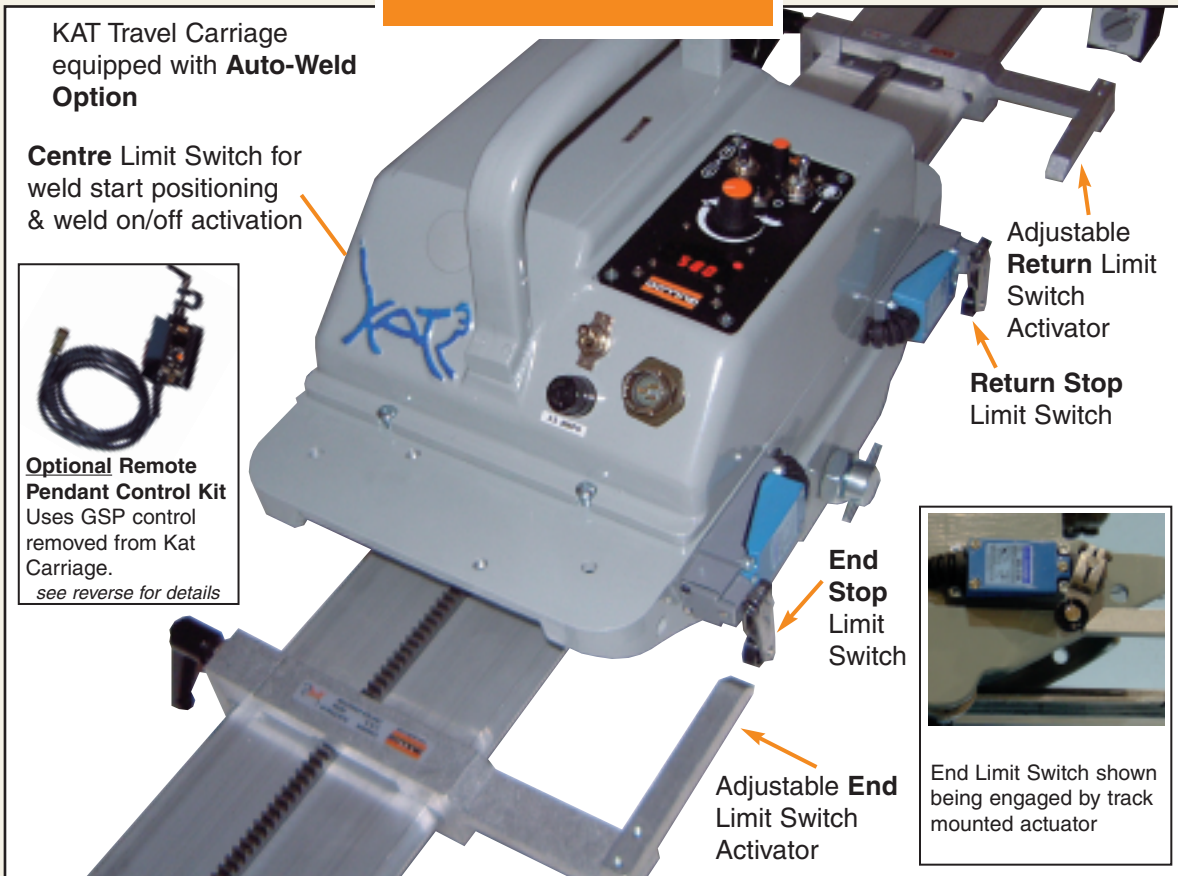




# GULLCO



## 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 Flex 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 ►►

## 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 micro-processor 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**

**GK-200-R**   -A

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)**

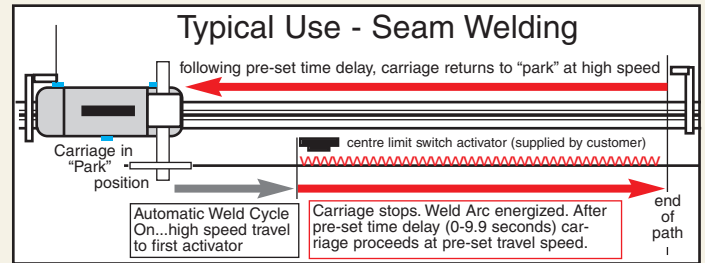
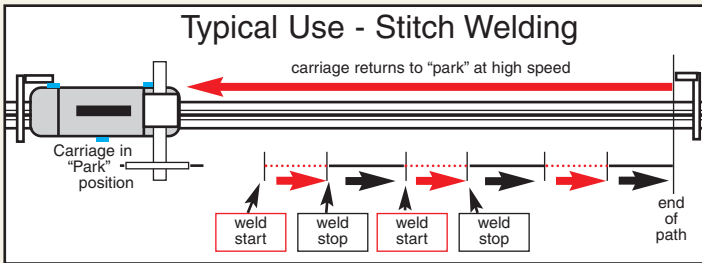
### FLEX KAT AUTO-WELD

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**

**GK-200-F**   -A

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 **RKGSP-12/03**
  - Gullco Flex Kat Travel Carriages Ask For Bulletin **FKGSP-12/03**
  - Gullco Kat Track Ask For Bulletin **GKT 10/03**

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