A complete system consists of the following:
- XR Control
- XR push-pull gun
- Recommended 14-pin Miller power source
Order separately, see page 4.

True torque feed motor push-pull design provides continuous push force to the wire while the gun motor controls the speed at the gun. The motors work together to provide accurate and positive wire feed speed without wire shaving or deformation.

Adjustable wire run-in control allows arc start fine tuning. Reduces wire stubbing or arc flaring which can result in contact tip burnback.

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

**XR-S**
Simple, cost-effective push-pull feeder has wire feed speed display, jog/purge, run-in control, and trigger hold. 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**
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 three years, parts and labor.
Gun warranted for one year, parts and labor.
Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Input Welding Circuit Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Type and Diameter Capacity</th>
<th>Maximum Spool Size Capacity</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>24 VAC, 5 A, 50/60 Hz</td>
<td>400 A at 100% duty cycle System duty cycle is limited to gun rating</td>
<td>50–900 rpm (1.3–22.9 m/min.)</td>
<td>Aluminum .035–.062 in. (0.9–1.6 mm) Solid Wire .035–.045 in. (0.9–1.2 mm)</td>
<td>12 in. (305 mm)</td>
<td>H: 16 in. (406 mm) W: 9.5 in. (241 mm) D: 21.25 in. (540 mm)</td>
<td>42.5 lb. (19.2 kg)</td>
</tr>
</tbody>
</table>

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

Control Panels

XR-D Front Panel

XR-S Front Panel

Side Panel (Common to Both Models)

1. Setup Menu Indicator
2. Left Display
3. Start Menu Indicator
4. Crater Menu Indicator
5. Volts Indicator
6. Arc Length Indicator
7. Left Adjust Knob
8. Start On Indicator
9. Setup Indicator
10. Setup Button
11. Start Button
12. Right Display
13. Wire Speed Indicator
14. Amps Indicator
15. Right Adjust Knob
16. Crater On Indicator
17. Crater Button
18. Jog/Purge Switch
19. Wire Speed Display
20. Run-In Speed Control
21. Trigger Hold Switch
22. Motor Torque Switch
23. Gas Flowmeter (Optional)
24. Gun Securing Knob
25. Gun Bushing
26. Drive Casting
Genuine Miller® Options and Accessories

Gas Flowmeter Kit 246127 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.

PSA-2 Control 141604
Required when using the XR Control with power sources having only 115 VAC available. Mounts at power source and includes a 10-foot (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. Control 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 Remote Voltage Control is not functional.

Extension Cords
242208025 25 ft. (7.6 m)
242208050 50 ft. (15 m)
242208080 80 ft. (24.4 m)
Provides 14-pin, 24 VAC contactor and voltage control. Can be added to the standard 10-foot (3 m) feeder cord to extend feeder farther from power source.

Coolant Systems
For more information, see literature AY/7.2.

Coolmate™ 3
043007 115 V
043008 230 V
For use with water-cooled torches rated up to 600 amps. Unique paddle-wheel indicator, external filter and easy-fill spout.

Coolmate™ 4
042288 115 V
For use with water-cooled torches rated up to 600 amps. Tough molded polyethylene case with carrying handle.

Coolant 043809
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.

Typical Installations

![Typical Installations Diagram]

Millar CV or CV/CC power source equipped with a 14-pin receptacle and 24 VAC power (see list on page 4)

PSA-2 115/24 VAC
Miller CV or competitive CV power source with 115 VAC power (see list on page 4)

10-foot (3 m) 24 VAC contactor cord supplied with feeder

XR-S or XR-D Control
XR-Aluma-Pro™ or XR™-Pistol/Pistol-Pro push-pull gun

Contactor
115 VAC

10-foot (3 m) 24 VAC contactor cord supplied with feeder

XR-S or XR-D Control
XR-Aluma-Pro™ or XR™-Pistol/Pistol-Pro push-pull gun
**Recommended Power Sources**

AlumaPower™ MPa  
See literature DC/34.0

Deltaweld® Series  
See literature DC/16.2

Dimension™ 650  
See literature DC/19.3

Invision™ MPa  
See literature DC/23.6

Trailblazer® 275 and 325  
See literature ED/4.75

Big Blue® 800 Series  
See literature ED/14.0

**Recommended Miller 14-pin power source (see list below)**

**Important notes:**

XR Control must be serial number KK309906 or higher to be used with products and descriptions mentioned in this literature. To confirm a product’s compatibility with older equipment, please contact the factory at 1-920-735-4505.

**Options**

Gas Flowmeter Kit  
246127  
Field

**Accessories**

PSA-2 Control  
141604  
For older power sources with 115 V feeder power

Extension Cords  
See page 3

Coolant Systems  
See page 3. See literature AY/7.2

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