Big Blue® 400 PipePro®
Diesel Engine-Driven Welder/AC Generator

Processes
Stick (SMAW)
MIG (GMAW)*
Flux-cored (FCAW)*
RMD***
Pulsed MIG (GMAW-P)**
DC TIG (GTAW)
Air carbon arc (GAC-A)
Rated: 1/4-inch (6.4 mm) carbons

Rated: 1/4-inch (6.4 mm) carbons

Heavy Industrial Applications
Cross-country pipeline
Process pipe welding

Quick Specs

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MIG (GMAW)*
Flux-cored (FCAW)*
RMD***
Pulsed MIG (GMAW-P)**
DC TIG (GTAW)
Air carbon arc (GAC-A)
Rated: 1/4-inch (6.4 mm) carbons

Output Range
DC stick 20–400 A
MIG/flux-cored 14–40 V
DC TIG 20–400 A

Generator Output Rated at 104°F (40°C)
12,000 watts peak, 10,000 watts continuous

Accu-Rated™ Not Inflated Generator Power

*With wire feeder. **With ArcReach Smart Feeder.

Designed for the transmission pipeline welder.
The Big Blue 400 PipePro offers superior downhill stick arc characteristics, as well as MIG/flux-cored capabilities, to meet high-strength steel requirements for the most demanding pipeline jobs.

MITSUBISHI ENGINE NORTH AMERICA, INC.
Mitsubishi S4L2 four-cylinder diesel.

NEW! CATERPILLAR C1.5T turbo-charged three-cylinder diesel.

Heavy-duty low-speed T4F industrial diesel engines designed to operate over 10,000 hours before the first basic overhaul. Backed by worldwide support and service.

ArcReach
Remote control of the power source without a cord. See pages 2 and 3.

Optimized arc control for stick welding applications. See page 3.

Also available with stainless steel enclosure. See page 8.

Welder/generator is warranted for three years, parts and labor.
Engine is warranted separately by engine manufacturer.

Miller Electric Mfg. LLC
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

Equipment Sales US and Canada
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com
**Big Blue® 400 PipePro® Features and Controls**

**Digital meters** with SunVision™ technology enable welding parameters to be viewed with greater clarity than analog meters — at virtually any angle. Meters can be seen clearly even in direct sunlight.

**Meters display**
- Process settings for quick and easy setup
- Preset and actual amperage

**Simple-to-set controls**
Require no elaborate procedure — just select process and weld!

**Industrial USB port.**
Quickly upload the latest software and download machine log files to retrieve in-depth information such as diagnostics and machine statistics.

**Low OCV stick (VRD), when enabled,** reduces the open-circuit voltage to 30 volts when the welding power source is not in use, increasing operator safety without compromising arc starts.

**Optional stainless steel enclosure.**
Enhances durability and adds to the look and resale value of the machine.

**Standard features include**
- Adjustable Hot Start™ automatic idle, thermal overload protection, 120-volt block heater, Dynamic DIG™, engine coolant temperature gauge and lift-off service door and .

**Arc control** allows arc characteristics to be adjusted in stick and wire processes. In stick modes, unlock the benefits of the all-new Miller® Dynamic DIG program, which gives welders the fine-tuning they need to overcome issues related to fitup and inconsistencies in the pipe.

**Standard 14-pin receptacle with Auto-Remote Sense™** for simple connection of remote controls and wire feeders.

**10,000 watts of pure generator power.**
Plug in an extra Miller® inverter-based power source for a second welding arc!

**LINE-X® top cover**
Workbench tough and provides superior impact, corrosion and abrasion protection.

**Quiet operation.**
Improves jobsite communication.

**ArcReach® Remote Control Technology**

Remote control of the power source without a control cord.
An ArcReach system allows you to change weld settings from your ArcReach feeder or remote, saving a trip to the power supply. ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.
Big Blue® 400 PipePro® Additional ArcReach® Features

ArcReach provides remote amperage and voltage control at the weld joint without needing a control cord.

**More arc-on time and reduced exposure to workplace hazards** for operators can be realized using ArcReach because less time is spent going back to the welding power supply to set process and arc amperage or voltage.

**Auto-Process Select.** Depending on connected accessory, the system automatically changes to stick or MIG/FCAW (with gas) if electrode positive polarity is detected or TIG or FCAW (no gas) if electrode negative polarity is detected, when ArcReach communication is established between the accessory and the Big Blue 400 PipePro — reducing the need to access the power supply.

**Dynamic DIG™ technology** automatically adjusts the amount of current required to clear a short. Delivers a smoother, more consistent arc that can be tailored to match the application, material, fit-up and welder technique.

**Remote override of Big Blue 400 PipePro.** When an ArcReach accessory is connected to a Big Blue, the accessory has full control and the Big Blue controls are disabled. While under ArcReach control, process and voltage/amperage adjustments are locked out, preventing accidental changes by personnel other than the welding operator.

**Cross platform compatible.** The same ArcReach accessories that work on engine-driven equipment can also be used on select ArcReach-equipped XMT® and Dimension™ power sources.

**Reverse compatible.** ArcReach-equipped power sources work with non-ArcReach accessories; however, the complete ArcReach benefit is only realized with the ArcReach system.

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**Reverse compatible.** ArcReach-equipped power sources work with non-ArcReach accessories; however, the complete ArcReach benefit is only realized with the ArcReach system.

**Improved weld quality**

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**Reduced maintenance**

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**Reverse compatible.** ArcReach-equipped power sources work with non-ArcReach accessories; however, the complete ArcReach benefit is only realized with the ArcReach system.

**Improved flexibility**

**More arc-on time and reduced exposure to workplace hazards** for operators can be realized using ArcReach because less time is spent going back to the welding power supply to set process and arc amperage or voltage.

**Auto-Process Select.** Depending on connected accessory, the system automatically changes to stick or MIG/FCAW (with gas) if electrode positive polarity is detected or TIG or FCAW (no gas) if electrode negative polarity is detected, when ArcReach communication is established between the accessory and the Big Blue 400 PipePro — reducing the need to access the power supply.

**Dynamic DIG™ technology** automatically adjusts the amount of current required to clear a short. Delivers a smoother, more consistent arc that can be tailored to match the application, material, fit-up and welder technique.

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**Reverse compatible.** ArcReach-equipped power sources work with non-ArcReach accessories; however, the complete ArcReach benefit is only realized with the ArcReach system.

**Big Blue® 400 PipePro® System and ArcReach® Accessories**

- **ArcReach SuitCase 8 and 12 feeders for MIG or flux-cored welding**
  - Remote voltage control
  - Polarity indication
  - Auto-Process Select™

- **ArcReach Stick/TIG Remote for stick or TIG welding**
  - Remote amperage control
  - Arc control for stick
  - Auto-Process Select™

- **ArcReach Smart Feeder for advanced wire processes**
  - RMD® and pulsed MIG processes
  - Remote voltage control
  - Store and recall weld settings

- **Big Blue 400 PipePro system (stainless steel enclosure, see page 8 for engine drive models and stock numbers)**, ArcReach SuitCase® 12 feeder with Bernard™ S-Gun™ (951730), ArcReach Stick/TIG Remote (301325), and ArcReach Smart Feeder with Bernard PipeWorx 300-15 MIG gun (951733).
## Engine Specifications (Engines warranted separately by the engine manufacturer.)

<table>
<thead>
<tr>
<th>Engine Brand</th>
<th>Features</th>
<th>HP</th>
<th>Type</th>
<th>Engine Speeds</th>
<th>Capacities</th>
<th>Automatic Engine Shutdown</th>
</tr>
</thead>
<tbody>
<tr>
<td>Caterpillar</td>
<td>EPA Tier 4 Final compliant, includes 120 V block heater</td>
<td>24.7</td>
<td>Turbo-charged three-cylinder, liquid-cooled industrial diesel</td>
<td>Idle: 1,500 rpm</td>
<td>Fuel: 11.5 gal. (43.5 L) Oil: 5.9 qt. (5.6 L) Coolant: 6 qt. (5.7 L)</td>
<td>Low oil pressure, high coolant temperature, low fuel level</td>
</tr>
<tr>
<td>C1.5T</td>
<td></td>
<td></td>
<td>Four-cylinder, liquid-cooled industrial diesel</td>
<td>Weld: 1,800 rpm</td>
<td>Fuel: 11.5 gal. (43.5 L) Oil: 5.8 qt. (5.5 L) Coolant: 10 qt. (9.5 L)</td>
<td></td>
</tr>
<tr>
<td>Mitsubishi</td>
<td></td>
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<td></td>
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<tr>
<td>S4L2</td>
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</table>

## Performance Data

### Fuel Consumption Curve

![Fuel Consumption Curve](image)

<table>
<thead>
<tr>
<th>DC Weld Amperes at 100% Duty Cycle</th>
<th>Simultaneous Welding and Power</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weld Amperes</td>
<td>Total Aux. Power Available (Watts)</td>
</tr>
<tr>
<td>25 A</td>
<td>10,000</td>
</tr>
<tr>
<td>75 A</td>
<td>10,000</td>
</tr>
<tr>
<td>125 A</td>
<td>10,000</td>
</tr>
<tr>
<td>175 A</td>
<td>9,000</td>
</tr>
<tr>
<td>225 A</td>
<td>7,500</td>
</tr>
<tr>
<td>300 A</td>
<td>4,500</td>
</tr>
<tr>
<td>350 A</td>
<td>1,000</td>
</tr>
</tbody>
</table>
1. Self-calibrating digital weld meters with fault code indication display preset or actual weld parameters.

2. Pushbutton main control knob used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

3. LED process indicator. Front panel process selections are illuminated with an LED that identifies the active process. This enables the selected weld process to be seen at a distance from the power source.

4. Lift-Arc™ TIG with Auto-Stop™ and Auto-Crater™.

5. USB port allows software updates from a USB drive. A summary file of recorded data from the unit will be saved to a USB drive that is inserted.

6. Weatherproof Lexan® nameplate is super durable and resists cracking and fading.

7. Adjustable arc control adjusts DIG when process control is in stick mode and adjusts inductance when process control is in FCAW or MIG mode. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the “wetness” of the weld puddle.

8. Maintenance interval reminder. Yellow and red indicator lights let an operator know when the machine is approaching and finally in need of routine maintenance.

9. Fuel indicator gauge. Low fuel shutdown shuts engine off prior to running out of fuel to prevent loss of fuel in the system, and make restarts easy.


11. Glow plugs assist in cold weather starting.

12. Engine control switch is used to start the engine and then select between auto idle and high speed lock.

13. Standard 14-pin receptacle for simple connection of remote controls and wire feeders. Includes Auto Remote Sense™ which automatically switches from panel to remote amperage/voltage (AV) control with remote connected. Eliminates confusion of a panel/remote switch.

14. 50 A, 120/240 V receptacle and 20 A, 120 V GFCI receptacles with circuit breakers
   Note: For matching 240 V plug, order 119172.

15. Weld output terminals
**Genuine Miller® Accessories**

**Full KVA Adapter Cord** 300517 Field
NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

**Full KVA Plug Kit** 119172 Field
120/240 V, 50 A plug (NEMA 14-50P) to fit full KVA receptacle.

**Engine Filter Kits**
- 274427 Field. For CAT Turbo
- 252782 Field. For Mitsubishi
Includes all filters required for proper engine maintenance. Oil filter, primary and secondary fuel filter, and primary air filter.

**Spark Arrestor (Muffler) Kit** 300585 Field
Prevents particles from leaving the muffler that could potentially start a fire. Mandatory when operating on California grasslands, brush, or forest-covered land, and in all national forests. For other areas, check your state and local laws. Meets U.S. Forest Service Standard 5100-1B.

**FA-1D Lockable Flame Arrestor Fuel Cap** 043947 Field
Fuel cap can be padlocked to prevent vandalism. A built-in flame arrestor prevents flames or sparks from entering the fuel tank.

**Protective Cover** 195301 Field
Blue water-resistant cover with Miller logo resists stains and mildew, and protects the finish of your welder.

**MIG (GMAW) or Flux-cored (FCAW)**

**ArcReach® SuitCase® 8**
- 951726 With Bernard™ BTB Gun 300 A
- 951727 With Bernard™ S-Gun™
- 951728 With Bernard™ Dura-Flux™ gun

**ArcReach® SuitCase® 12**
- 951729 With Bernard™ BTB Gun 300 A
- 951730 With Bernard™ S-Gun™
- 951731 With Bernard™ Dura-Flux™ gun
Portable feeder designed to run off of arc voltage. When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature M/6.55.

**ArcReach® Smart Feeder** 951733
For use with ArcReach models only (see pages 2 and 3 for more information). Includes drive rolls and Bernard™ PipeWorx 300-15 MIG gun. For MIG, FCAW, and advanced RMD® and pulse processes. See literature M/6.55.

**SuitCase® 12RC Wire Feeder** 951580
Lightweight and flexible enough to run wires up to .062-inch diameter. Includes remote voltage control, drive roll kit and Bernard™ BTB Gun 300 A. See literature M/6.5.

**MIG (GMAW)/Flux-cored (FCAW) Guns**
See Bernard™ literature SP-BTB for BTB air-cooled MIG guns, and SP-DF for Dura-Flux™ self-shielded flux-cored guns.

**Spoolmatic® 30A Spool Gun** 130831
Air-cooled, 200-amp, one-pound spool gun for aluminum and stainless MIG. See literature M/1.73. Requires WC-24 Control (137549).

**XR™ Wire Feeders and Guns**
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

**AC TIG (GTAW) Welding**
The Dynasty 210 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

**Dynasty™ 210 Series**
For portable AC/DC TIG. See literature AD/4.81.

**Multiple Operator Welding**
The XMT 350 FieldPro and CST 280 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

**XMT™ 350 FieldPro™**
See literature DC/18.96.

**CST™ 280**
See literature DC/29.55.
Genuine Miller® Accessories (Continued)

Plasma Cutting

Spectrum 375 X-TREME and 625 X-TREME shown.

Spectrum® 375 X-TREME™ 907529
See literature PC/9.2.

Spectrum® 625 X-TREME™ 907579
See literature PC/9.6.

Spectrum® 875 907583
See literature PC/9.8.

The Spectrum 375 X-TREME and 625 X-TREME come complete with protective X-CASE™ (not shown).

Stick/TIG Remote Controls

ArcReach® Stick/TIG Remote 301325
When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature AY/14.5.

RHC-14 Hand Control 242211020
Miniature hand control for remote current, voltage and contactor control. Dimensions: 4 x 4 x 3.25 in. (102 x 102 x 82 mm). Includes 20-foot (6 m) cord and 14-pin plug.

Wireless Remote Hand Control 300430
For remote current, voltage and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Wireless Antenna Kit 300749
Recommended for improved reception.

Trailer Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Gross Axle Weight Rating</th>
<th>Gross Vehicle Weight Rating</th>
<th>Net Payload</th>
<th>Height of Bed</th>
<th>Road Clearance</th>
<th>Track (Center to center of tires)</th>
<th>Standard Tires (Standard rating or P-size rating)</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWY-Mid Frame</td>
<td>1,605 lb. (728 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>19.5 in. (495 mm)</td>
<td>8 in. (203 mm)</td>
<td>46 in. (1,168 mm)</td>
<td>ST175/80D-13 Load Range C</td>
<td>Length: 101 in. (2,565 mm)</td>
<td>Width: 56 in. (1,422 mm)</td>
</tr>
</tbody>
</table>

*Width at outside of fenders.

Trailers and Hitches (Note: Trailers are shipped unassembled.)

HWY-Mid Frame Trailer 301438
1,424-pound (646 kg) capacity highway trailer with welded steel tubing frame, heavy-duty axle with roller bearing hubs and leaf-spring suspension. Includes jack stand, fenders, lights, and dual hitch with 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye.

Dual Hitch 301441
Combination 2-inch (50 mm) ball hitch and 3-inch (76 mm) lunette eye in one reversible assembly.

Mounting Specifications

Cable Tree 043826
Provides an area to conveniently wrap weld cables and extension cords.

2-In-1 Document/Fire Extinguisher Holder 301236
Stores documents and holds a 5-pound fire extinguisher.

Note: Holder shown mounted on trailer. Fire extinguisher not included.

RMS-14 On/Off Control 187208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

PRHC-14 Hand Control 195511
Complete current or voltage control brings 120 volts GFCI power to work area in a single cord. Housed in a durable, light aluminum case and includes 125-foot (38 m) cord with plugs.

Extension Cables for 14-Pin Remote Controls or 24 VAC Wire Feeders
242208025 25 ft. (7.6 m)
242208050 50 ft. (15.2 m)
242208080 80 ft. (24.4 m)
## Equipment and Options

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>907778</td>
<td>CAT. Blue with ArcReach remote control technology</td>
<td></td>
<td></td>
</tr>
<tr>
<td>90778001</td>
<td>CAT. Stainless steel with ArcReach remote control technology</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907703001</td>
<td>Mitsubishi. Blue with ArcReach remote control technology</td>
<td></td>
<td></td>
</tr>
<tr>
<td>907703</td>
<td>Mitsubishi. Stainless steel with ArcReach remote control technology</td>
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</table>

### Field Accessories

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>300517</td>
<td>Full KVA Adapter Cord</td>
<td></td>
<td></td>
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<tr>
<td>119172</td>
<td>Full KVA Plug Kit</td>
<td>120/240 V.</td>
<td></td>
</tr>
<tr>
<td>274427</td>
<td>Engine Filter Kits</td>
<td>Field</td>
<td></td>
</tr>
<tr>
<td>252782</td>
<td>Field for CAT Turbo. Includes air, oil and fuel filters</td>
<td></td>
<td></td>
</tr>
<tr>
<td>300585</td>
<td>Spark Arrestor (Muffler) Kit</td>
<td>Field</td>
<td></td>
</tr>
<tr>
<td>043947</td>
<td>FA-1D Lockable Flame Arrestor Fuel Cap</td>
<td>Field</td>
<td></td>
</tr>
<tr>
<td>195301</td>
<td>Protective Cover</td>
<td>Field</td>
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### MIG/Flux-cored Welding

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tbody>
<tr>
<td>951726</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.55</td>
<td></td>
<td></td>
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<tr>
<td>951727</td>
<td>With Bernard™ S-Gun™</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951728</td>
<td>With Bernard™ Dura-Flux™ gun</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951729</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.55</td>
<td></td>
<td></td>
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<tr>
<td>951730</td>
<td>With Bernard™ S-Gun™</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951731</td>
<td>With Bernard™ Dura-Flux™ gun</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951733</td>
<td>MIG/FCAW/RMD®/pulse feeder with Bernard™ PipeWorx 300-15 MIG gun. Tweco®-style connectors. See literature M/6.55</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951580</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.5</td>
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### MIG (GMAW) and Flux-cored (FCAW) Guns

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tbody>
<tr>
<td>130831</td>
<td>Requires WC-24 Control. See literature M/1.73</td>
<td></td>
<td></td>
</tr>
<tr>
<td>137549</td>
<td>See literature M/1.7 through M/1.74</td>
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### AC TIG Welding

See page 6

### Plasma Cutting

See page 7

### Stick/TIG Remote Controls

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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</thead>
<tbody>
<tr>
<td>301325</td>
<td>Provides remote control of stick and TIG processes without a control cord</td>
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<td></td>
</tr>
<tr>
<td>242211020</td>
<td>Hand control with 20 ft. (6 m) cord</td>
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<tr>
<td>300430</td>
<td>Hand control with wireless 300 ft. (91.4 m) operating range</td>
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<tr>
<td>300749</td>
<td>Recommended for improved reception</td>
<td></td>
<td></td>
</tr>
<tr>
<td>187208</td>
<td>Remote contactor control</td>
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<tr>
<td>151086</td>
<td>Fingertip control</td>
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<tr>
<td>195511</td>
<td>Hand control with 120 V GFCI receptacle, 125 ft. (38 m)</td>
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</tbody>
</table>

### Trailers and Hitches

<table>
<thead>
<tr>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>301438</td>
<td>Trailer with lights, fenders and dual hitch. For highway use</td>
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<tr>
<td>301441</td>
<td>Combination 2 in. (50 mm) ball hitch and 3 in. (76 mm) lunette eye in one reversible assembly</td>
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<tr>
<td>043826</td>
<td>Trailer-mounted cable holder</td>
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<tr>
<td>301236</td>
<td>Stores documents and holds a 5 lb. fire extinguisher</td>
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</tbody>
</table>