Process Quick Start Guide

Trailblazer® and Big Blue® welder/generators

⚠ WARNING



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.

1. **Registration** – Be sure to register your product at www.Millerwelds.com/support/product-registration.
2. **Operator's Manual** – Take out the operator's manual from the bag stored inside the service door. Refer to your operator's manual for specific installation instructions.
3. **Exhaust** – The exhaust pipe and mounting bracket with hardware are packaged with the owner's manual. Install these components using a 1/2" combination wrench.
4. **Wireless Interface Control Remote** *(for Wireless Interface Control models only)* – Remove the handheld remote package stored inside the welder and set aside. This is already paired with your new machine and ready to use.
5. **Battery** – The welder is shipped without the negative battery cable attached. Secure the negative battery cable to the negative battery terminal through the side door using a 1/2" combination wrench.
   - The battery on Big Blue models 500A and above is accessed by removing the battery access panel on the back side of the welder. This will require a 1/2" combination wrench. These Big Blues also contain a battery disconnect switch which is accessed from the side panel of the machine. This switch must be turned to the ON position prior to operation. See the owner's manual for more information.
6. **Oil** – Check the oil level. The unit is shipped with oil so the addition of oil is not necessary on new welders/generators.
7. **Fuel** – Add fresh fuel to the welder and be sure to not overfill. See owner's manual for best fueling practices.
8. **Coolant** (Big Blue's Only) – Check the coolant level on overflow/recovery tank from the access panel on top of the welder. The unit is shipped with coolant so the addition of coolant is not necessary on new welders.
9. **Air Compressor Oil** (Air Pak models only) – Check the air compressor oil gauge as described in the owner's manual. This unit is shipped with air compressor oil so the addition of oil is not necessary on new welders. See owner's manual for more details on the air compressor system.
10. **Installation Location** – Verify 18" of clearance on each side and the top of the unit to ensure proper airflow for cooling.
    - Mount welder – Secure the welder to a rigid frame by fastening bolts through the four mounting holes on the base of the unit.
    - Big Blues can also have mounting brackets welded. See the Installation section of the owner's manual for instructions.
    - Electric Shock Protection – Ground the welder to the truck or trailer if applicable (ground cable not supplied). Detailed instruction available in the owner's manual.
11. **Attach welding cables/connectors to the output terminals** – Be sure that the weld cables/connectors makes direct contact with the copper bar on the output

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Stick Welding

▶Getting Started



Ground Clamp (10 ft.)
195458
Up to 400A, comes with stud/Tweco adapter.



Electrode Holder (10 ft.)
195457
Up to 400A, comes with stud/Tweco adapter.

▶Do you need additional cable length?



Weld Cable Extension
195456
2/0 Tweco, 50 ft.

Weld Cable Extension
195455
2/0 Tweco, 100 ft.

▶Dinse Adapters for Cables



Dinse (male)/Tweco (female) adapter
042465



Tweco (male)/Dinse (female) adapter
210061

▶Do you need remote control?



ArcReach® Stick/TIG Remote
301325
ArcReach models only. Adjust amperage and arc control



Wireless Hand Control
301582
Adjust current, voltage and contractor control.



RHC-14 Hand Control
242211020
Wired remote control for current and contactor control.

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MIG/FCAW-G Welding

▶Do you have a flowmeter/regulator?



Argon/CO2 Flowmeter Regulator
22-80-580-6
CGA-580 inlet connection, 80 psi, 6 ft. air hose, gauge

▶Do you need to weld aluminum from a SuitCase feeder with a push/pull drive?



XR-AlumaFeed SuitCase Feeder
301567

▶Will wire welding be done with a spool gun?



WC-24 Control
137549
Enable spool gun functionality from 14-pin receptacle. Pairs with Spoolmatic 30A Spool Gun (130831).



Spoolmatic 30A Spool Gun
130831
200A aluminum spool gun, 30 ft. Requires WC-24 control (137549).

▶Will you be using a SuitCase® feeder?

If so, what diameter wire spools will you use and what type of MIG gun would be best?

8 inch wire spool diameter



ArcReach® SuitCase® 8
951726
Includes BTB Q-Gun – 300A gun using premium Centerfire consumables with threadless contact tips.

951727
Includes S-Gun™ – 250A gun using Quick Tip consumables with threaded taper lock contact tips.

12 inch wire spool diameter



ArcReach® SuitCase® 12
951729
Includes BTB Q-Gun – 300A gun using premium Centerfire consumables with threadless contact tips.

951730
Includes S-Gun™ – 250A gun using Quick Tip consumables with threaded taper lock contact tips.

Do you need advanced CV processes?



ArcReach® Smart Feeder
951733
With PipeWorx 300A gun. Enables RMD and Pulsed MIG.

FCAW-S Welding

▶What size wire spool does your SuitCase® feeder need to run?

8 inch maximum wire spool diameter



ArcReach® SuitCase® 8
951728
With DuraFlux gun

12 inch maximum wire spool diameter



ArcReach® SuitCase® 12
951731
With Dura Flux gun

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TIG Welding

▶Do you have a flowmeter/regulator?



CO2, Argon, and Helium, 6 ft. air hose, gauge
22-30-580-6
CGA-580 inlet connection, 30 psi

▶Do you need a TIG consumable kit?



Torch Consumable Kit
AK3C
Includes consumables for 1/16", 1/32" and 1/8" tungstens.



Gas Lens Kit
AK3GL
For improved gas flow for 150A, 200A and 250A torches. Sizes 6, 7 and 8.

▶What amperage torch will you need?



Weldcraft™ A-150A Valve Torch
Rubber, 25 ft.
Standard – **WP-17FV-25-R**
Flex – **WP-17FV-25-R**
Pair with connector 105Z57



Weldcraft™ A-200A Valve Torch
Rubber, 25 ft.
Standard – **WP-26V-25-R**
Flex - **WP-26FV-25-R**
Pair with connector 45V62



Weldcraft™ A-250A Valve Torch
Rubber, 25 ft.
Standard – **301526025** (two piece only – no adapter)



One Piece TIG Connector
150Z57
Up to 150A



One Piece TIG Connector
45V62
Above 150A

▶Do you need remote control?



ArcReach® Stick/TIG Remote
301325
ArcReach models only. Adjust amperage and arc control. Rubber, 25 ft.



Wireless Hand Control
301582
Adjust current, voltage and contractor control.



RHC-14 Hand Control
242211020
Wired remote control for current and contactor control.



Wireless Foot Control
301580
For remote current and contactor control.



RFCS-14 HD Foot Control
194744
Wired foot pedal current and contactor control.



RCCS-14 Finger Control
043688
Fingertip current and contactor control.

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Battery Charge/Jump Start
(for applicable models)



Battery Charge/Jump Start Cables
300422
25 ft. cables with plug

Air Compressor
(for applicable models)



Air Cooler & Seperator
300420
For use with Trailblazer 302 Air Pak



Desiccant Air Dryer
195117001
For use with Big Blue Air Pak models

Plasma Cutting

▶The cutting capabilities will be based on the output of the machine. See Spectrum literature for power requirements.



Spectrum 375
907529
Rated to cut 3/8” material



Spectrum 625
907579
Rated to cut 5/8” material



Spectrum 875
907583
Rated to cut 7/8” material



Full KVA Adapter Cord
300517
NEMA 14-50 to NEMA 6-50R for easy pairing with equipment such as Spectrum series plasma cutters.