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.
Specifications (Subject to change without notice.)
(Use with CC/CV, DC power sources.)

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

Control Panels

1. Wire Speed Display
2. Jog/Purge Switch
3. Run-In Speed Control
4. Trigger Hold Switch
5. Motor Torque Switch
6. Gas Flowmeter (Optional)
7. Gun Securing Knob
8. Gun Bushing
9. Drive Casting

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 .035–1/16 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)
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.

Typical Installations

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.

PSA-2 115/24 VAC
Miller® CV or competitive CV power source with 115 VAC power (see list on page 4)

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.
### XR-S Control requires the following to form a complete system:
- XR-push-pull gun (see 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.*

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#### Ordering Information

<table>
<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR™-S Control</td>
<td>300601</td>
<td>Features wire feed speed digital display, jog/purge, run-in control, and trigger hold</td>
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<tr>
<td>Gas Flowmeter Kit</td>
<td>246127</td>
<td>Field</td>
<td></td>
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#### Push-Pull Guns

<table>
<thead>
<tr>
<th>Gun Type</th>
<th>Stock No.</th>
<th>Cable Length</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR-Aluma-Pro™ Gun</td>
<td>300000</td>
<td>15 ft. (4.6 m)</td>
<td></td>
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<tr>
<td></td>
<td>300001</td>
<td>25 ft. (7.6 m)</td>
<td></td>
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<tr>
<td></td>
<td>300264</td>
<td>35 ft. (10.6 m)</td>
<td>See literature M/1.71</td>
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<tr>
<td>XR-Aluma-Pro™ Gun</td>
<td>300003</td>
<td>15 ft. (4.6 m)</td>
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<tr>
<td>(Water-cooled)</td>
<td>300004</td>
<td>25 ft. (7.6 m)</td>
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<tr>
<td></td>
<td>300265</td>
<td>35 ft. (10.6 m)</td>
<td>See literature M/1.71</td>
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<tr>
<td>XR™-Pistol Gun</td>
<td>198127</td>
<td>15 ft. (4.6 m)</td>
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<tr>
<td>(Air-cooled)</td>
<td>198128</td>
<td>30 ft. (9 m)</td>
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<tr>
<td>XR™-Pistol Gun</td>
<td>198129</td>
<td>15 ft. (4.6 m)</td>
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<tr>
<td>(Water-cooled)</td>
<td>198130</td>
<td>30 ft. (9 m)</td>
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<tr>
<td>XR™-Pistol-Pro Gun</td>
<td>300782</td>
<td>15 ft. (4.6 m)</td>
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<tr>
<td>(Air-cooled)</td>
<td>300783</td>
<td>25 ft. (7.6 m)</td>
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<td></td>
<td>300784</td>
<td>35 ft. (10.6 m)</td>
<td>See literature M/1.74</td>
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<tr>
<td>XR™-Pistol-Pro Gun</td>
<td>300786</td>
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<td>(Water-cooled)</td>
<td>300787</td>
<td>25 ft. (7.6 m)</td>
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<td>300788</td>
<td>35 ft. (10.6 m)</td>
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#### Accessories

<table>
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<tr>
<th>Items</th>
<th>Stock No.</th>
<th>Description</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR-S Control Drive Rolls</td>
<td>268847</td>
<td>(Control box includes .035 in. and 3/64 in. drive rolls)</td>
<td>.030 in. (0.8 mm)</td>
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<tr>
<td></td>
<td>268847</td>
<td>.035 in. (0.9 mm)</td>
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<td></td>
<td>268848</td>
<td>.040 in. (1.0 mm)</td>
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<td></td>
<td>268849</td>
<td>3/64 in. (1.2 mm)</td>
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<tr>
<td></td>
<td>268850</td>
<td>1/16 in. (1.6 mm)</td>
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<tr>
<td>PSA-2 Control</td>
<td>141604</td>
<td>For older power sources with 115 V feeder power</td>
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<tr>
<td>Extension Cords</td>
<td></td>
<td>See page 3</td>
<td></td>
</tr>
<tr>
<td>Coolant Systems</td>
<td></td>
<td>See page 3. See literature AY/7.2</td>
<td></td>
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</tbody>
</table>

**Total Quoted Price:**

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