



OM-401634C

2026-06

Processes



MIG (GMAW) Welding

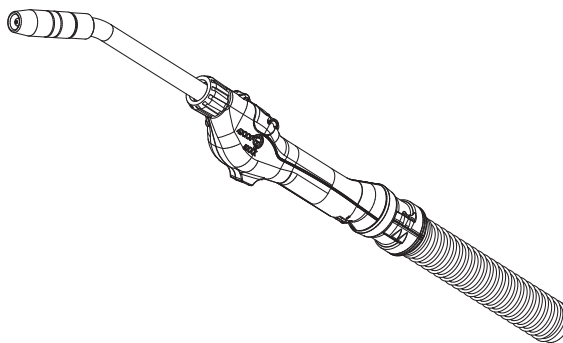
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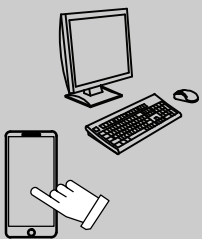
Cobot, Air/Water-Cooled MIG (GMAW)
Welding Gun

XR-Aluma-Pro™ CB

Air And Water-Cooled Guns CE, Non-CE,
and UKCA Models



300 Ampere (Air) Push-Pull Welding Gun
400 Ampere (Water) Push-Pull Welding Gun



For product information,
Owner's Manual translations,
and more, visit

www.MillerWelds.com

OWNER'S MANUAL

From Miller to You

Thank you and congratulations on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety Precautions. They will help you protect yourself against potential hazards on the worksite. We've made installation and operation quick and easy. With Miller, you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is, and our extensive service network is there to help fix the problem. Warranty and maintenance information for your particular model are also provided.

Miller Electric manufactures a full line of welders and welding-related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call**

1-800-4-A-Miller, or visit us at www.MillerWelds.com on the web.



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001 Quality System Standard.



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SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING

 Protect yourself and others from injury—read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage

 **DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

 Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid these hazards.

1-2. Arc Welding Hazards

 The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Principal Safety Standards, and in welding power source Owner's Manual. Read and follow all Safety Standards.

 Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is defined as one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

 During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrode or electrical parts.
- Do not store or use equipment in standing water.
- Replace worn, damaged, or cracked guns or cables.
- Turn off welding power source before changing contact tip or gun parts.
- Keep all covers and handle securely in place.



FUMES AND GASES can be hazardous.

- Keep your head out of the fumes.
- Ventilate area, or use breathing device. The recommended way to determine adequate ventilation

is to sample for the composition and quantity of fumes and gases to which personnel are exposed.

- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



MOVING PARTS can injure.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



WELDING can cause fire or explosion.

- Do not weld near flammable material.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Watch for fire; keep extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



ARC RAYS can burn eyes and skin.

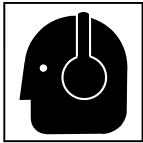
Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare, and sparks; warn others not to watch the arc.
- Wear body protection made from leather or flame-resistant clothing (FRC). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



HOT PARTS can burn.

- Allow gun to cool before touching.
- Do not touch hot metal.
- Protect hot metal from contact by others.



NOISE can damage hearing.

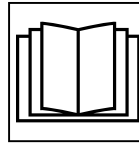
Noise from some processes or equipment can damage hearing.

- Check for noise level limits exceeding those specified by OSHA.
- Wear appropriate ear protection if noise level is high.
- Warn others nearby about noise hazard.



WELDING WIRE can injure.

- Keep hands and body away from gun tip when trigger is pressed.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.

1-3. California Proposition 65 Warnings



WARNING – This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm.

For more information, go to www.P65Warnings.ca.gov.

1-4. Principal Safety Sections

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: www.aws.org.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: safetyequipment.org.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csagroup.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

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1-5. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). The current from arc welding (and allied processes including spot welding, arc gouging, plasma arc cutting, and induction heating operations) creates EMF around the welding circuit. EMF can interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passersby or conduct individual risk assessment for operators. All operators should use the following procedures in order to minimize exposure to EMF fields:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between cables. Arrange cables to one side and away from the operator.

3. Do not coil or drape cables around your body.
4. Keep head and trunk as far away from the equipment in the output circuit as possible.
5. Connect work clamp to workpiece as close to the arc as possible.
6. Do not work next to, sit or lean on, or carry the power source or other equipment while operating.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, arc gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, follow the procedures above.

SECTION 2 – CONSIGNES DE SÉCURITÉ - LIRE AVANT UTILISATION

 Pour écarter les risques de blessure pour vous-même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

2-1. Symboles utilisés

 **DANGER!** – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

 Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

AVIS – Indique des déclarations pas en relation avec des blessures personnelles.

 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Reportez-vous aux symboles et aux directives cidessous afin de connaître les mesures à prendre pour éviter tout danger.

2-2. Dangers relatifs au soudage à l'arc

 Les symboles donnés ci-après sont utilisés dans tout le manuel pour attirer l'attention sur les dangers possibles et pour indiquer le type de danger dont il s'agit. Quand on voit le symbole, prendre garde et suivre les directives correspondantes pour éviter le danger. Les consignes de sécurité présentées ci-après ne font que résumer l'information contenue dans les Normes de sécurité principales, et dans le Guide d'utilisation de la source de courant de soudage. Lire et suivre toutes les Normes de sécurité.

 L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées. Une personne qualifiée est définie comme celle qui, par la possession d'un diplôme reconnu, d'un certificat ou d'un statut professionnel, ou qui, par une connaissance, une formation et une expérience approfondies, a démontré avec succès sa capacité à résoudre les problèmes liés à la tâche, le travail ou le projet et a reçu une formation en sécurité afin de reconnaître et d'éviter les risques inhérents.

 Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.



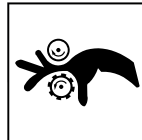
UN CHOC ÉLECTRIQUE peut tuer.

- Porter toujours des gants secs et isolants.
- S'isoler de la pièce et de la terre.
- Ne jamais toucher une électrode ou des pièces électriques sous tension.
- Ne stockez pas et n'utilisez pas l'équipement dans de l'eau stagnante.
- Remplacer les pistolets ou câbles de soudage qui sont endommagés, usés ou craquelés.
- Mettre la source du courant de soudage avant de remplacer un bec contact ou des pièces de pistolet.
- S'assurer que tous les couvercles et poignées sont fermement assujettis.



LES FUMÉES ET LES GAZ peuvent être dangereux.

- Garder la tête hors des fumées.
- Aérer la zone de travail ou porter un appareil respiratoire. Pour déterminer la bonne ventilation, il est recommandé de procéder à un prélèvement pour la composition et la quantité de fumées et de gaz auxquelles est exposé le personnel.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyants, les consommables, les produits de refroidissement, les dégraissants, les flux et les métaux.



Les PIÈCES MOBILES peuvent causer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



Le SOUDAGE peut provoquer un incendie ou une explosion.

- Ne pas souder à proximité de matériaux inflammables.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les Normes de Sécurité).
- Attention aux risques d'incendie: garder un extincteur à proximité.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyants, les consommables, les produits de refroidissement, les dégraissants, les flux et les métaux.



LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz comprimé en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

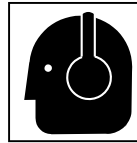
- Portez un casque de soudage approuvé muni de verres filtrants appropriés pour protéger visage et yeux contre les rayons et les étincelles d'arc pendant le soudage ou la surveillance (voir ANSI Z49.1 et Z87.1 énumérés dans les Normes de Sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.

- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter une protection corporelle en cuir ou des vêtements ignifuges (FRC). La protection du corps comporte des vêtements sans huile, comme des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.



LES PIÈCES CHAUDES peuvent provoquer des brûlures.

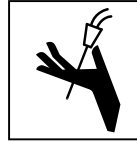
- Laisser refroidir le pistolet avant de le toucher.
- Ne pas toucher d'objets métalliques chauds.
- Abriter les objets métalliques contre tout contact par les personnes à proximité.



Le BRUIT peut endommager l'ouïe.

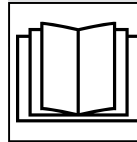
Le bruit des processus et des équipements peut affecter l'ouïe.

- Vérifier si les niveaux de bruit excèdent les limites spécifiées par l'OSHA.
- Utiliser des bouches-oreilles ou des serre-tête antibruit approuvés si le niveau de bruit est élevé.
- Avertir les personnes à proximité au sujet du danger inhérent au bruit.



LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Éloigner les mains et le corps de la buse du pistolet après avoir appuyé sur la gâchette.



LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque

section.

- N'utiliser que des pièces de remplacement provenant du fabricant.
- Effectuer l'installation, l'entretien et toute intervention selon les manuels d'utilisateurs, les normes nationales, provinciales et de l'industrie, ainsi que les codes municipaux.

2-3. Proposition californienne 65 Avertissements



AVERTISSEMENT – Ce produit peut vous exposer à des produits chimiques tels que le plomb, reconnus par l'État de Californie comme cancérigènes et sources de malformations ou d'autres troubles de la reproduction.

Pour plus d'informations, consulter www.P65Warnings.ca.gov.

2-4. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: www.aws.org.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: safetysupply.com.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csa-group.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

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2-5. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant issu d'un soudage à l'arc (et de procédés connexes, y compris le soudage par points, gouge à l'arc, le découpage plasma et les opérations de chauffage par induction) crée un CEM autour du circuit de soudage. CEM produits peuvent causer interférence à certains implants médicaux, p. ex. les stimulateurs cardiaques. Des mesures de protection pour les porteurs d'implants médicaux doivent être prises, par exemple, des restrictions d'accès pour les passants ou une évaluation individuelle des risques pour les opérateurs. Tous les opérateurs doivent appliquer les procédures suivantes pour minimiser l'exposition aux CEM provenant du circuit de soudage:

1. Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.
2. Ne pas se tenir au milieu des câbles. Disposer les câbles d'un côté et à distance de l'opérateur.

3. Ne pas courber et ne pas entourer les câbles autour de votre corps.
4. Maintenir la tête et le torse aussi loin que possible du matériel du circuit de sortie.
5. Connecter la pince sur la pièce aussi près que possible à l'arc.
6. Ne travaillez pas à côté, ne vous asseyez pas ou ne vous appuyez pas sur, et ne transportez pas le générateur ou d'autres équipements pendant l'opération.

En ce qui concerne les implants médicaux :

Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gouge à l'arc, du découpage plasma ou de chauffage par induction. Si votre médecin l'a autorisé, suivez les procédures ci-dessus.

SECTION 3 – SPECIFICATIONS

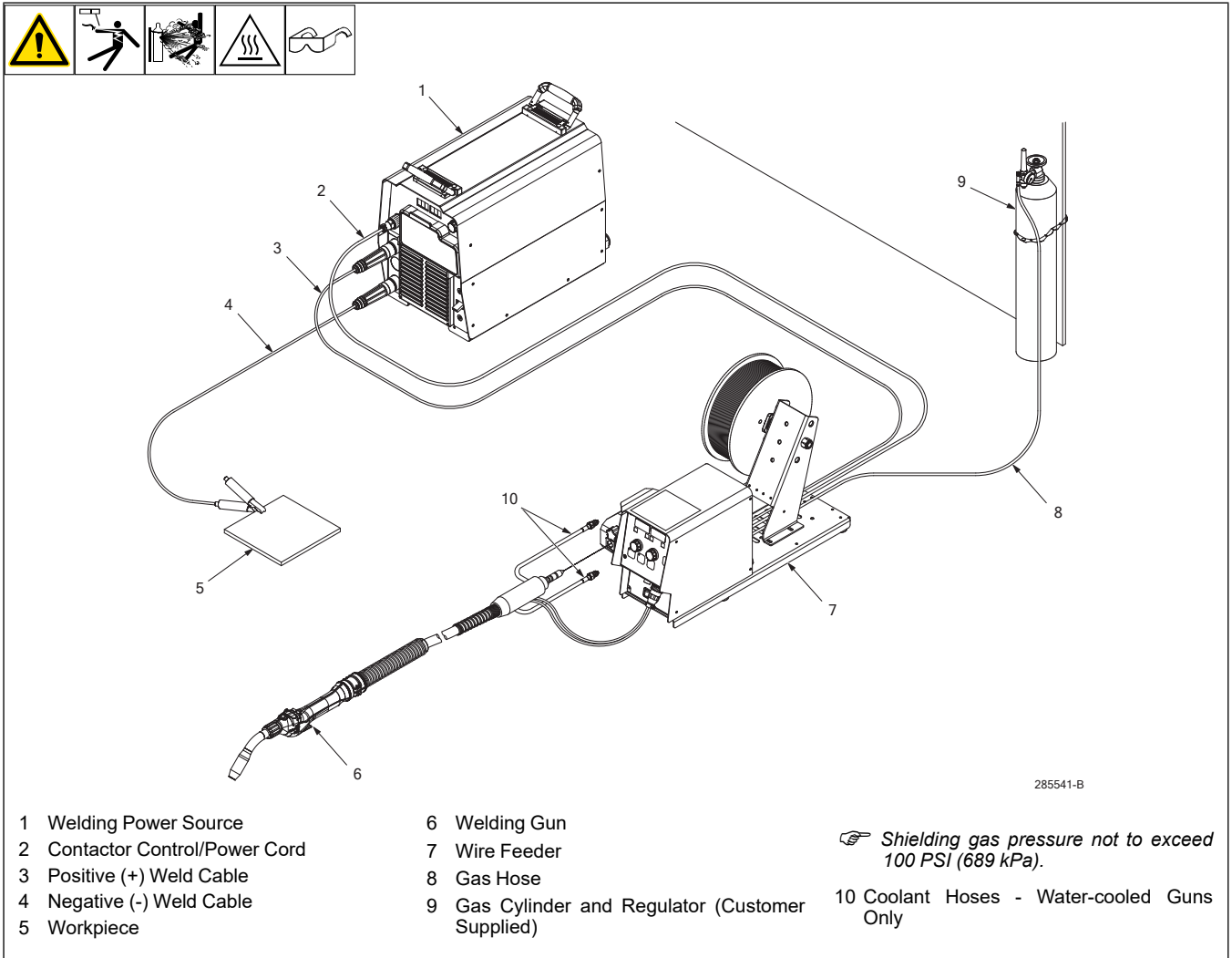
3-1. Specifications

Model	Welding Output Range	Electrode Wire Diameter Capacity	Wire Feed Speed Range	Net Weight (Torch Only)
XR-A Aluma-Pro CB 15 ft (4.7 m)	300 A at 100% Duty Cycle	.030 to 1/16 in. (0.8 to 1.6 mm) Aluminum wire	70 to 900 ipm (1.8 to 23 mpm)	2.7 lb (1.2 kg) (without cables)
XR-W Aluma-Pro CB 15 ft (4.7 m)	400 A at 100% Duty Cycle	.030 to 1/16 in. (0.8 to 1.6 mm) Aluminum wire	70 to 900 ipm (1.8 to 23 mpm)	2.7 lb (1.2 kg) (without cables)

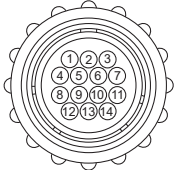
 When using 1/16 in. (1.6 mm) wire, Kit 003049 must be installed.

SECTION 4 – INSTALLATION

4-1. Equipment Connection Diagram—Single Feeder

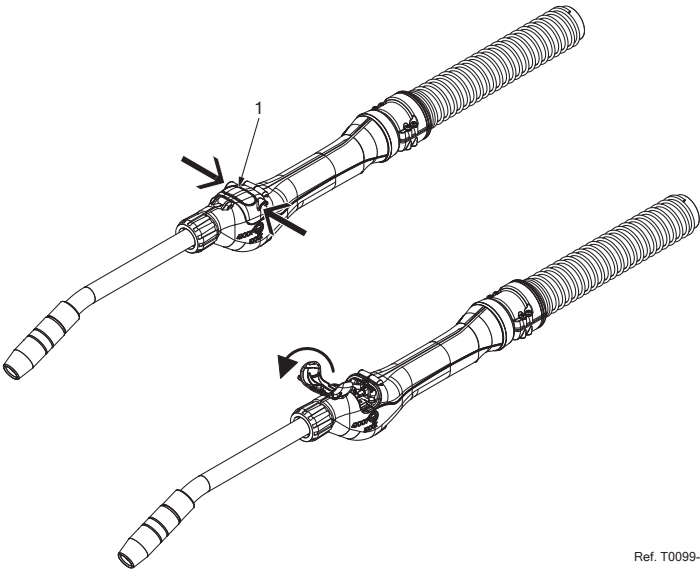


4-2. 14-Pin Plug Information For Connecting Wire Feeder To Power Source

Remote 14	Pin	Pin Information
	1	Motor 0 to +24 volts DC with respect to pin 2
	2	Motor common
	3	+5 volts DC tachometer power
	4	Tachometer reference
	5	Tachometer signal
	6	Trigger (Not Used)
	7	Trigger (Not Used)
	8	+5 volts DC wire speed reference (Not Used)
	9	Wire speed common (Not Used)
	10	Wire speed 0 to +5 volts DC with respect to pin 9 (Not Used)
	11	Gun sensing resistor with respect to pin 9
	12	Not used
	13	Not used
	14	Not used

4-3. Opening Top Cover Of XR-Aluma-Pro CB Gun





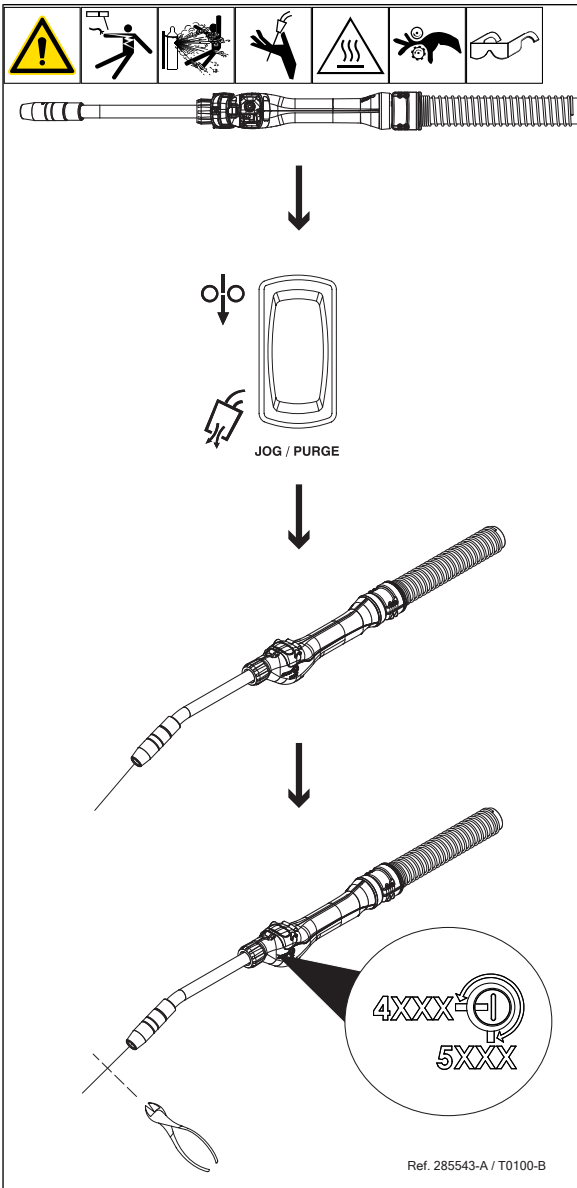
1 Top Cover

Squeeze sides of cover and lift up as shown.

To close cover, pivot cover closed on gun, and push cover down until cover locks tight.

Ref. T0099-B

4-4. Threading Welding Wire Through Gun



Refer to wire feeder manual for instructions on feeding wire through feeder.

☞ Turn OFF coolant supply before threading wire through gun.

☞ Be sure that contact tip, liner, and drive rolls are correct for wire size and type. See Parts List to change parts as needed.

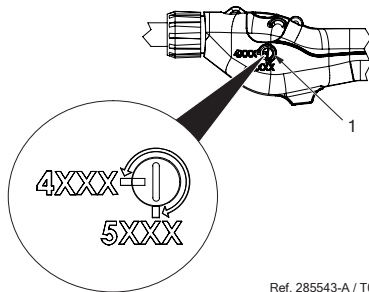
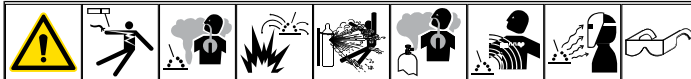
Lay gun cable out straight. Press Jog switch until about 6 in. (152 mm) of wire is sticking out end of contact tip.

Cut off wire. Close and latch wire feeder door.

Verify pressure adjustment on handle matches the wire type. See Section [5-1](#).

SECTION 5 – OPERATION

5-1. Gun Pressure Roll Tension Setting



☞ *Aluminum series specific - Pressure roll tension setting ensures smooth wire feeding action.*

☞ *Gun Pressure Roll Tension is factory set to 4XXX.*

1 Pressure Roll Adjustment Screw

Wire tension should be set to 4XXX for 4000 series aluminum wire.

Rotate Pressure Roll Adjustment Screw fully counterclockwise until indicator line on adjustment knob lines up with indicator line on handle in the 4XXX position.

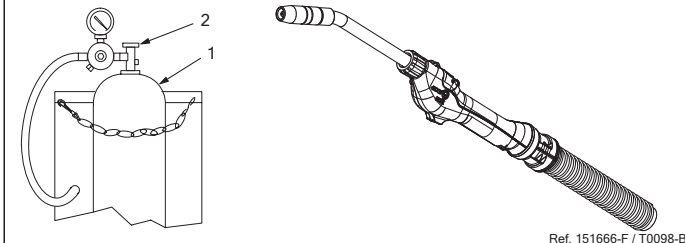
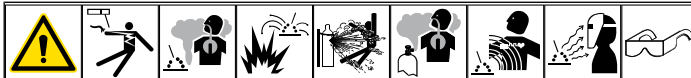
Wire tension should be set to 5XXX for 5000 series aluminum and stainless wire.

Rotate Pressure Roll Adjustment Screw fully clockwise until indicator line on adjustment knob lines up with indicator line on handle in the 5XXX position.

☞ *Small diameter (.035) 5000 series wire may run better on the 4XXX setting.*



5-2. Shielding Gas



1 Shielding Gas Cylinder

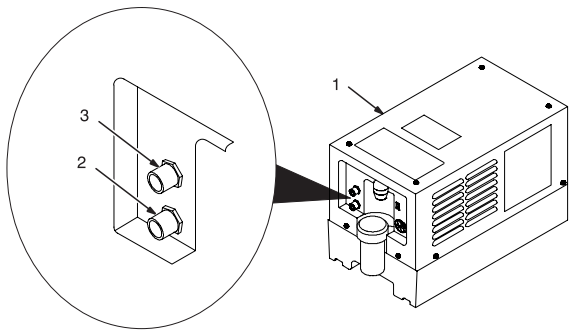
2 Valve

Open valve on cylinder just before welding.

Weld output and gas flow on and off controlled by robot.

Close valve on cylinder when finished welding.

5-3. Coolant Supply For Water-Cooled Models Only



Ref. 150755-A

Do not loosen head tube with cooler running.

- 1 Coolant Supply
- 2 Coolant "In"
- 3 Coolant "Out"

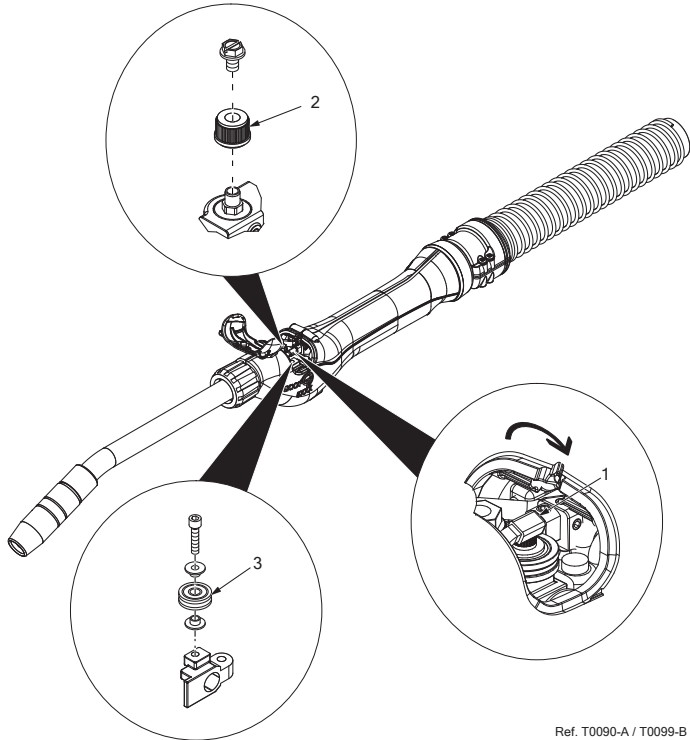
See table for coolant guidelines.

Turn On coolant supply before welding.

Turn Off coolant supply when finished welding.

Application	GMAW Or Where Coolant Contacts Aluminum Parts Or Where HF* Not Used	Requirement of Coolant Supply (Water-Cooled Models Only)
Coolant	Miller Aluminum Protecting Coolant No. 043809* Distilled Or Deionized Water OK Above 32°F (0°C)	Minimum flow rate: 0.3 G/min (1.14 L/min) Minimum inlet pressure: 40 psi (276 kPa) Maximum inlet pressure: 70 psi (483 kPa) Minimum cooling power: 6820 BTU/hr (2 kW)
*MILLER coolants protect to -37°F (-38°C) and resist algae growth.		

5-4. Gun Drive Assembly Maintenance



Ref. T0090-A / T0099-B

- 1 Lever Arm

Using lever arm open pressure roll with bearing as shown. Push forward to lock in place.

Retract wire onto spool.

- 2 Drive Roll

Use wire brush to clean drive roll. Install drive roll with hex opening down toward shaft hex, and secure with screw.

- 3 Pressure Roll

Thread welding wire through gun. Engage feeder drive rolls. Press jog switch until wire is sticking out end of contact tip.

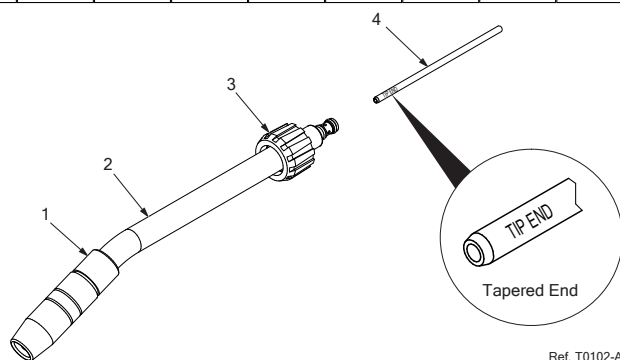
When changing wire size change feeder drive rolls and guides to match wire size and type. See wire feeder owners manual for details.

Close top cover.

7/64, 1/16 in.

3/8 in.

5-5. Replacing Head Tube Liner



☞ Turn OFF coolant supply before removing head tube on water-cooled gun.

The standard head tube liner (yellow) will accommodate wire diameters from 3/64 in.- 1/16 in. wire size.

When changing wire size, change feeder drive roll and idler.

- 1 Nozzle Insulator
- 2 Head Tube
- 3 Head Tube Nut

Loosen head tube nut and remove head tube from gun.

- 4 Head Tube Liner

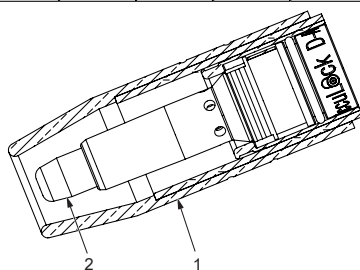
Pull liner out of head tube.

Insert new liner into head tube (install tapered end first) and reinstall head tube onto gun.

☞ A twisting motion may be needed to feed liner thru head tube.

NOTICE – Be sure head tube is seated and head tube nut is securely tightened before operating gun. If head tube nut is not adequately tightened, unwanted arcing may occur between head tube and gun housing.

5-6. Changing Gun Contact Tip



- 1 Nozzle

Unscrew nozzle.

- 2 AccuLock Contact Tip

Remove contact tip.

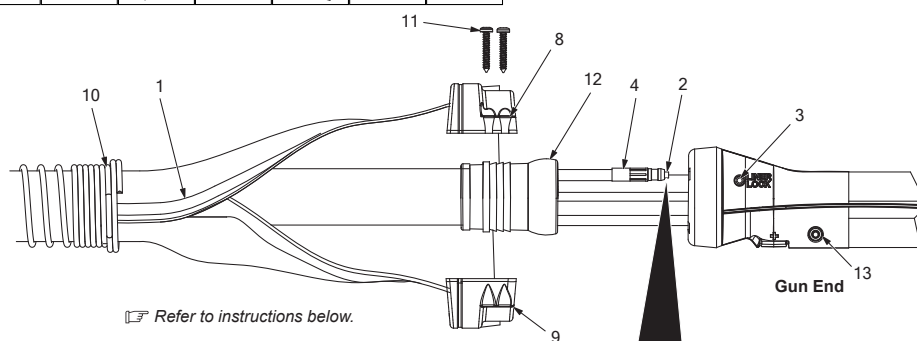
Install new contact tip.

NOTICE – Make sure correct size contact tip is being used. Incorrect size may cause arcing inside tip, poor feedability and poor arc starting characteristics (see Section 8).

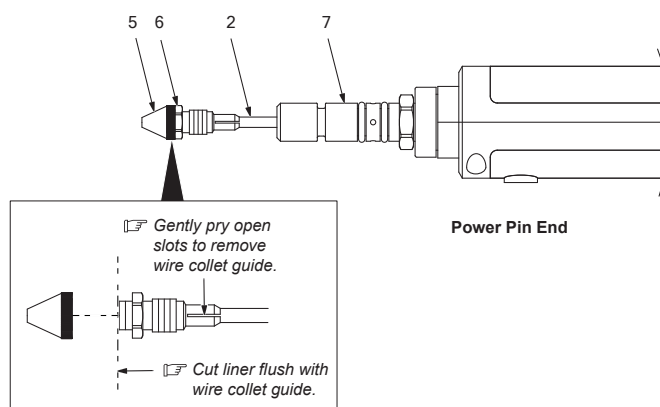
☞ AccuLock contact tips designed for aluminum wire have AL (Example T-A047AL) as a designator at the end of the part number.

Reinstall nozzle.

5-7. Replacing The Gun Liner



Remove Old Liner (Item 2) From Gun End →
Install New Liner (Item 2) Into Gun End ←



Ref. T0080B

⚠ Turn Off welding power source and wire feeder.

- 1 Cable Cover Jacket
- 2 Liner
- 3 Liner Lock Allen Screw
- 4 Liner Guide Reducer
- 5 Wire Guide Cone
- 6 Wire Collet Guide
- 7 Power Pin
- 8 Clasp Assembly Top
- 9 Clasp Assembly Bottom
- 10 Strain Relief
- 11 Screws (4)
- 12 Ball Swivel Hose Assembly
- 13 Screw

Lay gun cable out straight.

Remove screws (4) holding clasps (top and bottom) and separate halves.

Pull strain relief away from gun end.

Separate Velcro cable jacket approximately 12 inches to expose internals of cable.

Loosen screw (Item 13).

Pull back ball swivel assembly to greater expose internals.

Loosen liner lock allen screw (located near back of handle) to remove liner guide reducer from gun.

Remove wire guide cone and wire collet guide from power pin.

Remove old liner from gun end (see illustration above).

Insert new liner into gun end and continue feeding liner through cable assembly until

liner is through power pin assembly and invisible.

Install liner assembly into gun and firmly tighten (do not over tighten) liner lock allen screw.

Reinstall wire collet guide at power pin and tighten onto liner.

Cut liner off flush with wire collet guide. Reinstall wire guide cone.

Reinstall all components in reverse order as disassembled.

Torque screws (4) to 20 in. lb holding clasps (top and bottom) assembly.

See Section 4-4 for instructions on rethreading wire.

5-8. Duty Cycle And Overheating



Air-Cooled Models

100% Duty Cycle At 300 Peak Amperage Using 100% Argon Gas w/15 Foot Guns



Continuous Welding

Water-Cooled Models

100% Duty Cycle At 400 Peak Amperage Using 100% Argon Gas w/15 Foot Guns



Continuous Welding

Duty Cycle is percentage of 10 minutes that unit can weld at rated load without overheating.

NOTICE – Exceeding duty cycle can damage unit and void warranty.

SECTION 6 – MAINTENANCE AND TROUBLESHOOTING

6-1. Routine Maintenance For Aluminum Push/Pull Guns

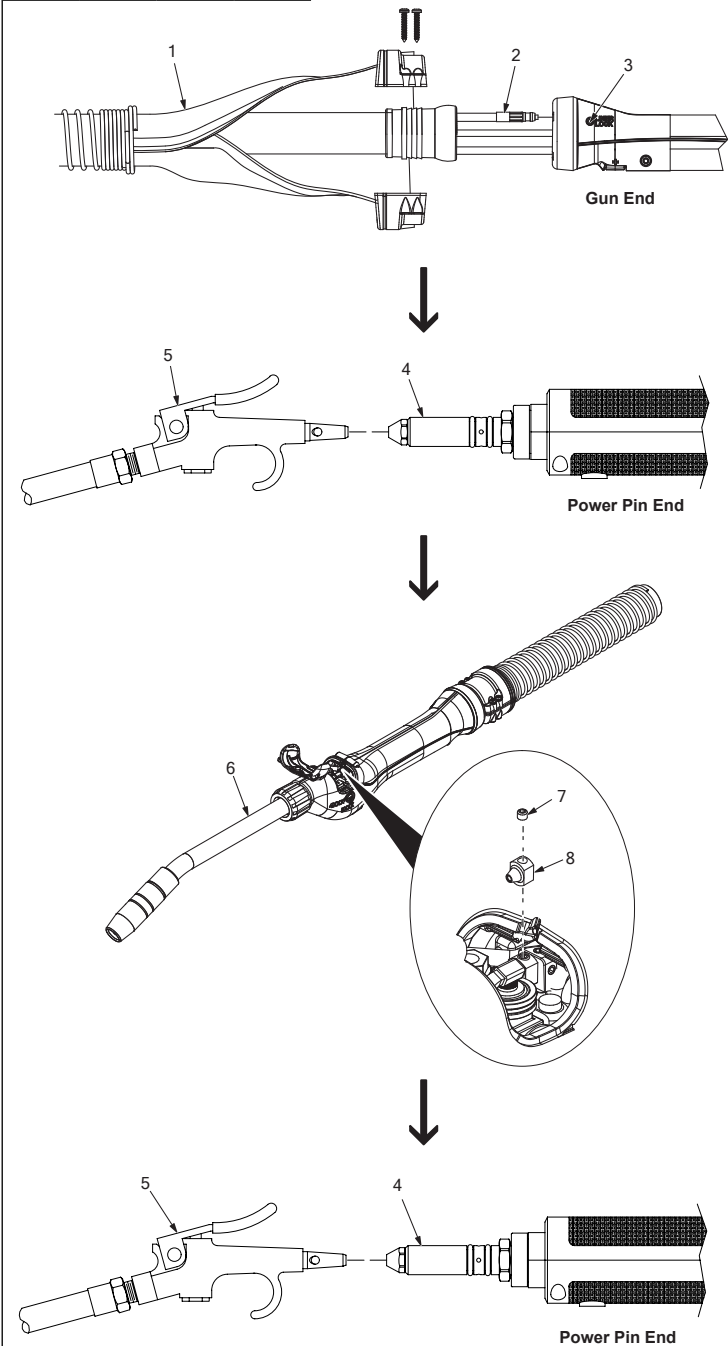


 **Disconnect power before maintaining.**

 *Service equipment more often if used in severe conditions.*

Maintenance Schedule		Daily	Weekly	Every Spool of Wire	Every 3 Months	Reference Section
Head Tube Liner and Drive Casting	Visually check condition of head tube liner and drive casting. Clean if needed. Replace if damaged.	.				5-5
Drive Rolls	Visually check condition of drive rolls and clean as needed.		.			
Nozzle/Contact Tip	Visually check condition of nozzle/contact tip. Clean as needed. Replace if damaged.			.		
Gun Casing	Clean gun casing			.		
Gun Liner	Visually check condition of gun liner. Clean as needed. Replace if damaged.			.		6-2
Labels	Check and replace labels if damaged.				.	
Weld Terminals	Clean weld terminals.				.	
Weld Cable	Visually check condition of weld cable. Replace if damaged.				.	
14-Pin Cord	Visually check condition of 14-pin cord. Replace if damaged.				.	
Gas Hoses and fittings	Visually check condition of gas hoses and fittings. Replace damaged hoses and fittings.				.	
Gun Cable	Visually check condition of gun cable. Replace if damaged.				.	

6-2. Cleaning Gun Liner



Ref. T0080-B / T0099-B

⚠ Turn Off welding power source and wire feeder.

NOTICE – Clean gun liner before cleaning stainless tube and inlet guide.

Lay gun cable out straight.

1 Cable Cover Jacket

Remove cable cover jacket as described in Section 5-7 to access liner assembly.

2 Liner Guide Reducer

3 Liner Lock Allen Screw

4 Power Pin

5 Air Nozzle

Loosen liner lock allen screw (located near back of handle) to remove liner guide reducer from gun.

Blow air from power pin end through liner until clean of debris.

Reinstall liner assembly into gun and firmly tighten (do not overtighten) liner lock allen screw when finished cleaning.

NOTICE – Do not overtighten liner lock allen screw.

6 Top Cover

7 Set Screw (Inlet Guide)

8 Inlet Guide

Remove inlet guide. From power pin end, blow air through liner and stainless tube until free of debris.

Reinstall inlet guide.

6-3. Troubleshooting Table

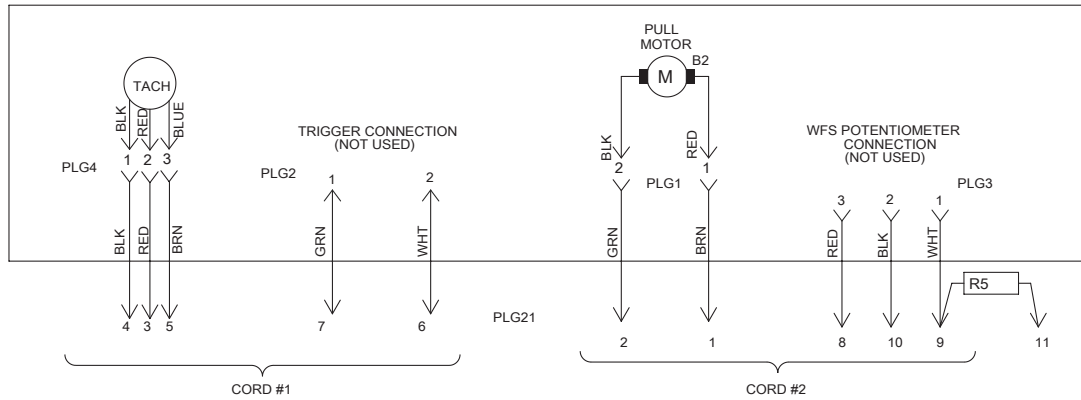


⚠ Disconnect power before troubleshooting.

Trouble	Remedy
No wire feed at gun, feeder not operating. Check motor or brake solenoid.	Reset circuit breaker at power source. See power source owner's manual.
No wire feed at gun, feeder operating properly.	Reset circuit breaker in feeder/control box and check for short in motor leads. See feeder/control owner's manual. Check motor wires for continuity.

Trouble	Remedy
	See feeder/control owner's manual.
Wire feeds, but welding wire is not energized.	Clean and tighten all power connections.
	See feeder/control owner's manual.
	Check operation of welding power source.
Wire feeds erratically.	Check conduit for wear and obstruction and replace if necessary.
	Check contact tip for correct size and replace if necessary.
	Check pressure roll tension setting (see Section 5-1).
	Check for proper head tube liner (see Section 8).
Wire feeds one speed only.	See feeder/control owner's manual.
Welding wire is not energized. Shielding gas does not flow.	Secure plug from gun control cable into gun control receptacle on feeder.
	Have nearest Factory Authorized Service Agent check optional water flow switch, if applicable.
Wire feeds, shielding gas flows, but welding wire is not energized.	See Troubleshooting section in welding power source manual.

SECTION 7 – ELECTRICAL DIAGRAMS



M1842-A

Figure 7-1. Circuit Diagram For XR-Aluma-Pro CB Gun

SECTION 8 – PARTS LIST

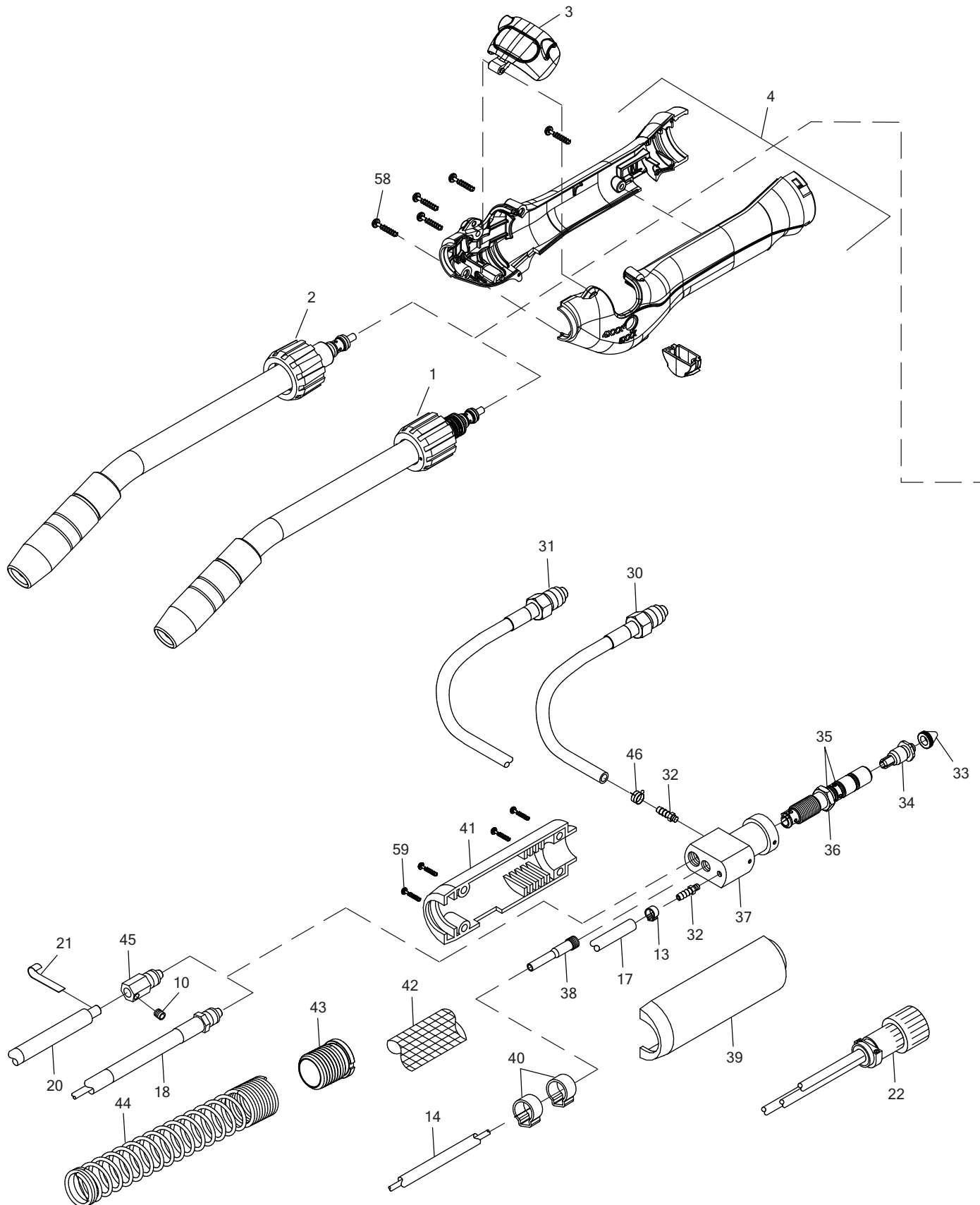
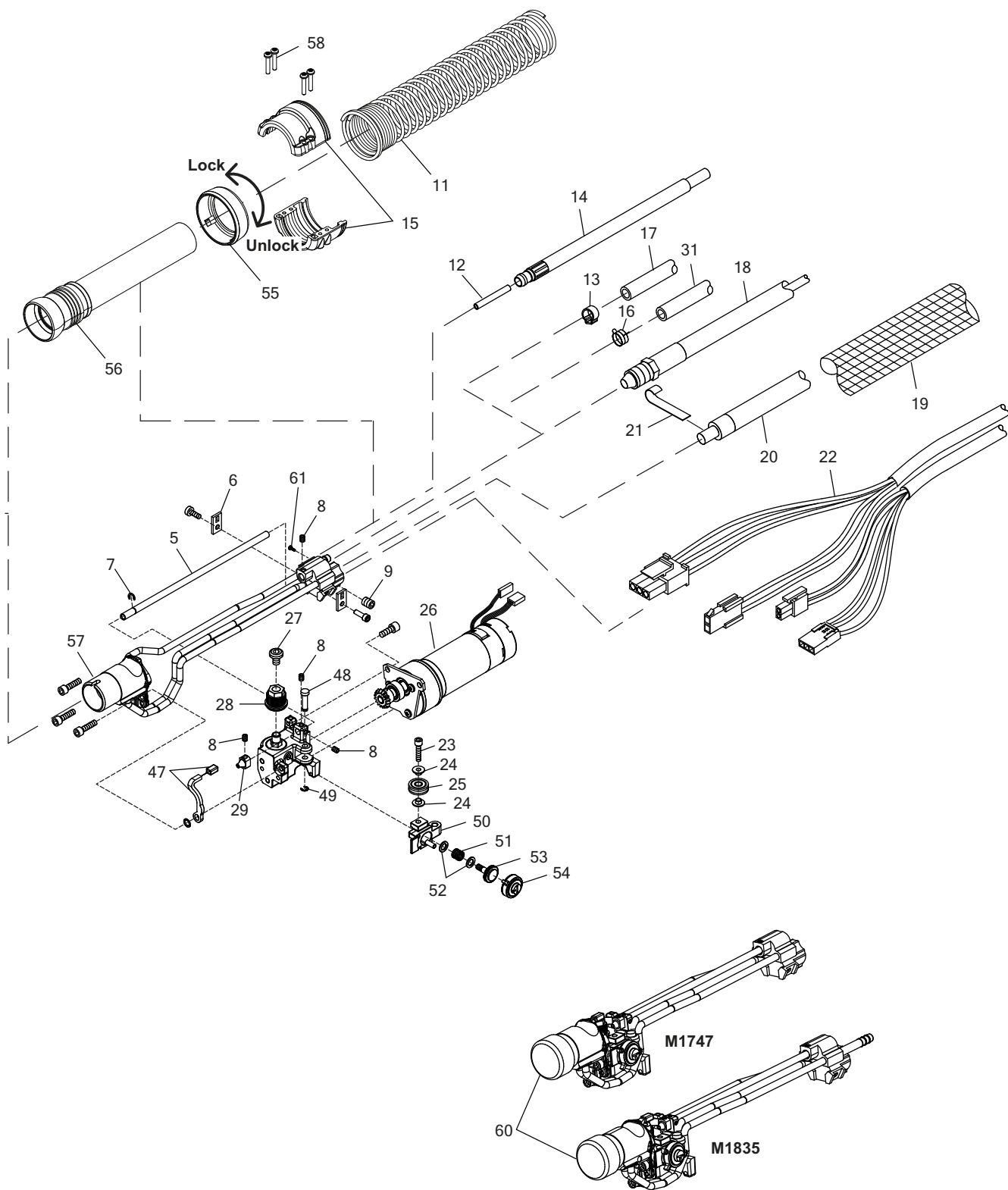


Figure 8-1. Exploded View Of XR-Aluma-Pro CB Gun



Ref. T0116-B

Figure 8-1. Exploded View Of XR-Aluma-Pro CB Gun

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
1		M1748	Head Tube Assy CB, Water Cooled (22 Degree)	1
2		M1833	Head Tube Assy CB, Air (22 Degree)	1
3		227403	Cover, W/Spring Plunger (Includes)	1
		187316	—Label, Pinch Wordless	1
4		M1637	Handle Assembly, Left/Right	1
5		M1646	Tube, Liner Stainless	1
6		254701	Clamp, Cable Stl	2
7		M1476	Clip, C, Retaining 0.1875 Dia Shaft	1
8		135126	Screw, Set # 6-32x .12 Cup Pt Sch Stl Pln	4
9		237515	Screw, Set 250-20X .37 Conept Sch Stl W/Nyl Patch	1
10		M1500	Screw, Set 312-18X .31 Conept Sch Stl Pln Nylok	1
11		M1854	Strain Relief, Spring AP	1
12		229887	Liner, Replacement 15 Ft	1
13		357-2	Clamp, Oetiker	2
14		M1658	Kit, Conduit Monocoil 15 Ft	1
15		M1857	Clasp, Top—Bottom, Gen 2	1
16		237864	Clamp, Hose .375 - .450 Clp Dia Slftng Green W/Shortened Middle Tab	1
17		M1720	Hose, Gas 15 Ft	1
18		M1860	Cable, Power/Water Out 15 Ft	1
19		M1681	Kit, Cable Cover W/Velcro 15 Ft	1
20		M1531	Cable, Power 15 Ft (Air)	1
21		235225	Strip, Cop .010 X 1.500 X .750	2
22		M1729	Cable, Control 15 Ft	1
23		231443	Screw, 006-32x .44 Soc Hd-Hex Gr8 Pld Lkg Patch	1
24		134624	Washer, Shldr.140id 0.187odx.094t .375odx.031t Nyl	2
25		227439	Drive Roll Assy, Idler .645 Od	1
26		M1727	Drive Motor Assy, Replacement AlumaPro Plus Guns	1
27		226588	Screw, 010-32x .37 Btn Hd-Soc Sst Lkg Patch	1
28		227434	Drive Roll, Knurled	1
29		227408	Guide, Inlet	1
30		196177	Hose, Water Out 10 In	1
31		191072	Hose, Water In 15 Ft	1
32		202513	Ftg, Hose Brs Barbed M 3/16 Tbg X .250-20	2
33		M1102	Guide, Cone Outlet	1
34		229852	Guide, Collet Outlet .030-1/16	1
35		079974	O-Ring, .500 Id X .103 Cs Rbr	2
36		193896	Pin, Power Assembly	1
37		187029	Connector, Power/Gas	1
38		203539	Fitting, Liner Double Wound Adapter	1
39		189811	Housing, Power Pin Lh	1
40		149332	Clamp, Hose .405 - .485 Clp Dia Slftng Olive Dra	2
41		189812	Housing, Power Pin Rh	1
42		227449	Jacket, Cable 3 Ft 4 In (Power Pin)	1
43		203560	Strain Relief, Spring Retainer	1
44		246119	Spring, Strain Relief	1
45		M1501	Ftg, Connection Power Weld	1
46		089120	Clamp, Hose .375 - .450 Clp Dia Slftng Green	1
47		227405	Lever, Pressure Arm	1
48		227420	Pin, Pressure Arm	1
49		191088	Ring, Rtng Ext .125 Shaft X .015 Thk E Style	1

Figure 8-1. Exploded View Of XR-Aluma-Pro CB Gun

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
50		227435	Arm, Pressure (Machined)	1
51		227421	Spring, Cprsn .360 Od X .059 Wire X .440 Free	1
52		229850	Washer, Pressure Arm Precision	2
53		229849	Shaft, Pressure Arm Brs	1
54		229851	Nut, Pressure Arm Plastic	1
55		M1639	Rear, Ring	1
56		M1858	Ball, Swivel Sleeve Assembly	1
57		M1746	Keyed Brazed Assembly (Air)	1
57		M1834	Keyed Brazed Assembly (Water)	1
58		217934	Screw, K40x 20 Pan Hd-Trx Stl Pld Pt Thread Forming	9
59		145217	Screw, K40x 12 Pan Hd-Phi Stl Pld Pt Thread Forming	4
60		++M1747	Keyed Drive Assy, Replacement Air	1
60		++M1835	Keyed Drive Assy, Replacement Water	1
61		227413	Screw, 006-32x .37 Soc Hd-Hex Gr8 Pld Lkg Patch	1

 *Hardware is common and not available unless listed.*

++ Drive assemblies include drive housing, pressure arm, pressure arm pin, pressure arm lever, power block assy, drive shaft assy, pressure arm shaft, tube liner, O-ring, set screws, and springs.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

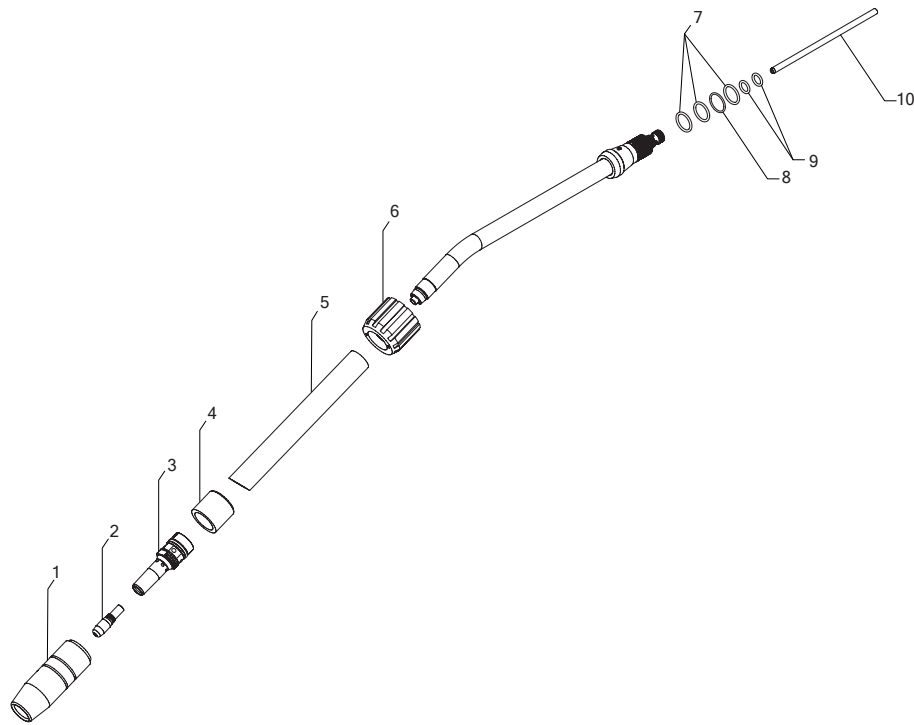


Figure 8-2. (Water) Head Tube Assembly Of XR-Aluma-Pro CB Gun

Figure 8-2. (Water) Head Tube Assembly Of XR-Aluma-Pro CB Gun

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
		M1833	Head Tube Assy CB, Water Cooled (22 Degree) (Includes)	1
1		*401-6-62	—Nozzle, AccuLock Copper 5/8 in. Recess 1/8 in.	1
2		*T-A047AL	—AccuLock Contact Tip 3/64 in. (1.2mm) (10 pack)	1
3		*D-ATSH	—Diffuser, AccuLock R D-ATSH	1
4		*4323R	—Insulator, Nozzle	1
5		*M1833-4	—Insulator, Outer Water (22 Degree)	1
6		229889	—Nut, Headtube Rotation Water	1
		230970	Kit, Replacement O-Rings Head Tube Water (Includes)	1
7		194261	—O-Ring, .551 Id X .070 Cs 70 Duro Buna-n	3
8		210771	—O-Ring, 14.99mm Id X 1.27mm Cs 70 Duro Buna-n	1
9		191191	—O-Ring, .312 Id X .070 Cs 70 Duro Buna-n	2
10		M1749	—Liner, Teflon .047 .062 Wire	1
10		M1856	—Liner, Teflon .030—.035 Wire	1

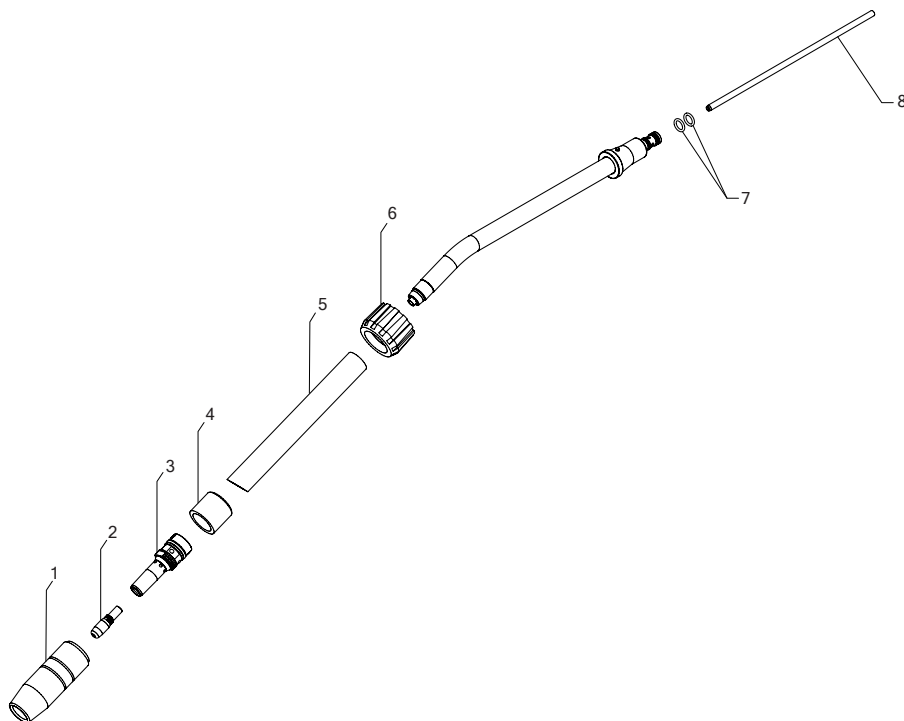
Hardware is common and not available unless listed.

*Recommended Spare Parts

For more consumable options, refer to AccuLock R consumables at www.bernardtregaskiss.com.

BE SURE TO PROVIDE MODEL WHEN ORDERING REPLACEMENT PARTS.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.



T0105-A

Figure 8-3. (Air) Head Tube Assembly Of XR-Aluma-Pro CB Gun

Figure 8-3. (Air) Head Tube Assembly Of XR-Aluma-Pro CB Gun

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
		M1748	Head Tube Assy CB, Air (22 Degree) (Includes)	1
1		*401-6-62	—Nozzle, AccuLock Copper 5/8 in. Recess 1/8 in.	1
2		*T-A047AL	—AccuLock Contact Tip 3/64 in. (1.2mm) (10 pack)	1
3		*D-ATSH	—Diffuser, AccuLock R D-ATSH	1
4		*4323R	—Insulator, Nozzle	1
5		*M1748-4	—Insulator, Outer Air (22 Degree)	1
6		227168	—Nut, Headtube Rotation	1
		230969	Kit, Replacement O-Rings Head Tube Air (Includes)	1
7		191191	—O-Ring, .312 Id X .070 Cs 70 Duro Buna-n	2
8		M1749	—Liner, Teflon .047 .062 Wire	1
8		M1856	—Liner, Teflon .030—.035 Wire	1

 Hardware is common and not available unless listed.

*Recommended Spare Parts

 For more consumable options, refer to AccuLock R consumables at www.bernardtregaskiss.com.

BE SURE TO PROVIDE MODEL WHEN ORDERING REPLACEMENT PARTS.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

SECTION 9 – DEFINITIONS

9-1. Additional Safety Symbol Definitions

 Some symbols are found only on CE products.

	Warning! Watch Out! There are possible hazards as shown by the symbols.
	Do not discard product (where applicable) with general waste. Reuse or recycle Waste Electrical and Electronic Equipment (WEEE) by disposing at a designated collection facility. Contact your local recycling office or your local distributor for further information.

9-2. Miscellaneous Symbols And Definitions

A	Amperes	%	Percent	IP	Degree of Protection
V	Volts	Hz	Hertz		Jog
	Alternating Current		Output		Purge
X	Duty Cycle		Increase	I₁	Primary Current
	Wire Feed	U₁	Primary Voltage		Water (Coolant) Output
	Water (Coolant) Input	I₂	Rated Current		

SECTION 10 – REGULATORY AND COMPLIANCE INFORMATION

10-1. Software Licensing Agreement

The End User License Agreement and any third-party notices and terms and conditions pertaining to third-party software can be found at <https://www.millerwelds.com/eula> and are incorporated by reference herein.

10-2. Information About Default Weld Parameters And Settings

NOTICE – Each welding application is unique. Although certain Miller Electric products are designed to determine and default to certain typical welding parameters and settings based upon specific and relatively limited application variables input by the end user, such default settings are for reference purposes only; and final weld results can be affected by other variables and application-specific circumstances. The appropriateness of all parameters and settings should be evaluated and modified by the end user as necessary based upon application-specific requirements. The end user is solely responsible for selection and coordination of appropriate equipment, adoption or adjustment of default weld parameters and settings, and ultimate quality and durability of all resultant welds. Miller Electric expressly disclaims any and all implied warranties including any implied warranty of fitness for a particular purpose.

10-3. Environmental Specifications

A. IP Rating

IP Rating
IP3X
This equipment is designed for indoor use and is not intended to be used or stored outside.

B. Temperature Specifications

Operating Temperature Range	Storage/Transportation Temperature Range
14 to 104°F (-10 to 40°C)	-4 to 131°F (-20 to 55°C)

DECLARATION OF CONFORMITY



for European Community (CE marked) products.

MILLER Electric Mfg. LLC, 1635 Spencer Street, Appleton, WI 54914 U.S.A. declares that the product(s) identified in this declaration conform to the essential requirements and provisions of the stated Council Directive(s), Commission Regulation(s) and Standard(s).

Product/Apparatus Identification:

Product	Stock Number
XR-Aluma-Pro™ CB 15W	301912

Council Directives and Commission Regulations:

- 2014/35/EU Low voltage
- 2011/65/EU and amendment 2015/863 Restriction of the use of certain hazardous substances in electrical and electronic equipment

Standards:

- EN IEC 60974-7:2019 Arc welding equipment – Part 7: Torches
- EN IEC 63000:2018 Technical documentation for the assessment of electrical and electronic products with respect to the restriction of hazardous substances

Signatory:

A handwritten signature in black ink, appearing to read "David A. Werba", written over a horizontal line.

January 12, 2026

David A. Werba
MANAGER, PRODUCT DESIGN COMPLIANCE

Date of Declaration



DECLARATION OF CONFORMITY

For United Kingdom (UKCA marked) products.

MILLER Electric Mfg. LLC, 1635 West Spencer Street, Appleton, WI 54914 U.S.A. declares that the product(s) identified in this declaration conform to the essential requirements and provisions of the stated Regulation(s) and Standard(s).

Product/Apparatus Identification:

Product	Stock Number
XR-Aluma-Pro™ CB 15W	301912

Regulations:

- S.I. 2016/1101 Electrical Equipment (Safety) Regulations 2016
- S.I. 2012/3032 Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations

Standards:

- EN IEC 60974-7:2019 Arc welding equipment – Part 7: Torches
- EN IEC 63000:2018 Technical documentation for the assessment of electrical and electronic products with respect to the restriction of hazardous substances

Signatory:

January 12, 2026

David A. Werba
MANAGER, PRODUCT DESIGN COMPLIANCE

Date of Declaration

Notes

Notes

Notes



Effective January 1, 2026 (Equipment with a serial number preface of NG or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY - Subject to the terms and conditions below, Miller Electric Mfg. LLC, Appleton, Wisconsin, warrants to authorized distributors that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. **THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.**

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Notifications submitted as online warranty claims must provide detailed descriptions of the fault and troubleshooting steps taken to diagnose failed parts. Warranty claims that lack the required information as defined in the Miller Service Operation Guide (SOG) may be denied by Miller.

Miller shall honor warranty claims on warranted equipment listed below in the event of a defect within the warranty coverage time periods listed below. Warranty time periods start on the delivery date of the equipment to the end-user purchaser.

1 5 Years Parts — 3 Years Labor

- Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules in non-inverter products

2 4 Years Parts (No Labor)

- Auto-Darkening ClearLight 2.0 and 4x Helmet Lenses

3 3 Years — Parts and Labor Unless Specified

- Auto-Darkening Helmet Lenses (No Labor)
- Copilot Collaborative Welding Systems
- Engine and Hydraulic Driven Welder/Generators (Including EnPak) (**NOTE: Engines are Warranted Separately by the Engine Manufacturer.**)
- Handheld Laser Power Sources
- Insight Welding Intelligence Products (Except External Sensors)
- Inverter Power Sources
- Plasma Arc Cutting Power Sources
- Process Controllers
- Semi-Automatic and Automatic Wire Feeders
- Transformer/Rectifier Power Sources

4 2 Years — Parts and Labor

- Auto-Darkening Weld Masks (No Labor)
- Fume Extractors - Filtair 215, Capture 5, Purifier, and Industrial Collector Series

5 1 Year — Parts and Labor Unless Specified

- ArcCapture Camera
- ArcReach Heater
- AugmentedArc, LiveArc, and MobileArc Welding Systems
- Automatic Motion Devices
- Bernard BTB Air-Cooled MIG Guns (No Labor)
- CoolBelt, PAPR Blower, and PAPR Face Shield (No Labor)
- Desiccant Air Dryer System

- Field Options (**NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.**)

- RFCS Foot Controls (Except RFCS-RJ45)
- Fume Extractors - Filtair 130, MWX and SWX Series, Standard, Telescopic, and ZoneFlow Extraction Arms and Motor Control Box
- Handheld Laser Torches (No Labor)
- Induction Heating Power Sources, Coolers (**NOTE: Digital Recorders are Warranted Separately by the Manufacturer.**)
- Insight Sensors
- Laser Welding Helmets (No Labor)
- Load Banks
- MDX Series MIG Guns (No Labor)
- Motor-Driven Guns
- Positioners and Controllers
- Racks (For Housing Multiple Power Sources)
- Running Gear/Trailers
- Spoolmate Spoolguns (No Labor)
- Subarc Wire Drive Assemblies
- Supplied Air Respirator (SAR) Boxes and Panels
- TIG Torches (No Labor)
- Tregaskiss Guns (No Labor)
- Venture 150 Battery (Warranted for 1 year or 1000 charge cycles, whichever comes first)
- Water Cooling Systems
- Wireless Remote Foot/Hand Controls and Receivers
- Work Stations/Weld Tables/Weld Booths (No Labor)
- XT Plasma Cutting Torches (No Labor)

6 6 Months — Parts

- 12 Volt Automotive-Style Batteries
- PAPR Batteries

7 90 Days — Parts

- Accessories (Kits)
- ArcReach Heater Quick Wrap and Air Cooled Cables
- Canvas Covers
- Induction Heating Coils and Blankets, Cables, Rolling Inductor, and Non-Electronic Controls
- M-Guns
- Subarc (SAW) Torches and External Cladding Heads
- Remote Controls and RFCS-RJ45
- Replacement Parts (No labor)

Miller's True Blue® Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or

misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

4. Defects caused by accident, unauthorized repair, or improper testing.

MILLER PRODUCTS ARE INTENDED FOR COMMERCIAL AND INDUSTRIAL USERS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

The exclusive remedies for warranty claims are, at Miller's option, either: (1) repair; or (2) replacement; or, if approved in writing by Miller, (3) the pre-approved cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon use). Products may not be returned without Miller's written approval. Return shipment shall be at customer's risk and expense.

The above remedies are F.O.B. Appleton, WI, or Miller's authorized service facility. Transportation and freight are the customer's responsibility. TO THE EXTENT PERMITTED BY LAW, THE REMEDIES HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES REGARDLESS OF THE LEGAL THEORY. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT) REGARDLESS OF THE LEGAL THEORY. ANY WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY, OR REPRESENTATION, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, ARE EXCLUDED AND DISCLAIMED BY MILLER.

Some US states do not allow limiting the duration of an implied warranty or the exclusion of certain damages, so the above limitations may not apply to you. This warranty provides specific legal rights, and other rights may be available depending on your state. In Canada, some provinces provide additional warranties or remedies, and to the extent the law prohibits their waiver, the limitations set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary by province.

Warranty Questions?

Call 1-800-4-A-MILLER for your local Miller distributor.

Your distributor also gives you...

Service

You always get the fast, reliable response you need. Most replacement parts can be in your hands in 24 hours.

Support

Need fast answers to the tough welding questions? The expertise of the distributor and Miller is there to help you, every step of the way.

Owner's Record

Please complete and retain with your personal records.

Model Name	Serial/Style Number
Purchase Date	(Date which equipment was delivered to original customer.)
Distributor	
Address	
City	
State	Zip

For Service

Contact a *DISTRIBUTOR* or *SERVICE AGENCY* near you.

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:	Welding Supplies and Consumables Options and Accessories Personal Protective Equipment (PPE) Service and Repair Replacement Parts Training (Schools, Videos, Books) Welding Process Handbooks To locate a Distributor or Service Agency visit www.millerwelds.com or call 1-800-4-A-Miller
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Contact the Delivering Carrier to:	File a claim for loss or damage during shipment. For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.
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For International Locations Visit
www.MillerWelds.com

