

# XR-S<sup>TM</sup> Control

## Push-Pull Control Feeder

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

Simple, cost-effective push-pull feeder has **wire feed speed display, jog/purge, run-in control, and trigger hold**. It's an 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.

**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.



A complete system consists of the following:

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

Order separately, see page 4.

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

**XR-S includes .035- and 3/64-inch (0.9 and 1.2 mm) drive rolls.**

*Note: XR-S Control comes 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.*



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



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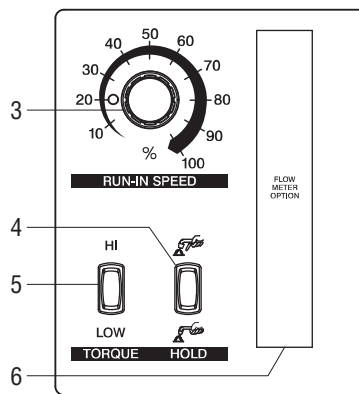
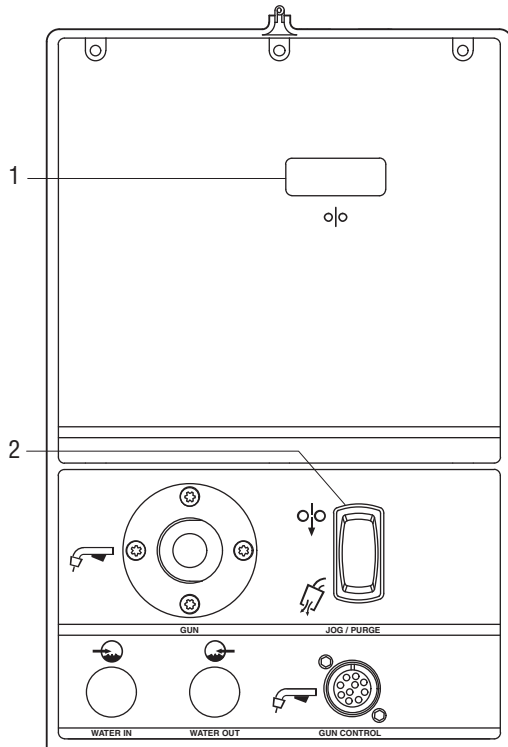
# Specifications (Subject to change without notice.)

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

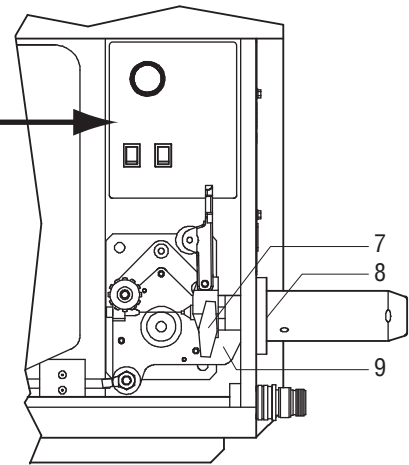
Input Power	Input Welding Circuit Rating	Wire Feed Speed	Wire Type and Diameter Capacity	Maximum Spool Size Capacity	Dimensions	Net Weight
24 VAC, 5 A, 50/60 Hz	400 A at 100% duty cycle System duty cycle is limited to gun rating	50–900 ipm (1.3–22.9 m/min.)	<b>Aluminum</b> .035–1/16 in. (0.9–1.6 mm) <b>Solid Wire</b> .035–.045 in. (0.9–1.2 mm) Drive roll kit <b>268850</b> 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



Side Panel Detail



Side Panel

- |                         |                             |
|-------------------------|-----------------------------|
| 1. Wire Speed Display   | 6. Gas Flowmeter (Optional) |
| 2. Jog/Purge Switch     | 7. Gun Securing Knob        |
| 3. Run-In Speed Control | 8. Gun Bushing              |
| 4. Trigger Hold Switch  | 9. Drive Casting            |
| 5. Motor Torque 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-S Control with power sources having only 115-volt power available. Can also be used with competitive constant voltage power sources requiring a contact

closure for contactor control. Control mounts at power source and is equipped with a 14-pin receptacle and a 10-foot (3 m) interconnecting cable with Hubbell connections for older-style power sources. Bracket included for side mounting to the power source.

### 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.



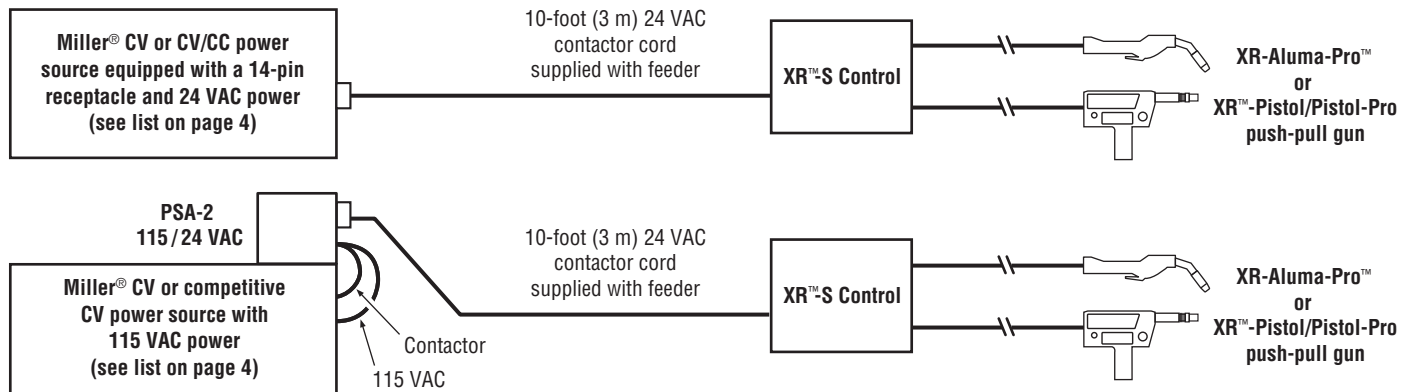
**Coolmate™ 4 042288** 115 V

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 Control requires the following to form a complete system:**

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

**Important note:**

XR-S 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

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® Series  
See literature ED/4.75

Big Blue® 800 Series  
See literature ED/14.0

Note: Other power sources may be used.

Equipment and Options	Stock No.	Description	Qty.	Price
<b>XR™-S Control</b>	<b>300601</b>	Features wire feed speed digital display, jog/purge, run-in control, and trigger hold		
Gas Flowmeter Kit	<b>246127</b>	Field		
<b>Push-Pull Guns</b>				
XR-Aluma-Pro™ Gun (Air-cooled)	<b>300000</b>	15 ft. (4.6 m) cable		
	<b>300001</b>	25 ft. (7.6 m) cable	See literature M/1.71	
	<b>300264</b>	35 ft. (10.6 m) cable		
XR-Aluma-Pro™ Gun (Water-cooled)	<b>300003</b>	15 ft. (4.6 m) cable		
	<b>300004</b>	25 ft. (7.6 m) cable	See literature M/1.71	
	<b>300265</b>	35 ft. (10.6 m) cable		
XR™-Pistol Gun (Air-cooled)	<b>198127</b>	15 ft. (4.6 m) cable	See literature M/1.73	
	<b>198128</b>	30 ft. (9 m) cable		
XR™-Pistol Gun (Water-cooled)	<b>198129</b>	15 ft. (4.6 m) cable	See literature M/1.73	
	<b>198130</b>	30 ft. (9 m) cable		
XR™-Pistol-Pro Gun (Air-cooled)	<b>300782</b>	15 ft. (4.6 m) cable		
	<b>300783</b>	25 ft. (7.6 m) cable	See literature M/1.74	
	<b>300784</b>	35 ft. (10.6 m) cable		
XR™-Pistol-Pro Gun (Water-cooled)	<b>300786</b>	15 ft. (4.6 m) cable		
	<b>300787</b>	25 ft. (7.6 m) cable	See literature M/1.74	
	<b>300788</b>	35 ft. (10.6 m) cable		
<b>Accessories</b>				
XR-S Control Drive Rolls (Control box includes .035 and 3/64 in. drive rolls.)	<b>268847</b>	.030 in. (0.8 mm)		
	<b>268847</b>	.035 in. (0.9 mm)		
	<b>268848</b>	.040 in. (1.0 mm)		
	<b>268849</b>	3/64 in. (1.2 mm)		
	<b>268850</b>	1/16 in. (1.6 mm)		
PSA-2 Control	<b>141604</b>	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:

