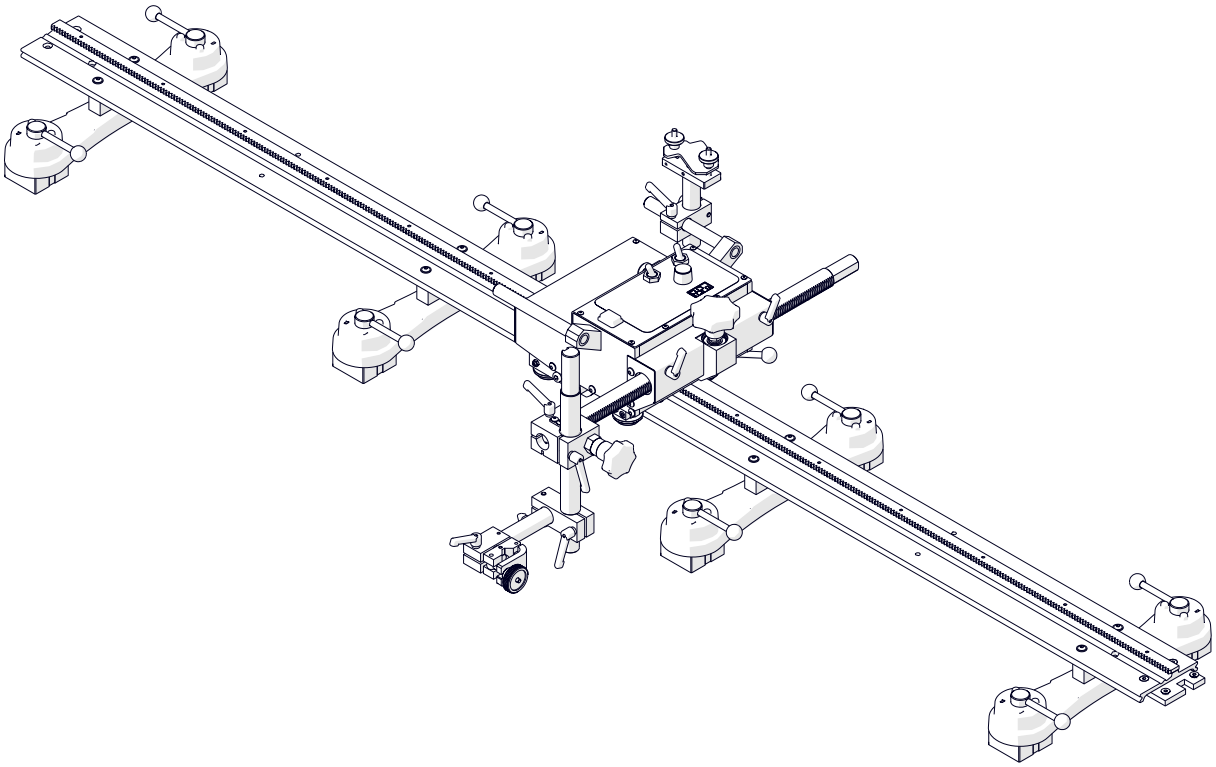
The tools of innovation.

OPERATOR'S MANUAL

Rail Runner LT

WELDING CARRIAGE



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Contents

1. GENERAL INFORMATION

1.1. Application

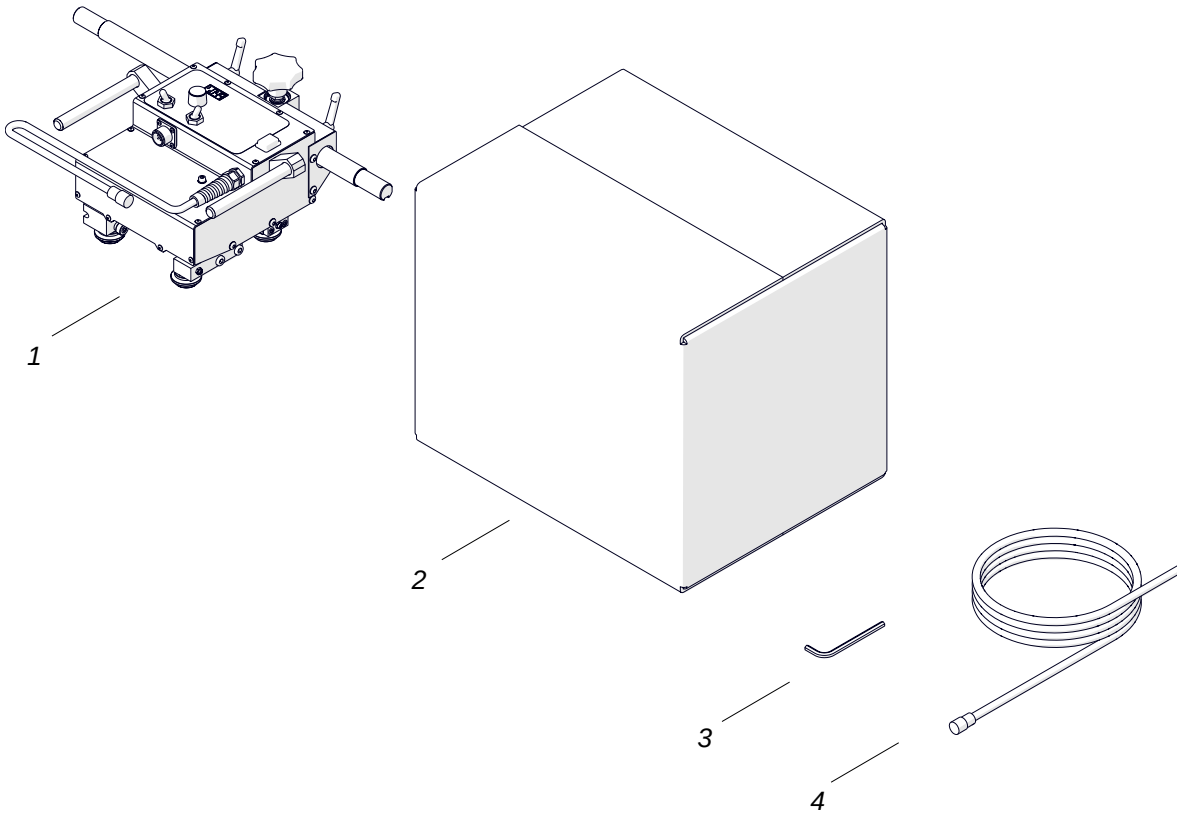
The Rail Runner LT is a track carriage designed to cut and to make butt and fillet welds. Allows MIG/MAG, SAW, oxy-fuel, or plasma torches. The track is clamped with magnetic units to ferromagnetic surfaces that are flat or curved.

Accessories allow using torches with a larger diameter, and guiding the carriage on a hi-flex, semi-flex, 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

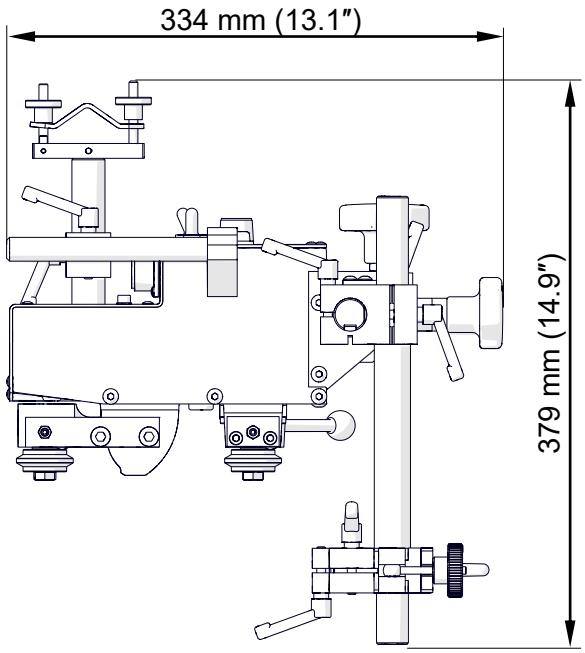
Voltage		1~ 115–230 V, 50–60 Hz
Power		66 W
Welding position (according to EN ISO 6947 and AWS/ASME)	Horizontal	PA/1F/1G PB/2F PC/2G PD/4F PE/4G
	Vertical	PG/3F (contact your dealer)
Diameter of round workpiece	Ring tracks (OD)	200 mm (8″) – 3 m (10 ft)
	Hi-flex tracks (OD)	Minimum 1.5 m (5 ft)
	Hi-flex tracks (ID)	Minimum 3.4 m (11 ft)
	Custom rolled tracks (OD)	3–10 m (10–32 ft) (contact your dealer)
	Semi-flex tracks (OD)	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	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 non-condensing		80%
Protection level		IP 23
Weight		10 kg (22 lbs)

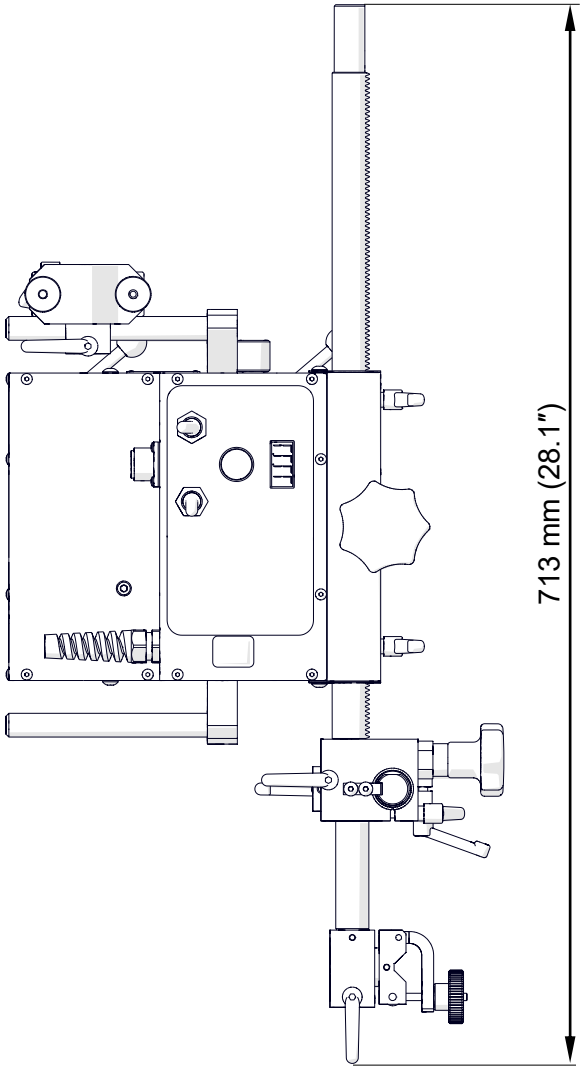
1.3. Equipment included



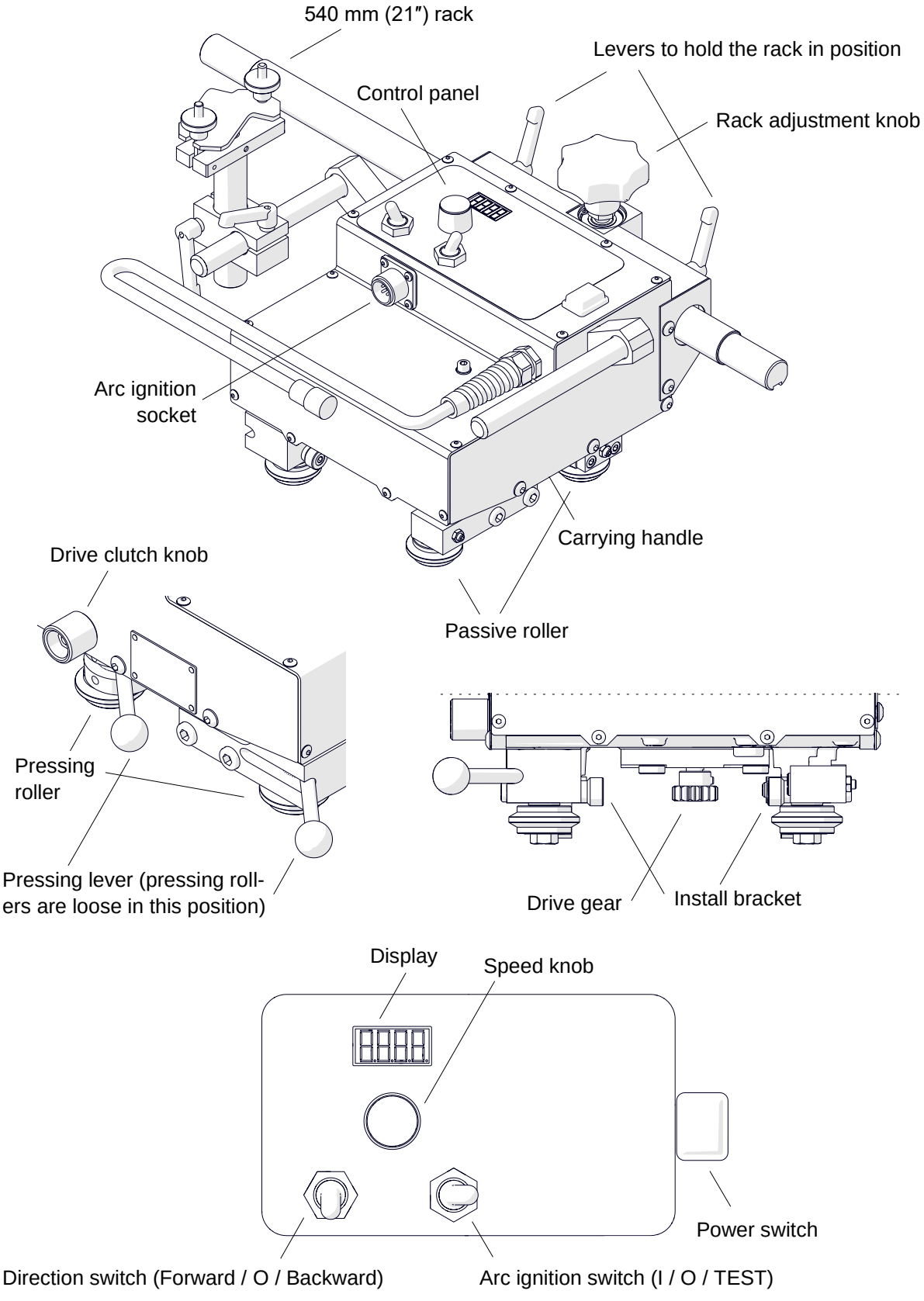
1	Carriage with a 540 mm (21″) rack	1 unit
2	Cardboard box	1 unit
3	6 mm hex wrench	1 unit
4	3 m (10 ft) power cord	1 unit
–	Operator’s Manual	1 unit

1.4. Dimensions





1.5. Design


540 mm (21″) rack
Levers to hold the rack in position
Control panel
Rack adjustment knob
Arc ignition socket
Carrying handle
Drive clutch knob
Passive roller
Pressing roller
Pressing lever (pressing rollers are loose in this position)
Drive gear
Install bracket
Display
Speed knob
Power switch
Direction switch (Forward / O / Backward)
Arc ignition switch (I / O / TEST)

2. SAFETY PRECAUTIONS

1. Before use, read this Operator's Manual and complete a training in occupational safety and health.
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 each use, ensure the correct condition of the carriage, power source, cords, arc ignition cable, connections, rollers, and gear.
9. 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.
10. Keep the carriage dry. Do not expose the carriage to rain, snow, or frost.
11. Keep the work area well lit, clean, and free of obstacles.
12. Do not use near flammable materials, or in explosive environments.
13. Transport and position the carriage by using the carrying handles.
14. Install the carriage only on the supplied track.
15. Make sure that the gear and rollers are clean.
16. Connect the cords and the arc ignition cable only after you set the power switch to 'O'.
17. Keep the sockets clean. Do not use high pressure during cleaning.
18. Install only torches whose diameter matches the diameter of the torch holder.
19. Hang the cables to decrease the load applied on the carriage.
20. Do not bend the hi-flex track to a radius less than 0.75 m (2.5 ft).
21. Do not bend the semi-flex track to a radius less than 5 m (16 ft).
22. Use the rigid track only on flat surfaces.
23. 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 hi-flex,

semi-flex 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.

24. Do not stay below the carriage or the track that is put at heights.
25. Use eye protection (helmet, shield, and screen), ear protection, gloves, and protective clothing. Do not use loose clothing.
26. Do not stop the carriage by hand. To stop, set the direction switch to ‘O’.
27. Maintain only after you unplug the carriage from the power source.
28. Repair only in a service center appointed by the seller.
29. If the carriage falls, is wet, or has any damage, stop the work and immediately send the carriage to the service center for check and repair.
30. Do not leave the carriage unattended during work.
31. 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 hi-flex, semi-flex, or rigid track

Attach magnetic units to the rail, and put it on the workpiece. Use the 4 mm or 5 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.

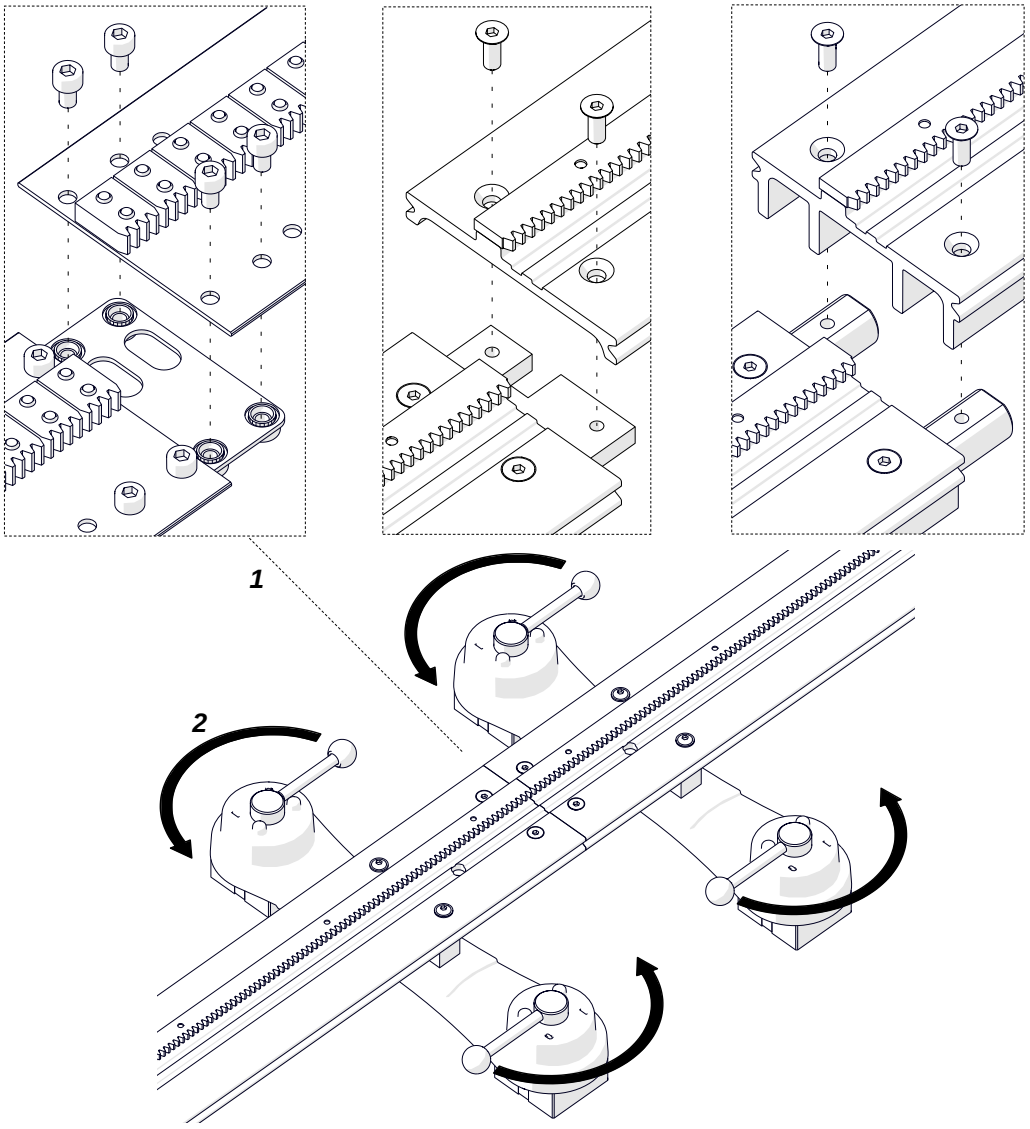


Fig. 1. Connecting the rails and clamping the magnetic units to the surface

If a semi-flex 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*).

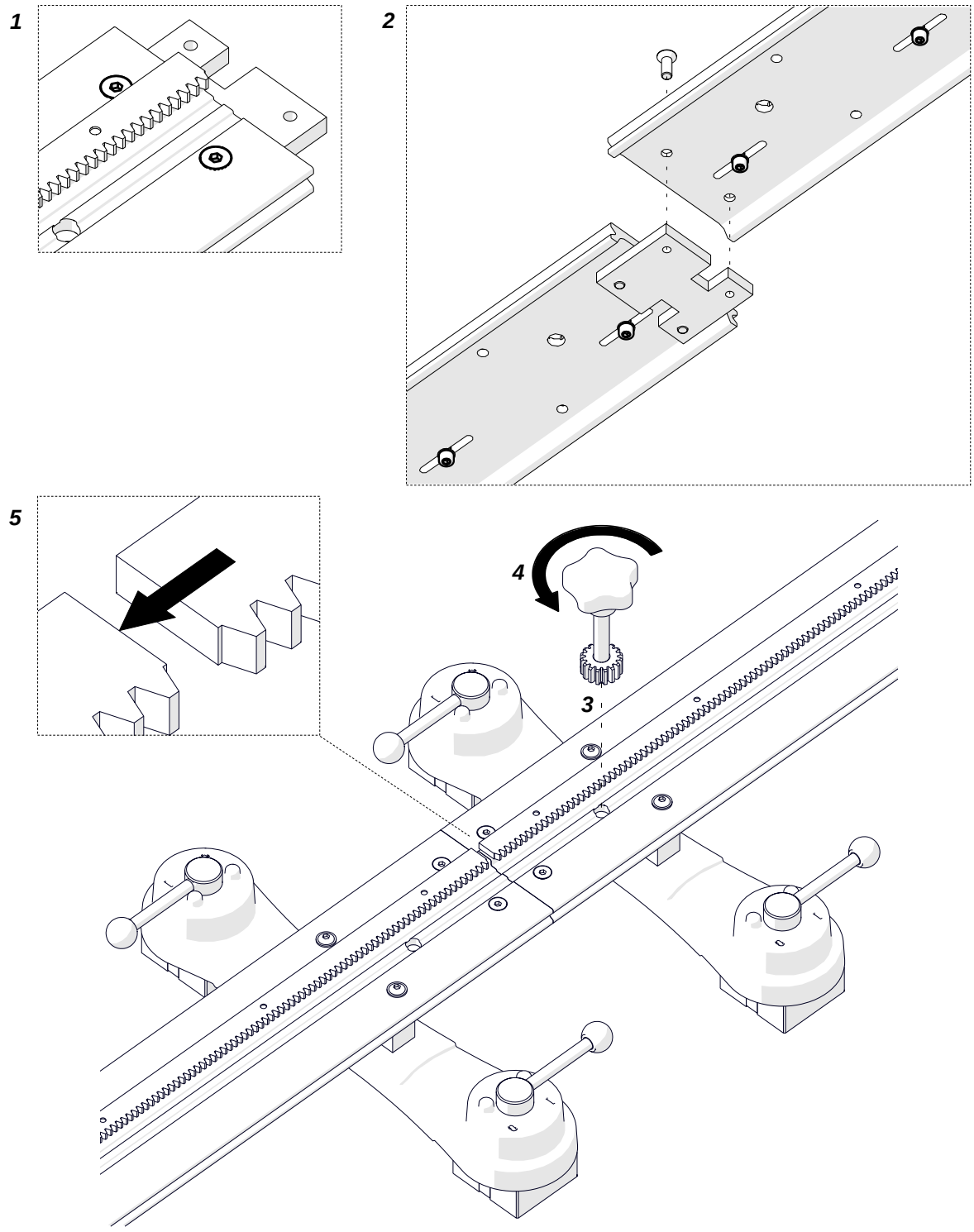
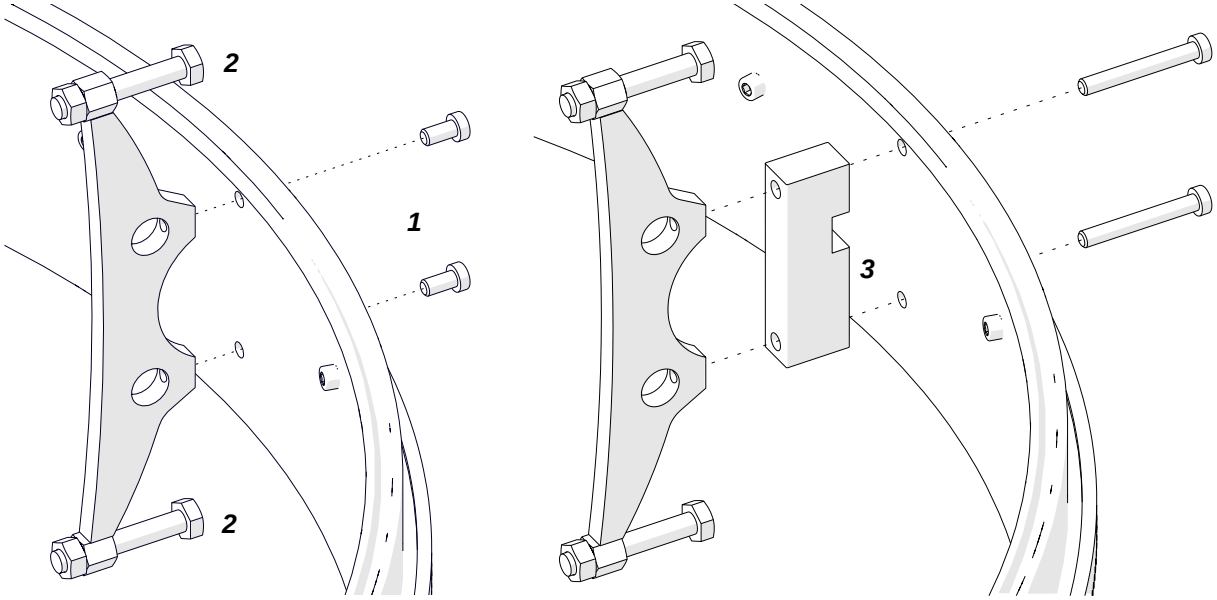


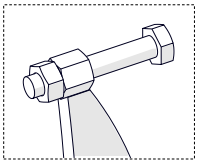
Fig. 2. Removing the gap between the racks of a semi-flex track

3.2. Assembling the ring track

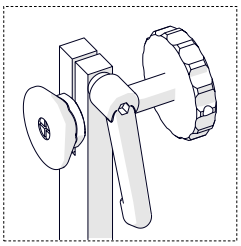
Select the track that matches the outer diameter of the round workpiece. Use the 4 mm hex wrench to attach the supports to the rails (*1*, Fig. 3). Next, on all supports, retract the bolts (*2*, or screws) as much as possible. To clamp the track on the workpiece with a smaller diameter, you can use brackets (*3*). But this will decrease the stiffness of the clamping.



Bolt
25 mm (1″) adjustment range



Screw with plastic foot
25 mm (1″) adjustment range



Screw with magnet
25 mm (1″) adjustment range

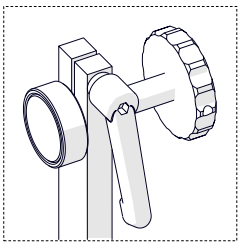


Fig. 3. Connecting the supports to the rails

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.

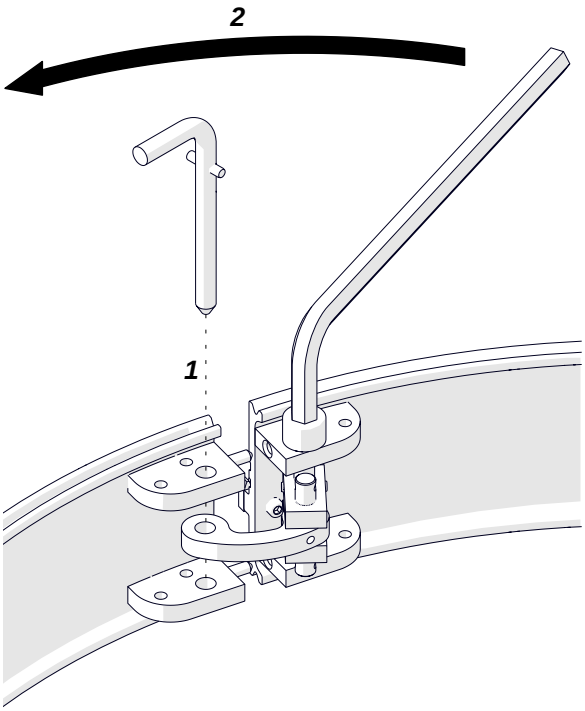


Fig. 4. Connecting the rails of the ring track

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.

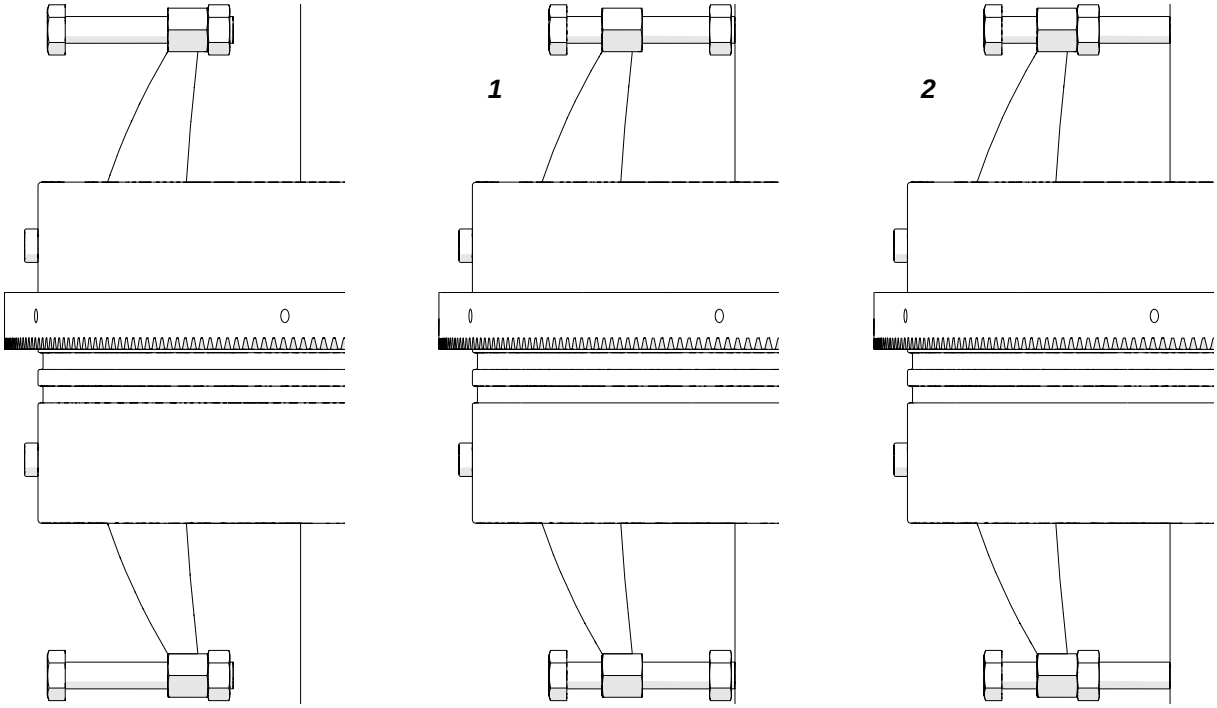


Fig. 5. Attaching the ring track to the workpiece

3.3. Positioning on a straight track

Set the power switch, arc ignition switch, and 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 mounting brackets are on the rail (*4*, *5*).

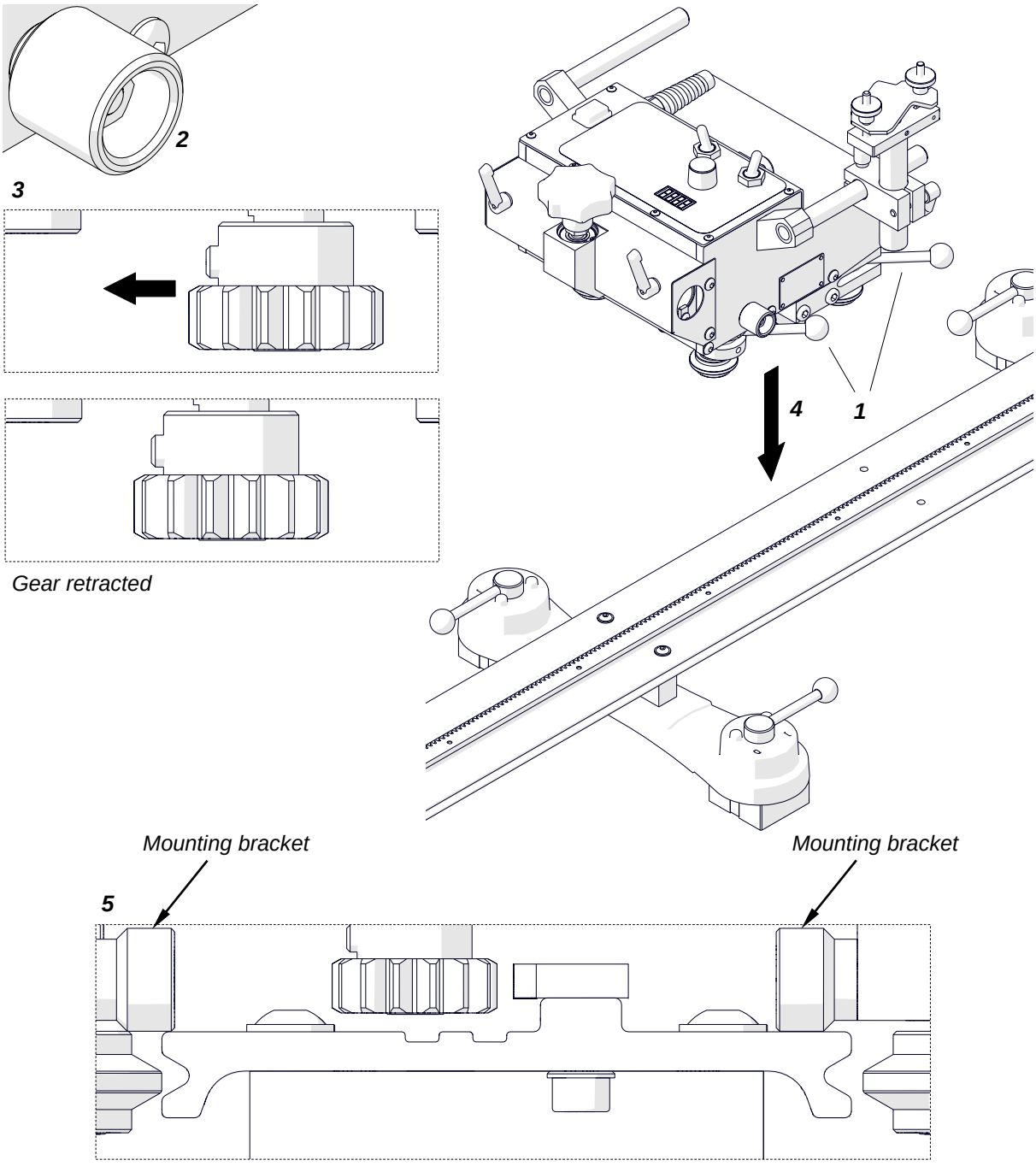


Fig. 6. Putting the carriage on a straight track

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*).

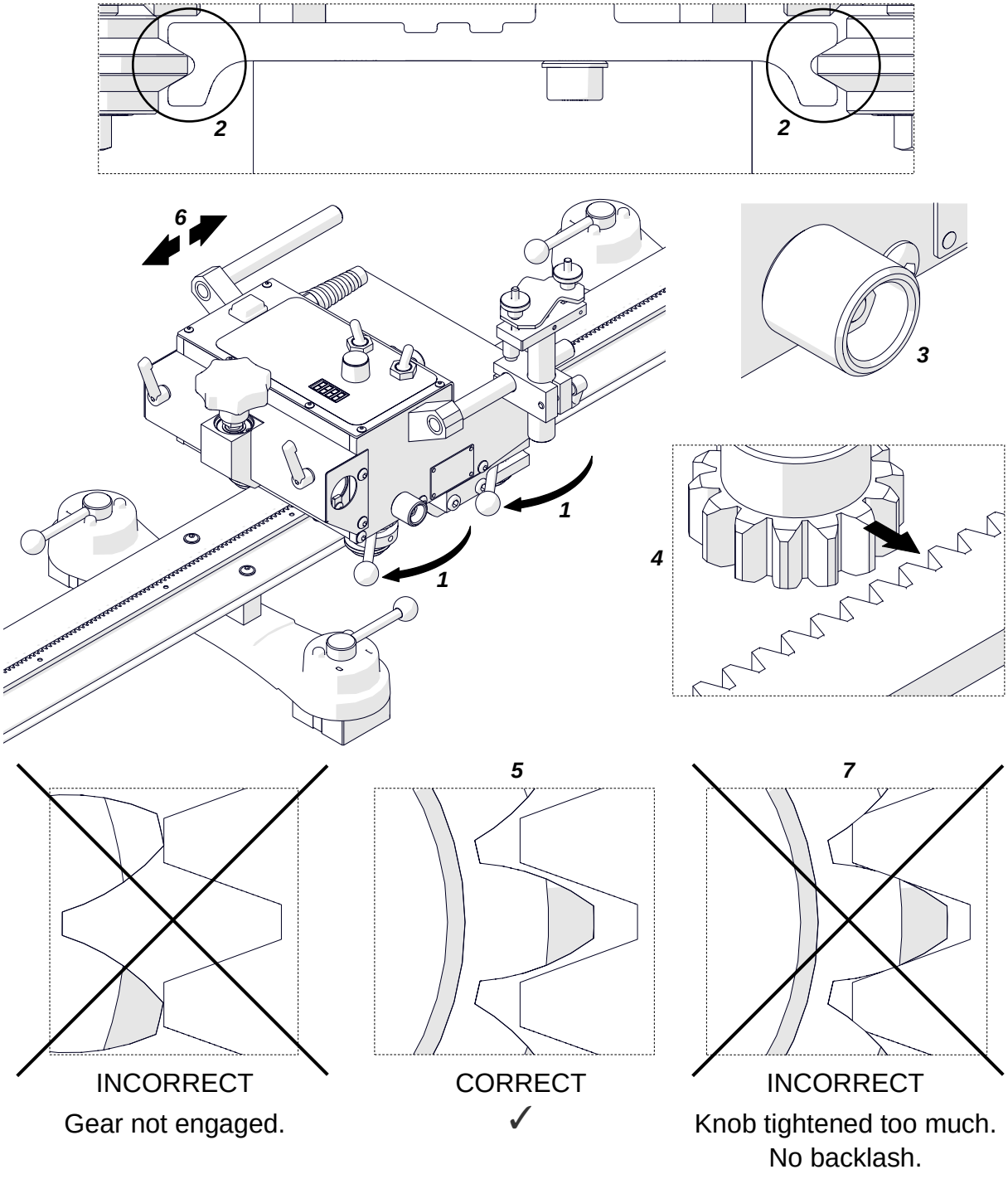


Fig. 7. Installing the carriage on the track

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”.

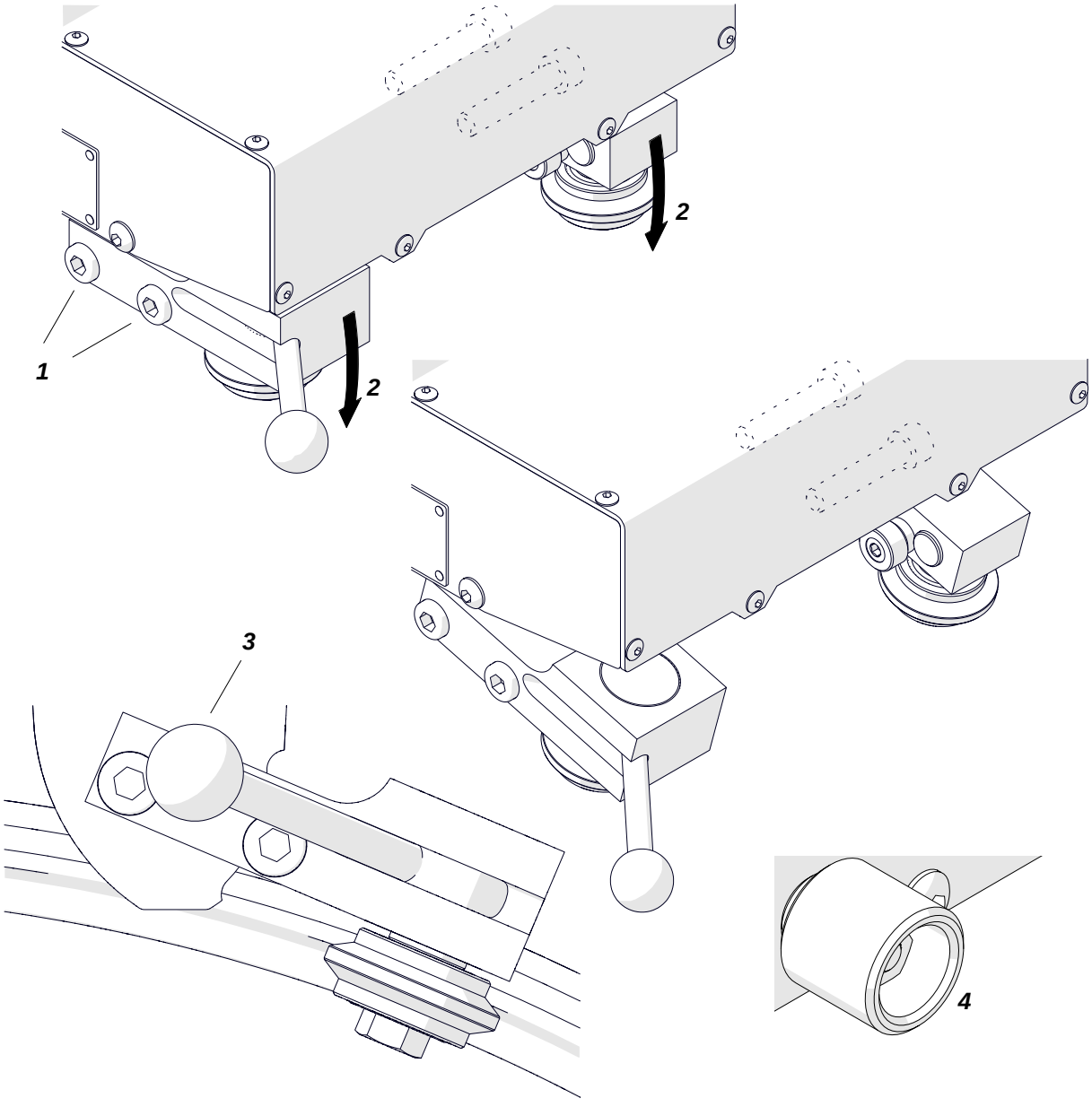
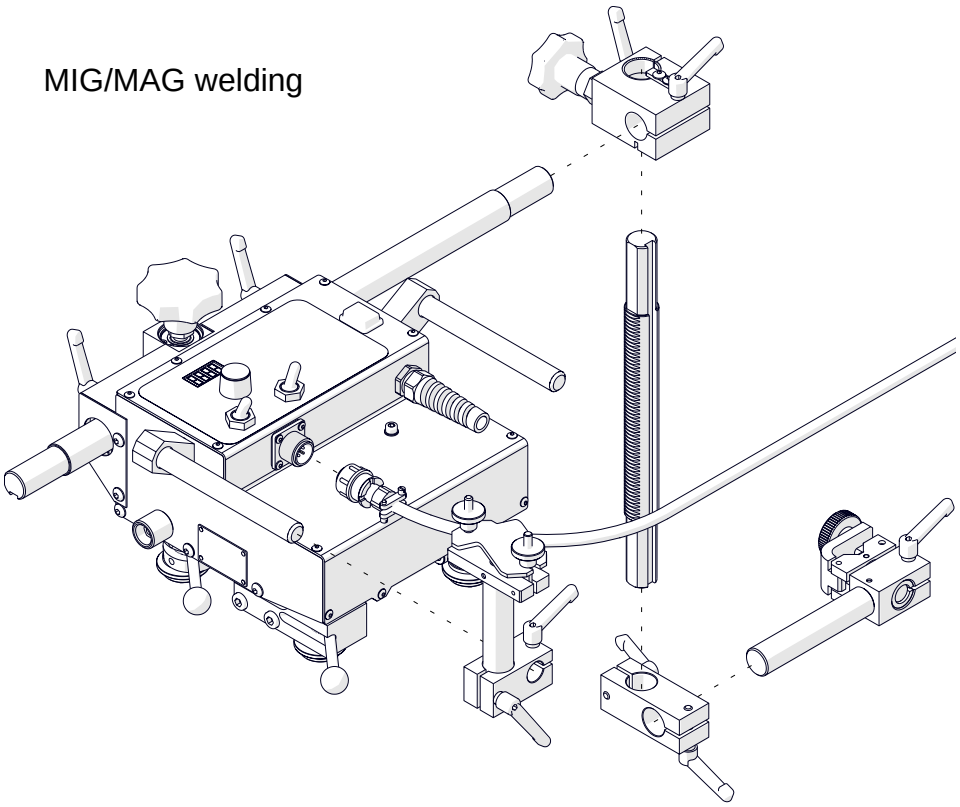


Fig. 8. Rotating the rollers for a curved track

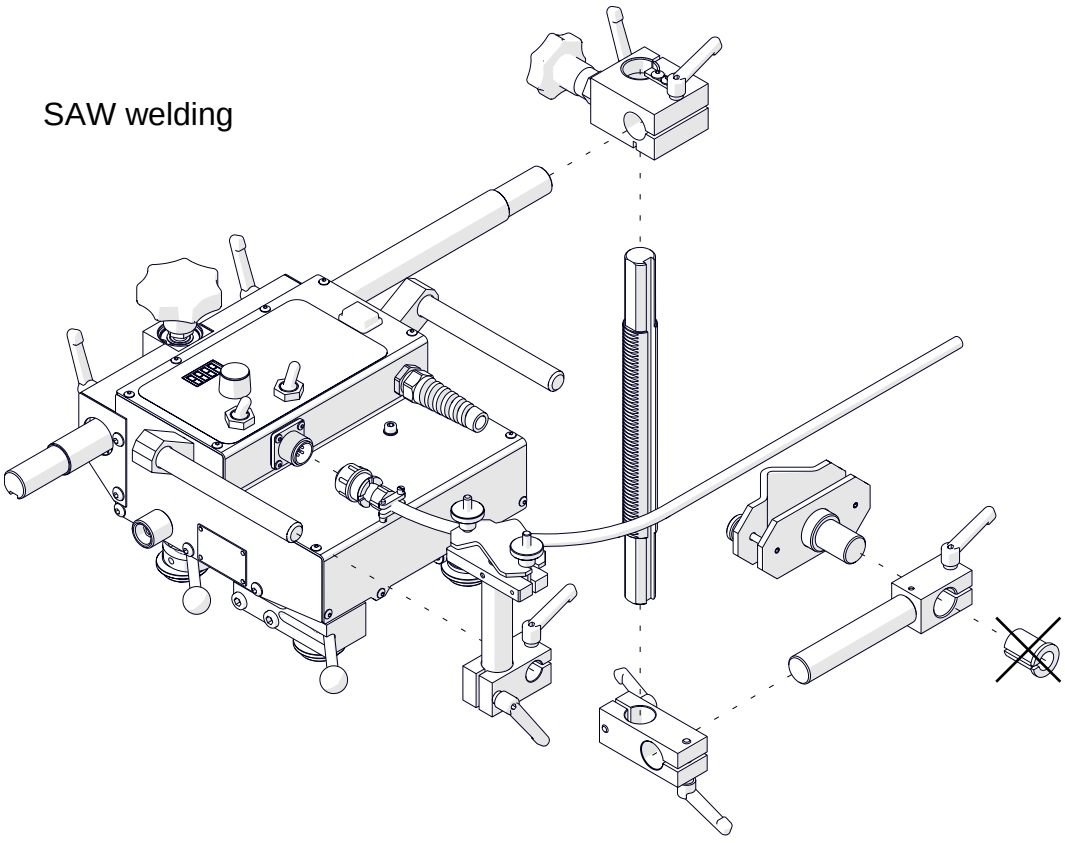
3.5. Preparing

Install an optional welding/cutting set as shown in Fig. 9.

MIG/MAG welding



SAW welding



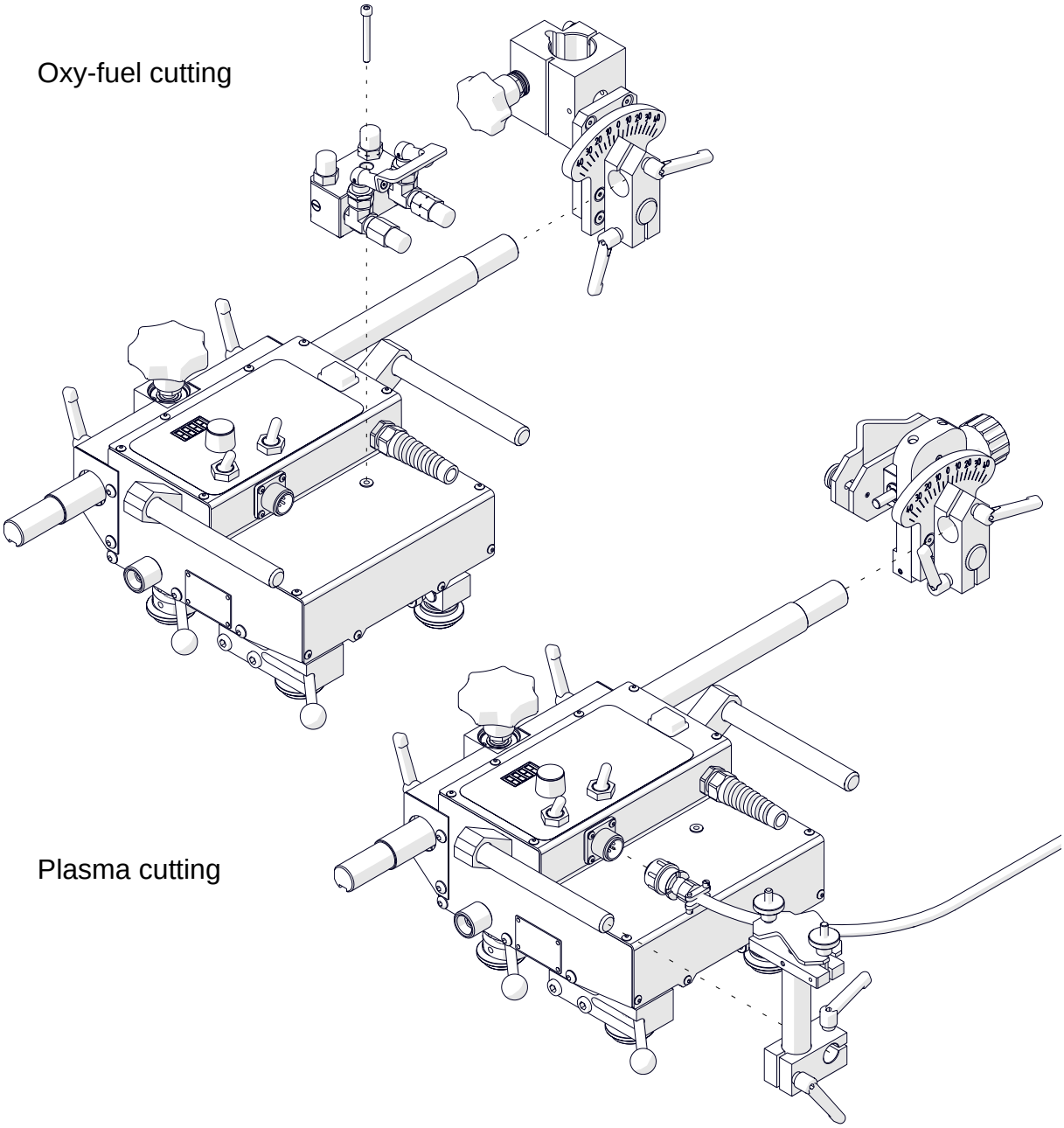


Fig. 9. Installing the welding/cutting set

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 hi-flex, semi-flex 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.

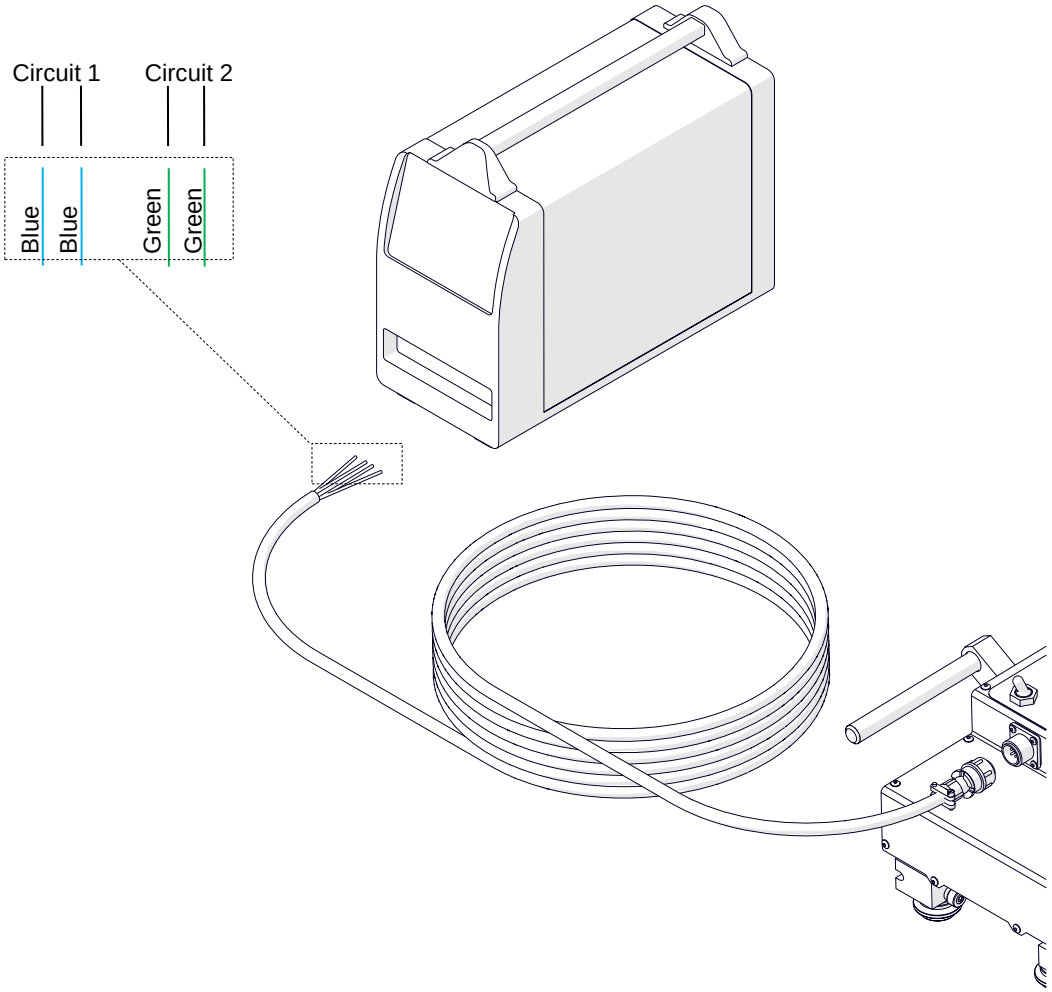


Fig. 10. Connecting the arc ignition cable to welding / plasma cutting circuits

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. Operating

Set the direction switch and arc ignition switch to ‘O’. Next, set the power switch to ‘I’ to turn on the power. Then, the display comes on (8888). Next, if the unit of speed is set to centimeters per minute**,** EUr shows. If the unit is set to inches per minute, USA shows. 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 immediately after you select a travel direction.

Use the 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 direction switch to ‘O’.

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

3.8. Adjusting the pressure of rollers

If the resistance during the travel is too little or too much, loosen the knob (*1*, Fig. 11). 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*).

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

If the carriage moves 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*).

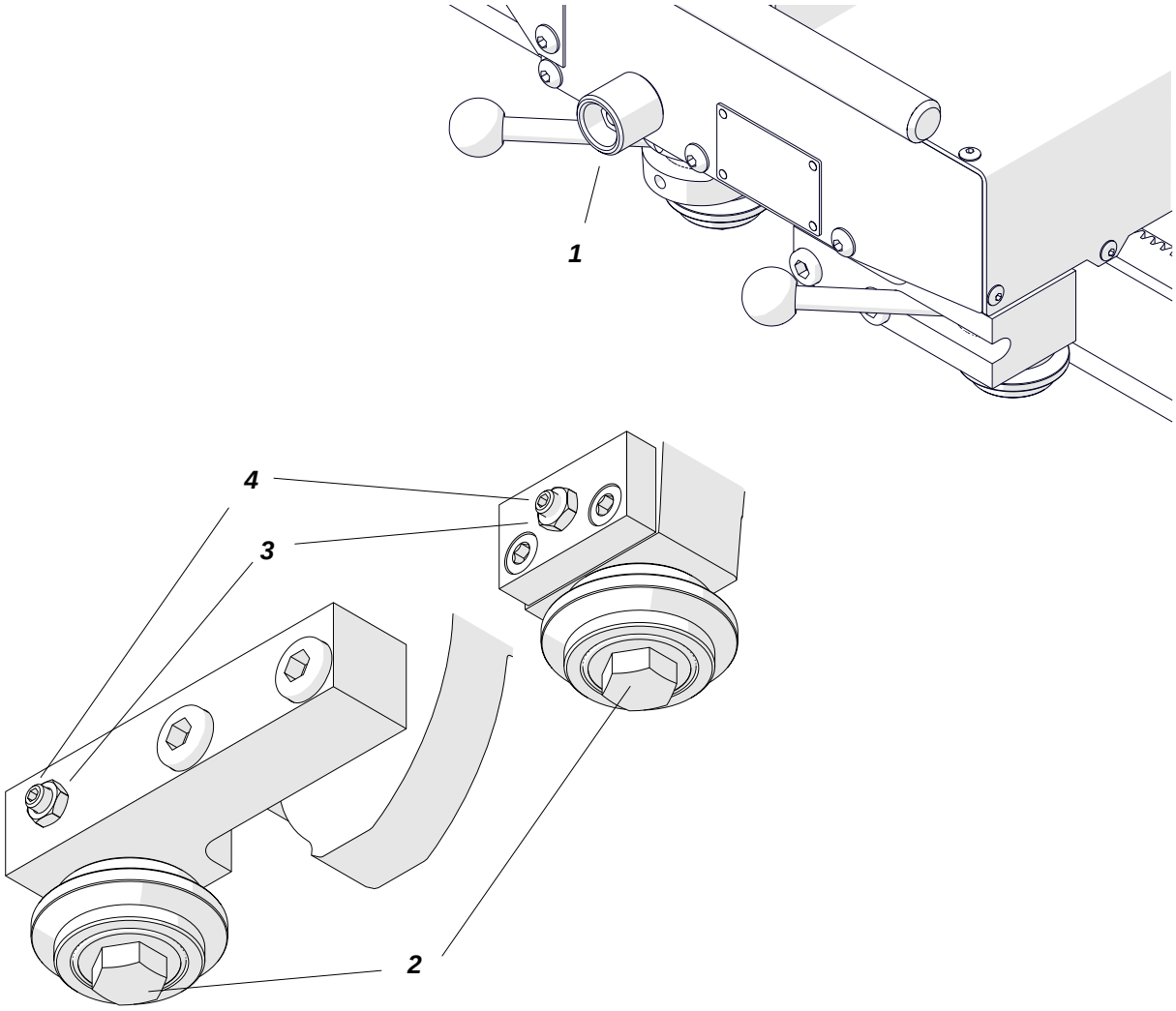
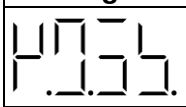
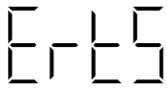


Fig. 11. Adjusting the pressure of rollers

3.9. Troubleshooting

Message	Problem	Solution
	Display not fully on after 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.
	Direction switch not set to ‘O’ when powering.	Set the direction switch to ‘O’. If the message still shows, contact service center for check and repair.
	Shown during travel indicates a malfunction.	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. The carriage stops.	Adjust the position of the cables so that they do not block the carriage. Remove other objects 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

Each day:

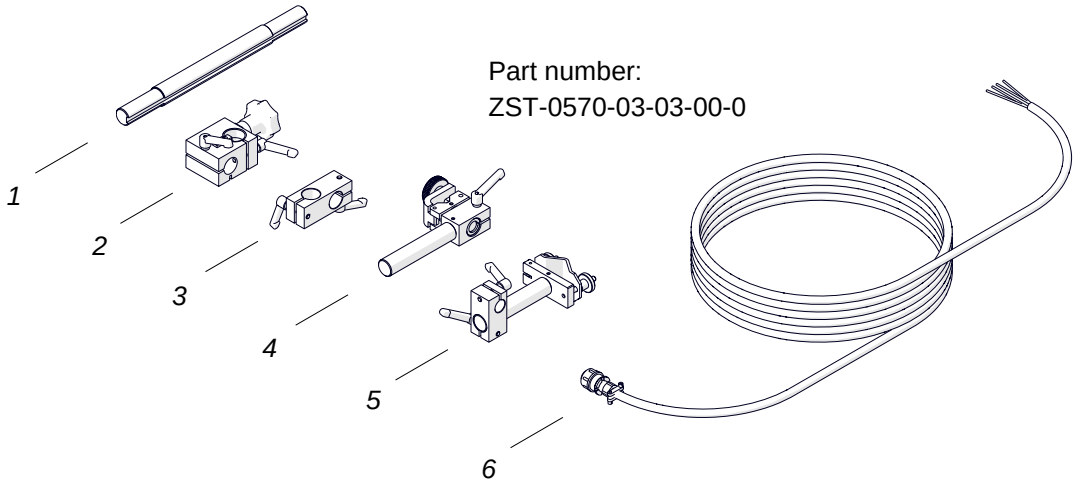
1. Clean the gear of the carriage and the rack of each rail.
2. Clean the rollers. Make sure that the rollers rotate freely.
3. Clean the torch nozzle and replace if damaged.

Each month:

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

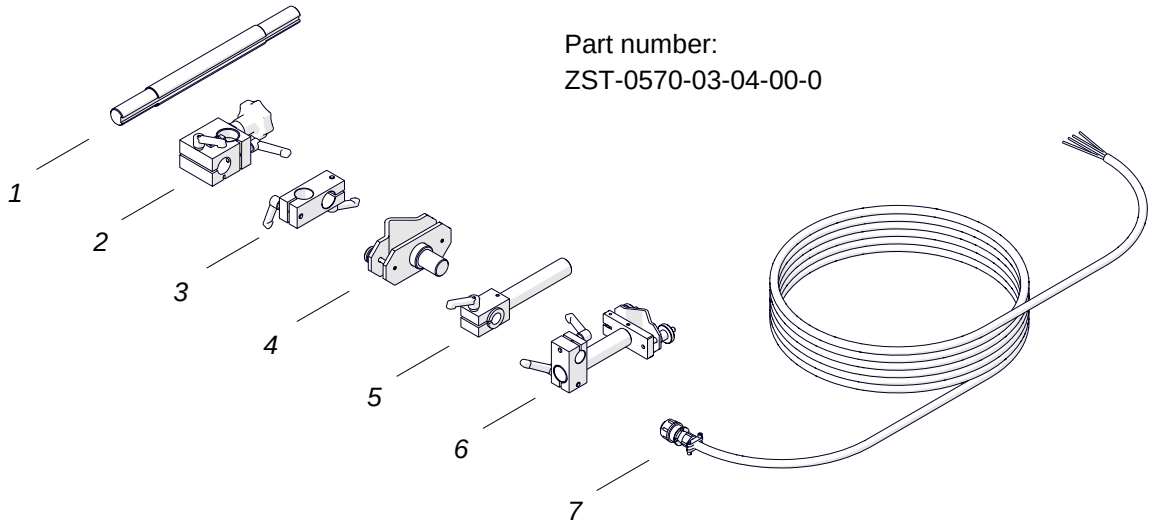
5. ACCESSORIES

5.1. MIG/MAG welding set



1	300 mm (12″) rack with 180 mm (7″) adjustment	1 unit
2	Rack holder	1 unit
3	Clamping block with levers	1 unit
4	Short rod torch holder with clamp 16–22 mm (0.63–0.87″)	1 unit
5	Cable anchor	1 unit
6	6.5 m (21 ft) arc ignition cable	1 unit

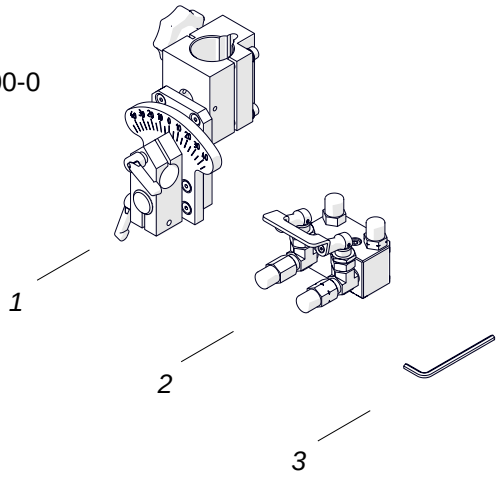
5.2. SAW welding set



1	300 mm (12″) rack with 180 mm (7″) adjustment	1 unit
2	Rack holder	1 unit
3	Clamping block with levers	1 unit
4	Cutting torch clamp 28–35 mm (1.10–1.38″)	1 unit
5	Short rod	1 unit
6	Cable anchor	1 unit
7	6.5 m (21 ft) arc ignition cable	1 unit

5.3. Oxy-fuel cutting set

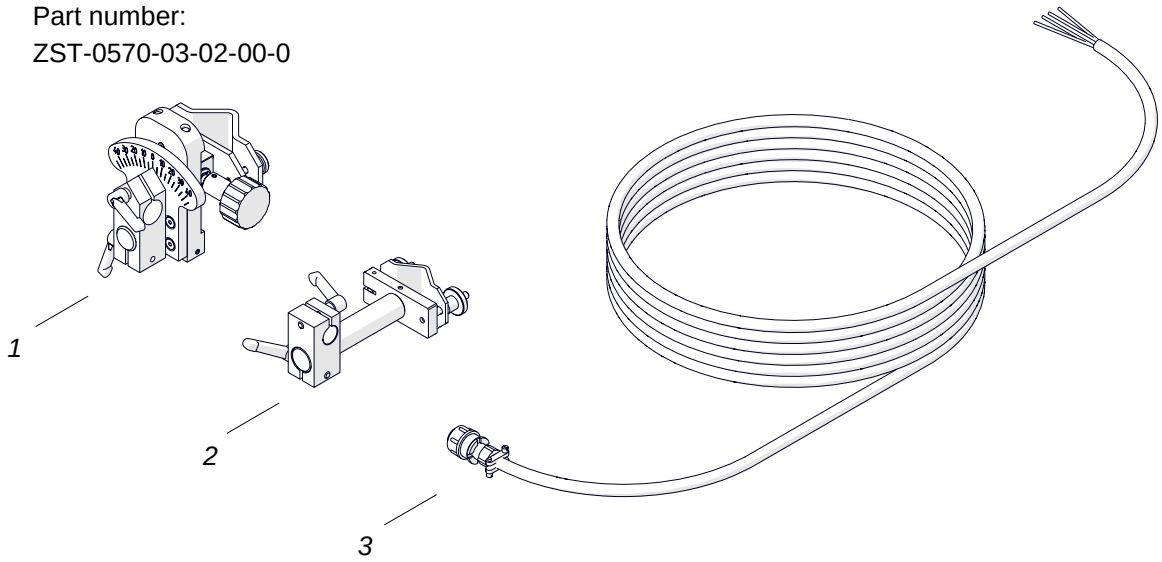
Part number:
ZST-0570-03-01-00-0



1	Precise machine torch holder 35 mm (1.38″)	1 unit
2	2/2 gas manifold with cut-off valve (imperial)	1 unit
3	4 mm hex wrench	1 unit

5.4. Plasma cutting set

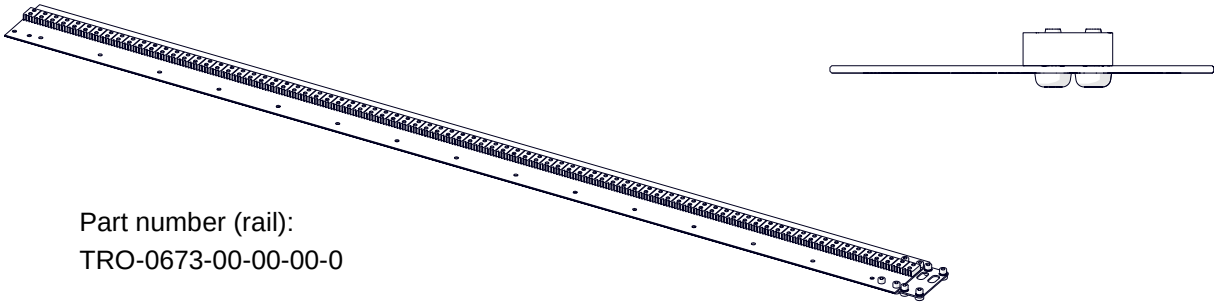
Part number:
ZST-0570-03-02-00-0



1	Precise torch holder 28–35 mm (1.10–1.38″)	1 unit
2	Cable anchor	1 unit
3	6.5 m (21 ft) arc ignition cable	1 unit

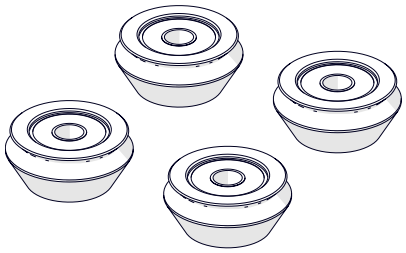
5.5. Hi-flex track

Allows guiding the carriage along a curve. The length of a single rail is 1.52 m (5 ft). The minimum bend radius is 0.75 m (2.5 ft). Use with 8 magnetic units or 8 narrow magnetic units. If you need to use more units, use narrow magnetic units.

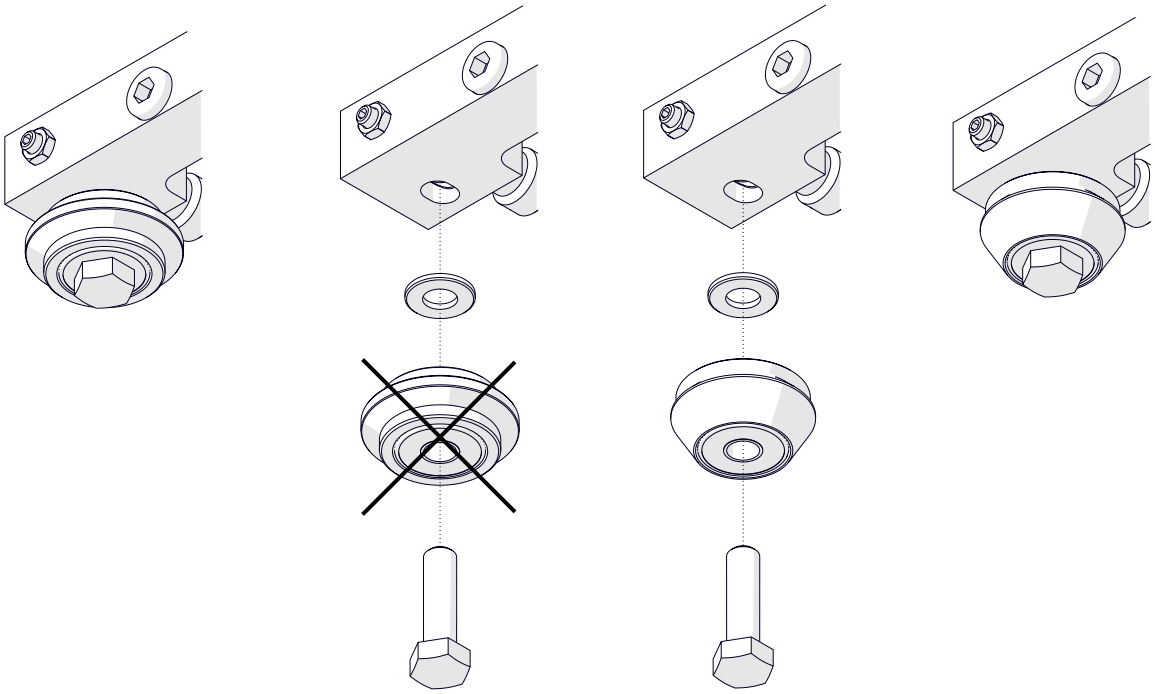


Part number (rail):
TRO-0673-00-00-00-0

Part number (rollers for hi-flex track):
ZSP-0673-07-00-00-0

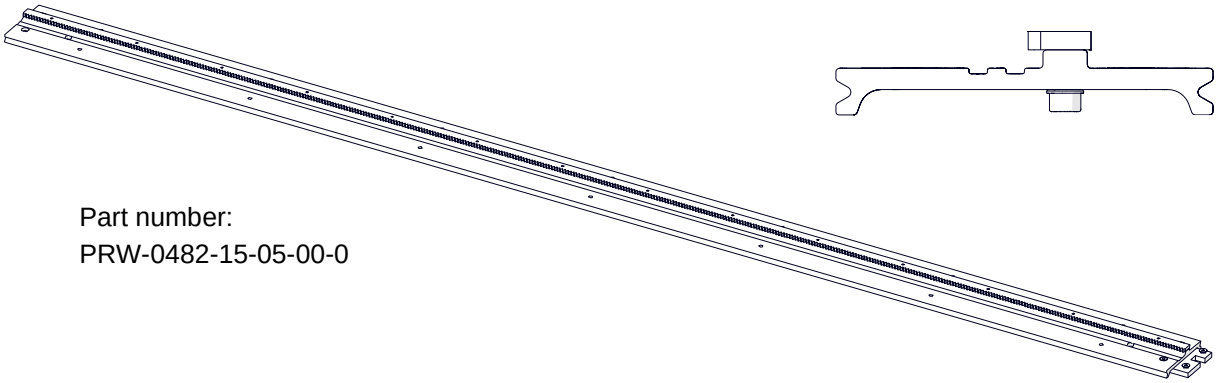


Use the 13 mm flat wrench to remove the standard rollers and install the rollers for hi-flex track.



5.6. Semi-flex track

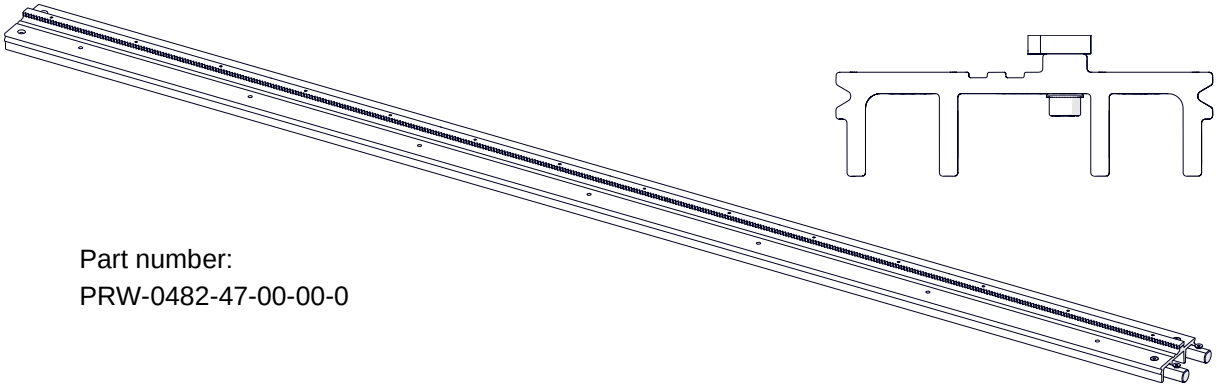
Allows guiding the carriage along a curve. The length of a single rail is 2 m (6.5 ft). The minimum bend radius is 5 m (16.5 ft).



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

5.7. Rigid track

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

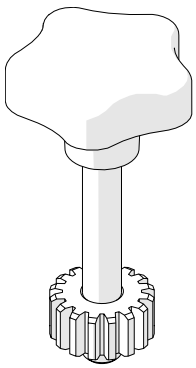


Part number:
PRW-0482-47-00-00-0

5.8. Rack adjustment tool

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

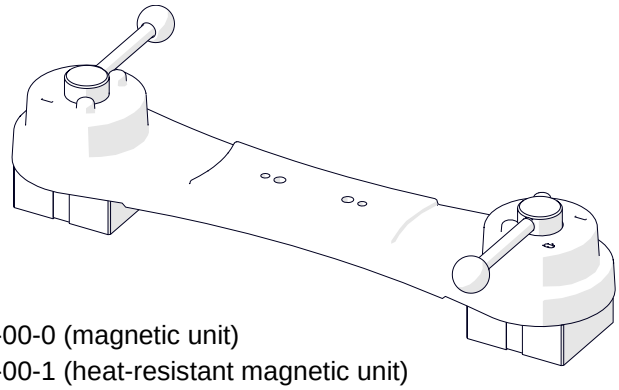
Part number:
PKT-0341-13-00-00-0



5.9. Magnetic units

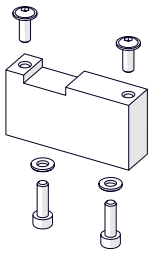
5.9.1. Magnetic unit

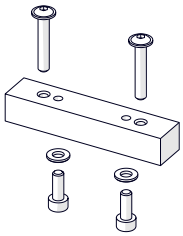
Allows clamping a hi-flex, semi-flex, or rigid track to ferromagnetic surfaces.



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

Part number (bracket for hi-flex and semi-flex track):
DYS-0482-19-00-00-0

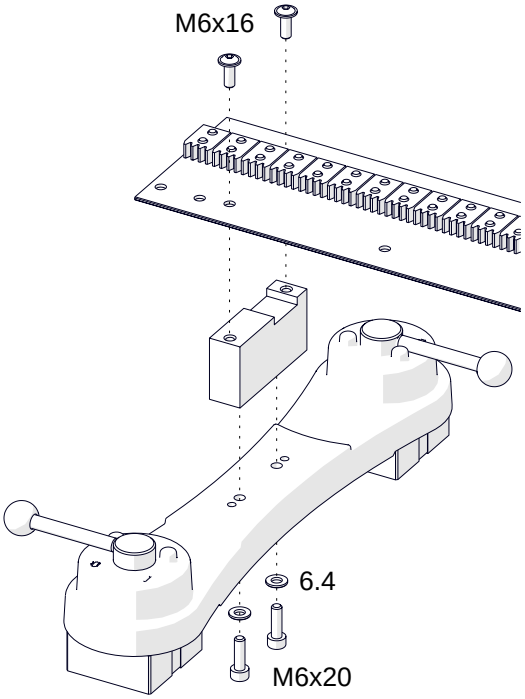


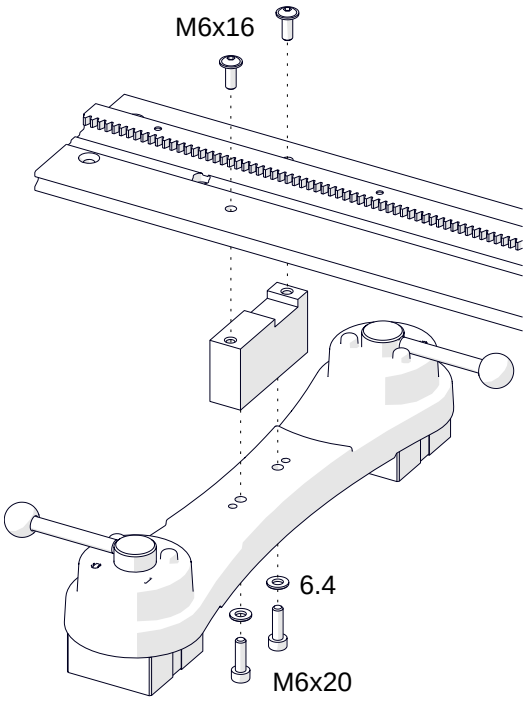


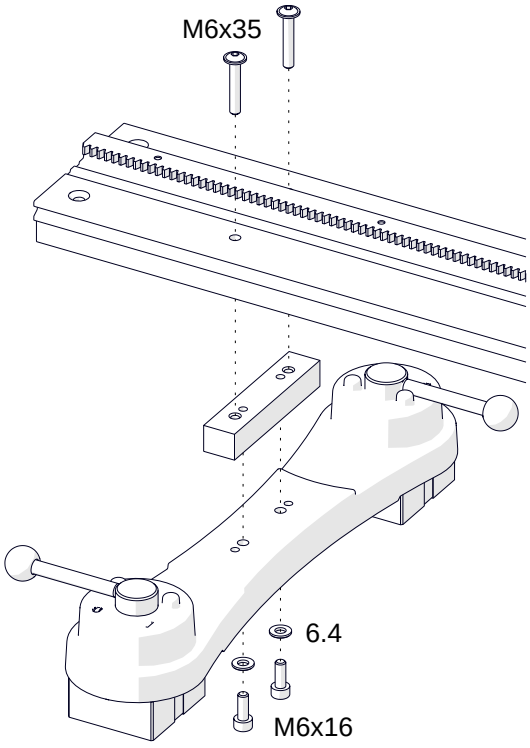
Part number (bracket for rigid track):
DYS-0482-21-00-00-0

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

Use the 4 mm hex wrench to attach the unit to the tracks as shown in the figures.


M6x16
6.4
M6x20

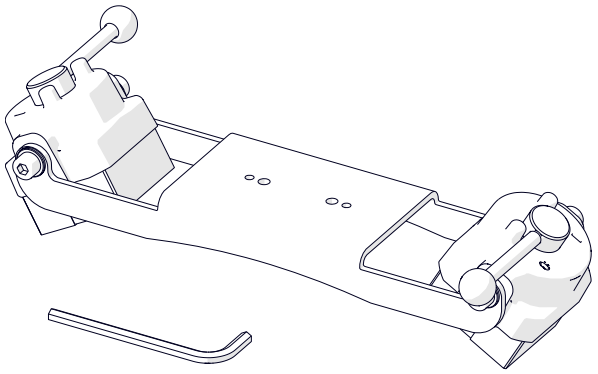

M6x16
6.4
M6x20


M6x35
6.4
M6x16

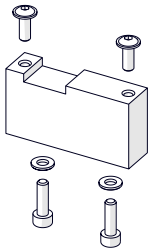
5.9.2. Pivoting magnetic unit

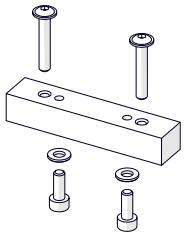
Allows clamping a hi-flex, semi-flex, or rigid track to ferromagnetic surfaces that are concave or convex, to pipes with outer diameters of at least 800 mm (31.5″), and to surfaces that differ in height up to 80 mm (3.1″).

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

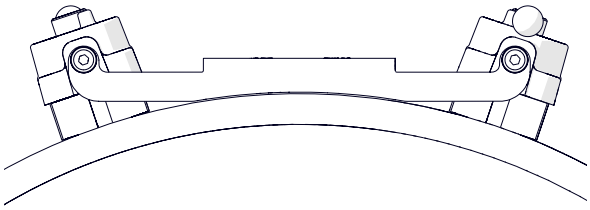


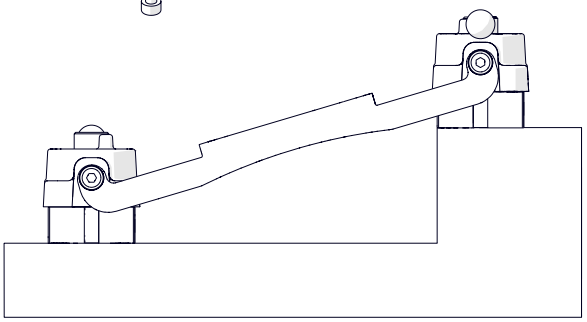
Part number (bracket for hi-flex and semi-flex track):
DYS-0482-19-00-00-0





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





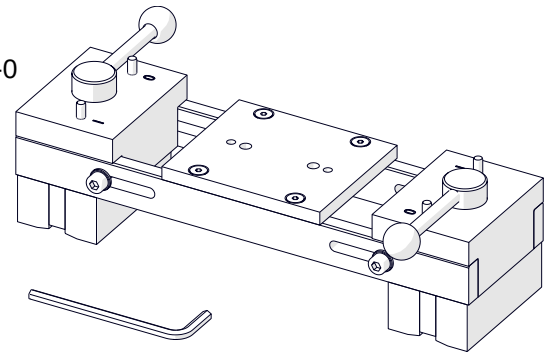
Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1200 N)	20°C (68°F)
75% (900 N)	80°C (176°F)
50% (600 N)	120°C (248°F)

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.

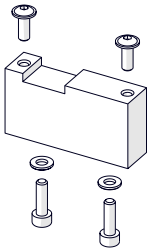
5.9.3. Spacing-adjustable magnetic unit

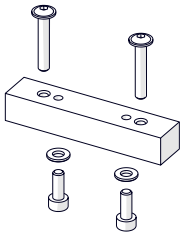
Allows clamping a hi-flex, semi-flex, or rigid track to two ferromagnetic pipes with diameters of 25–230 mm (1–9″) and with distance between pipe axes of 170–230 mm (6.7–9.1″).

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

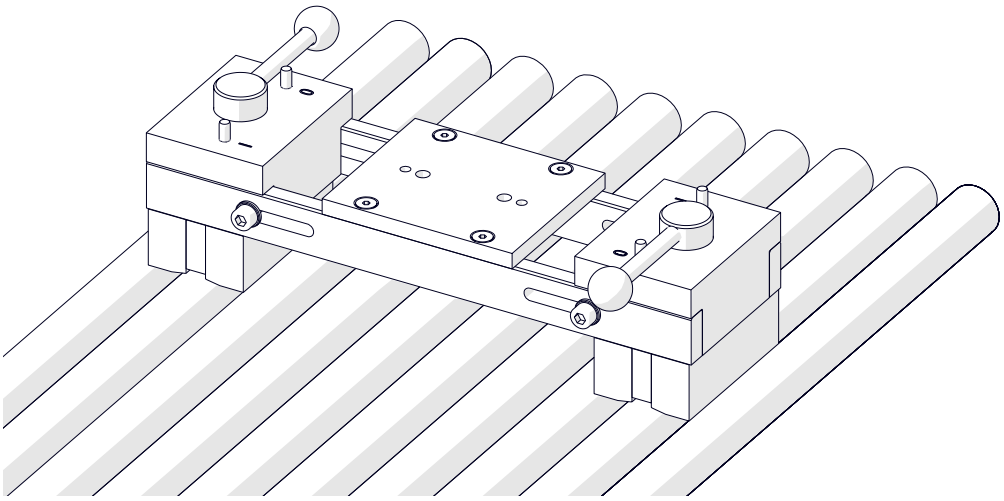


Part number (bracket for hi-flex and semi-flex track):
DYS-0482-19-00-00-0





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



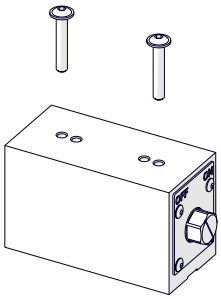
Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1200 N)	20°C (68°F)
75% (900 N)	80°C (176°F)
50% (600 N)	120°C (248°F)

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

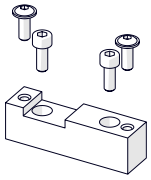
5.9.4. Narrow magnetic unit

Allows clamping a hi-flex, semi-flex, or rigid track to ferromagnetic surfaces.

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

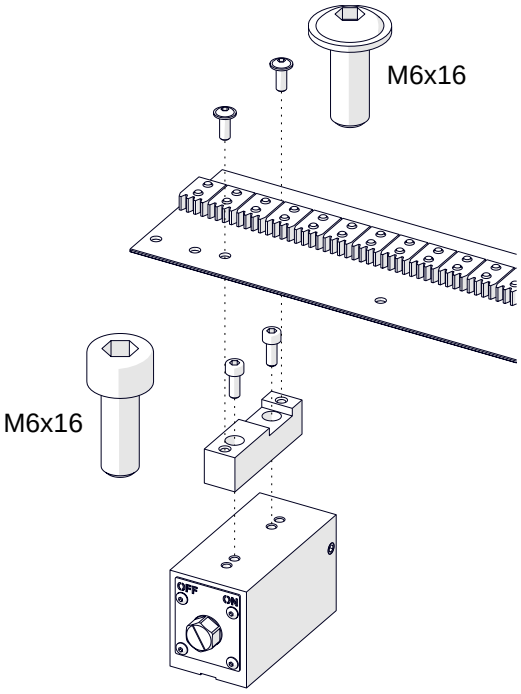


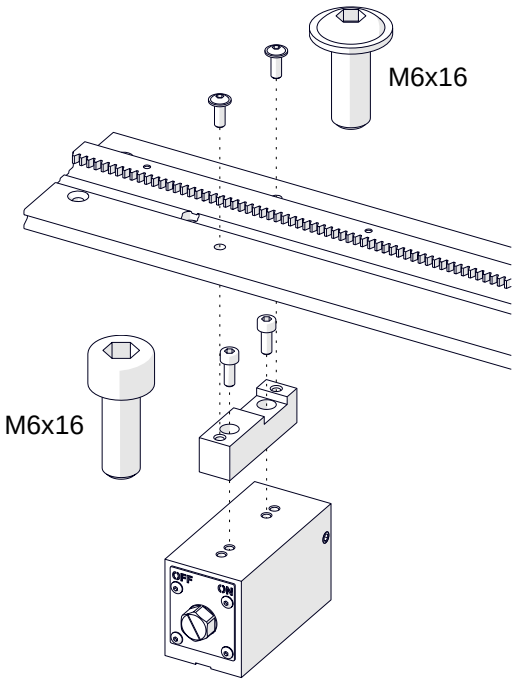
Part number (bracket for hi-flex and semi-flex track):
DYS-0582-10-00-00-0

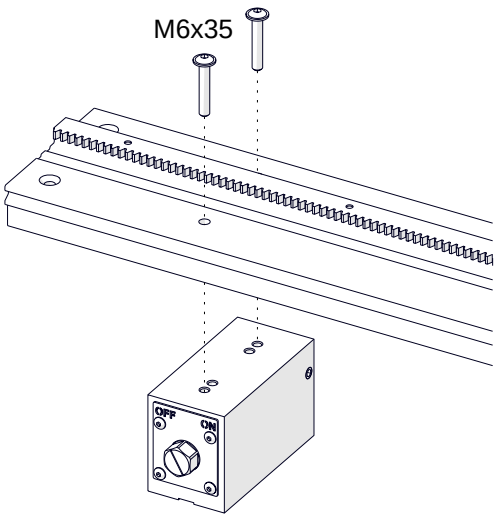


Holding force on a 5 mm (0.2″) thick surface	Temperature
100% (1000 N)	20°C (68°F)
75% (750 N)	80°C (176°F)
50% (500 N)	120°C (248°F)

Use the 4 mm hex wrench to attach the unit to the tracks as shown in the figures.





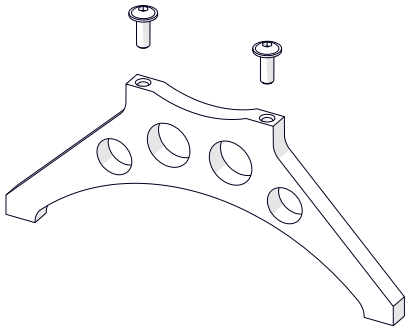


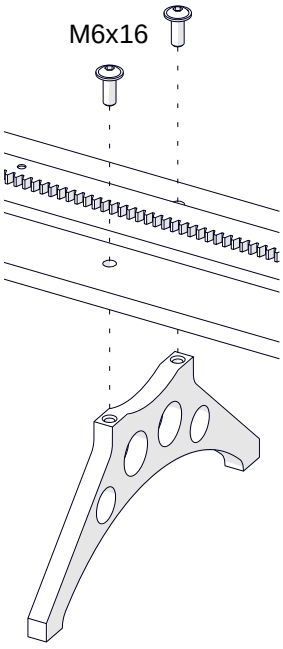
To clamp the unit to the surface, use the 17 mm flat wrench (not included) and set the side screw to ON.

5.10. Semi-flex track support

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

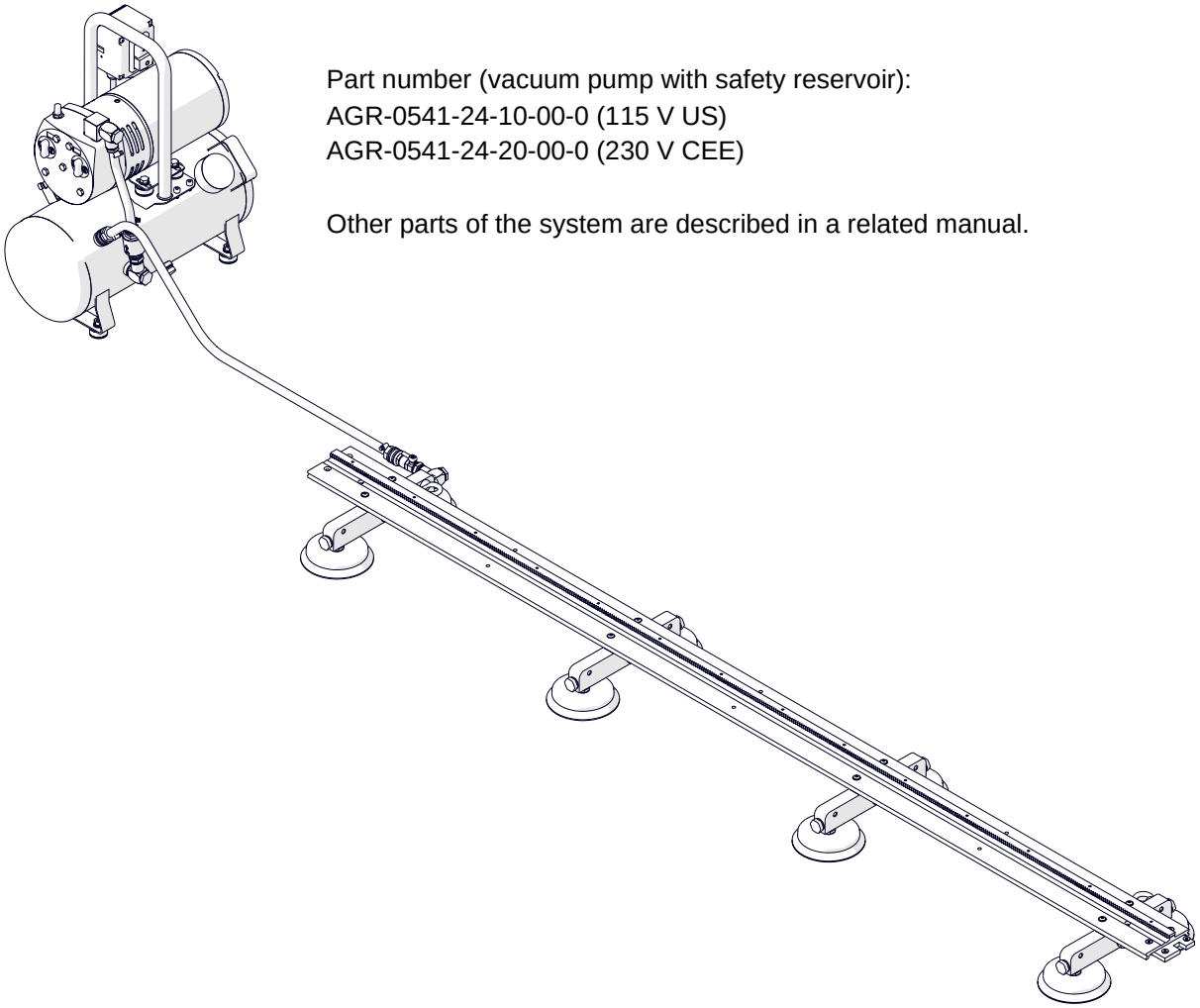
Part number:
WSP-0523-12-01-00-1





5.11. Vacuum track system

Dedicated to clamping the track to non-ferromagnetic surfaces.

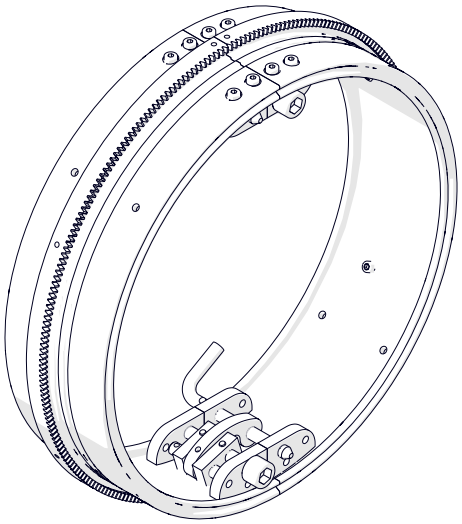


Part number (vacuum pump with safety reservoir):
AGR-0541-24-10-00-0 (115 V US)
AGR-0541-24-20-00-0 (230 V CEE)

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

5.12. Ring tracks

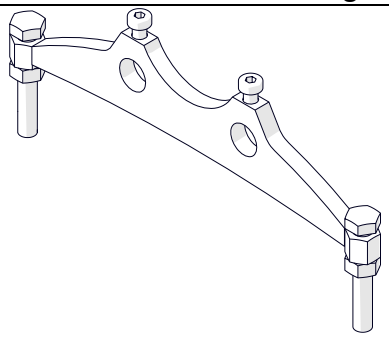
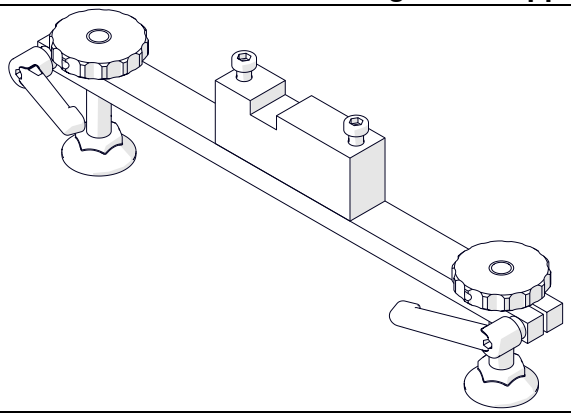
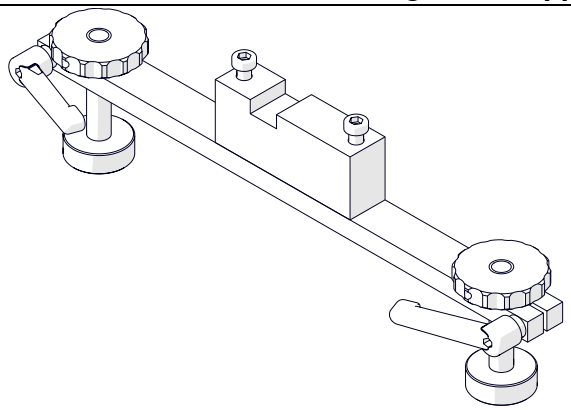
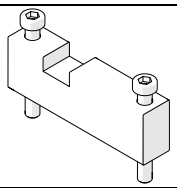
Allow welding of round workpieces with the outer diameters from 200 mm (8″) to 3000 mm (120″). Clamped to the workpiece with supports. You can use brackets to clamp the track to workpieces with diameters smaller by 50 mm. The tracks consist of two, three, or four rails. Tracks not shown in the table are available on request.



Workpiece outer diameter (without brackets)		**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

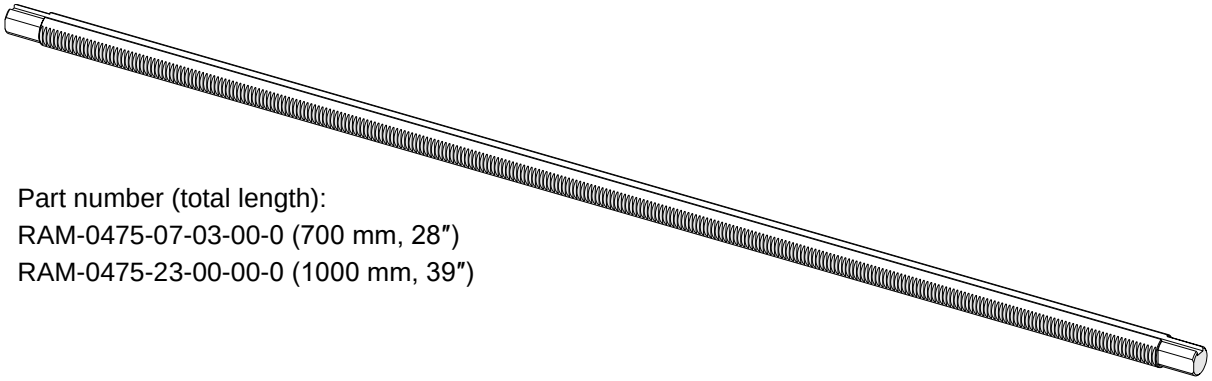
Workpiece outer diameter (without brackets)		Part number	Rails	Ring track supports required
Min. [mm]	**Max.** [mm]			
1200	1250	TRO-0523-39-00-00-0	3	9
1250	1300	TRO-0523-40-00-00-0	3	9
1300	1350	TRO-0523-41-00-00-0	3	12
1350	1400	TRO-0523-42-00-00-0	3	12
1400	1450	TRO-0523-43-00-00-0	3	12
1450	1500	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

5.13. Ring track supports and bracket

Ring track support with bolts	
	Part number: WSP-0523-14-02-00-0
Ring track support with plastic feet	
	Part number: WSP-0523-14-11-00-0
Ring track support with magnets	
	Part number: WSP-0523-14-12-00-0
Ring track bracket	
	Part number: DYS-0523-14-14-00-0

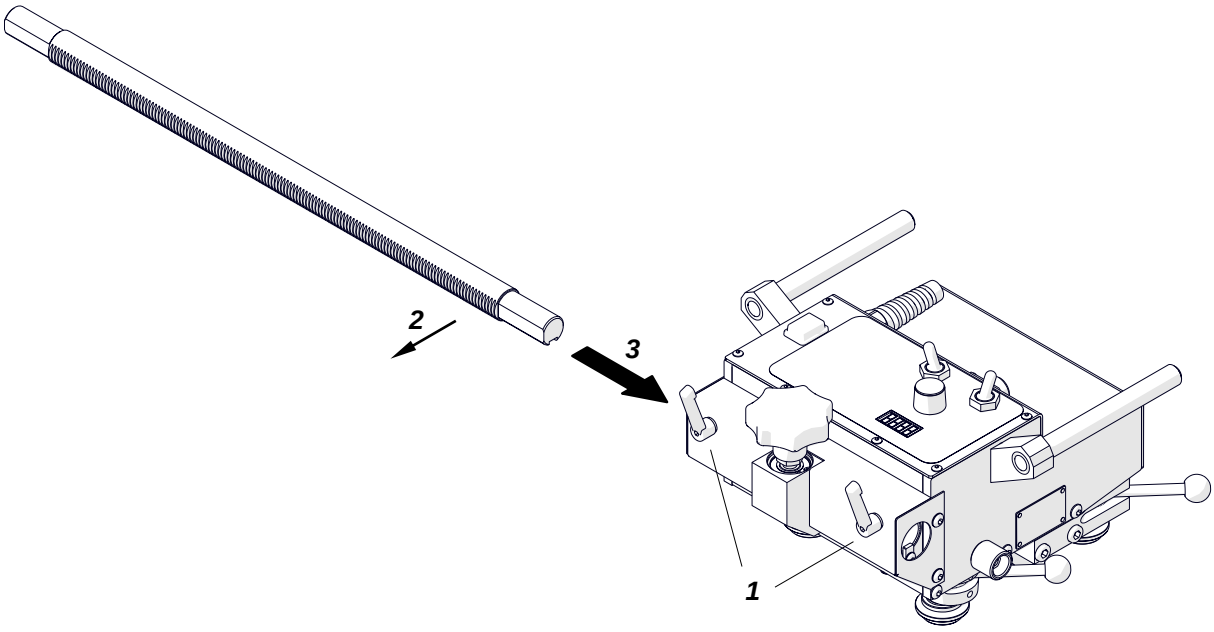
5.14. Rack

Changes the horizontal or vertical reach of the torch holder.

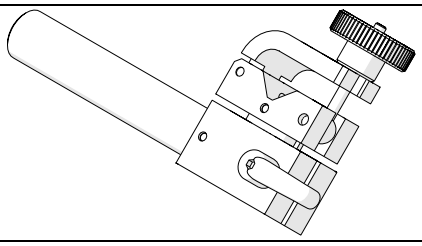
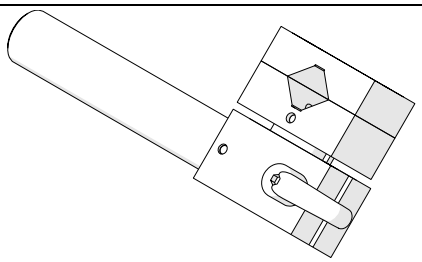
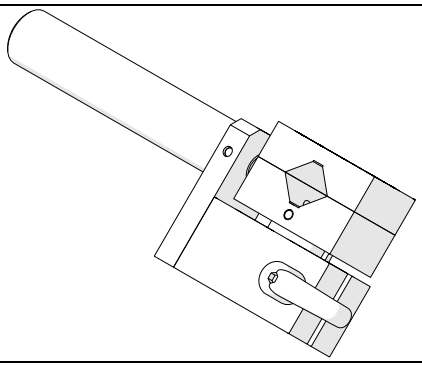
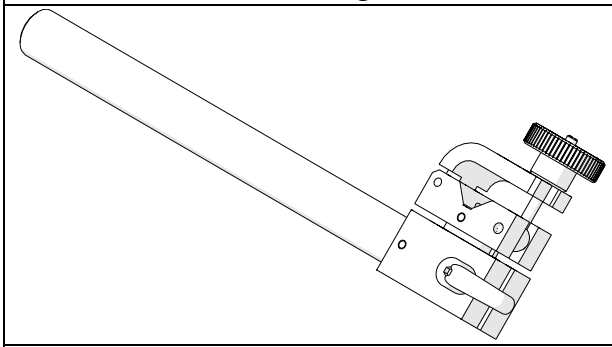
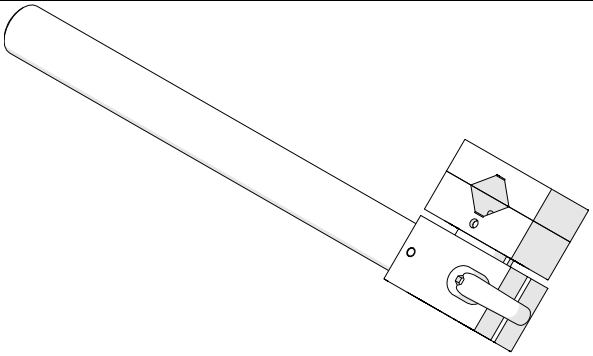


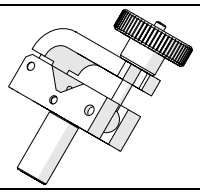
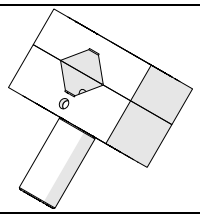
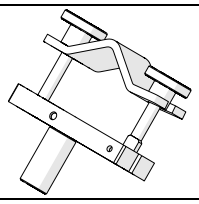
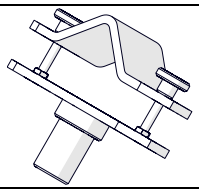
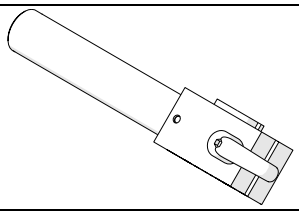
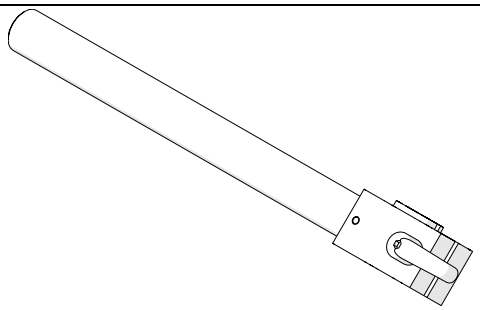
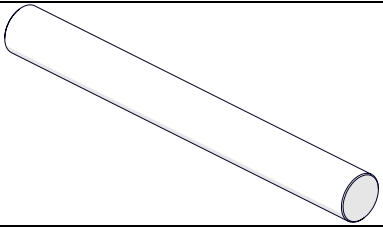
Part number (total length):
RAM-0475-07-03-00-0 (700 mm, 28″)
RAM-0475-23-00-00-0 (1000 mm, 39″)

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



5.15. Torch holders, clamps, and rods

Short rod torch holder with clamp 16–22 mm	
	Part number: UCW-0476-20-00-00-0
Short rod torch holder with clip 16–22 mm	
	Part number: UCW-0476-27-00-00-0
Short low rod torch holder with clip 16–22 mm	
	Part number: UCW-0476-06-00-00-0
Long rod torch holder with clamp 16–22 mm	
	Part number: UCW-0466-04-00-00-0
Long rod torch holder with clip 16–22 mm	
	Part number: UCW-0466-22-00-00-0

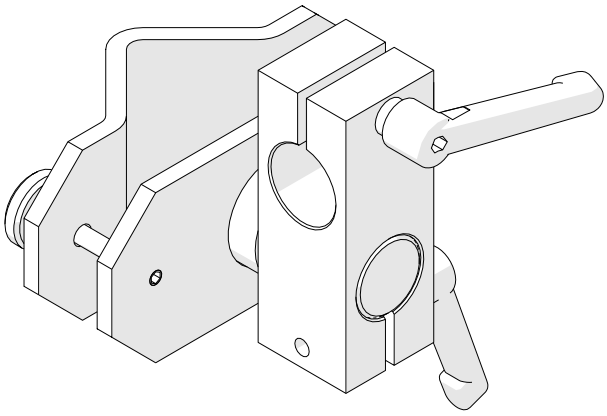
Torch clamp 16–22 mm	
	Part number: ZRZ-0466-04-01-00-0
Torch clip 16–22 mm	
	Part number: ZCS-0476-06-01-00-0
Torch clamp 22–35 mm	
	Part number: ZRZ-0466-19-00-00-0
Torch clamp 28–35 mm for SAW welding	
	Part number: ZCS-0475-28-10-00-0
Short rod	
	Part number: WLK-0476-20-01-00-0
Long rod	
	Part number: WLK-0466-04-10-00-0
Rod for cutting	
	Part number: KLM-0236-00-16-00-0

5.16. Cutting torch holders

5.16.1. Standard torch holder

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

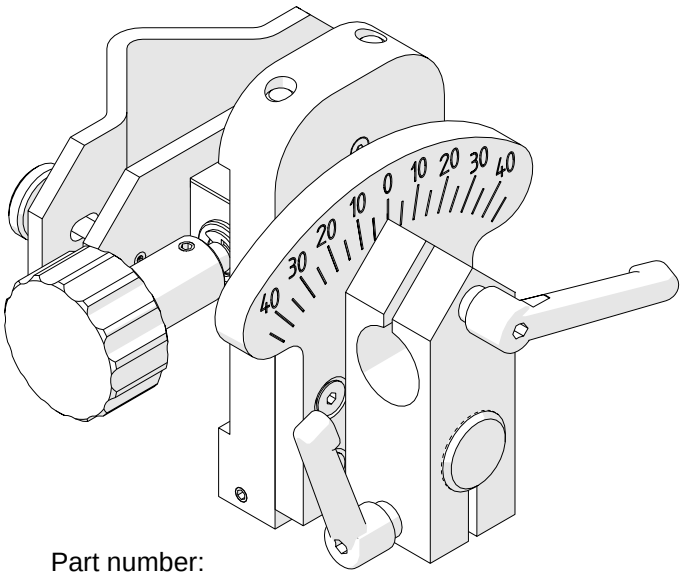


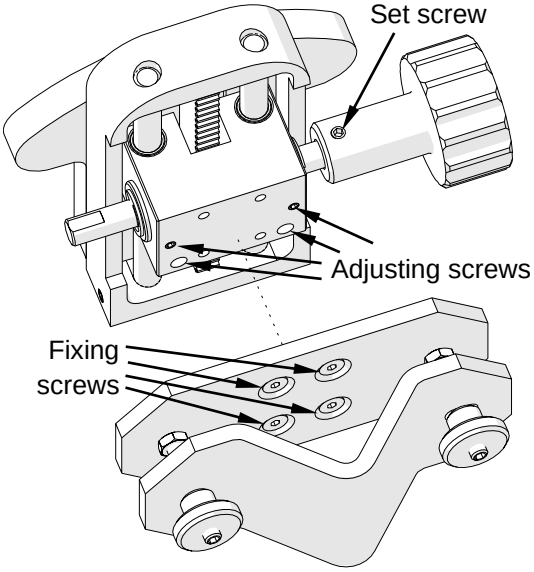
5.16.2. Precise torch holder

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 travel, use the 2.5 mm hex wrench to remove the fixing screws. Then, use the 2 mm hex wrench to rotate the adjusting screws.



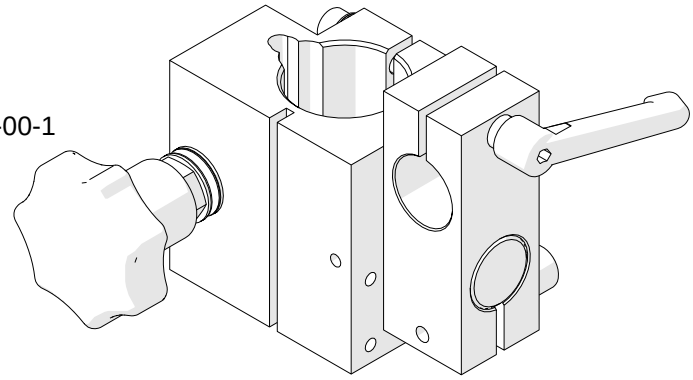


Part number:
UCW-0475-08-00-00-0

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

For torches with the diameter of 35 mm (1.38″) that have a rack. Allows adjustment of the vertical position of the torch by using the knob and rough adjustment of the angle.

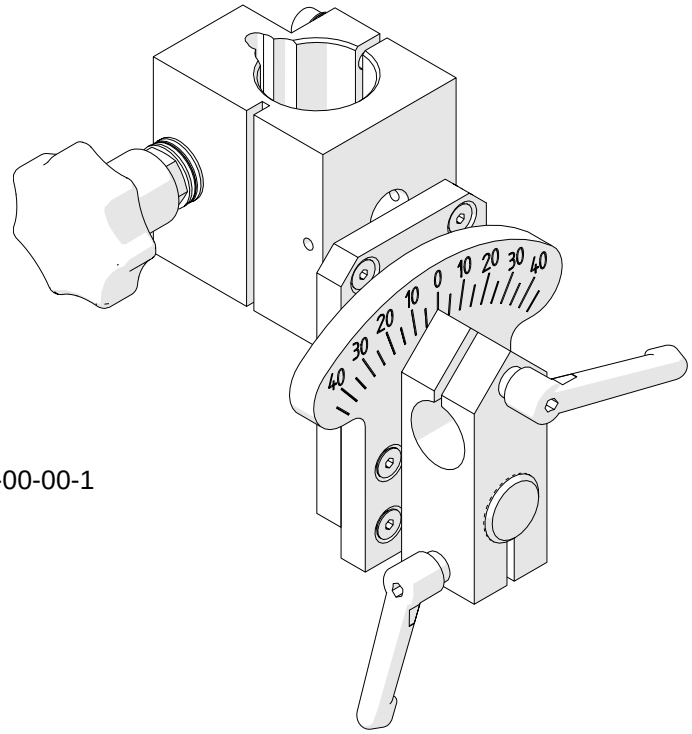
Part number:
UCW-0475-29-00-00-1



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

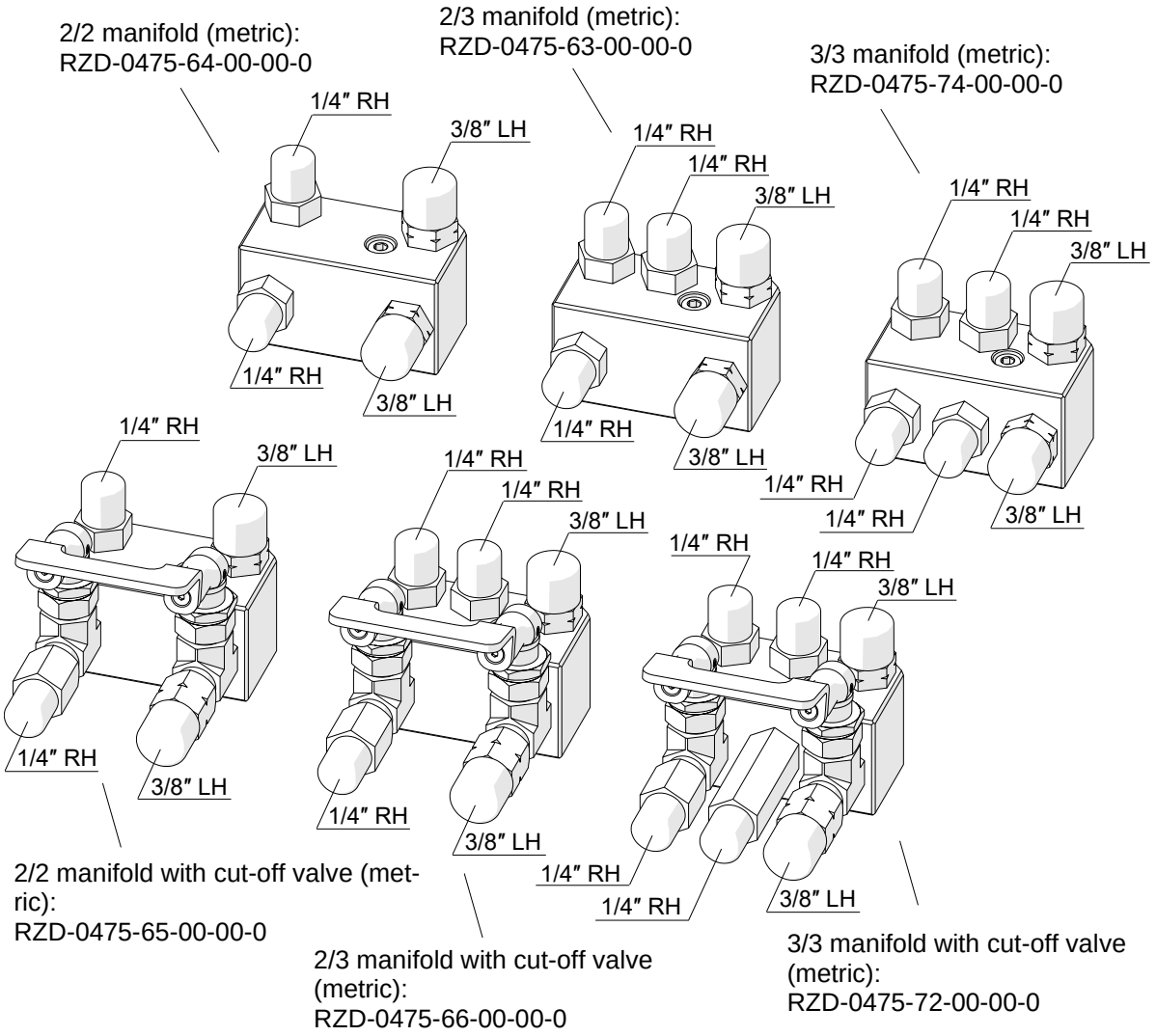
For torches with the diameter of 35 mm (1.38″) that have a rack. Allows adjustment of the vertical position of the torch by using the knob and precise adjustment of the angle.

Part number:
UCW-0475-42-00-00-1

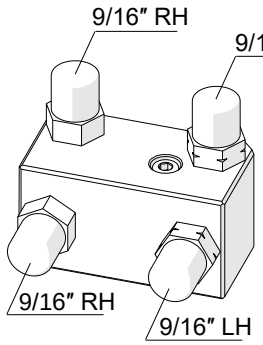


5.17. Gas manifold (for oxy-fuel cutting)

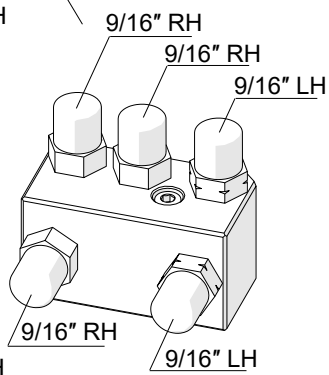
Provides safe gas delivery to 2- or 3-hose torches. Manifolds are available with or without gas cut-off valve in both metric and imperial versions.



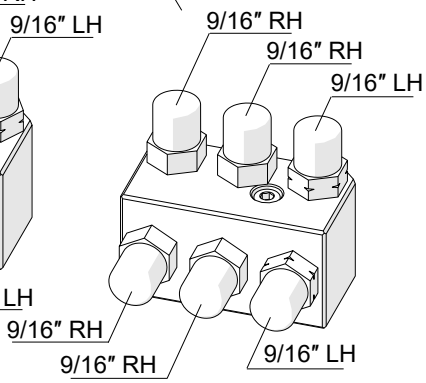
2/2 manifold (imperial):
RZD-0475-68-00-00-0

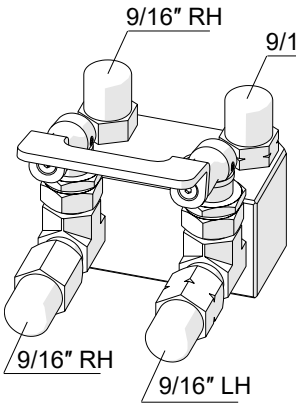


2/3 manifold (imperial):
RZD-0475-67-00-00-0

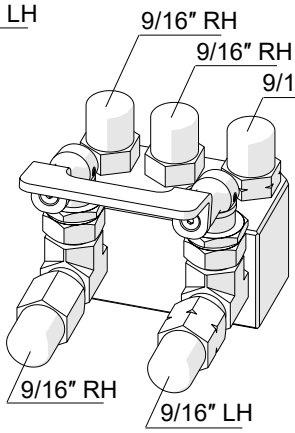


3/3 manifold (imperial):
RZD-0475-73-00-00-0

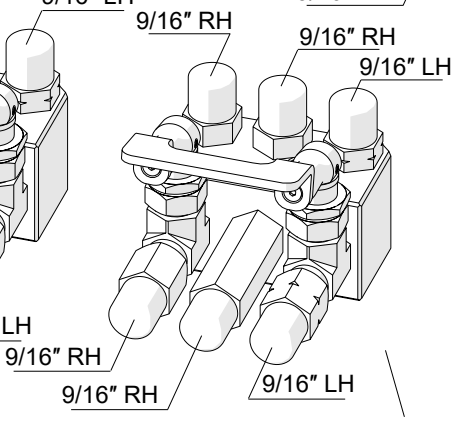




2/2 manifold with cut-off valve (imperial):
RZD-0475-70-00-00-0

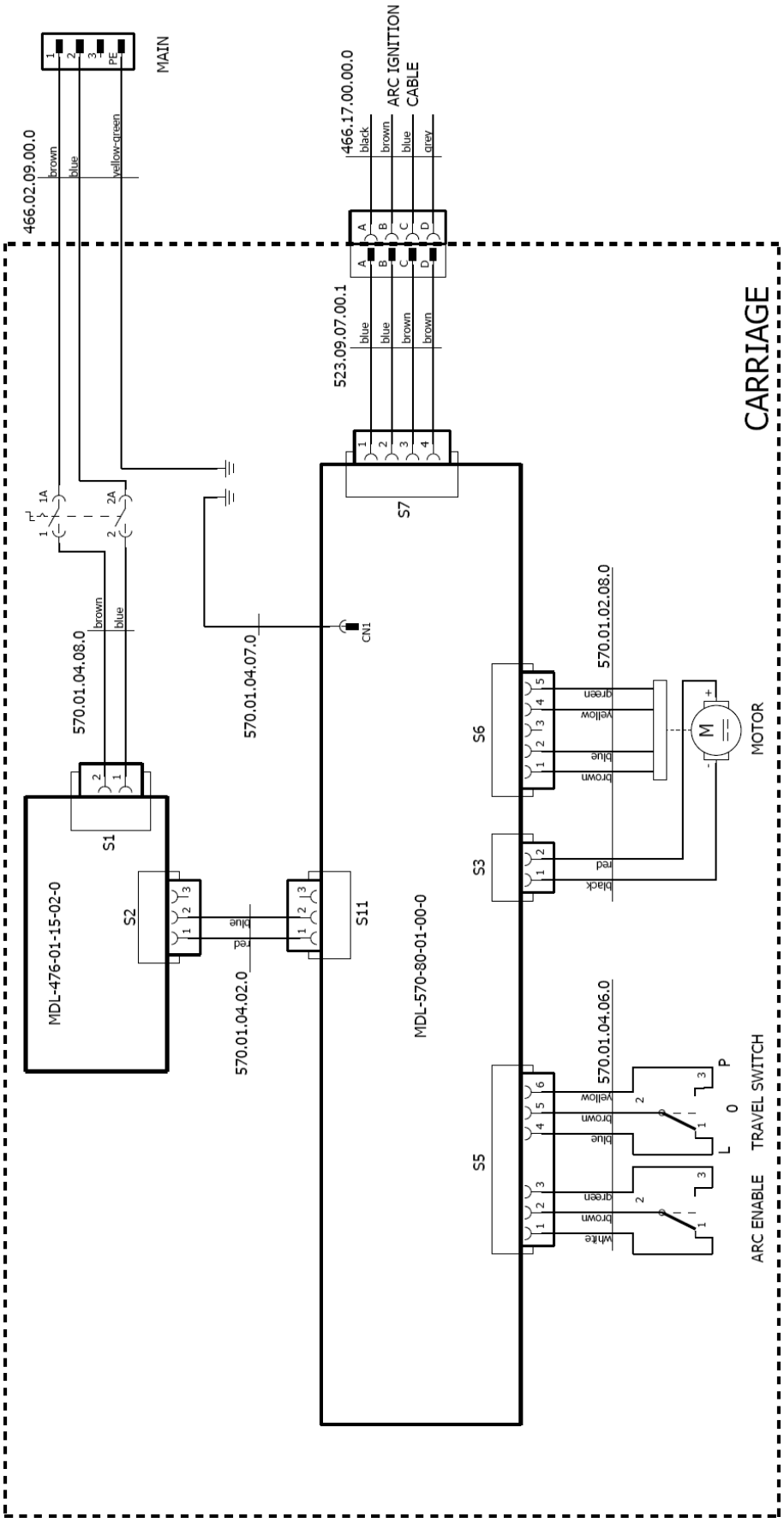


2/3 manifold with cut-off valve (imperial):
RZD-0475-69-00-00-0

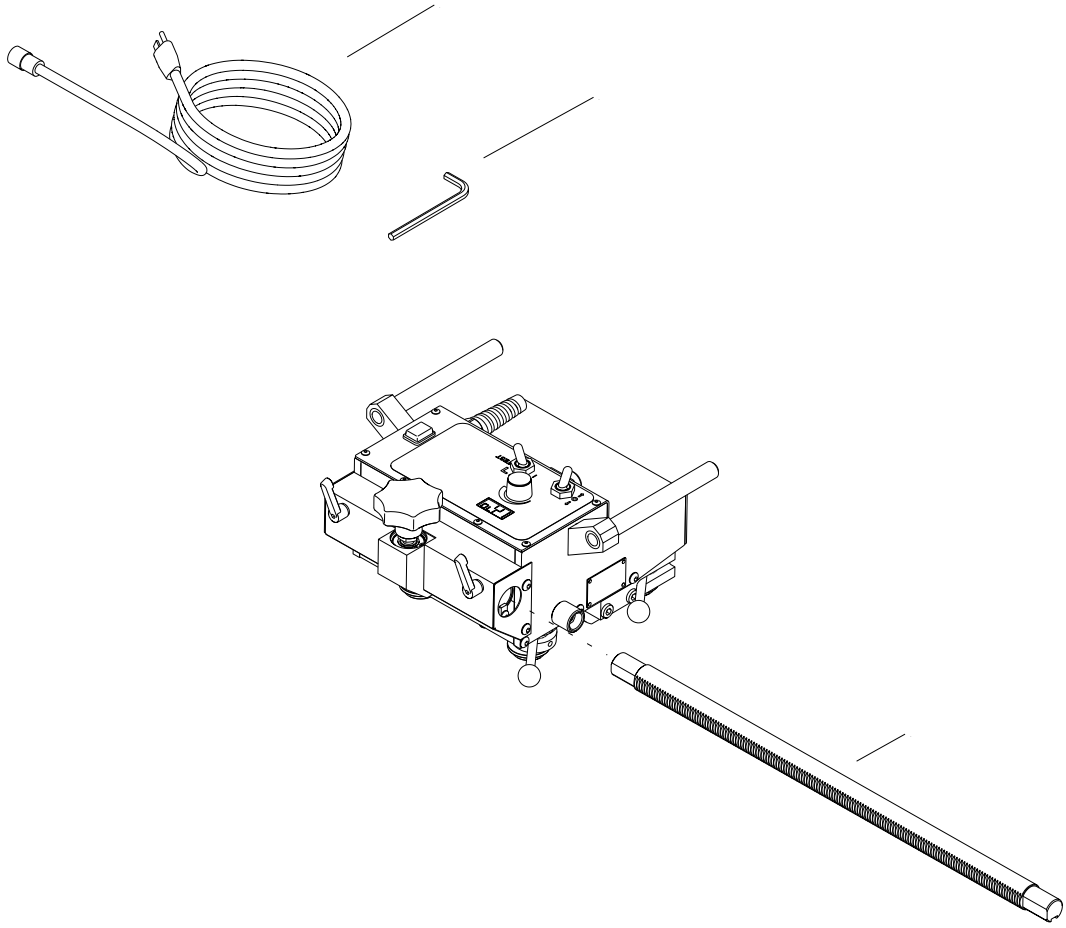


3/3 manifold with cut-off valve (imperial):
RZD-0475-71-00-00-0

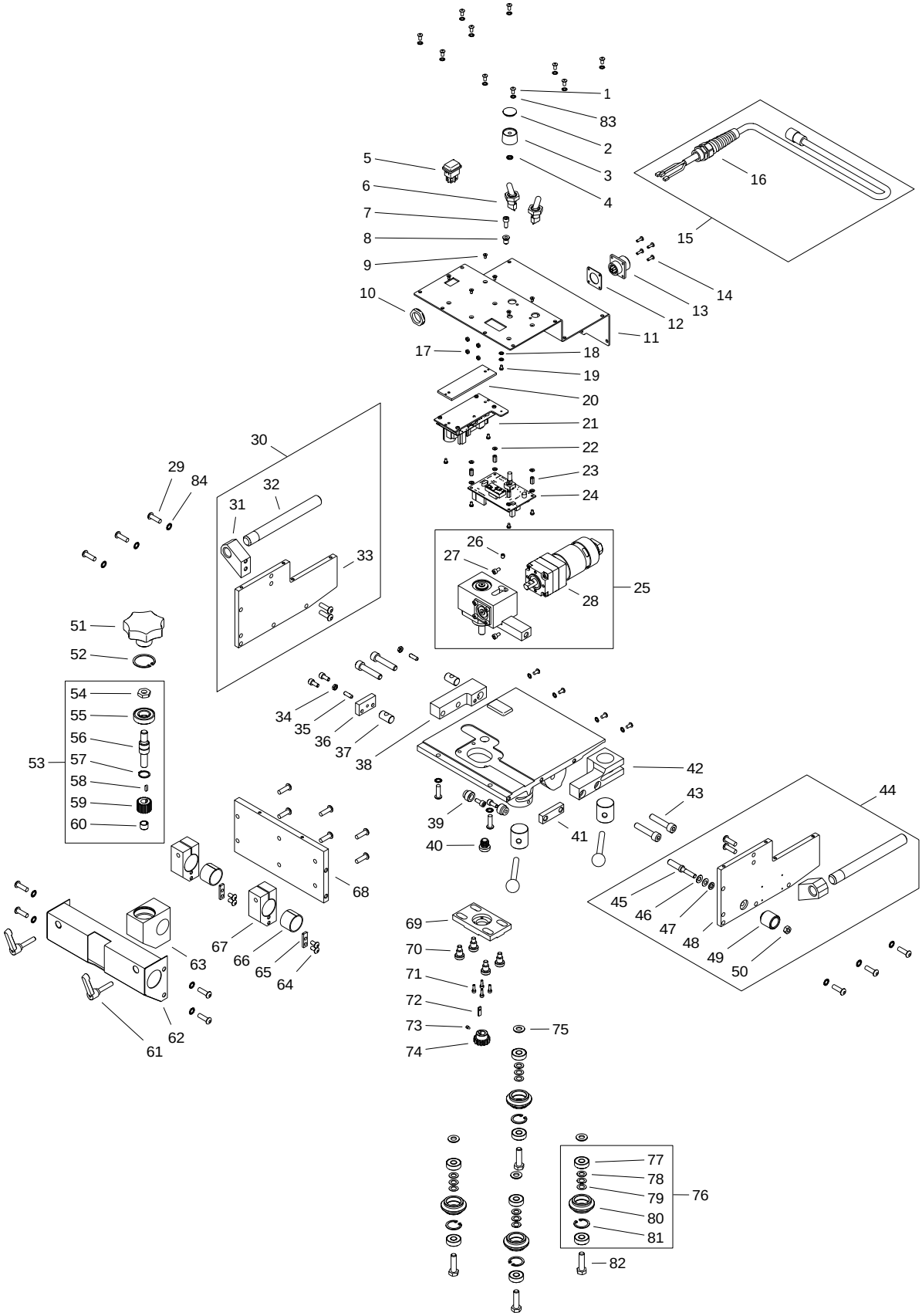
6. WIRING DIAGRAM



7. EXPLODED VIEWS AND PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PWD-0466-16-00-00-0	POWER CORD 115 V (US)	1
2	KLC-000009	6 MM HEX WRENCH	1
3	RAM-0525-07-00-00-0	RACK 540 MM (21″)	1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ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	WKR-000091	HEX SOCKET BUTTON HEAD SCREW M4x8	14
2	PKR-000055	CAP	1
3	PKT-000041	KNOB fi23	1
4	PRS-000114	SEAL O-RING 6.3x1.8	1
5	WZK-0570-01-04-08-0	POWER SUPPLY WIRE SET	1
6	WZK-0570-01-04-06-0	SWITCH WIRE SET	1
7	SRB-000078	HEX SOCKET HEAD CAP SCREW M5x12	7
8	NTN-000004	BLIND RIVET NUT M5	1
9	WKR-000349	HEX SOCKET COUNTERSUNK HEAD SCREW M3x6	6
10	NKR-000040	STRAIN RELIEF NUT	1
11	OSL-0570-01-04-01-0	TOP COVER	1
12	KLR-000005	SEAL FLANGE 14	1
13	WZK-0523-09-07-00-1	ARC IGNITION WIRE SET	1
14	WKR-000287	HEX SOCKET BUTTON HEAD SCREW M3x10	4
15	WZK-0570-01-04-09-0	POWER WIRE SET	1
16	DLW-000007	CABLE GLAND WITH STRAIN RELIEF PG11	1
17	NKR-000010	HEX NUT M3	4
18	PDK-000058	EXTERNAL TOOTH LOCK WASHER 3.2	2
19	WKR-000180	CROSS RECESSED PAN HEAD SCREW M3x5	7
20	DYS-0570-01-04-05-0	POWER SUPPLY SPACER	1
21	MDL-0570-01-04-03-0	POWER SUPPLY MODULE ASSY	1
22	PDK-000014	ROUND WASHER 3.2	8
23	TLJ-000023	SLEEVE M3x10	4
24	MDL-0570-80-01-00-0	ELECTRONIC MODULE	1
25	MTR-0570-01-02-00-0	MOTOR SET ASSY	1
26	WKR-000048	HEX SOCKET SET SCREW WITH FLAT POINT M5x6	1
27	SRB-000074	HEX SOCKET HEAD CAP SCREW M4x8	2
28	MTR-0570-01-02-08-0	MOTOR	1
29	WKR-000499	HEX SOCKET BUTTON HEAD SCREW M6x20	22
30	BOK-0570-01-07-00-0	RIGHT COVER ASSY	1
31	WSP-0570-01-06-02-0	HANDLE SUPPORT	2
32	RKJ-0570-01-06-03-0	HANDLE	2
33	PLY-0570-01-07-01-0	RIGHT COVER PLATE	1
34	NKR-000034	LOW HEX NUT M5	2
35	WKR-000077	HEX SOCKET SET SCREW WITH FLAT POINT M5x16	2
36	PLY-0523-01-01-02-0	RESISTING PLATE	1
37	NKR-0523-01-01-09-0	NUT	2
38	WSP-0523-01-01-05-0	LEFT BRACKET	1
39	ZDR-0523-01-01-08-0	BUMPER	3
40	WKL-000013	INSERT FOR TUBES fi 16	1
41	NKR-0523-01-01-06-0	SPECIAL NUT	2
42	WSP-0523-01-01-04-0	RIGHT BRACKET	1
43	SRB-000158	HEX SOCKET HEAD CAP SCREW M8x40	4
44	BOK-0570-01-06-00-0	LEFT COVER ASSY	1
45	SRB-0523-01-03-03-0	FEED SCREW	1
46	SPR-000010	DISC SPRING 6.2x12.5x0.6	2
47	PDK-000136	SMALL ROUND WASHER 6.4	1
48	PLY-0570-01-06-01-0	LEFT COVER PLATE	1
49	PKT-0341-02-08-00-0	KNOB	1
50	NKR-000017	HEX NUT M6	1
51	PKT-000038	STAR KNOB D63	1

ITEM	PART NUMBER	DESCRIPTION	Q-TY
52	PRS-000022	INTERNAL RETAINING RING 32w	1
53	ZSP-0475-06-00-00-1	FEED ASSY	1
54	NKR-000087	LOW HEX NUT M10	1
55	LOZ-000101	BALL BEARING 15x32x8	1
56	WLK-0475-06-02-00-1	GEAR SHAFT	1
57	PRS-000005	EXTERNAL RETAINING RING 15z	1
58	WPS-000005	PARALLEL KEY 3x3x10	1
59	KOL-0475-06-03-00-0	GEAR z20	1
60	TLJ-000095	SELF LUBRICATING SLEEVE 10x12x08	1
61	RKJ-000036	HANDLEVER M6-32	2
62	OSL-0570-01-05-00-0	FRONT COVER	1
63	OPR-0570-01-03-03-0	HOUSING	1
64	WKR-000096	HEX SOCKET BUTTON HEAD SCREW M5x10	4
65	WPS-0475-62-03-00-0	KEY	2
66	TLJ-000069	SELF LUBRICATING SLEEVE 25x28x20	2
67	WSP-0570-01-03-02-0	ARM SUPPORT	2
68	PLY-0570-01-03-01-0	FRONT PLATE	1
69	PLY-0523-01-01-07-0	BOTTOM PLATE	1
70	SRB-0341-02-10-00-0	MOUNTING SCREW	4
71	SRB-000310	HEX SOCKET HEAD CAP SCREW M3x10	4
72	WPS-0341-02-01-10-0	KEY	1
73	WKR-000012	HEX SOCKET SET SCREW WITH DOG POINT M4x6	1
74	KOL-0341-02-01-09-0	GEAR z14	1
75	PDK-000022	ROUND WASHER 8.4	4
76	RLK-0341-01-02-00-0	PRESSURE ROLLER ASSY	4
77	LOZ-000053	BALL BEARING 8x22x7	8
78	PDK-000173	WASHER 8x14x1	4
79	PDK-000174	WASHER 8x14x0.1	8
80	RLK-0341-01-02-01-0	PRESSURE ROLLER	4
81	PRS-000014	INTERNAL RETAINING RING 22w	4
82	SRB-000030	FULL THREAD HEX HEAD SCREW M8x30	4
83	PDK-000166	EXTERNAL TOOTH LOCK WASHER 4.3	14
84	PDK-000266	EXTERNAL TOOTH LOCK WASHER 6.4	12

8. DECLARATION OF CONFORMITY

Declaration of Conformity

PROMOTECH sp. z o.o.
ul. Elewatorska 23/1
15-620 Białystok
Poland

We declare with full responsibility that:

Rail Runner LT Welding Carriage

is manufactured in accordance with the following standards:

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

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

Person authorized to compile the technical file:
Marek Siergiej, ul. Elewatorska 23/1, 15-620 Białystok, Poland

Białystok, 15 February 2018

Marek Siergiej
CEO

9. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the Rail Runner LT 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.

Serial number .....

Date of sale .....

Signature and stamp of the seller .....

1.06 / 30 December 2019

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