EASY TO OPERATE
Turn on the shielding gas and main power switch, set the Heat and Wire Speed dials, and pull the trigger. That is all that is required of the operator of the MM250SL to perform the majority of welding jobs.

The MM250SL is easily switched into MIG Consumable Spot or Stitch welding modes. The unit can be used to produce high quality welds on steel, stainless steel, or aluminum. An Optional MHG5-B Spool gun is available for welding aluminum.

SMOOTH ARC DESIGN
A twelve position dial provides 4 TIG and 8 MIG voltage selections. The tapped transformer, diode rectifier, capacitor bank design, produces the smooth arc required for welding on thin gauge, as well as the amperage needed for welding heavier sections of material.

COMPACT DESIGN
The small size, light weight, sturdy running gear, and the 20 foot power input cable make the MM250SL the ideal machine for in-shop portability.

All controls are located on the front of the machine, to allow for easy reading and adjustment.

REMOTE FEED UNIT
The MM250SL standard package includes a removable feed unit. The feed unit is equipped with a 15 foot cable assembly. Optional 25, 35 and 50 foot cable assemblies are available.

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INDUSTRIAL MIG TORCH
The industrial rated MIG torch is designed to give years of dependable service. Its light weight, perfect balance, and positive trigger control are especially appealing to the operator. The Zero Gas Loss feature is standard with SNAP-ON TOOL MIG torches. This feature virtually eliminates expensive shielding gas loss. The single line cable with unique single unit connector attachment at the machine is one more plus, adding to the perfect machine.

ITEMS INCLUDED WITH THE MM250SL
SNAP-ON MUSCLE MIG SYSTEM:

- Combination Power Source / Remote Feed Unit
- Industrial Wheel Kit / Cylinder Rack
- 15 foot Feeder Control Cable Assembly
- Shielding Gas Regulator / Flowmeter
- 20 foot Power Input Cable
- 15 foot Work Cable with Clamp
- MIG Torch with 10 foot Cable (.030 wire)
- 200PK Parts Kit
The MM250SL is "Spool Gun Ready". The optional MHG5-B spool gun plugs into the welder and you are ready to weld. (The proper gas must be hooked up) but nothing needs to be removed from the welder for changeover to the spool gun.

**ALKALINE WELDING**

PURE ARGON GAS IS REQUIRED FOR ALUMINUM WELDING.

**T.I.G. (GTAW) WELDING**

Do you have a requirement for very high quality welds? The MM250SL is easily converted to a T.I.G. Welder. Weld Steel, Stainless Steel, Chrome-Moly, Copper, Cast Iron - but will NOT WELD ALUMINUM. With its built-in 4 TIG settings the MM250SL is capable of welding 18 gauge up to 1/4" thicknesses. (available in 12 and 25 foot cable lengths) PURE ARGON GAS IS REQUIRED FOR TIG WELDING.

**FLEX-TIG**

12 or 25 foot

**ALUMINUM WELDING**

The MM250SL is "Spool Gun Ready". The optional MHG5-B spool gun plugs into the welder and you are ready to weld. (The proper gas must be hooked up) but nothing needs to be removed from the welder for changeover to the spool gun. PURE ARGON GAS IS REQUIRED FOR ALUMINUM WELDING.

**Specifications**

**Power Input Requirements**

- Voltage: 208/230 volts AC
- Phase: single phase
- Frequency: 50/60 hertz
- Current: 33/30 amps

**Power Output**

- Open Circuit Voltage: 18 - 42 volts DC
- Arc Voltage: 14 - 28 volts DC
- Weld Current Range: 30 - 250 amps
- Rated Output (NEMA): 200 amps
- Duty Cycle: 60%
- Max. Output: 250 amps
- Duty Cycle at Max.: 35%

**Spot/Stitch**

- Duty Cycle - Spot Weld: 30 x 2 seconds
- Duty Cycle Time Period: 10 minutes
- Spot Weld Time Adjustment: 0 - 3 seconds

**Electrode Wire Capacity**

- Steel Wire: 0.023 - 0.045 inch
- Stainless Steel Wire: 0.030 - 0.045 inch
- Aluminum Wire (with MHG5-B): 0.025 - 0.047 inch
- Bronze Wire: 0.030 - 0.035 inch
- Flux Cored Wire: 0.030 - 0.045 inch
- Recommended Wire Size: 0.030 inch

**Wire Feeder**

- Input Voltage: 28 volts AC
- Wire Feed Speed Range: 50 - 800 IPM

**Shielding Gases**

- Steel Wire: CO2 or 75% ARGON-25% CO2
- Stainless Steel: 98% ARGON-2% O2
- Aluminum, Bronze: CO2 or 75% ARGON-25% CO2
- Flux Cored: none (Straight Polarity)
- Flux Cored - gasless: with Argon

**MIG Torch**

- Neck Angle: 60 degrees
- Overall Length: 10 feet
- Cooling Method: gas
- Rating - Duty Cycle: 200 amps - 100% duty cycle
- with CO2: 250 amps - 60% duty cycle
- with Argon: 150 amps - 100% duty cycle
- with Argon: 200 amps - 60% duty cycle
- Warranty Period: 30 days on MIG Torch

**Dimensions**

- Height: 35-3/4 inches
- Width: 14-1/2 inches
- Depth: 34-1/2 inches
- Weight: 175 pounds

The Pro's Advantage For Mig Welding

Snap-On Tools Corporation, Kenosha, WI 53141-1410

(Rev. 8/97)