The Dynasty 280 DX Multiprocess, paired with an ArcReach® SuitCase® feeder, provides a superior solution for all portable applications.

With multiprocess capabilities and features like Auto-Line™, AC TIG, pulse and high-frequency arc starts, the Dynasty 280 DX Multiprocess is the most versatile, portable machine in its class.

AC/DC CC/CV multiprocess equipment means always having the right equipment for the job. This also simplifies logistics and translates into less time locating and moving equipment and more time welding.

Reduced training time by utilizing one piece of equipment, saving labor costs and helping to keep projects on schedule.

Weld operators can quickly and easily adjust parameters, reducing the risk of operators trying to get by with less than ideal settings. Also, state-of-the-art TIG functions such as pulse, high-frequency starting, and AC (for aluminum) allow for optimization for virtually any material type.

Low power draw can mean additional welding equipment on the same circuit, getting work done faster by reducing the chances of power outages from tripped breakers or blown fuses.

Power source is warranted for three years, parts and labor.

Dynasty 280 DX Multiprocess (907514007) shown with ArcReach SuitCase 8 feeder (951726).
**Weld Process Features**

**AC TIG**

Balance control provides adjustable oxide removal which is essential for creating the highest quality aluminum welds. DX models provide extended ranges.

Frequency controls the width of the arc cone and can improve directional control of the arc.

**AC Waveforms**

- **Advanced squarewave**, fast freezing puddle, deep penetration and fast travel speeds.
- **Soft squarewave** for a soft buttery arc with maximum puddle control and good wetting action.
- **Sine wave** for customers that like a traditional arc. Quiet with good wetting.
- **Triangular wave** reduces the heat input and is good on thin aluminum. Fast travel speeds.

**MIG**

CV output of the power source gives this unit MIG process capabilities when paired with an ArcReach® SuitCase® feeder (or other voltage-sensing feeder). The feeder is powered off the arc voltage of the power source and can run both solid and flux-cored wires.

**AC/DC Stick**

DIG control allows the arc characteristics to be changed for specific applications and electrodes. Lower the DIG setting for smooth running electrodes like E7018 and increase the DIG setting for stiffer, more penetrating electrodes like E6010.

Hot Start™ adaptive control provides positive arc starts without sticking.

AC frequency control adds stability for smoother welds when AC stick welding.

Stick-Stuck detects if the electrode is stuck to the part and turns the welding output off to safely and easily remove the electrode. Menu selectable.

---

**Specifications** *(Subject to change without notice.)*

<table>
<thead>
<tr>
<th>Welding Mode</th>
<th>Input Power</th>
<th>Welding Amperage Range</th>
<th>Rated Output</th>
<th>Amps Input at Rated Load Output, 50/60 Hz</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>TIG (GTAW)</td>
<td>3-phase</td>
<td>2–280 A (AC)</td>
<td>235 A at 19.4 V, 60% duty cycle</td>
<td>19 17 10 9 7 7.0 6.7</td>
<td>60 VDC (11 VDC**)</td>
<td>H: 13.6 in. (346 mm) W: 8.6 in. (219 mm) D: 22.5 in. (569 mm)</td>
<td>55 lb. (25 kg)</td>
</tr>
<tr>
<td></td>
<td>1-phase</td>
<td>2–280 A (AC)</td>
<td>235 A at 19.4 V, 60% duty cycle</td>
<td>33 30 17 15 12 6.9 6.8</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stick (SMAW)</td>
<td>3-phase</td>
<td>5–280 A</td>
<td>200 A at 28 V, 60% duty cycle</td>
<td>22 20 11 10 8 8.2 7.9</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1-phase</td>
<td>5–280 A</td>
<td>180 A at 27.2 V, 60% duty cycle*</td>
<td>34 31 17 15 12 7.1 7.0</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* Refer to owner’s manual for 208 V output ratings and duty cycle. ** Low OCV sense voltage for stick and Lift-Arc™ TIG.

**IP23 rating** — This equipment is designed for outdoor use. It may be stored, but is not intended to be used outside during precipitation unless sheltered. Operating temperature range is 14 to 104°F (-10 to 40°C). Storage temperature range is -22 to 149°F (-30 to 65°C). Portions of the preceding text are contained in EN 60974-1: “Welding power sources for arc welding equipment.”

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

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**Performance Data**

<table>
<thead>
<tr>
<th></th>
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<th></th>
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<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>380–575 V</td>
<td>280 A, 40%</td>
<td>280 A, 35%</td>
<td>280 A, 35%</td>
<td>AC: 0.012–3/8 in. (0.3–9.5 mm)</td>
<td>3/16 in. (4.8 mm)</td>
<td>Voltage: 14–28 V</td>
<td>Wire speed: 50–780 ipm (1.3–19.8 m/min.)</td>
<td>12.5 kW</td>
</tr>
<tr>
<td></td>
<td>250 A, 60%</td>
<td>250 A, 60%</td>
<td>250 A, 60%</td>
<td>DC: 0.004–3/8 in. (0.1–9.5 mm)</td>
<td>200 A, 60%</td>
<td>Solid wire: .023–.052 in. (0.6–1.4 mm)</td>
<td>Flux-cored: .030–.052 in. (0.8–1.4 mm)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 A, 100%</td>
<td>200 A, 100%</td>
<td>200 A, 100%</td>
<td></td>
<td>145 A, 100%</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>208–240 V</td>
<td>280 A, 40%</td>
<td>280 A, 15%</td>
<td>280 A, 20%</td>
<td></td>
<td>180 A, 60%</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>250 A, 60%</td>
<td>200 A, 60%</td>
<td>200 A, 60%</td>
<td></td>
<td>145 A, 100%</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>200 A, 100%</td>
<td>160 A, 100%</td>
<td>160 A, 100%</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Material Type**

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>.024 in.</th>
<th>.030 in.</th>
<th>.035 in.</th>
<th>.045 in.</th>
<th>.052 in.</th>
<th>1/16 in.</th>
<th>5/64 in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solid wire (steel/SS)</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
</tr>
<tr>
<td>Aluminum</td>
<td>●</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dual (gas-) shielded flux-cored/metal core</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Self-shielded flux-cored</td>
<td>●</td>
<td></td>
<td>●</td>
<td>●</td>
<td>●</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

● Recommended — refer to wire manufacturer specifications for output requirements. ● Gun length may affect feedability.
**TIG Upgrade Chart**

<table>
<thead>
<tr>
<th>Why Upgrade?</th>
<th>Dynasty 280 UPGRADE</th>
<th>Dynasty 280 DX Multiprocess</th>
<th>Benefits</th>
</tr>
</thead>
<tbody>
<tr>
<td>Versatility</td>
<td>AC/DC TIG AC/DC Stick</td>
<td>AC/DC TIG AC/DC Stick MIG Flux-cored</td>
<td>Tackle virtually any welding job with one power source! Pair with a feeder to weld common materials such as steel, stainless and aluminum, or specialty metals such as Inconel®.</td>
</tr>
<tr>
<td>AC Frequency Control (Aluminum TIG)</td>
<td>Variable 70–150 Hz</td>
<td>Variable 20–400 Hz</td>
<td>Higher AC frequencies provide better arc control and faster travel speeds.</td>
</tr>
<tr>
<td>AC Balance Control (Aluminum TIG)</td>
<td>60–80% electrode negative</td>
<td>50–99% electrode negative</td>
<td>Greater electrode negative helps to produce welds with less etching for more aesthetic welds.</td>
</tr>
<tr>
<td>AC Waveforms (Aluminum TIG)</td>
<td>Soft squarewave Advanced squarewave Sine wave Triangular wave</td>
<td>Soft squarewave = maximum puddle control Advanced squarewave = faster travel Sine wave = traditional characteristics Triangular wave = reduced heat input</td>
<td></td>
</tr>
<tr>
<td>Arc Starting</td>
<td>High frequency (HF) Lift-Arc™</td>
<td>High frequency (HF) Lift-Arc™</td>
<td>High-frequency (HF) arc starter for non-contact arc initiation and refined Lift-Arc help prevent tungsten contamination.</td>
</tr>
<tr>
<td>Pulses per second (PPS)</td>
<td>Variable 0.1–250 pps</td>
<td>Variable 0.1–500 pps</td>
<td>Pulsing reduces heat input for sensitive materials. Higher pulse rates improve directional control.</td>
</tr>
<tr>
<td>Pulse Peak Time</td>
<td>Fixed 40%</td>
<td>Variable 5–95%</td>
<td>Allows for tailoring of pulse characteristics and reduce heat.</td>
</tr>
<tr>
<td>Pulse Background Amperage</td>
<td>Fixed 25%</td>
<td>Variable 5–95%</td>
<td>Allows for tailoring of pulse characteristics and reduce heat.</td>
</tr>
<tr>
<td>Portability</td>
<td>55 lb. 13.6 x 8.6 x 22.5 in.</td>
<td>55 lb. 13.6 x 8.6 x 22.5 in.</td>
<td>One person can easily move and compact design makes it ideal for narrow passages.</td>
</tr>
<tr>
<td>Power Flexibility</td>
<td>Auto-Line™, 208–575 V 1-phase or 3-phase</td>
<td>Auto-Line™, 208–575 V 1-phase or 3-phase</td>
<td>Auto-Line eliminates the need for manual linking and the power-efficient design allows more welding power sources on one circuit.</td>
</tr>
</tbody>
</table>

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**ArcReach® SuitCase® 8 and 12** (Note: Dynasty 280 DX is not capable of ArcReach control.)

Portable wire feeding at its best

Voltage-sensing, portable feeders designed to run off of arc voltage from almost any welding power source, provide extreme reliability for construction and fabrication.

- Scaled wire pressure knob provides easy adjustment and consistent pressure on the drive rolls and wire
- Wire drive and motor assembly is specifically designed for mobile welding applications to provide smooth and consistent wire delivery
- Gun locking tab works with guns having corresponding locking grooves to prevent gun from being pulled out if the feeder is dragged by the gun
- Ultra-low drag inlet guide pins make loading the wire easy and do not deform the wire on the way into the drive rolls

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Input Welding Circuit Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter Capacity</th>
<th>Max. Spool Size Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>8</td>
<td>Operates on open-circuit voltage and arc voltage: 14–48 VDC/110 max. OCV</td>
<td>330 A at 60% duty cycle</td>
<td>50–780 ipm (1.3–19.8 m/min.) dependent on arc voltage</td>
<td>Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–.064 in. (0.8–2.0 mm)</td>
<td>8 in. (203 mm) 14 lb. (6.4 kg)</td>
<td>H: 12.75 in. (324 mm) W: 7.25 in. (184 mm) D: 18 in. (457 mm)</td>
<td>28 lb. (13 kg)</td>
</tr>
<tr>
<td>12</td>
<td>425 A at 60% duty cycle</td>
<td>425 A at 60% duty cycle</td>
<td>425 A at 60% duty cycle</td>
<td>Solid wire: .023–.052 in. (0.6–1.4 mm) Flux-cored: .030–.064 in. (0.8–2.0 mm)</td>
<td>12 in. (305 mm) 45 lb. (20 kg)</td>
<td>H: 15.5 in. (394 mm) W: 9 in. (229 mm) D: 21 in. (533 mm)</td>
<td>35 lb. (15.9 kg)</td>
</tr>
</tbody>
</table>

---

**Coolmate® 1.3 Cooler**

- Dynasty® models with CPS turn Coolmate 1.3 on and off
- Power indicator light and fluid level sight window
- Rustproof polyethylene-molded coolant tank and filler spout
- 1/4 hp motor is thermally protected to guard against overheating
- Efficient fin and tube heat exchanger
- Factory-set pressure relief valve (55 psi) maintains consistent pressure during operation
- Filter and coolant filling spout are conveniently located
- Brass-body, positive displacement rotary vane pump provides consistent coolant flow and pressure rating with long pump-life expectancy

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Maximum Current Draw</th>
<th>Maximum Cooling Capacity</th>
<th>Rated Cooling Capacity</th>
<th>Tank Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>115 V, 60 Hz</td>
<td>4.7 A (60 Hz)</td>
<td>3,400 W (11,600 Btu/hr.) 3.8 qt./min. (3.6 L/min.)</td>
<td>1,330 W (4,540 Btu/hr.) 1.1 qt.min. (1 L/min.)</td>
<td>1.3 gal. (4.9 L)</td>
<td>H: 11.25 in. (286 mm) W: 10.375 in. (264 mm) D: 24 in. (610 mm)</td>
<td>43 lb. (20 kg)</td>
</tr>
</tbody>
</table>
Dynasty® 280 DX Control Panel

1. Standby Switch
2. Voltmeter Display
3. Ammeter Display
4. Polarity
   AC/DC
5. Process/
   Arc Starting
   MIG: Voltage-sensing feeder
   TIG: HF impulse, Lift-Arc
   Stick: Adaptive Hot Start
6. Output Control
   Standard remote,
   2T trigger hold,
   Output on
7. Pulser Control
   Pulses per Second* DC: 0.1–500 pps
   AC: 0.1–500 pps
   Peak Time* 5–95%
   Background Amps* 5–95%
8. Memory Card Port
9. Activity Indicator
10. Encoder Control

User Menu (Press Gas and Amperage buttons.)
1. Tungsten Size = .020–1/8 in. / GEN or .05–3.2 mm
2. Remote Trigger = 3T / 4T / 4TL / 4TLE
3. Wave Form = SOFT / ADVS / SINE / TRI
4. Stick Hot Start = ON / OFF

11. Amperage Button
12. AC Waveshape
   Balance* 50–99% EN
   Frequency* 20–400 Hz
13. Gas/DIG
   Preflow 0.0–25.0 seconds
   Postflow Auto / Off–50 seconds
   DIG* Off–100%
   Arc Control (Inductance)** 0–99% (solid wire - EP)
   Flux Core (flux-cored wire - EN)
14. Sequencer Control
   Initial Amps AC: 2–280 A
   DC: 1–280 A
   Initial Time 0.0–25.0 seconds
   Initial Slope 0.0–50.0 seconds
   Weld Time 0.0–999 seconds
   Final Slope 0.0–50.0 seconds
   Final Amps AC: 2–280 A
   DC: 1–280 A
   Final Time 0.0–25.0 seconds

*Pro-Set parameter selectable.
**Inductance control uses the DIG selection on the interface and illuminates that LED when you are in the V-Sense Feeder process.

Tech Menu (Hold Gas and Amperage buttons five seconds.)
1. Arc Time 0.0–9,999 hours
   0.0–59 minutes
   0–999,999 cycles
   Resettable
2. Error Log = Error event recorder
3. Sleep Timer = 1 / 5 / 10 / 15 / 30 / 45MIN / 1HR
4. Stick Stuc = OFF / ON
5. OCV = LOW / NORM
6. Weld Timers = OFF / ON
7. Cooler Power = AUTO / ON / OFF (Dynasty models with CPS only)
8. Locks = OFF / 1–4
9. Meter Display
10. External Pulse Control = OFF / ON
11. Machine Reset
12. Software Number
13. Serial Number
14. Insight (Dynasty models with Insight only)
Build a Dynasty 280 DX Multiprocess System

Air-Cooled System

Step 1 • Order Dynasty

- Dynasty 280 DX Multiprocess (with CPS) 907514007

Dynasty comes with adjustable shoulder strap, 8 ft. power cord (no plug), quick reference guide, two 50 mm Dinse-style connectors, and two Dinse/Tweco® adapters.

Step 2 • Order TIG Accessory (pick one)

- Foot Control Contractor Kit 301309
- Fingertip Control Contractor Kit 301311

See page 6 for kit contents.

Step 3 • Order MIG Wire Feeder and Gun (pick one)

- ArcReach® SuitCase® 8 with Bernard™ BTB Gun 300 A 951726
- ArcReach® SuitCase® 8 with Bernard™ Dura-Flux™ Gun 951728
- ArcReach® SuitCase® 12 with Bernard™ BTB Gun 300 A 951729
- ArcReach® SuitCase® 12 with Bernard™ Dura-Flux™ Gun 951731

See page 3 for feeder features.

Step 4 • Suggested Upgrades

- Dinse-style Connector Kit for up to #1/0 cable 042419
  (includes 1 male plug and 1 female receptacle)*
- Dinse-style Connectors for #1/0 to #2/0 cable (order one of each)*
  Single Male Dinse-style Plug 134460
  Single Female Dinse-style Receptacle 136600
- Gas Hose Quick Release** QRG
- Dual-groove Drive Roll** 269480
  (.035 in. V-groove/.045 in. V-knurled)
- Wireless Foot Control 300429

*10 feet of #4 to #1/0 cable recommended to connect feeder (NOT available through Miller).
**Two required per machine.

Water-Cooled System

Step 1 • Order ALL Listed

- Dynasty 280 DX Multiprocess (with CPS) 907514007
- Coolmate 1.3 300972
- Small Runner Cart 301318
- Low- Conductivity Coolant 043810
  (must be ordered in quantities of 4)

Dynasty comes with adjustable shoulder strap, 8 ft. power cord (no plug), quick reference guide, two 50 mm Dinse-style connectors, and two Dinse/Tweco® adapters.

Step 2 • Order TIG Remote Control (pick one)

- Wireless Foot (recommended) 300429
- RFCS-14 HD Foot 194744
- RCC-14 E/W Fingertip 151086
- RCCS-14 N/S Fingertip 043688
- RMS-14 Pushbutton 187208
- RMLS-14 Momentary/Maintained 129337
- RHC-14 Hand 242211020
- Wireless Hand 300430

See page 7 for remote descriptions.

Step 3 • Order TIG Torch Kit (pick one)

- W-250 Kit 300185
- W-280 Kit (recommended) 300990
- W-375 Kit 301268

See page 6 for kit contents.

Step 4 • Order MIG Wire Feeder and Gun (pick one)

- Dinse-style Connector Kit for up to #1/0 cable 042419
  (includes 1 male plug and 1 female receptacle)*
- Dinse-style Connectors for #1/0 to #2/0 cable (order one of each)*
  Single Male Dinse-style Plug 134460
  Single Female Dinse-style Receptacle 136600
- Gas Hose Quick Release** QRG
- Water Hose Quick Release** QRW
- Dual-groove Drive Roll** 269480
  (.035 in. V-groove/.045 in. V-knurled)

*10 feet of #4 to #1/0 cable recommended to connect feeder (NOT available through Miller).
**Two required per machine.

Step 5 • Suggested Upgrades

- Dinse-style Connector Kit for up to #1/0 cable 042419
  (includes 1 male plug and 1 female receptacle)*
- Dinse-style Connectors for #1/0 to #2/0 cable (order one of each)*
  Single Male Dinse-style Plug 134460
  Single Female Dinse-style Receptacle 136600
- Gas Hose Quick Release** QRG
- Water Hose Quick Release** QRW
- Dual-groove Drive Roll** 269480
  (.035 in. V-groove/.045 in. V-knurled)

*10 feet of #4 to #1/0 cable recommended to connect feeder (NOT available through Miller).
**Two required per machine.
Genuine Miller® Accessories

Protective Cover 301382
Fits Dynasty 210/280 and Maxstar 280.

Small Runner™ Cart 301318
Designed for Dynasty/Maxstar 210 and 280 with or without Coolmate 1.3 cooler. Cart features single-cylinder rack, foot pedal holder, two cable/torch holders, and two TIG filler rod holders.

Coolmate® 1.3 300972 120 V 1.3-gallon cooler designed to cool torches up to 280 amps.

Low- Conductivity Coolant 043810 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.

Performance TIG Gloves 263345 X-Small 263346 Small 263347 Medium 263348 Large 263349 X-Large Completely unlined, goat grain leather with triple-padded palm.

Memory Cards

Memory Card Expansion

301151 14-Pin Automation Expansion Provides the ability to access common automation functions through the 14-pin connection.

301152 14-Pin Modbus® Expansion Provides the ability to access basic and advanced functions through the 14-pin connection.

301235 Independent AC Expansion Allows EP and EN amperages and waveforms to be set independently to precisely control heat input to the work and electrode.

Memory Card (Blank) 301080 A blank, commercially available memory card used for transferring software updates and expandable features from your computer to the machine.

TIG Torches, Kits and Connectors

Contractor Kits

301309 150 A RFCS-14 HD Foot Pedal Kit
301311 150 A RCCS-14 Fingertip Kit

All-in-one TIG/stick welding kit comes with either a RFCS-14 HD foot control OR RCCS-14 fingertip control, Weldcraft® A-150 TIG torch, 200-amp stick electrode holder and 300-amp work clamp with 15-foot (4.6 m) cables, flow gauge regulator with 12-foot (3.7 m) gas hose, gas hose coupler, AK2C torch accessory kit and TIG torch connector.

Note: A-200 (WP-26) torches require 195379 connector.

Weldcraft® A-200 (WP-26) TIG Torch
WP-26-12-R (12 ft.)
WP-26-25-R (25 ft.)
200-amp air-cooled torch. Torch body gas valve models also available.

Weldcraft® Gas Hose Quick Connect QRG Allows for quick connection and removal of torch shielding gas hoses.

Weldcraft® Water Hose Quick Connect QRW Allows for quick connection and removal of torch coolant hoses.

Air-Cooled TIG Torch Connectors 195379 A-200 (WP-26) 195378* All others 50 mm Dinse-style for one-piece air-cooled torch.

* A-80 (WP-24) torches require 24-5 connector.

Water-Cooled Torch Kits

300185 W-250 300990 W-280 (recommended) 301268 W-375 Kit comes with Weldcraft® 25-foot (7.6 m) TIG torch with Dinse-style connector, torch cable cover, work clamp with 15-foot (4.6 m) cable, flowmeter regulator with gas hose and torch accessory kit (1/16-, 3/32- and 1/8-inch 2% ceriated tungsten, nozzles, collets and collet bodies).

Water-Cooled TIG Torch Connector 195377 50 mm Dinse-style with water return line. For use with all Weldcraft® water-cooled torches.

Dinse/Tweco® Adapter 042465 A one-piece adapter which has a Dinse-style male plug (to power source) on one end and a female Tweco receptacle (for weld cable connection) on other end.

Weldcraft® Gas Hose Quick Connect QRG A one-piece adapter which has a Weldcraft® female receptacle (for weld cable connection) on one end.
Wire Feeders

ArcReach® SuitCase® 8
951726 With Bernard® BTB Gun 300 A
951728 With Bernard® Dura-Flux™ gun

ArcReach® SuitCase® 12
951729 With Bernard® BTB Gun 300 A
951731 With Bernard® Dura-Flux™ gun

Portable feeder designed to run off of arc voltage. Holds up to an 8-inch (SuitCase 8) or 12-inch (SuitCase 12) spool of wire. See literature M/6.55.

Note: Dynasty 280 DX is not capable of ArcReach control.

Wire Feeders

RFCS-14 HD Foot Control 194744
Maximum flexibility is accomplished with a reconfigurable cord that can exit the front, back or either side of the pedal. Foot pedal provides remote current and contactor control. Includes 20-foot (6 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCCS-14 Remote Contactor and Current Control 043658
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

Remote Controls and Switches

Wireless Remote Foot Control 300429
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RMS-14 On/Off Control 187208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

Educational Materials

To order, please call Miller Literature at 866-931-9732 or visit MillerWelds.com/resources/tools.

Gas Tungsten Arc Welding (TIG) Publication 250833
Setup DVD 251116
Video topics include tungsten selection, setup menus, DC pulse, sequencer, balance and frequency settings.

Consumables (Order from Miller Service Parts.)

<table>
<thead>
<tr>
<th>Wire Size</th>
<th>Drive Rolls (Two required)</th>
<th>Centerfire™ Contact Tips</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>“V” groove for hard wire</td>
<td>“T” Series (.35 in. O.D.)</td>
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<tr>
<td>.023/.025 in. (.6 mm)</td>
<td>087130</td>
<td>T-023</td>
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<tr>
<td>.030 in. (.8 mm)</td>
<td>053695</td>
<td>T-030</td>
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<tr>
<td>.035 in. (.9 mm)</td>
<td>053700</td>
<td>T-035</td>
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<tr>
<td>.040 in. (1.0 mm)</td>
<td>053696</td>
<td>T-039</td>
</tr>
<tr>
<td>.045 in. (1.1/2 mm)</td>
<td>053697 053701</td>
<td>T-045</td>
</tr>
<tr>
<td>.052 in. (1.3/4 mm)</td>
<td>053698 053702</td>
<td>T-052</td>
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<tr>
<td>1/16 in. (1.6 mm)</td>
<td>053699 053706</td>
<td>T-062</td>
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<tr>
<td>.068/.072 in. (1.8 mm)</td>
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<td>T-072</td>
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<tr>
<td>5/64 in. (2.0 mm)</td>
<td>—</td>
<td>T-078</td>
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<td>053704</td>
<td>T-068</td>
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<td>132960</td>
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<td>053710</td>
<td>T-086</td>
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<td></td>
<td>132956</td>
<td>T-079</td>
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Select drive rolls from chart according to type and wire size being used. Wire inlet guide comes installed on ArcReach SuitCase wire feeders.
<table>
<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tbody>
<tr>
<td><strong>Dynasty® 280 DX (CPS) Multiprocess</strong></td>
<td>907514007</td>
<td>Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA.</strong> 8 ft. power cord</td>
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<td><strong>Accessories</strong></td>
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<tr>
<td>Protective Cover</td>
<td>301382</td>
<td>For Dynasty 210/280 and Maxstar 280</td>
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<tr>
<td>Small Runner™ Cart</td>
<td>301318</td>
<td>For Dynasty/Maxstar 210 and 280 with or without Coolmate 1.3</td>
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<tr>
<td>Coolmate™ 1.3</td>
<td>300972</td>
<td>120 V, 60 Hz, <strong>CSA.</strong> Requires coolant</td>
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<tr>
<td>TIG Coolant (must be ordered in quantities of four)</td>
<td>043810</td>
<td>1-gallon plastic bottle. Protects against freezing to -37° Fahrenheit (-38° C) or boiling to 227° Fahrenheit (108° C)</td>
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<tr>
<td><strong>TIG Torches, Kits and Connectors</strong></td>
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<tr>
<td>Air-Cooled Contractor Kits (see page 6 for contents)</td>
<td>301309</td>
<td>Foot pedal</td>
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<td></td>
<td>301311</td>
<td>Fingertip</td>
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<tr>
<td>Weldcraft™ A-150 (WP-17) TIG Torch</td>
<td>WP-17-12-R</td>
<td>12 ft. (3.7 m) cable. Requires <strong>195378</strong> connector</td>
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<tr>
<td></td>
<td>WP-17-25-R</td>
<td>25 ft. (7.6 m) cable. Requires <strong>195378</strong> connector</td>
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<tr>
<td>Weldcraft™ A-200 (WP-26) TIG Torch</td>
<td>WP-26-12-R</td>
<td>12 ft. (3.7 m) cable. Requires <strong>195379</strong> connector</td>
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<td></td>
<td>WP-26-25-R</td>
<td>25 ft. (7.6 m) cable. Requires <strong>195379</strong> connector</td>
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<td>Air-Cooled TIG Torch Connectors</td>
<td>195379</td>
<td>Connects Weldcraft™ A-200 (WP-26) to Dinse-style connector</td>
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<td></td>
<td>195378</td>
<td>Connects all air-cooled Weldcraft™ torches (except A-200) to Dinse-style connector. A-80 (WP-24) torches require <strong>24-5</strong> connector</td>
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<tr>
<td>Water-Cooled Torch Kits (see page 6 for contents)</td>
<td>300185</td>
<td>W-250</td>
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<td></td>
<td>300990</td>
<td>W-280 (recommended for Dynasty 280)</td>
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<td>301268</td>
<td>W-375</td>
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<td>Water-Cooled TIG Torch Connector</td>
<td>195377</td>
<td>Connects Weldcraft™ water-cooled torches to Dinse-style connector</td>
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<tr>
<td>Dinse/Tweco® Adapter</td>
<td>042465</td>
<td>One-piece adapter with Dinse-style male plug and Tweco-style female receptacle</td>
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<td>Weldcraft™ Quick Connects</td>
<td>QRG</td>
<td>For gas hoses</td>
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<td>QRW</td>
<td>For water hoses</td>
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<td><strong>Wire Feeders</strong></td>
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<tr>
<td>ArcReach® SuitCase® 8 (see literature M/6.55)</td>
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<td>With Bernard™ BTB Gun 300 A</td>
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<td>951728</td>
<td>With Bernard™ Dura-Flux™ gun</td>
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<td>ArcReach® SuitCase® 12 (see literature M/6.55)</td>
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<td>951731</td>
<td>With Bernard™ Dura-Flux™ gun</td>
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<td><strong>Remote Controls</strong></td>
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<tr>
<td>Wireless Remote Foot Control</td>
<td>300429</td>
<td>Foot control with wireless 90 ft. (27.4 m) operating range</td>
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<td>RFCS-14 HD</td>
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<td>Heavy-duty foot control</td>
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<td>RCC-14</td>
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<td>Side-to-side (east/west) fingertip control</td>
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<td>RCCS-14</td>
<td>043688</td>
<td>North/south fingertip control</td>
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<td>RMS-14</td>
<td>187208</td>
<td>Momentary rubber dome switch</td>
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<td>RMLS-14</td>
<td>129337</td>
<td>Momentary/maintained rocker switch</td>
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<td>RHC-14</td>
<td>242211020</td>
<td>Hand control</td>
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<td>Wireless Remote Hand Control</td>
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<td>Hand control with wireless 300 ft. (91.4 m) operating range</td>
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<td><strong>Educational Materials</strong></td>
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**Ordering Information**

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