The 175-amp XR-Aluma-Pro Lite is a compact, lightweight, air-cooled push-pull gun with a 25-foot (7.6 m) cable. It allows operators to easily access hard-to-reach welds, reducing hand and welder fatigue.

Aluminum-series-specific tension setting ensures smooth wire feeding performance with 4000 or 5000 series aluminum wires.

3-3/4 turn potentiometer provides better resolution when selecting the right wire speed for the job. The recessed WFS (wire feed speed) control offers durability, yet is easy to use while wearing welding gloves.

Trigger mounted at the back of the gun allows operator to easily access hard-to-reach weldments.

Replaceable feed cable liner is designed to provide consistent arc performance. It also reduces parts cost and service time by allowing a simple means of removing and replacing liner and not the complete feed cable.

Integrated with standard Bernard® rotatable head tube to allow better access into tight spots. Numerous optional Bernard head tubes are available in many sizes and lengths, for custom applications and to improve operator comfort. Optional head tubes require optional long head tube liners. Order optional head tube liners from the Standard Replacement Consumables section (see page 3).

Easy access to drive assembly and removable head tube reduces service time. Pressure release lever allows drive rolls to be held open for wire changeover.

Centerfire™ consumables provide superior gas coverage and arc performance. Also compatible with Miller Roughneck®, FasTip™ consumables. Order gas diffuser, contact tip and nozzle from Optional FasTip Consumables section (see page 2).

Guns are warranted for 1 year, parts and labor.
Specifications

<table>
<thead>
<tr>
<th>Welding Output Rating</th>
<th>Electrode Wire Diameter Capacity</th>
<th>Wire Speed</th>
<th>Dimensions</th>
<th>Net Weight (Torch only)</th>
</tr>
</thead>
<tbody>
<tr>
<td>175 A at 60% Duty Cycle with 25-ft. (7.6 m) air-cooled gun</td>
<td>.030 – .047 in.* (0.8 – 1.2 mm) aluminum wire</td>
<td>70 – 900 IPM (1.8 – 23 m/min.) dependent on feeder used</td>
<td>H: 4 in. (102 mm) W: 1.9 in. (48 mm) L: 15 in. (381 mm)</td>
<td>2.0 lb. (0.9 kg)</td>
</tr>
</tbody>
</table>

*Note: .047-inch wire and consumables are also referenced as 3/64-inch.

Standard Centerfire™ Series Consumables

Aluminum-Specific T Series Contact Tips
- T-035AL* .035 in. (0.9 mm)
- T-047AL* .047 in. (1.2 mm)

T Series Contact Tips for Hard or Cored Wires
- T-030 .030 in. (0.8 mm)
- T-035 .035 in. (0.9 mm)
- T-039 .039 in. (1.0 mm)
- T-045 .045 in. (1.2 mm)

TT Series Contact Tips for Hard or Cored Wires
- TT-030 .030 in. (0.8 mm)
- TT-035 .035 in. (0.9 mm)
- TT-045 .045 in. (1.2 mm)

Diffuser
- DS-1AP* (small)
- D-1AP (large)

Small Nozzles
- NS-5818B Brass, 5/8-in. I.D., 1/8-in. tip recess
- NS-1218B Brass, 1/2-in. I.D., 1/8-in. tip recess
- NS-1218C* Copper, 1/2-in. I.D., flush tip
- NST-3818B Brass, 3/8-in. I.D., 1/8-in. tip recess

Large Nozzles
- N-3414C Copper, 3/4-in. I.D., 1/4-in. tip recess
- N-3418B Brass, 3/4-in. I.D., 1/8-in. tip recession
- N-3414B Brass, 3/4-in. I.D., 1/4-in. tip recession
- N-5814C Copper, 5/8-in. I.D., 1/4-in. tip recession
- N-5818B Brass, 5/8-in. I.D., 1/8-in. tip recession
- N-5814B Brass, 5/8-in. I.D., 1/4-in. tip recession

Diffuser
- #DS-1AP* (small)
- #D-1AP (large)

Small Nozzle Configuration

Optional Large Nozzle Configuration

Optional FasTip™ Consumables

Nozzles
- Screw-On Brass
  - #199 610 1/2-in. orifice, tapered
  - #199 611 3/4-in. orifice, straight
  - #199 612 3/4-in. orifice, straight HD
  - #199 613 5/8-in. orifice, tapered
  - #199 614 5/8-in. orifice, tapered HD
- Screw-On Copper
  - #199 615 1/2-in. orifice, tapered
  - #199 616 3/4-in. orifice, straight
  - #199 617 3/4-in. orifice, straight HD
  - #198 855 5/8-in. orifice, tapered
  - #199 618 5/8-in. orifice, tapered HD
  - #207 313 5/8-in. orifice, tapered 15/16 OD
  - #209 035 3/8-in. orifice, tapered
  - #209 036 1/2-in. orifice, tapered

FasTip™ Contact Tips

- Heavy-Duty (Aluminum Wire)
  - #206 186 .030 in. (0.8 mm)
  - #206 187 .035 in. (0.9 mm)
  - #206 188 .040 in. (1.0 mm)
  - #206 189 3/64 in. (1.2 mm)
  - #206 191 1/16 in. (1.6 mm)

- Tapered (Aluminum Wire)
  - #209 026 .030 in. (0.8 mm)
  - #209 027 .035 in. (0.9 mm)
  - #209 029 3/64 in. (1.2 mm)
  - #209 030 1/16 in. (1.6 mm)

Gas Diffusers

- #206 195 Standard
  1/8-inch tip recess for heavy-duty FasTip™ contact tips.
- #210 664
  1/4-inch tip recess for heavy-duty FasTip™ contact tips.
- #206 196
 Flush tip for heavy-duty FasTip™ contact tips.

*The use of FasTip consumables requires the use of long head tube liners. Order long head tube liners from the standard replacement consumables section (see page 3).
**Standard Replacement Consumables**  
(Order from Miller Service Parts.)

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>Drive Rolls</th>
<th>Idler Rolls</th>
<th>Inlet Guides</th>
<th>Head Tube Liner: For use with Standard Head Tube and Centerfire Consumables (5 pk)</th>
<th>Long Head Tube Liner: For use with Optional Head Tube or Fast Tip Consumables (5 pk)*</th>
<th>Cable Liner: 25 ft. (7.6 m)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030 in. (0.8 mm)</td>
<td>#254 756</td>
<td>#227 439</td>
<td>#227 408</td>
<td>#258 541</td>
<td>#258 726</td>
<td>M-1440</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>#254 756</td>
<td>#227 439</td>
<td>#227 408</td>
<td>#258 541</td>
<td>#258 726</td>
<td>M-1440</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>#254 756</td>
<td>#227 439</td>
<td>#227 408</td>
<td>#258 542</td>
<td>#258 727</td>
<td>M-1440</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>#254 756</td>
<td>#227 439</td>
<td>#227 408</td>
<td>#258 542</td>
<td>#258 727</td>
<td>M-1440</td>
</tr>
</tbody>
</table>

*Long head tube liners must be cut to fit.

**Replacement and Optional Head Tubes**

**Replacement Head Tube**  
#254 477  
Standard replacement head tube assembly for an XR-Aluma-Pro Lite gun.

**Optional Head Tubes**

Numerous optional Bernard® head tubes are available in many sizes and lengths, for custom applications and to improve operator comfort. For more information on optional head tubes, visit the following links:

bernardwelds.com/files/SpSh_Necks.pdf
bernardwelds.com/files/SpSh_FlexNeck.pdf

*Note: The use of optional head tubes requires the use of long head tube liners. Order long head tube liners from the standard replacement consumables section above. Long head tube liners are 14 inches long and must be cut to fit.*

To locate the nearest Bernard distributor, visit:
bernardwelds.com/locator/locator_search.php

**Genuine Miller® Accessories**

**Leather Cable Cover**  
#234 110 25 ft. (7.6 m)  
Protects gun hose and cable assembly from wear and abrasion. Features a full length velcro seam.

**Short Leather Gun Cover**  
#234 416  
Optional cover is 17 inches (432 mm).
Machines and Wire Feeders

**Millermatic® 350P Aluminum/ XR-Aluma-Pro™ Lite System**

#951 454  200(208)/230/460 V

**Millermatic® 350P**

#907 300  200(208)/230/460 V
Standard all-in-one power supply features superior aluminum MIG welding with direct connection of optional push/pull and spool guns. Also features built-in Pulsed MIG programs and four-drive-roll system.

**Millermatic® 252**

#907 321  200(208)/230 V
#907 322  230/460/575 V
Standard all-in-one power supply features superior aluminum MIG welding with direct connection of optional push/pull and spool guns.

**XR™-S Control** #300 601
**XR™-D Control** #300 687
The updated XR Controls offer unsurpassed performance and reliability for feeding aluminum and other difficult-to-feed wire types. Models include .035-inch and factory-installed 3/64-inch drive rolls. See Lit. Index No. M/1.7.

**XR-AlumaFeed™ Wire Feeder** #300 509
Advanced push-pull wire feeder designed for high-volume, high-production aluminum MIG welding where quality and consistency is a high priority. See Lit. Index No. DC/34.

### 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-Aluma-Pro™ Lite</td>
<td>#300 948</td>
<td>175-amp, air-cooled push-pull gun with 25-ft. (7.6 m) cable</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Machines and Wire Feeders

**Millermatic® 350P Aluminum/ XR-Aluma-Pro Lite System**
(See Lit. Index No. DC/12.56)

#951 454  200(208)/230/460 V. True torque motor push-pull system. *Note: The Millermatic® 350P Aluminum is compatible only with push-pull guns — not standard MIG guns*

**Millermatic® 350P**
(See Lit. Index No. DC/12.51)

#907 300  200(208)/230/460 V. Standard power supply with constant-speed motor

**Millermatic® 252**
(See Lit. Index No. DC/12.49)

#907 321  200(208)/230 V. Standard power supply with constant-speed motor
#907 322  230/460/575 V. Standard power supply with constant-speed motor

**XR™-S Control**
(See Lit. Index No. M/1.7)

#300 601  Standard model includes .035- and 3/64-in. drive rolls, wire feed speed digital display, jog/purge, run-in control, and trigger hold

**XR™-D Control**
(See Lit. Index No. M/1.7)

#300 687  Enhanced model includes .035- and 3/64-in. drive rolls, has same features as XR-S, plus advanced digital and programming capabilities

**XR-AlumaFeed™**
(See Lit. Index No. DC/34)

#300 509  Advanced model includes .035- and 3/64-in. drive rolls, and adds Profile Pulse™, synergic control, trigger schedule select, lock capabilities and flowmeter

#### Accessories

| Leather Cable Cover                     | #234 110  | 25 ft. (7.6 m)                                                                      |      |       |
| Short Leather Gun Cover                 | #234 416  | 17 in. (432 mm)                                                                     |      |       |

Date:                                           Total Quoted Price:

 Distributed by:

*Litho in USA*