

XR™ Controls

Push-Pull Control Feeders

Push-Pull Wire Feeders
for Aluminum Welding 

Quick Specs

Heavy Industrial Applications

Emergency vehicles	Shipbuilding
Recreational vehicles	Tool boxes
Trucks and trailers	Railcars
Heat exchangers	Fabrication
Sign manufacturers	

Processes

MIG (GMAW)
Pulsed MIG (GMAW-P)
with pulsing power source

Input Power

24 VAC, 50/60 or 100 Hz

Dimensions

H: 16 in. (406 mm)
W: 9.5 in. (241 mm)
D: 21.25 in. (540 mm)

Wire Speed

50–900 ipm (1.3–23 m/min.)
dependent on gun used

Net Weight

42.5 lb. (19.2 kg)

The XR-S or XR-D Control and XR push-pull guns combine to form an aluminum wire feeding system.

True torque feed motor push-pull design provides continuous push force to the wire while the gun motor controls the speed at the gun. The motors work together to provide accurate and positive wire feed speed without wire shaving or deformation.

Adjustable wire run-in control allows arc start fine tuning. Reduces wire stubbing or arc flaring which can result in contact tip burnback.

Wire jog control allows wire to be threaded through gun cable without energizing weld output.



XR-S

XR-D

A complete system consists of the following:

- XR Control
- XR push-pull gun
- Recommended 14-pin Miller power source

Order separately, see page 4.

Trigger hold reduces fatigue by allowing operator to make long welds without holding trigger.

Feeders include .035- and 3/64-inch (0.9 and 1.2 mm) drive rolls.

Note: All XR Controls come set up out of the box to run 3/64-inch (1.2 mm) 5356 wire. If running 1/16-inch wire, order drive rolls separately.

XR-S

Simple, cost-effective push-pull feeder has **wire feed speed display, jog/purge, run-in control, and trigger hold**. Excellent choice for those who want a basic push-pull feeder, or have basic CV power sources.

Unit is **factory set with preflow on (0.2 seconds) and postflow off**. Preflow can be turned off and postflow turned on (3.5 seconds) via internal dip switch setting.

XR-D

Provides advanced digital and programming capabilities. Unit has the same features as the XR-S model, but adds a **digital weld voltage display and remote voltage control**.

Unit has improved **programmable interface for preflow/postflow, and start and crater settings** for more critical welding applications.



Wire feeder is warranted for three years, parts and labor.
Gun warranted for one year, parts and labor.



Miller Electric Mfg. Co.
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
    



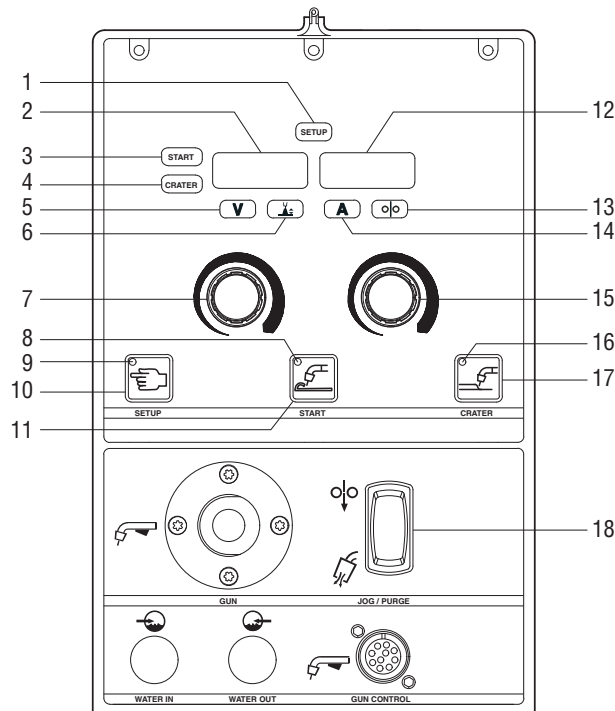
Specifications (Subject to change without notice.)

CC CV **DC** (Use with CC/CV, DC power sources.)

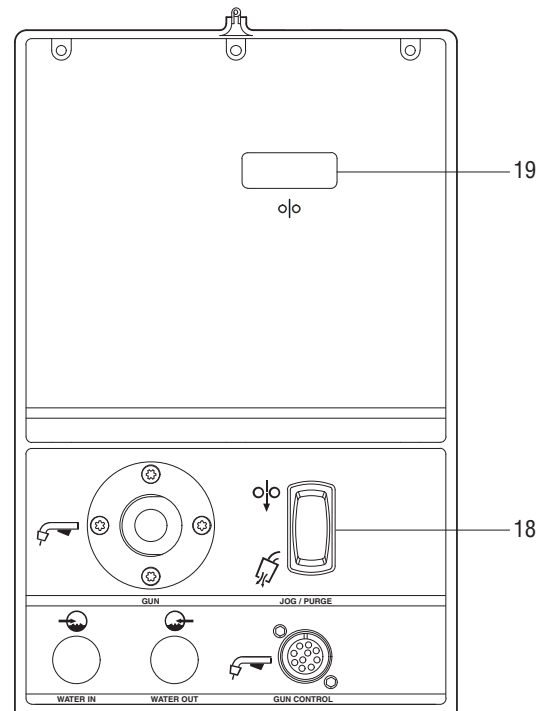
Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Maximum Spool Size Capacity	Dimensions	Net Weight
24 VAC, 5 A, 50/60 Hz	400 A at 100% duty cycle System duty cycle is limited to gun rating	50–900 ipm (1.3–22.9 m/min.)	Aluminum .035–.062 in. (0.9–1.6 mm) Solid Wire .035–.045 in. (0.9–1.2 mm) Drive roll kit 268850 required to run 1/16 in. (1.6 mm) wire	12 in. (305 mm)	H: 16 in. (406 mm) W: 9.5 in. (241 mm) D: 21.25 in. (540 mm)	42.5 lb. (19.2 kg)

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

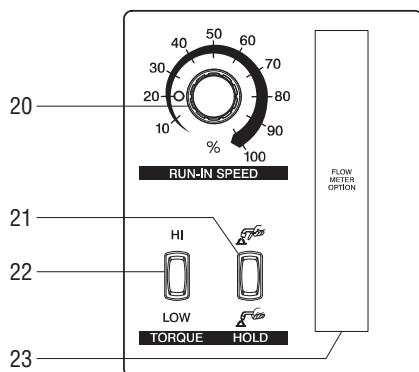
Control Panels



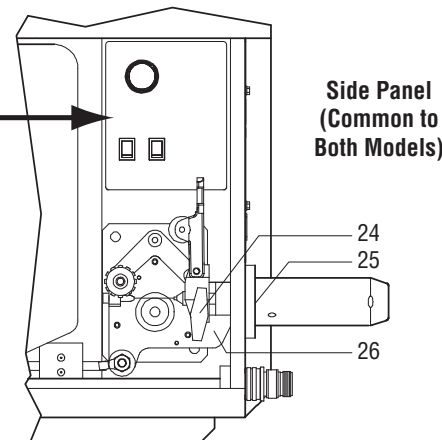
XR-D Front Panel



XR-S Front Panel



**Side Panel Detail
(Common to Both Models)**



**Side Panel
(Common to
Both Models)**

- | | | | |
|--------------------------|--------------------------|--------------------------|---------------------------------|
| 1. Setup Menu Indicator | 8. Start On Indicator | 15. Right Adjust Knob | 22. Motor Torque Switch |
| 2. Left Display | 9. Setup Indicator | 16. Crater On Indicator | 23. Gas Flowmeter
(Optional) |
| 3. Start Menu Indicator | 10. Setup Button | 17. Crater Button | 24. Gun Securing Knob |
| 4. Crater Menu Indicator | 11. Start Button | 18. Jog/Purge Switch | 25. Gun Bushing |
| 5. Volts Indicator | 12. Right Display | 19. Wire Speed Display | 26. Drive Casting |
| 6. Arc Length Indicator | 13. Wire Speed Indicator | 20. Run-In Speed Control | |
| 7. Left Adjust Knob | 14. Amps Indicator | 21. Trigger Hold Switch | |

Genuine Miller® Options and Accessories



Gas Flowmeter Kit 246127 Field Monitors and adjusts gas flow at the feeder.

Note: Gas pressure must be controlled at the primary gas supply with the use of a regulator.



PSA-2 Control 141604

Required when using the XR Control with power sources having only 115 VAC available. Mounts at power source and includes a 10-foot (3 m) 115 VAC cord and contactor cord with Hubbell connectors. A simple modification in the PSA-2 control also allows it to be used with competitive constant voltage power sources requiring a contact closure for contactor control. Control includes a 14-pin receptacle for direct connection of the standard interconnecting cord and optional extension cords. Bracket included for side mounting to the power source.

Note: When using the PSA-2 control, the Remote Voltage Control is not functional.

Extension Cords

242208025 25 ft. (7.6 m)

242208050 50 ft. (15 m)

242208080 80 ft. (24.4 m)

Provides 14-pin, 24 VAC contactor and voltage control. Can be added to the standard 10-foot (3 m) feeder cord to extend feeder farther from power source.

Coolant Systems

For more information, see literature AY/7.2.



Coolmate™ 3 043007 115 V

043008 230 V

For use with water-cooled torches rated up to 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

paddle-wheel indicator, external filter and easy-fill spout.



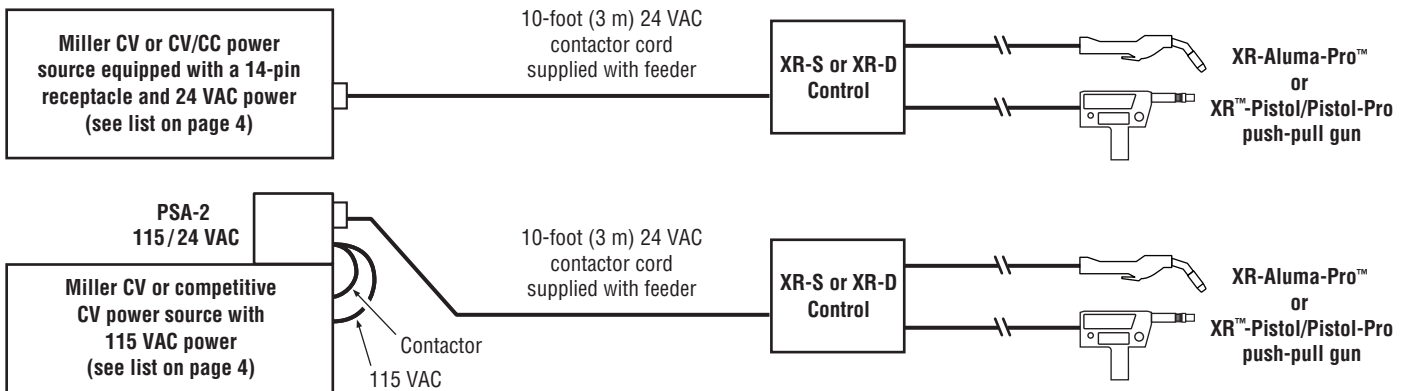
Coolmate™ 4 042288 115 V

For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Coolant 043809

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 degrees Fahrenheit (-38° C) or boiling to 227 degrees Fahrenheit (108° C). Also contains a compound that resists algae growth.

Typical Installations



Ordering Information

XR-S and XR-D Controls require the following to form a complete system:

- XR-push-pull gun (see at right)
- Recommended Miller 14-pin power source (see list below)

Important notes:

XR Control must be serial number KK309906 or higher to be used with products and descriptions mentioned in this literature. To confirm a product's compatibility with older equipment, please contact the factory at 1-920-735-4505.

Recommended Power Sources

AlumaPower™ MPa
See literature DC/34.0
Deltaweld® Series
See literature DC/16.2

Dimension™ 650
See literature DC/19.3
XMT® 350 Series
See literature DC/18.93
XMT® 450 Series
See literature DC/18.94

Invision™ MPa
See literature DC/23.6
Trailblazer® 275 and 325
See literature ED/4.75
Big Blue® 800 Series
See literature ED/14.0

Note: Other power sources may be used.

Equipment	Stock No.	Description	Qty.	Price
XR™-S Control	300601	Standard model with wire feed speed digital display, jog/purge, run-in control, and trigger hold		
XR™-D Control	300687	Enhanced model has same features as XR-S model plus advanced digital and programming capabilities		
XR-Aluma-Pro™ Gun (Air-cooled)	300000	15 ft. (4.6 m) cable		
	300001	25 ft. (7.6 m) cable	See literature M/1.71	
	300264	35 ft. (10.6 m) cable		
XR-Aluma-Pro™ Gun (Water-cooled)	300003	15 ft. (4.6 m) cable		
	300004	25 ft. (7.6 m) cable	See literature M/1.71	
	300265	35 ft. (10.6 m) cable		
XR™-Pistol Gun (Air-cooled)	198127	15 ft. (4.6 m) cable	See literature M/1.73	
	198128	30 ft. (9 m) cable		
XR™-Pistol Gun (Water-cooled)	198129	15 ft. (4.6 m) cable	See literature M/1.73	
	198130	30 ft. (9 m) cable		
XR™-Pistol-Pro Gun (Air-cooled)	300782	15 ft. (4.6 m) cable		
	300783	25 ft. (7.6 m) cable	See literature M/1.74	
	300784	35 ft. (10.6 m) cable		
XR™-Pistol-Pro Gun (Water-cooled)	300786	15 ft. (4.6 m) cable		
	300787	25 ft. (7.6 m) cable	See literature M/1.74	
	300788	35 ft. (10.6 m) cable		
XR Control Drive Rolls (Control box includes .035 and 3/64 in. drive rolls. Order 1/16 in. drive rolls separately)	268847	.030 in. (0.8 mm) Order from Miller Service Parts		
	268847	.035 in. (0.9 mm) Order from Miller Service Parts		
	268848	.040 in. (1.0 mm) Order from Miller Service Parts		
	268849	.047 in. (1.2 mm) Order from Miller Service Parts		
	268850	1/16 in. (1.6 mm) Order from Miller Service Parts		
Options				
Gas Flowmeter Kit	246127	Field		
Accessories				
PSA-2 Control	141604	For older power sources with 115 V feeder power		
Extension Cords		See page 3		
Coolant Systems		See page 3. See literature AY/7.2		

Date:

Total Quoted Price:

Distributed by:

