Maxstar® 400 and 800

**Processes**
- TIG (GTAW)
- Pulsed TIG (GTAW-P)
- Stick (SMAW)
- Air carbon arc (CAC-A)

**Input Power**
- 208–575 V, 3- or 1-phase power

**Amperage Range**
- **400**: 3–400 A
- **800**: 5–800 A

**Rated Output**
- **400**: 300 A at 32 V, 60% duty cycle
- **800**: 600 A at 44 V, 60% duty cycle

**Net Weight**
- **400**: 134 lb. (61 kg)
- **800**: 198 lb. (90 kg)

**Industrial Applications**
- Precision metal fabrication
- Tube mills
- Pipe and tube fabrication
- Tool and die
- Exotic material fabrication
- Pressure vessel fabrication

**Quick Specs**

**Power source**
- Allows for any input voltage hookup (208–575 V) with no manual linking, providing convenience in any job setting. Ideal solution for dirty or unreliable power.

**Meter calibration**
- Allows digital meters to be calibrated for certification.

**Cooler Power Supply (CPS)**
- Is an integrated 120-volt dedicated-use receptacle for the Coolmate™ 3.5.

**Cooler-On-Demand™**
- Feature operates the auxiliary cooling system only when needed, reducing noise, energy use, and airborne contaminants pulled through the cooler.

**Wind Tunnel Technology™**
- Protects internal electrical components from airborne contaminants, extending the product life.

**Fan-On-Demand™**
- Power source cooling system operates only when needed, reducing noise, energy use and the amount of contaminants pulled through the machine.

**Lift-Arc™**
- Provides DC arc initiation without the use of high frequency.

**Blue Lightning™**
- High-frequency (HF) arc starter for non-contact arc initiation. Provides more consistent arc starts and greater reliability compared to traditional HF arc starters.

**DC TIG Features**
- Exceptionally smooth and precise arc for welding exotic materials.
- Pulse. Pulsing can increase puddle agitation, arc stability and travel speeds while reducing heat input and distortion. These models provide extended ranges.

**DC Stick Features**
- 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.

**Program memory**
- Features nine independent program memories that maintain/save your parameters.

**Auto-postflow**
- Adjusts the length of postflow time based on the amperage setting, shielding your tungsten and eliminating the need to set the postflow time.

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

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**Miller Electric Mfg. Co.**
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA

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

**MillerWelds.com**

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**ISO 9001**
Registered Quality System
## Specifications

(Subject to change without notice.)

### Performance Data

<table>
<thead>
<tr>
<th>Model</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>
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<tbody>
<tr>
<td></td>
<td></td>
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<td></td>
<td>208 V</td>
<td>230 V</td>
<td>400 V</td>
<td>460 V</td>
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<tr>
<td>Maxstar 400</td>
<td>3-phase</td>
<td>3–400 A</td>
<td>250 A at 30 V, 100% duty cycle</td>
<td>27</td>
<td>24</td>
<td>14</td>
<td>12</td>
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<td></td>
<td></td>
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<td>300 A at 32 V, 60% duty cycle</td>
<td>33</td>
<td>30</td>
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<tr>
<td></td>
<td>1-phase</td>
<td>3–400 A</td>
<td>200 A at 28 V, 100% duty cycle</td>
<td>36</td>
<td>33</td>
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<td>250 A at 30 V, 60% duty cycle</td>
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<tr>
<td>Maxstar 800</td>
<td>3-phase</td>
<td>5–800 A</td>
<td>500 A at 40 V, 100% duty cycle</td>
<td>68</td>
<td>61</td>
<td>34</td>
<td>30</td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>600 A at 44 V, 60% duty cycle</td>
<td>90</td>
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<td></td>
<td>1-phase</td>
<td>5–800 A</td>
<td>400 A at 36 V, 100% duty cycle</td>
<td>89</td>
<td>80</td>
<td>44</td>
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<tr>
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<td>500 A at 40 V, 60% duty cycle</td>
<td>126</td>
<td>112</td>
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*Indicates sense-voltage for Lift-Arc™ TIG and Low OCV stick.

### Carbon Arc Gouging

<table>
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<tr>
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<tbody>
<tr>
<td>Maxstar 400</td>
<td>3-phase</td>
<td>400 A, 20% 300 A, 60% 250 A, 100%</td>
<td>400 A, 20% 300 A, 60% 250 A, 100%</td>
<td>.012–.5/8 in. (0.3–15.9 mm)</td>
<td>6010: 1/4 in. (6.4 mm) 7018: 1/4 in. (6.4 mm) 7024: 1/4 in. (6.4 mm)</td>
<td>1/4 in. (6.4 mm)</td>
<td>20 kVA</td>
</tr>
<tr>
<td></td>
<td>1-phase</td>
<td>300 A, 20% 250 A, 60% 200 A, 100%</td>
<td>300 A, 20% 250 A, 60% 200 A, 100%</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maxstar 800</td>
<td>3-phase</td>
<td>800 A, 20% 600 A, 60% 500 A, 100%</td>
<td>800 A, 20% 600 A, 60% 500 A, 100%</td>
<td>.020–1 in. (0.5–25.4 mm)</td>
<td>6010: 1/4 in. (6.4 mm) 7018: 1/4 in. (6.4 mm) 7024: 1/4 in. (6.4 mm)</td>
<td>3/8 in. (9.5 mm)</td>
<td>45 kVA</td>
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<tr>
<td></td>
<td>1-phase</td>
<td>500 A, 60% 400 A, 100%</td>
<td>500 A, 60% 400 A, 100%</td>
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</tbody>
</table>

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Certified by Canadian Standards Association to both the Canadian and U.S. Standards. "CC" All CE models conform to the applicable parts of the IEC 60974 series of standards.
Control Panel Parameter Values

1. Memory Switch
   18 Combinations
   (9 DC TIG)
   (9 DC stick)

2. Memory Display

3. Voltmeter Display

4. Ammeter Display

5. Process/Arc Starting
   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: 0.1–5,000 PPS
   Peak Time*
   5–95%
   Background Amps*
   5–95%

   *Pro-Set parameter selectable.

User Menu (Press Gas and Amperage buttons.)

1. Tungsten Size
   400 = .020–3/16 in./GEN or 0.5–4.8 mm
   800 = .040–1/4 in./GEN or 1.0–6.4 mm

2. Remote Trigger
   2T/3T/4T/4TL/4TE/4Tm

3. Stick Hot Start = ON/OFF

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
   Retestable

2. Error Log
   Error event recorder

3. Stick Stuc
   OFF/ON

4. OCV
   LOW/NORM

5. Weld Timers
   OFF/ON

6. Cooler Power
   AUTO/ON/OFF

7. Locks
   OFF/1–4

8. Meter Display

9. External Pulse Control
   OFF/ON

10. Machine Reset

11. Software Number

12. Serial Number

13. Slave (with Modbus* automation expansion)

   Address = 1–247
   Baudrate = 9600/19.2K
   Parity = EVEN/ODD/NONE
Pulsed TIG Controls

High-Speed DC Pulsed TIG Controls

- **PPS Pulses per second (Hz):** DC = 0.1 – 5,000 PPS
- **% ON – % Peak Time:** 5 – 95% (Controls the amount of time during each pulse cycle at the PEAK amperage.)
- **Background Amps:** 5 – 99% (Sets the low-pulse amperage value as a % of the Peak Amps.)

### Conventional Pulsed TIG

Typically from 1 to 10 PPS. Provides a heating and cooling effect on the weld puddle and can reduce distortion by lowering the average amperage. This heating and cooling effect also produces a distinct ripple pattern in the weld bead. The relationship between pulse frequency and travel speed determines the distance between the ripples. Slow pulsing can also be coordinated with filler metal addition and can increase overall control of the weld puddle.

### High-Speed Pulsed TIG

In excess of 40 PPS, Pulsed TIG becomes more audible than visible — causing increased puddle agitation for a better as-welded microstructure. Pulsing the weld current at high speeds — between a high Peak and a low Background amperage — can also constrict and focus the arc. This results in maximum arc stability, increased penetration and increased travel speeds (Common Range: 100 – 500 PPS).

The Arc-Sharpening effects of high speed pulsing are expanded to new dimensions. The ability to pulse at 5,000 PPS further enhances arc stability and concentration potential — which is extremely beneficial to automation where maximum travel speeds are required.
Maxstar® 400 and 800 Models/Packages

Machines and Preconfigured Water-Cooled Packages
Order machine only or use a single stock number to order a complete preconfigured system.

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Maxstar 400 (CSA)</td>
<td>907716</td>
<td>Maxstar 400 (CSA) 907716001</td>
</tr>
<tr>
<td>Maxstar 400 (CE)</td>
<td>907716002</td>
<td>Maxstar 400 (CSA) w/Foot Control 951692</td>
</tr>
<tr>
<td>Maxstar 800 (CSA)</td>
<td>907718</td>
<td>Maxstar 400 (CSA) w/Wireless Foot Control 951693</td>
</tr>
<tr>
<td>Maxstar 800 (CE)</td>
<td>907718002</td>
<td></td>
</tr>
</tbody>
</table>

Comes with:
- 8 ft. power cord (no plug) (400 model)
- Two 50 mm Dinse-style connectors (400 model)
- Two thread-lock connectors (800 model)
- One thread-lock water-cooled connector (800 model)

Comes with:
- 8 ft. power cord (no plug) (400 model)
- Runner™ cart 300244
- Coolmate™ 3.5 300245

Comes with:
- 8 ft. power cord (no plug) (400 model)
- Runner™ cart 300244
- Coolmate™ 3.5 300245
- 4 gallons of coolant 043810
- W-375 torch kit 301268
- Remote control 194744 (foot) or Remote control 300429 (wireless foot)

Build a Water-Cooled Package
Select desired stock number for each step.

Step #1 • Select Maxstar TIGRunner® and Coolant

<table>
<thead>
<tr>
<th>Maxstar 400 TIGRunner</th>
<th>907716001</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maxstar 800</td>
<td>907718</td>
</tr>
<tr>
<td>(add 300244 cart and 300245 Coolmate to create Maxstar 800 TIGRunner)</td>
<td></td>
</tr>
<tr>
<td>Low-Conductivity Coolant (must be ordered in quantities of four)</td>
<td>043810</td>
</tr>
</tbody>
</table>

Step #2 • Select Remote Control

| Wireless Foot | 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 |
| HRC-14 Hand | 242211020 |
| Wireless Hand | 300430 |

Step #3 • Select Torch Kit

| W-250 Kit | 300185 |
| W-280 Kit | 300990 |
| W-375 Kit | 301268 |
| W-400 (WP-18SC) Kit | 300186 (recommended for 800 model) |
| W-400 (WP-18SC) Kit | 300186 (recommended for 800 model) |
Water-Cooled Torch Kits

**W-280 Torch Kit  300990**
- Weldcraft® W-280 25-foot (7.6 m) TIG torch with Dinse-style connector
- Torch cable cover
- Work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK4C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (1/16, 3/32 and 1/8 inch)

**W-375 Torch Kit  301268**
*Recommended for Maxstar 400*
- Weldcraft® W-375 25-foot (7.6 m) TIG torch with Dinse-style connector
- Torch cable cover
- Work clamp with 15-foot (4.6 m) 1/0 cable and Dinse-style connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK4C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (1/16, 3/32 and 1/8 inch)

**W-400 (WP-18SC) Torch Kit  300186**
*Recommended for Maxstar 800*
- Weldcraft® W-400 (WP-18SC) 25-foot (7.6 m) TIG torch with thread-lock connector
- Torch cable cover
- Work clamp with 12-foot (3.7 m) 4/0 cable with thread-lock connector
- Flowmeter regulator
- Gas hose (regulator to machine)
- AK18C torch accessory kit includes nozzles, collets, collet bodies and 2% ceriated tungsten electrodes (3/32, 1/8 and 5/32 inch)

**Runner™ Cart  300244**
- Designed to accommodate Dynasty or Maxstar 400 or 800 power sources and a Coolmate™ 3.5 Cooler. Cart features single cylinder rack, foot pedal holder, three cable/torch holders, and two TIG electrode filler holders.

**Coolmate™ 3.5  300245**
- Designed to integrate with the Dynasty and Maxstar 400 and 800 power sources. For use with water-cooled torches rated up to 600 amps. 3.5-gallon capacity.

**Low-Conductivity TIG Coolant  043810**
- Sold in multiples of four in one-gallon recyclable plastic bottles. Miller coolants contains a base of ethylene glycol and deionized water to protect against freezing to -37° Fahrenheit (-38°C) or boiling to 227° Fahrenheit (108°C).

**Automation Interface Connection Kit  278161 Field**
- Provides control of power source welding parameters through a 28-pin receptacle. The 28-pin receptacle replaces the standard 14-pin receptacle and requires a PLC controller to operate the power source. Ideal for automated equipment integration.

**Weld Current Sensor  300179 Field**
- Detects when work clamp is not connected and prevents expensive damage to disconnect devices and input power cord and wiring.
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.

Wireless Remote Hand Control 300430
For remote current and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 90-foot (27.4 m) operating range.

RCCS-14 Remote Contactor and Current Control 043688
North/south rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Great for applications that require a finer amperage control. Includes 26.5-foot (8 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. Great for production or contractors that need quick ramp-up. Includes 26.5-foot (8 m) cord and 14-pin plug.

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.

RHC-14 Hand Control 242211020
Miniature hand control for remote current and contactor control. Dimensions: 4 x 4 x 3.25 inches (102 x 102 x 83 mm). Includes 20-foot (6 m) cord and 14-pin plug.

RMLS-14 Switch 129337
Momentary- and maintained-contact rocker switch for contactor control. Push forward for maintained contact and backward for momentary contact. Includes 26.5-foot (8 m) cord and 14-pin plug.

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.

Extension Cables for 14-Pin Remote Controls
- 242208025 25 ft. (7.6 m)
- 242208050 50 ft. (15.2 m)
- 242208080 80 ft. (24.4 m)

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.

Memory Card (Blank) 301080
A blank, commercially available memory card used for transferring software updates and expandable features from your computer to the machine. Free software updates and feature expansions can be downloaded at MillerWelds.com/tigsoftware.

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

Tungsten

<table>
<thead>
<tr>
<th>Tungsten</th>
<th>Amp Range</th>
<th>2% Ceriated (AC/DC)</th>
<th>2% Lanthanated (AC/DC)</th>
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<tbody>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>70–150 A</td>
<td>WC116X7</td>
<td>WL2116X7</td>
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<tr>
<td>3/32 in. (2.4 mm)</td>
<td>140–250 A</td>
<td>WC332X7</td>
<td>WL2332X7</td>
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<tr>
<td>1/8 in. (3.2 mm)</td>
<td>225–400 A</td>
<td>WC018X7</td>
<td>WL2018X7</td>
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<tr>
<td>5/32 in. (4.0 mm)</td>
<td>300–500 A</td>
<td>WC532X7</td>
<td>WL2532X7</td>
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## Equipment and Options

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<td>907716</td>
<td>Maxstar® 400 Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA</strong>. 8 ft. power cord</td>
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<tr>
<td>907716002</td>
<td>Maxstar® 400 International Auto-Line™ 380–575 V, 50/60 Hz, <strong>CE</strong>. 8 ft. power cord</td>
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<tr>
<td>907716001</td>
<td>Maxstar® 400 TIG Runner® Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA</strong>. 8 ft. power cord. Requires coolant</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951693</td>
<td>Maxstar® 400 Wireless Complete Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA</strong>. 8 ft. power cord</td>
<td></td>
<td></td>
</tr>
<tr>
<td>951692</td>
<td>Maxstar® 400 Complete Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA</strong>. 8 ft. power cord</td>
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<tr>
<td>907718</td>
<td>Maxstar® 800 Auto-Line™ 208–575 V, 50/60 Hz, <strong>CSA</strong></td>
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<tr>
<td>907718002</td>
<td>Maxstar® 800 International Auto-Line™ 380–575 V, 50/60 Hz, <strong>CE</strong></td>
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### TIG Torches, Kits and Connectors

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<th>Description</th>
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<tr>
<td>300990</td>
<td>W-280 Water-Cooled Torch Kits</td>
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<tr>
<td>301268</td>
<td>W-375 (recommended for Maxstar 400)</td>
</tr>
<tr>
<td>300186</td>
<td>W-400 (WP-18SC) (recommended for Maxstar 800)</td>
</tr>
<tr>
<td>195377</td>
<td>Connects Weldcraft™ water-cooled torches to Dinse-style connector</td>
</tr>
<tr>
<td>225028</td>
<td>Connects Weldcraft™ water-cooled torches to Maxstar 800 (thread-lock connector included with 800 models)</td>
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</table>

### Tungsten

See page 7

### Remote Controls

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<tr>
<th>Stock No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>300429</td>
<td>Wireless Remote Foot Control Foot control with wireless 90 ft. (27.4 m) operating range</td>
</tr>
<tr>
<td>300430</td>
<td>Wireless Remote Hand Control Hand control with wireless 300 ft. (91.4 m) operating range</td>
</tr>
<tr>
<td>043688</td>
<td>RCCS-14 North/south fingertip control</td>
</tr>
<tr>
<td>151086</td>
<td>RCC-14 East/west fingertip control</td>
</tr>
<tr>
<td>194744</td>
<td>RFCS-14 HD Heavy-duty foot control</td>
</tr>
<tr>
<td>242211020</td>
<td>RHC-14 Hand control</td>
</tr>
<tr>
<td>129337</td>
<td>RML-14 Momentary/maintained rocker switch</td>
</tr>
<tr>
<td>187208</td>
<td>RMS-14 Momentary rubber dome switch</td>
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### Accessories

<table>
<thead>
<tr>
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<th>Description</th>
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<tbody>
<tr>
<td>300244</td>
<td>Runner™ Cart See page 6</td>
</tr>
<tr>
<td>300245</td>
<td>Coolmate™ 3.5 120 V, 50/60 Hz, <strong>CE</strong>. Requires coolant</td>
</tr>
<tr>
<td>043810</td>
<td>TIG Coolant(1) gallon plastic bottle. Protects against freezing to (-37^\circ) Fahrenheit ((-38^\circ)C) or boiling to (227^\circ) Fahrenheit ((108^\circ)C)\</td>
</tr>
<tr>
<td>278161</td>
<td>Automation Interface Kit Field installation required. Provides 28-pin automation connections</td>
</tr>
<tr>
<td>300179</td>
<td>Weld Current Sensor Field installation required. Detects when work clamp is not connected</td>
</tr>
<tr>
<td>042418</td>
<td>Dinse-Style Connector 50 mm (1 male) Used to connect weld cable to Dinse terminal machine</td>
</tr>
<tr>
<td>225029</td>
<td>Thread-Lock Connectors (2 male) Used to connect weld cable to Dynasty 800 or Maxstar 800</td>
</tr>
<tr>
<td>042419</td>
<td>Dinse-Style Connector 50 mm (1 male, 1 female) Used to extend weld cables</td>
</tr>
<tr>
<td>042465</td>
<td>Dinse/Tweco® Adapter Male Dinse to female Tweco</td>
</tr>
<tr>
<td>042466</td>
<td>Dinse/Cam-Lok Adapter Male Dinse to female Cam-Lok</td>
</tr>
<tr>
<td>250833</td>
<td>Gas Tungsten Arc Welding (TIG) Publication</td>
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### Date:

<table>
<thead>
<tr>
<th>Total Quoted Price:</th>
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