |
| .035 in (0.9 mm) | #079 595 | #046 781 | #044 749 | #044 750 | #079 606 | #046 792 | — | — |
| .040 in (1.0 mm) | #161 189 | #161 190 | — | — | — | — | — | — |
| .045 in (1.1/1.2 mm) | #079 596 | #046 782 | #079 599* | #046 785 | #079 607 | #046 793 | #083 318 | #083 319 |
| .052 in (1.3/1.4 mm) | #079 597 | #046 783 | #079 600 | #046 786 | #079 608 | #046 794 | #083 317 | #083 320 |
| 1/16 in (1.6 mm) | #079 598 | #046 784 | #079 601 | #046 787 | #079 609 | #046 795 | #079 614 | #046 800 |
| .068/.072 in (1.8 mm) | — | — | — | — | #089 984 | #089 985 | — | — |
| 5/64 in (2.0 mm) | — | — | #079 602 | #046 788 | #079 610 | #046 796 | #079 615 | #046 801 |
| 3/32 in (2.4 mm) | — | — | — | #046 789** | — | #046 797** | — | #046 802** |

*Accommodates .045 and .047 in (3/64 mm) wires.

**3/32 in inlet guide (#194 264) is required when using 3/32 in drive rolls.

Nylon Wire Guides for Feeding Aluminum Wire (Order from Miller Service Parts.)

| Wire Size | Inlet Guide |
|-----------------------|-------------|
| .035-.047 in (1.2 mm) | #151 203 |
| 1/16 in (1.6 mm) | #151 205 |

Note: "U" groove drive rolls are recommended when feeding aluminum wire.

Genuine Miller Options and Accessories

Digital Display V/WFS #186 498 Field
Dual-function, back-lit LCD digital meter with selector switch. The digital meter allows the wire feed speed to be preset in inches per minute or meters per minute. The voltage function, if used with a current manufactured Miller electronically controlled constant voltage power source, allows the arc voltage to be preset and monitored on the digital display. When used with voltage control #194 211.

Voltage Control #194 211 Field
Standard on 24A. Installs in front panel of the feeder to allow remote voltage control of most Miller electrically controlled CV or CC/CV power sources.

Note: The field kit voltage control includes a 10 ft (3 m) cord that replaces the standard cord supplied with the feeder.

Run-In Control #193 391 Field
Standard on 24A. A separate wire feed speed adjustment to control wire speed prior to arc initiation. This control may be beneficial to aid arc starting with certain types of power sources.

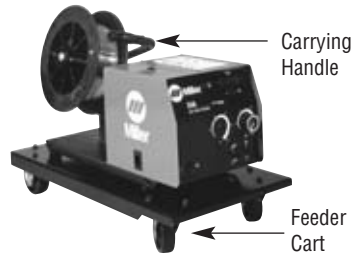
Preflow/Postflow and Spot Control #186 496 Field
Installs inside feeder under an easy access hinged cover. Provides up to 5 seconds of spot weld time and has adjustable timers (0.25 to 5 seconds) for controlling gas flow prior to arc initiation and after completion of weld.



Carrying Cart #056 301
A utility cart for the wire feeder and other miscellaneous welding supplies. Height: 34 in (863 mm) Lower tray height: 9 in (228 mm) Shipped disassembled.



Feeder Cart #142 382
A low-profile, creeper cart which allows the operator to easily move the feeder around the work area. Shipped disassembled.



Carrying Handle #193 762
For lifting and moving feeder. (Cannot be used with wire reel assembly #108 008.)



Hanging Bail #058 435
Suspends feeder over the work area.

Reel Cover #195 412
For 60 lb (27.2 kg) coil.

Spool Cover #057 607
For 12 in (304 mm) spool.



Wire Reel Assembly #108 008
For 60 lb (27.2 kg) coil of wire. (Cannot be used with carrying handle #193 762.)

Turntable Assembly #146 236
Allows rotation of feeder as operator changes work positions. This reduces strain and bending on gun cable.

Spool Adapter #047 141
For use with 14 lb (6.4 kg) spool of Lincoln self-shielding wire.



PSA-2 Control #141 604
Required when using the 22A wire feeder with power sources having only 115 VAC available. The PSA-2 control can be conveniently mounted on the wire feeder or positioned at the power source. The control is equipped with a 14-pin receptacle for direct connection of the wire feeder control cord. A short cord with a 4-pin Amp plug is hard wired to the control. A 10 ft (3 m) interconnecting cord with a 4-pin Amp for connection to the PSA-2 and Hubbell connectors for older-style Miller CV power sources is included. The PSA-2 control can also be used with competitive power sources requiring a contact closure for contactor control.

Extension Cords
#122 973 25 ft (7.6 m)
#122 974 50 ft (15 m)
#122 975 75 ft (23 m)

These extension cords can be added to the standard 10 ft cord to extend feeder farther from the power source.

2/0 MIG Welding Accessory Kit #173 856
25 ft (7.6 m). Includes gas hose, weld cable and work cable with clamp.

Ordering Information

| Power Source and Options | Stock No. | Description | Qty. | Price |
|-----------------------------------|---|---|------|-------|
| 22A | #193 066 #193 066-01-1 #193 066-02-2 | With run-in control With digital display and voltage control | | |
| 24A | #195 112 | | | |
| Drive Roll Kit | | See table on page 2 | | |
| Digital Display Meter | #186 498 | Field. | | |
| Voltage Control | #194 211 | Field. Standard on 24A | | |
| Run-In Control | #193 391 | Field. Standard on 24A | | |
| Preflow/Postflow and Spot Control | #186 496 | Field | | |
| Power Sources | | | | |
| CP-302 | | See Lit. Index No. DC/13.0 | | |
| XMT 456 | | See Lit. Index No. DC/18.8 | | |
| Deltaweld 302 | | See Lit. Index No. DC/16.2 | | |
| XMT 350 CC/CV | | See Lit. Index No. DC/18.8 | | |
| XMT-304 CC/CV | | See Lit. Index No. DC/18.8 | | |
| Invision 354 MP | | See Lit. Index No. DC/23 | | |
| Accessories | | | | |
| Carrying Cart | #056 301 | | | |
| Feeder Cart | #142 382 | | | |
| Carrying Handle | #193 762 | | | |
| Hanging Bail | #058 435 | | | |
| Reel Cover | #195 412 | For 60 lb coil | | |
| Spool Cover | #057 607 | For 12 in spool | | |
| Wire Reel Assembly | #108 008 | | | |
| Turntable Assembly | #146 236 | | | |
| Spool Adapter | #047 141 | For 14 lb spool of Lincoln self-shielding wire | | |
| PSA-2 Control | #141 604 | | | |
| Extension Cords | #122 973 #122 974 #122 975 | 25 ft 50 ft 75 ft | | |
| Bernard® Q-400 MIG gun | | | | |
| Roughneck® MIG Guns | | | | |
| Miscellaneous | | | | |
| Primary Power Cable | | | | |
| Secondary Weld Cable | | | | |
| Work Cable with Work Clamp | | | | |
| Gas Cylinder | | | | |
| Gas Hose with Fittings | | | | |
| Regulator/Flowmeter | | | | |
| Welding Wire | | | | |
| Helmet | | | | |
| Welding Gloves | | | | |

Date:

Total Quoted Price:



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