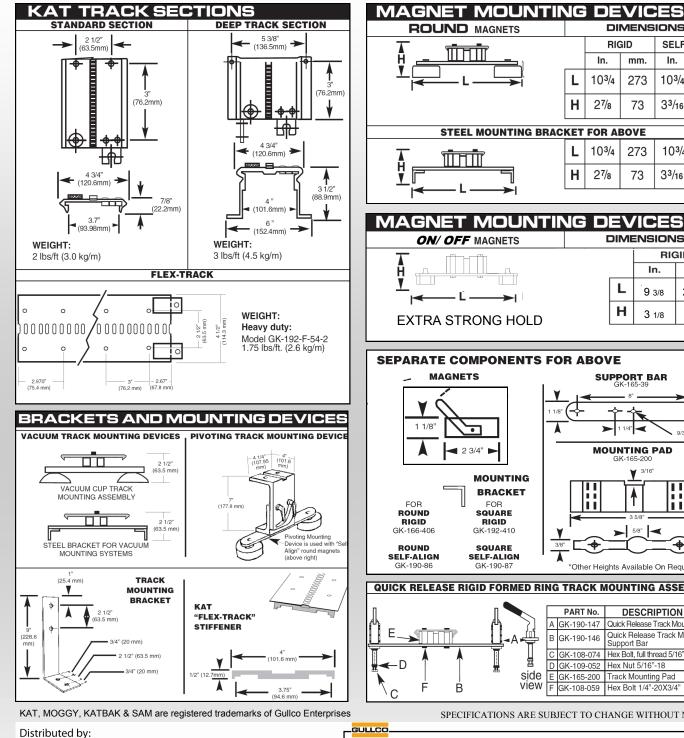
GULLCO RIGID AND FLEX TRACK MOUNTING DEVICES



MOUNTING PAD MOUNTING BRACKET FOR SQUARE RIGID GK-192-410 SOLIARE SELF-ALIGN GK-190-87 Other Heights Available On Regu QUICK RELEASE RIGID FORMED RING TRACK MOUNTING ASSEMBLY PART No. DESCRIPTION GK-190-147 Quick Release Track Mounting Lev GK-190-146 Quick Release Track Mounting Support Bar GK-108-074 Hex Bolt, full thread 5/16"-18X1-1/2 GK-109-052 Hex Nut 5/16"-18 side GK-165-200 Track Mounting Pad GK-108-059 Hex Bolt 1/4"-20X3/4" view SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE GULLCO **GULLCO INTERNATIONAL LIMITED - CANADA** Fax: 905-953-4138 e-mail: sales@gullco.com Phone: 905-953-4140 GULLCO INTERNATIONAL INC. - U.S.A Fax: 440-439-3634 e-mail: ussales@gullco.com GULLCO INTERNATIONAL (U.K.) LIMITED- EUROPE Phone: +44 1257-253579 Fax: +44 1257-254629 e-mail: sales@gullco.co.uk GULLCO INTERNATIONAL PTY LIMITED - AUSTRALIA GULLCO INTERNATIONAL INDIA PVT LIMITED - INDIA Fax: 91-20-26836656 one: 91-20-65260382 e-mail: india.lo@gullco.co GULLCO INTERNATIONAL SHANGHAI LIMITED- CHINA Phone: +8621-50460341 Fax: +8621-50463554 e-mail: gsuntech@sh163.ne GULLCO INTERNATIONAL LIMITED- LATIN AMERICA Phone: 55-11-3584-7936 e-mail: rogerio.macedo@gullco.cor STUCH GMBH & CO. KG SCWEISSTECHNIK - GERMANY Phone: (02 03) 72 94 95 Fax: (02 03) 72 94 96 e-mail: info@stuch-schweisstechnik.de

DIMENSIONS

mm.

273

73

73

DIMENSIONS

In.

9 3/8

3 1/8

SELF-ALIGN

33/16 81.0

103/4 273

33/16 81.0

RIGID

mm.

228.6

76.2

mm

273

In.

103/4

RIGID

103/4 273

L

Н

SUPPORT BAR

In.

103/4

н 27/8

H 27/8





WELDING AND CUTTING AUTOMATION

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TR-09-01



GULLCO RIGID KAT[®] TRACKS

KAT[®] Track is manufactured in "Standard" and "Deep" sections...each designed to suit a specific range of applications. Both are made to the highest quality levels and incorporate the following top performance features:

PRECISION EXTRUDED ALUMINUM

TRACK—made from aluminum that is solution heat treated and artificially aged to produce an alloy having excellent mechanical and corrosion resistant properties. The track is light but strong and the standard section can be readily formed to suit the work contour.

SUPPORTING STEEL RACK—is securely fixed to the KAT® track to provide a smooth,

positive drive. The long-life rack easily supports the Kat carriage under maximum load when used in a vertical position.

END DESIGN-

enables any two lengths of track to mate accurately and, because of symmetry of design, track lengths can be turned end to end. It is even possible to mate standard and deep track sections.

FAST, EASY JOINING—with combined dovetail and taper screw that provides accurate location between mating track lengths. The track can be joined in the time it takes to tighten two knurled thumb screws.

VERSATILE MOUNTING—Both standard and deep section tracks have fixing holes on 6" (152.4 mm) pitch along their entire length to provide ample means for mounting or securing brackets

Standard Section Track For use with the Gullco KAT[®] Travel Carriage Model GK-200 in most portable applications. Standard track sections are supplied in 48, 96 and 120 inch(1219, 2438 and 3048 mm) lengths complete with rack and interlocking ends. Standard track can be hard anodized and also formed to desired contours by Gullco or the customer. (see below) LENGTH I ENGTH MODEL GK-165-52. .48" (1219mm) GK-165-52-1... .96" (2438mm) GK-165-54 120" (3048mm) also available up to 20 ft (6096mm) long-special order

Deep Section Track

For use with the Gullco KAT[®] Travel Carriage in applications involving straight permanent runs where greater stiffness is required. Supplied in 60" and 120" (1524 and 3048mm) lengths complete with interlocking end. Deep Section Track can also be supplied internally stiffened and hard anodized. I ENGTH MODEL I FNGTH ..60" (1524mm) GK-166-260 GK-166-258 120" (3048mm) also available up to 20 ft (6096mm) long-special order

FORMING STANDARD KAT® TRACK The following information is provided as a guide to customers ordering Standard Section track pre-formed to the desired contour by Gullco, or to be formed in their own

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shop. 1. "Track Datum" always refers to the track surface to which the rack is fixed

2. When the rack is on the outside of the curve, the "Track Datum Radius" must be greater than 12".

3. When the rack is on the inside of the curve, the "Track Datum Radius" must be greater than 24".

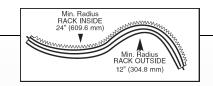
4. Always specify whether rack is on the inside or outside of the curve.

5. Standard formed track lengths are 3 ft. and 7 ft. This is because the first 6" at either end of a track cannot be formed and is therefore removed after bending.

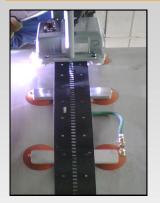
6. When calculating the "Track Datum Radius", allowance must be made for the method of fixing the track to the work. The minimum allowable work to "Track Datum" distance (to permit free movement of the KAT[®] carriage) is 1-1/2" and when using the standard magnet assemblies this distance is 2-7/8"

KAT[®] formed track may be held in position by track mounting devices (i.e. magnets, steel brackets tack welded in position, or vacuum cups), or it maybe perma nently attached to framework alongside the work piece.

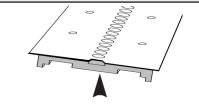
If your formed track is of a very permanent nature, it is often advisable to have a section formed and stiffened with welded aluminum side plates. This gives the stiffness of a deep section track in a formed shape. This method is often used in complete ring sections for cutting or welding large diameter pipes.



GULLCO KAT[®] "FLEXIBLE TRACKS"



Gullco Heavy Duty "Flexible-Track" is specifically designed for use with the Gullco "Flexible-KAT® all-position Travel Carriages as shown in application at left. Flexible-Track is made from tempered spring steel and can be easily mounted to conform with curved surfaces. This Flexible-Track can be used in applications involving curved surfaces 60" (1524 mm) diameter and greater.



Flexible-Track STIFFENER ADAPTS FLEX-TRACK SECTION FOR USE IN RIGID TRACK APPLICATIONS

Provides extra stiffness and reduces the number of magnet or vacuum track mounting devices required.

MODEL GK-192-F-57

Extruded aluminum stiffener for attachment to Gullco Flexible-Track sections supplied in 8 ft. (2438 mm) lengths.

Track Mounting Devices **ROUND MAGNET** MOUNTING DEVICES SQUARE MAGNET MOUNTING DEVICES SELF-ALIGNING **FIXED** SELF-ALIGNING **FIXED** Shown at right are the Round and Square Magnet devices and steel bracket assemblies used to mount either Gullco rigid Kat tracks or Flex-Kat tracks on ferrous surfaces. Gullco's Vacuum Track Mounting system, described in a separate bulletin, holds Kat Tracks in position on non-ferrous and ferrous materials. MODEL GK-165-138 MODEL GK-165-128 MODEL GK-165-125 **ROUND MAGNET ASSEMBLIES** feature two powerful magnets MODEL GK-165-215 each with 100 lbs of holding power and release levers. SQUARE MAGNET ASSEMBLIES feature magnets each with 75 lbs of holding power and positive on/off switch. Both of the above assemblies are available as fixed or self-aligning assemblies. MODEL GK-192-406 MODEL GK-190-129 MODEL GK-190-127 MODEL GK-165-219 STEEL BRACKET ASSEMBLIES are used with magnet assemblies to provide track stability. They also must be used for added safety, tack welded to the work surface in vertical and overhead welding applications. The four models conform to the heights of assemblies in each of the fixed and Self-Aligning groups. Standard brackets are mild steel but are available in stainless steel MODEL GK-192-407 MODEL GK-190-128 MODEL GK-192-408 MODEL GK-190-126 on request leight same as above Height same as a



Supplied in 8ft. (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.

Other lengths available on request.



Holds formed "rings" of track in position for pipe welding on nonferrous and ferrous materials. Heights can be adjusted from 2.8 in. (71.1mm) to 4.95" (125.7mm). Different heights car be achieved using different length 5/16"-18UNC bolts.



ferrous and ferrous materials. For details see Gullco Bulletin GV-991

PERPENDICULAR TRACK MOUNTING BRACKET Model GK-190-046



Holes in this rigid steel bracket align with those in Kat Track and support bars on all Gullco track mounting devices...for firm perpendicular mounting of straight or curved rigid Kat Track or Flex-Track sections

PIVOTING TRACK MOUNTING DEVICE Model GK-190-110

Used to mount Gullco Flex-Track in Spherical Tank welding applications to maintain proper welding angle.

