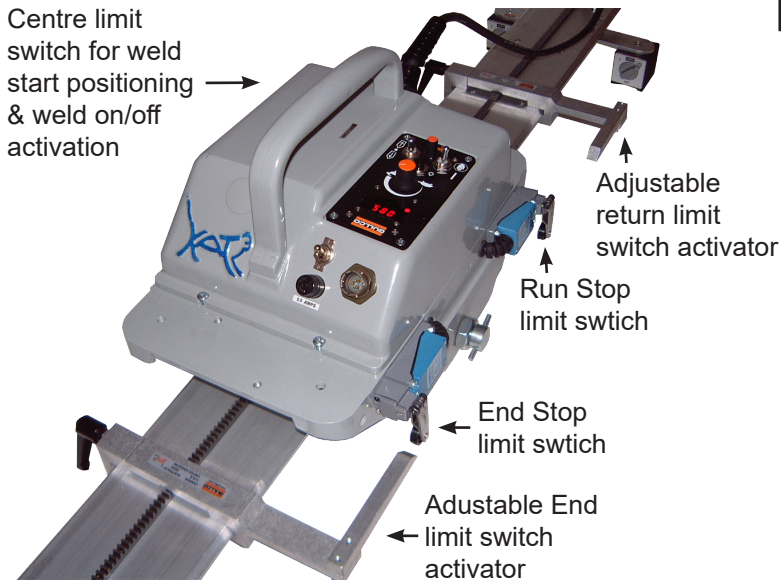




AUTOMATIC WELDING CARRIAGE - KAT® AUTO-WELD

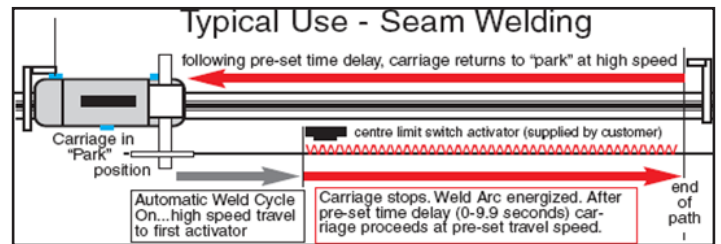
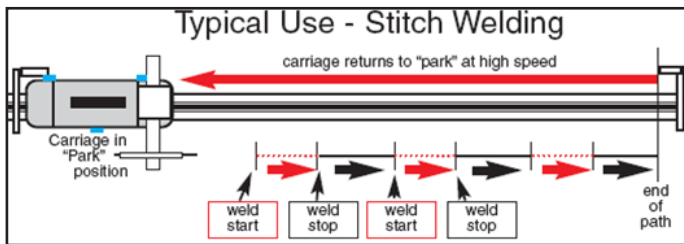


**MODEL GK-200-R\*-A**  
For use on KAT® Rigid Track

**MODEL GK-200-F\*-A**  
For use on KAT® Rigid Track

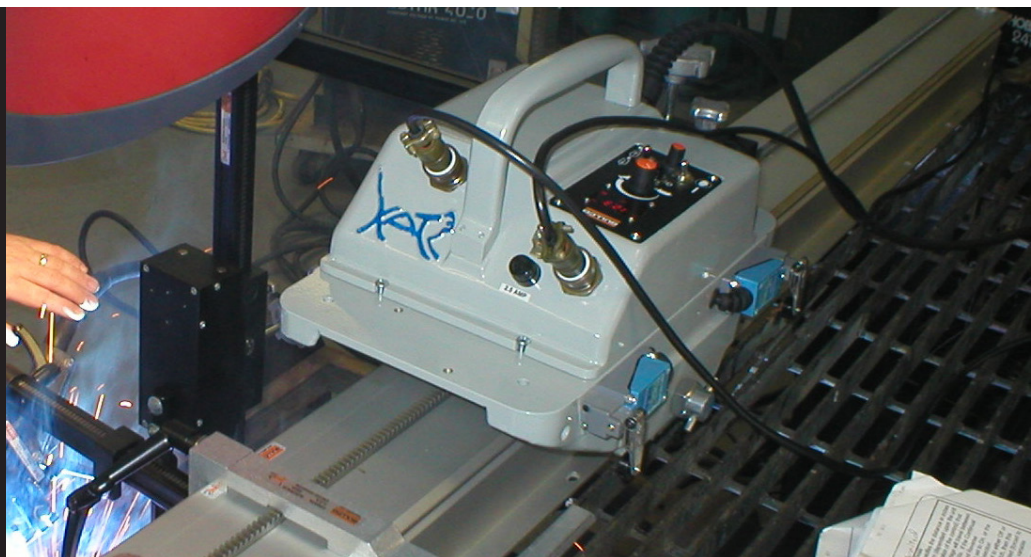
\* See reverse side for speed and voltage requirements

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.



*Increase Production and Precision with Weld Automation*

PRECISION AND REPEATABLE WELDS CAN BE PRODUCED ALONG ANY PLANE



# SPECIFICATIONS

**KAT® Travel Carriage Auto-Weld Combination** comprises:

Gullco Auto-Weld KAT® Travel Carriage with heavy duty self-aligning wheel assemblies and closed loop tack feedback for accurate speed control when running in any plane, regardless of load. Maximum 100 lbs. (45 kgs). Carriage is controlled by the 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. 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

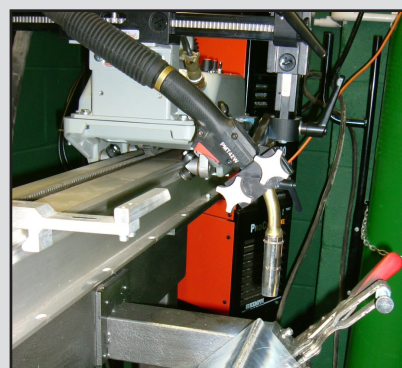
*NOTE: Gullco also has Kat Carriage models available with controls for Oscillation visit [www.gullco.com](http://www.gullco.com) for more information.*

## 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 travel to weld start point using center limit switch.\*
- Stitch weld electronically programmed using carriage travel distance, adjustable 0.1 - 99.9 in. or cm.
- 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.
- Weld Step Back feature

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



### 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 range and voltage to determine your Rigid KAT® Auto-Weld 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 range and voltage to determine your Flex KAT® Auto-Weld Model Number.

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

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