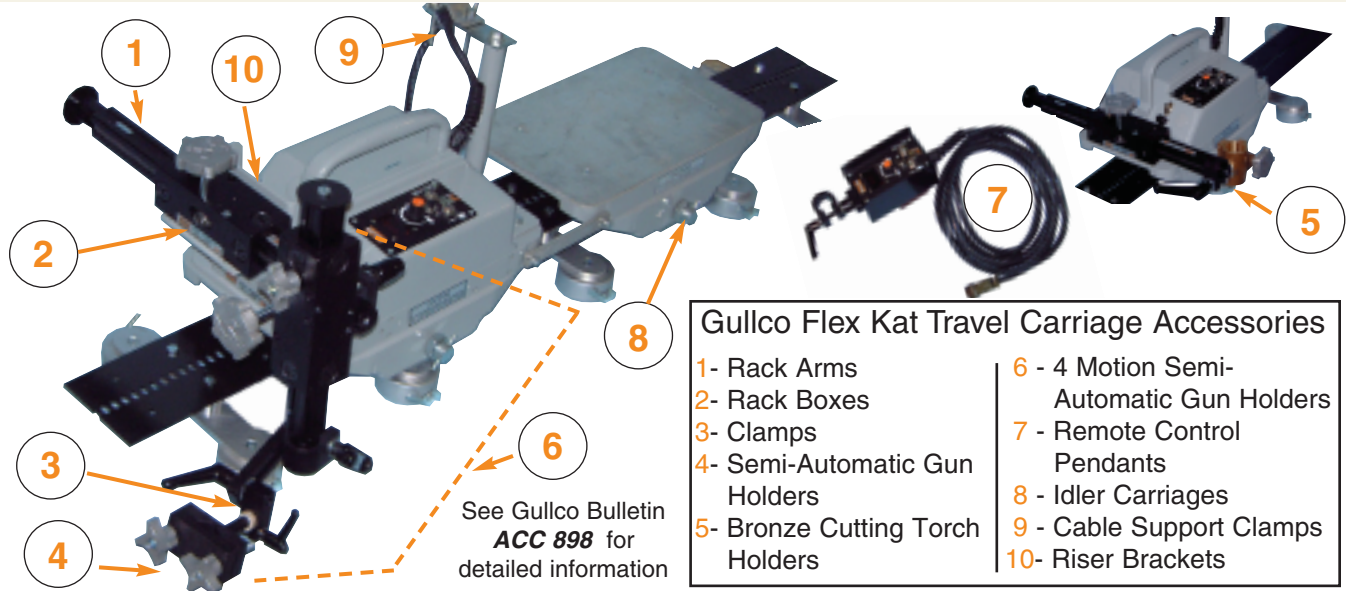


Flex Kat Carriage Is Drilled To Accommodate A Wide Range Of Accessories And Optional Welding/Cutting Systems



- Gullco Flex Kat Travel Carriage Accessories**
- | | |
|---------------------------------|---|
| 1- Rack Arms | 6 - 4 Motion Semi-Automatic Gun Holders |
| 2- Rack Boxes | 7 - Remote Control Pendants |
| 3- Clamps | 8 - Idler Carriages |
| 4- Semi-Automatic Gun Holders | 9 - Cable Support Clamps |
| 5- Bronze Cutting Torch Holders | 10- Riser Brackets |

See Gullco Bulletin ACC 898 for detailed information

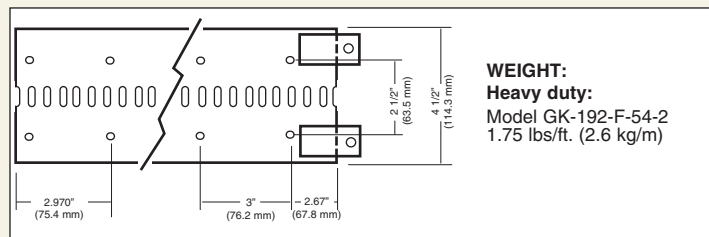
FLEX KAT TRACK AND MOUNTING DEVICES

Gullco Heavy Duty "Flex-Track" is specifically designed for use with Gullco "Flex-Kat" all-position Travel Carriages. Flex-Track is made from specialty tempered spring steel and can be easily mounted to conform with curved surfaces. This Flex-Track can be used in applications involving curved surfaces 60" (1524 mm) diameter and greater. The track is securely mounted on ferrous materials using round or square magnet assemblies and vacuum mount assemblies for non-ferrous materials.

VACUUM TRACK MOUNTING ASSEMBLIES



ROUND AND SQUARE MAGNET TRACK MOUNTING DEVICES



Flex-Track Stiffener

Extruded aluminum for attachment to Gullco Flex-Track sections for "rigid track" applications. Supplied in 8 ft. (2438 mm) lengths.

KAT FLEX-TRACK HEAVY DUTY FLEX-TRACK Model GK-192-F-54-2

Supplied in 8 ft. (2438 mm) lengths. Also available in custom lengths up to 8 ft. (2438 mm) with interlocking ends to facilitate complete circles for diameter 60" (1524 mm), O.D. & I.D. and over. **Tracks are easily joined for continuous runs.** Other lengths available on request.

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"KAT" FLEXIBLE TRACK TRAVEL CARRIAGE SYSTEM

PROGRAMMABLE - LOW VOLTAGE - ALL POSITION - VARIABLE SPEED
 INCORPORATING GULLCO'S HIGHLY VERSATILE "G TYPE" CONTROL
 Reliable automation that improves quality and reduces costs in welding and cutting operations



The Gullco Flex Kat is used throughout the world to automate a wide variety of welding and cutting operations. It is a rugged, reliable precision travel carriage designed for use on **flexible track** which enables it to operate on straight or curved surfaces along any plane. Gullco manufactures several systems and accessories designed for use with the Flex Kat ...making it one of the most versatile pieces of welding/cutting automation equipment available.

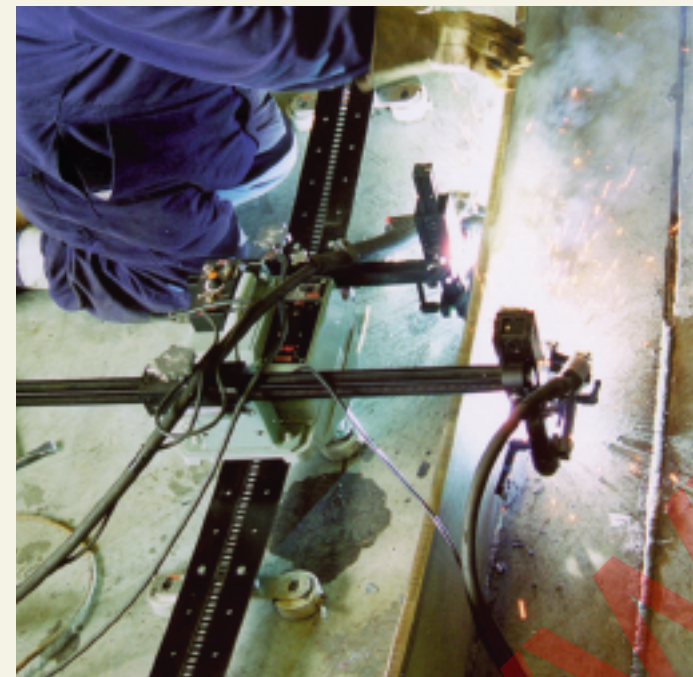
Gullco also produces a "Kat" designed for use on rigid track...ask for Gullco Bulletin RKGSP-12/03



GULLCO FLEX KAT AUTOMATED WELDING SYSTEMS

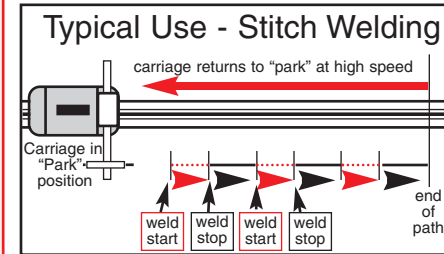
The Gullco Flex "KAT" carriage is used throughout the world to automate and improve the quality and efficiency of single or multiple "head" welding/cutting operations. Welding guns or cutting torches mounted on the "KAT" carriage move along flexible Gullco "Flex Track" at precisely controlled speeds along the desired path in forward or reverse direction. Gullco's Flex "KAT" carriage enables welding guns or cutting torches to operate with precise motion from start to finish regardless of the number of passes or the work pieces involved, improving the quality, efficiency and repeatability of the process. Poor or awkward accessibility, operator fatigue, or inconsistent workmanship are eliminated.

This unit is designed for operation on curved surfaces as the flexible track can be positioned to follow the contour of the workpiece. The self-aligning wheel system of the carriage grips the top and bottom of the track, enabling it to travel along any plane. The adjustable wheel assembly keeps the carriage snug to the track, while allowing it to be easily mounted and removed from the track at any point. The positive drive of the "KAT" is obtained from a uniquely designed sprocket that engages with slots in the track, driven by a low voltage permanent magnet motor and gear-head power unit assembly.



Auto-Weld Flex Kat Carriage

The Kat Auto-Weld Carriage option enables a wide variety of automated weld and cutting overlay cycles that can be repeatedly performed. The GSP control in this unit controls travel direction/speed and length of travel path and synchronizes them with precise weld start and weld stop settings. This travel carriage is pre-drilled for mounting Auto-Weld accessories (sold separately). It is ideal for stitch welding and seam welding applications where



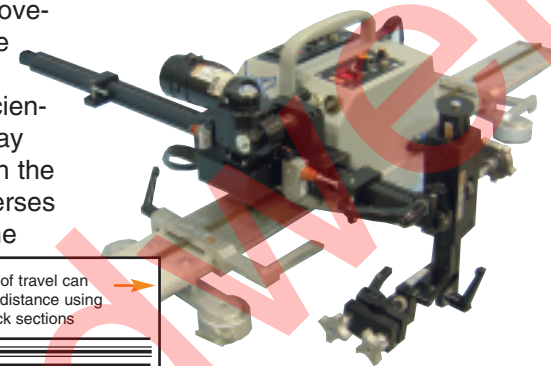
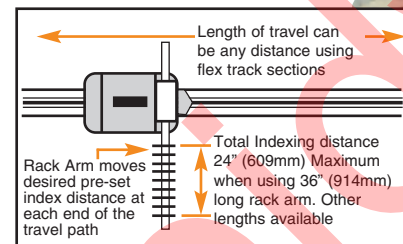
repeatability is desired. The reliability and precision of this automated welding/cutting system reduces cost, adds efficiency and improves quality.



SEE BULLETIN
GKA-00-04
FOR
DETAILS **A**

Indexing Rack Box & Flex Kat Carriage System

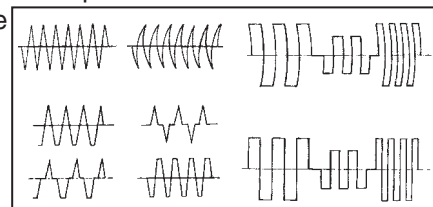
The Indexing option Flex Kat uses a GSP control that combines control of the carriage movement and start/stop parameters with precise indexing of the torch at the end of the path. This fully automates and increases the efficiency of overlay welding operations, flame spray work, hard facing etc. At the end of the path the travel carriage automatically stops and reverses direction while at the same time indexing the gun/torch. It can be programmed to weld or not weld during indexing. Carriage is pre-drilled for quick mounting of indexing unit (sold separately).



SEE BULLETIN
GKI-00-04 FOR
DETAILS

Flex Kat Carriage & Oscillator Head System

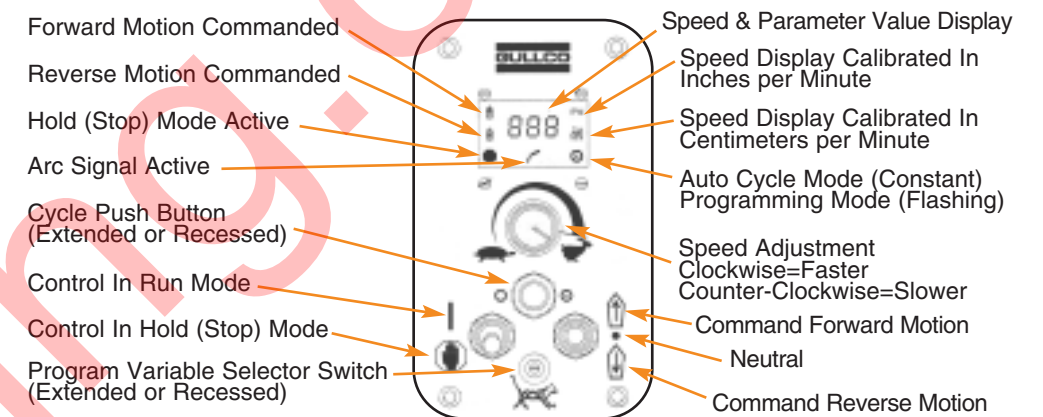
The Kat Carriage Oscillator Head Combination System combines welding gun oscillation movement with precise travel speed to produce a wide variety of angular and step weld patterns. With this option the Kat's GSP control directs both the carriage travel speed/direction and the weld gun movement/ operation. This enables pre-setting of stroke speed, oscillator and carriage dwell times and carriage delay/start after wire feed start. The system can also be programmed to allow dwell times to remain in a pre-set position during "no dwell" oscillation. The oscillator head (sold separately) is an independent unit that can be easily adjusted side-to-side or forward/backward to provide the most effective angle for multi-pass oscillation.



SEE BULLETIN
GKO-00-04 FOR
DETAILS

GSP CONTROL

The Gullco Standard Platform range of controls have switching for forward/neutral/reverse, run/ stop, Manual/Auto & program variable increment/decrement (where applicable) and a rotary encoder for speed control. This micro-processor based, 24 volt DC motor control can be supplied to provide a variety of "optional" functions such as indexing, weld oscillation and auto-weld. The selected "option" function and carriage travel speed/direction are directed by a single GSP control. This ensures high levels of accuracy, quality and reliability.



Select a speed, voltage and option to configure a Kat specifically suited to your needs...

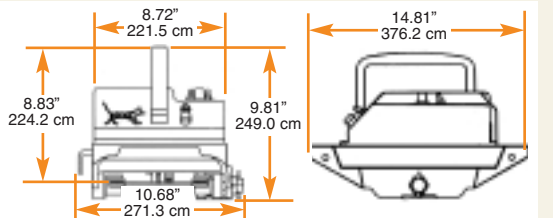
GK-200- [] [] [] - []

SPEED RANGES	
MODEL	SPEED RANGE
FL	0.8 to 25.8 IPM (2 to 65.4 cm/min)
FM	1.5 to 51.5 IPM (3.9 to 131 cm/min)
FH	4.2 to 139.1 IPM (10.6 to 353 cm/min)

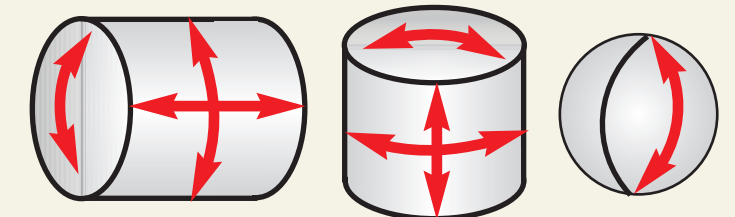
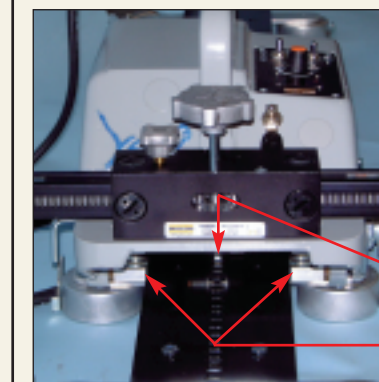
VOLTAGES	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC

SPECIFICATIONS

Weight: 29lbs. (13kg.)
Vertical load capacity: 100lbs. (45kg.)
Drive Motor: 24 VDC permanent magnet gear motor
Supply Voltage: 42, 115 or 230 VAC, single phase, 50/60 Hz., 200 watts
Complies with: C.S.A. & CE Certification



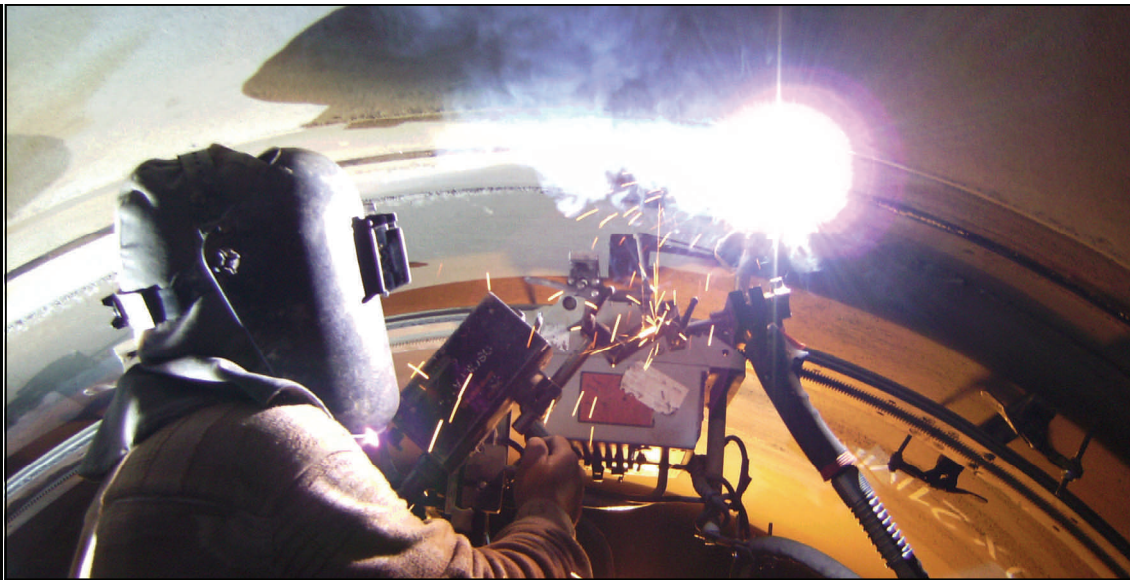
Unique Drive System And Wheel Assemblies Enable Travel In All Positions Including Overhead



Ball studded drive sprocket engages apertures in track
 Self-aligning "V" wheel assemblies run on both top and bottom of track...enabling operation on any plane

STEPPER MOTOR ELECTRONIC RADIAL AND LINEAR OSCILLATOR**NEW***Linear or Radial Oscillation ***Made for Rigid or Flexible Track***ALL POSITION WELDING AND CUTTING AUTOMATION**

WELDING AND CUTTING AUTOMATION

WWW.GULLCO.COM



Models For All-Position Flat or Curved Surface Weld Oscillation....

The Gullco Kat/Oscillator "Combo" is comprised of the Compact Oscillator head, controls, mounting brackets, connecting cable, 1-1/8" heavy duty micro fine rack boxes with rack arms for horizontal and vertical adjustments and standard MIG gun holder, together with a Kat carriage for **rigid track** or **flex track** as shown above.

Model Series GK-200-F (left) is supplied with a Gullco Kat specifically designed for operation on spring steel Kat Flexible Track.

Model Series GK-200-R Combo (right) is supplied with a Kat specifically designed for operation on rigid aluminum Kat track.

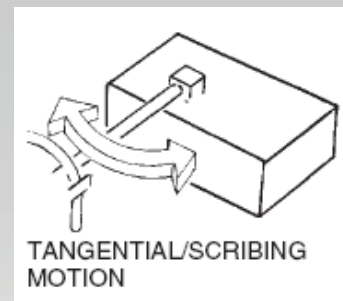
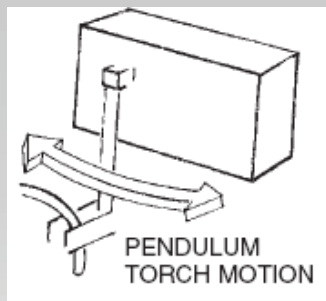
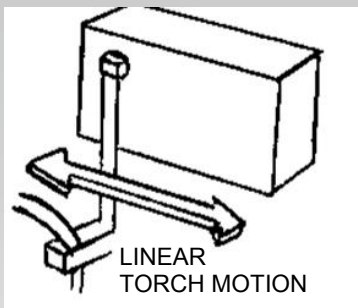
All are equipped with the Gullco micro processor-based programmable control with a closed loop feedback for complete speed accuracy regardless of load [0-100 lbs. (45kgs)] when operating in any weld position.

Detailed information is provided on the back page of this brochure.

Also Available....Linear or Radial Separate Remote Controlled Compact Oscillator Assembly- Model GK-201-100-RC

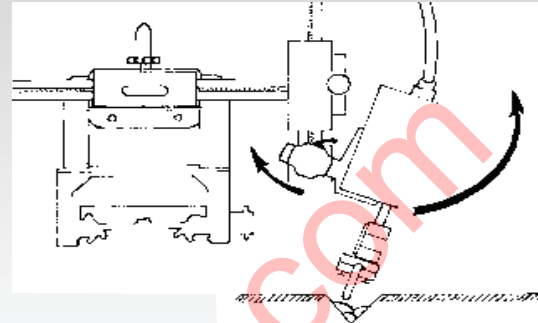
This assembly is comprised of either radial or linear Oscillator Head with MIG gun holder; Remote Control Box; Control Cable; Micro Fine Rack Boxes; Rack Arms: and Brackets. It can be mounted on existing KAT All-Position Travel Carriages, Welding Head Manipulators, Side Beam Carriages, etc.





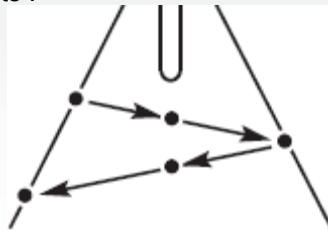
EXCLUSIVE TANGENTIAL AND PENDULUM OR LINEAR MOTION

The combination oscillator heads are capable of producing three distinct motions when mounted in either the horizontal or vertical position. Shown in the above left is a tangential or scribing motion. The other, (right) is a pendulum motion. Combined with the third linear straight line head they meet all welding oscillation requirements .



MOTORIZED CENTRE LINE ADJUSTMENT

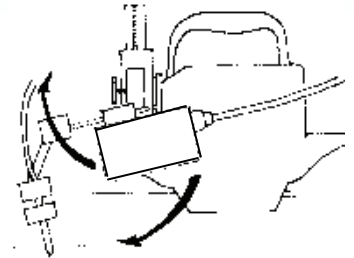
With independent, electronically controlled dwells (0-5sec.) at each end of the stroke and at the centre of the stroke path.



The proper torch angle/position is established quickly and easily with the Gullco Kat/Oscillator "Combo". It's simply a matter of tilting the oscillator, which can be adjusted side to side or forward/backward... eliminating the time consuming and generally ineffective procedure of tilting the carriage or track.

MOTORIZED STROKE WIDTH- Easy, precise adjustment to provide the required weld pattern.

OSCILLATION SPEED CONTROL- Oscillation speed electronically controlled by speed potentiometer (140 inches per minutes (linear) 45° per second (radial)).

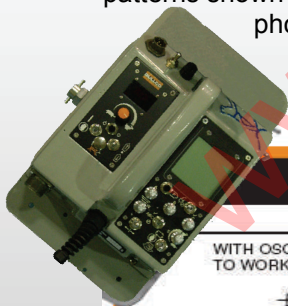


...Combining High Precision With Exceptional Versatility

High Precision, state-of-the-art controls on the Kat carriage automatically direct the desired forward/reverse movement or dwell of the welding gun and its oscillation motion to produce the numerous weld patterns shown below. The carriage control (left in photo) enables the carriage speed and direction to be pre-set and shown on

its LED display in ipm or cm/min. The oscillator controls at right enable pre-setting and carriage delay/start after wire feed start, dwell times, stroke speed, stroke width, program storage and cycle start.

Control information is available on the following page

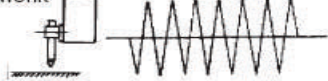


Some of the Weld Patterns Attainable With The Gullco "Kat"/Oscillator "Combo"

ANGULAR OSCILLATION PATTERN

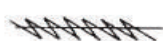
KAT CARRIAGE TRAVELS CONTINUOUSLY

WITH OSCILLATOR HEAD VERTICAL TO WORK

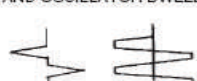


SPECIAL OSCILLATION

Tilted - for welding on horizontal plane



COMBINING OSCILLATION AND OSCILLATOR DWELL



Straight Line - Back and forth oscillation



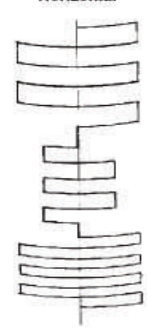
STEP OSCILLATION PATTERN

KAT CARRIAGE TRAVELS ONLY DURING END DWELLS

Oscillation Head Vertical



Oscillation Head Horizontal



KAT CARRIAGE OSCILLATOR COMBINATION

GULLCO



LINEAR or RADIAL

This advanced oscillation “package” is designed to **increase production** and improve the quality of the weld produced in automatic mechanized welding operations by **minimizing weld defects** such as poor penetration, incomplete fusion, overlap and undercut.

The GK-200 Series compact oscillator carriage combination comes with the option for **linear or radial oscillation head** and can be equipped for use on either rigid or flexible track.

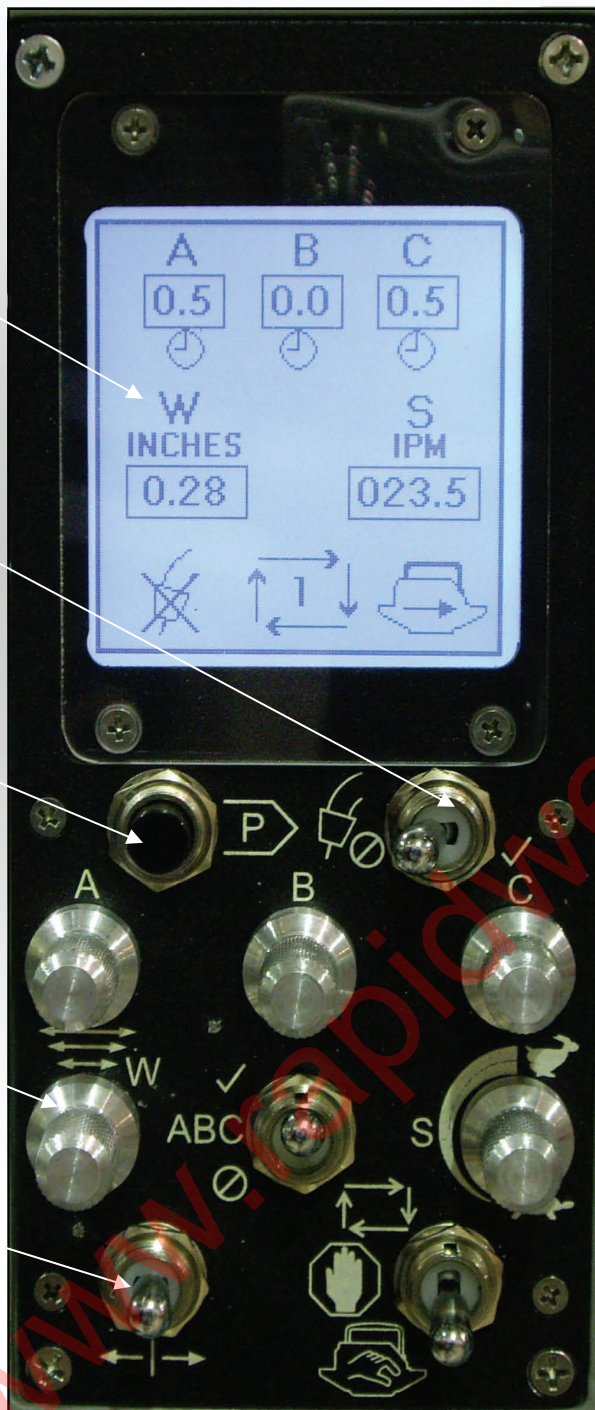
The oscillator is available with a linear, pendulum, tangential or step (square pattern) motion to the welding gun with adjustable **motorized stroke width**, infinitely variable stroke speed adjustment, three independent position dwell times, **motorized centre line positioning** and automatic wire feed start and travel start/stop interface.

By combining welding gun oscillation movement with the precision controlled travel speed of the Kat carriage, up to **10 weld programs** can be produced and stored.

Remote Control



LINEAR or RADIAL



DIGITAL DISPLAY

ARC START CONTROL

STORE UP TO 10 PROGRAMS

MOTORIZED OSCILLATION WIDTH

MOTORIZED CENTERLINE POSITIONING

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GULLCO



KAT CARRIAGE/COMPACT OSCILLATOR

This advanced oscillation “package” is designed to increase production and improve the quality of the weld produced in automatic mechanized welding operations by minimizing weld defects such as poor penetration, incomplete fusion, overlap and undercut.

It combines the Gullco kat all-position travel

carriage with the Model GK-200 Series Compact Oscillator head and its controls which are incorporated in the carriage.

The oscillator imparts a pendulum, tangential or step (square pattern) motion to the welding gun with adjustable stroke widths.





Models For All-Position Flat or Curved Surface Oscillation....

The Gullco Kat/Oscillator "Combo" is comprised of the Compact Oscillator head, controls, mounting brackets, connecting cable, 1-1/8" heavy duty micro fine rack boxes with rack arms for horizontal and vertical adjustments and standard MIG gun holder, to-

Model Series GK-200-R-O Combo (left) is supplied with a kat specifically designed for operation

Model Series GK-200-F-O Combo (right) is supplied with a Gullco kat specifically designed for

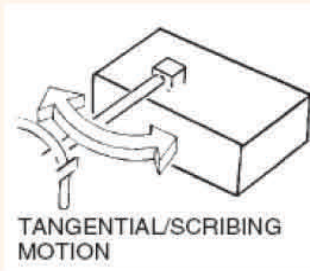
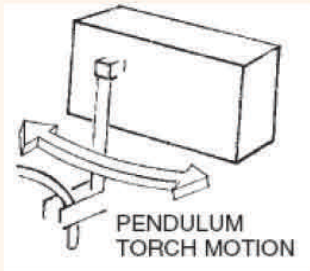
All are equipped with the Gullco micro processor-based programmable control with a closed loop feedback for complete speed accuracy regardless of load [0-100 lbs. (45kgs)] when operating on any plane.

Also Available....

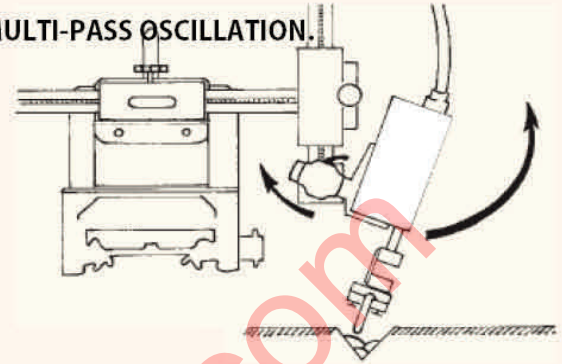
Separate Remote Controlled Compact Oscillator Assembly- Model GK-197-001-RC

This assembly, is comprised of Oscillator Head Model GK-197-O-100 with MIG gun holder; Remote Control Box; Control Cable; Micro Fine Rack Boxes;





Only The Gullco "Combo" Has It....
 OSCILLATOR HEAD TILTS INDEPENDENTLY
 ENABLING TORCH TO BE POSITIONED AT
 EXACTLY CORRECT ANGLE FOR EFFECTIVE
 MULTI-PASS OSCILLATION.

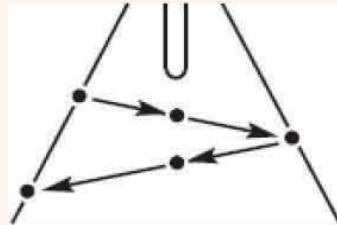


EXCLUSIVE TANGENTIAL AND PENDULUM MOTION

The oscillator head is capable of producing two distinct motions when mounted in either the horizontal or vertical position

INDEPENDENT DWELLS

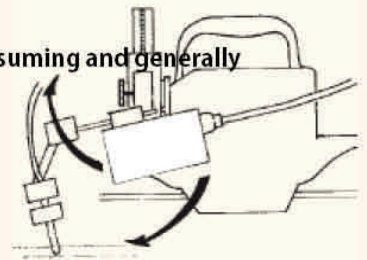
Independent, electronically controlled dwells (0-5sec.) at each



ADJUSTABLE STROKE WIDTH- Easy, precise adjustment to provide the required weld pattern.

OSCILLATION SPEED CONTROL- Oscillation

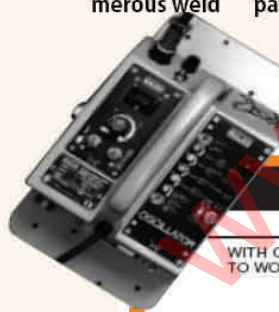
The proper torch angle/position is established quickly and easily with the Gullco Kat/Oscillator "Combo". It's simply a matter of tilting the oscillator, which can be adjusted side to side or forward/backward... eliminating the time consuming and generally



...Combining High Precision With Exceptional Versatility

High Precision, state-of-the-art controls on the kat carriage automatically direct the desired forward/ reverse movement or dwell of the welding gun and its oscillation motion to produce the numerous weld patterns shown below. The carriage control (left in photo) enables the carriage speed and

direction to be pre-set and shown on its LED display in lpm or cm/min. The oscillator controls at right enable pre-setting of and carriage delay/start after wire feed start. A dwell on/off stroke speed,

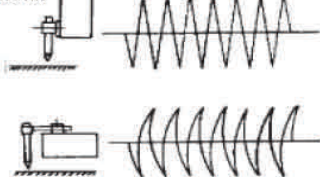


Some of the Weld Patterns Attainable With The Gullco "Kat"/Oscillator "Combo"

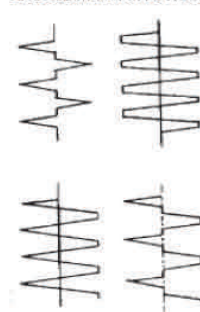
ANGULAR OSCILLATION PATTERN

KAT CARRIAGE TRAVELS CONTINUOUSLY

WITH OSCILLATOR HEAD VERTICAL TO WORK



COMBINING OSCILLATION AND OSCILLATOR DWELL



SPECIAL OSCILLATION

Tilted - for welding on horizontal plane



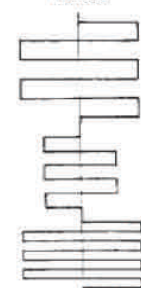
Straight Line - Back and forth oscillation



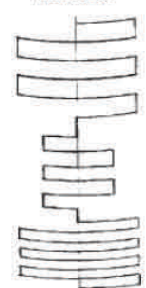
STEP OSCILLATION PATTERN

KAT CARRIAGE TRAVELS ONLY DURING END DWELLS

Oscillation Head Vertical



Oscillation Head Horizontal





Kat carriage oscillator combination

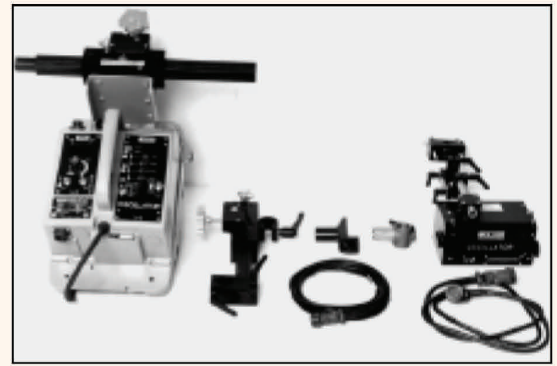
Specifications:

The Gullco kat Carriage/Oscillator "Combo" is available in two series of models to suit your specific application requirements.

Model GK-200-R-O: incorporates kat for use on rigid track

Model GK-200-F-O: incorporates kat for use on flexible track

The compact Oscillator is also available as a separate, remote controlled unit designated Model GK-197 -001-RC.



Gullco Kat Travel Carriage

Equipped with heavy duty wheel assemblies (Rigid Kat Track only). Controlled by Gullco micro processor-based 24 Volt D.C. programmable control with closed loop tack feedback system for complete speed accuracy, regardless of load, 0 to 100 lbs (0-45 kgs.) when operating in any

Compact Oscillator Head and Control

Independent Oscillator Head, Model GK-197-O-100 with 72" (1828.8mm) control cable; bracketry to provide both tangential and pendulum motion; stroke width adjustable 0 to 1.94" (49.3 mm) at 6" (152.4mm) extension; output torque 5lbs/ft. (80 kgs/cm); electronic Oscillator controls with speed potentiometer covering oscillation speed range 8 to 188 cycles/ minute; independent dwells at each end of stroke and at the center of stroke; variable from 0 to 5 seconds; automatic wire feed start; adjust-

Micro Fine Rack Boxes, Rack Arms and Brackets

1-1/8" (28.6 mm) Micro Fine Rack Box with 18" (457.2 mm) Rack Arm to provide 10" (254 mm) horizontal oscillator adjustment; 1-1/8" (28.6mm) Rack Box with 12" (304.8mm) Rack Arm to provide 4" (101.6mm) vertical

"KAT" CARRIAGE/COMBO SPEED RANGES

Model	Speed Ranges	
	in/min	cm/min
GK-200-RL-O	0.5 to 16.4	1.2 to 41.6
GK-200-RM-O	1 to 32.7	2.5 to 83.1
GK-200-RH-O	2.7 to 88.4	6.7-224

Note: The above standard speed ranges can be lowered or increased using optional gear train attachments available from Gullco.

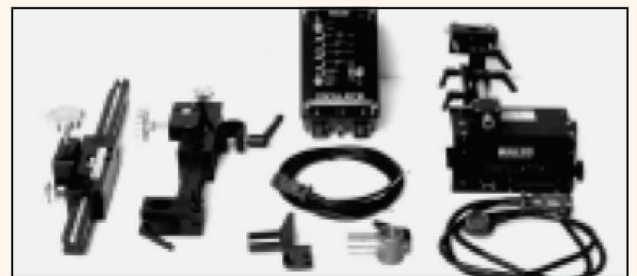
Model GK-200-F- Flex Track System

Model	Speed Ranges	
	in/min	cm/min
GK-200-FL-O	0.8 to 25.8	2 to 65.4
GK-200-FM-O	1.5 to 51.5	3.9 to 131
GK-200-FH-O	4.2 to 139.1	10.6-353

SEPARATE REMOTE CONTROL COMPACT OSCILLATOR MODEL

GK-197-001-RC

Includes independent Compact Oscillator Head Model GK-197-O-100 with MIG gun holder, Micro Fine rack boxes, rack arms and brackets as listed above and 72" (1828.8mm) control cable. The remote control box has the same controls as incorpo-



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GULLCO



KAT TRAVEL CARRIAGE AUTO-WELD COMBINATION

MODEL GK-200-RLA

For use on *Kat Rigid Track*

MODEL GK-200-FLA

For use on *Kat Flexible Track*

The Kat Carriage **Auto-Weld** enables a wide variety of automated welding cycles that can be repeatedly performed along any plane. The advanced Auto-Weld control monitors, via distance travelled, and responds to limit switches mounted on the Kat which in turn respond to adjustable activators mounted at appropriate positions on the Kat Track. Travel direction/speed and length of travel path are synchronized with precise weld start and weld stop settings. By combining different control settings and limit switch activator positions, a wide variety of welding cycles can be repeatedly performed. The Kat Auto-Weld Combination is ideal for stitch welding and seam welding applications where repeatability and accuracy are desired. The reliability and precision of this automated welding system reduces cost, adds efficiency and improves quality.

AUTO-WELD CONTROL SYSTEM

provides settings to establish:

- Operating position
- Travel start delay after arc start signal, adjustable 0 - 9.9 seconds.
- Crater fill delay, allowing the wire feed signal to stay active after carriage stop, adjustable 0- 9.9 seconds.
- Post weld delay, sets a delay adjustable 0 - 9.9 seconds after each crater fill delay for burnback or postflow to occur.
- Weld direction- forward, reverse, or "forward & reverse"
- Center limit switch use, to enable rapid traverse to weld start point using center limit switch.*
- Stitch weld electronically programmed using carriage travel distance, adjustable 0.1 - 99.9 in. or cm.
- Stitch no weld electronically programmed using carriage travel distance, adjustable 0.1 - 99.9 in. or cm.
- Automatic carriage return to home. Limit switch activated.
- Continual forward and reverse of carriage using limit activators.

*Note: Centre Limit Switch Activator to be supplied by customer



SPECIFICATIONS



GULLCO SPECIFICATIONS

"Kat" Travel Carriage/Auto Weld Combination comprises:

Gullco Auto-Weld Kat Travel Carriage with heavy duty self-aligning wheel assemblies, closed loop tack feed back for accurate speed control when running in any plane, regardless of load. Maximum 100lbs. (45kgs). Carriage is controlled by the new Gullco low voltage 24 volt GSP microprocessor pulsed width modulation motor control, interfacing with the forward/stop/reverse switch and infinitely variable 4- turn speed potentiometer. LED display in IPM or cm/min and with a ten position rotary switch to adjust various functions. (shown on other side of page) Operates on 42, 115 or 230 volts, single phase, 50/60 Hz A.C. power supply. Please specify voltage/speed when ordering. **(see below)**

Limit Switches - 3 limit switches are mounted on the outside of the carriage. One each for forward, reverse and centre limit for weld start positioning and weld on/off activation.

Adjustable Park and End Limit Switch Activators - for mounting on Gullco Kat Rigid or Flex Track. Centre limit switch activator(s) to be supplied by the customer.

Optional Remote Pendant Control Kit - Uses GSP control removed from Kat Carriage...enabling remote operator control of the Auto-Weld unit.

See below for details

NOTE: Gullco also has Kat Carriage models available with controls for Oscillation (Bulletin GKO-00-04) and Indexing (Bulletin GKI-00-04). Contact Gullco for copies.

RIGID KAT AUTO-WELD

MODEL	SPEED RANGE
L	0.5 to 16.4 IPM (1.2 to 41.6 cm/min)
M	1 to 32.7 IPM (2.5 to 83.1 cm/min)
H	2.7 to 88.4 IPM (6.7 to 224 cm/min)

Select a speed and voltage to determine your Rigid Kat Auto-Weld Combination Model Number

VOLTAGES	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC

REMOTE PENDANT CONTROL KIT

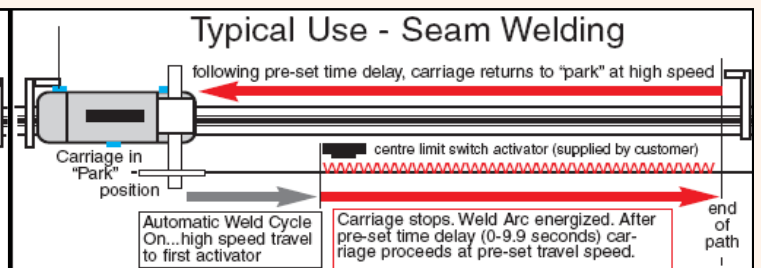
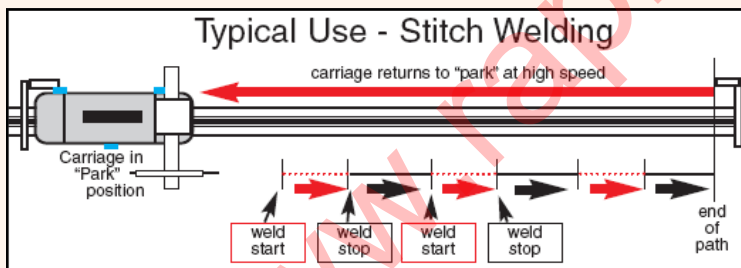
...for use with Rigid/Flex Kat Auto-Weld systems.
- Comprising Remote Pendant (no control) attached to 8 ft (843.84 cm) control cable one end and KAT control blanking plate other end with internal connectors at each end. This remote pendant uses the GSP control removed from the "KAT" Carriage. **This kit can be easily field installed (or factory installed at no charge)**

FLEX KAT AUTO-WELD

MODEL	SPEED RANGE
L	0.8 to 25.8 IPM (2 to 65.4 cm/min)
M	1.5 to 51.5 IPM (3.9 to 131 cm/min)
H	4.2 to 139.1 IPM (10.6 to 353 cm/min)

Select a speed and voltage to determine your Flex Kat Auto-Weld Combination Model Number

VOLTAGES	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC



for detailed information on:

- Gullco Rigid Kat Travel Carriages Ask For Bulletin **RKGP-12/03**
- Gullco Flex Kat Travel Carriages Ask For Bulletin **FKGP-12/03**
- Gullco Kat Track Ask For Bulletin **GKT 10/03**

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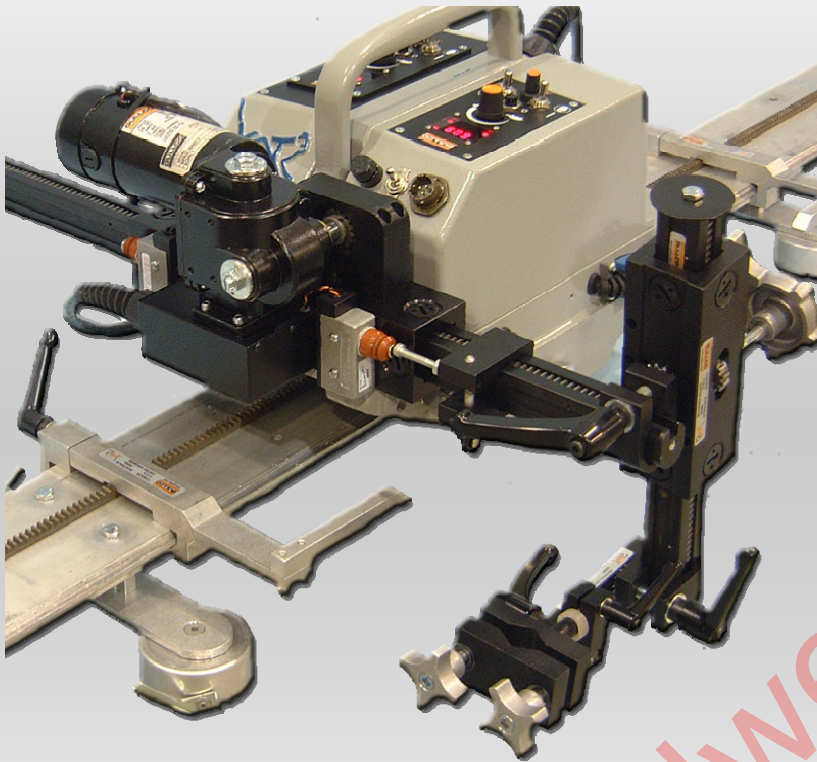
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KAT TRAVEL CARRIAGE/ INDEXER COMBINATION



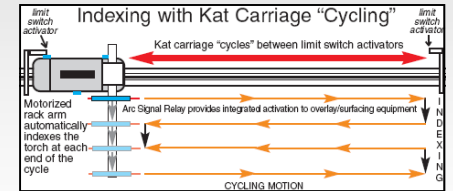
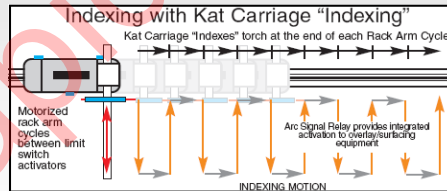
The Gullco **Kat** Indexing System is typically used to automate single or multi-head overlay/cladding welding operations, hard surfacing, etc. The automatic routine drives a motorized device (either the Kat carriage or the motorized rack arm), **cycling** back and forth between limit switches. When the device that is cycling reaches a limit switch, it pauses, and the other motorized device starts to index the gun/torch a preset distance in a preset direction.

An **Arc Signal Relay** is supplied with the system to provide integrated arc activation signals to the overlay/surfacing equipment. Two GSP controls, each with dedicated microprocessor chips, are used to control the automatic, two axis indexing system. One GSP control is the **Cycle Control** and the other is the **Index Control**. Each control offers user programmable parameters/variables to allow fine-tuning and functional control of the automatic cycle.

Gullco Indexing Systems, enable repetitive overlay-surfacing cycles to be preformed, with precise motion of the gun/torch from start to finish, regardless of the number of passes of the work pieces involved.



A Remote Control Pendant Is Available When Required



Automates Overlay/ Cladding Welding Operations*

MODELS AVAILABLE FOR USE WITH FLEXIBLE OR RIGID TRACK



WELDING AND CUTTING AUTOMATION



KAT TRAVEL CARRIAGE INDEXER COMBINATION

SPECIFICATIONS

Main Components: Kat Travel Carriage (Flex Kat for use on flexible track of Rigid Kat for use on rigid track), Kat Carriage/Indexer controls, Motorized Indexer Rack Box, Heavy Duty Rack Arm, Control Cable, Limit Switch activators for Carriage and Rack Arm, Torch Holder for standard MIG gun.

Controls: Two GSP controls mounted in the Kat, each with dedicated microprocessor chips, are used to control the automatic, two axis indexing system. One drives the Kat, carriage; and one drives the motorized rack arm. They provide: Auxiliary wire feeder on/off, 16 Position Switch giving selectable index increments, Maximum travel of 24" (609 mm) using 36" (914 mm) long rack arm, Two Digit Display indicating time that rack arm will index, Kat Carriage Forward/ Reverse Switch and Carriage speed potentiometer, rack arm Jog Switch and Left/Off/Right switch, Auto On/Off switch, LED display.

Indexing Motorized Rack Box: Complete with limit switches and activators to prevent rack arm overrun, high torque gear motor to provide precise repeatability of the rack arm indexing distance. Standard assembly combines heavy duty 8" (203 mm) long rack box with 1-1/8" (29 mm) sq. x 36 (914 mm) long rack arm. Other lengths available

Flex or Rigid Kat Travel Carriage: with microprocessor pulse width modulation motor controls offering operator interface of forward, stop, reverse and infinitely variable control of the speed, within the range of the models. Travel speeds of the Kat and Rack box are electronically controlled using an optical tachometer on the back of each gear-motor. Through the use of this closed loop, feedback circuitry, each motor control can obtain accurate and constant speed control of the equipment when running in any plane, regardless of the load (within the rating of the equipment). The length of the Kat travel path is pre-set by positioning the Track Stops at each end of the desired path. They engage and activate limit switches on the Kat Travel Carriage to: automatically stop the travel carriage and reverse its movement, activate the control that indexes the rack arm and signals the welding gun to weld or not weld during indexing.

Safety is greatly enhanced by the use of Gullco's low voltage (24V), highly advanced controls and power supply system. Three line voltage inputs, 42, 115 and 230 VAC, single phase, 50/60 Hz, are available (see chart below).

RIGID KAT INDEXER COMBO

MODEL	SPEED RANGE
L	0.5 to 16.4 IPM (1.2 to 41.6 cm/min)
M	1 to 32.7 IPM (2.5 to 83.1 cm/min)
H	2.7 to 88.4 IPM (6.7 to 224 cm/min)

Select a speed and voltage to determine your Rigid Kat Indexer Combination Model Number

GK-200-R -I

VOLTAGES	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC

REMOTE PENDANT CONTROL KIT

...for use with Rigid/Flex Track Kat Indexer systems.
- Comprising Remote Pendant (no control) attached to 8 ft (843.84 cm) control cable one end and KAT control blanking plate other end with internal connectors at each end. This remote pendant uses the GSP controls removed from the "KAT" Carriage. This kit can be easily field installed (or factory installed at no charge)

FLEX KAT INDEXER COMBO

MODEL	SPEED RANGE
L	0.8 to 25.8 IPM (2 to 65.4 cm/min)
M	1.5 to 51.5 IPM (3.9 to 131 cm/min)
H	4.2 to 139.1 IPM (10.6 to 353 cm/min)

Select a speed and voltage to determine your Flex Kat Indexer Combination Model Number

GK-200-F -I

VOLTAGES	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC

Remote Control Indexer for Miscellaneous Rotation Equipment

Comprising of one (1) control box with switches for rack arm jog, cycle start and speed potentiometer. Index distance setting in a range from 0.01 to 9.99 in increments of 0.01. A single limit switch on 15 feet (4572 mm) cable to provide 1/8" (29 mm) rack arm 36" (914 mm) long providing 24" (609 mm) of variable speed arm travel 1 to 32.7" (25 to 83.1 cm) per minute with limit switches to prevent rack arm over-travel and to stop wire feeder. Two (2) adjustable rack arm limit switch stops and one (1) four-motion welding gun holder.



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GULLCO MECHANICAL SEAM TRACKER AND HEIGHT SENSOR SYSTEM

Gullco Mechanical Seam Trackers and Height Sensors are designed for use with the Gullco Kat Travel Carriage to accurately maintain the required, pre-set distance between the gun or torch and the workpiece in automated welding and cutting operations.

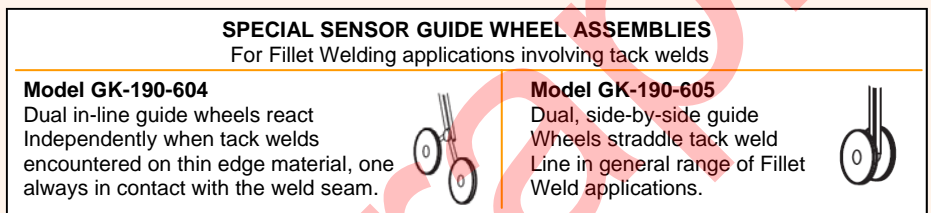
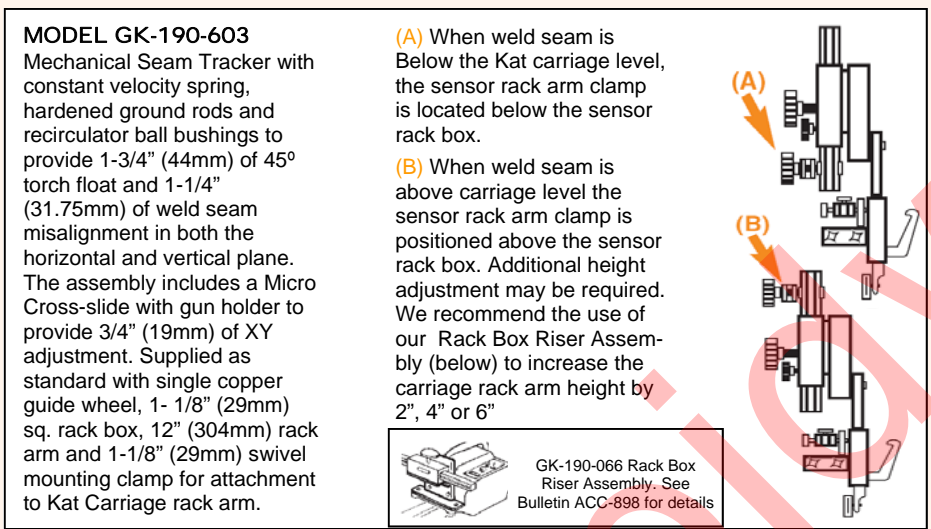
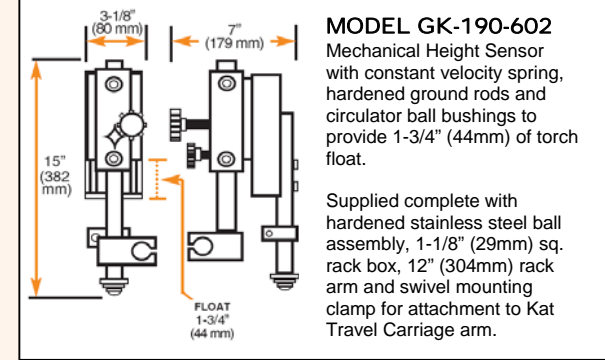
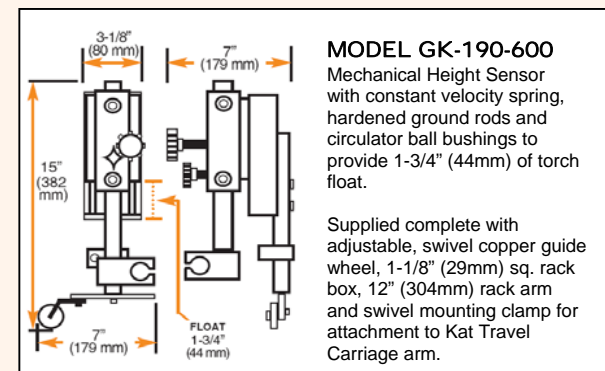
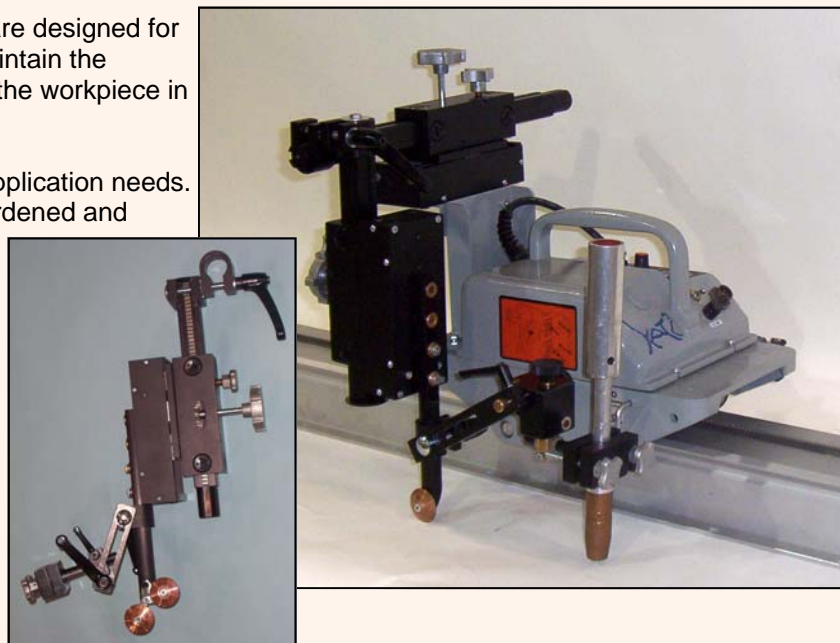
Three models are available to effectively meet various application needs. All are constant velocity, spring-type sensors utilizing hardened and ground slide bars with recirculator ball bushings to provide 1-3/4" (44mm) of torch float.*

Model GK-190-600 Height Sensor has an adjustable swivel copper guide wheel to contact the work surface.

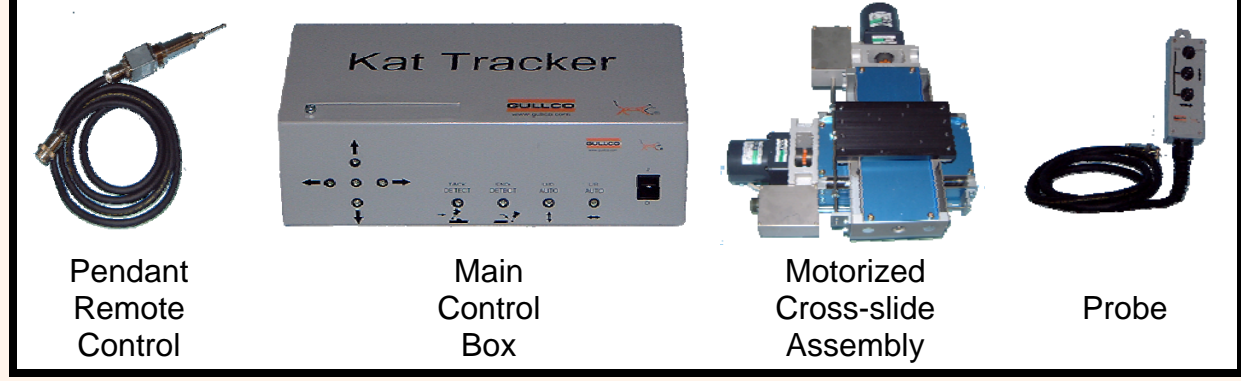
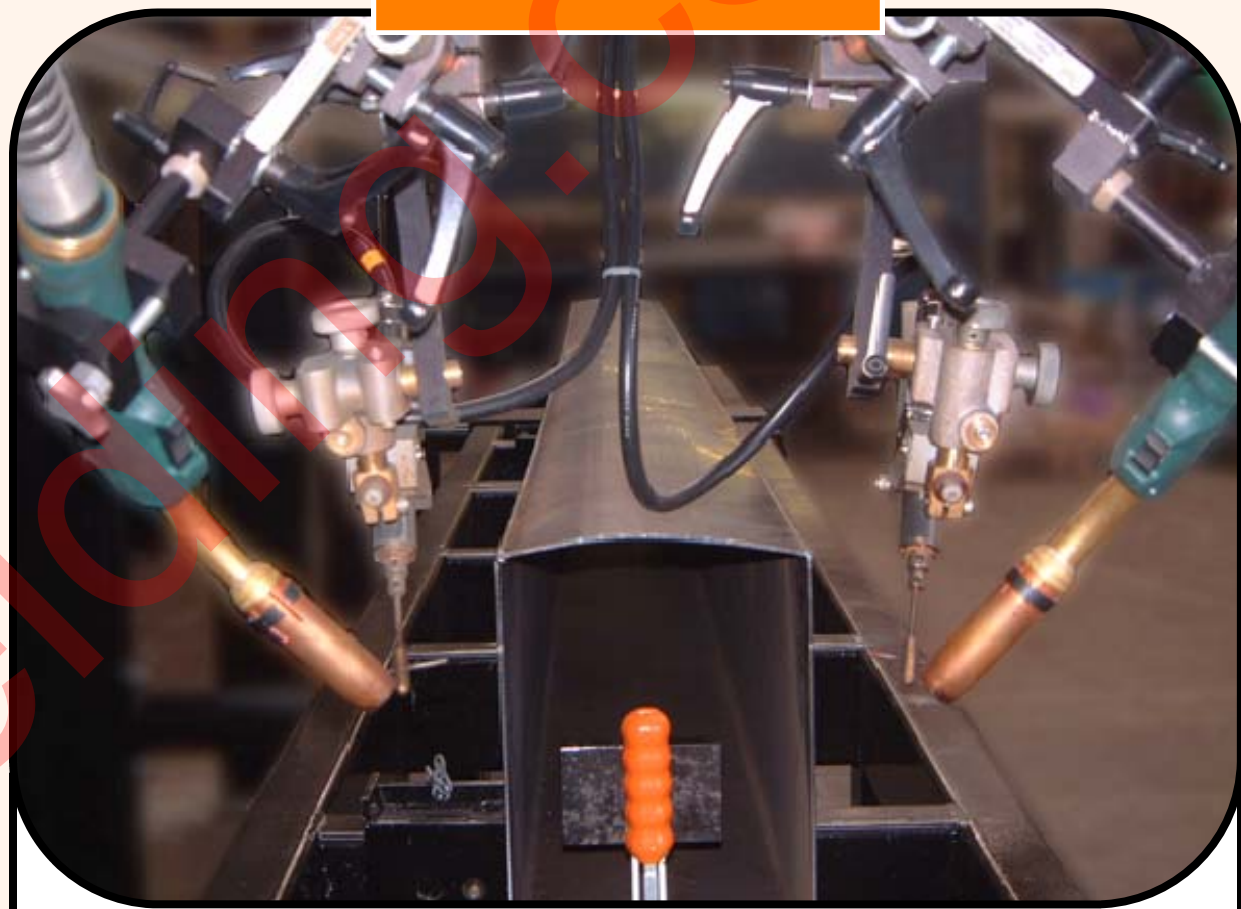
Model GK-190-602 Height Sensor has a stainless steel ball transfer that is particularly useful to maintain contact on curved surfaces or vertical applications.

Model GK-190-603 Seam Tracker is specifically designed for fillet welding applications.

*Other float distances available on request.



GULLCO



KAT TRACKER ELECTRONIC SEAM TRACKING SYSTEM

...high precision tracking system that maintain the torch in optimum operating position regardless of variations in the weld seam...providing improved quality and efficiency in a wide variety of welding operations.



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GULLCO LATIN AMERICA - Phone: 55-11-9485-1336		e-mail: rogerio.macedo@gullco.com

The quality and efficiency achieved with today's automated welding systems can be impaired by material warpage, misalignment, irregular edge fit-up, different material thickness and other conditions that cause variations in the weld seam.

Gullco Kat Tracker restore optimum performance when these conditions are encountered. They continually sense the slightest variation across the weld seam and automatically correct the position of the weld torch.

The trackers are designed for incorporation and use with the Gullco Kat travel carriage system but can readily be used with other travelling and rotating devices employed in automated welding operations.

The systems are effectively employed to cut costs and increase productivity in a wide range of applications such as tank, pressure vessel, pipe and structural component fabrication and deep groove welding operations.

Gullco Kat Trackers are available in standard or heavy duty models to meet virtually all requirements. A brief description of each is provided below.

GULLCO KAT TRACKERS

These Trackers provide precise right/left and vertical/ horizontal tracking plus...

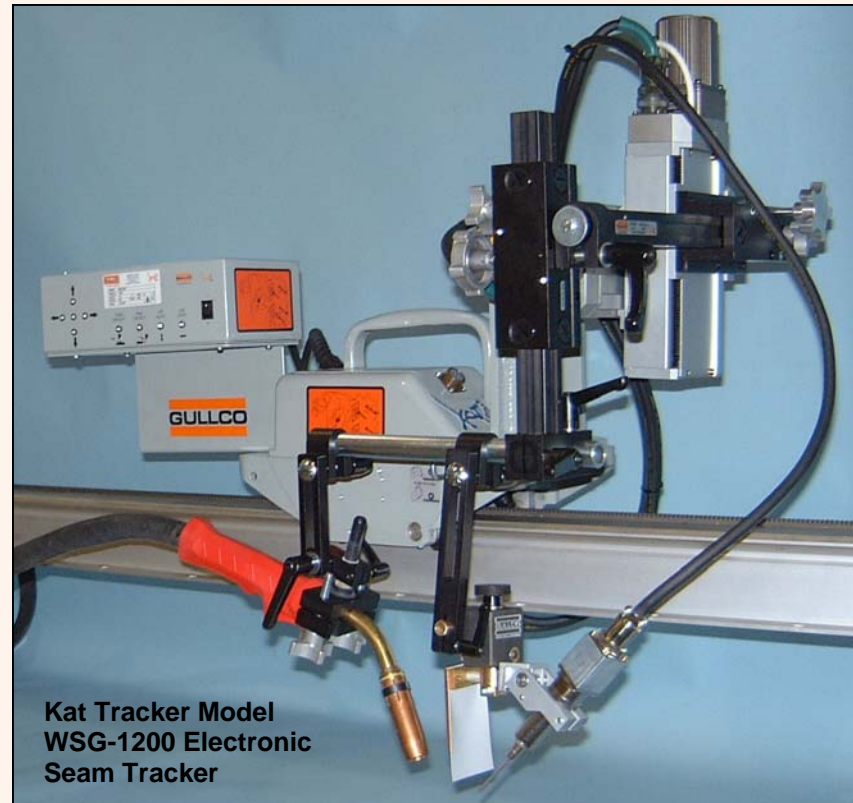
ELECTRONIC "END OF PLATE DETECTION"
-puts the tracking system on "hold"... Preventing the torch from driving into the plate and allowing welding to continue to the plate edge.

ELECTRONIC "TACK DETECTION"
- interrupts the automatic tracking action when a tack-weld is encountered preventing the torch from rising prematurely...and returns the system to normal action when it reaches the end of the tack weld.

Model WSG-1200:
This model has up to 55 lb. (25kg) vertical load capacity at 4" (100mm) extension from the face plate. The standard stroke is 4" x 4" (100x100mm).

Model WSG-2200:
The heavy duty version of model WSG-2200 with a vertical load capacity up to 220lbs. (100kg) at 6" (150mm) extension from the face plate. The standard stroke is 6"x6" (150x150mm).

Note: The above data applies to standard slide assemblies. Other slide lengths, speed and higher capacities are available



Kat Tracker Model WSG-1200 Electronic Seam Tracker

Kat Trackers are precise, dependable and highly versatile. They can be used with a wide range of Gullco accessories/ systems such as oscillators, bridge units, multiple torch assemblies etc. Contact Gullco with your requirement.



Model WSG-2200 Mounted On A Side Beam Carriage Equipped With A Submerged Arc Head

Specifications:
GULLCO MODEL WSG-1200 KAT TRACKER SYSTEM
SYSTEM COMPONENTS

Main Control Box, Pendant Remote Control Box, Probe, Probe Micro Cross-Slide, Motorized Cross-Slide Assembly, Probe-To-Torch Mounting Bracket, Control Cables from Probe and Cross-Slide to Main Control Box, Torch Holder With vertical/ horizontal adjustment, Brackets for mounting Cross-Slide and Main Control Box on Kat Travel Carriage.

MAIN CONTROL BOX

Incorporates main power switch, On.off pilot light, signal lights Indicating sensing function and fuse. Electronic circuit components Incorporated in modular system with Circuit boards for easy maintenance.
Size: (H) 5-1/2" (W) 2" (D) 1-1/2"
(140 x 50 x 38mm.)
Weight: 2 lbs. (900grams)



PENDANT REMOTE CONTROL BOX

Incorporates manual/automatic changeover switch and inching switch -vertical up/down and horizontal left/right.
Size: (H) 5-1/2" (W) 2" (D) 1-1/2"
(140 x 50 x 38mm.)
Weight: 2 lbs. (900 grams)



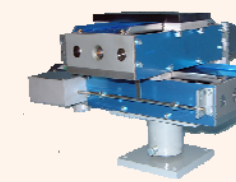
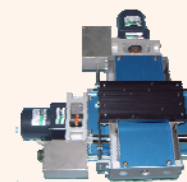
PROBE

Supplied complete with replaceable 1/8" dia. Probe tip. Assembly incorporates a Shock Protector that protects the system's electronics by breaking when heavy shock is encountered.



PROBE MICRO-CROSS-SLIDE

Provides precise manual pre-positioning of probe relative to torch prior to automatic operations. Stroke plus or minus 3/4" (20mm).
Weight: 1-3/4 lbs. (900 grams)



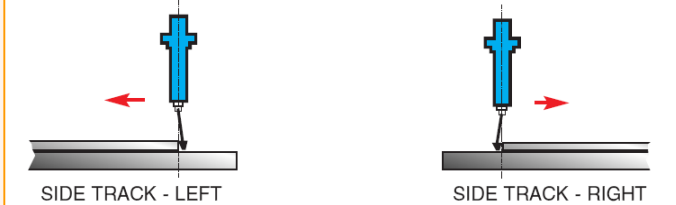
MOTORIZED CROSS-SLIDE ASSEMBLY

Model	WSG-1200	WSG-2200
Vertical Load Capacity:	up to 55 lbs. (25kg)	up to 220 lbs. (100kg)
Standard Stroke Length:	4" (100mm)	6" (150mm)
Standard Stroke Speed:	10.16 in/min (258 mm/min)	9.8 in/min. (250 mm/min)
Size (H)	14" (355mm)	18-1/2" (472 mm)
(W)	14" (355mm)	18-1/2" (472 mm)
(D)	4-3/4"(120mm)	6-1/2" (170 mm)
Weight:	22 lbs. (10kg)	50.6 lbs. (23 kg)

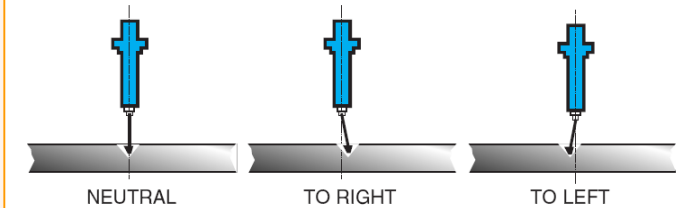
Power Requirements: 110/115 Volt AC-Single phase 50/60 Hz
Longer slides, other speeds and higher capacity units available on request

...incorporating sensing modes that cover virtually all tracking requirements

GULLCO KAT TRACKERS
Models WSG-1200 & 2200
SINGLE DIRECTION SENSING

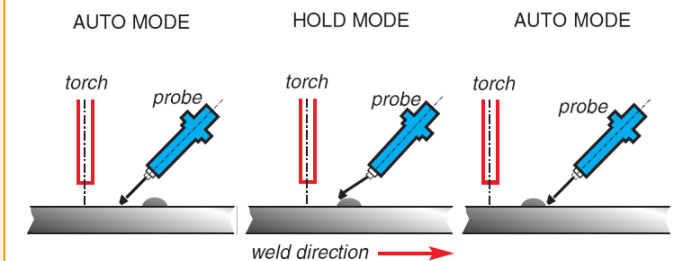


TWO DIRECTIONAL RIGHT/LEFT SENSING



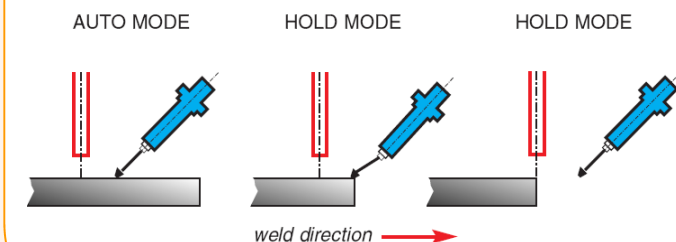
plus...

WELD TACK DETECTION



plus...

END OF PLATE DETECTION



GULLCO

TRACKLESS MAGNETIC MOGGY FILLET WELDING TRAVEL CARRIAGE

“low cost, highly efficient automation of out-of-position fillet, lap and butt welding applications”

This Gullco Moggy® is essentially the same as the Standard Moggy described inside this folder except it has a magnetic base and heavy duty urethane 0.875” (22.23 mm) wide wheels for continuous travel in the horizontal and vertical position. Two Models are available:

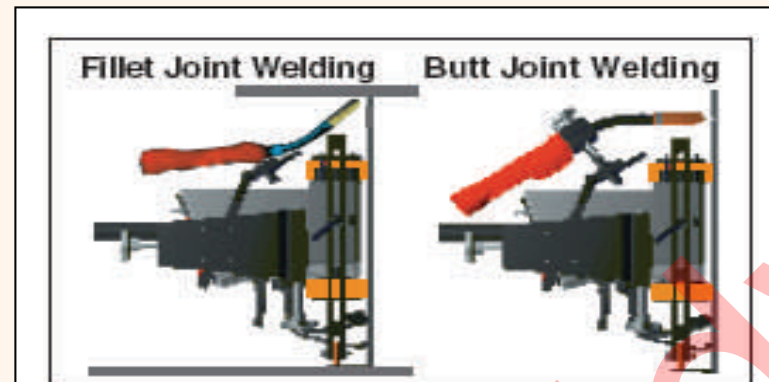


Magnetic MODEL GM-03-350 (Standard Model GM-03-050) Moggy Carriage with control for **continuous travel**, and with forward/stop/reverse switch, wire feed start on/off switch, travel speed potentiometer, auto wire feed start with delay carriage start, travel speed displayed in LED window, wire feed connector with 15ft. (4572mm) control cable.

Magnetic MODEL GM-03-300 (Standard Model GM-03-100) Moggy Carriage with control for **continuous or stitch welding**, and with a control that uses a Gullco micro-processor to provide accurate repeatability regardless of travel speeds for weld distance on and weld distance off. It has a forward/stop/reverse switch, wire feed start on/off switch, travel speed potentiometer, auto wire feed start with delay carriage start, wire feed connector with 15 ft. (4572mm) control cable. All functions displayed in LED window.

GM-03-320 - Magnetic Retro Fit Kit is available to upgrade your Standard GM-03-050 & GM-03-100 Moggy to a Magnetic Moggy.

Adjustable guide roll assemblies ensure accurate gun positioning while the Moggy carriage moves at precisely controlled speeds in forward/reverse direction. (see inside for details on the MOGGY®)



EFFICIENT...EFFECTIVE...VERSATILE
The Gullco magnetic moggy is highly versatile and is ideally suited to a wide variety of welding applications, particularly in Tee fillet welding where there is not enough room for the carriage to run on the horizontal plate.

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Moggy-07-01



GULLCO



MOGGY & MAGNETIC MOGGY PORTABLE FILLET WELDING TRAVEL CARRIAGE SYSTEM

- Ideal for automatic horizontal fillet, lap and butt welding operations
- Controls are available to perform continuous and/or stitch weld operations
- Dual gun holder assembly is available for efficient simultaneous welding
- Wheels on the standard Moggy can be reversed to allow the moggy to run on standard v-groove track
- The magnetic moggy has a magnetic base that clings to the vertical member for out of position applications



The Gullco Moggy® friction drive travel carriage is designed to perform Horizontal Fillet Welding, Lap Welding and Butt Welding. It can be fitted with a Gullco Compact Oscillator to perform multi-pass welding. These operations can be performed on horizontal fillets with a minimum radius of 39 in. (1 meter) and up to a 30° incline. Following is a brief description of the Moggy and components that make up the system.

It is a lightweight, portable, four wheel friction drive travel carriage that can be used with or without track to automate welding operations. A speed potentiometer provides infinite speed selection within the 6 to 115 in/min (15.2 to 292.2 cm/min) range. The unit comes complete with adjustable guide rolls, travel limit switch assembly, vertical and horizontal slides providing 1 3/4" (44.4mm) adjustment and a semi-automatic gun holder. It is designed to run on a horizontal path against a vertical surface or a vertical path against a horizontal surface (Magnetic Moggy) to perform a fillet weld.

The Standard Moggy can be adapted for use on standard 6" (152.4mm) v-groove track by reversing the wheel assemblies. Safety is assured by using Gullco low voltage 24 volt DC highly advanced control power supply system that is available in 3 line voltage inputs ... 42, 110 and 230 volt AC 50/60 Hz.





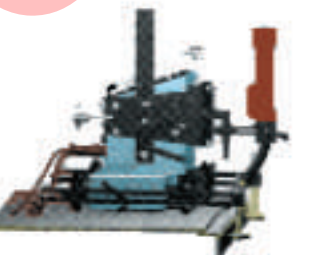

Please specify line voltage when ordering.
(Magnetic Moggy® details on back)

Standard MODEL GM-03-050
(Magnetic Model GM-03-350)
Moggy Carriage with control for **continuous travel**, and with forward/stop/reverse switch, wire feed start on/off switch, travel speed potentiometer, auto wire feed start with delay carriage start, travel speed displayed in LED window, wire feed connector with 15 ft. (4572mm) control cable.

Standard MODEL GM-03-100 (Magnetic Model GM-03-300) Moggy Carriage with control for continuous or stitch welding, and with a control that uses a Gullco microprocessor to provide accurate repeatability regardless of travel speeds for weld distance on and weld distance off. It has a forward/stop/reverse switch, wire feed start on/off switch, travel speed potentiometer, auto wire feed start with delay carriage start, wire feed connector with 15 ft. (4572mm) control cable. All functions displayed in LED window.

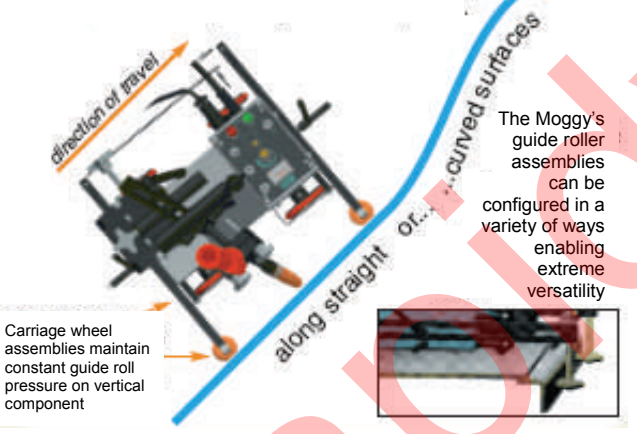
The Gullco moggy is a highly reliable, versatile heavy duty travel carriage which is ideal for a wide range of applications

The Moggy can be adapted to automate and reduce welding and set up costs in a broad range of applications. Some typical configurations are shown below

<p>Lap Joint Welding</p>  <p>The Moggy is performing a lap joint weld. It is guided by Industry Standard 6" (152.4mm) v-groove Track running parallel to the joint.</p>	<p>Fillet Joint Welding</p>  <p>The Moggy performing a fillet weld using a template, guide or fence positioned parallel to the work piece. The actual workpiece is often used as the guide.</p>	<p>Dual Gun Welding</p>  <p>Dual gun holder assembly mounted on the Moggy enables positioning of 2 guns and simultaneous activation of two wire feed signals. Moggy is guided by the workpiece.</p>	<p>Butt Joint Welding</p>  <p>The Moggy is ideal for butt joint welding. Here the Moggy is using a fence to guide it accurately along the desired path. Standard v-groove track can also be used.</p>	<p>Joint Tracking</p>  <p>Adjustable height guide roller assemblies are available to track joints with a vertical member higher or lower than the set height of guide roller wheels.</p>	<p>Radial Oscillation</p>  <p>Replaces the standard gun holder assembly in order to weave the gun across the joint while the Moggy provides the weld travel motion.</p>
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Precise Torch Alignment To The Seam

Adjustable guide rolls mounted on the front or back of the carriage monitor the slightest seam variations following straight or curved surfaces...maintaining optimum torch positioning. The carriage travels in forward or reverse direction at precisely controlled speeds.



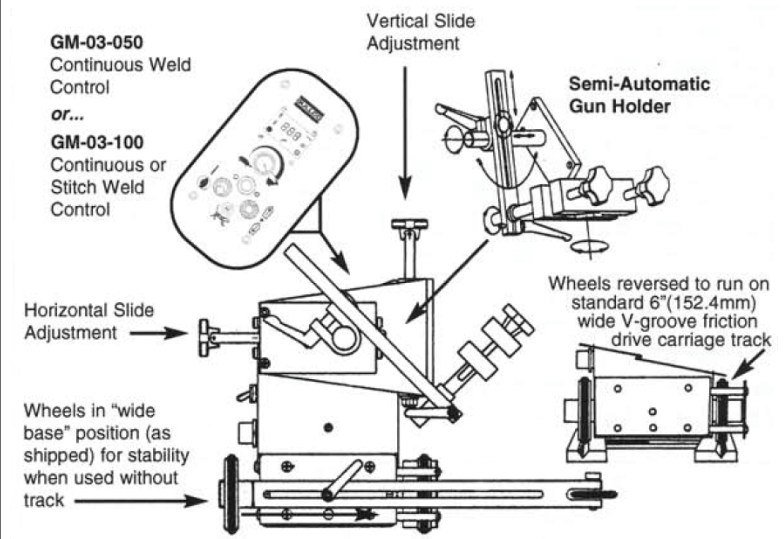
Accessories available

Model GK-194-O-330- Radial Oscillator complete with bracketry for mounting on Gullco Moggy Carriage.

Model GM-01-064- Adjustable Guide Roller Assembly enables joint tracking where the vertical member is lower/higher than set height of guide roller wheels.

Model GM-01-065- Cutting Torch Holder Assembly enables automated torch cutting operations.

GM-01-070- Dual Gun Holder Assembly enables the use of two independently positioned welding guns with two wire feed signals simultaneously activated.



Also available as a SUBMERGED ARC MOGGY

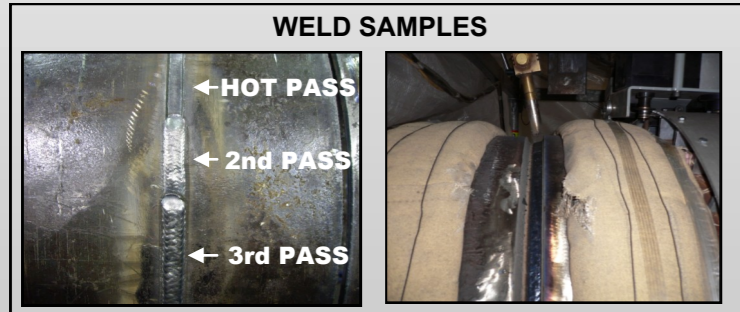


SAM Submerged Arc Carriage... shown set at 45° for beam welding application.



Visit us at
www.gullco.com





WELD TORCH AND WIRE INFORMATION:
 Welding torch uses Abicor Binzel consumables. Wire feed 10 lb. spool capacity. Maximum wire speed of 791 IPM. With a wire size range of .8 to 1.6 mm. All motors 24 volt DC.

GULLCO PIPE KAT CARRIAGE CONTROL
 Includes:

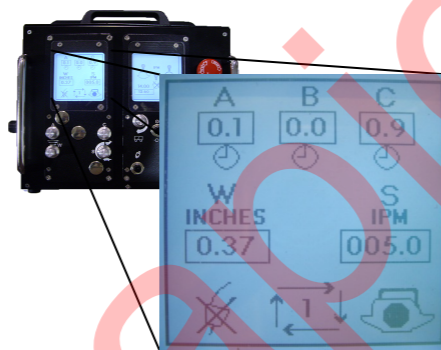
- Motorized Width Adjustment
- High Speed Return
- Motorized Weld Head Joint Positioning
- Motorized Vertical Slide
- High Speed Carriage Jog
- Up / Down Jog Switch
- Wire Feed Jog
- Weld Enabled / Disabled Switch
- Auto Start Warning Buzzer

REMOTE HAND PENDANT



Remote pendant on 12 ft. of cable incorporates carriage speed and jog, wire feed speed and jog, vertical slide adjustments, oscillation width and centerline adjustment with start/stop and emergency stop buttons.

CARRIAGE CONTROL



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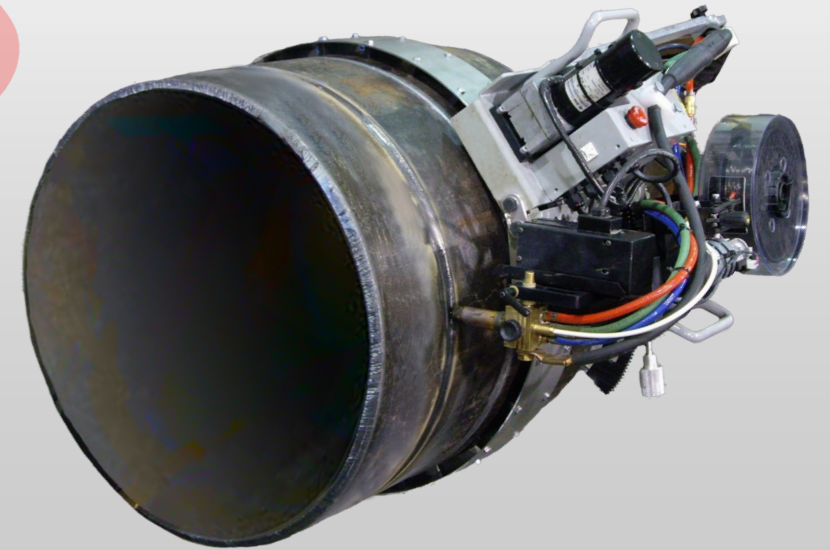
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ORBITAL PIPE WELDING CARRIAGE - PIPE KAT®

WWW.GULLCO.COM



Gullco PIPE KAT® Automated Pipe Welding System with integrated wire feeder unit incorporates 40 IPM welding carriage design with quick action mounting for ease of installation. The carriage is equipped with a high speed return feature for faster repositioning of the carriage. The PIPE KAT® also comes equipped with a linear oscillator with adjustable weave width and weld joint centerline adjustment and all electronic motorized functions incorporate jog settings. The system comes with a main control box with 12 ft umbilical and 27 ft. of gas hose and ground cable, wire feed spool capacity of 10 lbs, with a maximum wire speed of 791 IPM and a wire size range of 0.8 to 1.6 mm. The welding torch uses Abicor Binzel consumables.



PK-200-B 115 Volt

PK-200-C 230 Volt



High Deposit Rate
 More Arc On Time



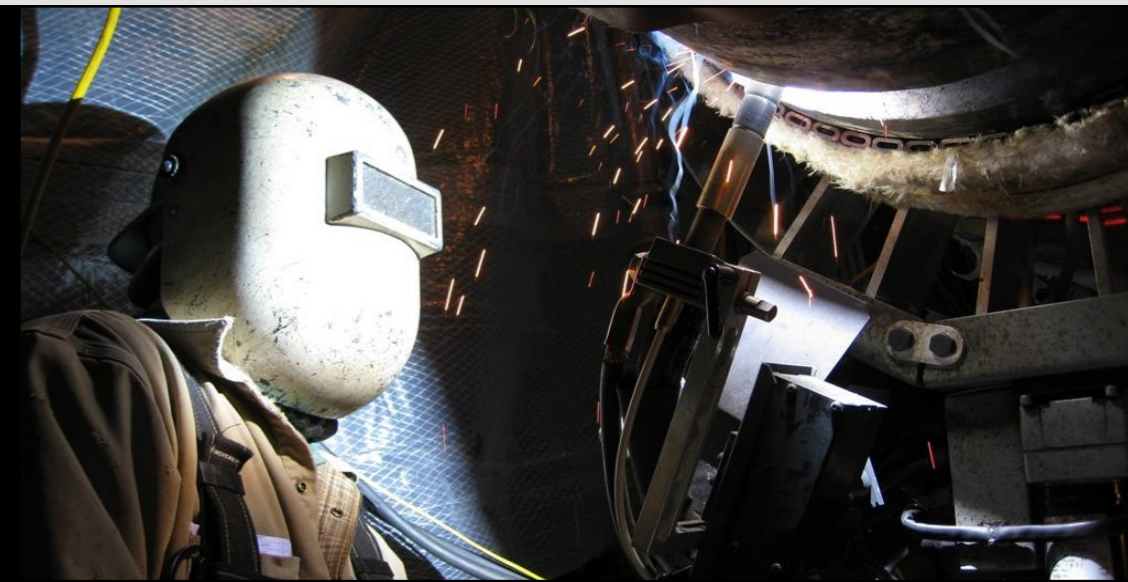
Easy To Use
 Quick Setup Time



Gullco PIPE KAT® Automated Pipe Welding System with integrated wire feeder

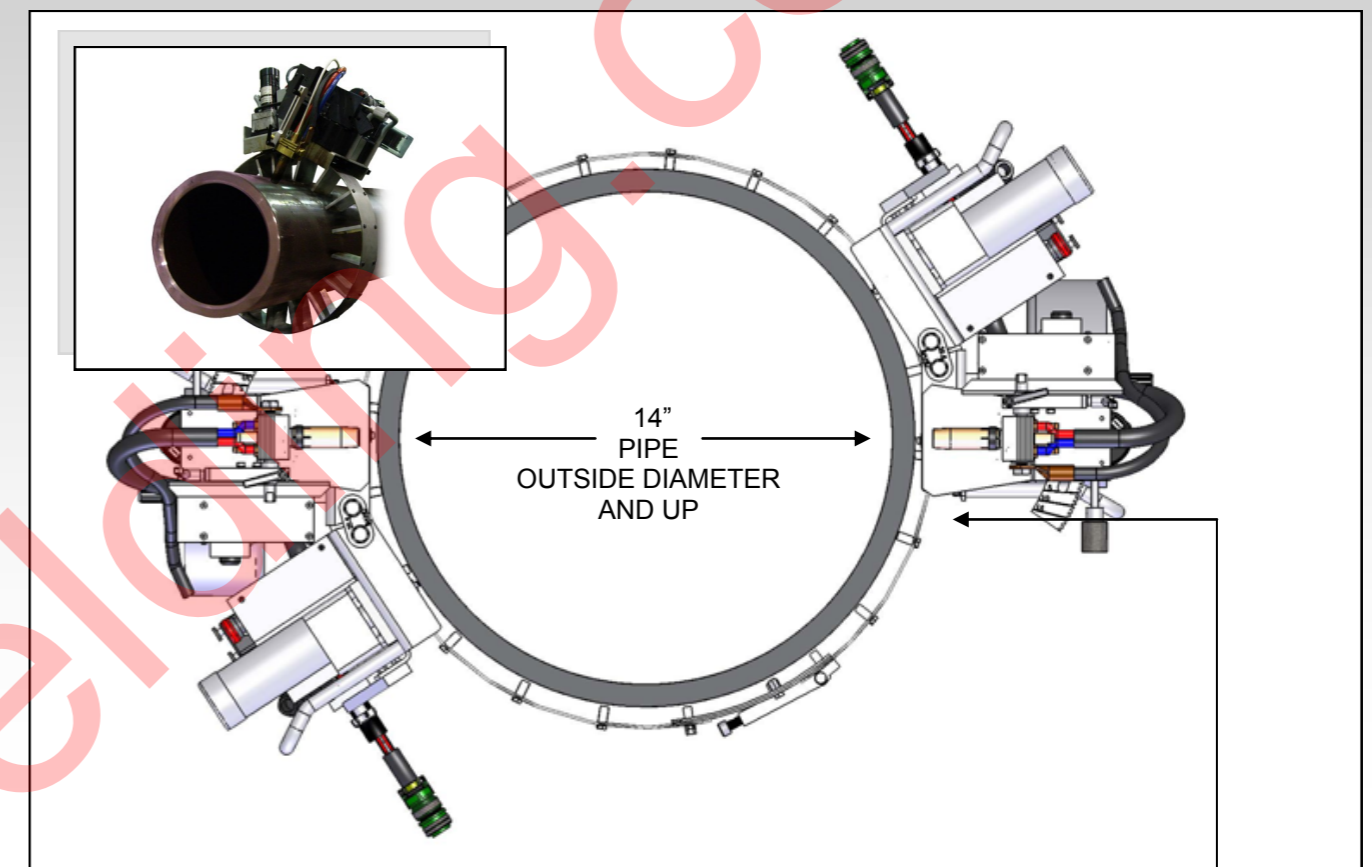
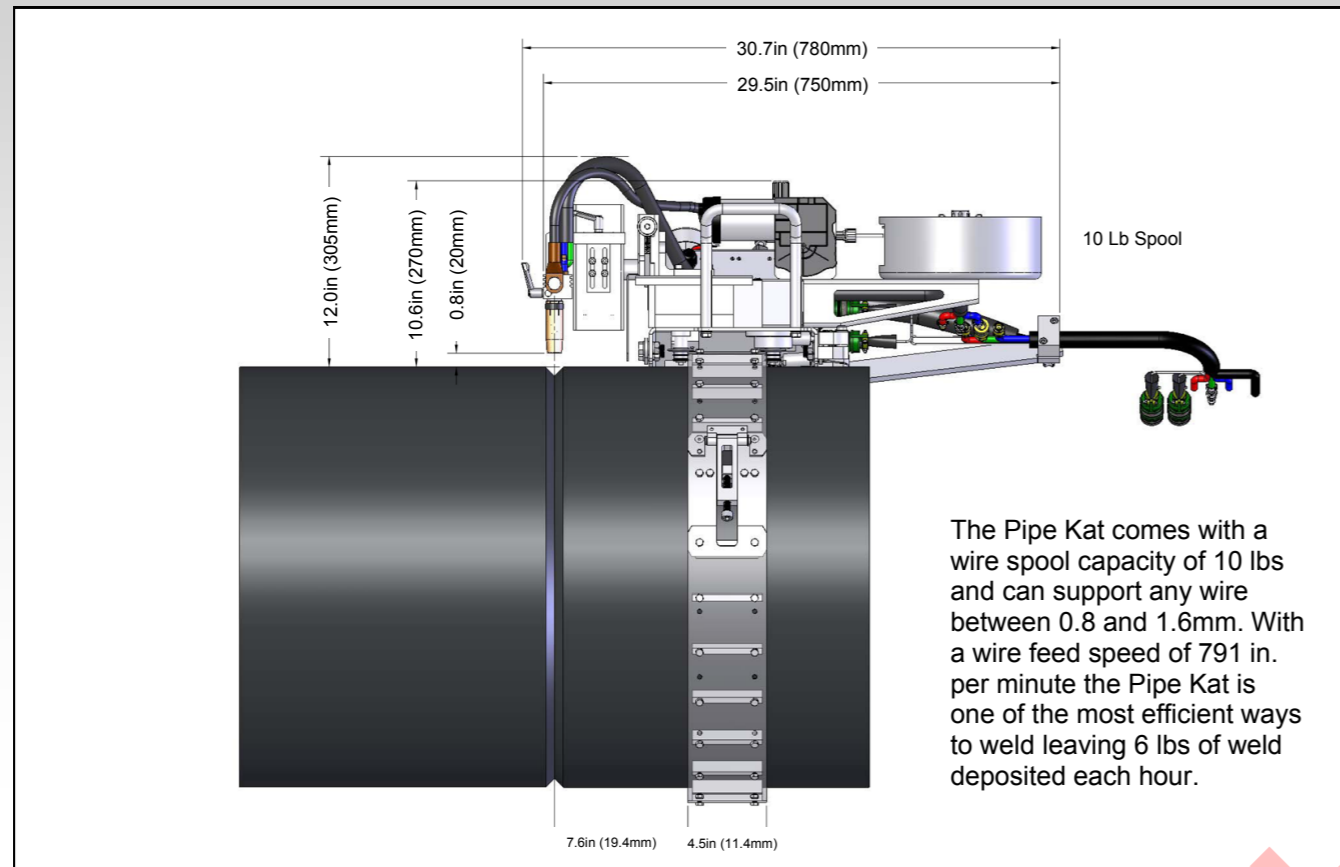


WELDING AND CUTTING AUTOMATION





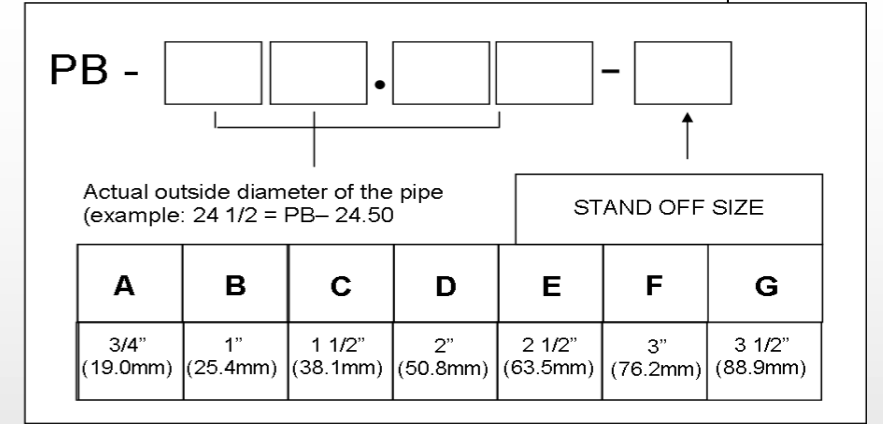
PIPE KAT® ORBITAL WELDER CARRIAGE DIMENSIONS



The Gullco Pipe Kat is a practical, affordable alternative to manual welding of larger diameter and heavy wall pipes. It produces x-ray quality welds at 5 to 15 times the deposition rate of GTAW. Robotic consistency and precision make it ideal for pipeline site use or industrial shop areas. The Pipe Kat's versatility allows it to be powered by a variety of power sources, keeping overall cost low while still providing welds that meet ASME IX and API 1104 code requirements.

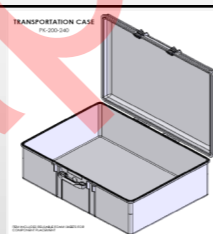
The Head unit is mounted on the pipe by means of a quick mount metal guide ring, which is available for all standard and most custom pipe sizes. The weld head unit mounts entirely on one side of the joint, providing full open access to the weld joint area.

The Pipe Kat's unique design allows it to weld pipes as small as 14" up to and including flat horizontal or vertical welding. For a more precise control over the welding process the Pipe Kat is equipped with our newest linear Oscillator. This allows the operator to control the direction, wire feed jog, carriage speed (0-40 IPM) as well as motorized centerline positioning and motorized width adjustment. By combing all of these features in to one easily used remote controlled pendant the operator has the freedom to move around the carriage and inspect the weld in real time with the ability to make minor or major adjustments to the welding process at the push of a button.



EASY STORAGE AND MOBILITY- PROTECTIVE CASE

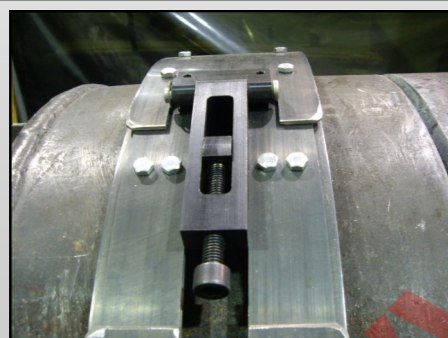
The Pipe Kat can be purchased with a moisture resistant protective case which will protect the carriage and ensure that all of the components are kept secure and in one place. The Pipe Kat and all of its components are protected by a dense reusable foam making it easy to both remove and replace the carriage and its accessories after welding has been completed. This makes the pipe welder ideal for field and plant use.



QUICK RELEASE TRACK DESIGN

The Pipe Kat orbital welder uses a new track design which utilizes a quick release track attachment to greatly decrease setup time and improve the stability of the carriage during welding.

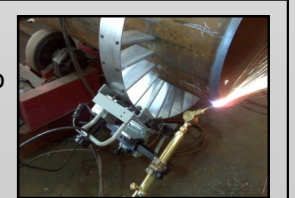
A track band can be designed for any pipe 14" in diameter or larger.



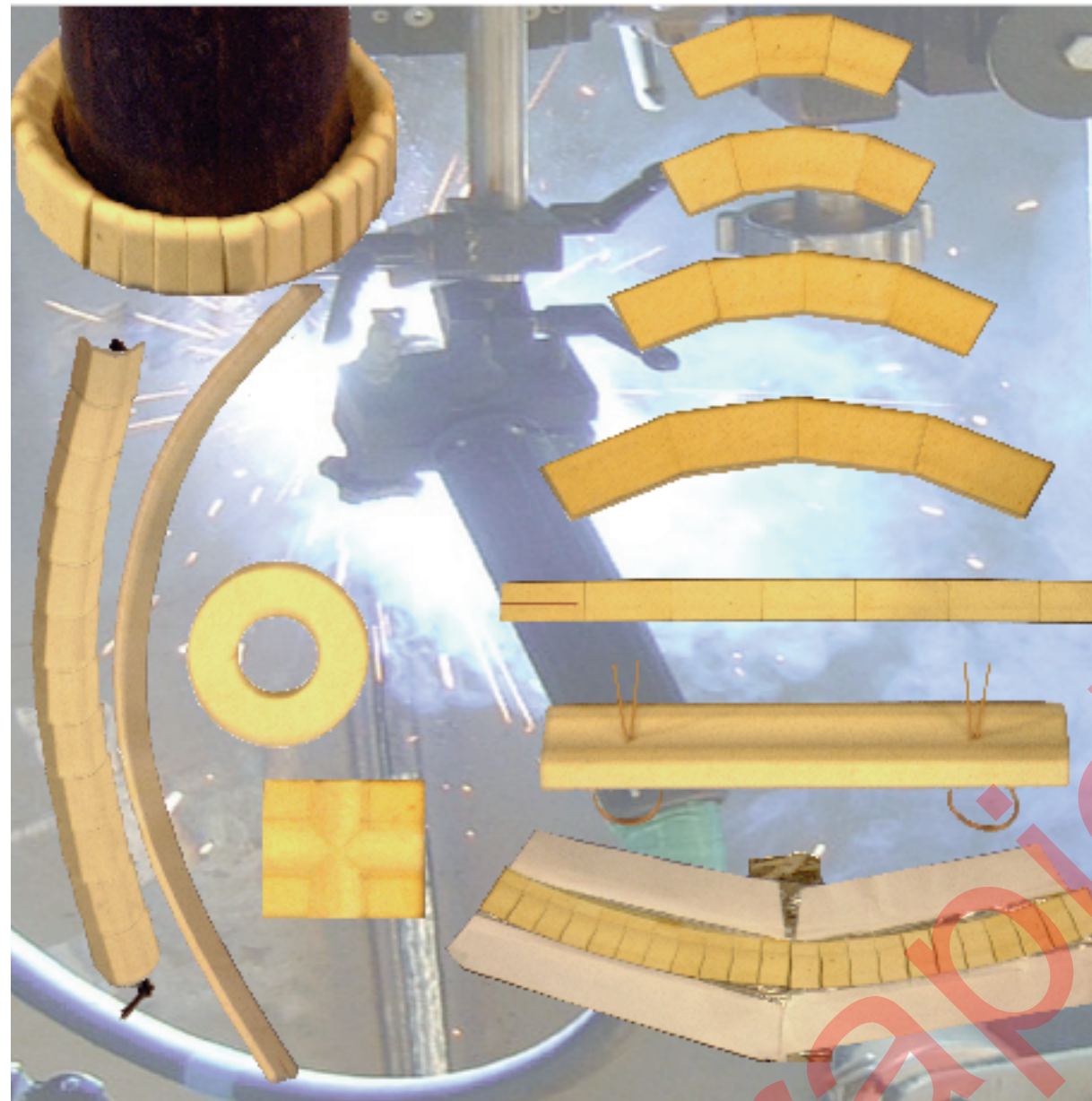
Gullco's Pipe Kat uses the Flux Core Arc Welding (FCAW) process and is compatible with all material where flux core wire can be used. With the Pipe Kats unique design it is able to weld any pipe regardless of its wall thickness. This allows the Pipe Kat to be adapted to fit any pipe project.

CUTTING ATTACHMENTS AVAILABLE

The Pipe Kat is a versatile carriage and can be modified in order to complete cutting applications. Using our rack box and rack arm system the Pipe Kat is able to make clean precise cuts whether it is flame beveling or horizontal cutting.



As a manufacturer and distributor of ceramics, Gullco can provide you with a KATBAK ceramic weld backing to meet your needs. If you don't see the ceramic you need in this brochure contact Gullco or your Gullco distributor to discuss your specific requirement.



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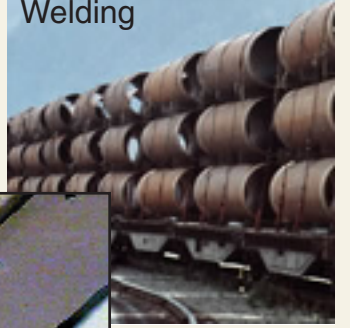
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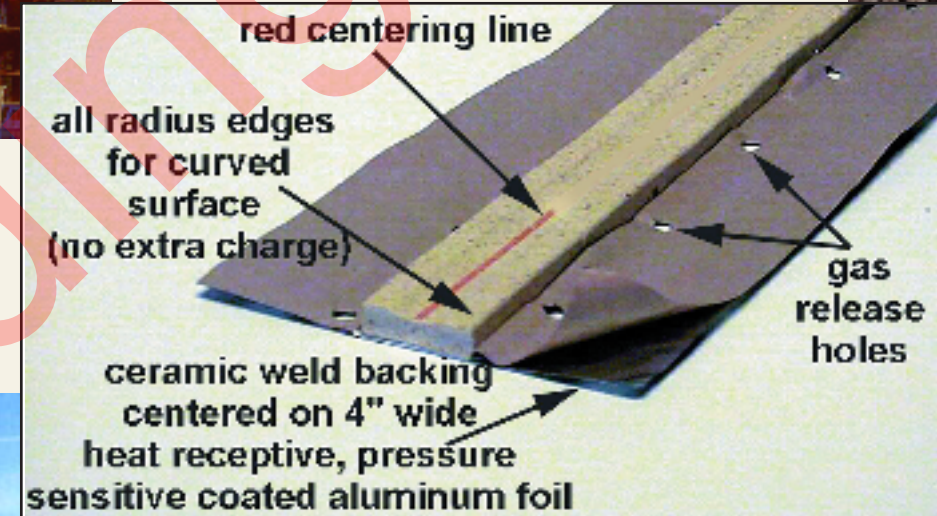
Use KATBAK in Tank Welding



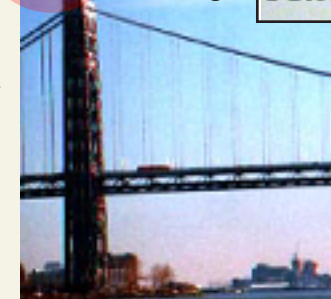
Use KATBAK in Pipe Welding



KATBAK[®] Ceramic Weld Backing



Use KATBAK in Bridge Building



Use KATBAK in Ship Building



GULLCO CERAMIC WELD BACKINGS
...A COST EFFECTIVE RELIABLE METHOD FOR
PRODUCING X-RAY QUALITY BACK BEADS WITHOUT
COSTLY GRINDING, GOUGING AND REWELDING.
**KATBAK CERAMICS HAVE KNUCKLE JOINTS FOR USE
ON FLAT OR CURVED SURFACES**

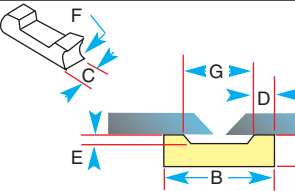
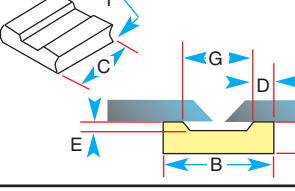
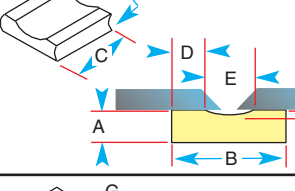
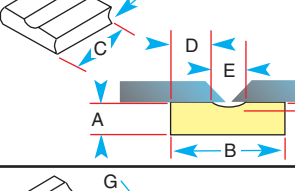
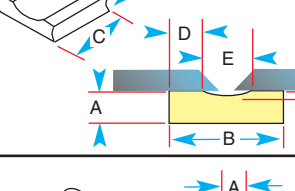
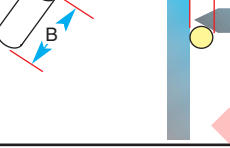
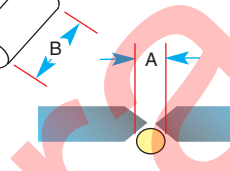
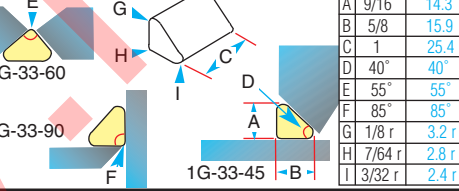
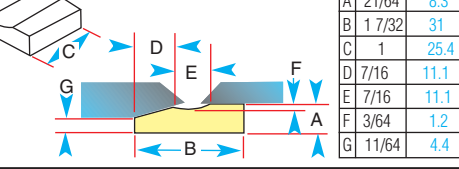
- Impart X-ray Quality Back Beads On Root Pass
- Weld One Side Only
- Deposit More Weld Metal
- Root Weld And Fill In One Pass
- Eliminate Defects And Rework
- Eliminate Costly Unnecessary Gouging And Grinding
- Sizes 1/4" (6.3 mm) to 6" (152.4 mm)
- Special Sizes And Configurations Available
- Conveniently Packaged and Sealed In Plastic For Moisture Proof Protection
- Wider Heat Receptive Pressure Sensitive Foil For Improved Adhesion To Work Piece

IMPROVE WELDS AND REDUCE COSTS WITH GULLCO KATBAK

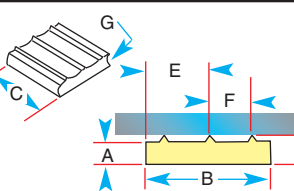
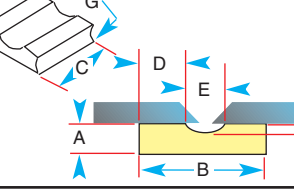
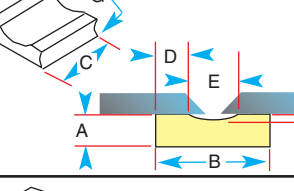
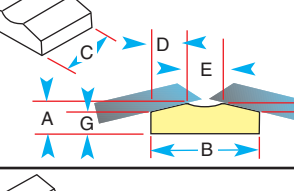
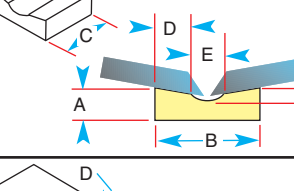
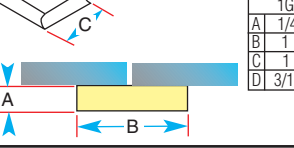
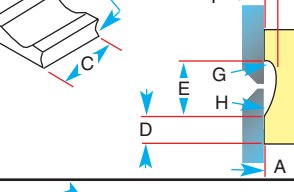
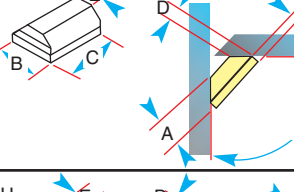
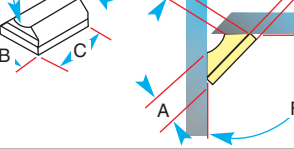
QUALITY CERTIFICATION TO:
ISO 9000

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SPECIFICATIONS ►►

MODEL	SPECIFICATION/TYPICAL APPLICATION	SPECS. inches / (mm)																											
1G93-R-1/4 (12m - 40ft./ box)	Similar to the 1G93-R tile but in 1/4" lengths making it much more flexible to wrap around smaller diameters of pipe and vessel. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>7/8 to 1</td><td>22.2-25.4</td></tr> <tr><td>C</td><td>1/4</td><td>6.3</td></tr> <tr><td>D</td><td>5/32</td><td>4</td></tr> <tr><td>E</td><td>1/16</td><td>1.6</td></tr> <tr><td>F</td><td>3/16 r</td><td>4.8r</td></tr> <tr><td>G</td><td>7/16</td><td>11.1</td></tr> </table>	A	1/4	6.3	B	7/8 to 1	22.2-25.4	C	1/4	6.3	D	5/32	4	E	1/16	1.6	F	3/16 r	4.8r	G	7/16	11.1						
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C	1/4	6.3																											
D	5/32	4																											
E	1/16	1.6																											
F	3/16 r	4.8r																											
G	7/16	11.1																											
1G93-R (12m - 40ft./ box)	This tile is most suitable for those applications where slag is involved, mainly M.A.G. welding with cored wire. It gives space for the slag to go while leaving a good root bead. Each tile is radiused to form a strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>7/8 to 1</td><td>22.2-25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>5/32</td><td>4</td></tr> <tr><td>E</td><td>1/16</td><td>1.6</td></tr> <tr><td>F</td><td>3/16 r</td><td>4.8r</td></tr> <tr><td>G</td><td>7/16</td><td>11.1</td></tr> </table>	A	1/4	6.3	B	7/8 to 1	22.2-25.4	C	1	25.4	D	5/32	4	E	1/16	1.6	F	3/16 r	4.8r	G	7/16	11.1						
A	1/4	6.3																											
B	7/8 to 1	22.2-25.4																											
C	1	25.4																											
D	5/32	4																											
E	1/16	1.6																											
F	3/16 r	4.8r																											
G	7/16	11.1																											
1G42-R (12m - 40ft./ box)	This tile is useful for M.I.G. welding with solid wires and metal cored wires. It is also useful for T.I.G. welding. Cored wires can also be used with this tile but smaller root reinforcement will be produced. Each tile is radiused to form the strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>9/32</td><td>7.2</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	9/32	7.2	E	7/16	11.1	F	1/16	1.6	G	3/16r	4.8r						
A	1/4	6.3																											
B	1	25.4																											
C	1	25.4																											
D	9/32	7.2																											
E	7/16	11.1																											
F	1/16	1.6																											
G	3/16r	4.8r																											
1G43-R (12m - 40ft./ box)	This tile is for similar applications as the 1G42-R but where a narrower root bead is required. Each tile is radiused to form a strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/8</td><td>9.5</td></tr> <tr><td>E</td><td>1/4</td><td>6.3</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	3/8	9.5	E	1/4	6.3	F	1/16	1.6	G	3/16r	4.8r						
A	1/4	6.3																											
B	1	25.4																											
C	1	25.4																											
D	3/8	9.5																											
E	1/4	6.3																											
F	1/16	1.6																											
G	3/16r	4.8r																											
1G82-R (9m - 30ft./ box)	This tile is similar to the 1G42-R but it is thicker and more robust for heavier weld deposits and higher amperages. Each tile is radiused to form the strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>13/32</td><td>10.3</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>3/16r</td><td>4.8r</td></tr> </table>	A	5/16	7.9	B	1 1/4	31.7	C	1	25.4	D	13/32	10.3	E	7/16	11.1	F	1/16	1.6	G	3/16r	4.8r						
A	5/16	7.9																											
B	1 1/4	31.7																											
C	1	25.4																											
D	13/32	10.3																											
E	7/16	11.1																											
F	1/16	1.6																											
G	3/16r	4.8r																											
1G6-RD (12m - 40ft./ box) 1G9-RD (12m - 40ft./ box)	This is a 6mm round tile suitable for X preps, K preps and single bevel, single v butt joints (similar to fillet welds) on thin plates up to 10mm thick. Suitable for welding with M.I.G./M.A.G. solid, flux cored or metal cored wires. 1G9-RD is for use on thicker plates.	 <table border="1"> <tr><td colspan="3">1G6-RD</td></tr> <tr><td>A</td><td>1/4 dia</td><td>6.3 dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G9-RD</td></tr> <tr><td>A</td><td>3/8 dia</td><td>9.5 dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> </table>	1G6-RD			A	1/4 dia	6.3 dia	B	1	25.4	1G9-RD			A	3/8 dia	9.5 dia	B	1	25.4									
1G6-RD																													
A	1/4 dia	6.3 dia																											
B	1	25.4																											
1G9-RD																													
A	3/8 dia	9.5 dia																											
B	1	25.4																											
1G13-RD (12m - 40ft./ box) 1G15-RD (12m - 40ft./ box) 1G20-RD (12m - 40ft./ box)	These tiles are for similar uses as the 1G6-RD but for thicker plates up to 15mm thick. Suitable for welding with M.I.G./M.A.G. solid, flux cored or metal cored wires. <i>can be used as shown</i>	 <table border="1"> <tr><td colspan="3">1G13-RD</td></tr> <tr><td>A</td><td>1/2 dia</td><td>12.7 dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G15-RD</td></tr> <tr><td>A</td><td>5/8 dia</td><td>15.9 dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td colspan="3">1G20-RD</td></tr> <tr><td>A</td><td>7/8 dia</td><td>22.2 dia</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> </table>	1G13-RD			A	1/2 dia	12.7 dia	B	1	25.4	1G15-RD			A	5/8 dia	15.9 dia	B	1	25.4	1G20-RD			A	7/8 dia	22.2 dia	B	1	25.4
1G13-RD																													
A	1/2 dia	12.7 dia																											
B	1	25.4																											
1G15-RD																													
A	5/8 dia	15.9 dia																											
B	1	25.4																											
1G20-RD																													
A	7/8 dia	22.2 dia																											
B	1	25.4																											
1G33-45 (12m - 40ft./ box) 1G33-60 (12m - 40ft./ box) 1G33-90	All 1G33 tiles are suitable for K or X preps where the bevel angles are 45, 60 or 90 degrees. Also suitable for welding with M.I.G./M.A.G. solid wire, metal cored or flux cored wires. They are a substitute for round tiles where the benefit of the 1G33 range of tiles is a "full-face" contact with the joint preparation... reducing the risk of burn-through as may occur with the round tiles where you have a single point contact of the tile with the work piece. 1G33-90 also used when reverse side of a single bevel, single V butt joint where the reverse angle will always be 90°.	 <table border="1"> <tr><td>A</td><td>9/16</td><td>14.3</td></tr> <tr><td>B</td><td>5/8</td><td>15.9</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>40°</td><td>40°</td></tr> <tr><td>E</td><td>55°</td><td>55°</td></tr> <tr><td>F</td><td>85°</td><td>85°</td></tr> <tr><td>G</td><td>1/8 r</td><td>3.2 r</td></tr> <tr><td>H</td><td>7/64 r</td><td>2.8 r</td></tr> <tr><td>I</td><td>3/32 r</td><td>2.4 r</td></tr> </table>	A	9/16	14.3	B	5/8	15.9	C	1	25.4	D	40°	40°	E	55°	55°	F	85°	85°	G	1/8 r	3.2 r	H	7/64 r	2.8 r	I	3/32 r	2.4 r
A	9/16	14.3																											
B	5/8	15.9																											
C	1	25.4																											
D	40°	40°																											
E	55°	55°																											
F	85°	85°																											
G	1/8 r	3.2 r																											
H	7/64 r	2.8 r																											
I	3/32 r	2.4 r																											
1G62 (12m - 30ft./ box)	This tile is used when two plates to be welded are of a different thickness and is suitable for MIG welding with solid wire, metal core wire and can also be used with flux core wire.	 <table border="1"> <tr><td>A</td><td>21/64</td><td>8.3</td></tr> <tr><td>B</td><td>1 7/32</td><td>31</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/16</td><td>11.1</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>3/64</td><td>1.2</td></tr> <tr><td>G</td><td>11/64</td><td>4.4</td></tr> </table>	A	21/64	8.3	B	1 7/32	31	C	1	25.4	D	7/16	11.1	E	7/16	11.1	F	3/64	1.2	G	11/64	4.4						
A	21/64	8.3																											
B	1 7/32	31																											
C	1	25.4																											
D	7/16	11.1																											
E	7/16	11.1																											
F	3/64	1.2																											
G	11/64	4.4																											

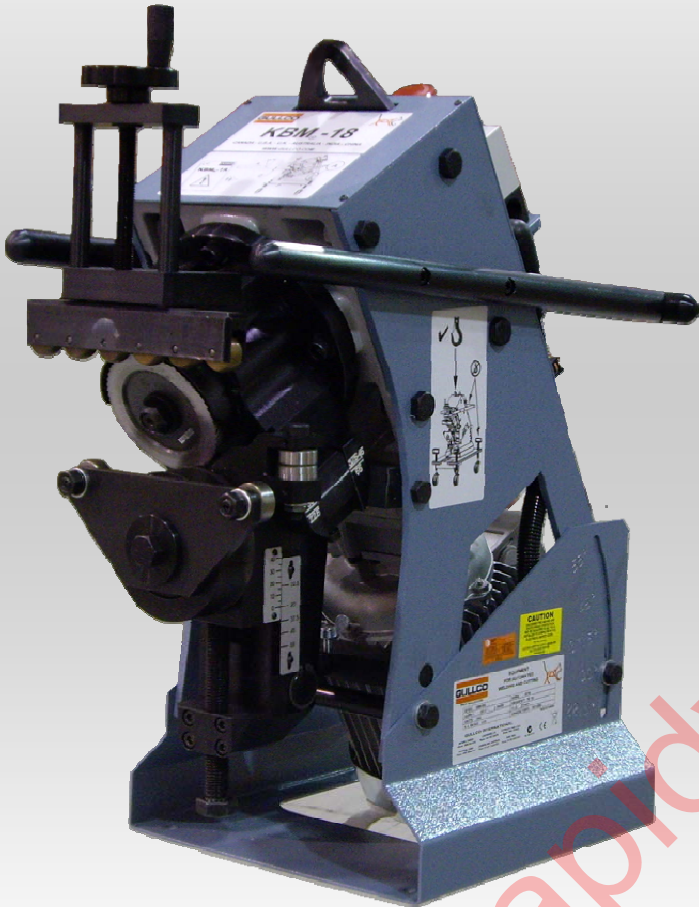
✓ Available in 1/4" to 2" (6.3mm to 50.8mm) tiles.

MODEL	SPECIFICATION/TYPICAL APPLICATION	SPECS. inches / (mm)																														
1G42-ER (12m - 40ft./ box)	This tile is suitable for use with M.I.G./M.A.G. applications with solid, flux or metal cored wires where minimal penetration is required but higher amperage is necessary because the small up-stands that are present in this tile will not burn away with amperages less than about 120 amps. Each tile is radiused to form the strip around a cylinder.	 <table border="1"> <tr><td>A</td><td>3/16</td><td>4.8</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>15/64</td><td>6</td></tr> <tr><td>E</td><td>1/2</td><td>12.7</td></tr> <tr><td>F</td><td>11/32</td><td>8.7</td></tr> <tr><td>G</td><td>3/16 r</td><td>4.8r</td></tr> </table>	A	3/16	4.8	B	1	25.4	C	1	25.4	D	15/64	6	E	1/2	12.7	F	11/32	8.7	G	3/16 r	4.8r									
A	3/16	4.8																														
B	1	25.4																														
C	1	25.4																														
D	15/64	6																														
E	1/2	12.7																														
F	11/32	8.7																														
G	3/16 r	4.8r																														
1G41-R (12m - 40ft./ box)	This is similar to the 1G42-R but has a slightly smaller groove where more penetration is required than with the 1G42-R. Each tile is radiused to form a strip around a cylinder. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>5/16</td><td>7.9</td></tr> <tr><td>E</td><td>3/8</td><td>9.5</td></tr> <tr><td>F</td><td>1/32</td><td>1</td></tr> <tr><td>G</td><td>3/16 r</td><td>4.8 r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	5/16	7.9	E	3/8	9.5	F	1/32	1	G	3/16 r	4.8 r									
A	1/4	6.3																														
B	1	25.4																														
C	1	25.4																														
D	5/16	7.9																														
E	3/8	9.5																														
F	1/32	1																														
G	3/16 r	4.8 r																														
1G44-R (9m - 30ft./ box)	This tile is a larger tile and has a larger groove than the 1G42 tile or the 1G41-R tile where the user needs more penetration and more substance in the tile. Possibly for submerged arc welding applications and thicker plates. Each tile is radiused to form a strip around the cylinder. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>9/32</td><td>7.2</td></tr> <tr><td>E</td><td>11/16</td><td>17.5</td></tr> <tr><td>F</td><td>1/16</td><td>1.6</td></tr> <tr><td>G</td><td>1/4 r</td><td>6.3 r</td></tr> </table>	A	3/8	9.5	B	1 1/4	31.7	C	1	25.4	D	9/32	7.2	E	11/16	17.5	F	1/16	1.6	G	1/4 r	6.3 r									
A	3/8	9.5																														
B	1 1/4	31.7																														
C	1	25.4																														
D	9/32	7.2																														
E	11/16	17.5																														
F	1/16	1.6																														
G	1/4 r	6.3 r																														
1G61 (12m - 40ft./ box)	This is for inserting behind plates where there is a taper on the backside of the plate. This tile allows the groove portion to fit snugly against the root. Note that these tiles are square edged and so, will not go round a radius. They are meant for flat plates. Again, these tiles are used for M.I.G./M.A.G. welding with all the wires. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 7/32</td><td>31</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>25/64</td><td>10</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>1/32</td><td>.79</td></tr> <tr><td>G</td><td>1/4</td><td>6.3</td></tr> </table>	A	3/8	9.5	B	1 7/32	31	C	1	25.4	D	25/64	10	E	7/16	11.1	F	1/32	.79	G	1/4	6.3									
A	3/8	9.5																														
B	1 7/32	31																														
C	1	25.4																														
D	25/64	10																														
E	7/16	11.1																														
F	1/32	.79																														
G	1/4	6.3																														
1G60 (9m - 30 ft./ box)	This tile has upturned sides for use when the plates are introduced at an angle or with differing thicknesses to allow the root of the weldment to sit snugly against the tile and present next to the radiused portion where the root will form. ✓	 <table border="1"> <tr><td>A</td><td>3/8</td><td>9.5</td></tr> <tr><td>B</td><td>1 3/16</td><td>30.2</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/8</td><td>9.5</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>9/64</td><td>3.6</td></tr> </table>	A	3/8	9.5	B	1 3/16	30.2	C	1	25.4	D	3/8	9.5	E	7/16	11.1	F	9/64	3.6												
A	3/8	9.5																														
B	1 3/16	30.2																														
C	1	25.4																														
D	3/8	9.5																														
E	7/16	11.1																														
F	9/64	3.6																														
1G42-FR (12m - 40ft./ box) 1G83-FR (9m - 30 ft./ box) 1G42-FR-1/4 (12m - 40ft./ box)	This tile is similar to the standard flat tile but it is more flexible to go round a tighter radius. Please note that all other tile shapes can be made 1/4" long to aid flexibility of the tile. Each tile is radiused to form a strip around a cylinder. 1G83-FR This is similar to the 1G42-FR but it is a thicker, larger tile to withstand higher currents where minimal penetration is required. ✓	 <table border="1"> <tr><td colspan="3">1G83-FR</td></tr> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>1 1/4</td><td>31.7</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>3/16r</td><td>4.8 r</td></tr> <tr><td colspan="3">1G42-FR-1/4</td></tr> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1/4</td><td>6.3</td></tr> <tr><td>D</td><td>3/16r</td><td>4.8 r</td></tr> </table>	1G83-FR			A	5/16	7.9	B	1 1/4	31.7	C	1	25.4	D	3/16r	4.8 r	1G42-FR-1/4			A	1/4	6.3	B	1	25.4	C	1/4	6.3	D	3/16r	4.8 r
1G83-FR																																
A	5/16	7.9																														
B	1 1/4	31.7																														
C	1	25.4																														
D	3/16r	4.8 r																														
1G42-FR-1/4																																
A	1/4	6.3																														
B	1	25.4																														
C	1/4	6.3																														
D	3/16r	4.8 r																														
1G80-R (9m - 30 ft./ box)	This tile is specially designed to prevent back bead droop in horizontal welding and can be used with MIG welding with solid wire, metal core wire and can also be used with flux core wire. ✓	 <table border="1"> <tr><td>A</td><td>1/4</td><td>6.3</td></tr> <tr><td>B</td><td>1</td><td>25.4</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>1/4</td><td>6.3</td></tr> <tr><td>E</td><td>1/2</td><td>12.7</td></tr> <tr><td>F</td><td>3/32</td><td>2.4</td></tr> <tr><td>G</td><td>3/32 r</td><td>2.4 r</td></tr> <tr><td>H</td><td>3/4 r</td><td>19. r</td></tr> <tr><td>I</td><td>3/16 r</td><td>4.8 r</td></tr> </table>	A	1/4	6.3	B	1	25.4	C	1	25.4	D	1/4	6.3	E	1/2	12.7	F	3/32	2.4	G	3/32 r	2.4 r	H	3/4 r	19. r	I	3/16 r	4.8 r			
A	1/4	6.3																														
B	1	25.4																														
C	1	25.4																														
D	1/4	6.3																														
E	1/2	12.7																														
F	3/32	2.4																														
G	3/32 r	2.4 r																														
H	3/4 r	19. r																														
I	3/16 r	4.8 r																														
1G66-B (12m - 40ft./ box)	This is for fitting behind a single bevel, single v butt where a fillet weld must be produced on the backside of the joint during welding on the front side of the joint... possibly where access for welding or repairs is not possible. This tile will produce a mitered fillet. ✓	 <table border="1"> <tr><td>A</td><td>11/32</td><td>8.7</td></tr> <tr><td>B</td><td>3/4</td><td>19.</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/32</td><td>5.6</td></tr> <tr><td>E</td><td>5/16</td><td>7.9</td></tr> <tr><td>F</td><td>90°</td><td>90°</td></tr> <tr><td>G</td><td>1/8</td><td>3.2</td></tr> </table>	A	11/32	8.7	B	3/4	19.	C	1	25.4	D	7/32	5.6	E	5/16	7.9	F	90°	90°	G	1/8	3.2									
A	11/32	8.7																														
B	3/4	19.																														
C	1	25.4																														
D	7/32	5.6																														
E	5/16	7.9																														
F	90°	90°																														
G	1/8	3.2																														
1G65-B (12m - 40ft./ box)	Similar applications to the 1G66-B but the fillet weld produced will be a convex radiused fillet instead of a mitered fillet. ✓	 <table border="1"> <tr><td>A</td><td>5/16</td><td>7.9</td></tr> <tr><td>B</td><td>7/8</td><td>22.2</td></tr> <tr><td>C</td><td>1</td><td>25.4</td></tr> <tr><td>D</td><td>7/32</td><td>5.6</td></tr> <tr><td>E</td><td>7/16</td><td>11.1</td></tr> <tr><td>F</td><td>90°</td><td>90°</td></tr> <tr><td>G</td><td>3/32</td><td>2.4</td></tr> <tr><td>H</td><td>9/16 r</td><td>14.3 r</td></tr> </table>	A	5/16	7.9	B	7/8	22.2	C	1	25.4	D	7/32	5.6	E	7/16	11.1	F	90°	90°	G	3/32	2.4	H	9/16 r	14.3 r						
A	5/16	7.9																														
B	7/8	22.2																														
C	1	25.4																														
D	7/32	5.6																														
E	7/16	11.1																														
F	90°	90°																														
G	3/32	2.4																														
H	9/16 r	14.3 r																														

✓ Available in 1/4" to 2" (6.3mm to 50.8mm) tiles.



KBM-18® HEAVY DUTY BEVELLING MACHINES



KBM-18-100

Gullco's KBM-18® & KBM-18U® Portable, Self-Propelled Plate Edge Bevelers produce clean machined bevels with **no thermal distortion** on mild steel, stainless steel and aluminum plate from 1/4" (6.0 mm) to 1 1/2" (38.1 mm) thick. Thinner material can be bevelled... consult factory for details. The KBM-18U® bevels the underside of plate eliminating the need to flip the work piece...**reducing time and cost.** Savings are further enhanced when both units are used in applications where both sides of the material require beveling.

Adjustable Undercarriage...For Easy Height Adjustment

The KBM-18® can be purchased with a adjustable height, self-aligning, spring-loaded caster wheel assembly for self-propelled beveling along any length of plate maintaining a uniform bevel and consistent root face. Undercarriage sold separate

Angle Bevel Pins...Enable Bevel Angle Adjustment

...KBM-18® units are supplied with angle bevel pins for 22 1/2°, 30°, 37 1/2°, 45° and 55° bevels. Pins for other bevel angles are available upon request.

KBM-18®

KBM-18U®

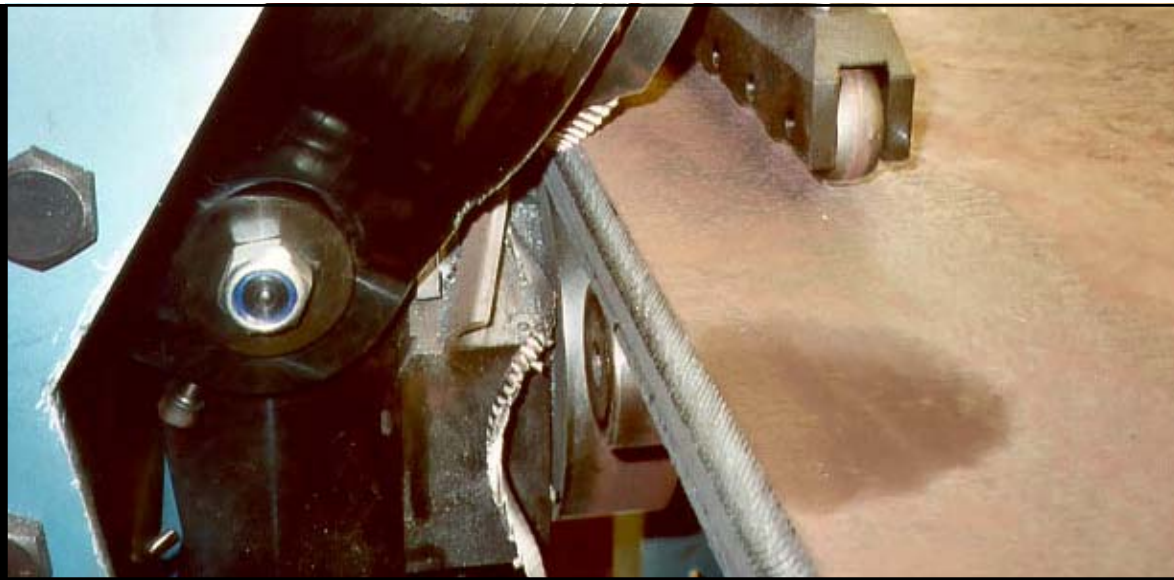
...for beveling the top-side of plate

...for beveling the under-side of plate



Operates at 10 feet (3 meters) per minute*

WITH ADJUSTABLE BEVELLING HEAD TO PRODUCE BEVEL ANGLES 22 1/2° THROUGH 55°



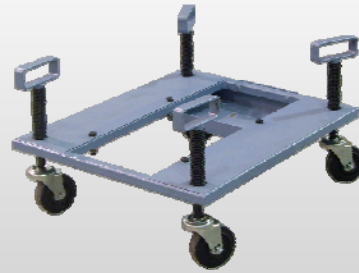
KBM-18® & 18U Self-Propelled Plate Edge Beveller



KBM-18U

KBM-18U UNDERSIDE BEVELLING

The KBM-18U is perfect for beveling the underside of the plate without need for flipping the work piece over. In combination with the KBM-18 efficiency is greatly increased when beveling both the top and bottom of the plate. Safety is also increased as there is no need for constant maneuvering of heavy workloads.



KBM-18-069

CASTER SPRING LOADED ADJUSTABLE UNDERCARRIAGE

Adjustable undercarriages come with Gullco's adjustable height self-aligning spring loaded caster wheel assemblies for self-propelled operation. Best suited for applications where constant machine height is required. The spring-loaded wheels help to eliminate imperfections in the ground to ensure a clean consistent bevel. Sold separate

Maximum Bevel Width:	0.71" (18.00 mm) at standard 30° bevel angle on material with a tensile strength of 64,000 lb/in ² (45 Kg/mm ²)
Maximum Bevel Depth:	0.61" (15.6 mm) at standard 30° bevel angle on material with a tensile strength of 64,000 lb/in ² (45 Kg/mm ²)
Min. Plate Thickness:	1/4" (6.0mm) Thinner material can be bevelled...consult factory for details
Max. Plate Thickness:	1 1/2" (38.1 mm)
Bevel Speed:	120 in. (304.8 cm) per minute*
Motor:	2HP, 3 phase, available for 230, 460 and 575V~ at 60Hz and also 380 and 400/415V~ at 50Hz supply
Weight:	340 lbs. (154Kg.) including undercarriage assembly
Complies With:	C.S.A./N.R.T.L. (File # LR 35006-6) and C.E. Regulations

* top speed can vary depending on bevel depth, voltage and frequency fluctuation

KBM-18® comes complete with the following standard equipment:

- 1- GBM-18-X1 Deep Tooth Cutter (medium cut)
- 1- set Bevel Angle Pins for 22 1/2°, 30°, 37 1/2°, 45° and 55°
- 1- Tool Kit

Accessories available:

- Gullco KBM-18-069 Adjustable Height Undercarriage
- KBM-18-X1C: Medium Tooth Cutter (smooth finish)
- GBM-18-X1: Deep Tooth Cutter (medium cut)
- GBM-18-FXS: Shallow Tooth Cutter (fine cut)
- GBM-18(Specify Degree Required): Angle Bevel Pins for angles other than those supplied as standard
- GBM-18-0.5: Cutter Shims
- GBM-18-1.0: Cutter Shims

MAXIMUM RECOMMENDED BEVELLING CAPACITIES



Bevel Angle	TENSILE STRENGTH					
	64,000 lbs/in ² (45 kg/mm ²)		71,000 lbs/in ² (50 kg/mm ²)		85,000 lbs/in ² (60 kg/mm ²)	
A	W	D	W	D	W	D
22 1/2°	0.71" (18 mm)	0.65" (16.6 mm)	0.63" (16 mm)	0.58" (14.8 mm)	0.55" (14 mm)	0.51" (13 mm)
30°	0.71" (18 mm)	0.61" (15.6 mm)	0.63" (16 mm)	0.55" (13.9 mm)	0.55" (14 mm)	0.48" (12.1 mm)
37 1/2°	0.67" (17 mm)	0.53" (13.5mm)	0.59" (15 mm)	0.47" (11.9 mm)	0.51" (13 mm)	0.41" (10.3 mm)
45°	0.63" (16 mm)	0.45" (11.3mm)	0.55" (14 mm)	0.39" (9.9 mm)	0.47" (12 mm)	0.33" (8.5 mm)
55°	0.59" (15 mm)	0.34" (8.6 mm)	0.51" (13 mm)	0.29" (7.5 mm)	0.43" (11 mm)	0.25" (6.3 mm)



KBM-18-069
KBM-18-100



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KBM-28® HEAVY DUTY BEVELLING MACHINES**KBM-28® & KBM-28U® Heavy Duty Portable, Self-Propelled Plate Edge**

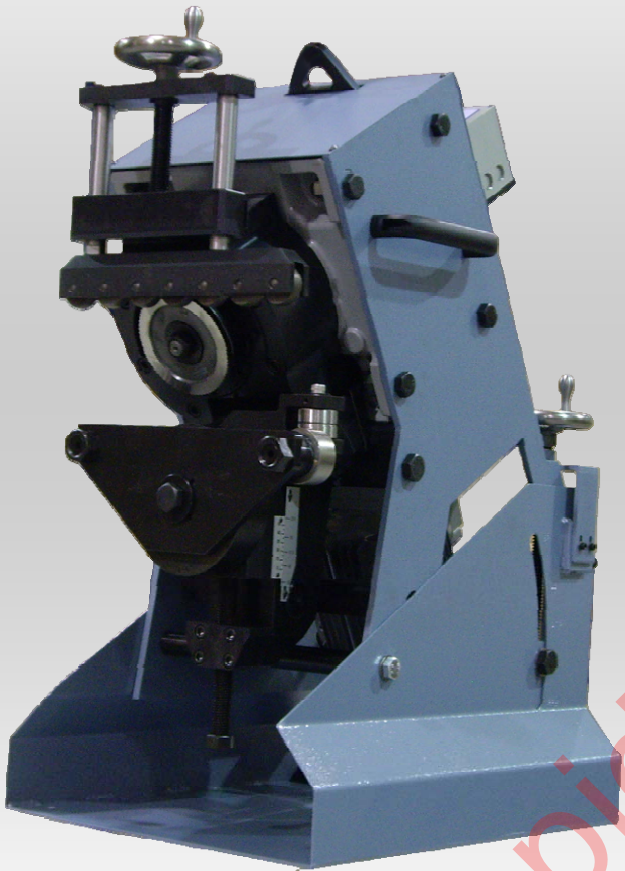
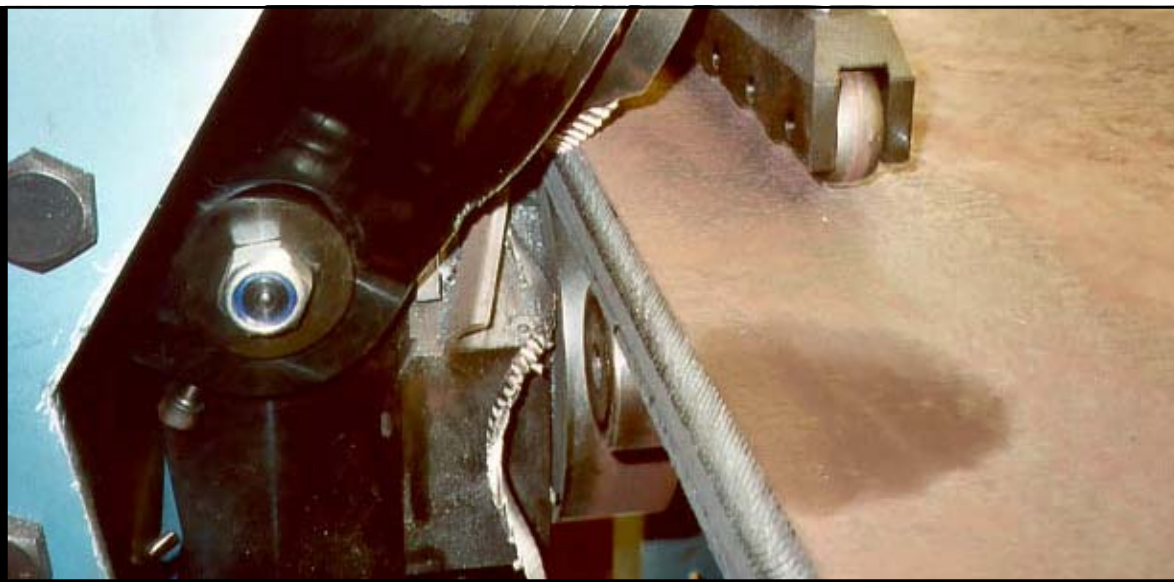
Bevellers produce clean machined bevels with **no thermal distortion** on mild steel, stainless steel and aluminum plate from 5/16" (8.0 mm) to 2" (50.0 mm) thick. The KBM-28U® bevellers the underside of plate eliminating the need to flip the workpiece...**reducing time and cost**. Savings are further enhanced when both units are used in applications where both sides of the material require bevelling.

Adjustable Undercarriage...For Easy Height Adjustment

The KBM-28® units can be purchased with Gullco's exclusive adjustable height self-aligning spring-loaded caster wheel assembly for self-propelled bevelling along any length of plate maintaining a uniform bevel and consistent root face. Sold separate

Angle Bevel Pins...Enable Bevel Angle Adjustment

...KBM-28® units are supplied with angle bevel pins for 22 1/2°, 30°, 37 1/2°, 45° and 55° bevels. Pins for other bevel angles are available upon request.

**KBM-28-100****KBM-28®****KBM-28U®***...for bevelling the top-side of plate**...for bevelling the under-side of plate***Operates at 6.5 feet (2 meters) per minute*****WITH ADJUSTABLE BEVELLING HEAD TO PRODUCE BEVEL ANGLES 22 1/2° THROUGH 55°**

KBM-28® & 28U Self-Propelled Plate Edge Beveller



KBM-28-080

HYDRAULIC ADJUSTABLE UNDERCARRIAGE

For easy height adjustment

KBM-28 units can be supplied with choice of undercarriages. Both are supplied with Gullco exclusive self-aligning caster wheel assemblies for self-propelled bevelling along the length of the plate, maintaining a uniform bevel and consistent root face. Undercarriage sold separate



KBM-28-002

Best suited for applications when frequent height adjustments are required.

Adjustable undercarriage supplied with Gullco's adjustable height self-aligning spring-loaded caster wheel assemblies for self-propelled operation. Best suited for applications where constant machine height is required.

- Maximum Bevel Width:** -1.10" (28.00 mm) at standard 30° bevel angle on material with a tensile strength of 64,000 lb/in² (45 Kg/mm²)
- Maximum Bevel Depth:** -0.95" (24.2 mm) at standard 30° bevel angle on material with a tensile strength of 64,000 lb/in² (45 Kg/mm²)
- Min. Plate Thickness:** -5/16" (8.0 mm)
- Max. Plate Thickness:** -2" (50.0 mm)
- Bevel Speed:** -78.7" (200 cm) per minute*
- Motor:** -3 HP, 3 phase, available for 230, 460 and 575V~ at 60Hz and also 380 and 400/415V~ at 50Hz supply
- Weight:** -890 lbs. (404Kg.) including undercarriage assembly
- Complies With:** -C.S.A./N.R.T.L. (File # LR 35006-6) and C.E. Regulations

KBM-28 U

The KBM-28U is perfect for bevelling the underside of the plate without need for flipping the work piece over. In combination with the KBM-28 efficiency is greatly increased when bevelling both the top and bottom of the plate.



* top speed can vary depending on bevel depth, voltage and frequency fluctuation

KBM-28® comes complete with the following standard equipment:

- 1- GBM-28-X1 Deep Tooth Cutter (medium cut)
- 1- Set Bevel Angle Pins for 22 1/2°, 30°, 37 1/2°, 45° and 55°
- 1- Tool Kit

Accessories available:

- **KBM-28-X1C:** Medium Tooth Cutter (smooth finish)
- **GBM-28-X1:** Deep Tooth Cutter (medium cut)
- **GBM-28-FXS:** Shallow Tooth Cutter (fine cut)
- **GBM-28:** (Specify Degree Required): Angle Bevel Pins for angles other than those supplied as standard
- **GBM-28-0.5:** Cutter Shims
- **GBM-28-1.0:** Cutter Shims
- **KBM-28-080:** Hydraulic Undercarriage
- **KBM-28-002:** Adjustable Undercarriage

MAXIMUM RECOMMENDED BEVELLING CAPACITIES



Bevel Angle	TENSILE STRENGTH					
	64,000 lbs/in ² (45 kg/mm ²)		71,000 lbs/in ² (50 kg/mm ²)		85,000 lbs/in ² (60 kg/mm ²)	
A	W	D	W	D	W	D
22 1/2°	1.10" (28 mm)	1.02" (26 mm)	1.02" (26 mm)	0.95" (24 mm)	0.91" (23 mm)	0.84" (21.2 mm)
30°	1.10" (28 mm)	0.98" (25 mm)	0.98" (25 mm)	0.85" (21.7 mm)	0.89" (22.5 mm)	0.77" (19.5 mm)
37 1/2°	1.06" (27 mm)	0.84" (21.2 mm)	0.98" (25 mm)	0.78" (19.8 mm)	0.83" (21 mm)	0.66" (16.7 mm)
45°	1.02" (26 mm)	0.72" (18.4 mm)	0.94" (24 mm)	0.67" (17 mm)	0.83" (21 mm)	0.58" (14.8 mm)
55°	0.98" (25 mm)	0.56" (14.3 mm)	0.91" (23 mm)	0.52" (13.2 mm)	0.83" (21 mm)	0.47" (12 mm)

GULLCO



KBM-28-100
KBM-28-080

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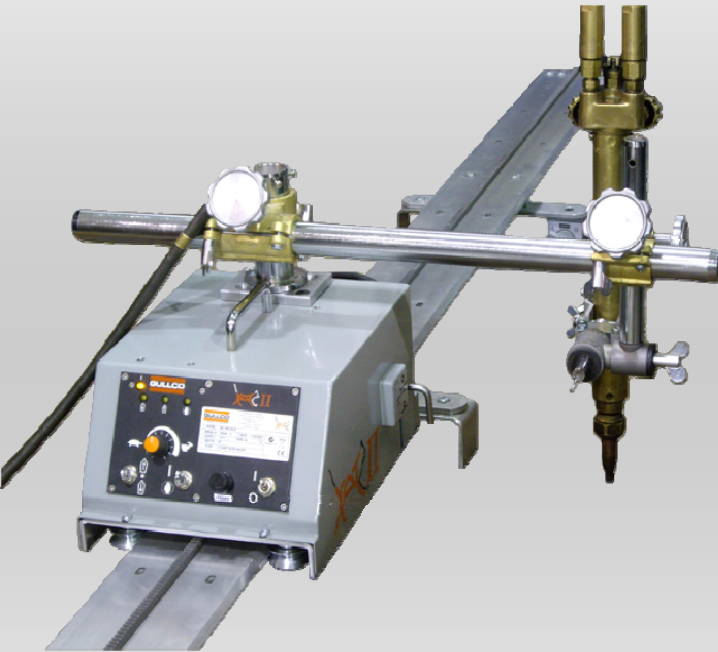
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KAT II ALL POSITION TRAVEL CARRIAGE



This system* incorporates everything required to automate your cutting/ welding operations...quickly, easily, economically. It is comprised of the Kat II travel carriage and rigid 8 ft. (2438mm) straight track and torch or gun holder assembly. The carriage travels in a forward or reverse direction (vertical or horizontal) on its track, moving the torch or welding gun along the pre-set path at precisely controlled speeds. The accuracy, uniformity and quality of the cut or weld is improved. Productivity is increased. Costs reduced. It is important to note that the Kat II carriage is **not designed to travel on radius roll formed track.**

*The carriage and accessories that make up this system (see reverse) can also be purchased separately

AND...YOU CAN EASILY CONVERT YOUR KAT II INTO AN EXCELLENT CIRCLE CUTTING MACHINE

This Gullco accessory, comprised of undercarriage, radius arm and centering pin, eliminates the need for track. The travel carriage is readily fitted on the top of the undercarriage. Its drive system engages the undercarriage gears ...moving the assembly in a forward or reverse direction at desired cutting speeds along a perfectly circular path. A slide lock on the radius arm allows fast, easy adjustment of the circular diameter.

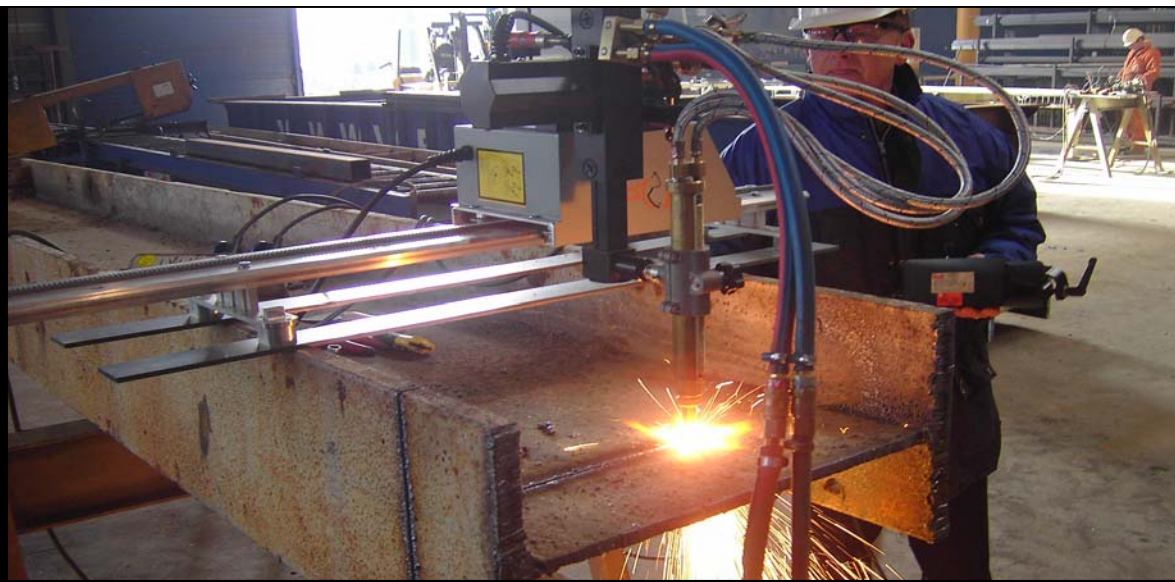


*Automates Cutting/ Welding Operations**

ALL POSITION TRAVEL CARRIAGE FOR TORCH CUTTING/ WELDING



WELDING AND CUTTING AUTOMATION



KAT II ALL POSITION TRAVEL CARRIAGE

SPECIFICATIONS

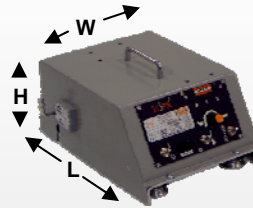
KAT II AUTOMATED CUTTING/WELDING SYSTEM

The Gullco Kat II Travel Carriage is combined with an appropriate series of accessories to provide either the Torch Cutting Package or Welding Package. The following briefly describes the Kat II carriage:

KAT II Carriage- Model GK-189-045

A light duty, all position variable speed travel carriage with electronic drive, dynamic braking and speed potentiometer providing infinite speed selection within the range of 2-45 ipm (5-114cm/min.). It is equipped with Forward/Reverse switch, Run/Stop switch and slow-blow fuse, and "power on" pilot light. The carriage is designed to run only on rigid, straight Kat track. It has a vertical load capacity of 50 lbs. (23 kg.)

Safety is assured by the use of Gullco's low voltage, (24 volt D.C) highly advanced control/ power supply system that is available in three line voltage inputs...42, 110, and 230 volt A.C single phase, 50/60 Hz. Specify line voltage when ordering.



DIMENSIONS

(KAT II Travel Carriage Only)

W- 8 3/4" (22cm)

H- 5 3/4" (14.5cm)

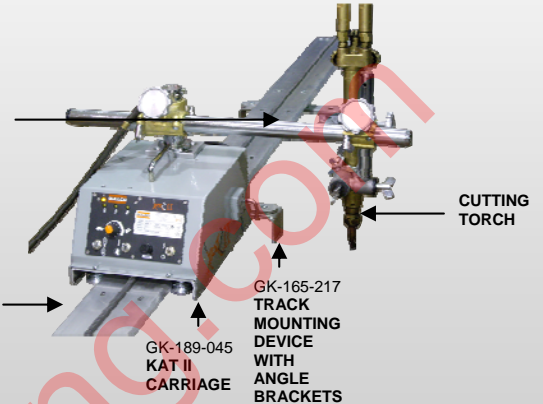
L- 12 1/4" (31cm)

WEIGHT

Approx. 17 lbs (7.8kg)

GK-165-215
TRACK
MOUNTING
DEVICE
WITH ON/OFF
MAGNET

GK-165-52-1
KAT TRACK



GK-189-045
KAT II
CARRIAGE

GK-165-217
TRACK
MOUNTING
DEVICE
WITH
ANGLE
BRACKETS

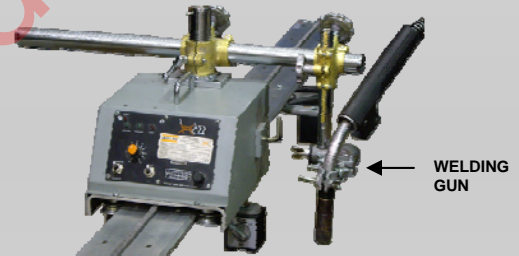
CUTTING
TORCH

WELDING OR CUTTING TORCH RACK ACCESSORY



GK-189-054

WELDING OR CUTTING TORCH RACK ACCESSORY



WELDING
GUN

MODEL GK-184-200 CIRCLE CUTTING ACCESSORY

Includes: NOT SHOWN

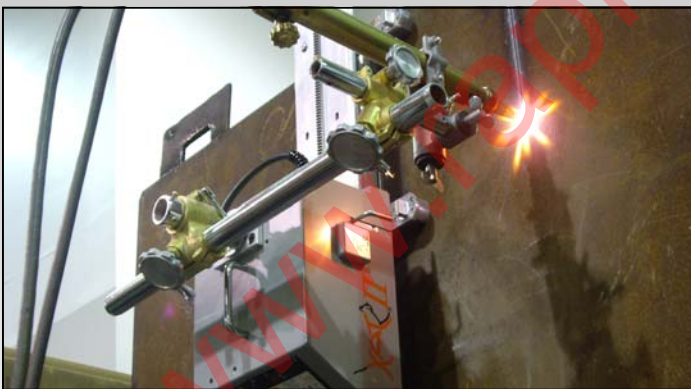
Undercarriage:

-equipped with gear assembly that is engaged and driven by carriage gear system. Also has a clutch that allows free-wheeling during set-up.

Radius arm- 36" long

-with slide/lock for diameter size adjustment.

Magnet/Holder for centering pin. (not shown in cover photo).



Capable of cutting in all positions: vertical, horizontal and circular



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GULLCO



Model GM-02-295

Model GM-02-275

GULLCO SAM - Submerged Arc Moggy HEAVY DUTY MOGGY FOR SUBMERGED ARC AND MIG WELDING

The versatility and reliability of the world famous Gullco "Moggy" trackless travel carriage system and a variety of quality engineered components combine to provide a highly flexible self-contained welding unit. This Gullco unit is designed to produce precision, quality **Submerged Arc or MIG welds**.

SAM Carriage, Model GM-02-295 - Friction drive heavy-duty travel Carriage, with positive chain drive on four (4) rubber tired wheels using a closed loop tack feedback for accurate speed control. Carriage controlled by the Gullco low voltage 24 volt GSP microprocessor pulse width modulation motor control, all mounted in a remote pendant control box attached to 8 ft. (243.84 cm) control cable housing the GSP control providing the forward/stop/reverse switch and infinitely variable 4-turn speed potentiometer. LED display in IPM or cm/min. An interface cable assembly allows the Miller HDC 1500 DX to control the run/stop function of the SAM Carriage. A manual clutch enables free wheeling. Carriage complete with a main mounting mast and handle assembly, mounting arm for one wire reel, all mounting arms equipped with quick jaw mast clamp assembly; vertical and horizontal manual 4" x 4" slides (with hardened ground rods with sleeve bearings for ease of adjustment). Control support arm and one (1) set (two[2]) adjustable guide roll arms. For operation on either 42/115/230 volts, single phase, 50/60 Hz AC power supply.

SAM Carriage, Model GM-02-275 - SAM Heavy-Duty Friction Drive Carriage for mounting customer's supplied single sub-arc package. Carriage specifications same as model GM-02-295. No welding equipment is supplied.

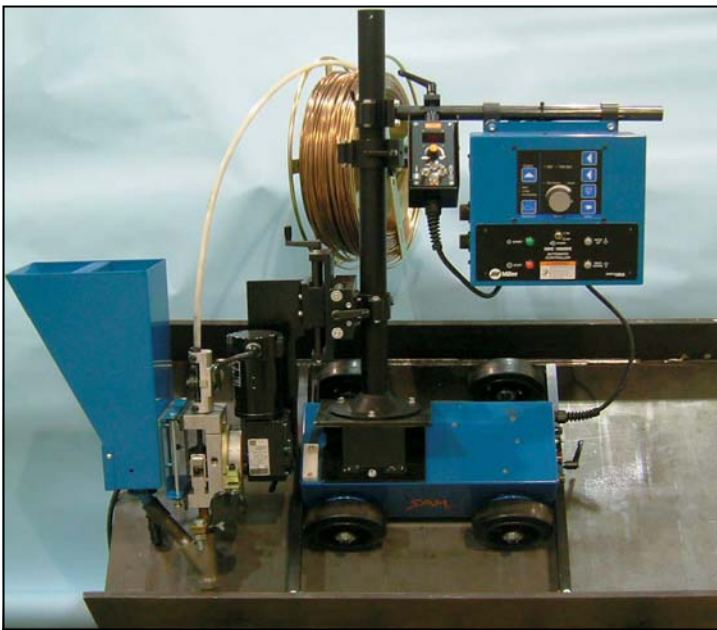


SPECIFICATIONS

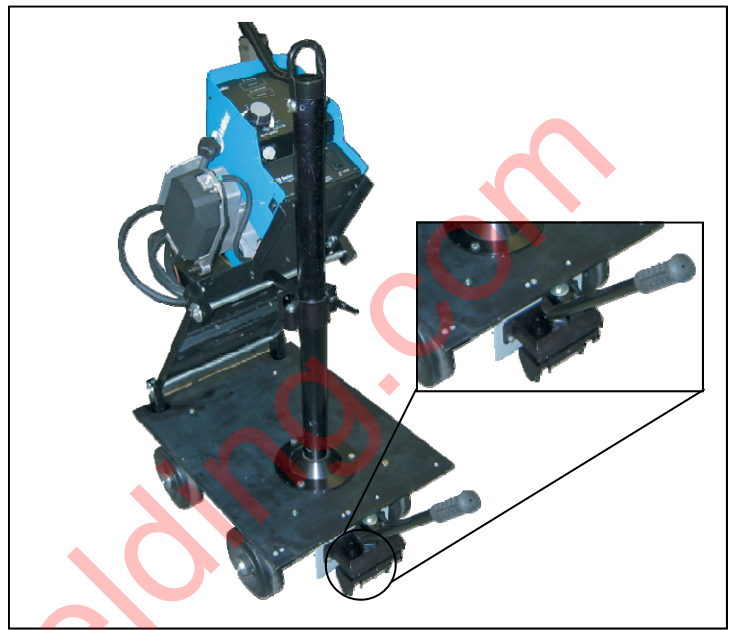


GM-02-250 SAM Heavy-Duty Friction Drive Carriage

Carriage specifications same as that of the GM-02-295, but provided with 17" x 22" (43.18 x 55.89 cm) aluminum plate providing full flat mounting surface for customer's supplied wire feeder.



SAM Submerged Arc Carriage...Shown set at 45° for beam welding application



SAM Heavy-Duty MIG Carriage...Shown supplied with optional steering mechanism and mast assembly

Special track and wheels

- available upon request.

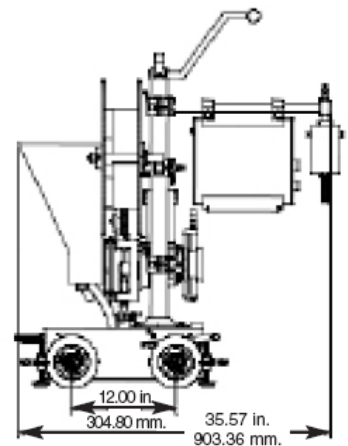
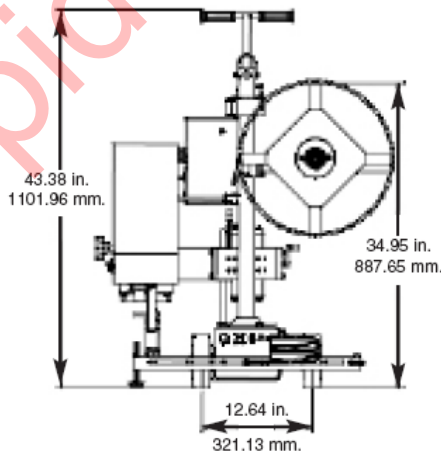


SPECIFICATIONS:

Power Supply: for operation on either 42/115/230 volts, single phase, 50/60 Hz AC. (Specify voltage when placing order - B = 115 V, C = 230 V).

Speed Range: 4 to 6.1 ipm. (10 to 168 cm/min)

Weight: 172 lbs. (78 kg)



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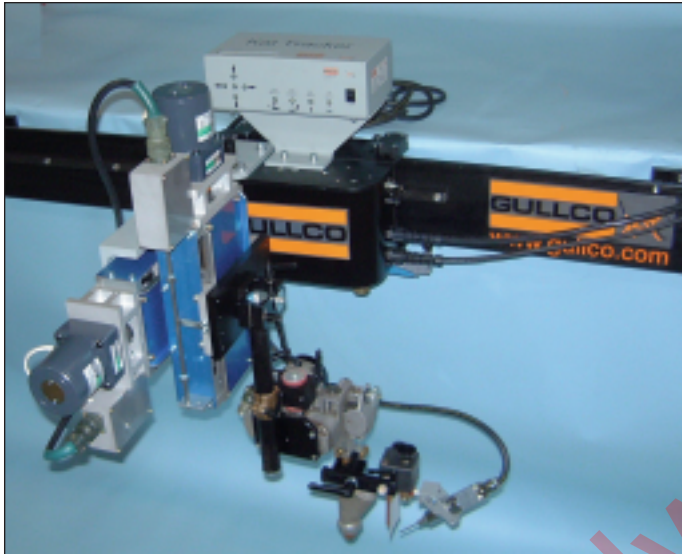
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Variable Speed
***Side Beam* Travel Carriages**
 From 12" to 36" Long



Gullco Side Beam Carriage shown with Gullco Kat Tracker and Miller Submerged ARC Head



Gullco Side Beam Carriage shown hard facing a sugar crusher.

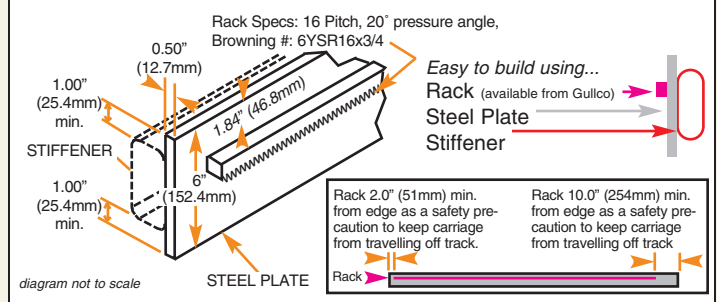
Gullco Variable Speed Side Beam Carriages have a load capacity up to 1000 lbs.

This unit is controlled by a Gullco closed loop tack feedback low voltage GSP microprocessor pulse width modulation motor control interfaced with the forward/stop/reverse switch, infinitely variable 4-turn speed potentiometer with LED display and limit switches for arc start time delay and end of travel.

IDEAL FOR MOUNTING:

- MIG WIRE FEEDER
- SUBMERGED ARC HEAD, WIRE, FLUX
- SEAM TRACKER

Custom Build Your Own "Side Beam" Track



Gullco Side Beam Carriages are very versatile and can be equipped with a variety of different accessories suitable for a broad range of applications.

track is available in 5, 8 and 10 foot lengths

see our new Automatic Gouging Machine ➤



GULLCO



Kat Automatic Gouging Machine

SMALL · COMPACT · POWERFUL

Performs smooth consistent gouging operation in the *flat, horizontal and vertical down position* using the SYMEX STAR TRAC II Automatic Gouging System.

- use for continuous gouging of long seams in the manufacturing of ships, pressure vessels, tanks, bridges etc.
- high resolution voltage control capability regulates accurate gouging depth to a machine-like tolerance of $\pm .015"$ (0.4mm) even over a warped plate.
- total weight approximately 49 lbs less track.
- equipped to work with 3/8" to 5/8" jointed gouging electrodes up to 1200 amps. (available from Gullco)
- ideally suited for out-of-position work due to compact design and light weight.

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see our new Side Beam Carriages

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GULLCO



POWER ROLL WITH FOOT SWITCH: **MODEL KR-200-L & MODEL KR-200-M** IDLER ROLL: **MODEL KR-750**

“KAMEL” PIPE TURNING ROLLS

Reduce pipe preparation costs with this rugged, portable equipment which rotates pipe from 2” to 16” (51 - 406mm) diameter. Two models are available; **Model KR-200-L** has a turning capacity of 1500 lbs (680 kg), and an infinitely variable forward/reverse speed range of 1-35.4 ipm (2.5-89.9 cm/min). **Model KR-200-M** has a turning capacity of 1500 lbs (680 kg) and an infinitely variable forward/reverse speed range of 2.2-70.8 ipm (5.6-180 cm/min). Rotation speed is precisely controlled and displayed in inches/mm per minute on an LED readout. Contact Gullco or your Gullco distributor for complete details on these highly efficient, very affordable turning rolls.

Long life, 6” (15.24 cm) diameter roller bearing wheels with rubber tires provide friction drive and uniformly smooth pipe rotation.

Electronic controls are immune to damage from high frequency and electromagnetic interference.

Portable: total weight of power and idler roll is 69 lbs. (31.3 kg). Use anywhere that 42, 115 or 220-240 volts* 50/60 cycle single phase power supply is available.

Protected on/off foot switch on 7.5 ft. (2.3m) cable provides maximum convenience and freedom for operator.



SPECIFICATIONS



GULLCO SPECIFICATIONS

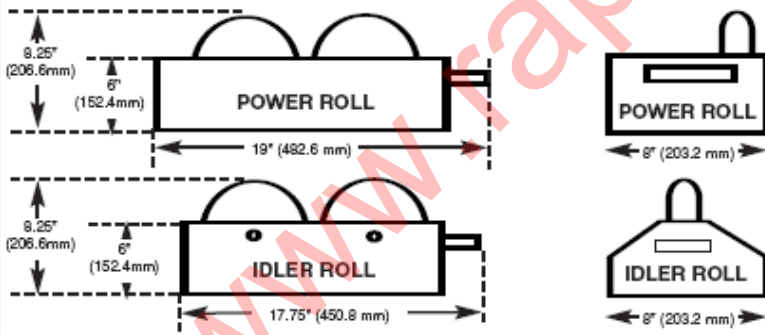
MODELS KR 200-L AND KR-200-M "KAMEL" PIPE TURNING ROLLS AND MODEL KR-750 IDLER ROLLS.



Models KR 1500-35 and -70 are comprised of a Power Unit and protected on/off Foot Switch on a 7.5 ft. (2.3m) control cable. They incorporate a pilot light, forward/stop/reverse switch, speed potentiometer, LED readout for inches/mm per minute and foot switch cable connection.

	POWER ROLLS	
	Model KR-200-L	Model KR-200-M
TURNING CAPACITY	1500 LBS (680 kg)	1500 lbs (680kg)
LOAD CAPACITY/ROLL	750 LBS (340 kg)	750 LBS (340 kg)
PIPE DIA. RANGE	2"-16" (51-406 mm)	2"-16" (51-406mm)
SPEED RANGE	1-35.4 ipm (2.5-89.9 cm./min.)	2.2-70.8 ipm (5.6-180 cm./min.)
WEIGHT	48 lbs (21.8 kg)	48 lbs (21.8 kg)
	IDLER ROLLS Model KR-750	
LOAD CAPACITY	750 lbs (340 kg)	
PIPE DIA. RANGE	2" - 16" (51-406 mm)	
WEIGHT	21 lbs (9.5 kg)	

DIMENSIONS: POWER AND IDLER ROLLS



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FREE STANDING TORCH SUPPORTS AND TORCH / GUN HOLDERS

MODEL KR-1000 CSB TORCH SUPPORT

1 1/8" (28.6mm) square rack arms providing 22" (866 mm) of vertical adjustment and 10 1/2" (266.7 mm) of horizontal adjustment. Weight: 25 lbs (11.34 kg)



MODEL KR-2000 CSB TORCH SUPPORT

Same as above but 1 1/2" (38.1mm) square rack arms providing 18" (709 mm) vertical adjustment and 6 1/2" (165.1mm) of horizontal adjustment. Supplied with swivel mounted standard rack-type cutting torch holder. Weight: 42 lbs (19.05 kg)



MODEL KR-1000 WSB TORCH SUPPORT

1 1/8" (28.6 mm) square rack arm providing 22" (866mm) of vertical adjustment and 10 1/2" (266.7mm) of horizontal adjustment. Weight: 25 lbs. (11.34kg)

MODEL KR-2000 WSB TORCH SUPPORT

Same as above but 1 1/2" (38.1mm) square rack arms providing 18" (709 mm) vertical adjustment and 6 1/2" (165.1 mm) of horizontal adjustment. Supplied with insulated 4 motion, semi-automatic gun holder and swivel arm that allows adjustment of gun angle tilt. Weight: 42 lbs. (19.05 kg)



NOTE:

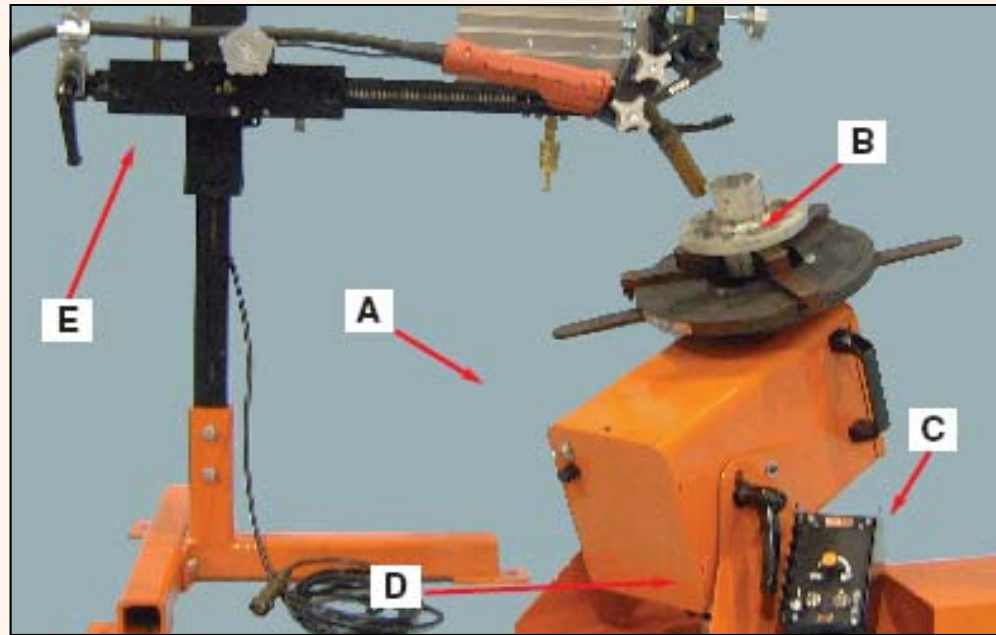
The above models can be, and often are, supplied with the Gullco Motorized Rack Arm, equipped with a remote joy stick control. See Gullco Bulletin TPA-91 for detailed information.

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ITEM DESCRIPTION

- A - Welding Positioner
- B - 3 Jaw Gripper
- C - Footswitch Assembly for Manual Operation
- D - Wire-feed/Arc Start Signal Kit
- E - Pneumatic Gun Positioning Assembly

AN ACCURATE AND RELIABLE AUTOMATIC ROTARY WELD PRODUCTION SYSTEM FOR A FRACTION OF THE PRICE OF A P.L.C./SERVO SYSTEM.

Gullco's new microprocessor control not only provides improved speed regulation to Gullco's proven "GP" range of positioners, it also allows the positioner to be expanded into a fully automated welding cell. The control uses a tach feedback system to ensure smooth and accurate rotation of the workpiece and has the ability to activate pneumatic welding gun holder and wire-feed/arc activation signals, based on an operator defined welding cycle. The programmable microprocessor also provides adjustable positioning timing cycles, amount of weld rotation and weld on/off through 360°.

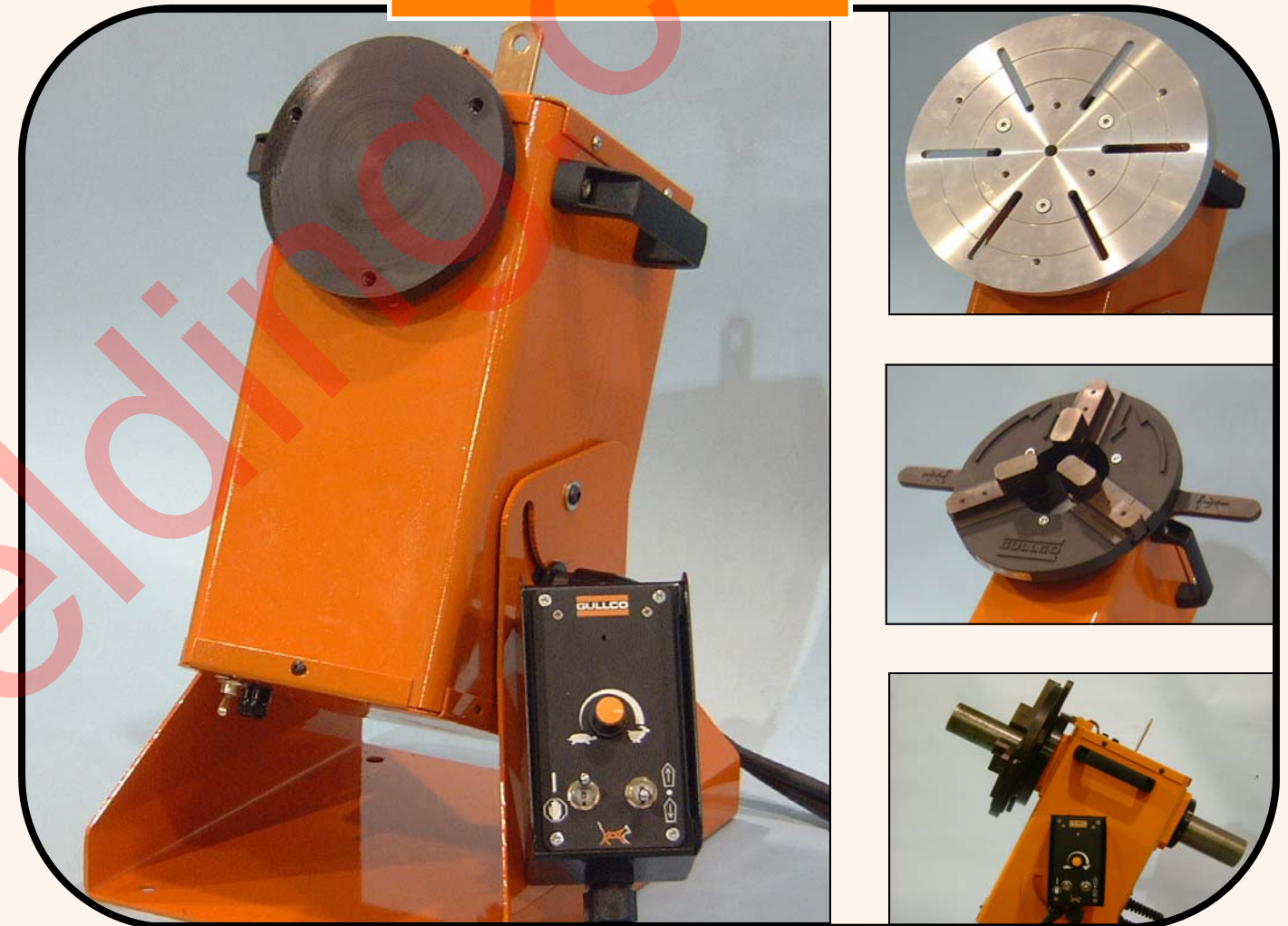
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WELDING POSITIONER

*increase productivity, quality and profitability in
circumferential
welding applications*

Gullco Welding Positioners are positive drive rotary turn tables complete with mounting flange, drive and tilt mechanisms and Microprocessor based pulse width modulation motor controls. Standard and Programmable models are available. They are driven by a low voltage permanent magnet motor and gearhead power unit assembly. The microprocessor motor control enables operator interface of start, stop, clockwise rotation, neutral, counter clock-wise rotation and infinitely variable control of the speed, within the range of the model.

Rotation speed is electronically controlled using an optical tachometer located on the back of the gear-motor. Speeds within the range of the model are infinitely variable in both clockwise and counter-clockwise directions through a rotary speed adjustment potentiometer located on the remote control. Table tilt is manually set at any desired angle, from 0° through 90°, quickly and easily. Safety is greatly enhanced with Gullco's low voltage (24 V) control and power supply system.



GULLCO Welding Positioners

GP/GPP 200 SERIES POSITIONERS ARE AVAILABLE IN STANDARD OR PROGRAMMABLE MODELS WHICH ARE EQUIPPED WITH CORRESPONDING REMOTE CONTROLS

STANDARD

The Standard Remote Control provides

- infinitely variable rotation speed within the model's speed range,
- forward/neutral/reverse switch,
- run/stop switch
- speed potentiometer



PROGRAMMABLE

The Programmable Remote Control with LED readout provides

- infinitely variable rotation speed within the model's speed range,
- forward/neutral/reverse switch,
- run/stop switch
- programmable microprocessor providing adjustable positioning timing cycles, amount of weld rotation, weld on/weld off through 360° and a signal to activate a pneumatically operated weld gun holder and wire feed arc activation.



FOOTSWITCHES (optional)

Three footswitch models are available;

GP-200-024 - Run/Stop footswitch assembly for manual operation. This kit provides a run/stop footswitch; a footswitch guard cover; a connecting control cable; and strain relief glands. When activated, the footswitch will provide a run signal to the control.



GP-200-025 - Variable Speed footswitch assembly for manual operation. This kit provides a run/stop/variable speed footswitch; a footswitch guard cover; a connecting control cable; and strain relief glands. When activated, the footswitch will provide a run signal to the control and allow regulation of the rotational speed via the compression of the footswitch pedal.

GP-200-023 - Forward/Stop/Reverse footswitch assembly for manual operation. This kit provides a directional footswitch; a footswitch guard cover; a connecting control cable; and strain relief glands. When activated, the footswitch will provide a run signal and rotary direction signal to the control.

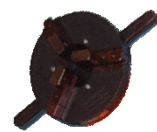
PURGE-EQUIPPED MODELS:

have a 1/4" (6.4 mm) hole through the centre of the table drive shaft and a gas rotary coupling mounted on the underside of the table ... the shaft having a 1/4" NTP tapped gas inlet hole.



GULLCO SELF-CENTERING WELDING GRIPPER

(optional)
The Gullco **WPG-250** Gripper is quickly and easily mounted on any make of positioner, turntable or tail stock. They are slim but rugged... weighing only about half that of a standard chuck, minimizing reduction in positioner capacity. Single lever provides smooth, positive self-centering "close/open" action.

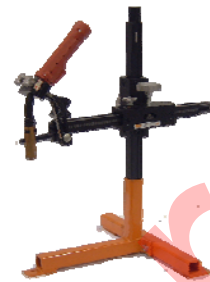


MOUNTING TABLE (optional)

Gullco GP-200-016 12" (305mm) diameter mounting table. This round mounting table is used to facilitate direct mounting of components or fixtures and provides (6) radial mounting slots and various three (3) hole pitch circle bolt patterns. The mounting table is quickly and easily mounted on the positioner spindle flange.



Gullco offers a wide range of accessories that provide low cost welding/cutting automation solutions including...



KR-1000 & 2000 WSB

KR-1000 WSB...free standing support and welding gun holder assembly. 1-1/8" (28.6mm) square rack arms and rack boxes provide 11-1/2" (292.1mm) of vertical adjustment and 10-1/2" (266.7mm) of horizontal adjustment. Supplied with swivel mounted, adjustable gun holder assembly.

KR-2000 WSB Same as above, except uses 1-1/2" (38.1mm) rack arms and rack boxes and provides 7-1/2" (190.5mm) of vertical and 6-1/2" (165.1mm) of horizontal adjustment.

KR-1000 CSB & KR-2000 CSB are the same as above except they are supplied with swivel mounted, standard rack-type cutting torch holder instead of welding gun holder

CUSTOMIZED AUTOMATION

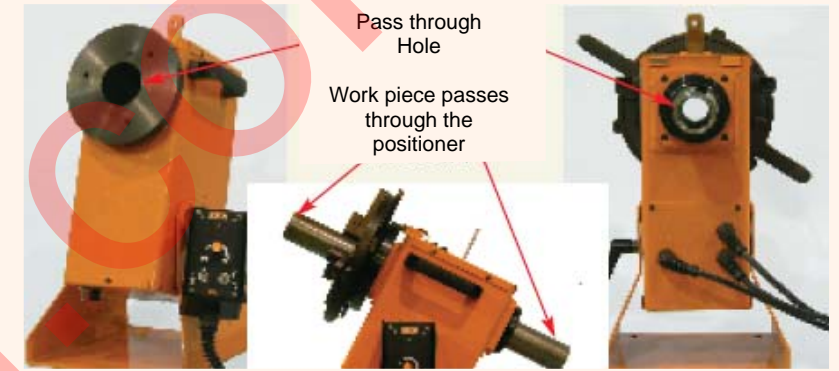
The above cutting torch and welding gun support assemblies can be, and often are, equipped with one or two Gullco motorized rack arms controlled by a remote joystick pendant.



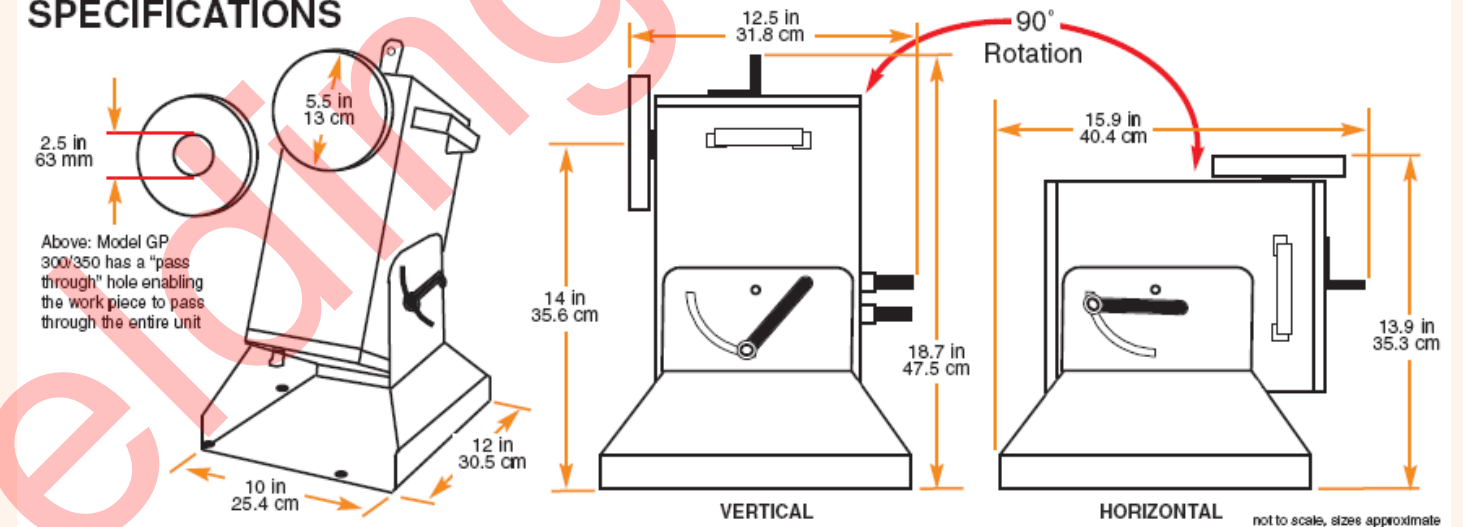
KR-1000 & 2000 CSB

Model GP-300/350 "Through Hole" Positioners

These positioner models are designed with a 2.5 inch (63 mm) "through hole" so the work piece can be passed through the unit... making production on long pieces easier and faster.



SPECIFICATIONS



LOAD CAPACITY/SPEEDS

Models:
GP/GPP-(200 & 250)-M and GP (300 & 350)-M
(Speeds 0.27 to 4.63 RPM) 150 lbs. (68 kg) at 3" (76 mm) center of gravity and 3" (76 mm) eccentricity with the table in the vertical position...300 lbs. (136 kg) with the table horizontal.

Models:
GP/GPP-(200 & 250)-H and GP (300 & 350)-H
(Speeds 0.75 to 12.5 RPM)
75 lbs. (34 kg) at 3" (76 mm) center of gravity and 2" (51 mm) eccentricity with the table in the vertical position...150 lbs. (68 kg) with the table horizontal.

Model	Gas Purge	Programmable	Rotational Speed	Vertical Table Loading @ 3" C of G	Horizontal Table Loading
GP-200 & 300-M			0.27 - 4.63 RPM	150 lbs. (68 kg.)	300 lbs. (132 kg.)
GPP-200-M	■				
GP-250 & 350-M		■			
GPP-250-M	■	■	0.75 - 12.5 RPM	75 lbs. (34 kg.)	150 lbs. (68 kg.)
GP-200 & 300-H					
GPP-200-H	■				
GP-250 & 350-H		■			
GPP-250-H	■	■			

TABLE ROTATION

Electronically controlled, infinitely variable in either direction. Positive drive.

TABLE TILT

0° through 90°

ROTATIONAL TORQUE

GP/GPP-(200 & 250)-M and GP (300 & 350)-M 450 inch lbs. (518 kg.cm)

GP/GPP-(200 & 250)-H and GP (300 & 350)-H 150 inch lbs. (172 kg.cm) through the speed range. The maximum allowable eccentricity of centre of gravity of the work piece for a given load in inches is calculated as follows.

450 weight of work in lbs.
The weight must not exceed the values for overhung load ratings shown below.

C of G	(D) Distance		(L) Load	
	IN.	MM.	LBS.	KGS.
3	3	76	150	68
6	6	152	97	44
9	9	229	72	33
12	12	305	57	26

GULLCO ELECTRODE STABILIZING OVENS

specifications

	PORTABLE OVENS				COMPACT IN-SHOP MODELS			
	10 A-20	10 B-20	10 N-20	50	125	350	350A	1000
Capacity	10 to 20 lbs			50 to 70 lbs.	125 to 175 lbs.	350 to 400 lbs.		Sixteen 12" Spools/1000 lbs.
Outside Dimensions	7" dia. x 23" high			11" dia. x 23" high	16"h x 16" w x 24 1/2"d	22"h x 22"w x 24 1/2" d		39 3/4"h x 30 1/4"w x 30 3/4"d
Inside Dimensions	3" dia. x 19" high			7" dia. x 19" high	8 1/4"h x 9 3/4"w x 19"d	14"h x 16"w x 19"d		24"h x 21 3/4"w x 24"d
Unit Weight (approx.)	14 lbs.			32 lbs.	58 lbs	105 lbs.		330 lbs.
Electrode Size	up to 18"			up to 18"	up to 18"	up to 18"		up to 24"
Line Cord	3 wire - 8 ft.			3 wire - 8 ft.	3 wire - 8 ft.	3 wire - 8 ft.	None	None
Element	100W - 115Volt	125W - 115Volt	300W - 115Volt	300 W - 115 Volt	1000 W - 115 V	1500 W - 115 V	1500 W - 220/440 V	3000 W - 220/440 V - 1 Phase
Thermostat	No	Yes	Yes (2)	Yes	Yes	Yes		Yes
Pilot Light	Yes			Yes	Yes	Yes		Yes
Temp. Range	Av. 275° F	100° - 300° F		100° - 300° F	100° - 550° F	100° - 550° F		100° - 550° F
Door Latch	Lift Lid			Lift Lid	Push/Pull	Push/Pull		Push/Pull
Stacking	No			No	Yes	Yes		Yes

All specifications subject to change without notice note: Weight capacity depends on electrode length

and for flux conditioning and control...

flux hoppers and holding ovens



The 100 lb. capacity hopper and 600 lb. capacity holding oven illustrated at right are just part of a complete range of flux conditioning/control units available from Gullco. All are equipped with low watt density elements to maintain uniform temperature through the flux load...all are designed to assure that the most stringent flux specifications are maintained. Complete details are provided in Gullco Bulletin GHO. Bulletins are readily available from Gullco or your Gullco

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Ovens-09-01-1



GULLCO



compact, in-shop models

...and portables

ELECTRODE STABILIZING OVENS

- Eliminate the risk of costly rework and rejects
- Ensure consistent physical properties and x-ray quality welds
- Protect low hydrogen quality in electrode and flux-cored wire
- Protect coatings on aluminum, bronze, cast iron Stainless and other electrodes



SELECT FROM THE WORLD'S MOST COMPLETE RANGE OF ELECTRODE STABILIZING OVENS

THE PORTABLES...

They're lightweight, rugged and completely portable...easy to load, easy to carry...ready to provide low cost control of welding quality in the shop or in the field. Reduce operating costs by providing your welding operators with fast access to electrodes at the point-of-work. There's a model exactly suited to your requirements.



Thermometer/ Rod Lifter Accessory

Model T10 - for use with portable oven models 10 A-20 and 10B-20... a two compartment rod lifter with thermometer top mounted and protected.

For Added Protection From Ground Damage

...The Gullco Model 10-RS Oven Riser Stand raises all Gullco 10 & 20 lb. portable ovens 6 1/2" from the ground surface adding to stability and protection in extremely adverse job site conditions.



20 POUND CAPACITY PORTABLES

Model 10 A-20

Operates from any 115 volt, AC/DC source, is equipped with rod lifter, pilot light and has 1" high false bottom to prevent moisture damage to electric connections. Oven temperature, not controlled by thermostat, average 275° F Provides absolute electrode stability when used in conjunction with temperature controlled ovens

Model 10 N-20 Nuclear

Operates on 115 volt, AC only. Has two pilot lights and two thermostats that maintain oven temperature in 100-300°F range. Equipped with divided rod lifter with provisions for thermometer- part 1029

Model 10 B-20

Operates on 115 volt, AC only. Has rod lifter, pilot light, and thermostat that maintains oven temperature in 100° F to 300° F range, providing independent control of electrode welding quality.

Extended Moisture Control Weld Electrode Dispenser

Maintains electrodes from the holding oven below AWS and ASME

Allowable moisture levels for more than 24 hours.

Dispenses electrodes one at a time.

Entirely portable. Does not require power.



70 pound CAPACITY PORTABLES

MODEL 50

This handy portable oven, only 23" high and 11" in diameter, gives fast access to up to 50 lbs. of stabilized rods in the shop or in the field. It operates on 115volt, AC. Thermostatic control maintains oven temperature in the 100°-300° F range. High performance/efficiency feature include:

- a full 2 inches of insulation surrounds oven wall
- Central calrod element ensures uniform distribution of heat in oven
- Equipped with two separate rod lifters to give the welding operator fast access to different rod types

.....AND COMPACT, IN-SHOP MODELS



Model 125
125 POUND CAPACITY
- for operation on
115 Volt, AC.



Model 350
350 POUND CAPACITY - for
operation on 115 Volt, AC.
Also available: Model 350 A for
operation on 220/440 Volt, AC.



Compact
And
Stackable

These Gullco Stabilizing Ovens have gained international recognition and acceptance based on a variety of quality and performance features including....

- compact, modular design with controls recessed for protection.
- shelves easily removed to accommodate large size loads.
- oven fully insulated to prevent heat loss....pilot light indicates oven operation.
- thermostat control, incorporating on/off switch, maintains oven temperature in 100° - 550° F range.
- models 125 and 350 feature nesting feet and sockets for safe, easy stacking.



Model 1000
1000 POUND CAPACITY - for
operation on 220/440 Volt, AC.

Custom configured palletized multi-compartment OVENS

Do your specs involve different temperatures/ bake times?

Gullco has a configuration to suit your needs!



Thermometer Accessory - Model T23 - thermometer with a mounting bracket and screw for front mounting on the Model 125 and 350 ovens.

also from Gullco...



1000 POUND CAPACITY HIGH TEMPERATURE ELECTRODE RE-BAKING/STABILIZING OVEN

...available in two models - one equipped with an Indicating Control System and the other with an Electronic Digital Programmer/ Controller. Complete details are provided in Gullco Bulletin GHTO... available from Gullco or your Gullco distributor.