

# Spoolmatic® and XR-Pistol™

## Pistol-Grip Guns

MIG Guns for Aluminum Welding 

### Quick Specs

#### Heavy Industrial Applications

Emergency vehicles	Shipbuilding
Recreational vehicles	Tool boxes
Trucks and trailers	Railcars
Boat/yacht building	Fabrication
Sign manufacturers	

#### Processes

MIG (GMAW) with aluminum wire and other soft alloys  
Pulsed MIG (GMAW-P) with pulsing power source

#### Rated Output at 100% Duty Cycle

Spoolmatic: 200 A  
XR-Pistol (air-cooled): 200 A  
XR-Pistol (water-cooled): 400 A

#### Net Weight (Gun Only)

Spoolmatic: 2.9 lb. (1.3 kg)  
XR-Pistol (air-cooled): 2.2 lb. (1 kg)  
XR-Pistol (water-cooled): 2.4 lb. (1.1 kg)

**Spoolmatic spool gun** is available with 15- or 30-foot (4.6 or 9 m) cable lengths. The well-balanced industrial spool gun features a built-in gas valve, rotatable canister, and all-wire dual-groove drive roll.



**Head tubes are FasTip™ and Bernard® Centerfire™ compatible.** Head tube comes standard with FasTip consumables. (See page 4 for FasTip and optional Bernard consumables.)

**Easy access to drive assembly and removable head tube** reduces service time by allowing a simple means of changing drive rolls and head tube or performing routine maintenance without disassembly of gun.

**Quick-change, single-turn contact tip** provides excellent performance and ease of replacement.

**Wire speed on gun handle and reversible drive rolls** save time and money.

The **Spoolmatic** is designed to be used with a **WC-24** or **WC-115 weld control** or as a direct connect to select power sources. (See page 6.)

**A complete system consists of the following:**

- **Spoolmatic spool gun**  
(Includes .035–1/16 in. dual drive roll and two FasTip™ contact tips — .035 in. and 3/64 in.)
- **WC-24 or WC-115 weld control**  
(Required unless using a machine that allows direct hookup.)
- **Recommended Miller 14-pin power source, Bobcat™ 200 Air Pak™ OR select Millermatic® and Multimatic® models** (See page 6.)

**XR-Pistol push-pull gun** is available in air- or water-cooled versions with 15- or 30-foot (4.6 or 9 m) cable lengths. The replaceable feed cable liner saves time and money, while the trigger hold, when paired with the XR-AlumaFeed® SuitCase®, eliminates hand strain. Also has a full leather cable cover with full length hook-and-loop closure for easy maintenance.



**Replaceable feed cable liner** reduces parts cost and service time by allowing a simple means of removing and replacing liner and not the complete feed cable. (XR-Pistol only.)

**Trigger hold** reduces fatigue by allowing operator to weld without holding trigger. (Feature only available when XR-Pistol is paired with XR-AlumaFeed SuitCase.)



The **XR-Pistol** is designed to be used with an **XR-AlumaFeed SuitCase** as part of a push-pull system.

**A complete system consists of the following:**

- **XR-Pistol push-pull gun**
- **XR-AlumaFeed SuitCase**  
(See literature DC/34.0.)
- **Recommended Miller 14-pin power source** (See page 7.)



Guns are warrantied for one year, parts and labor.



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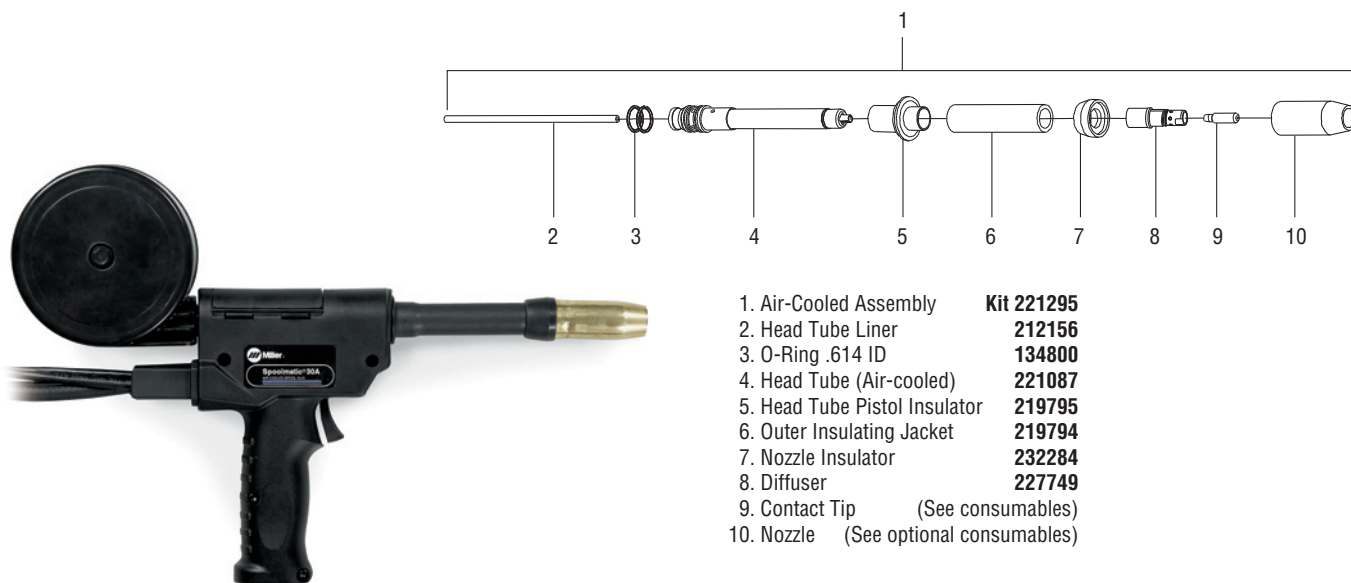


# Spoolmatic® Specifications (Subject to change without notice.)



Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Maximum Spool Size Capacity	Gun Dimensions	Net Weight
200 A at 100% duty cycle	70–875 ipm (1.8–22.2 m/min.) dependent on control box or power source used	Aluminum: .030–1/16 in. (0.8–1.6 mm) Hard Wire: .030–.045 in. (0.8–1.1 mm)	4 in. (102 mm)	H: 10.25 in. (260 mm) W: 2.5 in. (64 mm) L: 15.125 in. (384 mm)	Gun only: 2.9 lb. (1.3 kg) Gun with 15 ft. cable: 9 lb. (4.1 kg) Gun with 30 ft. cable: 14 lb. (6.4 kg)

## Spoolmatic Air-Cooled Parts Breakdown



- 1. Air-Cooled Assembly **Kit 221295**
- 2. Head Tube Liner **212156**
- 3. O-Ring .614 ID **134800**
- 4. Head Tube (Air-cooled) **221087**
- 5. Head Tube Pistol Insulator **219795**
- 6. Outer Insulating Jacket **219794**
- 7. Nozzle Insulator **232284**
- 8. Diffuser **227749**
- 9. Contact Tip (See consumables)
- 10. Nozzle (See optional consumables)

## Spoolmatic Standard Replacement Consumables

Aluminum Wire Size	FasTip™ Contact Tip (Qty. 25)	Drive Rolls	All-Wire Dual-Groove Drive Rolls	Head Tube Liner
.030 in. (0.8 mm)	<b>206186</b> .041 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>
.035 in. (0.9 mm)	<b>206187</b> .047 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>
.040 in. (1.0 mm)	<b>206188</b> .053 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>
3/64 in. (1.2 mm)	<b>206189</b> .061 in. ID	<b>183358</b>	<b>136135</b>	<b>212156</b>
1/16 in. (1.6 mm)	<b>206191</b> .071 in. ID	<b>183358</b>	<b>136135</b>	<b>212156</b>

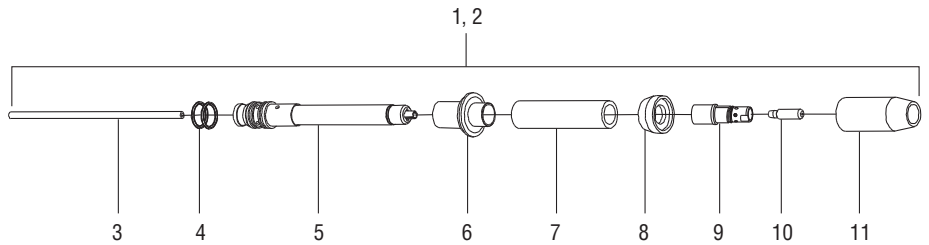
Each gun is shipped with .035-inch and .047-inch standard tips.

# XR™-Pistol Specifications (Subject to change without notice.)



Model	Welding Current Rating	Wire Feed Speed	Wire Diameter Capacity	Dimensions	Net Weight
XR-Pistol (air-cooled)	200 A at 100% duty cycle 250 A at 60% duty cycle	70–875 ipm (1.8–22.2 m/min.) dependent on control box used	.030–1/16 in. (0.8–1.6 mm) aluminum wire	H: 7.375 in. (187 mm) W: 1.875 in. (48 mm) D: 10.625 in. (270 mm)	Gun only: 2.2 lb. (1 kg) Gun with 15 ft. cable: 13 lb. (5.9 kg) Gun with 30 ft. cable: 21 lb. (9.5 kg)
XR-Pistol (water-cooled)	400 A at 100% duty cycle				Gun only: 2.4 lb. (1.1 kg) Gun with 15 ft. cable: 14 lb. (6.4 kg) Gun with 30 ft. cable: 21.5 lb. (9.8 kg)

## XR-Pistol Air-Cooled Parts Breakdown



- |                               |                            |
|-------------------------------|----------------------------|
| 1. Air-Cooled Assembly        | <b>Kit 231523</b>          |
| 2. Water-Cooled Assembly      | <b>Kit 231524</b>          |
| 3. Head Tube Liner            | <b>212156</b>              |
| 4. O-Ring .614 ID             | <b>134800</b>              |
| 5. Head Tube (Air-cooled)     | <b>221087</b>              |
| Head Tube (Water-cooled)      | <b>221519</b>              |
| 6. Head Tube Pistol Insulator | <b>219795</b>              |
| 7. Outer Insulating Jacket    | <b>219794</b>              |
| 8. Nozzle Insulator           | <b>232284</b>              |
| 9. Diffuser                   | <b>227749</b>              |
| 10. Contact Tip               | (See consumables)          |
| 11. Nozzle                    | (See optional consumables) |

## XR-Pistol Standard Replacement Consumables (Air-cooled only.)

Aluminum Wire Size	FasTip™ Contact Tip (Qty. 25)	Drive Rolls	All-Wire Dual Groove Drive Rolls	Head Tube Liner	Cable Liners
.030 in. (0.8 mm)	<b>206186</b> .041 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>	<b>191065</b> 15 or 30 ft. (4.6 or 9 m)
.035 in. (0.9 mm)	<b>206187</b> .047 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>	
.040 in. (1.0 mm)	<b>206188</b> .053 in. ID	<b>183357</b>	<b>136135</b>	<b>212156</b>	
3/64 in. (1.2 mm)	<b>206189</b> .061 in. ID	<b>183358</b>	<b>136135</b>	<b>212156</b>	
1/16 in. (1.6 mm)	<b>206191</b> .071 in. ID	<b>183358</b>	<b>136135</b>	<b>212156</b>	

## Standard Consumables – FasTip™ Series

### Gas Diffusers



**227749** 1/8 in. tip recess (Standard)  
For heavy-duty FasTip contact tips.

**231511** 1/4 in. tip recess  
For heavy-duty FasTip contact tips.

**231512** Flush tip  
For heavy-duty FasTip contact tips.

### FasTip Contact Tips (25 per package)



#### Heavy-Duty (Aluminum Wire)

**206186** .030 in. (0.8 mm)

**206187** .035 in. (0.9 mm)

**206188** .040 in. (1.0 mm)

**206189** 3/64 in. (1.2 mm)

**206191** 1/16 in. (1.6 mm)

#### Tapered (Aluminum Wire)

**209026** .030 in. (0.8 mm)

**209027** .035 in. (0.9 mm)

**209029** 3/64 in. (1.2 mm)

**206030** 1/16 in. (1.6 mm)

### Nozzles

#### Screw-On Brass

**199610** 1/2 in. orifice, tapered

**199611** 3/4 in. orifice, straight HD

**199612** 3/4 in. orifice, straight HD

**199613** 5/8 in. orifice, tapered

**199614** 5/8 in. orifice, tapered HD

#### Screw-On Copper

**199615** 1/2 in. orifice, tapered

**199616** 3/4 in. orifice, straight

**199617** 3/4 in. orifice, straight HD

**198855** 5/8 in. orifice, tapered

**199618** 5/8 in. orifice, tapered HD

**207313** 5/8 in. orifice, tapered 15/16 O.D.

**209035** 3/8 in. orifice, tapered

**209036** 1/2 in. orifice, tapered

## Optional Consumables – Centerfire™ Series

**Insulator** 10012  
4323R

**Diffuser** D-1 Large  
DS-1 Small

#### Aluminum-Specific T Series Contact Tips

**T-035AL** .035 in. (0.9 mm)

**T-047AL** .047 in. (1.2 mm)

**T-062AL** 1/16 in. (1.6 mm)

#### T Series Contact Tips

for Hard or Cored Wires 1.5 in. (38.1 mm)

**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)

**T-052** .052 in. (1.4 mm)

**T-062** 1/16 in. (1.6 mm)

#### TT Series Contact Tips

for Hard or Cored Wires 2 in. (50.8 mm)

**TT-030** .030 in. (0.8 mm)

**TT-035** .035 in. (0.9 mm)

**TT-045** .045 in. (1.2 mm)

**TT-052** .052 in. (1.4 mm)

**TT-062** 1/16 in. (1.6 mm)

#### 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 recess

**N-3414B** Brass, 3/4 in. I.D., 1/4 in. tip recess

**N-5814C** Copper, 5/8 in. I.D., 1/4 in. tip recess

**N-5818B** Brass, 5/8 in. I.D., 1/8 in. tip recess

**N-5814B** Brass, 5/8 in. I.D., 1/4 in. tip recess

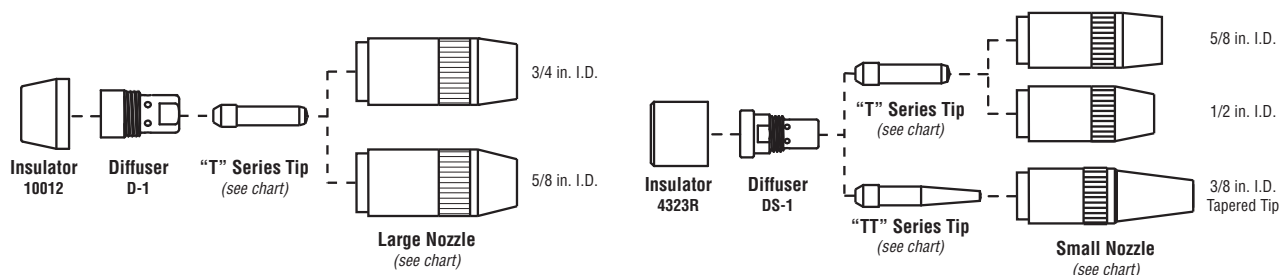
#### Small Nozzles

**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-1200B** Brass, 1/2 in. I.D., flush tip

**NST-3818B** Brass, 3/8 in. I.D., 1/8 in. tip recess



## Genuine Miller® Accessories

### Hose and Cable Extension Kits

**132228** 25 ft. (7.6 m)  
**132229** 50 ft. (15 m)

Extends Spoolmatic® away from the control box. Convenient plug-in connections. Includes gas hose, control cord, and weld power cable with insulated connector. *For Spoolmatic only.*

### Hardwire Liner Kit for Steel and Stainless 198377

For 15 or 30 ft. (4.6 or 9 m) guns. Kit consists of gun head tube liner and feed cable liner. Recommend using .030–.045 inch mild steel or stainless steel electrode wire. *For XR™-Pistol only.*

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

### Leather Cable Cover

**241159** 15 ft. (4.6 m)  
**241160** 30 ft. (9 m)

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



### One-Pound (0.5 kg) Spool Canister 132230

Ideal for use with XR guns if a small job arises requiring a different wire size and/or wire type that does not justify a 12-inch (305 mm) spool of wire. The XR feed cable is removed if the spool canister is being used. Canister accommodates 4-inch (102 mm) spools of wire.

### Air-Cooled Head Tubes

*For Spoolmatic and XR-Pistol.*



#### 50-Degree Curved Head Tube-A

**222462** *For FasTip™ consumables*  
6-inch (152 mm). Used with .030–1/16 inch (0.8–1.6 mm) wire. Kits supplied with liner that accommodates all wire sizes.



#### 10-Inch Flex Head-A 273232

For .030–1/16 inch (0.8–1/6 mm) wire. Used in place of the standard straight head tube. Flexible head tube bends 60 degrees in any direction for easier joint access and improved operator comfort. Supplied with liners. Uses FasTip contact tips.



#### 10-Inch Head Tube-A 222461

Ideal when a longer reach is required.

### Replacement Liners for Air-Cooled Head Tubes

#### For 50-Degree Curved Head Tube

**212411** .030–1/16 in. (0.8–1.6 mm)

#### For 10-Inch Flex Head

**222853** .030–.035 in. (0.8–0.9 mm)

**222854** .047–.062 in. (1.2–1.6 mm)

#### For 10-Inch Straight Head Tube

**212401** .030–1/16 in. (0.8–1.6 mm)

### 50-Degree Curved Nozzle Kit-A

**147174** For old-style multi-piece head tubes  
**300161** For newer Roughneck®-style head tubes  
Attaches to gun head tube assembly for access to confined weld joint areas. Used with .030–1/16 inch (0.8–1.6 mm) wire. Kit includes two of each size contact tips to accommodate all wire sizes, nozzle adapter kit and curved nozzle. Uses standard straight head tube liner.

### Replacement Contact Tips for 50-Degree Curved Nozzle

**148155** .030 and .035 in. (0.8 and 0.9 mm) wire

**148154** .047 in. (1.2 mm) wire

**148156** 1/16 in. (1.6 mm) wire

### Water-Cooled Head Tubes

*For XR-Pistol only.*



#### 50-Degree Curved Head Tube-W 222464

6-inch (152 mm). Used with .030–1/16 inch (0.8–1.6 mm) wire. Kits supplied with liner that accommodates all wire sizes.

### Replacement Liners for Water-Cooled Head Tubes

#### For 50-Degree Curved Head Tube

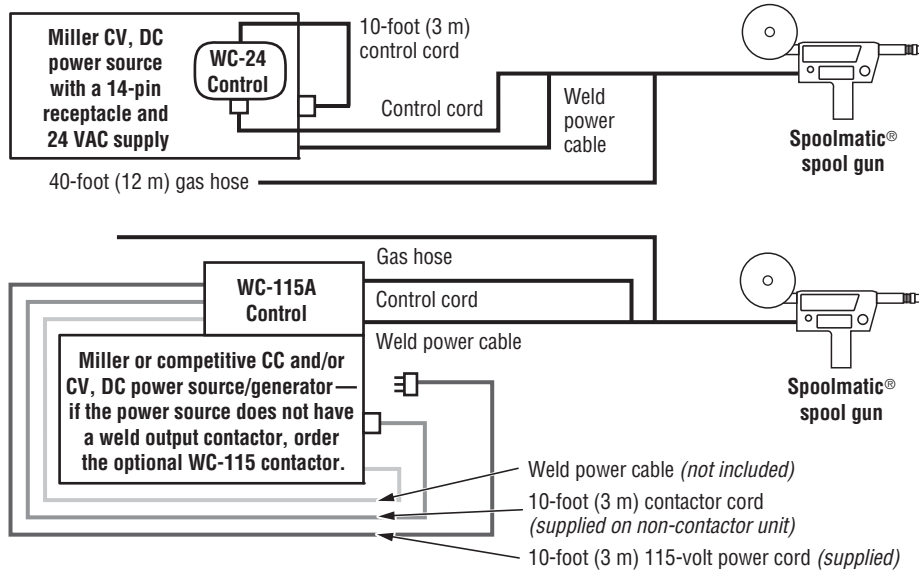
**212411** .030–1/16 in. (0.8–1.6 mm)

#### For 10-Inch Straight Head Tube

**212401** .030–1/16 in. (0.8–1.6 mm)

# Typical Spoolmatic® Installations

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



## Spoolmatic Spool Gun Hook-Up Recommendations

CV Power Supply	Spoolmatic
Millermatic® Vintage*	Need module <b>043084</b>
Millermatic DVI™, DVI <sub>2</sub> ™, 210*, 212*	Need adapter cable <b>195287</b> (WFS controlled at machine)
Bobcat™ 200 Air Pak™, Millermatic 252, 255, 355, Multimatic® 235, 255, Millermatic 212 Auto-Set™, 250X*, 251*, 300 w/meters*, 350*, 350P*, Shopmate™ 300 DX*	Direct hook-up
AlumaPower™ MPa, Dimension™ 650, Invision™ Series, XMT® Series, Trailblazer® Series, CP Series*, Deltaweld® Series*, Dimension Series*, Regency® 250*, Shopmaster™, PipePro® 304*	Need WC-24 <b>137549</b>
Bobcat Series, Miller Legend® 302*	Need WC-115A <b>137546011</b>

\*Discontinued product.



### WC-115A Weld Control

**137546** Without contactor  
**137546011** With contactor

Operates on 115-volt power and designed primarily for constant-current DC power sources. Can also be used with constant-voltage power sources or DC engine drives supplying 115 volts. Used with a CC source the control circuit functions in a voltage-sensing mode, and with a CV source it functions as a constant-speed circuit.



### WC-24 Weld Control 137549

Packaged in a compact, lightweight, non-metallic enclosure, the WC-24 easily mounts directly on the power source. Designed for use with Miller constant-voltage power sources with 14-pin receptacles and supplying 24 VAC. The control includes a board-mounted potentiometer which can alter the drive motor acceleration rate to optimize arc starting performance.

#### Important note:

To connect the Spoolmatic gun and WC-24 control to older-style Miller or competitive CV power sources that do **NOT** have a 24 VAC supply, the PSA-2 Control **141604** is required.

Standard features include a wire run-in control and a drive motor acceleration control which ensure optimum arc starting performance, regardless of the type of power source being used. The WC-115A comes with a 10-foot (3 m), wall-type plug power cord.

#### Important notes:

To connect the WC-115A control to older-style Miller power sources having Hubbell or 5-pin contactor control receptacles, the appropriate connector must be ordered **separately**.

To connect to older-style Miller CC power sources having a two-socket Hubbell connector, order plug **039618**.

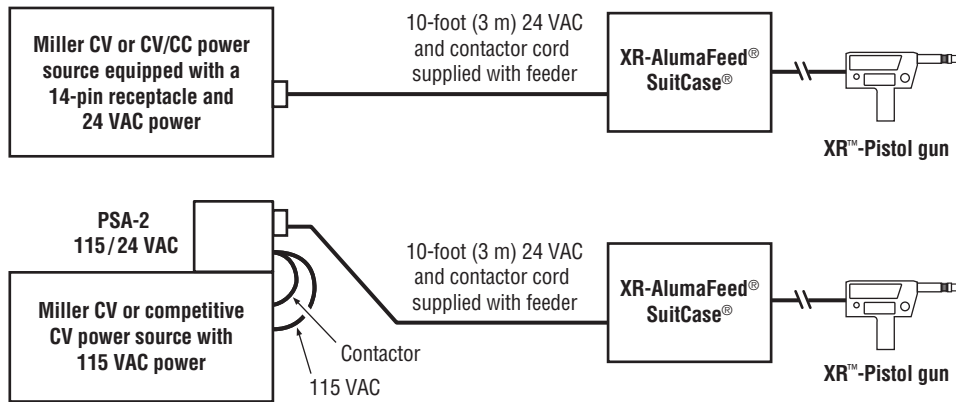
If power source has a Miller 5-pin receptacle, order **039273** and **039685**.

To connect to older-style Miller CV power sources having a two-prong Hubbell connector, order plug **039635**.

These connectors are to replace the 14-pin connector on the 10-foot interconnect contactor cord. Internal wiring changes may be necessary.

# Typical XR™-Pistol Installations

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



## XR-Pistol Gun Hook-Up Recommendations

CV Power Supply	Control
AlumaPower™ 350 MPa, 450 MPa	XR-AlumaFeed SuitCase
Deltaweld® 350, 500 (with 14-pin receptacle)	
Dimension™ 650	
Invision™ Series	
XMT® Series (except VS model)	
Trailblazer® 325, 302 Air Pak™	
Big Blue® Series (with 14-pin receptacle)	



### XR-AlumaFeed® SuitCase® Wire Feeder 301567

Push-pull wire feeder in an impact-resistant and flame-retardant suitcase-style case is designed for high-volume, high-production aluminum MIG welding where quality and consistency is a high priority. See literature DC/34.0.

## Ordering Information

### Important notes:

Spoolmatic guns require a WC-24 or WC-115 weld control, unless used on a machine that allows direct hookup. Refer to chart on page 6.

XR-Pistol guns require an XR-AlumaFeed SuitCase. Refer to chart on page 7.

Equipment	Stock No.	Description	Qty.	Price
<b>Spoolmatic® Spool Gun</b>	<b>195156</b>	15 ft. (4.6 m) cable		
	<b>130831</b>	30 ft. (9 m) cable		
WC-24 Weld Control	<b>137549</b>	For Spoolmatic guns		
WC-115A Weld Control	<b>137546</b>	Without contactor. For Spoolmatic guns		
	<b>137546011</b>	With contactor. For Spoolmatic guns		
<b>XR™-Pistol Push-Pull Gun (Air-Cooled)</b>	<b>198127</b>	15 ft. (4.6 m) cable		
	<b>198128</b>	30 ft. (9 m) cable		
<b>XR™-Pistol Push-Pull Gun (Water-Cooled)</b>	<b>198129</b>	15 ft. (4.6 m) cable		
	<b>198130</b>	30 ft. (9 m) cable		
XR-AlumaFeed® SuitCase® (See literature DC/34.0)	<b>301567</b>	Includes .035 and 3/64 in. drive rolls		
XR-AlumaFeed SuitCase Drive Roll	<b>195591</b>	1/16 in (1.6 mm)		
<b>Consumables and Accessories</b>				
Consumables		See pages 2–5		
Hose and Cable Extension Kits	<b>132228</b>	25 ft. (7.6 m). Spoolmatic only		
	<b>132229</b>	50 ft. (15 m). Spoolmatic only		
Hardware Liner Kit for Steel and Stainless	<b>198377</b>	For 15 or 30 ft. (4.6 or 9 m) guns. XR-Pistol only		
Leather Cable Cover	<b>241159</b>	15 ft. (4.6 m)		
	<b>241160</b>	30 ft. (9 m)		
One-Pound Spool Canister	<b>132230</b>			
Head Tubes		See page 6		
Coolant Systems		See literature AY/7.2		

Date:

Total Quoted Price:

Distributed by:

