

XR™-S and XR™-D Controls

Push-Pull Control Feeders

Issued March 2010 • Index No. M/1.7

Push-Pull
Wire Feed System 

Quick Specs

Heavy Industrial Applications

| | |
|-----------------------|--------------|
| Emergency Vehicles | Shipbuilding |
| Recreational Vehicles | Tool Boxes |
| Trucks and Trailers | Railcars |
| Heat Exchangers | Fabrication |
| Sign Manufacturers | |

Processes

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

Input Power

24 VAC, 50/60 Hz

Dimensions

H: 16 in (406 mm)
W: 9-1/2 in (241 mm)
D: 21-1/4 in (540 mm)

Wire Speed

70–780 IPM (1.8–19.8 m/min)
(Dependent on gun used)

Weight

42.5 lb (19.2 kg)

The Power of Blue.®

True push-pull wire feeder. Slave/torque motor provides continuous push force to the wire while the gun motor controls wire feed speed at the arc, together providing accurate and positive wire feed speed over long distances (up to 35 ft).

Run-in control can be adjusted to tune arc starting, reducing wire stubbing or arc flaring which can result in burnbacks to the contact tip.

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



Updated design, same great reliability and performance.



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 pg. 4

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

Feeders include .035 and 3/64 in drive rolls. 3/64 in installed. If running 1/16 in wire, order drive rolls separately.

XR-S Model

A simple alternative to costly complicated systems. Unit has only **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.

XR-D Model

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 3 years, parts and labor.
Guns are warranted for 1 year.

MADE IN **USA**
APPLETON, WI



Miller Electric Mfg. Co.
An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

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

Web Site
www.MillerWelds.com



Specifications (Subject to change without notice.)

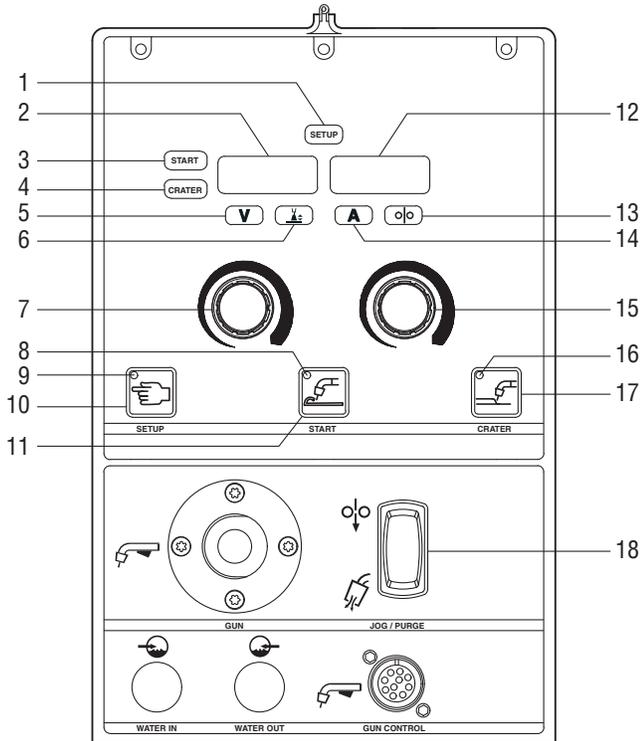


(Use with CC/CV, DC Power Sources.)

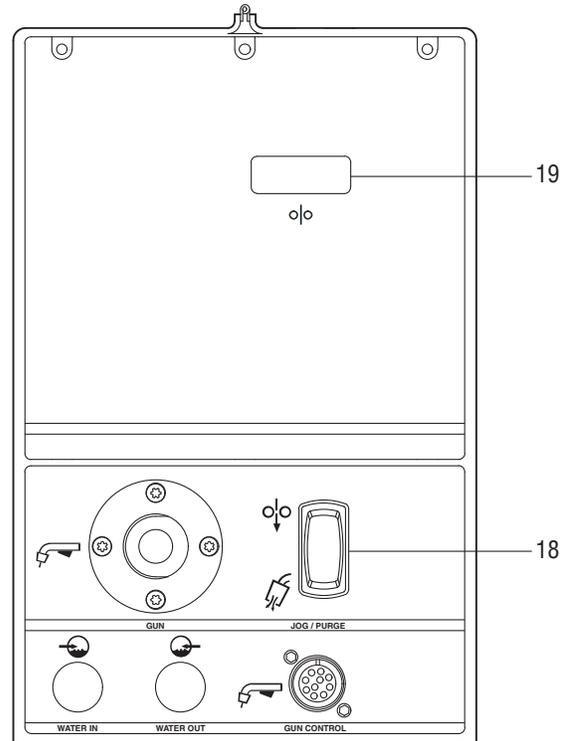
| Input Power | Input Welding Circuit Rating | Wire Speed | Wire Diameter Range | Maximum Spool Size Capacity | Dimensions | Net Weight |
|-----------------------|---|--------------------------------|---|-----------------------------|--|-------------------|
| 24 VAC, 5 A, 50/60 Hz | 400 A at 100% Duty Cycle (System duty cycle is limited to gun rating.) | 70–780 IPM (1.8–22.2 m/min) | Aluminum: .035–.062 in (0.9–1.6 mm) Solid Wire: .035–.045 in (0.9–1.2 mm) Drive roll kit #195 591 required to run 1/16 in (1.6 mm) wire | 12 in (305 mm) | H: 16 in (406 mm) W: 9-1/2 in (241 mm) D: 21-1/4 in (540 mm) | 42.5 lb (19.2 kg) |

Certified to both the Canadian and U.S. Standards for welding equipment.

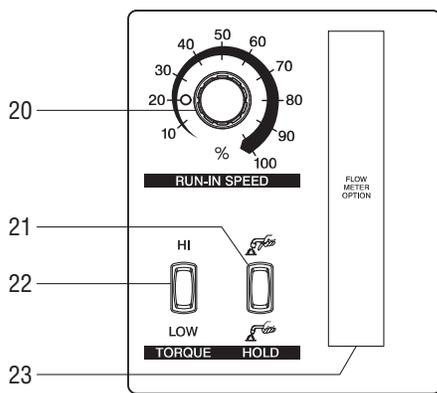
Control Panels



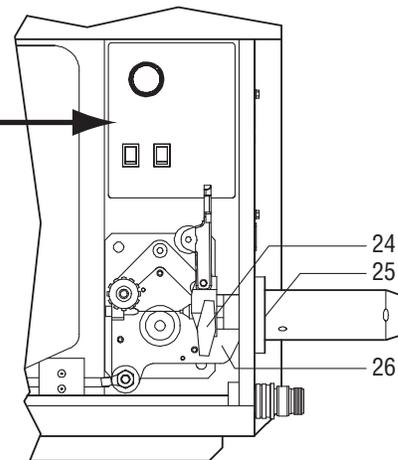
XR-D Front Panel



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 #246 127 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.



Optima™ MIG (GMAW) Pulse Control #043 389

For Invisions and XMTs (except MPa and VS models). A multipurpose, microprocessor-based pulse control for synergic MIG (wire welding or GMAW), manual MIG pulsing or standard MIG welding. Use this control with all above power sources and any Miller wire feeder. Includes 25 ft (7.6 m) cord with 14-pin plug.



PSA-2 Control #141 604 Required when using the XR Control with power sources having only 115 VAC available. Mounts at power source and includes a 10 ft (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. The PSA-2 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 optional Remote Voltage Control is not functional.

Extension Cords

#122 973 25 ft (7.6 m)

#122 974 50 ft (15.2 m)

#122 975 75 ft (22.9 m)

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

Water Coolant Systems



Coolmate™ 3 #043 007 115 VAC

Coolmate™ 3 #043 008 230 VAC

Coolmate™ V3 #043 009 115 VAC

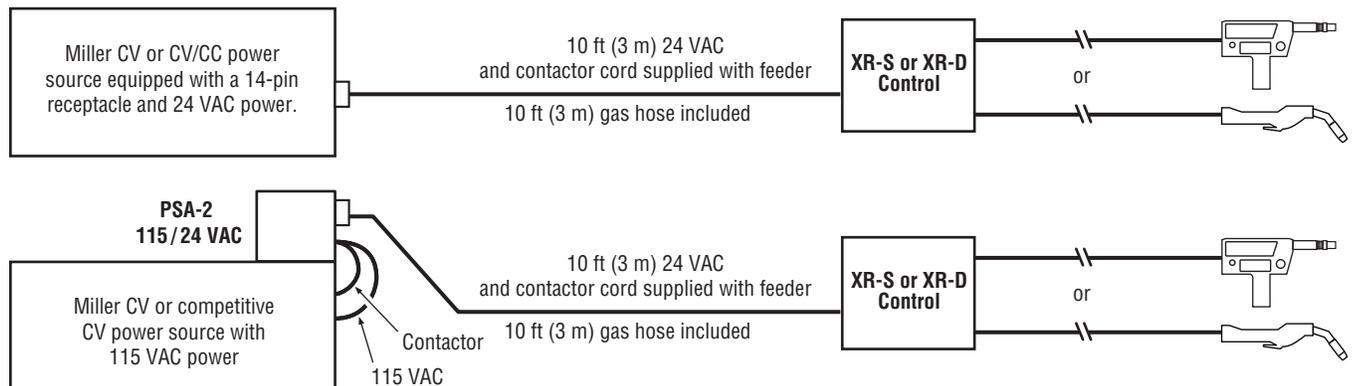
Coolmate™ 4 #042 288 115 VAC

For use with water-cooled guns. Refer to Lit. Index No. AY/7.2 for additional coolant system information.

Coolant #043 809

Sold in cases of four 1-gallon recyclable plastic bottles.

Typical Installations



Ordering Information (Use the 3-step process below to assemble a complete system.)

How to Assemble a System

1 Pick a Control XR-S or XR-D



2 Pick a Gun Style Gooseneck or Pistol (15, 25, 30 or 35 ft Cable, Air- or Water-Cooled)



See Lit. Index No. M/1.71 or M/1.73 for information on Gooseneck or Pistol guns

3 Pick a Power Source*

Deltaweld® Series Lit. Index No. DC/16.2
 XMT® 350 Lit. Index No. DC/18.83
 Invision™ 352 MPa Lit. Index No. DC/23.6
 Trailblazer® Series Lit. Index No. ED/4.77
 PipePro® 304 Lit. Index No. ED/10.6

*Other power sources may be used.

| Equipment | Stock No. | Description | Qty. | Price |
|--|-----------------|---|------|-------|
| XR™-S Control | #300 601 | Standard model with wire feed speed digital display, jog/purge, run-in control, and trigger hold | | |
| XR™-D Control | #300 687 | Enhanced model has same features as XR-S model plus advanced digital and programming capabilities | | |
| XR-Aluma-Pro A Gun (Air-Cooled) | #300 000 | 15 ft (4.6 m) cable | | |
| | #300 001 | 25 ft (7.6 m) cable See Lit. Index No. M/1.71 | | |
| | #300 264 | 35 ft (10.6 m) cable | | |
| XR-Aluma-Pro W Gun (Water-Cooled) | #300 003 | 15 ft (4.6 m) cable | | |
| | #300 004 | 25 ft (7.6 m) cable See Lit. Index No. M/1.71 | | |
| | #300 265 | 35 ft (10.6 m) cable | | |
| XR-A Pistol Grip Gun (Air-Cooled) | #198 127 | 15 ft (4.6 m) cable See Lit. Index No. M/1.73 | | |
| | #198 128 | 30 ft (9 m) cable | | |
| XR-W Pistol Grip Gun (Water-Cooled) | #198 129 | 15 ft (4.6 m) cable See Lit. Index No. M/1.73 | | |
| | #198 130 | 30 ft (9 m) cable | | |
| XR-Control Drive Rolls <i>(Control box includes .035 and 3/64 in drive rolls. Order 1/16 in drive rolls separately)</i> | #194 118 | .030 in (0.8 mm) <i>(Order from Miller Service Parts.)</i> | | |
| | #194 118 | .035 in (0.9 mm) <i>(Order from Miller Service Parts.)</i> | | |
| | #196 301 | .040 in (1.0 mm) <i>(Order from Miller Service Parts.)</i> | | |
| | #194 119 | .047 in (1.2 mm) <i>(Order from Miller Service Parts.)</i> | | |
| | #195 591 | .062 in (1.6 mm) <i>(Order from Miller Service Parts.)</i> | | |
| Options | | | | |
| Gas Flowmeter Kit | #246 127 | Field | | |
| Accessories | | | | |
| Optima MIG Pulse Control | #043 389 | | | |
| PSA-2 Control | #141 604 | For older power sources w/115 V feeder power | | |
| Extension Cords | | See XR-Control Accessories on page 3 | | |
| Water Coolant Systems | | See Lit. Index No. AY/7.2 | | |

Date:

Total Quoted Price:

Important note: The products and descriptions mentioned in this literature are for use with XR-Control systems with serial #KK309906 or higher. To confirm compatibility of any products listed here with older equipment, please contact the factory at 1-920-735-4505.

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