

SuitCase™ X-TREME™ 12VS

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**Voltage-Sensing
Wire Feeder**



Quick Specs

Industrial Applications

Shipbuilding
Construction
Heavy Manufacturing
Rental

Processes

MIG (GMAW)
Flux Cored (FCAW)

Input Power 14–48 VDC Open Circuit/Arc Voltage

Wire Feed Speed 50–780 IPM (1.3–19.8 m/min)

Weight 35 lb (15.9 kg)

The Power of Blue.®

NEW! Polypropylene case with built-in slide rails and the ability to open the door to change wire with feeder in vertical position.

Digital meters with SunVision™ technology are standard for voltage and wire speed, and can also display amperage if desired. Meters can be seen clearly even in direct sunlight.

Potted and trayed main printed circuit board for the harshest environments adds exceptional reliability. Board has full-trigger isolation so a shorted gun trigger will not affect feeder operation.



Improved contactor and overall duty cycle for high-amperage applications (425 A at 60%).

Trigger hold, wire jog, and gas purge are all standard and located on front panel.

Wider voltage range for small and large wires with no contactor chatter or arc outages.

NEW! Double-filtered gas valve helps keep dirt from clogging and affecting gas flow.

Excellent starts and improved superior arc performance for all types and sizes of wires whether using CV or CC power supply. Best low-end CC arc in the industry.

Specifications (Subject to change without notice.)



(Use with CC/CV,
DC Power Sources.)

Input Power	Welding Power Source Type	Input Welding Circuit Rating	Electrode Wire Diameter Capacity	Maximum Spool Size Capacity	Wire Speed	Dimensions	Net Weight
Open-Circuit Arc Voltage 14–48 VDC	Constant Voltage (CV) or Constant Current (CC) DC	425 A at 60% Duty Cycle	Solid Wire: .023–5/64 in (0.6–2.0 mm) Flux Cored: .030–5/64 in (0.8–2.0 mm)	12 in (305 mm) Up to 45 lb (20.4 kg)	50–780 IPM (1.3–19.8 m/min) dependent on arc voltage	H: 21 in (533 mm) W: 9 in (229 mm) D: 15-1/2 in (394 mm)	35 lb (15.9 kg)



Wire feeder is warranted for 3 years, parts and labor.

MADE IN USA
APPLETON, WI



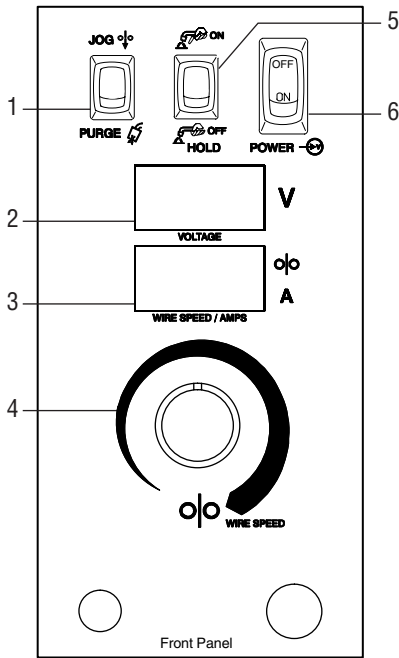
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Control Panels



1. Jog/Purge Switch
2. Voltmeter
3. Wire Speed/Amperage Meter
4. Wire Speed Control
5. Trigger Hold Switch
6. Power Control Switch

Drive Roll Kits (Order from Miller Service Parts.)

Select drive roll kits from chart below according to type and wire size being used. Drive roll kits include 2 drive rolls, the necessary guides and feature an anti-wear inlet guide.

Wire size	 "V" groove for hard wire	 "U" groove for soft wire or soft-shelled cored wires	 "V" knurled for hard-shelled cored wires	 "U" clogged for extremely soft wire or soft-shelled cored wires (i.e., hard facing types)
.023 / .025 in (0.6 mm)	#087 131	—	—	—
.030 in (0.8 mm)	#079 594	—	—	—
.035 in (0.9 mm)	#079 595	#044 749	#079 606	—
.040 in (1.0 mm)	#161 189	—	—	—
.045 in (1.1/1.2 mm)	#079 596	#079 599	#079 607	#083 318
.052 in (1.3/1.4 mm)	#079 597	#079 600	#079 608	#083 317
1/16 in (1.6 mm)	#079 598	#079 601	#079 609	#079 614
.068/.072 in (1.8 mm)	—	—	#089 984	—
5/64 in (2.0 mm)	—	#079 602	#079 610	#079 615

Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
SuitCase™ X-TREME™ 12VS	#195 500			
Flowmeter Kit	#195 217			
Inline Filter	#195 189			
Lincoln® Spool Adapter	#047 141	For 14 lb spools		
Guns				
Ironmate™ 1260 (FCAW)		See Lit. Index No. AY/16.0		
Roughneck® C-Series (GMAW)		See Lit. Index No. AY/17.0		
Power Sources				
XMT® Series		See Lit. Index No. DC/18.8		
Dimension™		See Lit. Index No. DC/19.2		
Gold Star®		See Lit. Index No. DC/8.1		
Mark VI™		See Lit. Index No. DC/9.8		
Big Blue® Turbo		See Lit. Index No. ED/10.3		
Big Blue® 400 & 500		See Lit. Index No. ED/10.8		
Big Blue® Air Pak™		See Lit. Index No. ED/10.5		
Bobcat™		See Lit. Index No. ED/4.4		
Trailblazer®		See Lit. Index No. ED/4.77		
Consumables				
Drive Rolls				
Wire				

Date:

Total Quoted Price:



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