

# SuitCase® X-TREME™ 8VS & 12VS Voltage-Sensing Wire Feeder



## Quick Specs

### Industrial Applications

Shipbuilding  
Construction  
Heavy Manufacturing  
Rental

### Processes

MIG (GMAW)  
Flux-Cored (FCAW)  
Pulsed MIG (GMAW-P)

**Input Power** 14–48 VDC Operating Voltage  
110 VDC Maximum OCV

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

**Weight** 8VS: 28 lb. (13 kg) 12VS: 35 lb. (15.9 kg)

## Portable wire feeding at its best.

The SuitCase X-TREME 8VS and 12VS provide wire feed speed that is accurate and consistent from the start of the weld to the finish, and from one weld to the next. Consistent wire feed speed is very important with large-diameter cored wire, because small changes in wire feed speed make large changes in deposition rates.



**IMPROVED!** SuitCase® X-TREME™ 8VS with optional meters

SuitCase® X-TREME™ 12VS



**Built to last in harsh industrial environments**

Plastic case design, potted PC board and double-filtered gas valve ensure SuitCase withstands the harshest industrial environments.



**Improved weld quality**

Wire drive with tachometer control improves weld feed speed accuracy and consistency to make it easier to produce quality welds.



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



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# SuitCase® X-TREME™ Features



**Ultra-low drag inlet guide pins** make loading the wire easy and does not deform the wire on the way into the drive rolls. Simply thread the wire through the pins and into drive rolls. There are two ways to advance the wire through the drive roll and into the gun. Either open the pressure arm and thread the wire into the grooves in the drive roll and on into the gun inlet **or** place the wire between the pins and use the jog/purge switch to advance the wire through the drive roll.



**Scaled wire pressure knob** provides easy adjustment and consistent pressure on the drive rolls and wire. **Wire drive and motor assembly** is specifically designed for mobile welding applications to provide smooth and consistent wire delivery. Improved motor torque and drive roll system are designed to feed small-diameter solid wire (.023 inch) to large-diameter cored wire (5/64 inch).

**Electronic wire feed speed control with integrated tachometer** ensures wire feed speed accuracy that rivals the best benchtop feeders.



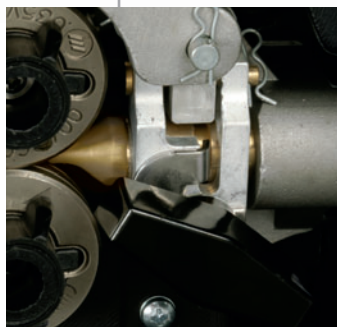
**Potted and trayed main printed circuit board** for the harshest environments adds exceptional reliability. Board has full-trigger isolation so a shorted gun trigger will not affect feeder operation.

**Digital meters with SunVision™ technology** can display voltage and wire speed, and also amperage if desired. Meters can be seen clearly even in direct sunlight. (8VS: Meters optional).

**Front panel** has trigger hold, wire jog, and gas purge all located on front panel.

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

**Wire speed dual schedule** reduces wire speed to 87.5 percent of standard speed. Requires a dual schedule gun or dual schedule switch (sold separately).



**Gun locking tab** works with guns having corresponding locking grooves to prevent gun from being pulled out if the feeder is dragged by the gun.



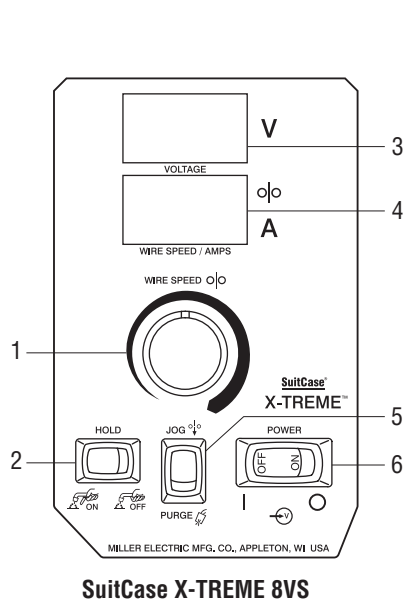
**Gas inlet** recessed into back of case is protected from incidental contact by the weld cable, ensuring consistent and contaminant-free shielding gas delivery to the gun. **Double-filtered gas valve** helps keep dirt from clogging and affecting gas flow.

# Specifications (Subject to change without notice.)

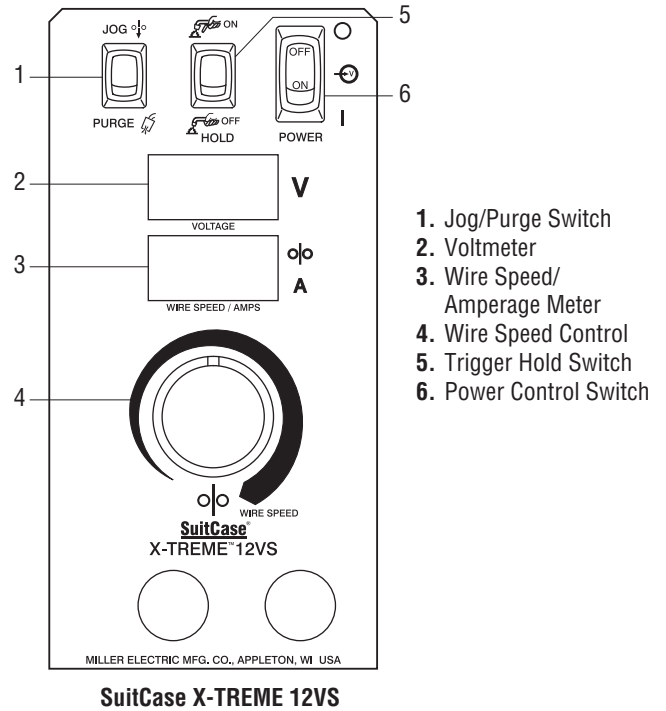


Model	Input Power	Welding Power Source Type	Input Welding Circuit Rating	Wire Speed	Electrode Wire Diameter Capacity	Max. Spool Size Capacity	Dimensions	Net Weight
<b>8VS</b>	Operates on open-circuit voltage and arc voltage: 14–48 VDC/110 Max OCV	CC or CV DC power sources. AC type not recommended.	330 A at 60% Duty Cycle	50–780 IPM (1.3–19.8 m/min.)	<b>Solid Wire:</b> .023–.052 in. (0.6–1.4 mm) <b>Flux Cored:</b> .030–5/64 in. (0.8–2.0 mm)	8 in. (203 mm) 14 lb. (6.4 kg)	H: 12.75 in. (324 mm) W: 7.25 in. (184 mm) D: 18 in. (457 mm)	28 lb. (13 kg)
<b>12VS</b>			425 A at 60% Duty Cycle	dependent on arc voltage.	<b>Solid Wire:</b> .023–.052 in. (0.6–1.4 mm) <b>Flux Cored:</b> .030–5/64 in. (0.8–2.0 mm)	12 in. (305 mm) Up to 45 lb. (20 kg)	H: 15.5 in. (394 mm) W: 9 in. (229 mm) D: 21 in. (533 mm)	35 lb. (15.9 kg)

## Control Panel







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



1. Jog/Purge Switch
2. Voltmeter
3. Wire Speed/Amperage Meter
4. Wire Speed Control
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## Drive Rolls (Two Required. Order from Miller Service Parts.)

Select drive rolls from chart below according to type and wire size being used. Wire inlet guide comes installed on this wire feeder.

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)	#087 130	—	—	—
.030 in. (0.8 mm)	#053 695	—	—	—
.035 in. (0.9 mm)	#053 700	#072 000	#132 958	—
.040 in. (1.0 mm)	#053 696	—	—	—
.045 in. (1.1/1.2 mm)	#053 697	#053 701	#132 957	#083 489
.052 in. (1.3/1.4 mm)	#053 698	#053 702	#132 956	#083 490
1/16 in. (1.6 mm)	#053 699	#053 706	#132 955	#053 708
.068/.072 in. (1.8 mm)	—	—	#132 959	—
5/64 in. (2.0 mm)	—	#053 704	#132 960	#053 710

## Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>SuitCase® X-TREME™ 8VS</b>	#951 582	With Meters and Bernard® Q300 Gun		
	#951 583	With Bernard® Q300 Gun		
<b>SuitCase® X-TREME™ 12VS with Meters</b>	#951 543	With Bernard® Q300 Gun		
	#951 544	With Bernard® Dura-Flux™ gun		
Flowmeter Kit	#300 343			
Inline Filter	#195 189			
Spool Adapter	#047 141	For 14-lb. spools		
Dual Schedule Switch DSS-9-15	#071 833			
International Gun Adapter	#164 902	Adapter is required to connect SuitCase® X-TREME™ to a Euro-style gun.		
<b>Guns</b>				
Bernard® Dura-Flux™ (FCAW)		See Welding Components and Parts Guide		
Bernard® Q300 (GMAW)		See Welding Components and Parts Guide		
Bernard® PipePro® Dura-Flux™ (FCAW)		Dura-Flux gun with built-in dual schedule switch. See Bernard Lit. No. SPEC DFP-1.2		
Ironmate™ 1260 (FCAW)		See Lit. Index No. AY/16.0		
Roughneck® C-Series (GMAW)		See Lit. Index No. AY/17.0		
<b>Power Sources</b>				
XMT® Series		See Lit. Index No. DC/18.8 and DC/18.83		
Dimension™ Series		See Lit. Index No. DC/19.2		
Gold Star® Series		See Lit. Index No. DC/8.1		
Big Blue® 400 Pro		See Lit. Index No. ED/5.7		
Big Blue® 500 Pro		See Lit. Index No. ED/11.0		
Big Blue® 800 Air Pak™		See Lit. Index No. ED/13.0		
Bobcat™		See Lit. Index No. ED/4.4		
Trailblazer®		See Lit. Index No. ED/4.75 and ED/4.78		
<b>Consumables</b>				
Drive Rolls				
Wire				

Date:

Total Quoted Price:

Distributed by:

