Big Blue® 400 PipePro®

Diesel Engine-Driven Heater/AC Generator

Quick Specs

<table>
<thead>
<tr>
<th>Heavy Industrial Applications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cross-country pipeline</td>
</tr>
<tr>
<td>Process pipe welding</td>
</tr>
</tbody>
</table>

Processes

- Stick (SMAW)
- MIG (GMAW)
- Flux-cored (FCAW)
- RMD®
- Pulsed MIG (GMAW-P)
- DC TIG (GTAW)
- Air carbon arc (CAC-A)

Rated: 1/4-inch (6.4 mm) carbons

Output Range

- DC stick: 20–400 A
- DC TIG: 20–400 A
- FCAW/MIG: 14–40 V

Generator Output Rated at 104°F (40°C)

12,000 watts peak, 10,000 watts continuous

Accu-Rated™ - Not inflated Generator Power

Designed for the transmission pipeline welder.

The Big Blue 400 PipePro offers superior downhill stick arc characteristics, as well as MIG/flux-cored capabilities, to meet high-strength steel requirements for the most demanding pipeline jobs.

MITSUBISHI ENGINE NORTH AMERICA, INC.

Mitsubishi S4L2 four-cylinder diesel.

Heavy-duty low-speed T4F industrial diesel engine designed to operate over 10,000 hours before the first basic overhaul. Backed by worldwide support and service.

Remote control of the power source without a cord. See pages 2 and 3.

Also available with stainless steel enclosure. See page 8.

Computerize ArcReach®

Welding is taken to a whole new level. Remote control of the power source without a cord. See pages 2 and 3.

Also available with stainless steel enclosure. See page 8.

Welder/generator is warranted by Miller for three years, parts and labor. Engine is warranted separately by engine manufacturer.

Miller Electric Mfg. Co.
An ITW Welding Company
1635 West Spencer Street
P.O. Box 1079
Appleton, WI 54912-1079 USA
Phone: 866-931-9730
FAX: 800-637-2315
International Phone: 920-735-4554
International FAX: 920-735-4125

MillerWelds.com


**Big Blue® 400 PipePro® Features and Controls**

**Digital meters** with SunVision™ technology enable welding parameters to be viewed with greater clarity than analog meters — at virtually any angle. Meters can be seen clearly even in direct sunlight.

**Meters display**
- Process settings for quick and easy setup
- Preset and actual amperage

**Simple-to-set controls** require no elaborate procedure — just select process and weld!

**Industrial USB port.** Quickly upload the latest software and download machine log files to retrieve in-depth information such as diagnostics and machine statistics.

**Low OCV stick (VRD),** when enabled, reduces the open-circuit voltage to 30 volts when the welding power source is not in use, increasing operator safety without compromising arc starts.

**Optional stainless steel enclosure.** Enhances durability and adds to the look and resale value of the machine.

**Arc control** allows arc characteristics to be adjusted in stick and wire processes. In stick modes, unlock the benefits of the all-new Miller® Dynamic DIG program, which gives welders the fine-tuning they need to overcome issues related to fitup and inconsistencies in the pipe.

**Standard 14-pin receptacle** with Auto-Remote Sense™ for simple connection of remote controls and wire feeders.

**10,000 watts of pure generator power.** Plug in an extra Miller® inverter-based power source for a second welding arc!

**LINE-X® top cover** is workbench tough and provides superior impact, corrosion and abrasion protection.

**Quiet operation.** Improves jobsite communication.

**Standard features include** adjustable Hot Start™ output contactor control, automatic idle, thermal overload protection and 120-volt block heater.

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**ArcReach® Remote Control Technology**

**Remote control of the power source without a control cord.**

An ArcReach system allows you to change weld settings from your ArcReach feeder or remote, saving a trip to the power supply. ArcReach technology uses the existing weld cable to communicate welding control information between the feeder or remote and the power source. This technology eliminates the need for control cords, and their associated problems and costs.
**Additional ArcReach® Features**

**Big Blue® 400 PipePro®**

**ArcReach provides remote amperage and voltage control at the weld joint without needing a control cord.**

More arc-on time and reduced exposure to workplace hazards for operators can be realized using ArcReach because less time is spent going back to the welding power supply to set process and arc amperage or voltage.

**Auto-Process Select.™** Depending on connected accessory, the system automatically changes to stick or MIG/FCAW (with gas) if electrode positive polarity is detected or TIG or FCAW (no gas) if electrode negative polarity is detected, when ArcReach communication is established between the accessory and the Big Blue 400 PipePro — reducing the need to access the power supply.

**Automatic return to panel settings.** System automatically returns to Big Blue 400 PipePro setting when ArcReach communication is terminated. For example, if the Big Blue is set to gouging at 350 amps and an ArcReach feeder is connected, the Big Blue will go to a MIG/FCAW process. If the feeder is disconnected, the Big Blue will go back to its previous setting (gouging at 350 amps).

Less operator fatigue by not needing to move or reposition heavy secondary weld leads bundled with control cords on the jobsite. Control cords are not used.

**Operator can precisely set arc amperage or voltage** at the weld joint and monitor the actual arc voltage and current delivered to the weld using the digital meters on the accessory. This removes guesswork when it comes to adhering to weld procedures.

**Remote override of Big Blue 400 PipePro.** When an ArcReach accessory is connected to a Big Blue the accessory has full control and the Big Blue controls are disabled. While under ArcReach control, process and voltage/amperage adjustments are locked out, preventing accidental changes by personnel other than the welding operator.

**Cross platform compatible.** The same ArcReach accessories that work on engine-driven equipment can also be used on select ArcReach-equipped XMT® and Dimension™ power sources.

**Reverse compatible.** ArcReach-equipped power sources work with non-ArcReach accessories; however, the complete ArcReach benefit is only realized with the ArcReach system.

**Save time** by no longer needing to troubleshoot welding system problems that result from damaged control cords.

**Eliminate costly control cord repairs** because control cords are not used.

**Improved weld quality**

Increased productivity

**FLEET COMPATIBILITY**

Cross platform compatible. The same ArcReach accessories that work on engine-driven equipment can also be used on select ArcReach-equipped XMT® and Dimension™ power sources.

**Improved flexibility**

**Big Blue® 400 PipePro® System and ArcReach® Accessories**

**ArcReach SuitCase 8 and 12 feeders for MIG or flux-cored welding**
- Remote voltage control
- Polarity indication
- Auto-Process Select™

**ArcReach Stick/TIG Remote for stick or TIG welding**
- Remote amperage control
- Polarity indication
- Arc control for stick
- Auto-Process Select™

**ArcReach Smart Feeder for advanced wire processes**
- RMD® and pulsed MIG processes
- Remote voltage control
- Store and recall weld settings

**Big Blue 400 PipePro system (stainless steel enclosure, Mitsubishi, 907703), ArcReach SuitCase® 12 feeder with Bernard™ S-Gun™ (951730), ArcReach Stick/TIG Remote (301325), and ArcReach Smart Feeder with Bernard PipeWorx 300-15 MIG gun (951733).**
### Engine Specifications (Engines warranted separately by the engine manufacturer.)

<table>
<thead>
<tr>
<th>Engine Brand</th>
<th>Features</th>
<th>HP</th>
<th>Type</th>
<th>Engine Speeds</th>
<th>Capacities</th>
<th>Automatic Engine Shutdown</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mitsubishi S4L2</td>
<td>EPA Tier 4 Final compliant, includes 120 V block heater</td>
<td>24.7</td>
<td>Four-cylinder, liquid-cooled, industrial diesel</td>
<td>Idle: 1,500 rpm</td>
<td>Fuel: 11.5 gal. (43.5 L)</td>
<td>Low oil pressure, high coolant temperature, low fuel level</td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td>Weld: 1,800 rpm</td>
<td>Oil: 5.8 qt. (5.5 L)</td>
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<td>Coolant: 10 qt. (9.5 L)</td>
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</tbody>
</table>

### Welding Specifications

<table>
<thead>
<tr>
<th>Weld Mode/Process</th>
<th>Weld Output Range</th>
<th>Weld Output Rated at 100% Duty Cycle at 104°F (40°C)</th>
<th>Max. Open-Circuit Voltage</th>
<th>Generator Power Output Rated at 104°F (40°C)</th>
<th>Sound Levels at Rated Output, 23 ft. (7 m)</th>
<th>Dimensions</th>
<th>Net Weight (without fuel)***</th>
</tr>
</thead>
<tbody>
<tr>
<td>CC/DC (TIG)</td>
<td>20–400 A</td>
<td>300 A at 32 VDC</td>
<td>85 VDC</td>
<td>12,000 watts peak, 10,000 watts continuous 1-phase, 84/42 A, 120/240 VAC, 60 Hz</td>
<td>Idle: 68.7 dB (93 Lwa) Weld: 72.1 dB (97 Lwa)</td>
<td>993 lb. (450 kg)</td>
<td></td>
</tr>
<tr>
<td>CC/DC (Stick)</td>
<td>20–400 A</td>
<td>350 A at 27 VDC</td>
<td>30 VDC*</td>
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<tr>
<td>CV/DC (FCAW/MIG)</td>
<td>14–40 V</td>
<td>400 A at 24 VDC</td>
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</tbody>
</table>

*Sense voltage for stick and Lift-Arc™ TIG. **Will operate either 60 Hz or 50/60 Hz power tools, lights, etc. ***Additional 82 lb. (37 kg) when fuel tank is full.

### Performance Data

#### Fuel Consumption Curve

![Fuel Consumption Curve](image)

#### Simultaneous Welding and Power

<table>
<thead>
<tr>
<th>Weld Amperes</th>
<th>Total Aux. Power Available (Watts)</th>
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</thead>
<tbody>
<tr>
<td>25 A</td>
<td>10,000</td>
</tr>
<tr>
<td>75 A</td>
<td>10,000</td>
</tr>
<tr>
<td>125 A</td>
<td>10,000</td>
</tr>
<tr>
<td>175 A</td>
<td>9,000</td>
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<tr>
<td>225 A</td>
<td>7,500</td>
</tr>
<tr>
<td>300 A</td>
<td>4,500</td>
</tr>
<tr>
<td>350 A</td>
<td>1,000</td>
</tr>
</tbody>
</table>
1. **Self-calibrating digital weld meters with fault code indication** display preset or actual weld parameters.

2. **Pushbutton main control knob** used for adjusting amperage/voltage, adjusting arc control, and accessing the service menu.

3. **LED process indicator.** Front panel process selections are illuminated with an LED that identifies the active process. This enables the selected weld process to be seen at a distance from the power source.

4. **Lift-Arc™ TIG with Auto-Stop™ and Auto-Crater™.**

5. **USB port** allows software updates from a USB drive. A summary file of recorded data from the unit will be saved to a USB drive that is inserted.

6. **Weatherproof Lexan® nameplate** is super durable and resists cracking and fading.

7. **Adjustable arc control** adjusts DIG when process control is in stick mode and adjusts inductance when process control is in FCAW or MIG mode. The amount of DIG determines how much amperage (heat) varies with stick arc length. Inductance determines the “wetness” of the weld puddle.

8. **Maintenance interval reminder.** Yellow and red indicator lights let an operator know when the machine is approaching and finally in need of routine maintenance.

9. **Fuel indicator gauge.** Low fuel shutdown shuts engine off prior to running out of fuel to prevent loss of fuel in the system, and make restarts easy.


11. **Glow plugs** assist in cold weather starting.

12. **Engine control switch** is used to start the engine and then select between auto idle and high speed lock.

13. **Standard 14-pin receptacle** for simple connection of remote controls and wire feeders. Includes **Auto Remote Sense™** which automatically switches from panel to remote amperage/voltage (AV) control with remote connected. Eliminates confusion of a panel/remote switch.

14. **50 A, 120/240 V receptacle and 20 A, 120 V GFCl receptacles with circuit breakers**

   *Note: For matching 240 V plug, order 119172.*

15. **Weld output terminals**
Genuine Miller® Accessories

**Full KVA Adapter Cord**  300517  Field NEMA 14-50P to NEMA 6-50R. Adapts engine drive 120/240 V plug to common Millermatic® and Spectrum® 240 V plug.

**Full KVA Plug Kit**  119172  Field 120/240 V, 50 A plug (NEMA 14-50P) to fit full KVA receptacle.

**Engine Filter Kit**  252782  Field For Mitsubishi. Includes all filters required for proper engine maintenance. Oil filter, primary and secondary fuel filter, and primary air filter.

**Spark Arrestor (Muffler) Kit**  300585  Field Prevents particles from leaving the muffler that could potentially start a fire. Mandatory when operating on California grasslands, brush, or forest-covered land, and in all national forests. For other areas, check your state and local laws. Meets U.S. Forest Service Standard 5100-1B.

**FA-1D Lockable Flame Arrestor Fuel Cap**  043947  Field Fuel cap can be padlocked to prevent vandalism. A built-in flame arrestor prevents flames or sparks from entering the fuel tank.

**Protective Cover**  195301  Field Blue water-resistant cover with Miller logo resists stains and mildew, and protects the finish of your welder.

**MIG (GMAW) or Flux-cored (FCAW)**

**SuitCase® X-TREME® 8VS Wire Feeder**  951582
**SuitCase® X-TREME® 12VS Wire Feeder**  951543
Lightweight, voltage-sensing wire feeders include secondary contactor, gas valve, drive roll kit and Bernard™ BTB Gun 300 A. See literature M/6.42.

**SuitCase® 12RC Wire Feeder**  951580
Lightweight and flexible enough to run wires up to .062-inch diameter. Includes remote voltage control, drive roll kit and Bernard™ BTB Gun 300 A. See literature M/6.5.

**MIG (GMAW)/Flux-cored (FCAW) Guns**
See Bernard™ literature SP-BTB for BTB air-cooled MIG guns, and SP-DF for Dura-Flux™ self-shielded flux-cored guns.

**Spoolmatic® 30A Spool Gun**  130831
Air-cooled, 200-amp, one-pound spool gun for aluminum and stainless MIG. See literature M/1.73. Requires WC-24 Control (137549).

**XR™ Wire Feeders and Guns**
Push-pull system designed to handle difficult-to-feed soft alloy wires such as aluminum. See literature M/1.7 through M/1.74.

**AC TIG (GTAW) Welding**
The Dynasty 210 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

**Dynasty® 210 Series**
For portable AC/DC TIG. See literature AD/4.81.

**Multiple Operator Welding**
The XMT 350 FieldPro and CST 280 power sources can be run off the engine drive’s generator to provide two arcs with only one engine.

**XMT® 350 FieldPro™**
See literature DC/18.96.

**CST™ 280**
See literature DC/29.55.
Plasma Cutting

Spectrum® 375 X-TREME™ 907529
See literature PC/9.2.
Spectrum® 625 X-TREME™ 907579
See literature PC/9.6.
Spectrum® 875 907583
See literature PC/9.8.
The Spectrum 375 X-TREME and 625 X-TREME come complete with protective X-CASE™ (not shown).

Stick/TIG Remote Controls

ArcReach® Stick/TIG Remote 301325
When paired with an ArcReach power source, provides remote control of the power source without a control cord — saving time and money. See literature AY/14.5.

Wireless Remote Hand Control 300430
For remote current, voltage and contactor control. Receiver plugs directly into the 14-pin receptacle of Miller machine. 300-foot (91.4 m) operating range.

Wireless Antenna Kit 300749
Recommended for improved reception.

RHC-14 Hand Control 24221020
Miniature hand control for remote current, voltage and contactor control. Dimensions: 4 x 4 x 3.25 in. (102 x 102 x 82 mm). Includes 20-foot (6 m) cord and 14-pin plug.

RMS-14 On/Off Control 187208
Momentary-contact switch for contactor control. Rubber-covered pushbutton dome switch ideal for repetitive on-off applications. Includes 26.5-foot (8 m) cord and 14-pin plug.

RCC-14 Remote Contactor and Current Control 151086
East/west rotary-motion fingertip control attaches to TIG torch using two hook-and-loop fasteners. Includes 26.5-foot (8 m) cord and 14-pin plug.

PRHC-14 Hand Control 195511
Complete current or voltage control brings 120 volts GFCI power to work area in a single cord. Housed in a durable, light aluminum case and includes 125-foot (38 m) cord with plugs.

Extension Cables for 14-Pin Remote Controls or 24 VAC Wire Feeders
242208025 25 ft. (7.6 m)
242208050 50 ft. (15.2 m)
242208080 80 ft. (24.4 m)

Trailer Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Gross Axle Weight Rating</th>
<th>Gross Vehicle Weight Rating</th>
<th>Net Payload</th>
<th>Height of Bed</th>
<th>Road Clearance</th>
<th>Track (Center to center of tires)</th>
<th>Standard Tires (Standard rating or P-size rating)</th>
<th>Dimensions</th>
<th>Net Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HWY-Mid Frame</td>
<td>1,605 lb. (728 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>1,424 lb. (646 kg)</td>
<td>19.5 in. (495 mm)</td>
<td>8 in. (203 mm)</td>
<td>46 in. (1,168 mm)</td>
<td>ST175/800-13 Load Range C</td>
<td>Length: 101 in. (2,565 mm) Width: 55 in. (1,397 mm)</td>
<td>181 lb. (82 kg)</td>
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</tbody>
</table>

*Width at outside of fenders.
<table>
<thead>
<tr>
<th>Equipment and Options</th>
<th>Stock No.</th>
<th>Description</th>
<th>Qty.</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Big Blue® 400 PipePro</strong></td>
<td>907703001</td>
<td>Mitsubishi. Blue with ArcReach remote control technology</td>
<td></td>
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<tr>
<td></td>
<td>907703</td>
<td>Mitsubishi. Stainless steel with ArcReach remote control technology</td>
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<tr>
<td><strong>Field Accessories</strong></td>
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<tr>
<td>Full KVA Adapter Cord</td>
<td>300517</td>
<td>Field</td>
<td></td>
<td></td>
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<tr>
<td>Full KVA Plug Kit</td>
<td>119172</td>
<td>120/240 V. Field</td>
<td></td>
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<tr>
<td>Engine Filter Kit</td>
<td>252782</td>
<td>Field. For Mitsubishi, includes air, oil and fuel filters</td>
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<tr>
<td>Spark Arrestor (Muffler) Kit</td>
<td>300585</td>
<td>Field</td>
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<tr>
<td>FA-1D Lockable Flame Arrestor Fuel Cap</td>
<td>043947</td>
<td>Field</td>
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<tr>
<td>Protective Cover</td>
<td>195301</td>
<td>Field</td>
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<tr>
<td><strong>MIG/Flux-cored Welding</strong></td>
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<tr>
<td>SuitCase® X-TREME™ 8VS</td>
<td>951582</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.42</td>
<td></td>
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<tr>
<td>SuitCase® X-TREME™ 12VS</td>
<td>951543</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.42</td>
<td></td>
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<tr>
<td>SuitCase® 12RC</td>
<td>951580</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.5</td>
<td></td>
<td></td>
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<tr>
<td>ArcReach® SuitCase® 8</td>
<td>951726</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.55</td>
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<tr>
<td></td>
<td>951727</td>
<td>With Bernard™ S-Gun”</td>
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<td></td>
<td>951728</td>
<td>With Bernard™ Dura-Flux™ gun</td>
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<tr>
<td>ArcReach® SuitCase® 12</td>
<td>951729</td>
<td>With Bernard™ BTB Gun 300 A. See literature M/6.55</td>
<td></td>
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<tr>
<td></td>
<td>951730</td>
<td>With Bernard™ S-Gun”</td>
<td></td>
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<tr>
<td></td>
<td>951731</td>
<td>With Bernard™ Dura-Flux™ gun</td>
<td></td>
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<tr>
<td>ArcReach® Smart Feeder</td>
<td>951733</td>
<td>MIG/FCAW/RMD®/pulse feeder with Bernard™ PipeWorx 300-15 MIG gun. Tweeco®-style connectors. See literature M/6.55</td>
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<tr>
<td><strong>MIG (GMAW) and Flux-cored (FCAW) Guns</strong></td>
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<tr>
<td>Spoolmatic® 30A Spool Gun</td>
<td>138831</td>
<td>Requires WC-24 Control. See literature M/1.73</td>
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<tr>
<td>WC-24 Control</td>
<td>137549</td>
<td>See literature M/1.73</td>
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<tr>
<td>XR™ Wire Feeder Control and Guns</td>
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<td></td>
<td></td>
<td>See literature M/1.7 through M/1.74</td>
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<tr>
<td><strong>TIG Welding</strong></td>
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<td><strong>Multiple Operator Welding</strong></td>
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<td><strong>Plasma Cutting</strong></td>
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<tr>
<td><strong>Stick/TIG Remote Controls</strong></td>
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<tr>
<td>ArcReach® Stick/TIG Remote</td>
<td>301325</td>
<td>Provides remote control of stick and TIG processes without a control cord</td>
<td></td>
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<tr>
<td>Wireless Remote Hand Control</td>
<td>300430</td>
<td>Hand control with wireless 300 ft. (91.4 m) operating range</td>
<td></td>
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<tr>
<td>Wireless Antenna Kit</td>
<td>300749</td>
<td>Recommended for improved reception</td>
<td></td>
<td></td>
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<tr>
<td>RHC-14 Hand Control</td>
<td>242211020</td>
<td>Hand control with 20 ft. (6 m) cord</td>
<td></td>
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<tr>
<td>RMS-14 On/Off Control</td>
<td>187208</td>
<td>Remote contactor control</td>
<td></td>
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<tr>
<td>RCC-14 Remote Contactor and Current Control</td>
<td>151086</td>
<td>Fingertip control</td>
<td></td>
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<tr>
<td>PRHC-14 Hand Control</td>
<td>195511</td>
<td>Hand control with 120 V GFCI receptacle, 125 ft. (38 m)</td>
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<tr>
<td>Extension Cables</td>
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<td>See page 7</td>
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<tr>
<td><strong>Trailers and Hitches</strong></td>
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<tr>
<td>HWY-Mid Frame</td>
<td>301438</td>
<td>Trailer with lights, fenders and dual hitch. For highway use</td>
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<tr>
<td>Cable Tree</td>
<td>043826</td>
<td>Trailer-mounted cable holder</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2-In-1 Document/Fire Extinguisher Holder</td>
<td>301236</td>
<td>Stores documents and holds a 5-pound fire extinguisher</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Date: ____________________________  Total Quoted Price: ____________________________

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