AlumaFeed®
Synergic Aluminum Welding System

Quick Specs

<table>
<thead>
<tr>
<th>Heavy Industrial Applications</th>
<th>XR-AlumaFeed SuitCase</th>
<th>AlumaPower 350 MPa and 450 MPa</th>
</tr>
</thead>
<tbody>
<tr>
<td>Boat, ship and yacht building</td>
<td>Input Power</td>
<td>Input Power</td>
</tr>
<tr>
<td>Recreational vehicles</td>
<td>24 VAC, 5 A, 50/60 Hz</td>
<td>350: Requires 3- or 1-phase power,</td>
</tr>
<tr>
<td>Trucks and trailer</td>
<td>Wire Feed Speed</td>
<td>208–575 V, 50/60 Hz</td>
</tr>
<tr>
<td>Sign manufacturers</td>
<td>50–900 ipm (1.3–22.9 m/min.)</td>
<td>450: Requires 3-phase power,</td>
</tr>
<tr>
<td>Emergency vehicles</td>
<td>Net Weight</td>
<td>230/460 V or 575 V, 60 Hz</td>
</tr>
<tr>
<td></td>
<td>31 lb. (14.1 kg)</td>
<td>Rated Output</td>
</tr>
<tr>
<td></td>
<td></td>
<td>350: 10–38 V, 5–425 A</td>
</tr>
<tr>
<td></td>
<td></td>
<td>450: 10–38 V, 15–600 A</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Net Weight</td>
</tr>
<tr>
<td></td>
<td></td>
<td>350: 80 lb. (36.3 kg)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>450: 122 lb. (55.3 kg)</td>
</tr>
</tbody>
</table>

The XR-AlumaFeed® system consistently delivers premium feeding performance, portability when needed, and a balanced and ergonomic gun design to allow you to weld aluminum all day.

Ultra portable and versatile.
The slim ergonomic design of the XR-Aluma-Pro torch allows access into the tightest of quarters. Coupled with an XR-AlumaFeed SuitCase feeder and AlumaPower 350 MPa or 450 MPa synergic power supply, it has the features for all of your aluminum fabrication needs.

Synergic pulsed welding mode offers the simplicity of single-knob control.
The machine will select the correct pulse power based on the wire feed speed (WFS) set by the operator.

Parameter and system locks provide three levels of protection to prevent accidental modification of welding parameters or manipulation of setup menu items.

Power source/wire feeder are warrantied for three years, parts and labor.
Original main power rectifier parts are warrantied for five years.
Gun warranted for one year, parts and labor.

Coming complete with:
- XR-AlumaFeed® SuitCase® push-pull wire feeder
- AlumaPower® 350 MPa OR 450 MPa power source
- XR-Aluma-Pro® OR XR™-Pistol-Pro push-pull welding gun
- .035- and 3/64-inch (0.9 and 1.2 mm) contact tips, drive roll and liners for guns
- .035- and 3/64-inch (0.9 and 1.2 mm) drive rolls for wire feeder, 3/64-inch installed

Note: All AlumaFeed systems come set up out of the box to run 3/64-inch (1.2 mm) 5356 wire.
Order weld cables and other accessories separately.

Synchronized, true push-pull wire feed system. Slave/torque motor ensures smooth, consistent feeding and improved arc performance, while reducing the problems normally associated with feeding aluminum.

AlumaFeed®
Synergic aluminum welding system also available with XR-Pistol-Pro gun.
XR-AlumaFeed® SuitCase® Wire Feeder

**Profile Pulse:** Achieve “stacked dime” weld bead appearance without back-stepping.

**Advanced trigger** provides “trigger interlock” capability and the ability to control the amount of time spent in the arc start and arc crater steps.

**Bright digital displays** are easy to read, and display voltage or arc length and wire feed speed or amperage. They also have indicators for start and crater, setup, schedule select and advanced trigger operations. Two-knob, three-button panel layout makes it simple to change parameters and reduces training time.

**XR-AlumaFeed SuitCase Specifications** (Subject to change without notice.) (Use with CC/CV, DC power sources.)

<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 ipm (1.3–22.9 m/min.)</td>
<td>Aluminum .035–.1/16 in. (0.9–1.6 mm) Solid Wire .035–.045 in. (0.9–1.2 mm) Drive roll kit 268850 required to run 1/16 in. (1.6 mm) wire</td>
<td>12 in. (305 mm)</td>
<td>H: 15.5 in. (394 mm) W: 9 in. (229 mm) D: 21 in. (533 mm)</td>
<td>31 lb. (14.1 kg)</td>
</tr>
</tbody>
</table>

**XR-AlumaFeed SuitCase Control Panel**

1. Start Menu Indicator
2. Crater Menu Indicator
3. Volts Indicator
4. Schedule B Indicator
5. Advanced Trigger Indicator
6. Amps Indicator
7. Left Adjust Knob
8. Start Button and On Indicator
9. Setup Button and On Indicator
10. Voltage/Arc Length Display
11. Lock Indicator
12. Arc Length Indicator
13. Setup Menu Indicator
14. Amperage/Wire Feed Speed Display
15. Wire Feed Speed Indicator
16. Right Adjust Knob
17. Crater Button and On Indicator

**Power Source Compatibility for XR-AlumaFeed SuitCase Wire Feeder**

<table>
<thead>
<tr>
<th>Power Source</th>
<th>Pulse Capable</th>
<th>Synergic Pulsed MIG</th>
<th>Profile Pulse Capability</th>
<th>Electronic Inductance/SharpArc®</th>
<th>Compatibility</th>
</tr>
</thead>
<tbody>
<tr>
<td>AlumaPower® 350 and 450 MPa</td>
<td>Yes (Aluminum only)</td>
<td>Yes (Aluminum only)</td>
<td>Yes</td>
<td>Yes</td>
<td>Optimized</td>
</tr>
<tr>
<td>Invision® 352 and 450 MPa</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Best</td>
</tr>
<tr>
<td>XMT® 350 and 450 MPa</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Best</td>
</tr>
<tr>
<td>XMT® 350 and 450 CC/CV</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>XMT® 304 CC/CV</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 456P</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 456MP</td>
<td>Yes</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 354P</td>
<td>Yes (with Optima)</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Invision® 354MP</td>
<td>Yes</td>
<td>No</td>
<td>No</td>
<td>Yes</td>
<td>Better</td>
</tr>
<tr>
<td>Deltaweld® (after KF790532)</td>
<td>No</td>
<td>No</td>
<td>No</td>
<td>No</td>
<td>Good</td>
</tr>
</tbody>
</table>

Note: Power sources not included in this list are not recommended. For specific information, please contact your local Miller distributor.
Gun Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Welding Current Rating</th>
<th>Wire Feed Speed</th>
<th>Wire Diameter Capacity</th>
<th>Dimensions</th>
<th>Net Weight (Gun only)</th>
</tr>
</thead>
<tbody>
<tr>
<td>XR-Aluma-Pro</td>
<td>300 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Wire kit 230708 required to run 1/16 in. (1.6 mm) wire</td>
<td>H: 5 in. (127 mm) W: 2.5 in (64 mm) D: 17 in. (432 mm)</td>
<td>2.5 lb. (1.1 kg)</td>
</tr>
<tr>
<td>(air-cooled)</td>
<td></td>
<td>dependent on control box or Millermatic® used</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Aluma-Pro</td>
<td>400 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Wire kit 230708 required to run 1/16 in. (1.6 mm) wire</td>
<td>H: 7.375 in. (187 mm) W: 1.875 in. (48 mm) D: 10.825 in. (270 mm)</td>
<td>2.2 lb. (1 kg)</td>
</tr>
<tr>
<td>(water-cooled)</td>
<td></td>
<td>dependent on control box or Millermatic® used</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Pistol-Pro</td>
<td>200 A at 100% duty cycle</td>
<td>70–900 ipm (1.8–23 m/min.)</td>
<td>.030–1/16 in. (0.8–1.6 mm) aluminum wire Wire kit 230708 required to run 1/16 in. (1.6 mm) wire</td>
<td>H: 5 in. (127 mm) W: 2.5 in (64 mm) D: 17 in. (432 mm)</td>
<td>2.4 lb. (1.1 kg)</td>
</tr>
<tr>
<td>(air-cooled)</td>
<td>250 A at 60% duty cycle</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>XR-Pistol-Pro</td>
<td>400 A at 100% duty cycle</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(water-cooled)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Standard Gun Consumables

**XR-Aluma-Pro™ Gun**

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>FasTip Contact Tip (Qty. 25)</th>
<th>Drive Rolls</th>
<th>Idler Rolls</th>
<th>Inlet Guides</th>
<th>Liner for Short Air-Cooled Head Tube 4 in. (102 mm)</th>
<th>Liner for Long Air- or Water-Cooled Head Tube 6 in. (152 mm)</th>
<th>Cable Liners</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030 in. (0.8 mm)</td>
<td>206186 .041 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>2299674</td>
<td>299887 15 ft. (4.6 m)</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>206187 .047 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>2299674</td>
<td>299891 25 ft. (7.6 m)</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>206188 .053 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>227161</td>
<td>2299674</td>
<td>232321 35 ft. (10.6 m)</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>206189 .061 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>227408</td>
<td>230239</td>
<td>229431</td>
<td></td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>206191 .071 in. ID</td>
<td>227434</td>
<td>230710</td>
<td>230711</td>
<td>230239</td>
<td>229431</td>
<td></td>
</tr>
</tbody>
</table>

**XR™-Pistol-Pro Gun**

<table>
<thead>
<tr>
<th>Aluminum Wire Size</th>
<th>FasTip Contact Tip (Qty. 25)</th>
<th>Drive Rolls</th>
<th>Idler Rolls</th>
<th>Head Tube Liner 4 in. (102 mm)</th>
<th>Cable Liners</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030 in. (0.8 mm)</td>
<td>206186 .041 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>M1115 15 ft. (4.6 m)</td>
</tr>
<tr>
<td>.035 in. (0.9 mm)</td>
<td>206187 .047 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>248359 25 ft. (7.6 m)</td>
</tr>
<tr>
<td>.040 in. (1.0 mm)</td>
<td>206188 .053 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1272</td>
<td>248375 35 ft. (10.6 m)</td>
</tr>
<tr>
<td>3/64 in. (1.2 mm)</td>
<td>206189 .061 in. ID</td>
<td>227434</td>
<td>227439</td>
<td>M1273</td>
<td></td>
</tr>
<tr>
<td>1/16 in. (1.6 mm)</td>
<td>206191 .071 in. ID</td>
<td>227434</td>
<td>230710</td>
<td>M1273</td>
<td></td>
</tr>
</tbody>
</table>
AlumaPower™ 350/450 MPa Power Source

MPa: M (MIG), P (Pulse), a (Advanced Arc Control). Advanced arc control enables an improved pulse welding arc. The operator has more control over puddle and bead characteristics using SharpArc. In addition, the unit provides a more robust and stable arc at very low arc length, reducing heat input, and providing the ability to weld on a wider range of material thickness. Benefits include easier setup and no more changing wire speed, and then having to go back to the power source to reset the welding output.

Auto-Line™ power management technology on 350 model allows for any input voltage hook-up (208–575 V) with no manual linking. Ideal solution for dirty or unreliable input power. (450 model is manual link.)

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

Large, dual digital meters are easy to view and are presettable to ease setting weld output.

Inverter arc control technology provides greater puddle control for outstanding MIG and pulsed MIG weld performance.

Easy setup for MIG and pulsed MIG applications. SharpArc® controls the arc in pulsed MIG mode and gives control over the arc cone shape, puddle fluidity, and bead profile. If a gas is used other than Ar 100% (argon), SharpArc can be adjusted to help customize your arc to the gas being used.

Lightweight, aerospace-grade aluminum case offers protection and the benefit of reduced weight.

Ultra-tough, polycarbonate-blended cover for control panel protects front controls from damage.

Power factor of .95 enables smaller fuses/breakers and primary wiring. Primary amperage draw at rated output is 25 percent less than the competition.

Line voltage compensation keeps welding output constant even if input power varies by +/-10 percent. 350 models further expand line voltage compensation to an amazing +37/-59 percent when operating on 460 V.

Built-in synergic or standard pulsed MIG capabilities. See the list below of built-in pulsed MIG (GMAW-P) aluminum programs.

<table>
<thead>
<tr>
<th>Wire Type</th>
<th>Gas Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>.035 AL4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.040 AL4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>3/64 AL4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>1/16 AL4043</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.035 AL5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.040 AL5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>3/64 AL5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>1/16 AL5356</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.035 AL49</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>.040 AL49</td>
<td>Ar 100% (argon)</td>
</tr>
<tr>
<td>1/16 AL49</td>
<td>Ar 100% (argon)</td>
</tr>
</tbody>
</table>

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

AlumaPower Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Input Power</th>
<th>Amp/Volt Ranges</th>
<th>Rated Output</th>
<th>Amps Input at Rated Load Output, 60 Hz</th>
<th>KVA</th>
<th>Max. Open-Circuit Voltage</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>AlumaPower 350 MPa</td>
<td>Three-phase</td>
<td>CC mode: 5–425 A, CV mode: 10–38 V</td>
<td>350 A at 34 VDC, 60% duty cycle</td>
<td>40.4</td>
<td>36.1</td>
<td>20.6</td>
<td>17.8</td>
<td>14.1</td>
</tr>
<tr>
<td></td>
<td>Single-phase</td>
<td>CC mode: 5–425 A, CV mode: 10–38 V</td>
<td>300 A at 32 VDC, 60% duty cycle</td>
<td>60.8</td>
<td>54.6</td>
<td>29.7</td>
<td>24.5</td>
<td>19.9</td>
</tr>
<tr>
<td>AlumaPower 450 MPa</td>
<td>Three-phase</td>
<td>CC mode: 15–600 A, CV mode: 10–38 V</td>
<td>450 A at 36.5 VDC, 100% duty cycle</td>
<td>—</td>
<td>49.4</td>
<td>—</td>
<td>27.2</td>
<td>23.6</td>
</tr>
<tr>
<td></td>
<td>Single-phase</td>
<td>CC mode: 15–600 A, CV mode: 10–38 V</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>21.6</td>
</tr>
</tbody>
</table>
**AlumaPower™ Control Panel**

1. Output ON Indicator Light
2. Left Display
3. Voltage Indicator
4. Arc Length Indicator
5. Wire Feeder Receptacle
6. Adjustment Control
7. Right Display
8. Setup Indicator
9. Amperage Indicator
10. Setup Indicator Lights
    - Arc Control Indicator
    - Process Indicator
    - Wire/Gas Type Indicator
    - Setup Button

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**Performance Data**

**AlumaPower 350 MPa Duty Cycle Chart**

- 500 welding amperes
- 450 welding amperes
- 400 welding amperes
- 350 welding amperes
- 300 welding amperes
- 250 welding amperes
- 200 welding amperes
- 150 welding amperes
- 100 welding amperes

**AlumaPower 450 MPa Duty Cycle Chart**

- 700 welding amperes
- 600 welding amperes
- 500 welding amperes
- 400 welding amperes
- 300 welding amperes
- 200 welding amperes
- 100 welding amperes

**Legend**

- 3-phase operation
- 1-phase operation
- 6 AWG power cord
- 8 AWG power cord

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**Setup**

1. OUTPUT ON Indicator Light
2. Left Display
3. Voltage Indicator
4. Arc Length Indicator
5. Wire Feeder Receptacle
6. Adjustment Control
7. Right Display
8. Setup Indicator
9. Amperage Indicator
10. Setup Indicator Lights
    - Arc Control Indicator
    - Process Indicator
    - Wire/Gas Type Indicator
    - Setup Button
### AlumaFeed® System Packages

#### Stationary Packages

**AlumaFeed System Stationary Packages**
Stationary display without running gear/cylinder rack.

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951838</td>
<td>AlumaPower 350 MPa with 15 ft. (4.6 m) air-cooled XR-Aluma-Pro gun</td>
</tr>
<tr>
<td>951834</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) air-cooled XR-Aluma-Pro gun</td>
</tr>
<tr>
<td>951836</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) air-cooled XR-Pistol-Pro gun</td>
</tr>
<tr>
<td>951842</td>
<td>AlumaPower 450 MPa with 25 ft. (7.6 m) water-cooled XR-Aluma-Pro gun</td>
</tr>
</tbody>
</table>

Packages include:
- AlumaPower™ 350 (without auxiliary power)
  - OR AlumaPower™ 450 MPa (with 115-volt auxiliary power) power source
- XR-AlumaFeed® SuitCase® wire feeder
- XR-Aluma-Pro™ (gooseneck-style)
  - OR XR™-Pistol-Pro (pistol-grip-style) push-pull gun
- Gun and feeder drive rolls and consumables to run .035–3/64 inch (0.9–1.2 mm) wire (1/16-inch consumables not included, order separately)
- Coolmate™ 3 and coolant included with water-cooled package

### MIGRunner™ Packages

**AlumaFeed System MIGRunner Packages**
MIGRunner system with running gear/cylinder rack.

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>951833</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) air-cooled XR-Aluma-Pro gun</td>
</tr>
<tr>
<td>951837</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) water-cooled XR-Aluma-Pro gun</td>
</tr>
<tr>
<td>951841</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) air-cooled XR-Pistol-Pro gun</td>
</tr>
<tr>
<td>951835</td>
<td>AlumaPower 350 MPa with 25 ft. (7.6 m) water-cooled XR-Pistol-Pro gun</td>
</tr>
<tr>
<td>951840</td>
<td>AlumaPower 450 MPa with 25 ft. (7.6 m) air-cooled XR-Aluma-Pro gun</td>
</tr>
<tr>
<td>951867</td>
<td>AlumaPower 450 MPa with 25 ft. (7.6 m) water-cooled XR-Aluma-Pro gun</td>
</tr>
</tbody>
</table>

Packages include:
- AlumaPower™ 350 (with 115-volt auxiliary power in water-cooled packages)
  - OR AlumaPower™ 450 MPa (with 115-volt auxiliary power) power source
- XR-AlumaFeed® SuitCase® wire feeder
- XR-Aluma-Pro™ (gooseneck-style)
  - OR XR™-Pistol-Pro (pistol-grip-style) push-pull gun
- MIGRunner cart
- Industrial MIG 4/0 MIG kit with Dinse-style connectors for AlumaPower 350 MPa
  - OR with lug connectors for AlumaPower 450 MPa (see page 7 for contents)
  - Note: Positive weld cable connection to the feeder requires the ring lug be cut off and replaced with the Tweco-style connector supplied with the XR-AlumaFeed SuitCase feeder.
- Gun and feeder drive rolls and consumables to run .035–3/64 inch (0.9–1.2 mm) wire (1/16-inch consumables not included, order separately)
- Coolmate™ 3 and coolant included with water-cooled packages
Genuine Miller® Accessories

**Guns**

**XR-Aluma-Pro™ Guns**
- 301568 15 ft. (4.6 m), air-cooled
- 301569 25 ft. (7.6 m), air-cooled
- 301570 35 ft. (10.6 m), air-cooled
- 301571 15 ft. (4.6 m), water-cooled
- 301572 25 ft. (7.6 m), water-cooled
- 301573 35 ft. (10.6 m), water-cooled

This easy to use and maintain gooseneck-style MIG gun is designed for push-pull wire feed systems. Available in air- or water-cooled versions. Gun design allows for better access into tight spots. See literature M/1.71.

**XR-Pistol-Pro Guns**
- 300782 15 ft. (4.6 m), air-cooled
- 300783 25 ft. (7.6 m), air-cooled
- 300784 35 ft. (10.6 m), air-cooled
- 300786 15 ft. (4.6 m), water-cooled
- 300787 25 ft. (7.6 m), water-cooled
- 300788 35 ft. (10.6 m), water-cooled

This easy to use and maintain pistol-grip MIG gun is designed for push-pull wire feed systems. Available in air- or water-cooled versions. See literature M/1.74.

**Cable Cover**
- M1681 15 ft. (4.6 m)
- M1682 25 ft. (7.6 m)
- M1683 35 ft. (10.6 m)

Protects gun hose and cable assembly from wear and abrasion. Features full-length hook-and-loop closure for ease of maintenance or replacement.

**Short Air-Cooled Head Tube Assembly** 231519
60-degree/4-inch (102 mm) standard head tube includes liner.

**Long Air-Cooled Head Tube Assembly** 231518
60-degree/6-inch (152 mm) optional head tube includes liner.

**Hardwire Liner Kit for Steel and Stainless** 198377
For 15, 25, or 35 ft.
(4.6, 7.6 or 10.6 m) guns

Kit consists of gun head tube liner 233998 listed below and feed cable liner. Recommend using .030–.045 inch mild steel or stainless steel electrode wire.

*Note: .052- and 1/16-inch wires not recommended.*

**Phosphorous Bronze Liner**
- 233999 Long head tube (air or water)
- 233998 Short head tube (air only)

For use with hardwire liner kit 198377 when used in XR-Aluma-Pro gun.

**1/16-inch (1.6 mm) Wire Kit** 230708
Specially designed for 1/16-inch wire. Includes idler roll, head tube liner and inlet guide. Required when running 1/16-inch wires. Not included with standard XR-Aluma-Pro or XR-Pistol-Pro gun.

**1/16-inch (1.6 mm) Drive Roll Kit** 268850
Required when running 1/16-inch wires on XR-AlumaFeed® SuitCase.

**Flowmeter Kit** 301306
Includes flowmeter and components required for mounting to the back of the XR-AlumaFeed SuitCase wire feeder.

**SuitCase Mounting Bracket** 301592
Used for mounting the XR-AlumaFeed SuitCase to the MIGRunner cart or other mounting location determined by customer.

**Industrial MIG 4/0 Kit with Dinse Connectors** 300405
For AlumaPower™ 350 MPa power source. Includes flowmeter regulator with 10-foot (3 m) gas hose, 10-foot (3 m) 4/0 feeder weld cable with Dinse-style connector on one end and a lug on the other, 15-foot (4.6 m) work cable with Dinse-style connector on one end and 600-amp C-clamp on the other.

*Note: Positive weld cable connection to the feeder requires the ring lug be cut off and replaced with the Tweco-style connector supplied with the XR-AlumaFeed SuitCase feeder.*

**Industrial MIG 4/0 Kit** 300390
For AlumaPower™ 450 MPa power source. Includes the same as the kit above, except weld and work cables have lugs instead of Dinse-style connectors.

*Note: Positive weld cable connection to the feeder requires the ring lug be cut off and replaced with the Tweco-style connector supplied with the XR-AlumaFeed SuitCase feeder.*

**11-Conductor Extension Cables**
- 247831025 25 ft. (7.6 m)
- 247831050 50 ft. (15 m)
- 247831080 80 ft. (24.3 m)

*For XR-AlumaFeed SuitCase feeder. Eleven conductors to support contactor control and remote voltage control on all Miller® electronic power sources.*

**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
- 043809 230 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.

**Cable Connectors and Adapters**

Note: AlumaPower™ 350 power sources are equipped with Dinse-style connectors for secondary connections.

**Dinse/Tweco® Adapter** 042465
**Dinse/Cam-Lok Adapter** 042466
One-piece adapter with Dinse-style male plug (to power source) on one end and female receptacle (Tweco or Cam-Lok for weld cable connection) on other end.

**Dinse-Style Connector Kit**
- 042418 Accepts #4 to #1/0 AWG cable size.
- 042533 Accepts #1/0 to #2/0 AWG cable size.

Kit includes one male Dinse-style plug which attaches to the work and/or weld cables and plugs into the Dinse-style receptacles on the power source.

**Extension Kit for Dinse-Style Cable Connectors**
- 042419

Accepts #4 to #1/0 AWG cable size. Used to adapt or extend weld and/or work cables. Kit includes one male Dinse-style plug and one in-line female Dinse-style receptacle.

**Running Gear**

**MIGRunner™ Cart** 195445
Small footprint and easily maneuverable, with cylinder rack low enough that you do not have to lift bottles.

**Universal Carrying Cart and Cylinder Rack** 042934
Holds power source, and gas cylinder up to 56 inches (142.2 cm) high measuring 6 to 9 inches (15.2 to 22.8 cm) in diameter.
### Ordering Information

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<tr>
<th>Power Source and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
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<tr>
<td><strong>AlumaFeed® System Stationary Packages</strong></td>
<td>951838</td>
<td>350 MPa with 15-foot (4.6 m) air-cooled XR-Aluma-Pro gun</td>
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<td>951842</td>
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<td>951837</td>
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<td>951842</td>
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<td>951840</td>
<td>450 MPa with 25-foot (7.6 m) water-cooled XR-Aluma-Pro gun</td>
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<td><strong>AlumaPower™ 350 MPa Power Source</strong></td>
<td>907420</td>
<td>Power source only. 208 – 575 V with Auto-Line™</td>
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<td>907420001</td>
<td>Power source only. 208 – 575 V with Auto-Line™ and auxiliary power</td>
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<tr>
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<td>Power source only. 230/460 V with auxiliary power</td>
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<td>907484</td>
<td>Power source only. 575 V with auxiliary power</td>
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<td><strong>XR-AlumaFeed® SuitCase® Wire Feeder</strong></td>
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<td>Feeder only. Full synergic operation when used with MPa power sources only.</td>
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<td>Other Miller 14-pin power sources may be used, but feature operation may be</td>
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<td>limited. Call your Miller distributor for more information</td>
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</tbody>
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#### Guns and Gun Accessories
- **XR-Aluma-Pro™ Guns**
  - See page 7
- **XR™-Pistol-Pro Guns**
  - See page 7
- **Replacement Cable Covers**
  - See page 7
- **Drive Rolls and Liners**
  - See page 3

#### 1/16-inch (1.6 mm) Wire Kit
- **230708**
  - Required with 1/16-inch drive roll kit below to run 1/16-inch wire

#### Feeder and Power Supply Accessories
- **XR-AlumaFeed SuitCase 1/16-inch (1.6 mm) Drive Roll Kit**
  - **268850**
  - Required with 1/16-inch wire kit above to run 1/16-inch wire
- **Flowmeter Kit**
  - **301306**
  - See page 7
- **SuitCase Mounting Bracket**
  - **301597**
  - See page 7
- **Industrial MIG 4/0 Kit with Dinse Connectors**
  - See page 7
- **11-Conductor Extension Cables**
  - See page 7
- **Cable Connectors and Adapters**
  - See page 7

#### System Accessories
- **MIGRunner™ Cart**
  - **195445**
- **Universal Carrying Cart and Cylinder Rack**
  - **042934**
- **Coolant Systems**
  - See page 7. See literature AY/7.2

### Typical Installation

Note: Cords and cables are supplied unless noted otherwise on drawing below. Refer to Owner’s Manual for complete installation instructions.

1. Connect the 10-foot (3 m) 24 VAC contactor cord supplied with feeder to the XR-AlumaFeed® SuitCase® wire feeder.
2. Connect the XR-Aluma-Pro™ or XR™-Pistol-Pro push-pull gun.

**AlumaPower™ 350 or 450 MPa or other compatible power supply**
- See chart on page 2

**XR-AlumaFeed® SuitCase®**

**Power Source and Options**
- **951838**
  - 350 MPa with 15-foot (4.6 m) air-cooled XR-Aluma-Pro gun
- **951834**
  - 350 MPa with 25-foot (7.6 m) air-cooled XR-Aluma-Pro gun
- **951836**
  - 350 MPa with 25-foot (7.6 m) air-cooled XR-Pistol-Pro gun
- **951842**
  - 450 MPa with 25-foot (7.6 m) water-cooled XR-Aluma-Pro gun

**AlumaFeed® System MIGRunner™ Packages**
- **951833**
  - 350 MPa with 25-foot (7.6 m) air-cooled XR-Aluma-Pro gun
- **951837**
  - 350 MPa with 25-foot (7.6 m) water-cooled XR-Aluma-Pro gun
- **951841**
  - 350 MPa with 25-foot (7.6 m) air-cooled XR-Pistol-Pro gun
- **951835**
  - 350 MPa with 25-foot (7.6 m) water-cooled XR-Pistol-Pro gun
- **951840**
  - 450 MPa with 25-foot (7.6 m) air-cooled XR-Aluma-Pro gun
- **951867**
  - 450 MPa with 25-foot (7.6 m) water-cooled XR-Aluma-Pro gun

**AlumaPower™ 350 MPa Power Source**
- **907420**
  - Power source only. 208 – 575 V with Auto-Line™
- **907420001**
  - Power source only. 208 – 575 V with Auto-Line™ and auxiliary power

**AlumaPower™ 450 MPa Power Source**
- **907483**
  - Power source only. 230/460 V with auxiliary power
- **907484**
  - Power source only. 575 V with auxiliary power

**XR-AlumaFeed® SuitCase® Wire Feeder**
- **301567**
  - Feeder only. Full synergic operation when used with MPa power sources only. Other Miller 14-pin power sources may be used, but feature operation may be limited. Call your Miller distributor for more information

**Guns and Gun Accessories**
- **XR-Aluma-Pro™ Guns**
  - See page 7
- **XR™-Pistol-Pro Guns**
  - See page 7
- **Replacement Cable Covers**
  - See page 7
- **Drive Rolls and Liners**
  - See page 3

**1/16-inch (1.6 mm) Wire Kit**
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  - See page 7. See literature AY/7.2

**Date:**

**Total Quoted Price:**

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