

XR™ Control

Push-Pull Wire Feed System

Index No. M/1.7
Issued June 2000



Process

 MIG (GMAW)
Welding

TRUE BLUE
3YR. WARRANTY
1-year warranty on gun



Note: Drive roll kit must be ordered separately.



The XR Control push-pull wire feed system now offers the ability to select either an XR-Edge gooseneck-style gun or an XR-Pistol gun for a truly customized system that delivers optimum performance for your desired application.

The XR-A and XR-W Pistol guns have been redesigned with a quick-connect, similar to the XR-Edge guns, for easy connection to the XR Control. The XR-Pistol guns are available in 15 and 30 ft lengths, and the XR-Edge gooseneck-style guns are available in 15, 30 and 50 ft lengths. All guns are available in both air- and water-cooled models.

The wire drive kits are to be **ordered separately** from the guns because the drive rolls are wire size dependent. All wire drive kits consist of gun drive rolls, two push feeder drive rolls, head tube liner, five contact tips, collet nut and a contact tip wrench

A unique solid-state control circuit permits the XR systems to work with most CC, CV, or CC/CVDC welding power sources, giving you true adaptability.

Applications

- Emergency vehicles
- Boat building
- Shipbuilding
- Trucks and trailers
- Railcars
- Snowmobiles
- Watercraft
- Recreational vehicles
- Tool boxes
- Heat exchangers
- Overhead doors
- Sign manufacturers
- Automotive components

Features

Benefits

Air-cooled and water-cooled models	Whether your application is light gauge metals or demanding, high-amperage heavy plate, we've got the model for you.
All gear-driven drive rolls	Both rolls are driving the wire for positive feeding performance, reducing burnbacks and improving arc starts.
Smooth groove drive-roll design	Prevents shaving the wire, which causes build-up in the drive-roll grooves, liner and contact tip. Improved feeding performance, helping to eliminate burnbacks and enhancing arc starts.
True push-pull design	The push feeder motor provides continuous torque to the wire. The gun motor controls the actual wire feed speed at the arc. Each motor works in concert to provide accurate and positive wire feed speed.
Arc starting control	The control has wire run-in speed, which can be adjusted to tune arc starting. This prevents wire stubbing or arc flaring which leads to burnbacks to the contact tip.
Wire jog control	Allows you to thread wire through gun cable without energizing weld output.
Master/gun wire-feed-speed control	Improves resolution, by limiting speed range available at the gun. This makes it easier to fine-tune arc conditions.
Trigger hold	Reduces fatigue by allowing the operator to weld without holding the gun trigger.

XR Control Specifications (Subject to change without notice.)

Heavy Industrial



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

Input Power	Wire Speed	Maximum Spool Size Capacity	Dimensions	Net Weight
24 VAC, 50/60 or 100 Hz	70–875 IPM (1.8–22.2 m/min)	12 in (305 mm)	H: 16 in (406 mm) W: 9-1/4 in (235 mm) D: 21-1/4 in (540 mm)	38 lb (17.2 kg)

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

 Conforms to European standards.

Ordering Information  See back page.



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

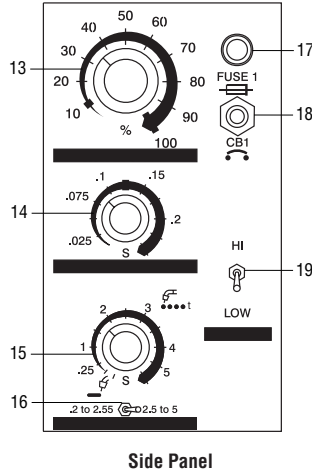
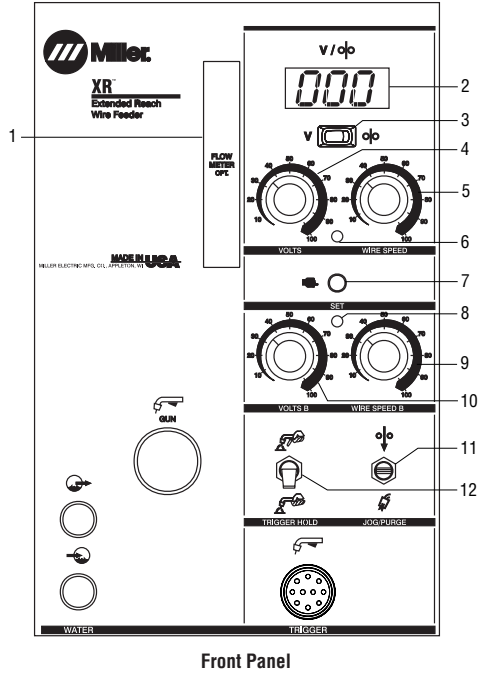
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XR Control

Control Panels



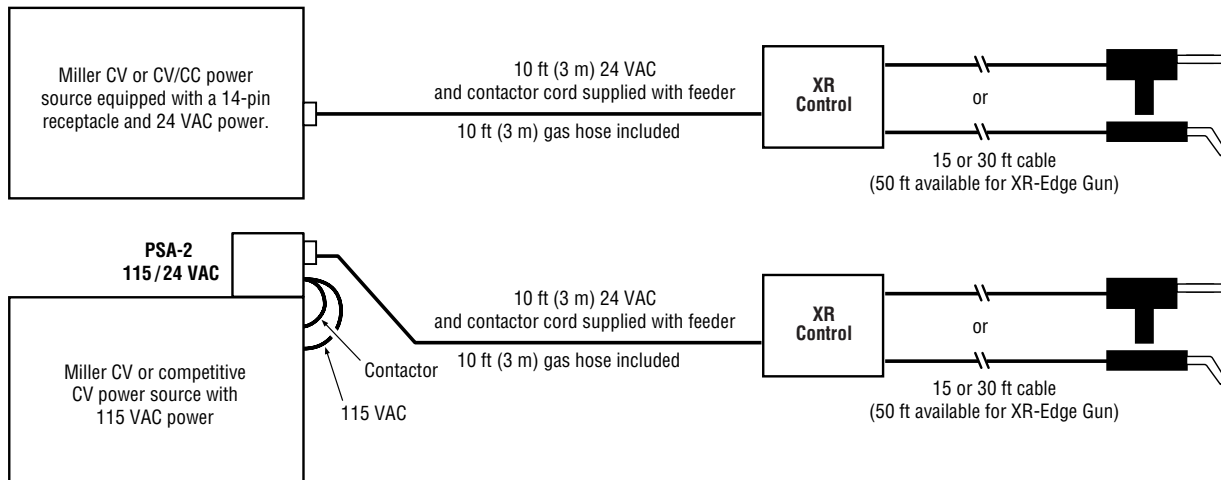
1. Gas Flowmeter*
 2. Voltage/Wire Speed Meter*
 3. Voltage/Wire Speed Switch*
 4. Voltage Control*
 5. Wire Speed Control
 6. Schedule A Indicator LED*
 7. Press To Set Push Button*
 8. Schedule B Indicator LED*
 9. Wire Speed B Control*
 10. Remote Volts B Control*
 11. Wire Jog/Gas Purge Switch
 12. Trigger Hold Switch
 13. Run-In Speed Control
 14. Burnback Time Control*
 15. Continuous/Spot Time Control*
 16. Spot Time Range Switch*
 17. Fuse F1
 18. Circuit Breaker CB1
 19. Motor Torque Switch
- * Optional

XR Control Drive Roll Kits (Order from Miller Service Parts.)

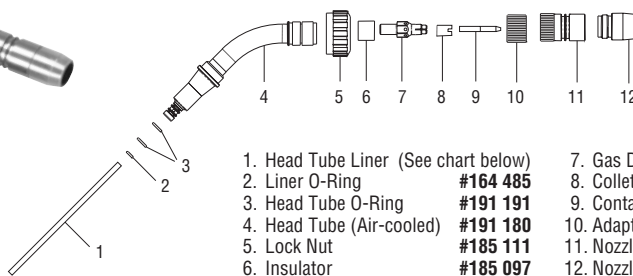
Wire Size	
.030 in (0.8 mm)	#194 118
.035 in (0.9 mm)	#194 118
.040 in (1.0 mm)	#196 301
.047 in (1.2 mm)	#194 119
.062 in (1.6 mm)	#194 119

Drive roll kits consist of two control drive rolls, insulating washers and installation instructions.

Typical Installations Refer to Owner's Manual for complete installation instructions.



XR-Edge Gun (Note: Air-cooled gun shown)



- | | | |
|--------------------------------------|----------------------------------|----------|
| 1. Head Tube Liner (See chart below) | 7. Gas Defuser | #185 110 |
| 2. Liner O-Ring | 8. Collet Nut | #136 748 |
| 3. Head Tube O-Ring | 9. Contact Tip (See chart below) | |
| 4. Head Tube (Air-cooled) | 10. Adapter Jam Nut | #185 102 |
| 5. Lock Nut | 11. Nozzle Adapter | #185 105 |
| 6. Insulator | 12. Nozzle (Standard) | #185 100 |

Features

Benefits

All gear-driven drive rolls	Both rolls are driving the wire for positive feeding performance, reducing burnbacks and improving arc starts.
Smooth groove drive-roll design	Prevents shaving the wire, which causes build-up in the drive-roll grooves, liner and contact tip. Improved feeding performance, helping to eliminate burnbacks and enhancing arc starts.
Patent-pending gas delivery	Reduce weld clean-up and repair by improving shielding gas coverage. This is accomplished through reduction of atmospheric contamination in the gas delivery system.
Gun head tube rotates 360 degrees	Reduces operator fatigue by providing a simple means to position the gun comfortably for various welding positions.
Quick-connect of gun to controller	Reduces time to set-up the welding equipment and reduces maintenance.
Replaceable feed cable liner	Reduces parts cost and service time by providing a simple means of removing and replacing the cable liner and not the complete feed cable.
Easy access to drive assembly	Reduces service time by providing a simple means of removing and replacing the drive rolls or performing routine maintenance without disassembly of the gun.
Replaceable head tube	Reduces service time by providing a simple means of replacing the head tube or performing routine maintenance without disassembly of the gun.
Adjustable gun barrel	Allows operator to easily vary contact tip-to-nozzle position.
Quick-change, collet-type contact tip	Easy to change contact tip when the need arises.

XR-Edge Gun Specifications (Subject to change without notice.)

Model	Welding Output Range	Electrode Wire Diameter Capacity	Wire Speed	Maximum Spool Size Capacity	Dimensions	Net Weight
XR-A Edge Gun	Air: 200 A at 100% duty cycle	.030-.047 in (0.8-1.2 mm) aluminum wire	70-875 IPM (1.8-22.2 m/min)	12 in (305 mm)	H: 5 in (127 mm) W: 2-1/2 in (64 mm) L: 17 in (432mm)	2.5 lb (1.1 kg)
XR-W Edge Gun	Water: 400 A at 100% duty cycle					





A=Air-Cooled W=Water-Cooled Certified by Canadian Standards Association to both Canadian and U.S. Standards. Conforms to European standards.

XR-Edge Gun Consumables (Order from Miller Service Parts.)




Wire Size	Contact Tips		Gun Head Tube Liner	Gun Drive Roll Kits	Gun Drive Roll Kits (Insulated)	Wire Drive Kits (One Required)		Feed Cable Liners	
	Standard Tip I.D.	Optional (Smaller) Tip I.D.				Standard	Optional (Insulated)	Length	Aluminum
.030 in (0.8 mm)	.041 in (1.0 mm) #135 428	.036 in (0.9 mm) #135 427	#193 793 Air	#194 114	#198 434	#193 520	#198 385	15 ft (4.6 m)	#191 064
.035 in (0.9 mm)	.052 in (1.3 mm) #135 430	.041 in (1.0 mm) #147 314	#197 729 Water	#194 115	#198 435	#193 521	#198 376	30 ft (9 m)	#191 065
.040 in (1.0 mm)	.052 in (1.3 mm) #135 430	—		#196 302	#198 436	#196 300	#198 375	50 ft (15.2 m)	#191 066
.047 in (1.2 mm)	.061 in (1.5 mm) #135 424	.052 in (1.3 mm) #135 429	#193 792 Air	#194 116	#198 437	#193 522	#198 374		
.062 in (1.6 mm)			#197 730 Water	#194 117	#198 438		#198 373		

The optional contact tips listed are for applications where a smaller I.D. tip is preferred. All contact tips are stamped with wire size and the tip I.D. For example: .035/52 designates .035 in wire and .052 in tip I.D. Drive roll kits consist of drive rolls, idler roll screw and conductive grease. Wire drive kits consist of gun drive rolls, two control drive rolls, two head tube liners (one air liner [7.18 in] and one water liner [7.8 in]), five contact tips, collet nut, and contact tip wrench.

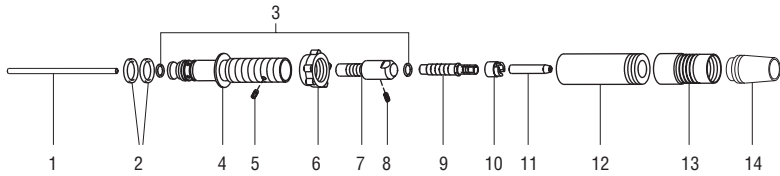
XR-Edge Gun Standard Nozzles (Order from Miller Service Parts.)

 <p>#185 100 5/8 in (16 mm) orifice (Standard with air-cooled gun)</p>	 <p>NEW! #197 728 5/8 in (16 mm) orifice (Standard with water-cooled gun)</p>	 <p>#193 790 1/2 in (13 mm) orifice</p>	 <p>#050 116 13/16 in (21 mm) orifice Note: Nozzle adapter kit #193 794 required.</p>
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XR-Edge Gun Spot Nozzles (Order from Miller Service Parts.)

 <p>#009 925 Outside corner Note: Nozzle adapter kit #193 794 required.</p>	 <p>#000 443 Inside corner Note: Nozzle adapter kit #193 794 required.</p>	 <p>#000 442 Flat 15/16 in (24 mm) orifice Note: Nozzle adapter kit #193 794 required.</p>	 <p>#004 466 Flat 1-3/8 in (35 mm) orifice Note: Nozzle adapter kit #193 794 required.</p>
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XR-Pistol Gun (Note: Air-cooled gun shown)



- | | | | |
|-----------------------------------|-------------------|-----------------------------------|-------------------|
| 1. Head Tube Liner | (See chart below) | 8. Set Screw (Air-cooled) | #604 612 |
| 2. O-Ring .614 ID | #134 800 | 9. Contact Tip Adapter | #136 680 |
| 3. O-Ring .176 ID | #164 485 | 10. Collet Nut | #136 748 |
| 4. Head Tube Adapter (Air-cooled) | #164 423 | 11. Contact Tip | (See chart below) |
| 5. Set Screw | #602 172 | 12. Barrel Extension (Air-cooled) | #156 821 |
| 6. Jam Nut (Air-cooled) | #058 685 | 13. Nozzle Extension (Air-cooled) | #144 862 |
| 7. Head Tube (Air-cooled) | #164 422 | 14. Nozzle (Standard) | #050 622 |

Features

Benefits

New! Quick-connect of gun to controller	Reduces time to set-up the welding equipment and reduces maintenance.
Replaceable head tube	Reduces service time by providing a simple means of replacing the head tube or performing routine maintenance without disassembly of the gun.
Adjustable gun barrel	Allows operator to easily vary contact tip-to-nozzle position.
Quick-change, collet-type contact tip	Easy to change contact tip when the need arises.
Replaceable feed cable liner	Reduces parts cost and service time by providing a simple means of removing and replacing the cable liner and not the complete feed cable.
Easy access to drive assembly	Reduces service time by providing a simple means of removing and replacing the drive rolls or performing routine maintenance without disassembly of the gun.

XR-Pistol Gun Specifications (Subject to change without notice.)

Model	Welding Output Range	Electrode Wire Diameter Capacity	Wire Speed	Maximum Spool Size Capacity	Dimensions	Net Weight
XR-A Gun	Air: 200 A at 100% duty cycle	.030–1/16 in (0.8–1.6 mm)	70–875 IPM (1.8–22.2 m/min)	12 in (305 mm)	H: 7-3/8 in (187 mm) W: 1-7/8 in (48 mm) L: 10-5/8 in (270 mm)	2.4 lb (1.1 kg)
XR-W Gun	Water: 400 A at 100% duty cycle	aluminum wire				2.9 lb (1.3 kg)

A=Air-Cooled W=Water-Cooled



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



Conforms to European standards.

XR-Pistol Gun Consumables (Order from Miller Service Parts.)

Contact Tips				Gun Head Tube Liner	Drive Rolls		Feed Cable Liners	
Wire Size	Standard Tip I.D.	Optional (Smaller) Tip I.D.	Dual Groove for One Wire Size		Wire Drive Kits (One Required)	Length	Aluminum	
.030 in (0.8 mm)	.041 in (1.0 mm) #135 428	.036 in (0.9 mm) #135 427	#136 682	#183 357	#198 384	15 ft (4.6 m)	#191 064	
.035 in (0.9 mm)	.052 in (1.3 mm) #135 430	.041 in (1.0 mm) #147 314	#136 682	#183 357	#198 384	30 ft (9 m)	#191 065	
.040 in (0.9 mm)	—	—	—	—	#198 383	50 ft (15.2 m)	#191 066	
.047 in (1.2 mm)	.061 in (1.5 mm) #135 424	.052 in (1.3 mm) #135 429	#136 683	#183 358	#198 382			
.062 in (1.6 mm)	.081 in (2.1 mm) #135 425	.073 in (1.9 mm) #135 426	#136 683	#183 358	#198 381			

Other size tips must be ordered separately. The optional contact tips listed are for those applications where a smaller I.D. tip is preferred. All contact tips are stamped with wire size and the tip I.D. For example: .035/52 designates .035 in wire and .052 in tip I.D. **Wire drive kits** consist of gun drive rolls, two control drive rolls, head tube liner, five contact tips, collet nut, and contact tip wrench.

XR-Pistol Gun Standard Nozzles (Order from Miller Service Parts.)



#050 622
5/8 in (16 mm) orifice
(Standard with gun)



#050 116
13/16 in
(21 mm) orifice



#050 115
1/2 in
(13 mm) orifice

XR-Pistol Gun Spot Nozzles (Order from Miller Service Parts.)



#009 925
Outside corner



#000 443
Inside corner



#000 442
Flat 15/16 in
(24 mm) orifice



#004 466
Flat 1-3/8 in
(35 mm) orifice

XR Gun Accessories

Cable Cover

#118 677 15 ft

#118 678 30 ft

Protects gun hose and cable assembly from wear and abrasion. Features a full length zipper.

50 ft Cable Cover

Not available for 50 ft gun.

Hardwire Liner Kits for Steel and Stainless

#198 380 For 15 ft air-cooled gun

#198 379 For 30 ft air-cooled gun

#198 378 For 15 ft water-cooled gun

#198 377 For 30 ft water-cooled gun

For XR-Pistol and XR-Edge gun. Kits consist of gun head tube liner and feed cable liner.

Recommend using .030-.045 in mild steel, flux cored, or stainless steel electrode wire.



SX Heat Shield #131 103

For XR-Pistol. Helps protect operator's hand from spatter and reflected heat.



1 lb (0.5 kg) Spool Canister #132 230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12 in (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. (Canister accommodates 4 in [102 mm] spools of wire.)

XR-Pistol Gun Barrels (Air-Cooled)



SX-A 50 Degree Curved Barrels

#147 175 6 in (152 mm)

#147 176 10 in (254 mm)

Used with .030-1/16 in (0.8-1.6 mm) wire. Kits supplied with two liners that accommodate all wire sizes.



SX 12 in Flex Head Kit #131 104

For .030-1/16 in (0.8-1.6 mm) wire. Used in place of the standard straight barrel. Flexible head tube bends 60 degrees in any direction for easier joint access and improved operator comfort. Supplied with two Teflon liners and one contact tip for each wire size listed.



3 in Head Tube Extension #137 787

Extends the standard gun barrel 3 in (72 mm) when a longer reach is required. The head tube extension is supplied with two liners to accommodate all wire sizes.

Replacement Teflon Liners for Air-Cooled Barrels (Order from Miller Service Parts.)

For 6 in Curved Barrel

#144 858 .030 and .035 in (0.8 and 0.9 mm) wire

#144 859 .047 and 1/16 in (1.2 and 1.6 mm) wire

For 10 in Curved Barrel

#144 854 .030 and .035 in (0.8 and 0.9 mm) wire

#144 855 .047 and 1/16 in (1.2 and 1.6 mm) wire

For Flex Head

#138 255 .030 and .035 in (0.8 and 0.9 mm) wire

#132 682 3/64 and 1/16 in (1.2 and 1.6 mm) wire

For Head Tube Extension

#138 223 .030 and .035 in (0.8 and 0.9 mm) wire

#138 224 3/64 and 1/16 in (1.2 and 1.6 mm) wire



SX-A 50 Degree Curved Nozzle Kit #147 174

Attaches to standard gun barrel assembly and is ideal for access to confined weld joint areas. Used with .030-1/16 in (0.8-1.6 mm) wire. Kit includes two of each size contact tips to accommodate all wire sizes. Uses standard straight barrel head tube liner.

Replacement Contact Tips for Curved Nozzle (Order from Miller Service Parts.)

#148 155 .030 and .035 in (0.8 and 0.9 mm) wire

#148 154 .047 in (1.2 mm) wire

#148 156 1/16 in (1.6 mm) wire

XR-Pistol Gun Barrels (Water-Cooled)



SX-W 50 Degree Curved Barrels

#130 843 6 in (152 mm)

#130 842 10 in (254 mm)

Used with .030-1/16 in (0.8-1.6 mm) wire. Kits supplied with two liners that accommodate all wire sizes.



SX-W 10 in Straight Barrel #130 841

Used with .030-1/16 in (0.8-1.6 mm) wire. Kits supplied with two liners that accommodate all wire sizes.

Replacement Teflon Liners for Water-Cooled Barrels (Order from Miller Service Parts.)

For 6 in Curved Barrel

#144 858 .030 and .035 in (0.8 and 0.9 mm) wire

#144 859 .047 and 1/16 in (1.2 and 1.6 mm) wire

For 10 in Curved Barrel

#144 854 .030 and .035 in (0.8 and 0.9 mm) wire

#144 855 .047 and 1/16 in (1.2 and 1.6 mm) wire

For 10 in Straight Barrel

#144 857 .030 and .035 in (0.8 and 0.9 mm) wire

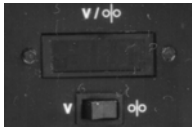
#144 856 .047 and 1/16 in (1.2 and 1.6 mm) wire

XR Control Options

*Factory option available only in XR Control packages — see Ordering Information on page 8.



Voltage Control* #194 027 Field
Allows voltage adjustment at the current XR Control when used with Miller electrically controlled, constant-voltage DC power sources that have a 14-pin receptacle.



Digital Display V/WFS* #193 274 Field
Allows wire feed speed to be preset and displayed. Will also monitor voltage while welding. If used with current manufactured Miller CV or CC/CV power sources (excluding CPs) and the optional voltage control or dual schedule control is used, the arc voltage can also be preset on the digital display. Includes back-lit LCD digital display that is easy to read in virtually any lighting condition. A selector switch allows the display to switch between wire feed speed and voltage.



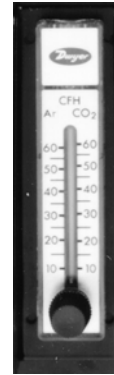
Dual Schedule Control* #193 276 Field
Allows two different welding conditions (voltage and wire feed speed) to be used on the same wire. This is ideal when different heat settings are required or when the need arises to change conditions while welding, i.e. different material thickness, out of position welding, etc. Is also ideal for use as a start control or crater fill control.

Note: The Digital Display option is required to use the Dual Schedule. Only for use with Miller CV or CC/CV power sources. Dual Schedule Switch required.

Dual Schedule Switch

DSS-30 #193 271 Field
For 15 ft (4.6 m) and 30 ft (9 m) guns
DSS-50 #193 272 Field
For 50 ft (15.2 m) gun

Required to operate the dual schedule control. A two position slide switch that can be positioned at the XR-Edge gun to remotely select schedule A or B conditions.



Gas Flowmeter*
#193 278 Field
#197 793 Field w/CE
Monitors and adjust gas flow at the XR Control.

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



Spot Weld/Burnback Control #193 279 Field
Provides up to 5 seconds of spot weld time and 0 (zero) to 0.25 seconds of burnback time.

Water Flow Shutdown Switch #194 039 Field
For use with water cooled guns only. Protects the water-cooled gun from overheating if water is not present or water stops flowing to the gun.

XR Control Accessories



Optima™ MIG (GMAW) Pulse Control #043 389

For Invision, Phoenix 456P and XMT 304 CC/CV. 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 #043 810

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

Typical Welding Systems for Aluminum MIG Welding



Conventional Aluminum MIG System
CP-252TS with XR™ Control
and 30 ft XR-A Edge Gun
#950 704



Aluminum MIG and Pulsed MIG System
Invision™ 354MP with XR™ Control
and 30 ft XR-A Edge Gun
#950 705

*Note: For high-current pulse welding,
water-cooled system recommended.*

Ordering Information and System Checklist

How to Assemble a System

1

Pick a Control
Standard or
with Options



2

Pick a Gun Style
Gooseneck or Pistol
15, 30 or 50 ft Cable
Air- or Water-Cooled



3

Pick a Wire Drive Kit
.030, .035, .040, .047 or .062 in
Wire drive kits consist of gun drive
rolls, two push feeder drive rolls,
head tube liner, five contact tips,
collet nut and a contact tip wrench.

Equipment	Stock No.	Description	Qty.	Price
Important: The XR Control and specific type and length gun must be ordered separately. Also order proper wire drive kit below for the size wire being used.				
XR™ Control	#181 538	Standard model		
	#181 538-01-1	Standard model w/CE		
	#181 538-03-3	W/digital display, voltage control & gas flow meter		
	#181 538-04-2	W/digital display, voltage control & gas flow meter w/CE		
	#181 538-03-2	W/digital display, dual schedule & gas flow meter		
XR-A Edge Gun (Air-Cooled)	#181 534	15 ft (4.6 m) cable		
	#181 534-01-1	15 ft (4.6 m) cable w/CE		
	#181 535	30 ft (9 m) cable		
	#181 535-01-1	30 ft (9 m) cable w/CE		
	#181 537	50 ft (15.2 m) cable		
XR-W Edge Gun (Water-Cooled)	#181 537-01-1	50 ft (15.2 m) cable w/CE		
	#181 531	15 ft (4.6 m) cable		
	#181 531-01-1	15 ft (4.6 m) cable w/CE		
	#181 532	30 ft (9 m) cable		
	#181 532-01-1	30 ft (9 m) cable w/CE		
XR-A Pistol Gun (Air-Cooled)	#181 533	50 ft (15.2 m) cable		
	#181 533-01-1	50 ft (15.2 m) cable w/CE		
	#198 127	15 ft (4.6 m) cable. New with quick-disconnect		
XR-W Pistol Gun (Water-Cooled)	#198 128	30 ft (9 m) cable. New with quick-disconnect		
	#198 129	15 ft (4.6 m) cable. New with quick-disconnect		
XR-Edge Gun Wire Drive Kits (One Required — See page 3 for Insulated Wire Drive Kits)	#198 130	30 ft (9 m) cable. New with quick-disconnect		
	#193 520	.030 in (0.8 mm)		
	#193 521	.035 in (0.9 mm)		
	#196 300	.040 in (1.0 mm)		
	#193 522	.047 in (1.2 mm)		
XR-Pistol Gun Wire Drive Kits (One Required)	#198 384	.030/.035 in (0.8/0.9 mm)		
	#198 383	.040 in (1.0 mm)		
	#198 382	.047 in (1.2 mm)		
	#198 381	.062 in (1.6 mm)		
Options				
CP-252TS with XR Control and XR-Edge Gun Package	#950 704	Complete conventional aluminum MIG package		
Invision 354MP with XR Control and XR-Edge Gun Package	#950 705	Complete aluminum MIG and pulsed MIG package		
Voltage Control	#194 027	Field		
Digital Display V/WFS	#193 274	Field		
Dual Schedule Control	#193 276	Field		
Dual Schedule Switch	#193 271	Field. For 15 ft (4.6 m) and 30 ft (9 m) guns		
Gas Flowmeter	#193 272	Field. For 50 ft (15.2 m) gun		
Spot Weld/Burnback Control	#193 278	Field		
Water Flow Shutdown Switch	#193 278-01-1	Field w/CE		
Water Flow Shutdown Switch	#193 279	Field		
Water Flow Shutdown Switch	#194 039	Field		
Accessories				
Optima MIG Pulse Control	#043 389			
PSA-2 Control	#141 604	For use with older 115 V power sources		
Extension Cords		See XR Control Accessories on page 6		
Water Coolant Systems		See Lit. Index No. AY/7.2		
Cable Cover	#118 677	15 ft (4.5 m)		
	#118 678	30 ft (9 m)		
SX Heat Shield	#131 103	For XR-Pistol gun only		
Spool Canister	#132 230			
XR-Pistol Gun Barrels		See page 5		
Date:			Total Quoted Price:	

Recommended Power Sources*

Regency® 250	Lit. Index No. DC/12.6
CP-252TS	Lit. Index No. DC/13
Deltaweld® Series	Lit. Index No. DC/16.2
Shopmaster™	Lit. Index No. AD/2.3
XMT® 304	Lit. Index No. DC/18.8
Invision™ 354 MP	Lit. Index No. DC/23
Trailblazer® 251	Lit. Index No. ED/4.5
Miller Air Pak™	Lit. Index No. ED/10.5
PipePro™	Lit. Index No. ED/10.6
Trailblazer® 300D NT	Lit. Index No. ED/4.6

*other power sources may be used

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.



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