Issued Dec. 2011 • Index No. AU/9.0

Auto-Axcess® E Analog Systems

With Insight™ Weld Data Monitoring System

Robotic 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-Cored
RMD® (GMAW-SCT)

Rated Output
300: 300 A at 29 VDC, 60% Duty Cycle
(225 A at 25.3 VDC, 100% Duty Cycle)
450: 450 A at 36.5 VDC, 100% Duty Cycle
675: 675 A at 38 VDC, 100% Duty Cycle

Voltage Range 10–44 V

Auxiliary Power 120 VAC, 10 A Duplex

Ship Weight
300: 134 lb. (60.8 kg)
450: 181 lb. (82.1 kg)
675: 226 lb. (102.5 kg)

The Power of Blue®

Field Upgrade Module

Update a standard Auto-Axcess power source by installing an Auto-Axcess E Field Upgrade Module (see page 10). Not compatible with Auto-Axcess DI.

Flexible, Expandable and Upgradeable

Multi-MIG capable welding systems are precise, digitally controlled and software-driven. For additional information see page 5.

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

Shown with AA-40GB with OCP wire drive motor assemblies (Motor control cables must be ordered separately.)

AA-40GB motor connections.

Scan this tag with your mobile device to see Axcess E videos.

Individual carrier rates may apply. Start by downloading the free mobile app at http://gettag.mobi

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

Website
MillerWelds.com

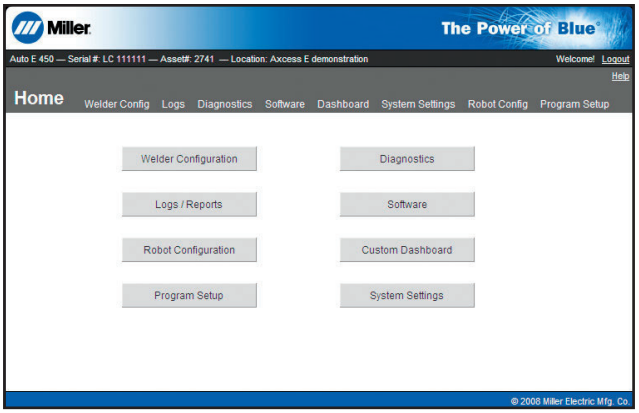
ISO 9001 REGISTERED QUALITY SYSTEM

Interface with Auto-Axcess® E Via Web Pages

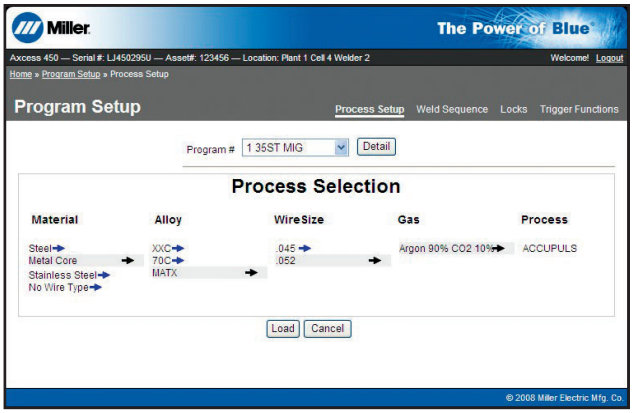
With a compliant Web browser* and access to the company's factory network, authorized employees can interface with the Auto-Axcess E to change configurations, check settings, define programs, monitor basic functions, troubleshoot the system, and much, much more. In addition, with external access to the factory network, this can be accomplished from anywhere in the world. The use of Web pages is easy and intuitive, which means the learning curve is short.

Internet Explorer 7 or higher, Firefox 3.5 or higher — Java script **must be enabled.*

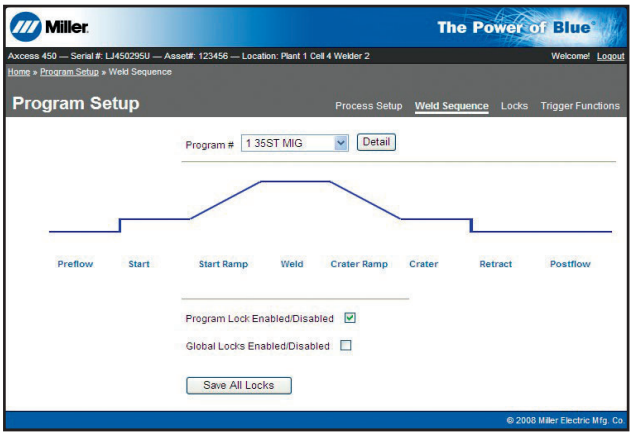
Web Page Examples



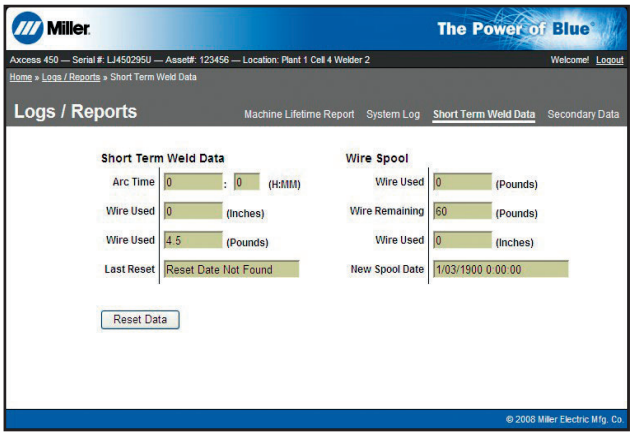
Home Page
Provides quick access to all Auto-Axcess E information and set-up screens.



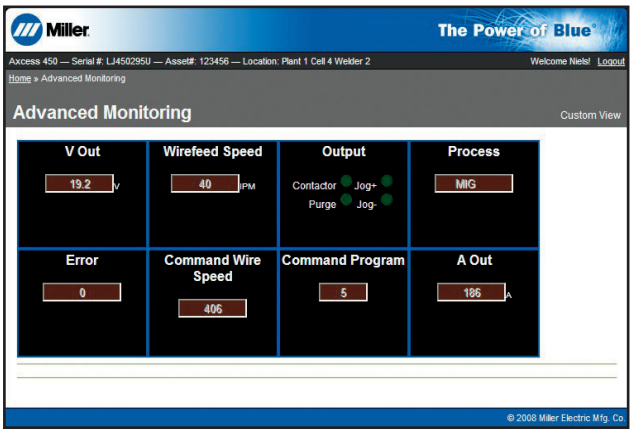
Process Setup Page
Define each of the eight available Auto-Axcess E programs.



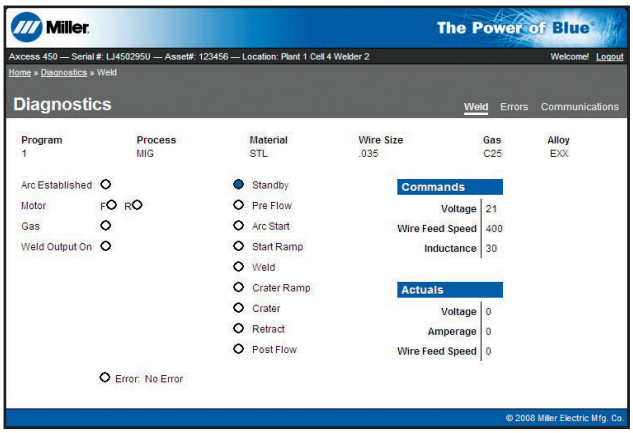
Weld Sequencer Page
Define each attribute of the weld sequence for each program.



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



Custom Dashboard Page
Customized view of critical machine information.



Weld Diagnostics Page
Determine the status of internal component performance.

Miller

Learn More at MillerWelds.com/advanced

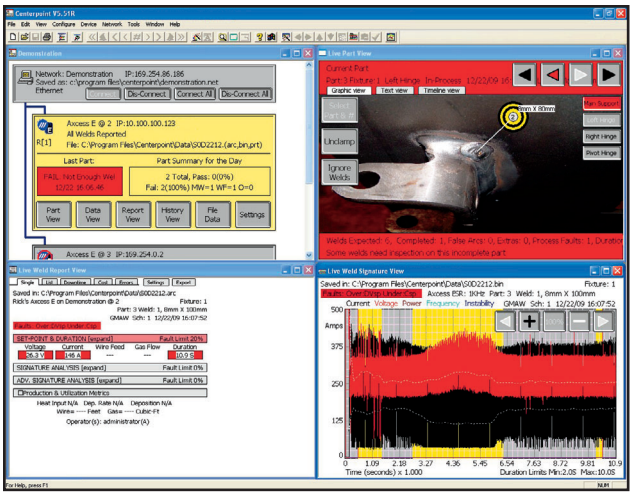
Insight Centerpoint™ Weld Process Management System

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® Auto-Axcess E with Insight provides a comprehensive welding information system. ***Insight is embedded into the operating system of the Auto-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.

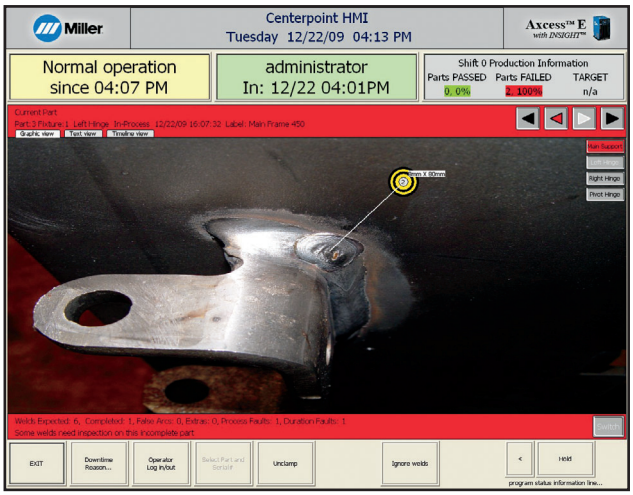
Auto-Axcess® E with Insight Centerpoint™

- 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 Auto-Axcess E systems via factory Ethernet network

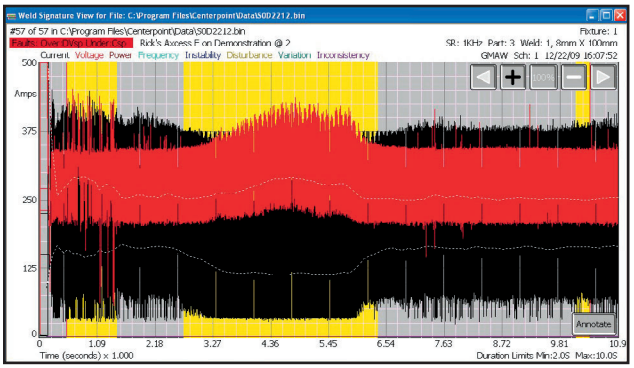
Insight Centerpoint Application – View Examples



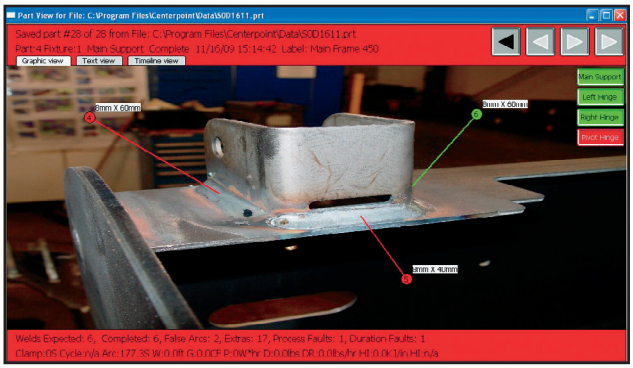
Administrative View



HMI View for Operator

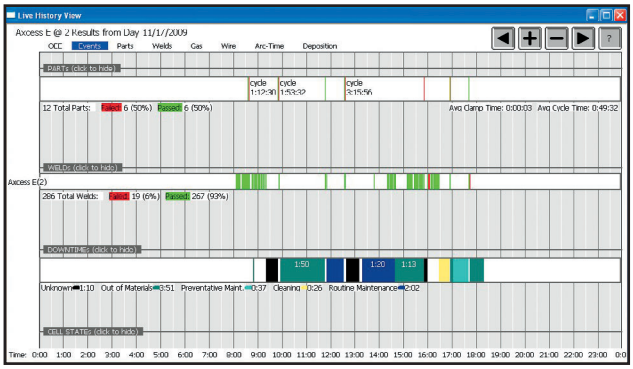


Weld Signature™* View with Faults Highlighted



Part View with Failures

History View — Parts



History View — Parts, Welds, Downtime

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

Insight Reporter™ Production 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 pre-configured process, production, and management charts and reports. This information is stored in a SQL server database which contains data from multiple Insight Centerpoint™ sources.

There are two primary components to Insight Reporter: database software and client software. Any Auto-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

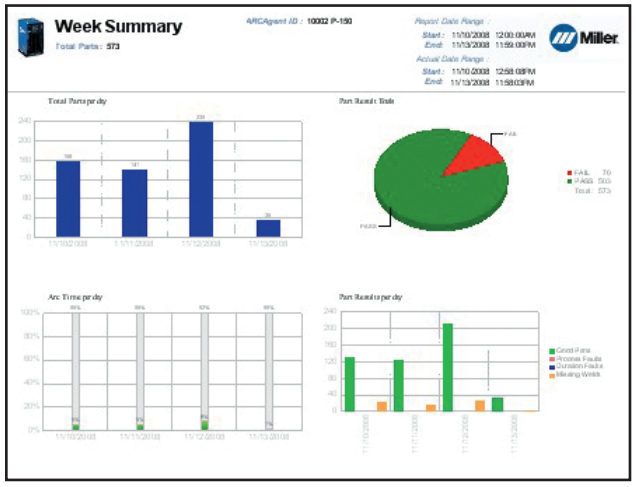
Part Analysis Charts
- Part summary
- Parts per time
- Part faults per time
- Faults on a single part
- Weld counts per part
- Parts with missing welds
- Single part report

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

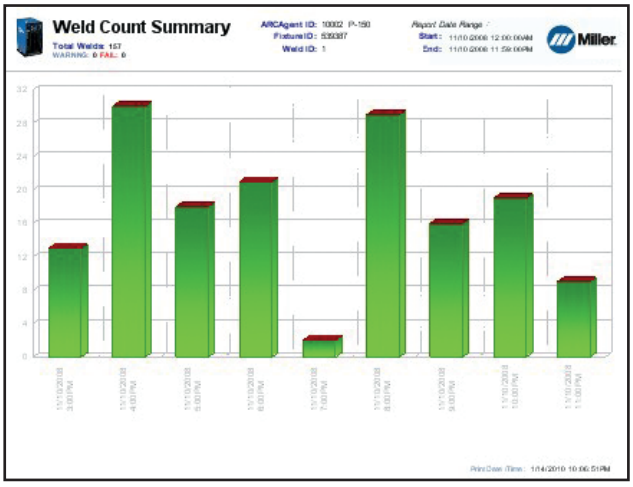
Costing Analysis Charts
- Wire usage
- Gas usage
- Summary reports
- Available by shift, day, week, month, or year

Note: Insight Reporter requires installation of Insight Reporter SQL database on a networked PC or server.

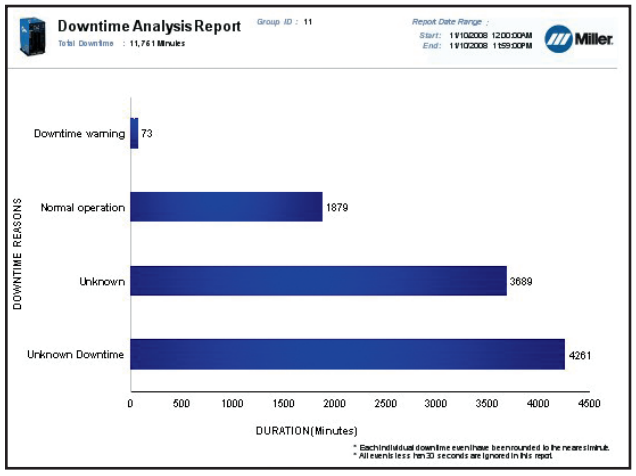
Report Examples



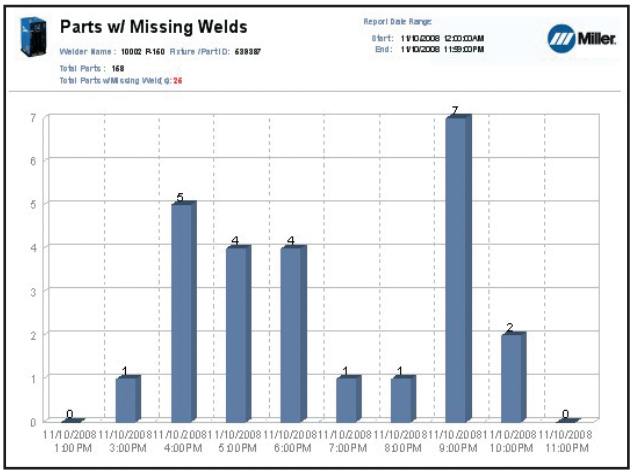
Weekly Summary Report



Weld Count Summary by Hour Report



Downtime Analysis Report



Parts with Missing Welds Report

Miller

Learn More at MillerWelds.com/advanced

Features and Benefits

HARDWARE (Standard)

AUTO-LINE Power Management Technology	Miller® Auto-Line 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 Auto-Axcess® E either directly or via the factory Ethernet network.
Connections for USB	USB flash drives can be used for executing code updates.

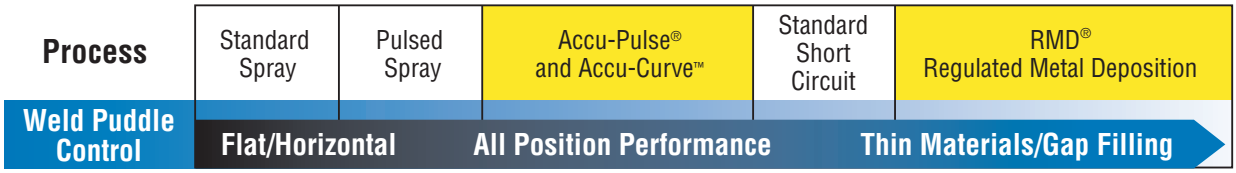
SOFTWARE (Standard)

Multi-MIG® capability	Includes common carbon steel, aluminum and stainless welding programs, including Accu-Pulse®, Accu-Curve™, standard or adaptive pulse, conventional MIG, Metal-Cored, and RMD® (Regulated Metal Deposition) programs using the most popular wire diameters and gas combinations.
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 and wetting action for RMD.
Remote/trigger program select	Allows changing weld programs to take advantage of up to eight 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 percent Argon and 10 percent Carbon Dioxide) on steel using the same wire-feed speed and also gives an indication of puddle control characteristics based on arc type selected.



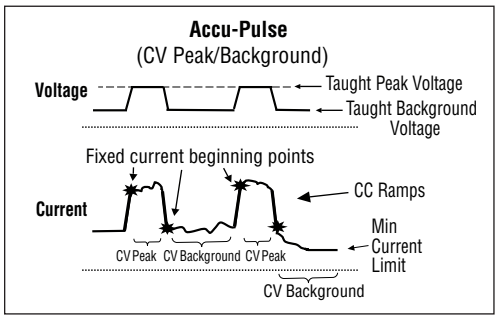
Note: To achieve optimum performance, 4/0 welding power secondary cable is recommended and the supplied work-sense lead must be connected as close to arc as possible.

Featured Welding Processes

Accu-Pulse®

STANDARD on all Auto-Axcess® E models

The 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 percent 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.



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 Auto-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.

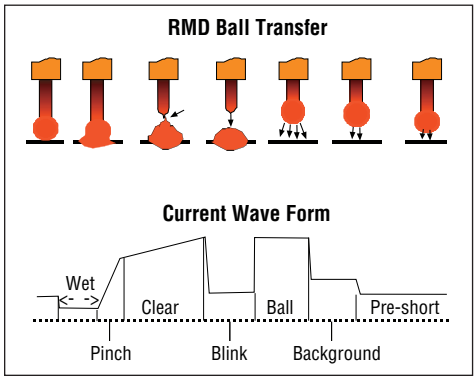
Benefits

- "Softer" arc feel than Accu-Pulse
- Maintains tight arc lengths
- Maintains better puddle control

RMD® (Regulated Metal Deposition)

STANDARD on all Auto-Axcess® E models

The unique patented design of RMD (Regulated Metal Deposition) is a precisely controlled short-circuit transfer. It is a method of detecting when the short is going to clear and then rapidly reacting to this data changing the current levels. Features Proactive Dynamic Puddle Control.



Benefits

- Well suited to thin materials
- Can replace TIG process in some applications
- Gap filling
- Spatter reduction
- Provides less heat into work piece
- Excellent performance on stainless steel
- Can be combined with other Axcess®-related programs
- Minimize distortion
- Use larger diameter wire on thin materials

Software Feature Guide

Note: As new and improved software features are developed, they can be added to existing Auto-Axcess E systems for FREE. Code transfer is accomplished via a USB memory stick plugged directly into USB connection on the Auto-Axcess E.

Insight™

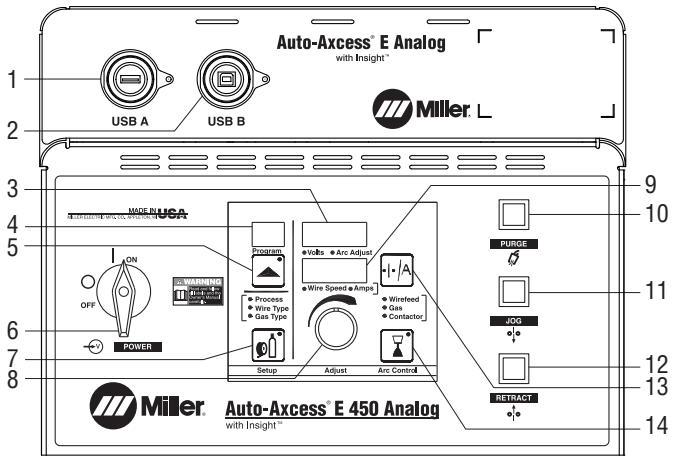
Insight is an application that is integrated into the Auto-Axcess® E operating system. The standard Auto-Axcess E comes equipped with Insight i100. For even more functionality, upgrade any Auto-Axcess E to Insight i1000 or i2000.

Key Benefits/Features*	Standard i100	Optional i1000	Optional i2000
Support for Insight Centerpoint™ and Insight Reporter™	■	■	■
Support for External Wire Feed Speed and Gas Flow Sensors (sensors and interface board sold separately)	■	■	■
Data Capture for Current, Voltage, Wire, and Gas (gas flow sensor sold separately)	■	■	■
Process Control — High/Low Set Points	■	■	■
Jobs (central repository for all Part Tracking™ information)	■	■	■
Detects Missing Welds, Extra Welds, and Incomplete Welds	■	■	■
Totalization of Arc Time, Consumable Usage, Parts, and Welds (per hour/per shift since last reset)	■	■	■
Overall Equipment Effectiveness (OEE) Calculations	■	■	■
Weld History Extraction Support (no full-time PC connection)	■	■	■
Dual Feeder Support	■	■	■
Auto Learn	■	■	■
Weld Signature™**—Low Resolution	■	■	■
Weld Signature™**—High Resolution		■	■
Workflow		■	■
Measurement of Process Mode Features (pulse characteristics, short circuit frequency, etc.)			■
Advanced Signature Analysis			■
Weld Process Production Manager (WPPM)			■

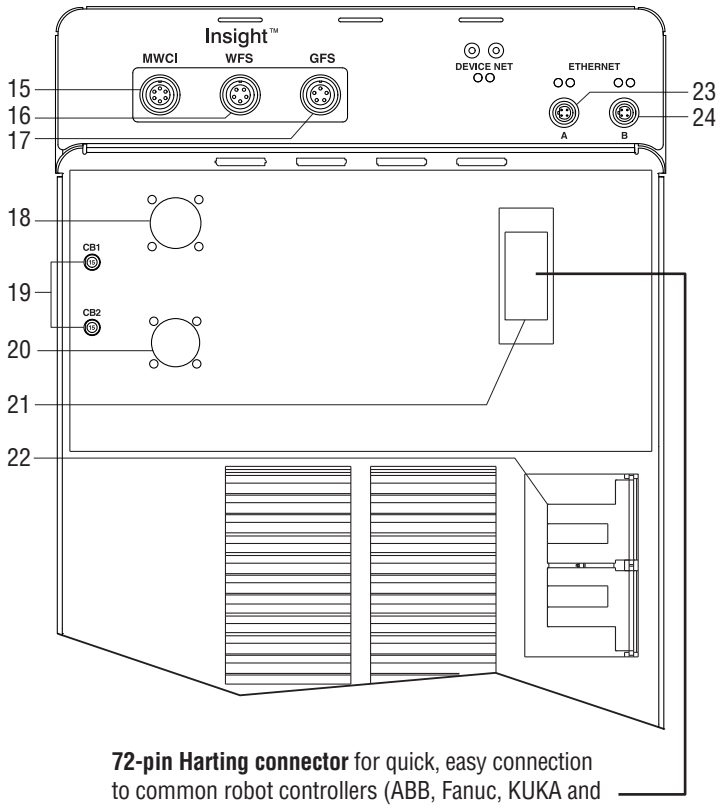
**Insight Centerpoint required.*
***Part Tracking™ and Weld Signature™ are registered trademarks of IMPACT Engineering.*

Control Panels

Front Panel



Back Panel



1. USB Connection A (Host)
2. USB Connection B (Device)
3. Voltage/Arc Adjust Display Meter
4. Program Display
5. Program # Select
6. Power Switch
7. Process Setup Button
8. Control Knob
9. Wire Speed/Amperage Display Meter
10. Purge Pushbutton
11. Jog Forward Pushbutton
12. Jog Retract Pushbutton
13. Wire Feed/Amperage Select
14. Arc Control
15. MWCI Connection (Optional)
16. Wire Feed Speed Sensor Conn. (Optional)
17. Gas Flow Sensor Connection (Optional)
18. Peripheral Connector
19. Circuit Breakers
20. Motor Connector
21. Robot Connection
22. 115 VAC, 10 A Duplex Receptacle
23. Ethernet Connector A
24. Ethernet Connector B

72-pin Harting connector for quick, easy connection to common robot controllers (ABB, Fanuc, KUKA and Motoman) with optional adapter cables. Analog robot controls. Available on analog power supplies.

Capabilities

Auto-CAL (Automatic Calibration)— Patented software-based feature exclusive to Auto-Axcess E. Allows simple, quick and accurate wire feed speed and voltage commands from most robots using analog signals. Auto-Axcess E calibrates itself to deliver exact responses to commands from robots. This allows Auto-Axcess E to be used interchangeably with many brands of robots, and allows quick replacement of competitive power supplies without the need to change wire feed speeds. Available on analog power supplies.

Remote Program Select— Allows changing weld programs from the robot controller to take advantage of up to eight programs or Multi-MIG® welding process capabilities.

Integrated 80 V Touch Sensor— To be used with external circuitry or peripheral equipment when touch sensing.

Front Panel Features
- Weld Process Selection
- Wire Size and Type
- Gas Type
- Wire Jog Forward Button
- Wire Jog Reverse Button
- Purge Button
- Digital Display Meters:
  - Voltage/Arc Adjust (Trim)
  - Wire Feed Speed/Amperage
- Program Number
- Arc Control (SharpArc® and Inductance)

Analog Outputs
- Voltage
- Current

Analog Inputs
- Voltage/Arc Adjust (Trim)
- Wire Feed Speed

Auto Setup
- Robot Specific

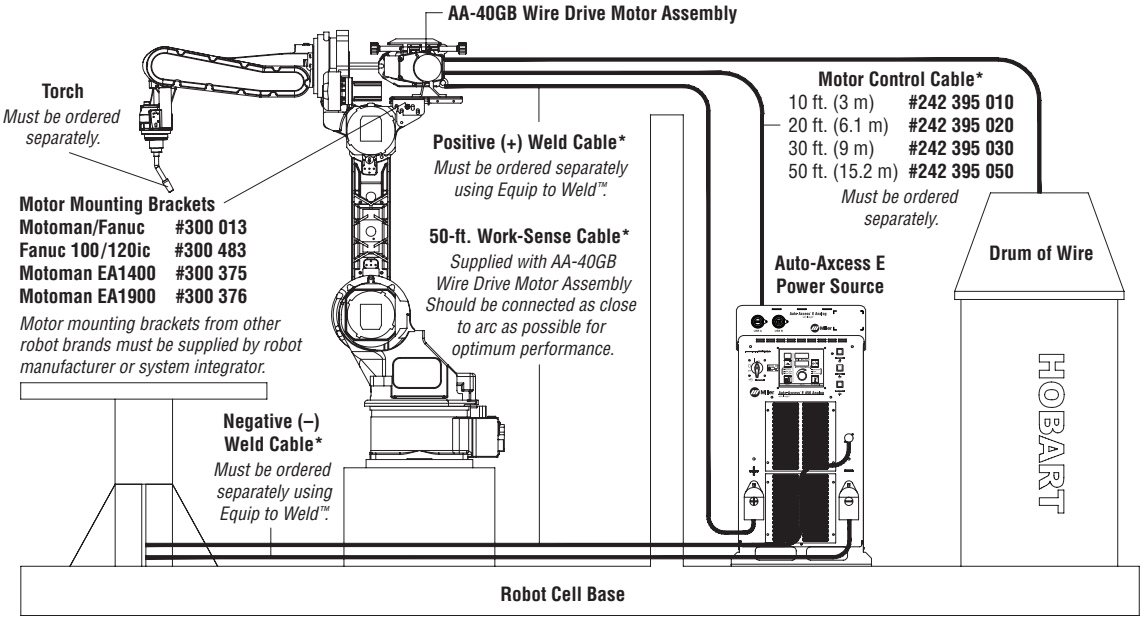
Sequence
- Preflow: 0–9.9 sec.
- Start Power: 0–2.5 sec.
- Voltage: 10–44
- IPM: 50–1400
- Crater: 0–2.5 sec.
- Retract
- Postflow: 0–9.9 sec.

Typical Installation (Robotic/Automation Pulsed MIG or Conventional MIG)

The Auto-Axcess® E platform is designed to bring the benefits of digital control technology to manufacturers who currently use analog robot control. When combined with a Smart Adapter **(#300 012)** and AA-40GB wire drive motor assembly the Auto-Axcess E will automatically reconfigure itself to function as a semi-automatic, thereby providing for single asset management and simplicity. *Contact Robot Manufacturers for fully-digital versions of the Axcess compatible with specific robot controllers.*

Visit tregaskiss.com for additional torch information.

**Custom cable lengths are available through Equip to Weld™ in 5-foot increments from 5 to 50 feet, and 10-foot increments from 60 to 100 feet.*



Power Source

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 208 V	230 V	400 V	460 V	575 V	KVA	KW	Dimensions	Net Weight
Auto-Axcess E 300	300 A at 38 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: 31 in. (787 mm) 675 H: 39 in. (991 mm) W: 17 in. (432 mm) D: 22.5 in. (572 mm)	116 lb. (52.6 kg)
Auto-Axcess E 450	450 A at 38 VDC, 100% Duty Cycle	10–44 V	5–600 A	80 VDC	—	60	33.7	28.8	22.8	23.8	22.9		163 lb. (73.9 kg)
Auto-Axcess E 675	675 A at 38 VDC, 100% Duty Cycle	10–44 V	5–900 A	80 VDC	—	89.7	—	43.7	34.8	35.7	34.4		208 lb. (94.3 kg)

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

Wire Drive Motor Assembly

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-foot volt-sense lead.

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

Model	Gas Valve	Type of Input Power	Connection to Power Source	Wire Feed Speed Range**	Wire Diameter Range	AA-40GB Dimensions	Ship Weight
AA-40GB	Included and enclosed	40 VDC (from Auto-Axcess E)	Motor Control Cable* (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)

**Custom cable lengths are available through Equip to Weld™ in 5-foot increments from 5 to 50 feet, and 10-foot increments from 60 to 100 feet.*
***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

Fanuc Internal Wiring Kit #300 229
Includes 30-foot cable that connects to the Fanuc controller, and 22-inch connector for mounting the wire drive assembly on top of the robot arm.

Receptacle/Adapter Kits
#194 793 ABB
#194 791 Fanuc
#194 790 Motoman
#300 056 Panasonic
#195 002 Universal
One required per machine. For analog communication with robot controls via 72-pin Harting connector on Auto-Axcess E. One-foot length.

Smart Adapter #300 012
Allows Auto-Axcess E to be configured to function as semi-automatic. To be used when there is a desire to have a common power supply and motor in both robotic and semi-automatic application. Easy asset management. 21-foot trigger control cable is included.

Universal Connector for Analog Control #195 002
Includes mating Harting connector with pins to allow custom configuration for robotic and fixed automation applications.

Shell Connector #194 847
For use by anyone wishing to interface peripherals, but not wanting to source the appropriate female amphenol connector.

Wire Drive Motor Mounting Brackets
#300 013 Fanuc/Motoman
#300 483 Fanuc 100/120ic
#300 375 Motoman EA1400
#300 376 Motoman EA1900

Coolant Flow Switch #195 461
To ensure coolant is flowing in the system. Lack of coolant flow may cause damage to water-cooled guns. Module allows wiring into the peripheral connector port. 50-foot (15.2 m) cable with connector and separate shell connector for simple modification to desired length in the field. It can be mounted on the Auto-Axcess E or as desired elsewhere. 1/4-turn quick connection.

Fixed or Hard Automation Accessories

Oscillators and Motorized Cross Slides
Refer to Lit. Index No. AU/6.0.

Manual Welding Guns –
see www.bernardwelds.com or www.tregaskiss.com

Automation welding guns –
see www.tregaskiss.com

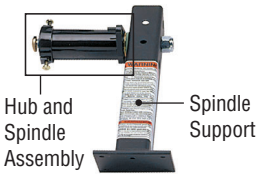
Auto-Axcess® E Field Upgrade Module #300 852 Field
Upgrade your investment in standard Axcess equipment. Standard Axcess power sources can be upgraded to Axcess E systems with the addition of the Axcess E field upgrade module. This module comes with everything you need for installation.
Note: Not compatible with Auto-Axcess DI.

Motor Control Cables*
#242 395 020 20 ft. (6.1 m)
#242 395 030 30 ft. (9 m)
#242 395 050 50 ft. (15.2 m)
Includes overmolded connections on high-flex cables for optimal service life.

50-foot Volt-Sense Work Cable* #242 208 050
Replacement cable. One cable supplied with every drive motor.

ADAM DI/O Module #300 803
Provides a digital I/O interface for communication between a robot /PLC and the Auto-Axcess E power supply. The interface allows for the interaction of a robot or PLC and the Insight Centerpoint application. This module is **required** for all analog Auto-Axcess E models.

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



Hub and Spindle Assembly #072 094

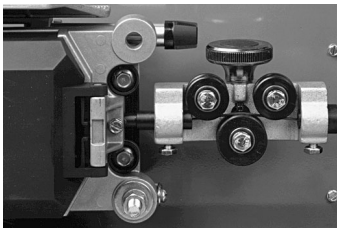
Spindle Support #092 989

Wire Reel Assembly #108 008

Spool Covers #057 607

Reel Covers #058 256
For 60-pound (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.



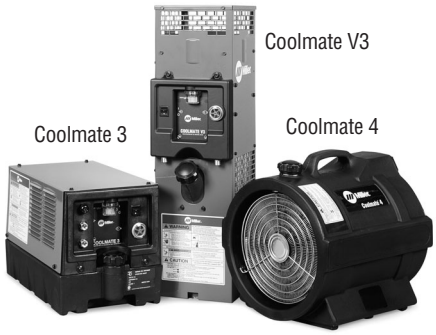
Wire Straightener
#141 580
For .035–.045 in. (0.9–1.1 mm) diameter wire.
#141 581
For 1/16–1/8 in. (1.6–3.2 mm) diameter wire.
Helps reduce the cast in wire to improve wire feeding performance and increase the service life of the gun liner and contact tip.

**Note: Custom cable lengths are available through Equip to Weld™ in 5-foot increments from 5 to 50 feet, and 10-foot increments from 60 to 100 feet.*

Genuine Miller® Accessories (continued)

Coolant Systems

For more information, see the Miller Coolmate Series 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 one-gallon recyclable plastic bottles. Miller coolants contain a base of ethylene glycol and deionized water to protect against freezing to -37° Fahrenheit (-38˚C) or boiling to 227° Fahrenheit (108˚C). Also contains a compound that resists algae growth.

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

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include four drive rolls, 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)	"U" groove for aluminum wires contains nylon guides
.035 in. (0.9 mm)	**#151 026**	—	**#151 052**	—	**#243 233**
.040 in. (1.0 mm)	**#161 190**	—	—	—	—
.045 in. (1.1/1.2 mm)	**#151 027**	**#151 037***	**#151 053**	**#151 070**	**#243 234***
.052 in. (1.3/1.4 mm)	**#151 028**	**#151 038**	**#151 054**	**#151 071**	—
1/16 in. (1.6 mm)	**#151 029**	**#151 039**	**#151 055**	**#151 072**	**#243 235**
.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**	—

**Accommodates .045- and .047-inch (3/64-inch) wire.*

Nylon Wire Guides for Feeding Aluminum Wire

Wire Size	Inlet Guide	Intermediate Guide
.035 in. (0.9 mm)	**#221 912**	**#242 417**
.047 in. (1.2 mm)	**#221 912**	**#205 936**
1/16 in. (1.6 mm)	**#221 912**	**#205 937**

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

Wire Guides

Wire Size	Inlet Guide	Intermediate Guide
.023 – .040 in. (0.6 – 1.0 mm)	**#221 030**	**#149 518**
.045 – .052 in. (1.1 – 1.4 mm)	**#221 030**	**#149 519**
1/16 – 5/64 in. (1.6 – 2 mm)	**#221 030**	**#149 520**
3/32 – 7/64 in. (2.4 – 2.8 mm)	**#229 919**	**#149 521**

Genuine Miller® Services

Consulting Services

Field Application Support #195 480
Auto-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.

Service and Troubleshooting

Analog Robot Simulator #195 030
Device simulates the analog commands of typical robots. it can be used as a diagnostic tool to determine power source functionality and isolate robot, power source or cable issues.

Ordering Information

Learn More at MillerWelds.com/advanced

Automatic Equipment Options	Stock No.	Description	Qty.	Price
Auto-Axcess® E 300 *(Robotic receptacle kit sold separately)*	**#907 442** **#907 442-00-1**	Inverter power supply Inverter power supply with sensor board		
Auto-Axcess® E 450 *(Robotic receptacle kit sold separately)*	**#907 443** **#907 443-00-1**	Inverter power supply Inverter power supply with sensor board		
Auto-Axcess® E 675 *(Robotic receptacle kit sold separately)*	**#907 444** **#907 444-00-1**	Inverter power supply Inverter power supply with sensor board		
Auto-Axcess® E Field Upgrade Module	**#300 852**	Field. Upgrades standard semi-automatic power source to Auto-Axcess E. *Not compatible with Auto-Axcess DI*		
Insight™ Software Upgrades	**#300 812** **#300 815** **#300 830**	Field. Upgrades Insight i100 to i1000 Field. Upgrades Insight i100 to i2000 Field. Upgrades Insight i1000 to i2000		
Insight Centerpoint™	**#300 708** **#300 765**	Individual license. Weld data monitoring system software Site license		
Insight Reporter™	**#300 709**	Management reporting system client software		
Insight Reporter™ SQL Database	**#300 710**	Management reporting system database software		
Motor/Cable/Kit Options				
AA-40GB Wire Drive Motor Assembly	**#195 426** **#195 515**	Left-hand wire drive assembly Right-hand wire drive assembly		
Motor Control Cable		See page 10. See page 9 for the connection diagram. Custom cable lengths are available through Equip to Weld™ in 5-foot increments from 5 to 50 feet, and 10-foot increments from 60 to 100 feet		
Receptacle/Adapter Kits		See page 10. *One required per machine, consult factory*		
Accessories				
Fanuc Internal Wiring Kit	**#300 229**			
Smart Adapter	**#300 012**	Robotic/automation. Allows automatic to function as semi-automatic		
Universal Connector for Analog Control	**#195 002**	Robotic/automation. Allows custom configuration		
Shell Connector	**#194 847**			
Wire Drive Motor Mounting Brackets		See page 10		
Coolant Flow Switch	**#195 461**			
Volt-Sense Work Cable	**#242 208 050**	Replacement 50-ft. (15.2 m) cable. This cable is included with every drive motor Custom cable lengths are available through Equip to Weld™ in 5-foot increments from 5 to 50 feet, and 10-foot increments from 60 to 100 feet		
ADAM DI/O Module	**#300 803**	Required for all analog Auto-Axcess E models		
Axcess® Feeder Base and Spool Support	**#195 369**	Allows mounting of AA-40GB motor when using ROI option		
Hub and Spindle Assembly	**#072 094**			
Spindle Support	**#092 989**			
Wire Reel Assembly	**#108 008**			
Spool Covers	**#057 607**			
Reel Covers	**#058 256**			
Turntable Assembly	**#146 236**			
Wire Straightener		See page 10		
Coolant Systems		See page 11		
Drive Roll Kits *(Required)* and Guides		See page 11		
Field Application Support	**#195 480**	Robotic/automation. One day minimum, not subject to discount. See page 11		
Analog Robot Simulator	**#195 030**	Robotic/automation. See page 11		

Date: **Total Quoted Price**

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