



R-115

115 Volt, Replacement Feeder



Shown with optional carrying handle



The R-115 constant speed semi-automatic wire feeder utilizes 115 VAC input power.

The R-115 offers easy connection to older Miller and competitive welding power sources supplying 115 VAC power.

The R-115 will work on the following power sources:

- Older Style Miller w/hubble connectors
- Hobart
- Lincoln
- Thermal Arc
- Airco
- L-Tech

... and other power sources supplying 115V (see optional cords).

Feeders are not shipped with an interconnecting cord. An optional cord is required (see page 2) or an existing interconnecting cord can be used.

Processes



MIG (GMAW)
Welding



Flux Cored (FCAW) Welding
(Gas and Self-shielded)

Description



Use with CV
Power Sources

Features

Benefits

Universal 115V feeder power	Adapts to a wide variety of older Miller and competitive power sources.
Industrial 4 drive roll system	Offers exceptional feed performance and reliability.
Optional interconnecting cords	Quick and easy installation to a variety of power sources. (Refer to page 2 for power source control cord and drive roll kits.)
Convenient terminal block	Easily adapts to existing feeder innerconnecting cords.
Heavy duty industrial design	16 gauge sheet metal enclosure for durability in harsh environments.
Motor ramp and burnback control	Aids in starting and stopping performance to match power source characteristics.
Trigger hold	Allows operator to make long extended welds without having to hold gun trigger.
Wire feed speed range is 75-750 IPM	Covers a wide variety of wire sizes (.030-3/32).
Gas solenoid	Accommodates self-shielded and gas-shielded wires.
Quick change drive rolls	Four gear driven rolls are easy to change – no tools required.
Optional run-in control	A separate wire feed speed adjustment to control wire speed prior to arc initiation.
Miller True Blue® Warranty	Wire feeder is warranted for 3 years - parts and labor.

Specifications *(Subject to change without notice.)*

Industrial (Use with CV Power Sources.)

Input Power	Electrode Wire Diameter Capacity	Wire Speed	Dimensions	Net Weight
115 VAC, 2 A, 50/60 Hz	.030–3/32 in (0.8–2.4 mm)	75 – 750 IPM (1.9–19 m/min)	L: 23-1/2 in (597 mm) W: 10-3/4 in (273 mm) H: 11 in (279 mm)	40 lb (18 kg)



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

Ordering Information

#193 164 R-115 Wire Feeder

Note: Refer to page 2 for power source control cord and drive roll kits (must be ordered separately).

#193 164-01-1 R-115 Wire Feeder

Includes run-in control.

Miller Electric Mfg. Co.

An Illinois Tool Works Company
 1635 West Spencer Street
 Appleton, WI 54914 USA

International Headquarters—USA

USA Phone: 920-735-4505 (Auto-Attended)

USA FAX: 920-735-4134

Canadian FAX: 920-735-4169

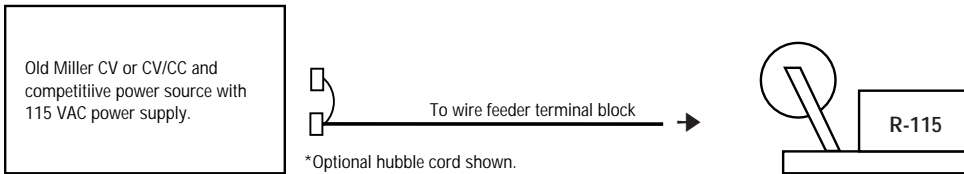
International FAX: 920-735-4125

Web Site—www.MillerWelds.com



Miller
The Power of Blue.

Typical Installations

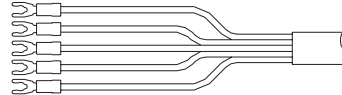


Feeder to Power Source Control Cords – All cords are 10 ft (3 m) in length.

Select control cord from list below for the type of power source being used.
Cords shown reflect connection at the power source.



#193 387
Old style Miller and Airco power source with two and three prong (Hubbell style) twistlock connectors.



#193 385
Lincoln power source with five wire terminal strip connection.



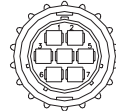
#193 381
Hobart power source with 19-pin plug.



#193 384
Lincoln power source with 14-pin connector.



#193 383
Hobart power source with 115 volt wall type plug and 5-pin plug.



#193 379
L-tec power source with 7-pin connector.







#193 382
L-tec power source with 19-pin connector.



#193 386
Airco power source with straight blade 115 volt wall type plug and two prong twistlock.



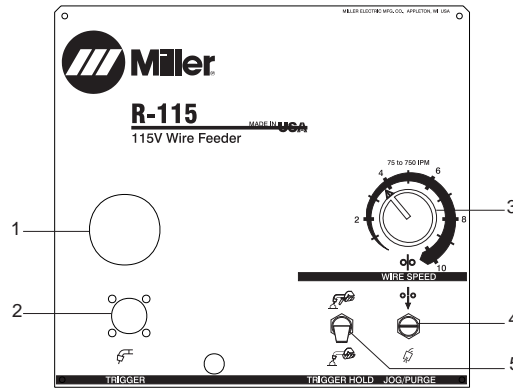
Drive Roll Kits Select drive roll kits from chart below according to type and wire size being used. Kit includes drive rolls and inlet guide.

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" coggled for extremely soft wire or soft-shelled cored wires (i.e., hard facing types) 
.030 in (0.8 mm)	#046 780	—	—	—
.035 in (0.9 mm)	#046 781	#044 750	#046 792	—
.040 in (1.0 mm)	#161 190	—	—	—
.045 in (1.1/1.2 mm)	#046 782	#046 785	#046 793	#083 319
.052 in (1.3/1.4 mm)	#046 783	#046 786	#046 794	#083 320
1/16 in (1.6 mm)	#046 784	#046 787	#046 795	#046 800
.068/.072 in (1.8 mm)	—	—	#089 985	—
5/64 in (2.0 mm)	—	#046 788	#046 796	#046 801
3/32 in. (2.4 mm)	—	#046 789*	#046 797*	#046 802*

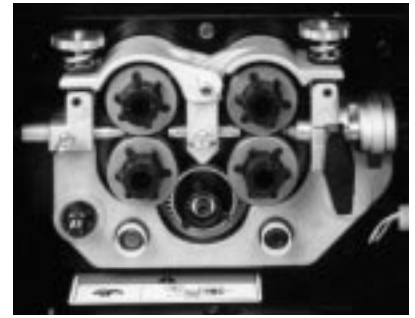
* 194 264 - 3/32 inlet guide is required when using 3/32 drive rolls.

Control Panel

1. Gun Connection
 2. Trigger Receptacle
 3. Wire Speed Control
 4. Jog/Purge
 5. Trigger Hold
- Power On/Off (on rear panel)



Wire Drive Assembly



Options and Accessories

Skill Level Index

The bracketed entry to the right of the stock number of field-installed options contains a letter and number. The letter indicates the skill level required to install the option. The number indicates the approximate time required for installation (see legend).

- A – Easy.** No previous experience needed.
- B – Average.** Requires removal of service panels. Mechanical ability is helpful.
- C – Difficult.** May require the use of an ohmmeter and/or splicing of electrical wires. Repair or replacement of component parts is more difficult.

D – Technical. May require the use of an ohmmeter and the ability to read a circuit diagram. Repair or replacement of component parts is complex.

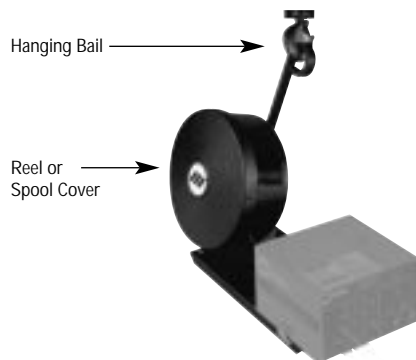
Example:

[B: 30] Skill Level: B, Time: 30 minutes

Run-In Control

#193 391 Field [A: 25]

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.



Hanging Bail #058 435 [A: 05]

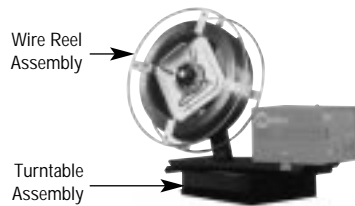
Suspends feeder over the work area.

Reel Cover #058 256 [A: 05]

For 60 lb (27.2 kg) coil

Spool Cover #057 607 [A: 05]

For 12 in (304 mm) spool



Wire Reel Assembly #108 008 [A: 05]

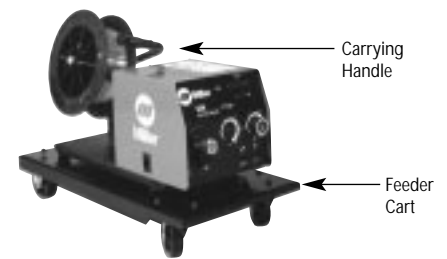
For 60 lb (27.2 kg) coil of wire.

Turntable Assembly #146 236 [B: 20]

Allows rotation of feeder as operator changes work positions. This reduces strain and bending on gun cable.

Spool Adapter #047 141 [A: 05]

For use with 14 lb (6.4 kg) spool of Lincoln self-shielding wire.



Carrying Handle #193 762 [A: 05]

For lifting and moving feeder.

Feeder Cart #043 698 Field only [A: 25]

A low-profile creeper cart with high-quality rubber casters, front swivel and rear rigid.



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