OPERATOR'S MANUAL

Rail Tug

WELDING CARRIAGE

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Contents

1. GENERAL INFORMATION

1.1. Application

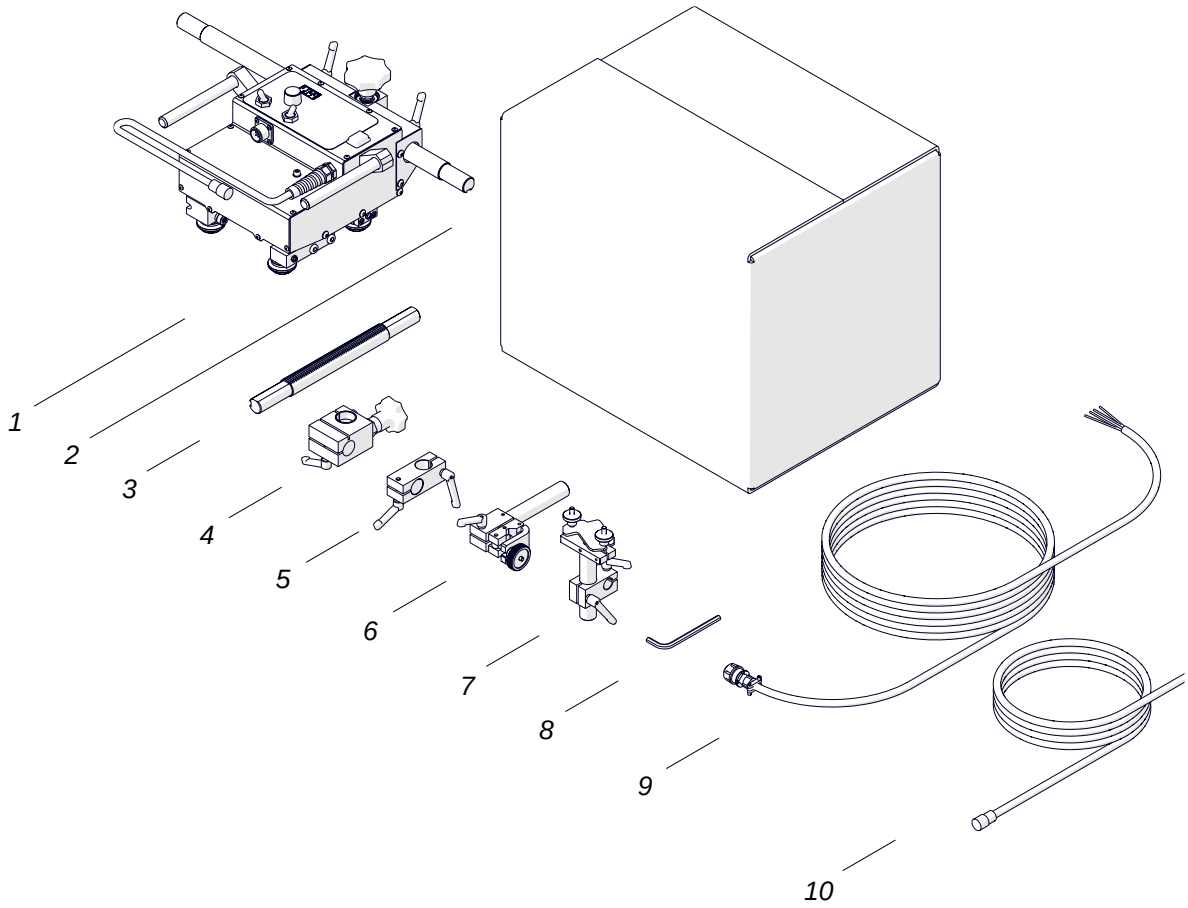
The Rail Tug is a track carriage designed to cut and to make butt and fillet welds. The carriage allows MIG/MAG, SAW, oxy-fuel, or plasma torches. The track is clamped with magnetic units to ferromagnetic surfaces that are flat or curved.

Accessories allow, for example, using torches with a larger diameter, and guiding the carriage on a semi-flexible, rigid, or ring track. Using a vacuum track system allows the track to be clamped to surfaces that are non-ferromagnetic.

1.2. Technical data

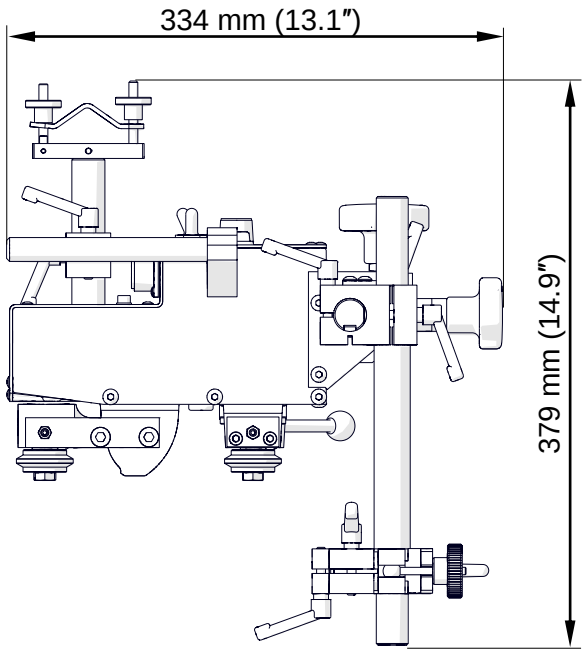
Voltage		1~ 115–230 V, 50–60 Hz
Power		66 W
Welding position (according to EN ISO 6947 and AWS/ASME)	Horizontal	PA / 1F / 1G PB / 2F PC / 2G PD / 4F PE / 4G
	Vertical	PG / 3F (contact your dealer)
Outer diameter of round workpiece	Ring tracks	200 mm (8″) – 3 m (10 ft)
	Custom rolled tracks	3 m (10 ft) – 10 m (32 ft) (contact your dealer)
	Semi-flexible tracks	Minimum 10 m (32 ft)
Torch type		MIG/MAG, SAW, oxy-fuel, plasma
Torch diameter	MIG/MAG	16–22 mm (0.63–0.87″)
	SAW, plasma	28–35 mm (1.10–1.38″)
	Oxy-fuel	30 mm (1.18″), 35 mm (1.38″)
Minimum workpiece thickness for magnetic clamping		5 mm (0.2″)
Horizontal pulling force		300 N
Vertical pulling force		200 N
Horizontal speed		10–200 cm/min (4–80 in/min)
Vertical speed		10–200 cm/min (4–80 in/min)
Allowed ambient temperature		0–50°C (32–122°F)
Maximum allowed ambient humidity without condensation		80%
Protection level		IP 23
Weight		10 kg (22 lbs)

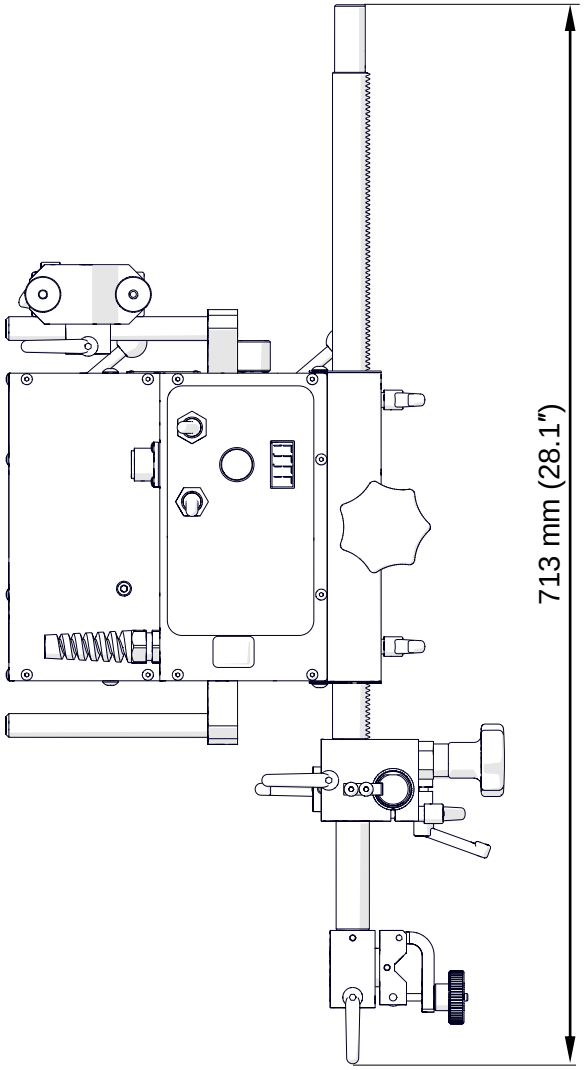
1.3. Equipment included



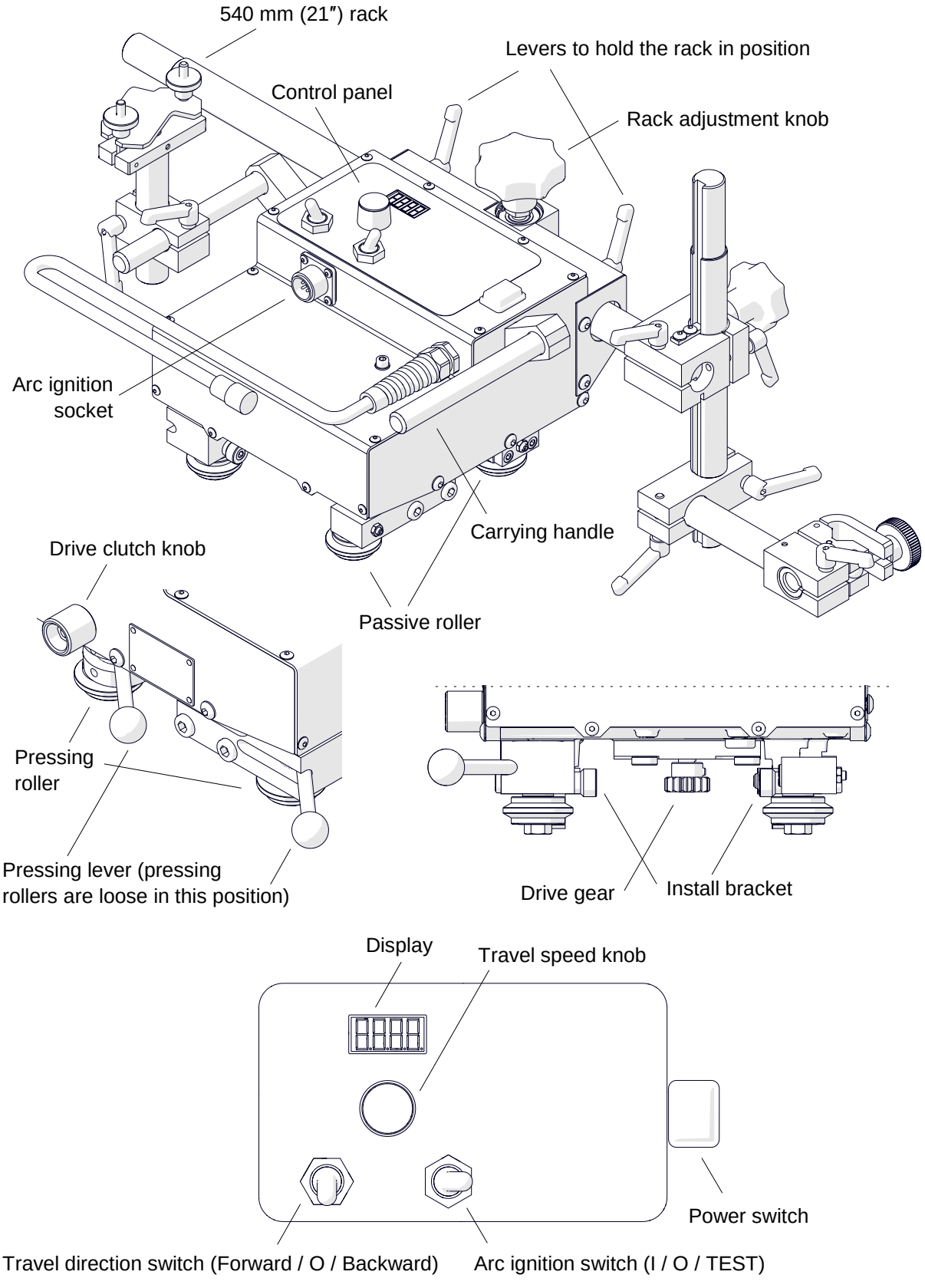
1	Carriage with a 540 mm (21″) rack	1 unit
2	Cardboard box	1 unit
3	300 mm (12″) rack with 180 mm (7″) adjustment	1 unit
4	Rack holder	1 unit
5	Clamping block with levers	1 unit
6	Short rod torch holder with clamp	1 unit
7	Cable anchor	1 unit
8	6 mm hex wrench	1 unit
9	6.5 m (21 ft) arc ignition cable	1 unit
10	3 m (10 ft) power cord	1 unit
–	Operator’s Manual	1 unit

1.4. Dimensions





1.5. Design



2. SAFETY PRECAUTIONS

1. Before you start, read this Operator's Manual and complete occupational safety and health training.
2. Use only in applications specified in this Operator's Manual.
3. Make sure that the carriage has all parts and they are genuine and not damaged.
4. Make sure that the specifications of the power source are the same as those specified on the rating plate.
5. Connect the carriage to a correctly grounded power source.
6. Do not carry the carriage by the cords or cables, and do not pull them. This can cause damage and electric shock.
7. Keep untrained bystanders away from the carriage.
8. Before you start, ensure the correct condition of the carriage, power source, cords, arc ignition cable, connections, rollers, and gear.
9. Keep the carriage dry. Do not expose it to rain, snow, or frost.
10. Keep the work area well lit, clean, and free of obstacles.
11. Do not use near flammable materials, or in explosive environments.
12. Transport and position the carriage by using the carrying handles.
13. Install the carriage only on the supplied track.
14. Make sure that the gear and rollers are clean.
15. Plug the cords and arc ignition cable into sockets only after you set the power switch to 'O'.
16. Keep the sockets clean. Do not use high pressure during cleaning.
17. Install only torches whose diameter matches the diameter of the torch holder.
18. Hang the cables to decrease the load of the carriage.
19. Do not bend the semi-flexible track to a radius less than 5 m (16 ft).
20. Use the rigid track only on flat surfaces.
21. At heights, protect the carriage and the track from falling. To do this, use chains (not included) to attach the leftmost and rightmost magnetic units of the semi-flexible or rigid track to a stable structure. To protect the carriage, attach a chain to a carrying handle. Make sure that the chains are not loose.
22. Do not stay below the carriage or the track that is put at heights.
23. Use eye protection (helmet, shield, and screen), hearing protection, gloves, and protective clothing during work. Do not use loose clothing.

24. Before each use, make sure that the carriage is not damaged and no part is cracked or loose. Make sure to maintain correct conditions that can have an effect on the operation of the carriage.
25. Do not try to stop the travel by hand. To stop, set the travel direction switch to ‘O’.
26. Maintain only after you unplug the carriage from the power source.
27. Repair only in a service center appointed by the seller.
28. If the carriage falls from any height, is wet, or has any damage, stop the work and promptly send the carriage to the service center for check and repair.
29. Do not leave the carriage unattended during work.
30. If you are not going to use the carriage, remove it from the worksite and keep in a safe and dry place.

3. STARTUP AND OPERATION

3.1. Assembling the semi-flexible or rigid track

Connect magnetic units to the rail, and put it on the workpiece. Use the 4 mm hex wrench to attach more rails (*1*, Fig. 1). Then, set the levers of the magnetic units to 'I' (*2*). This will clamp the track to the surface.

When working in PC/2G welding position, put the track so that the teeth of the racks point down.

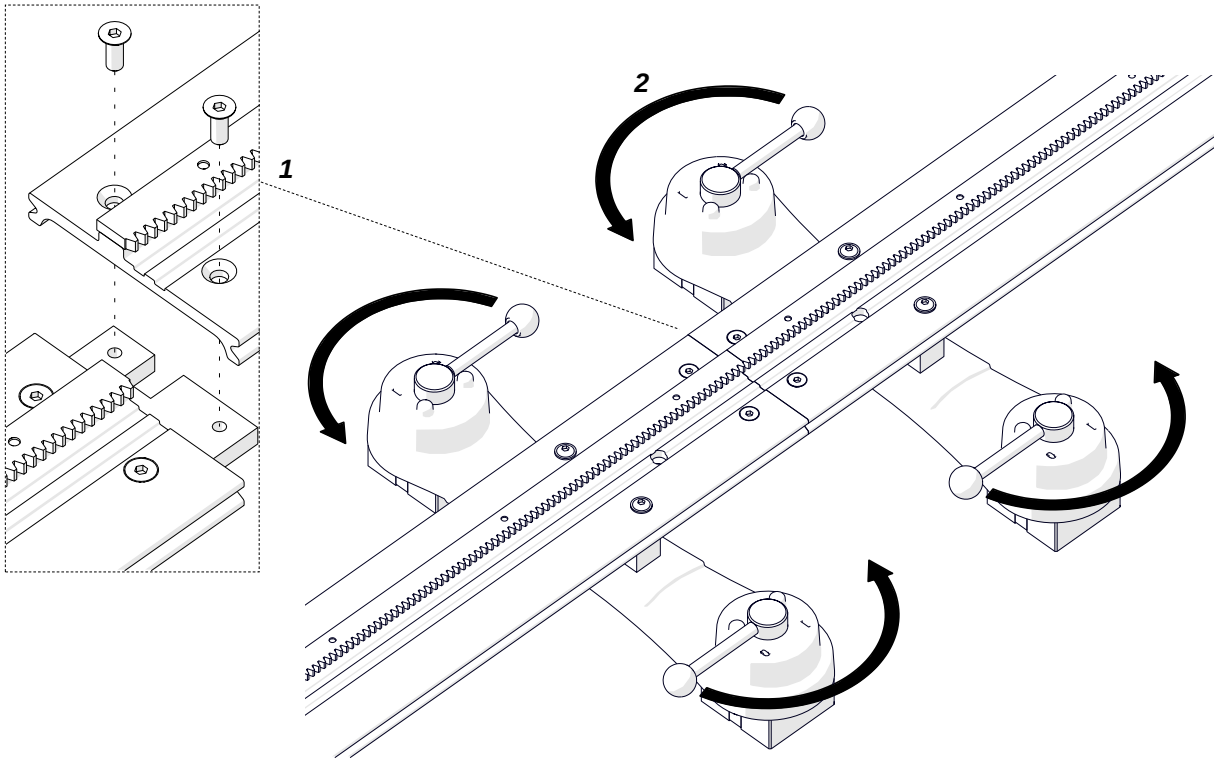


Fig. 1. Connecting the rails and clamping the magnetic units to the surface

If a semi-flexible rail is put on a curve, before you attach more rails use the 4 mm hex wrench to loosen the screws of the connecting plates (*1*, Fig. 2) and of the racks (*2*). Next, attach the rails, clamp them with levers, and then tighten the connecting plates. Put the rack adjustment tool (not included) into the hole (*3*), and rotate the tool to the left (*4*) to remove the gap (*5*) between the racks. Then, tighten the leftmost screw and the rightmost screw of each rack (*2*).

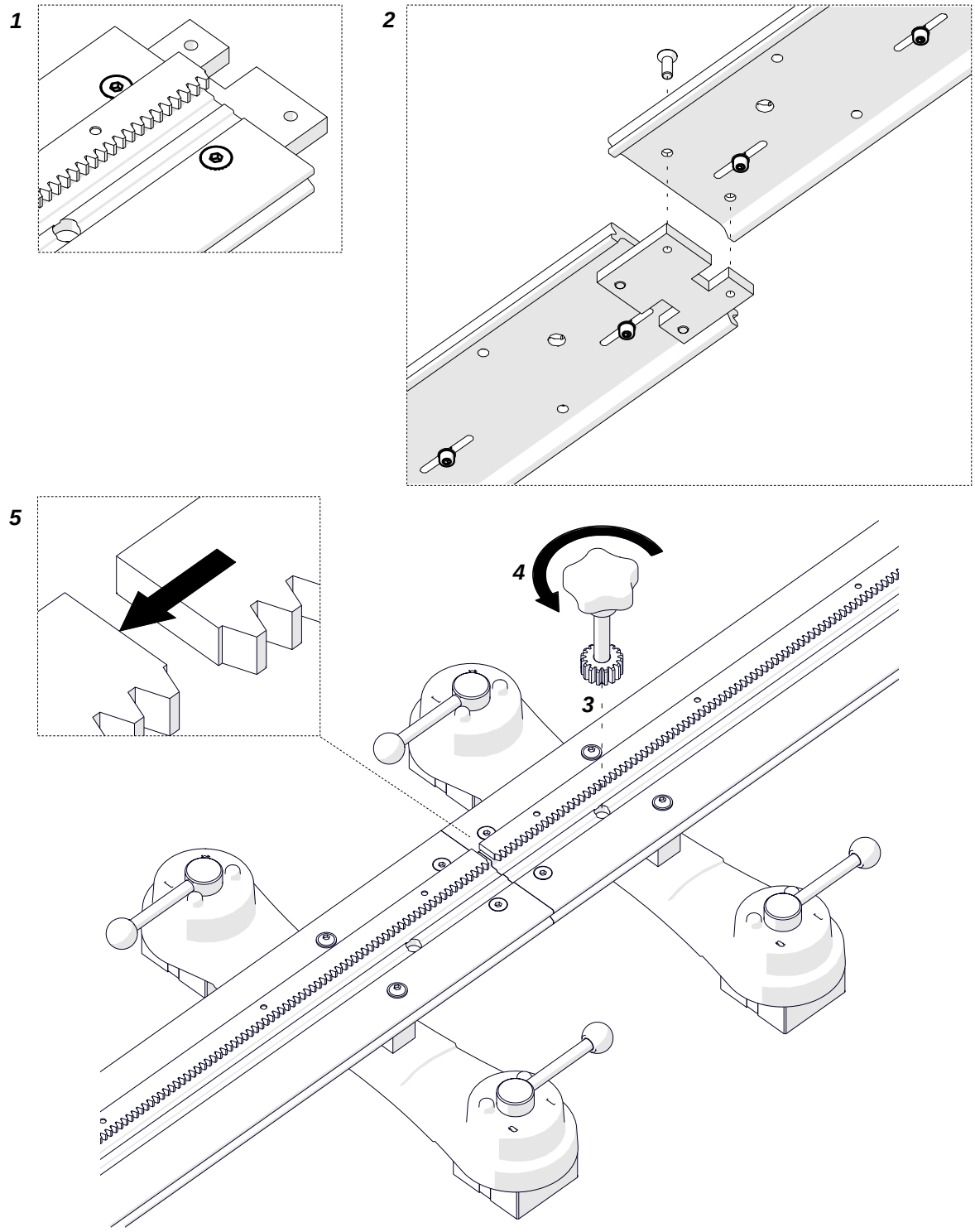


Fig. 2. Removing the gap between the racks of a semi-flexible track

3.2. Assembling the ring track

Select the track that matches the outer diameter of the round workpiece. Use the 4 mm hex wrench to attach the supports to the rails (*1*, Fig. 3). Next, on all supports, retract the bolts (*2*, or screws) as much as possible.

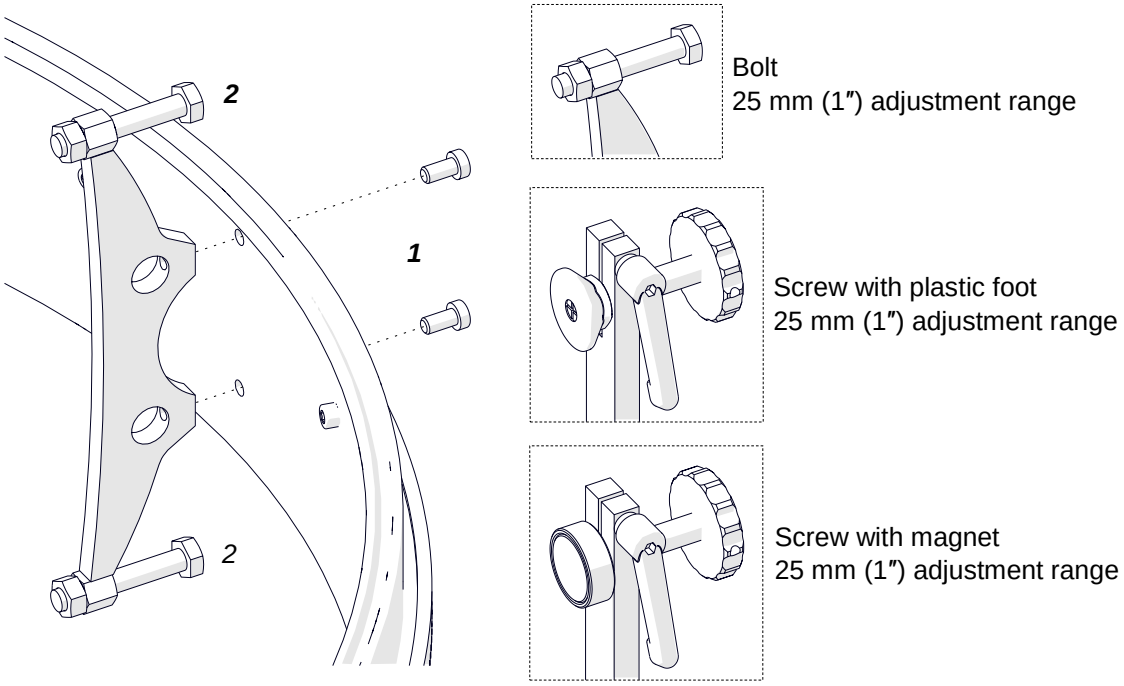


Fig. 3. Connecting the supports to the rails

Put the workpiece vertically, and then put the rails onto the workpiece so that the teeth of the racks point down. Next, for all rails, use the 12 mm hex wrench to set the hinge as shown in Fig. 4. Then, put the lock pin through the holes (*1*), and then rotate the wrench (*2*) to connect the rails.

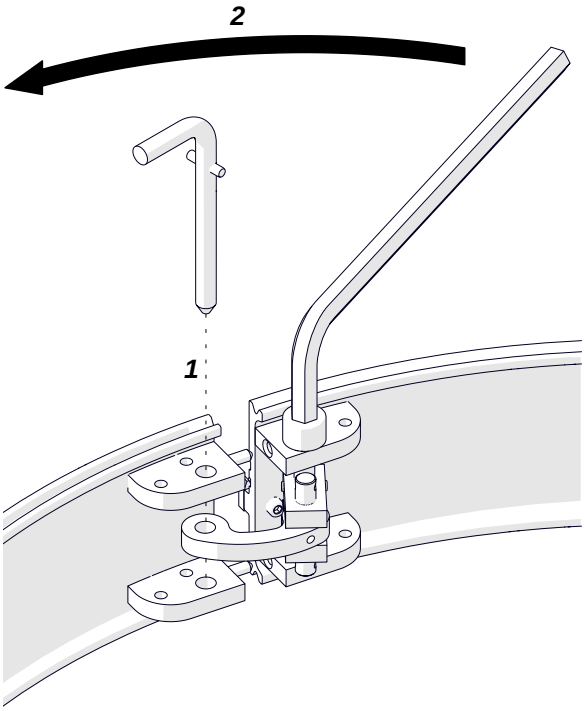


Fig. 4. Connecting the rails of the ring track

Use the 13 mm flat wrench to adjust the bolts (or the screws by hand) until they are in contact with the workpiece (*1*, Fig. 5). Adjust each support equally to make the track concentric to the workpiece. Lock the supports with the nuts (*2*) or levers.

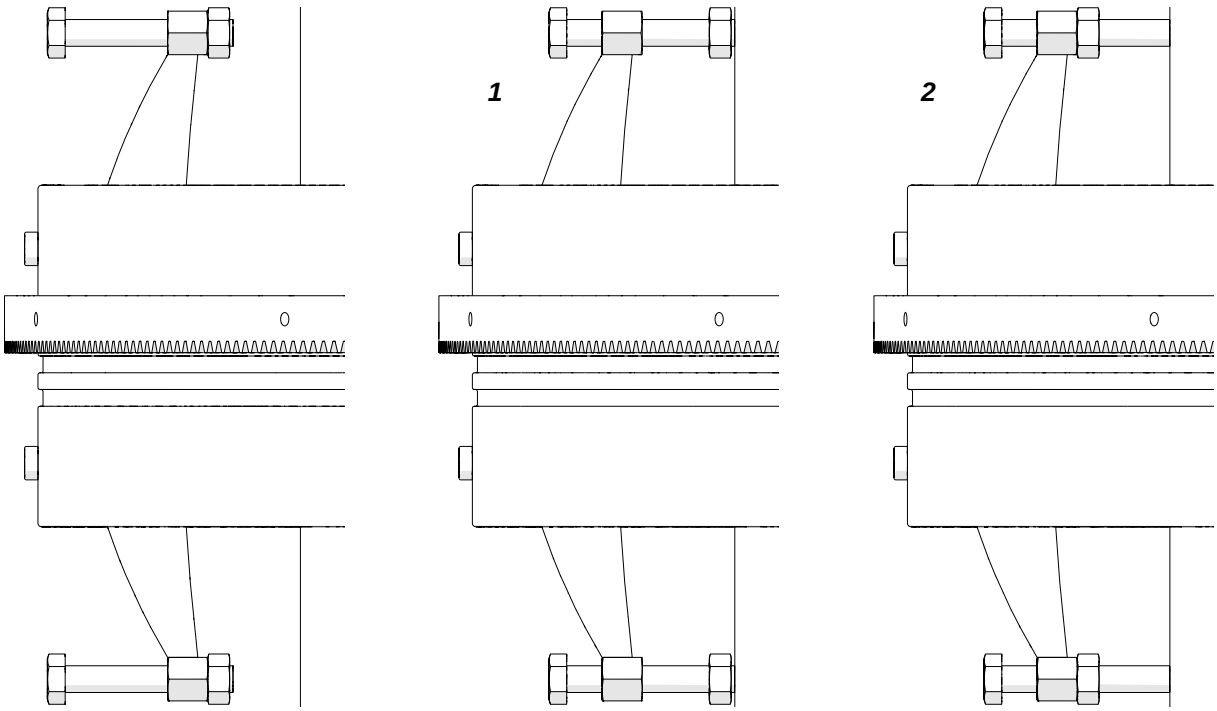


Fig. 5. Attaching the ring track to the workpiece

3.3. Positioning on a straight track

Set the power switch, arc ignition switch, and travel direction switch to ‘O’. Next, set the levers to OFF (*1*, Fig. 6), and then loosen the knob (*2*) fully to retract the gear (*3*). Then, put the carriage so that the install brackets are on the rail (*4*, *5*).

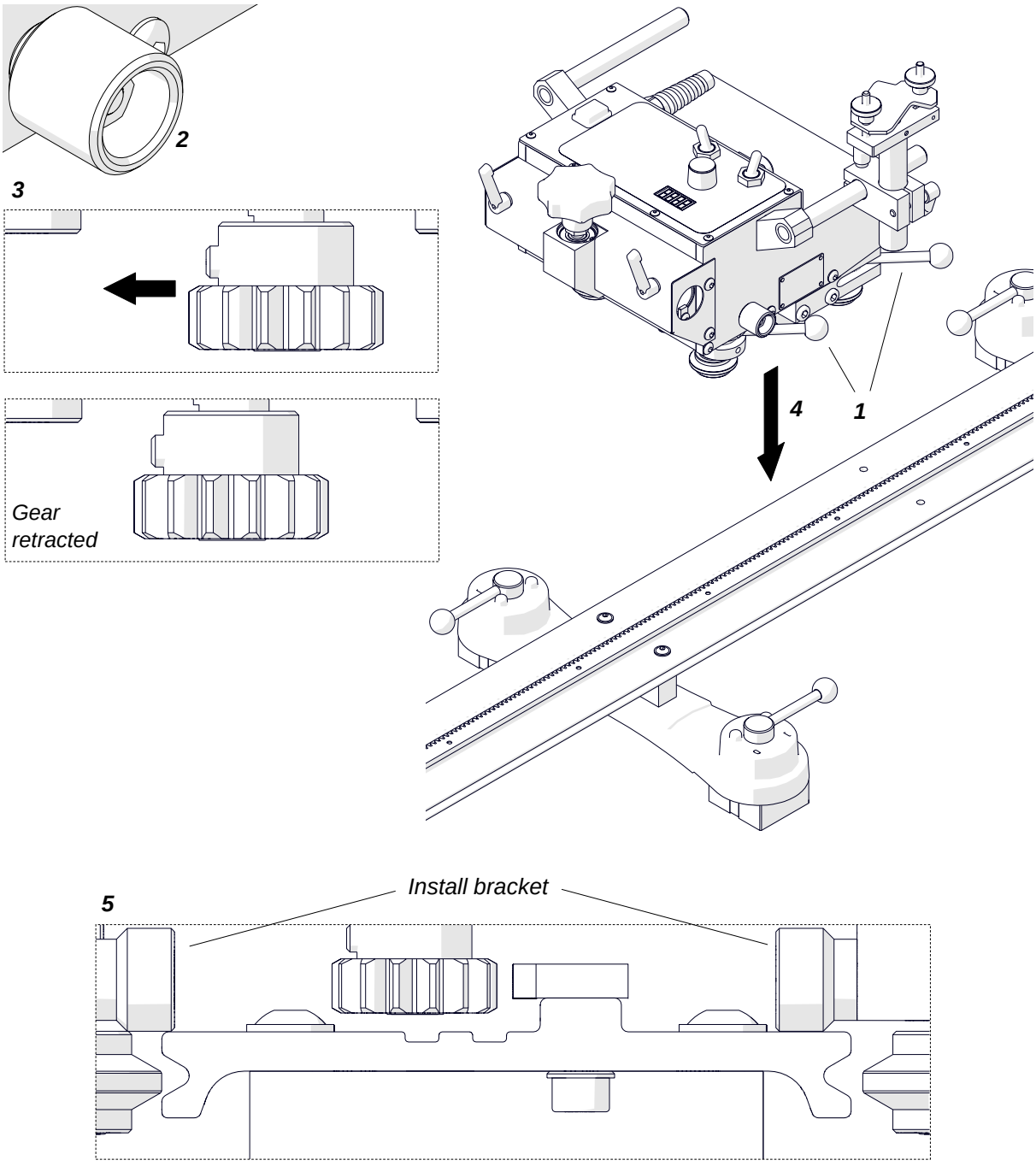


Fig. 6. Putting the carriage on a straight track

Set the levers to ON (*1*, Fig. 7) to put the rollers into the grooves (*2*). Then, tighten the knob (*3*) to engage the gear of the carriage with the rack of the rail (*4*). Keep a small backlash between the gear and the rack (*5*). Move the carriage slightly back and forth (*6*) to make sure that there is a backlash. Do not tighten the knob with too much force (*7*).

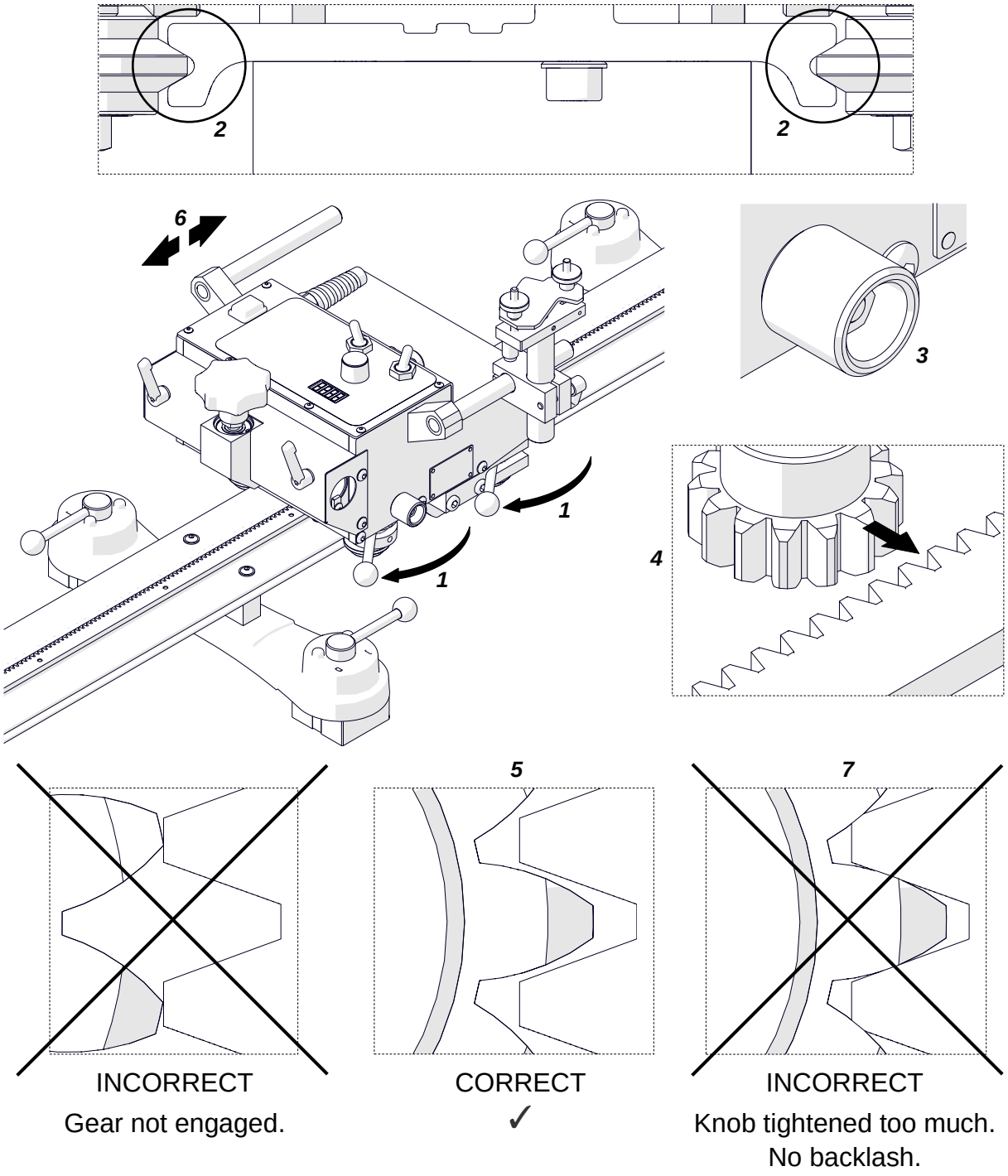


Fig. 7. Installing the carriage on the track

3.4. Positioning on a curved track

Use the 6 mm hex wrench to loosen four screws (*1*, Fig. 8), and then put the carriage on the track. Rotate two roller brackets (*2*) to put the rollers into the grooves, and then set the levers to ON (*3*). Next, move the carriage back and forth to make sure that it moves smoothly. Then, tighten the screws (*1*) and use the knob (*4*) to engage the gear with the rack as described in “Positioning on a straight track”.

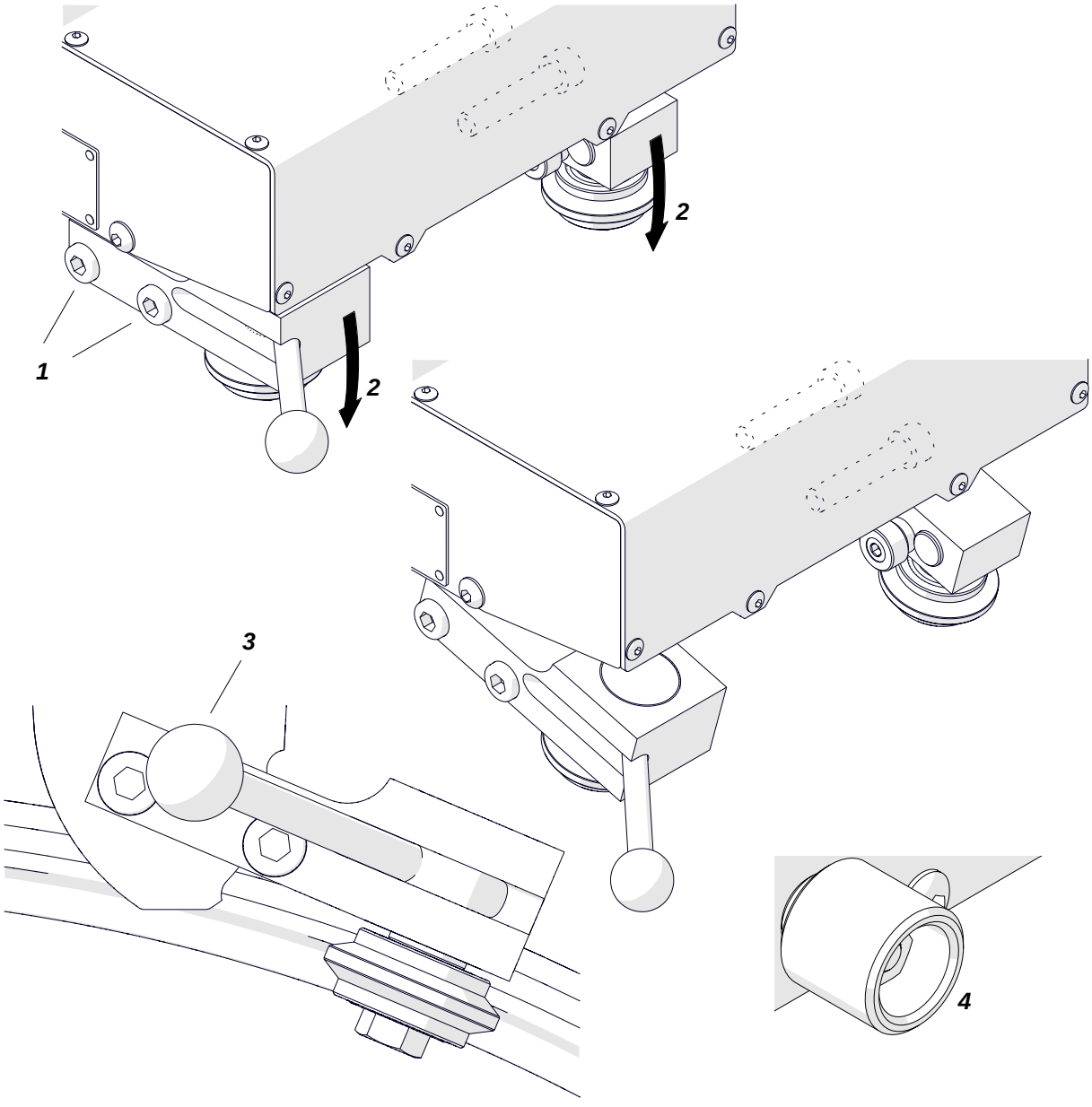


Fig. 8. Rotating the rollers for a curved track

3.5. Preparing

Install the torch holder and the cable anchor as shown in Fig. 9.

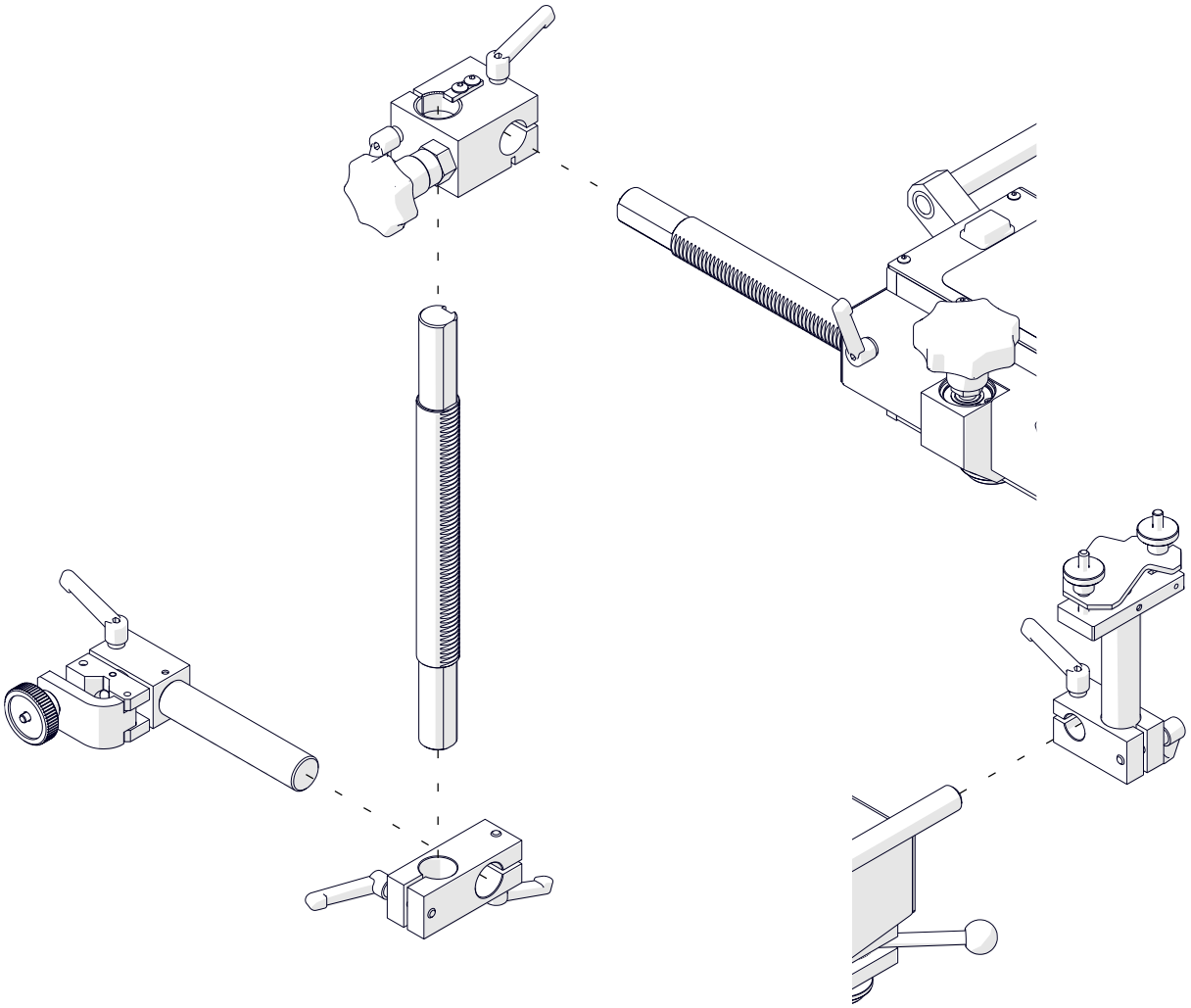


Fig. 9. Installing the torch holder and cable anchor

At heights, protect the carriage and the track from falling. To do this, use chains (not included) to attach the leftmost and rightmost magnetic units of the semi-flexible or rigid track to a stable structure. To protect the carriage, attach a chain to a carrying handle. Make sure that the chains are not loose.

Connect the carriage to the power source. Then, put the torch and torch cables into the holders.

3.6. Connecting to the welding or plasma cutting circuits

The carriage can control two torches by using the arc ignition cable plugged into the arc ignition socket. To do this, refer to the diagram from Fig. 10 and connect one blue-jacketed wire to one terminal of the welding / plasma cutting circuit. Then, connect the other blue-jacketed wire to the other terminal of the same circuit. To control the second torch, connect the green-jacketed wires to the terminals of the second welding circuit.

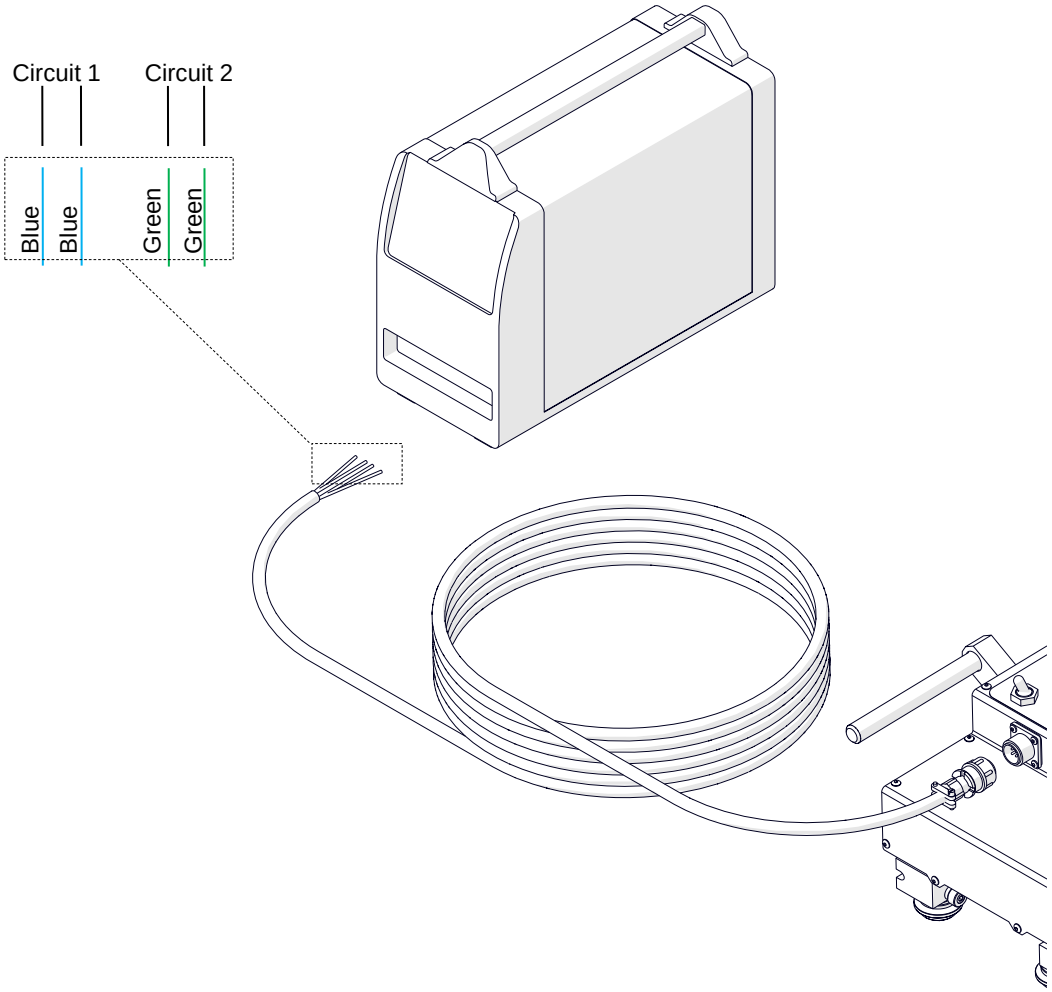


Fig. 10. Connecting the arc ignition cable to welding / plasma cutting circuits

Make sure that the arc ignition cable is connected correctly. To do this, turn on the power of the carriage, and then set the arc ignition switch to TEST. This should enable the arc for a while.

3.7. Adapting for SAW welding and cutting

To adapt the carriage for SAW welding, remove the clamp from the torch holder (Fig. 11), and then install a 28–35 mm torch clamp. Next, refer to the diagram from Fig. 10 and use the arc ignition cable to connect the carriage to the welding circuits.

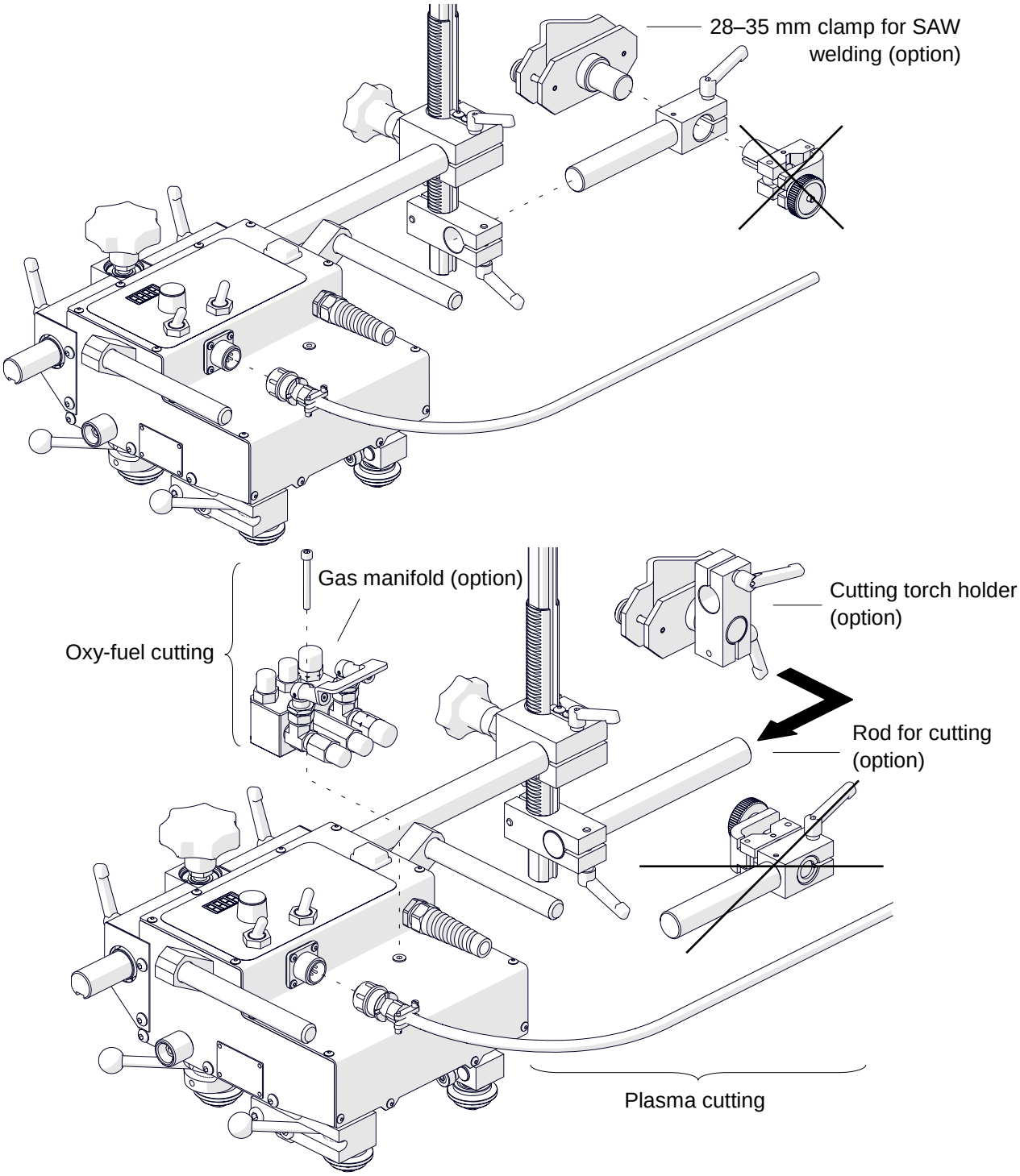


Fig. 11. Adapting the carriage for SAW welding and cutting

To adapt the carriage for oxy-fuel or plasma cutting, remove the welding torch holder (Fig. 11). Then, install a rod for cutting and a cutting torch holder.

For oxy-fuel cutting, use the 4 mm hex wrench and the M5x45 screw to attach a gas manifold.

For plasma cutting, refer to the diagram from Fig. 10 and use the arc ignition cable to connect the carriage to the cutting circuits.

3.8. Operating

Set the travel direction switch and arc ignition switch to ‘O’. Next, set the power switch to ‘I’ to turn on the power. The whole display will then lit (8888). Then, EUr shows (for centimeters per minute) or USA (for inches per minute). Next, the carriage speed shows. Use the knob to set the required speed.

To control the torch through the carriage, set the arc ignition switch to ‘I’.

If the arc ignition switch is set to ‘I’, the torch starts welding / plasma cutting promptly after you select a travel direction.

Use the travel direction switch to select a direction of travel. Then, the travel starts with the speed that is shown. You can adjust the speed at any time.

To stop the travel, set the travel direction switch to ‘O’.

After the work is finished, use the power switch to turn off the power. Then, unplug the carriage from the power source.

3.9. Adjusting the pressure of rollers

If the resistance during the travel is too little or too much, loosen the knob (*1*, Fig. 12). At the opposite side of the carriage, use the 13 mm and 8 mm flat wrenches to loosen the bolts (*2*) and nuts (*3*). Next, use the 2.5 mm hex wrench to adjust the screws (*4*), and then tighten the bolts (*2*).

Travel the carriage along the track. If the resistance is still incorrect, repeat the above steps.

If the carriage travels smoothly, use the 2.5 mm hex wrench to prevent rotation of each screw (*4*). Then, use the 8 mm flat wrench to tighten the nuts (*3*).

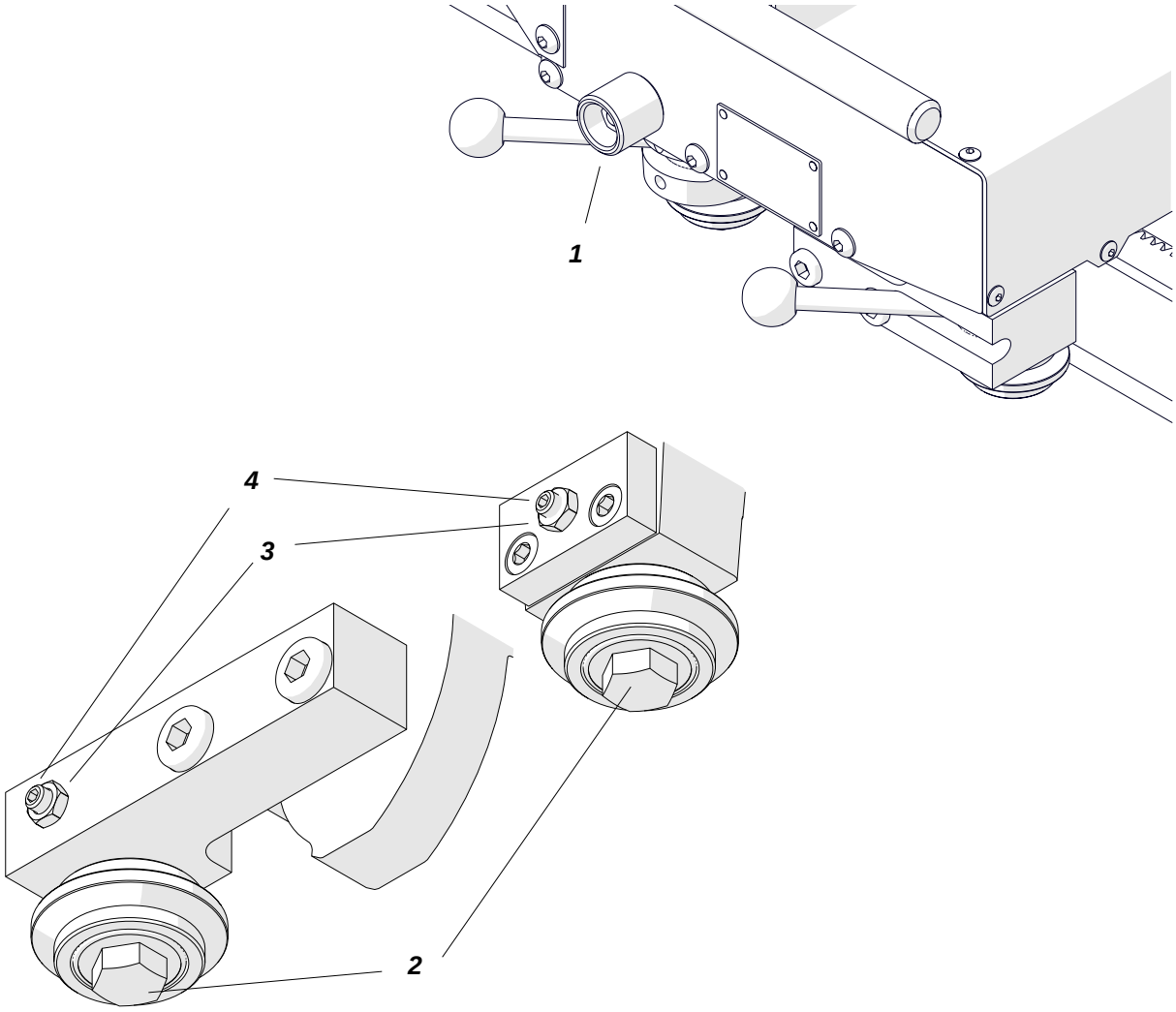
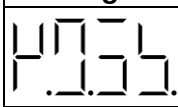
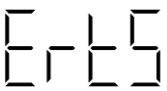


Fig. 12. Adjusting the pressure of rollers

3.10. Troubleshooting

Message	Cause	Solution
	Display not lit fully when powering.	Contact service center for check and repair.
	Speed shown in centimeters per minute instead of inches per minute.	Contact service center.
	Speed shown in inches per minute instead of centimeters per minute.	Contact service center.
	1. Travel direction switch not set to ‘O’ when powering. 2. Shown during travel indicates a malfunction of the switch or controller.	1. Set the travel direction switch to ‘O’. If the message still shows, contact service center for check and repair. 2. Contact service center for check and repair.
	Arc ignition switch not set to ‘O’ when powering.	Set the arc ignition switch to ‘O’. If the message still shows, contact service center for check and repair.
	Motor overload that promptly stops the carriage.	Adjust the position of the cables so that they do not block the travel. Remove other elements that block the carriage or the drive gear. Disengage the gear from the rack and engage them again as described in “Positioning on a straight track”. If this message still shows, contact service center for check and repair.

4. MAINTENANCE

Daily:

1. Clean the gear of the carriage and the rack of each rail.
2. Clean the rollers and make sure that they rotate freely.
3. Clean the torch nozzle. Replace if damaged.

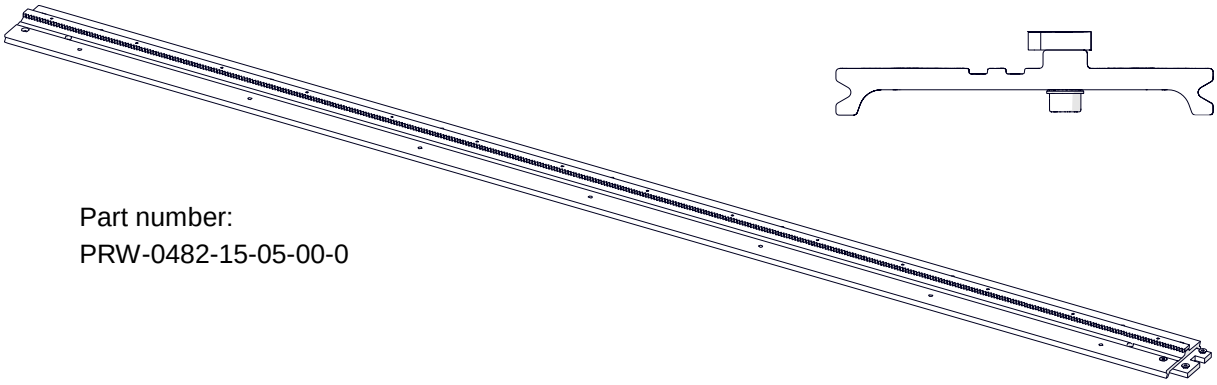
Monthly:

1. Make sure that the knobs and the switches work as intended. Replace if loose or damaged.
2. Examine cables, cords, and hoses. Replace if damaged.
3. Tighten screws if loose.

5. ACCESSORIES

5.1. Semi-flexible track

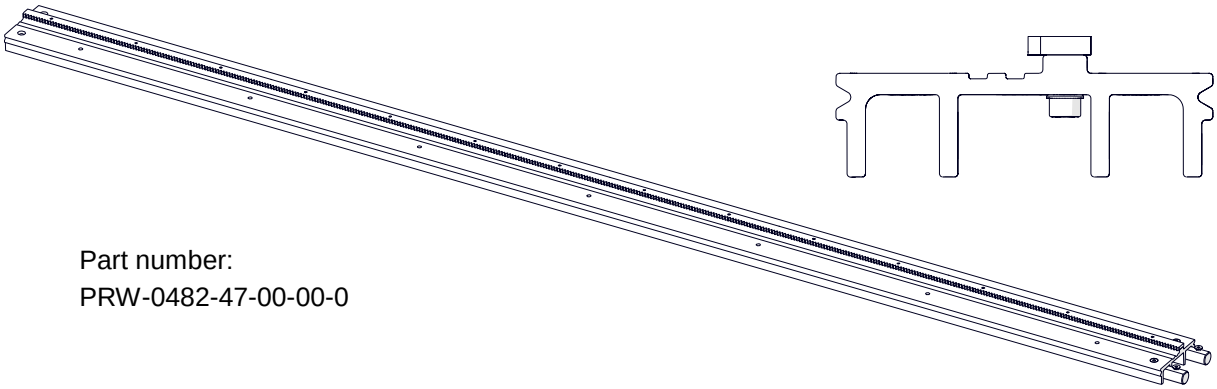
Allows guiding the carriage along a curve. The length of a single rail is 2 m (6.5 ft).



Part number:
PRW-0482-15-05-00-0

5.2. Rigid track

Allows guiding the carriage along a straight line. The length of a single rail is 2 m (6.5 ft).

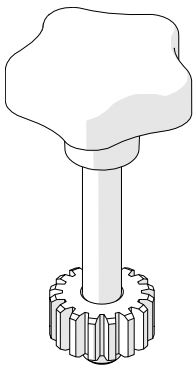


Part number:
PRW-0482-47-00-00-0

5.3. Rack adjustment tool

Removes the clearance between the racks of two semi-flexible rails that are put on a curve.

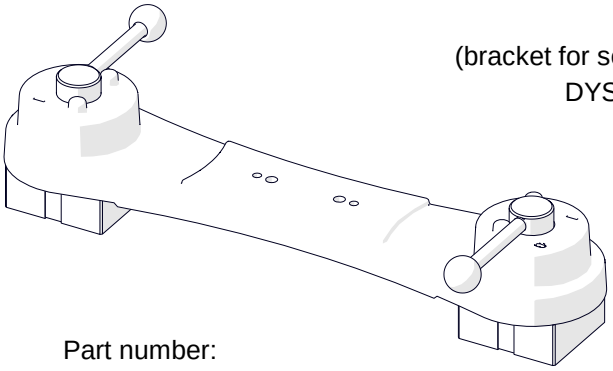
Part number:
PKT-0341-13-00-00-0



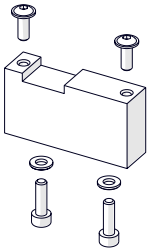
5.4. Magnetic units

5.4.1. Magnetic unit

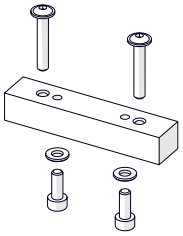
Allows clamping a semi-flexible or rigid track to ferromagnetic surfaces.



Part number
(bracket for semi-flexible track):
DYS-0482-19-00-00-0



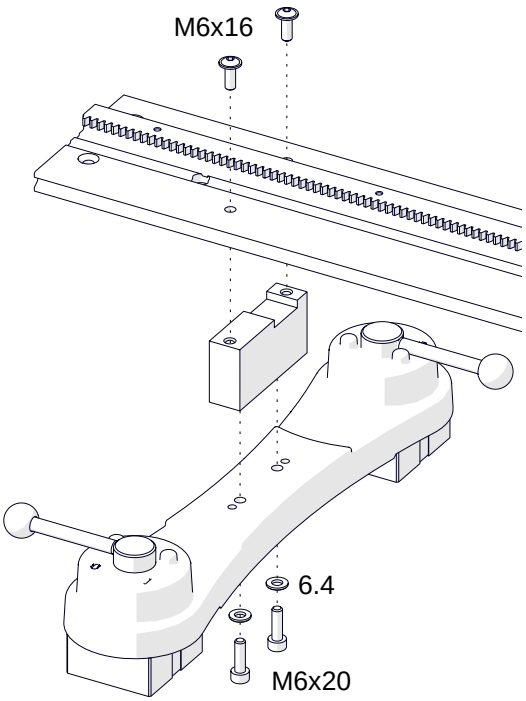
Part number
(bracket for rigid track):
DYS-0482-21-00-00-0

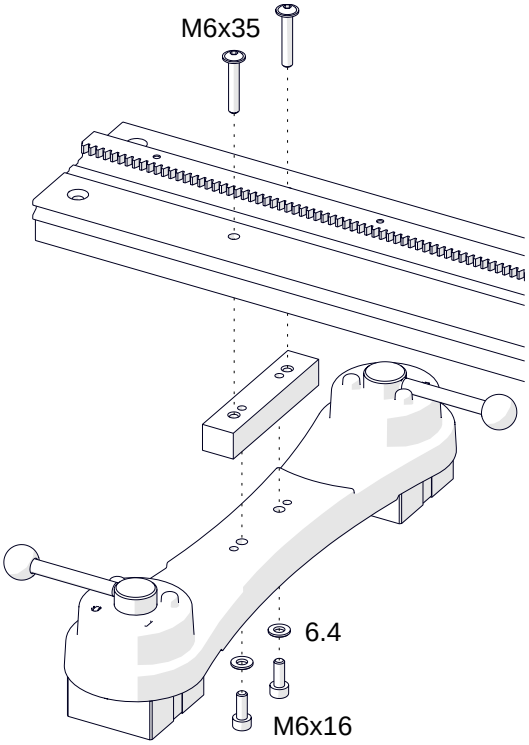


Part number:
ZSP-0475-44-00-00-0 (magnetic unit)
ZSP-0475-44-00-00-1 (heat-resistant magnetic unit)

Holding force on a 5 mm (0.2″) thick surface	Temperature	
	Magnetic unit	Heat-resistant magnetic unit
100% (1200 N)	20°C (68°F)	20°C (68°F)
75% (900 N)	80°C (176°F)	160°C (320°F)
50% (600 N)	120°C (248°F)	200°C (392°F)

Use the 4 mm hex wrench to attach the unit to a semi-flexible or rigid track as shown in the figures.





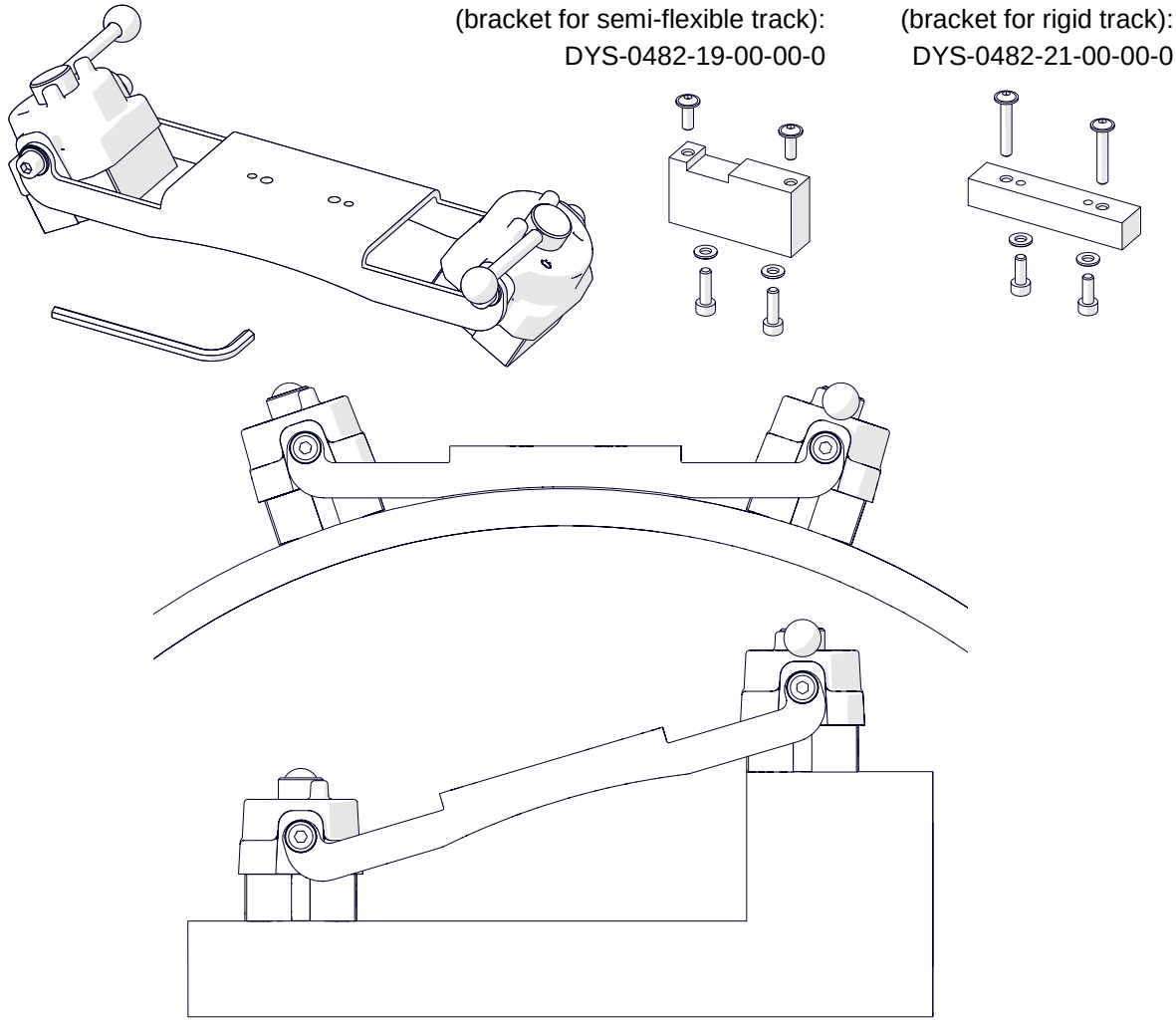
5.4.2. Pivoting magnetic unit

Allows clamping a semi-flexible or rigid track to ferromagnetic surfaces that are concave or convex, to pipes with outer diameters of at least 800 mm (31.5″), and to surfaces that differ in height up to 80 mm (3.1″).

Part number:
ZSP-0475-85-00-00-0

Part number
(bracket for semi-flexible track):
DYS-0482-19-00-00-0

Part number
(bracket for rigid track):
DYS-0482-21-00-00-0



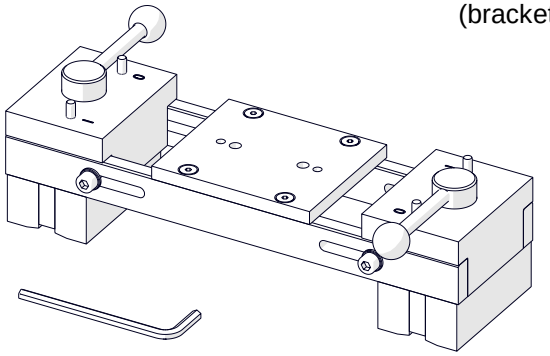
Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1200 N)	20°C (68°F)
75% (900 N)	80°C (176°F)
50% (600 N)	120°C (248°F)

Install the unit in the same way as the magnetic unit is installed. To adjust the angle, use the 6 mm hex wrench and loosen four side screws.

5.4.3. Spacing-adjustable magnetic unit

Allows clamping a semi-flexible track or rigid track to two ferromagnetic pipes with diameters of 25–230 mm (1–9″) and the distance between pipe axes of 170–230 mm (6.7–9.1″).

Part number:
ZSP-0523-19-00-00-0



Part number
(bracket for semi-flexible track):
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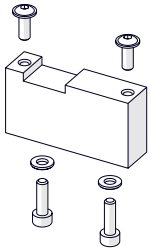
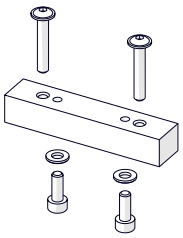
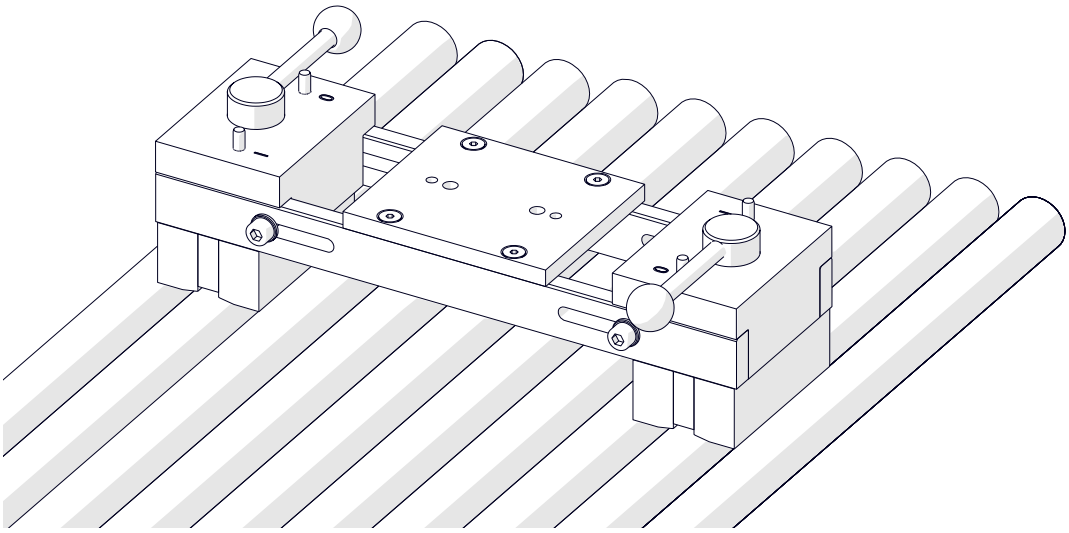


Part number
(bracket for rigid track):
DYS-0482-21-00-00-0





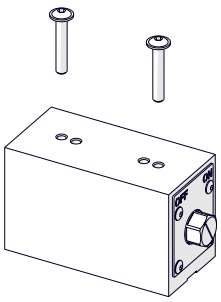
Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1200 N)	20°C (68°F)
75% (900 N)	80°C (176°F)
50% (600 N)	120°C (248°F)

Install the unit in the same way as the magnetic unit is installed. To adjust the spacing, use the 5 mm hex wrench and loosen four side screws.

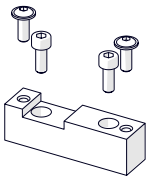
5.4.4. Narrow magnetic unit

Allows clamping a semi-flexible track or rigid track to ferromagnetic surfaces.

Part number:
PDS-0582-10-00-02-0

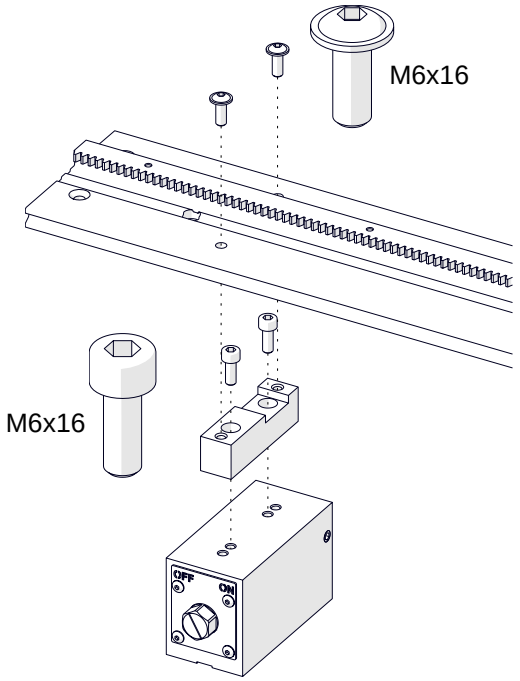


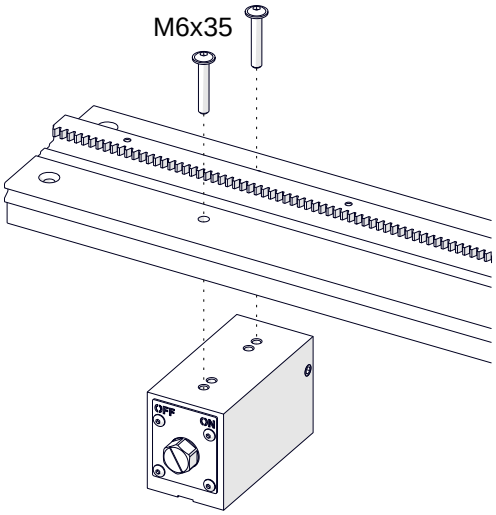
Part number
(bracket for semi-flexible track):
DYS-0582-10-00-00-0



Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1000 N)	20°C (68°F)
75% (750 N)	80°C (176°F)
50% (500 N)	120°C (248°F)

Use the 4 mm hex wrench to attach the unit to a semi-flexible or rigid track as shown in the figures.



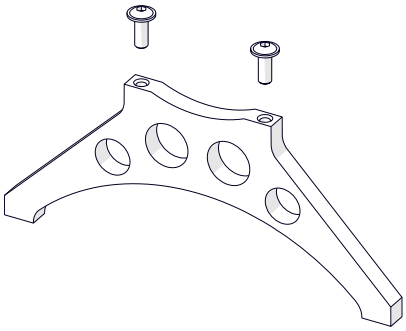


To clamp the unit to the surface, use the 17 mm flat wrench (not included) and set the side screw to ON.

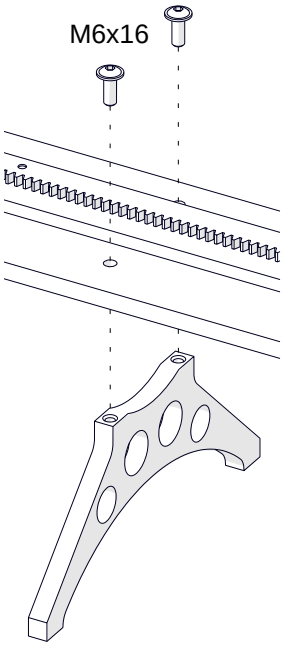
5.5. Semi-flexible track support

Allows supporting a semi-flexible track by using the support instead of a magnetic unit. Use the 4 mm hex wrench to attach the support to a semi-flexible track.

Part number:
WSP-0523-12-01-00-1

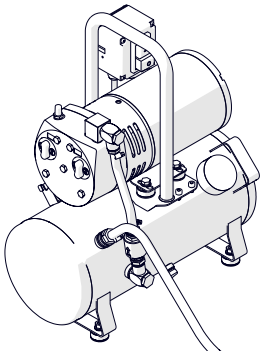


M6x16



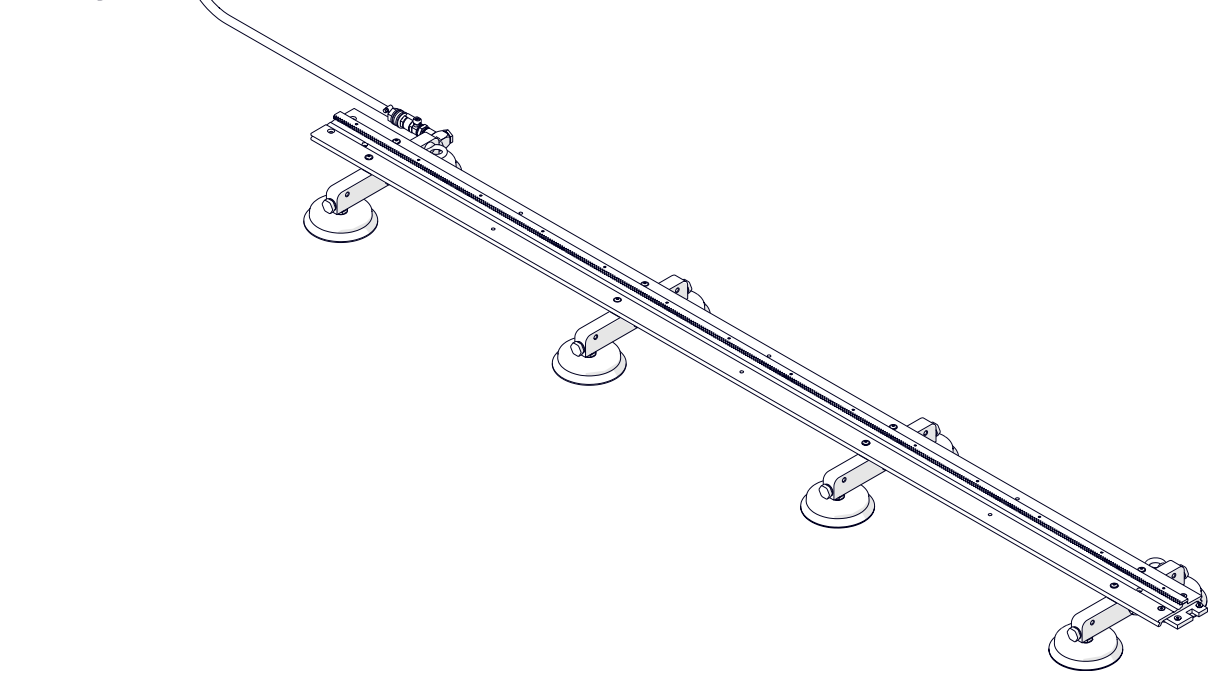
5.6. Vacuum track system

Dedicated to clamping the track to non-ferromagnetic surfaces.



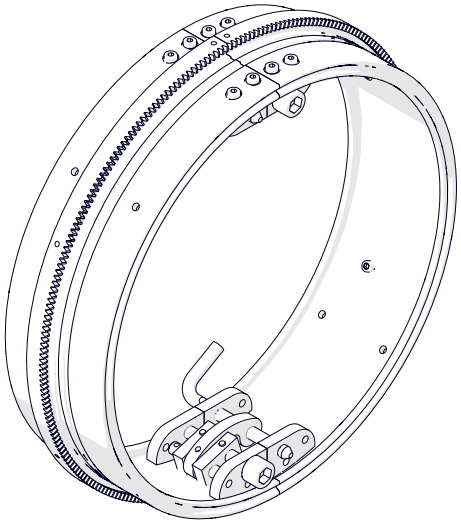
Part number (vacuum pump with safety reservoir):
AGR-0541-10-10-00-0 (115 V UK)
AGR-0541-10-20-00-0 (230 V CEE)

Other parts of the system are described in a related manual.



5.7. Ring tracks

Allow welding of round workpieces with the outer diameters from 200 mm (8″) to 3000 mm (120″). The tracks consist of two, three, or four rails. Tracks not shown in the table are available on request.



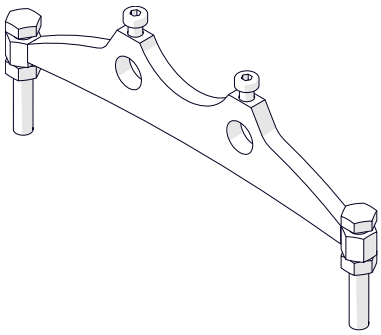
Pipe outer diameter		Part number	Rails	Ring track supports required
Min. [mm]	**Max.** [mm]			
200	250	TRO-0523-14-00-00-0	2	4
250	300	TRO-0523-78-00-00-0	2	4
300	350	TRO-0523-20-00-00-0	2	4
350	400	TRO-0523-21-00-00-0	2	4
400	450	TRO-0523-23-00-00-0	2	6
450	500	TRO-0523-24-00-00-0	2	6
500	550	TRO-0523-25-00-00-0	2	6
550	600	TRO-0523-26-00-00-0	2	6
600	650	TRO-0523-22-00-00-0	2	6
650	700	TRO-0523-28-00-00-0	2	6
700	750	TRO-0523-29-00-00-0	2	6
750	800	TRO-0523-30-00-00-0	2	6
800	850	TRO-0523-31-00-00-0	2	6
850	900	TRO-0523-32-00-00-0	2	6
900	950	TRO-0523-33-00-00-0	2	8
950	1000	TRO-0523-34-00-00-0	2	8
1000	1050	TRO-0523-35-00-00-0	2	8
1050	1100	TRO-0523-36-00-00-0	3	9
1100	1150	TRO-0523-37-00-00-0	3	9
1150	1200	TRO-0523-38-00-00-0	3	9
1200	1250	TRO-0523-39-00-00-0	3	9
1250	1300	TRO-0523-40-00-00-0	3	9

Pipe outer diameter		Part number	Rails	Ring track supports required
Min. [mm]	**Max.** [mm]			
1300	1350	TRO-0523-41-00-00-0	3	12
1350	1400	TRO-0523-42-00-00-0	3	12
1400	1450	TRO-0523-43-00-00-0	3	12
1450	1500	TRO-0523-44-00-00-0	3	12
1500	1550	TRO-0523-45-00-00-0	3	12
1550	1600	TRO-0523-46-00-00-0	3	12
1600	1650	TRO-0523-47-00-00-0	3	12
1650	1700	TRO-0523-48-00-00-0	3	12
1700	1750	TRO-0523-49-00-00-0	3	12
1750	1800	TRO-0523-50-00-00-0	3	12
1800	1850	TRO-0523-51-00-00-0	3	12
1850	1900	TRO-0523-52-00-00-0	3	15
1900	1950	TRO-0523-53-00-00-0	3	15
1950	2000	TRO-0523-54-00-00-0	3	15
2000	2050	TRO-0523-55-00-00-0	3	15
2050	2100	TRO-0523-56-00-00-0	4	16
2100	2150	TRO-0523-57-00-00-0	4	16
2150	2200	TRO-0523-58-00-00-0	4	16
2200	2250	TRO-0523-59-00-00-0	4	16
2250	2300	TRO-0523-60-00-00-0	4	20
2300	2350	TRO-0523-61-00-00-0	4	20
2350	2400	TRO-0523-62-00-00-0	4	20
2400	2450	TRO-0523-63-00-00-0	4	20
2450	2500	TRO-0523-64-00-00-0	4	20
2500	2550	TRO-0523-65-00-00-0	4	20
2550	2600	TRO-0523-66-00-00-0	4	20
2600	2650	TRO-0523-67-00-00-0	4	20
2650	2700	TRO-0523-68-00-00-0	4	20
2700	2750	TRO-0523-69-00-00-0	4	20
2750	2800	TRO-0523-70-00-00-0	4	20
2800	2850	TRO-0523-71-00-00-0	4	20
2850	2900	TRO-0523-72-00-00-0	4	20
2900	2950	TRO-0523-73-00-00-0	4	20
2950	3000	TRO-0523-74-00-00-0	4	20
3000	3050	TRO-0523-75-00-00-0	4	20

5.8. Ring track supports

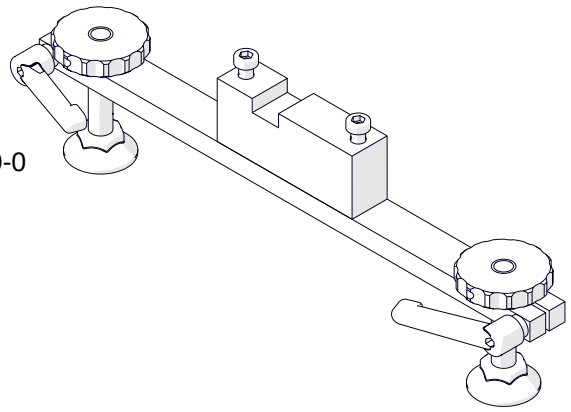
5.8.1. Ring track support with bolts

Part number:
WSP-0523-14-02-00-0



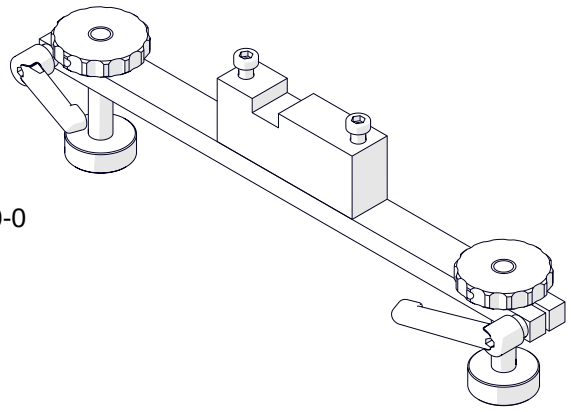
5.8.2. Ring track support with plastic feet

Part number:
WSP-0523-14-11-00-0



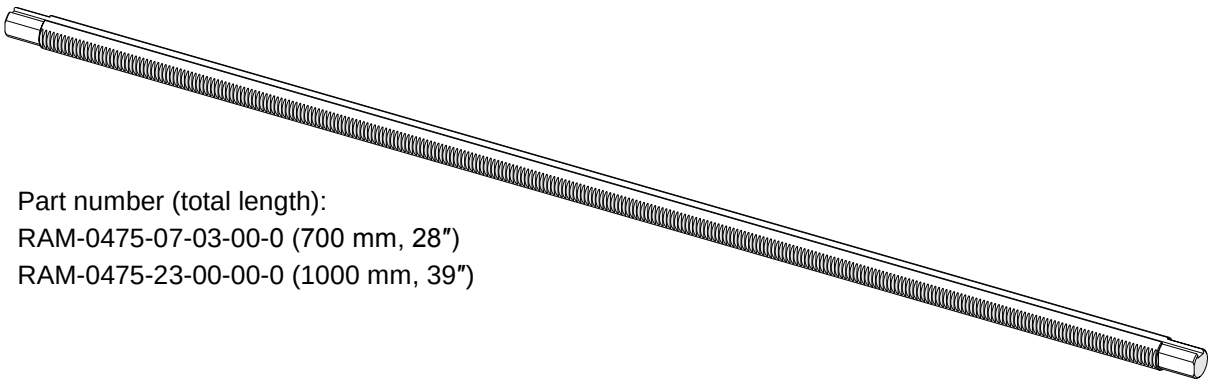
5.8.3. Ring track support with magnets

Part number:
WSP-0523-14-12-00-0



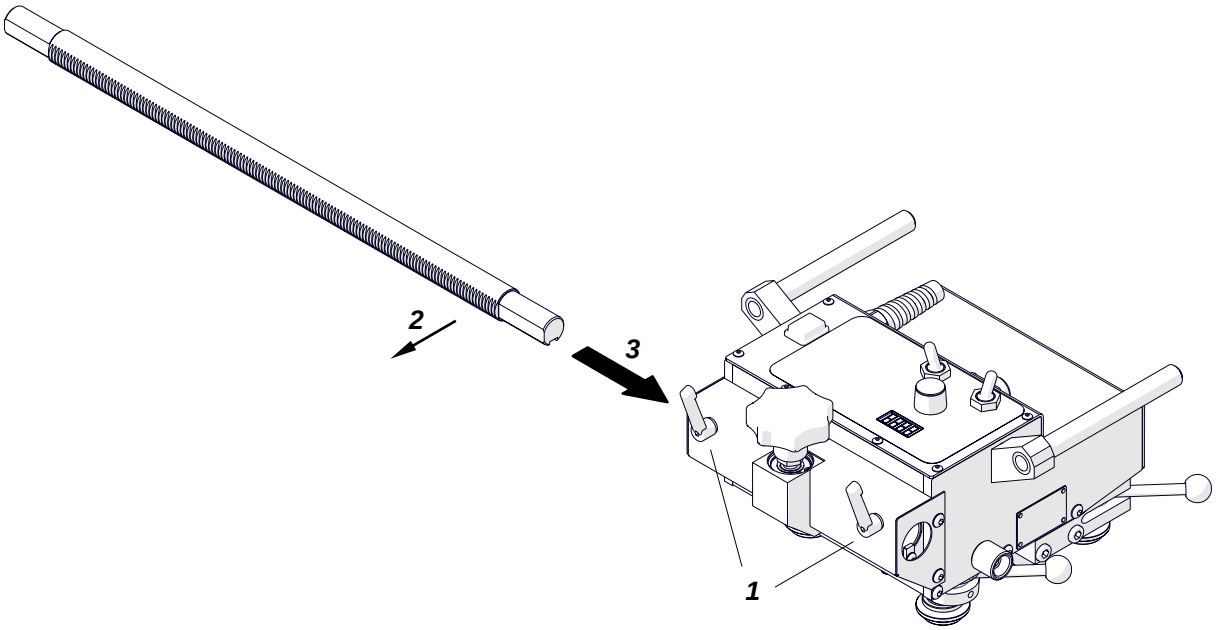
5.9. Rack

Changes the horizontal or vertical reach of the torch holder.



Part number (total length):
RAM-0475-07-03-00-0 (700 mm, 28″)
RAM-0475-23-00-00-0 (1000 mm, 39″)

Loosen the levers (*1*) and remove the installed rack. Point the teeth of the rack to the side (*2*) and move the rack into the carriage (*3*).

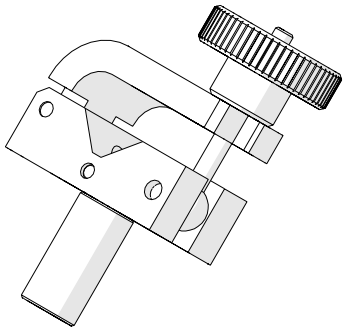


5.10. Torch clamps

5.10.1. 16–22 mm torch clamp

Allows using a torch with the diameter of 16–22 mm (0.63–0.87″).

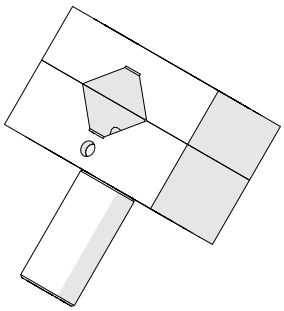
Part number:
ZRZ-0466-04-01-00-0



5.10.2. 16–22 mm torch clip

The clip allows using a torch with the diameter of 16–22 mm (0.63–0.87″). Use the 4 mm hex wrench to tighten the torch in the clip.

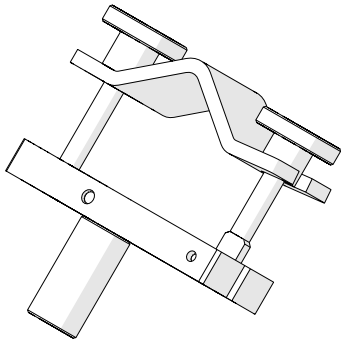
Part number:
ZCS-0476-06-01-00-0



5.10.3. 22–35 mm torch clamp

Allows using a torch with the diameter of 22–35 mm (0.87–1.38″).

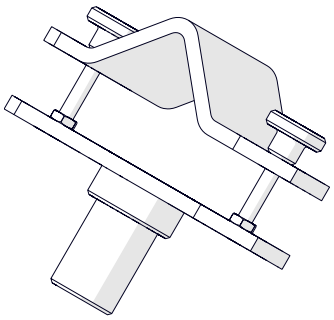
Part number:
ZRZ-0466-19-00-00-0



5.10.4. 28–35 mm torch clamp

Allows using a SAW torch with the diameter of 28–35 mm (1.10–1.38″).

Part number:
ZCS-0475-28-10-00-0

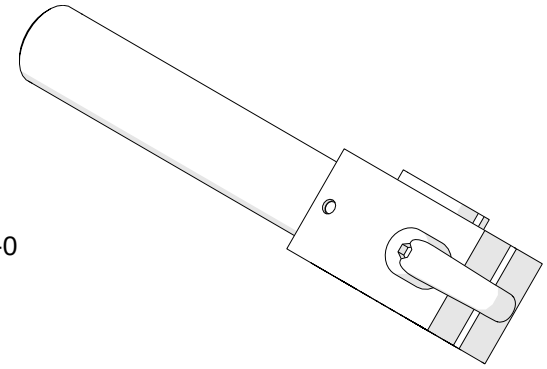


5.11. Rods

5.11.1. Short rod

Provides a 120 mm (4.7″) reach.

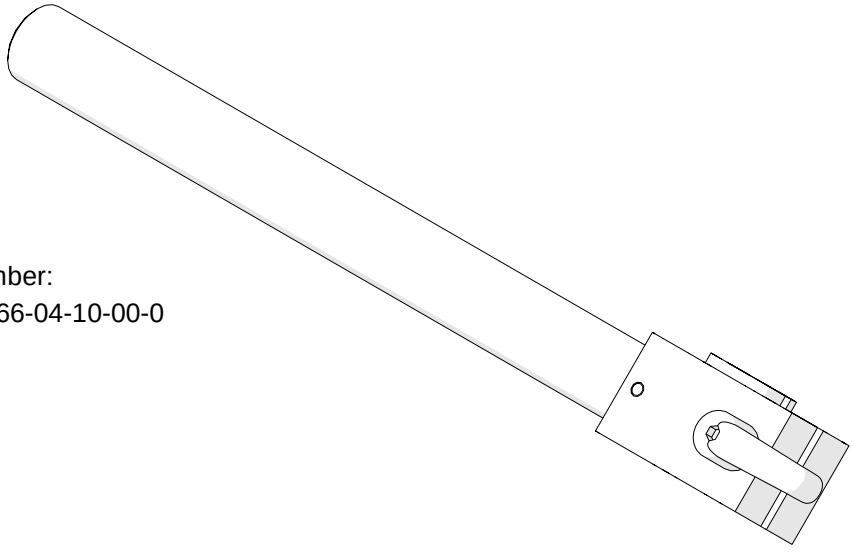
Part number:
WLK-0476-20-01-00-0



5.11.2. Long rod

Provides a 240 mm (9.4″) reach.

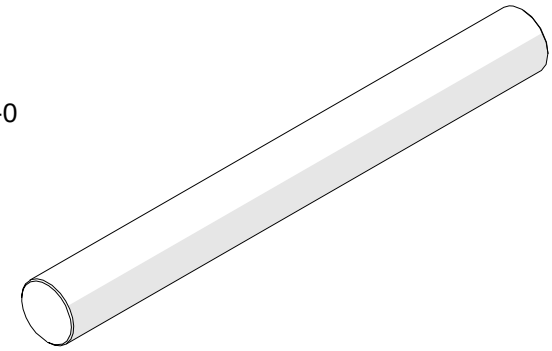
Part number:
WLK-0466-04-10-00-0



5.11.3. Rod for cutting

Allows using a cutting torch holder.

Part number:
KLM-0236-00-16-00-0

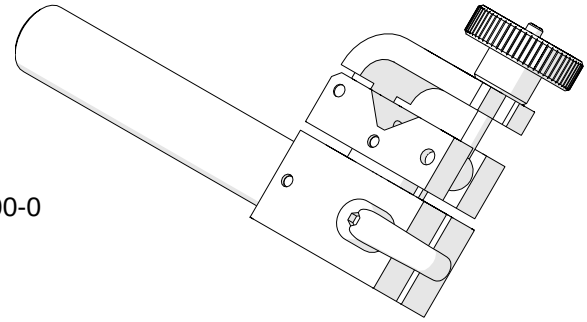


5.12. Torch holders

5.12.1. Short rod torch holder with clamp

Allows using a torch with the diameter of 16–22 mm (0.63–0.87″).

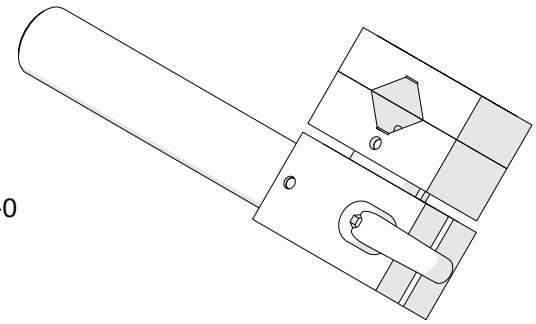
Part number:
UCW-0476-20-00-00-0



5.12.2. Short rod torch holder with clip

The holder allows using a torch with the diameter of 16–22 mm (0.63–0.87″). Use the 4 mm hex wrench to tighten the torch in the clip.

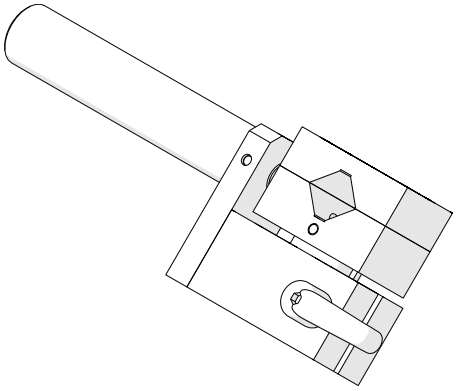
Part number:
UCW-0476-27-00-00-0



5.12.3. Short rod low torch holder with clip

The holder allows using a torch with the diameter of 16–22 mm (0.63–0.87″). Use the 4 mm hex wrench to tighten the torch in the clip.

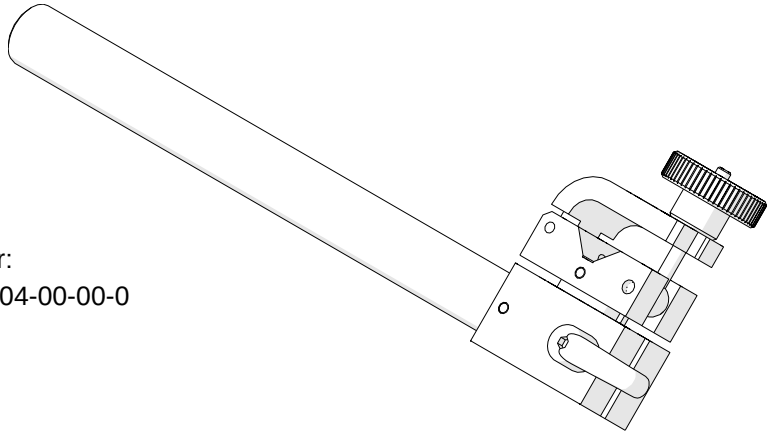
Part number:
UCW-0476-06-00-00-0



5.12.4. Long rod torch holder with clamp

Allows using a torch with the diameter of 16–22 mm (0.63–0.87″).

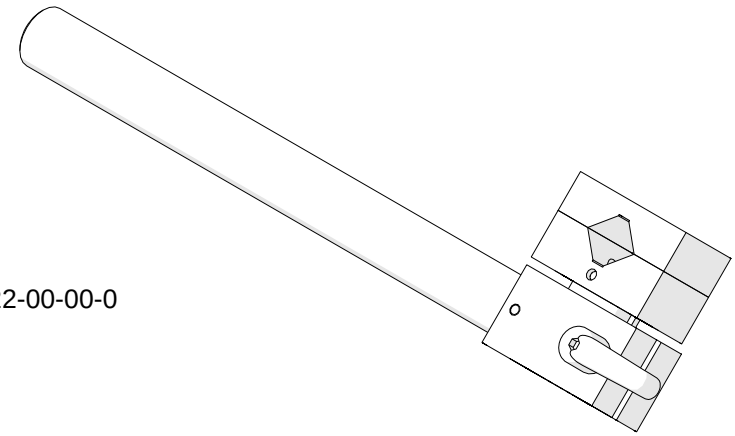
Part number:
UCW-0466-04-00-00-0



5.12.5. Long rod torch holder with clip

The holder allows using a torch with the diameter of 16–22 mm (0.63–0.87″). Use the 4 mm hex wrench to tighten the torch in the clip.

Part number:
UCW-0466-22-00-00-0

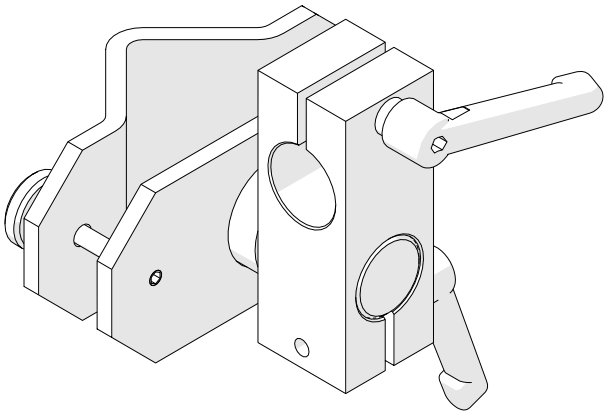


5.13. Cutting torch holders

5.13.1. Standard torch holder

Designed for torches with the diameter of 28–35 mm (1.10–1.38″). Allows rough adjustment of the torch angle.

Part number:
UCW-0475-28-00-00-0

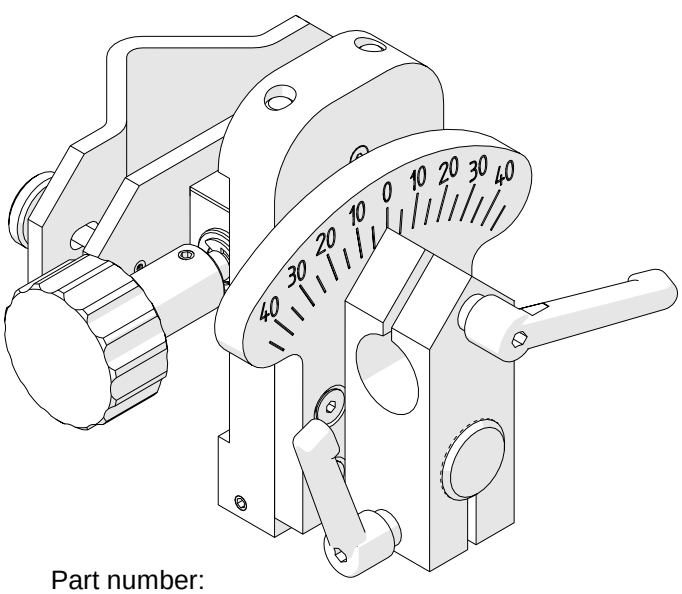


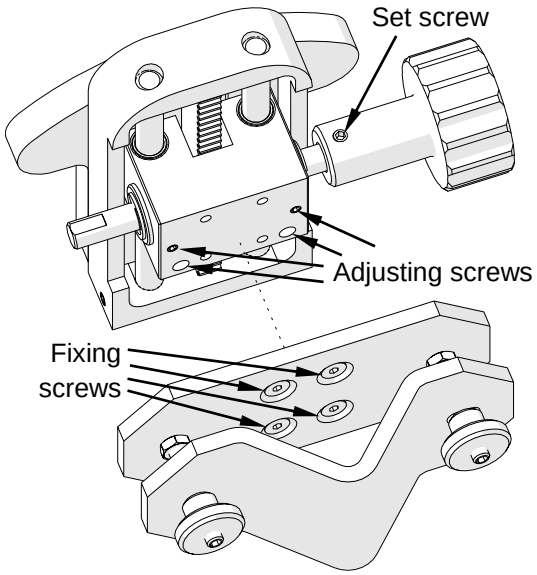
5.13.2. Precise torch holder

Designed for torches with the diameter of 28–35 mm (1.10–1.38″). Allows precise adjustment of the torch angle.

Use the knob to adjust the vertical position. Install the knob at any side by using the 2.5 mm hex wrench and the set screw.

To adjust the resistance of the vertical move, use the 2.5 mm hex wrench to unscrew the fixing screws. Then, use the 2 mm hex wrench to rotate the adjusting screws.



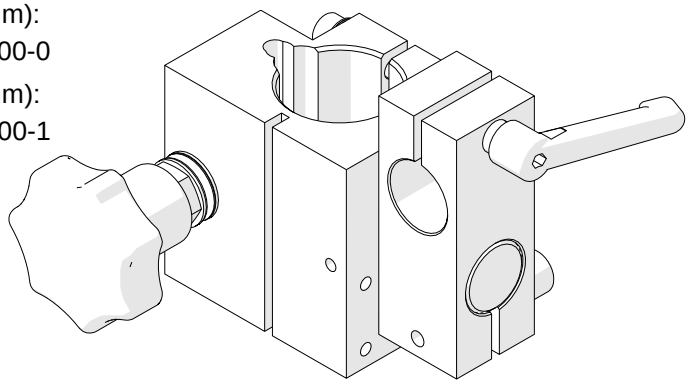


Part number:
UCW-0475-08-00-00-0

5.13.3. Machine torch holder (fox oxy-fuel cutting)

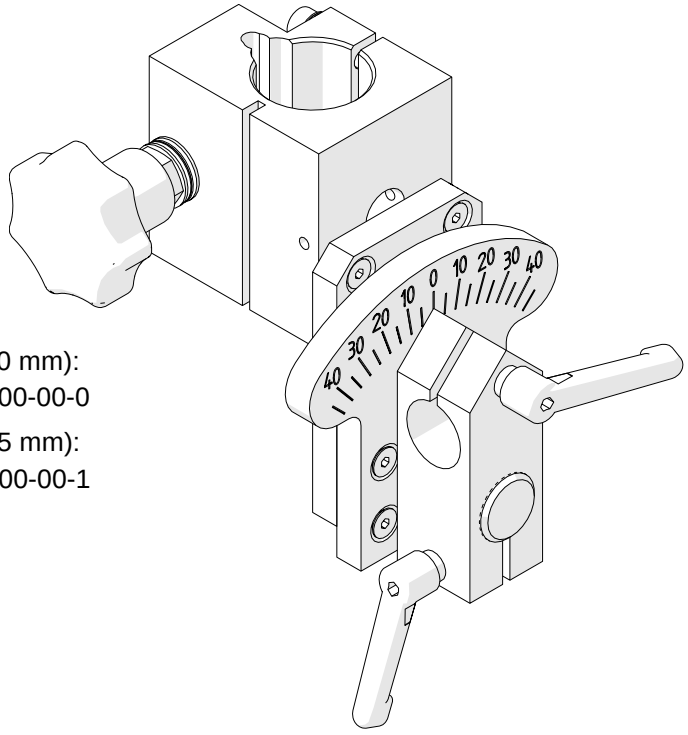
Designed for torches with the diameter of 30 mm (1.18″) or 35 mm (1.38″) equipped with a rack. The holder allows adjustment of the vertical position of the torch by using the knob and rough adjustment of the angle.

Part number (30 mm):
UCW-0475-61-00-00-0
Part number (35 mm):
UCW-0475-29-00-00-1



5.13.4. Precise machine torch holder (for oxy-fuel cutting)

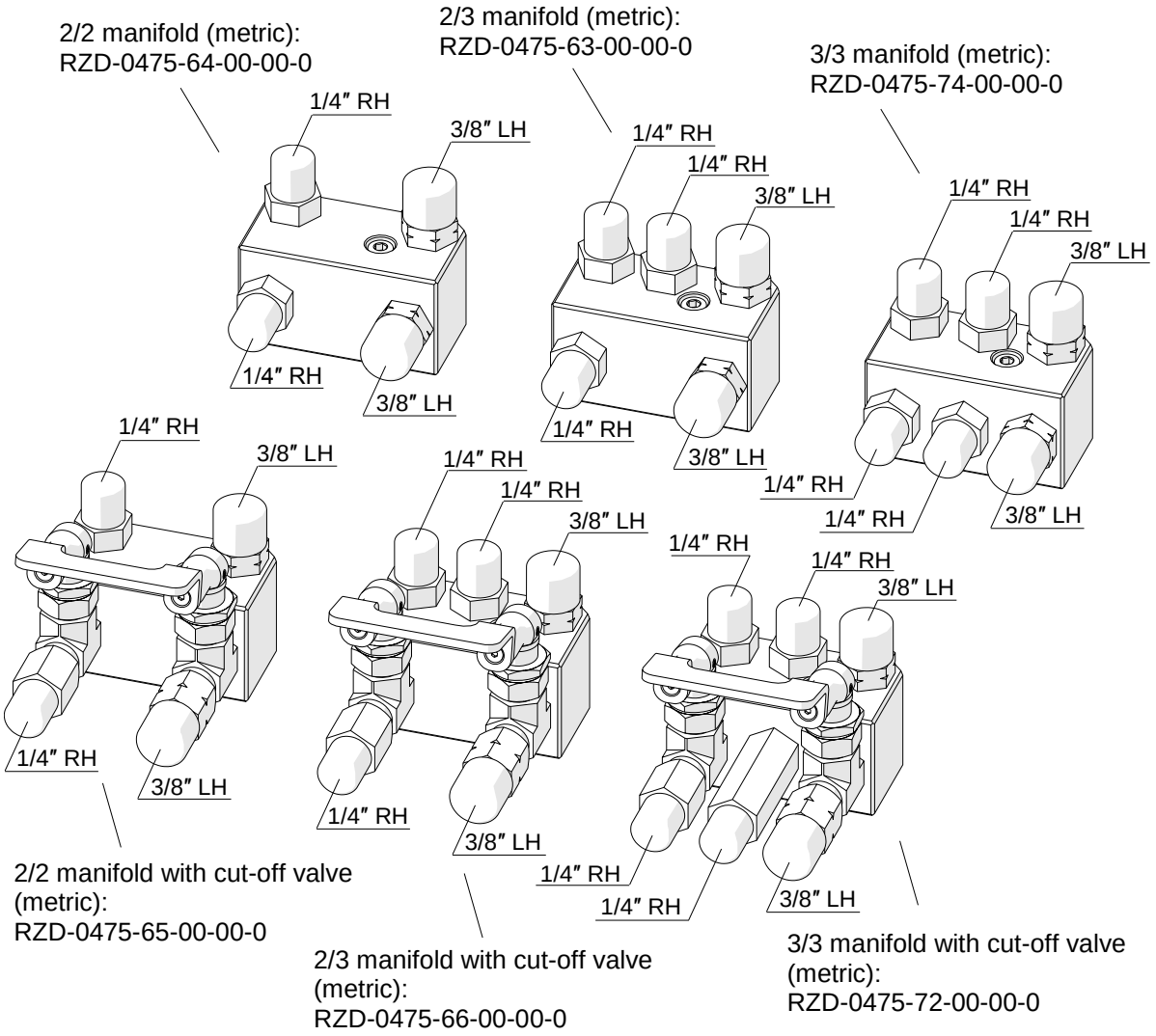
Designed for torches with the diameter of 30 mm (1.18″) or 35 mm (1.38″) equipped with a rack. The holder allows adjustment of the vertical position of the torch by using the knob and precise adjustment of the angle.

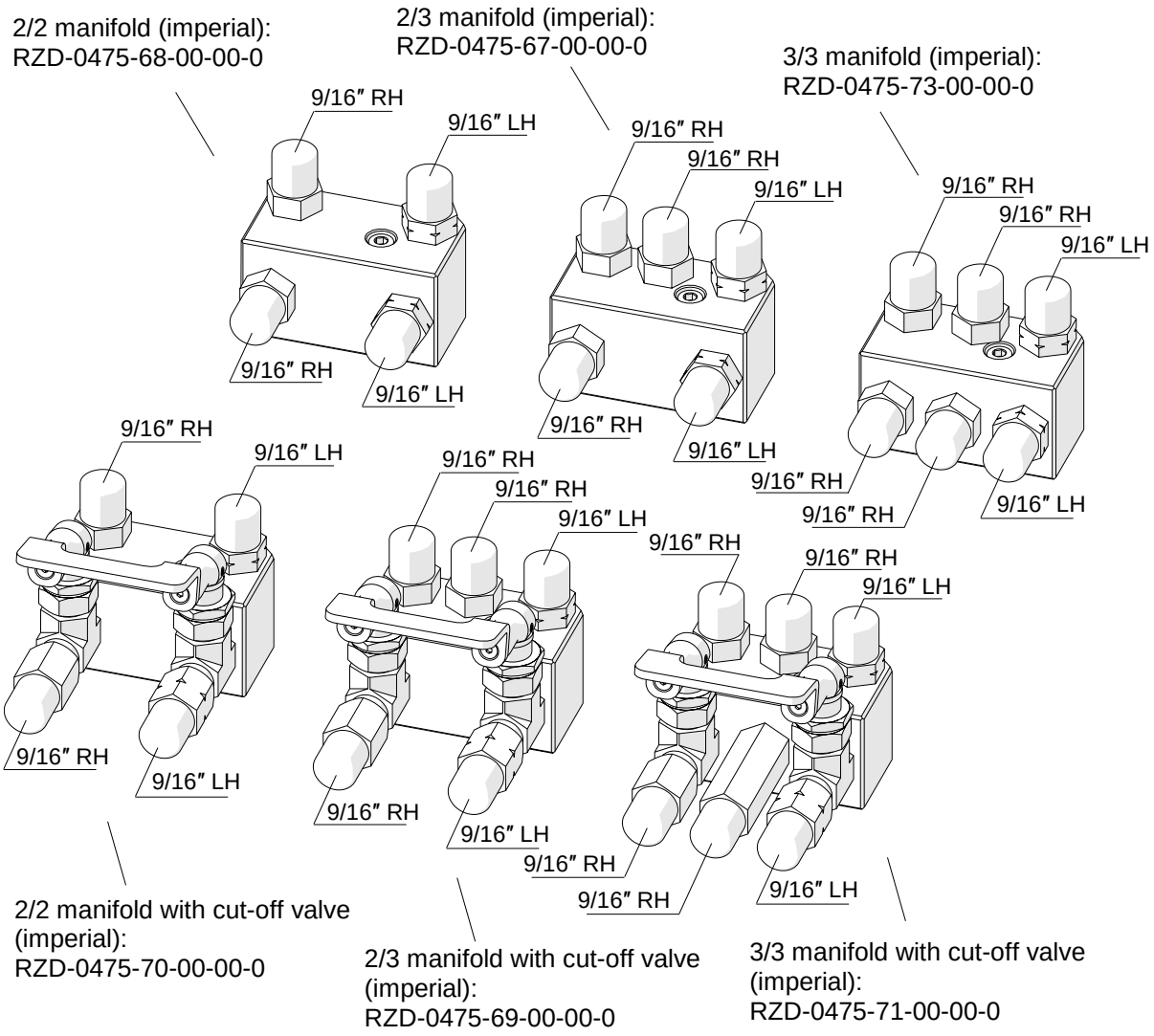


Part number (30 mm):
UCW-0475-59-00-00-0
Part number (35 mm):
UCW-0475-42-00-00-1

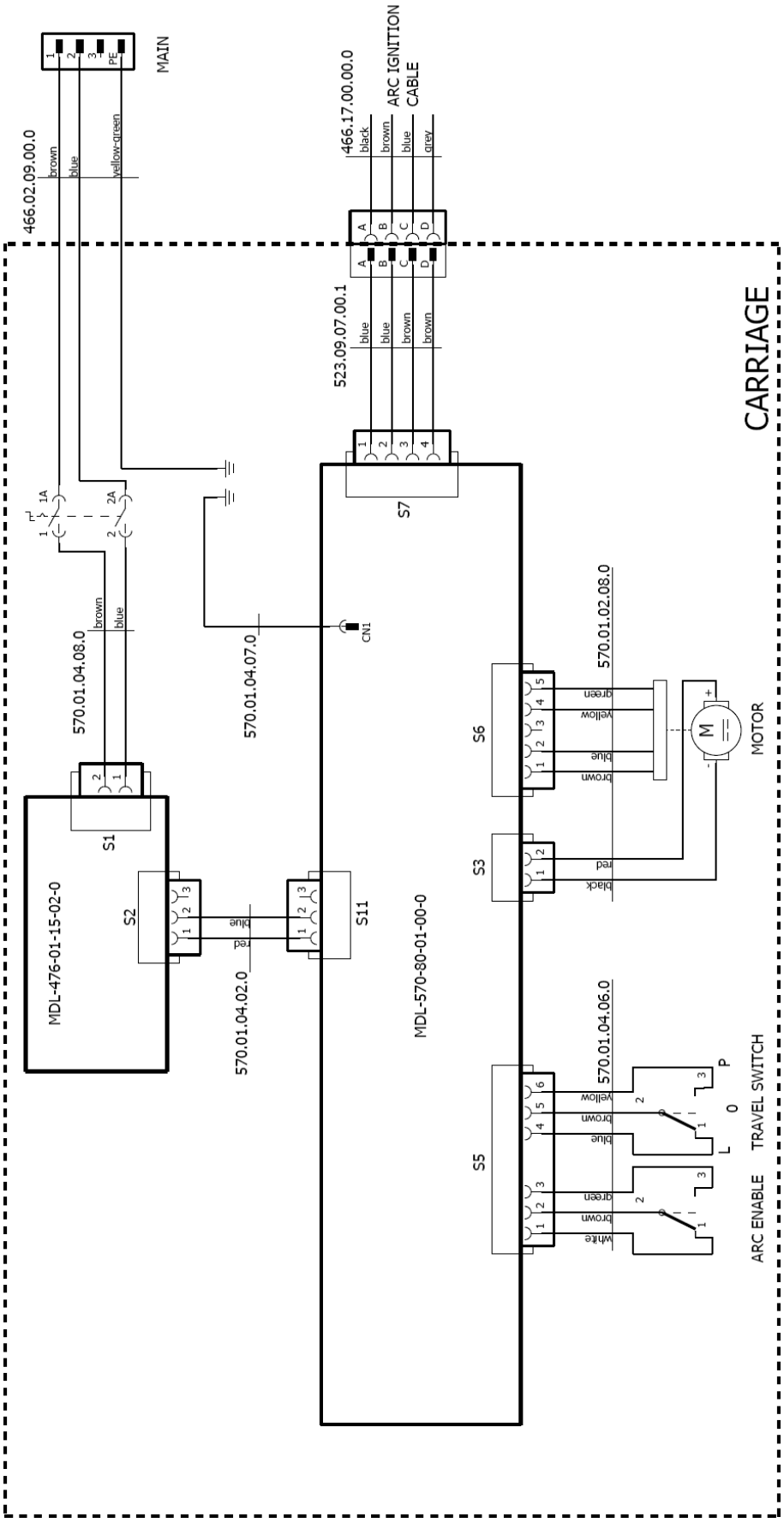
5.14. Gas manifold (for oxy-fuel cutting)

Provides safe gas delivery to 2- or 3-hose torches. Manifolds are available with or without gas cut-off valve in both metric and imperial versions.





6. WIRING DIAGRAM



7. DECLARATION OF CONFORMITY

EC Declaration of Conformity

We

Ansa Group Ltd
Unit 21 Empire Business Park
Enterprise Way, Burnley
Lancs, BB12 6LT, UK

declare with full responsibility that:

Rail Tug Welding Carriage

is manufactured in accordance with the following standards:

- EN 12100
- EN 60204-1
- EN 60974-10

and satisfies safety regulations of the guidelines: 2014/30/EC, 2014/35/EC, 2006/42/EC.

Person authorized to compile the technical file:
David McFadden, Unit 21 Empire Business Park, Burnley, United Kingdom

Burnley, 15 February 2018

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David McFadden
Managing Director

8. WARRANTY CARD

WARRANTY CARD No……

..... in the name of Manufacturer warrants the Rail Tug Welding Carriage to be free of defects in material and workmanship under normal use for a period of 12 months from the date of sale.

This warranty does not cover rollers as well as damage or wear that arise from misuse, accident, tempering, or any other causes not related to defects in workmanship or material.

Date of production .....

Serial number .....

Date of sale .....

Signature of seller.....

1.02 / 3 December 2018

WE RESERVE THE RIGHT TO MAKE CHANGES IN THIS MANUAL WITHOUT NOTICE