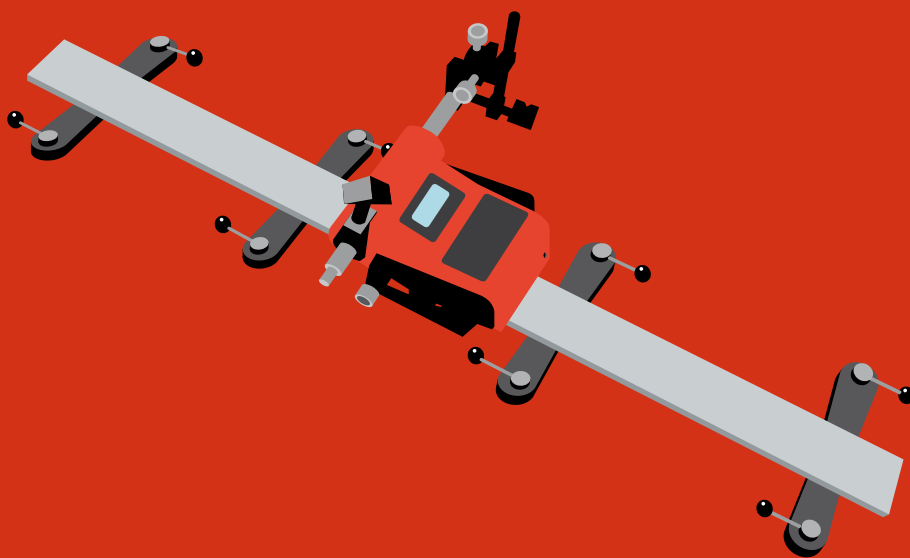


Lorch Automation Solutions

WELDING CARRIAGES LORCH TRAC



Welding solutions for the world's smartest companies.

LORCH

WELDING CARRIAGES LORCH TRAC

Increased productivity, higher quality, lower cost

Increase the performance of your welding production and combine your Lorch welding inverters with the new Lorch welding carriages.

The welding carriage ensures continuous guidance of the torch, the welder focuses on the adjustment of welding parameter. This increases productivity and quality of the welds. The heat input becomes more manageable and causes less distortions. Recurrence and reproducibility cause less stress. And a higher distance to the torch improves the welder's workplace.

For each application the proper solution

Welding carriages are extremely helpful when it comes to welding of longitudinal and curved welding seams. Typical application areas are long metal structures such as trailer manufacturing and rail vehicles, shipyards and large tanks such as truck, oil and water storage tanks.

The basic requirement of guiding the torch precisely is true for all application areas. However, each individual application has also its own and specific requirements. The Lorch welding carriage program with a very comprehensive offering of accessories is made to match these needs.

Your Lorch partner is happy to prepare the proper solution for you.

OVERVIEW LORCH TRAC



TRAC WHEEL

LORCH TRAC WHEEL are portable welding carriages for high-quality, reproducible longitudinal and curved welding seams. The battery version simplifies the welding within tanks.

Variants:

- TRAC WL
- TRAC WL HS
- TRAC WL BATT

TRAC WHEEL PRO

LORCH TRAC WHEEL PRO are portable and programmable welding carriages for extra challenging longitudinal and curved welding seams, both horizontally and vertically. Stitch welding and welding seams with larger dimensions are further key applications.

Variants:

- TRAC WL PRO
- TRAC WL PRO OSCILLATOR ADD-ON

TRAC RAIL

LORCH TRAC RAIL are rail-based carriages for welding of long, continuous butt and fillet welds. With the versatile rail system the application becomes independent from the workpiece geometry.

Variants:

- TRAC RL
- TRAC RL PRO

TRAC RAIL CUT

LORCH TRAC RAIL CUT are rail-based carriages for cutting and beveling in various applications. Housing and rail design consider the increased requirements with respect to spatter and dirt.

Variants:

- TRAC CUT
- TRAC CUT HS

LORCH TRAC WHEEL

LORCH TRAC WHEEL is a portable welding carriage for high-quality, reproducible longitudinal and curved welding seams. The carriage works both for horizontal and vertical welding seams.

Typical application areas are long metal structures such as trailer manufacturing and rail vehicles, shipyards and large tanks such as truck, oil and water storage tanks.



Features and Benefits

- 4-wheel-drive with magnetic fixation and active control for stable welding speed in all welding positions
- Constant and reproducible speed control facilitates consistent quality of welds
- Easy and flexible 3D torch adjustment allows optimal torch position
- Concave and convex curved welding seams for large tanks possible
- Comprehensive accessories for welding with two torches and a wide range of different seam geometries
- Easy connection with welding inverter
- Robust aluminum housing with only 8 kg ensures easy handling
- LORCH TRAC WHEEL HS (High Speed) with increased horizontal speed is suitable both for speed welding and plasma cutting
- LORCH TRAC WHEEL BATT (Battery powered) provides additional application flexibility

Specifications



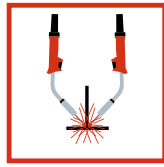
		TRAC WL	TRAC WL HS	TRAC WL BATT
Order No.		453.0001.0	453.0002.0	453.0003.0
Welding position horizontal		PA, PB, PC	PA, PB, PC	PA, PB, PC
Welding position vertical		PF	- -	PF
Curved seam convex R min	(mm)	1.000	1.000	1.000
Curved seam concave R min	(mm)	1.250	1.250	1.250
Minimum workpiece thickness	(mm)	4	4	4
Ground clearance	(mm)	4	4	4
Pulling force horizontal	(N)	150	150	150
Pulling force vertical	(N)	100	- -	100
Torch adjustment range (X/Y)	(mm)	35/35	35/35	35/35
Speed horizontal	(cm/min)	0-110	5-220	0-110
Speed vertical	(cm/min)	0-100	- -	0-100 *
Voltage	(V)	230/115 Multivoltage	230/115 Multivoltage	18 DC Batterie
Battery capacity	(Ah)	- -	- -	4,2
Power	(W)	20	20	20
Weight, net	(kg)	8	8	8,6
Dimensions (L/B/H)	(mm)	320x366x277	320x366x277	320x366x277

* when battery fully charged

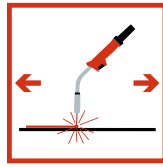
Application spectrum



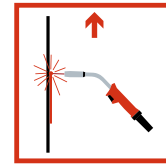
Continuous welding



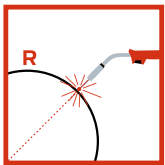
Dual torch welding



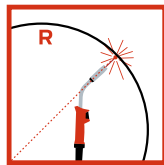
Horizontal welding



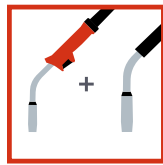
Vertical welding



Convex curved welding

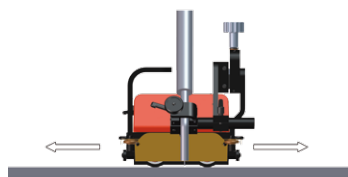


Concave curved welding

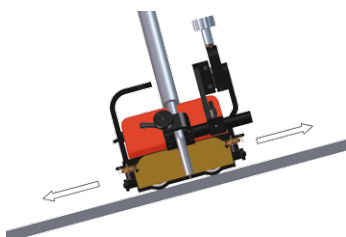


Manual or machine torch welding

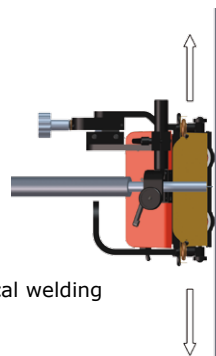




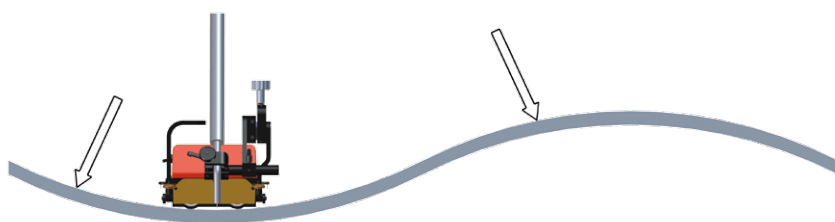
Horizontal welding



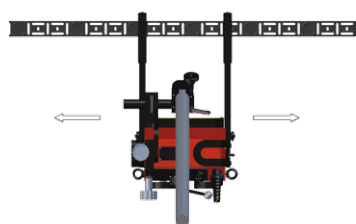
Oblique surface welding



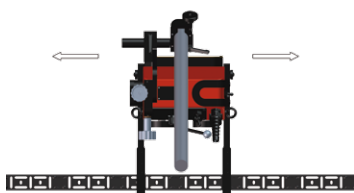
Vertical welding



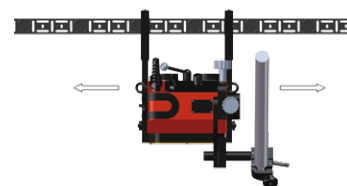
Curved surface welding



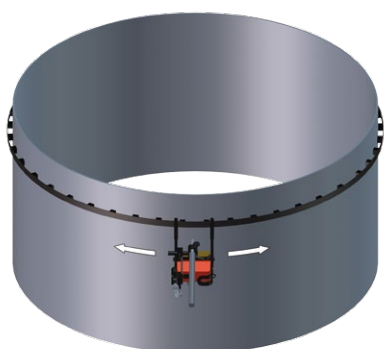
Welding with torch and Flexible Track on same side



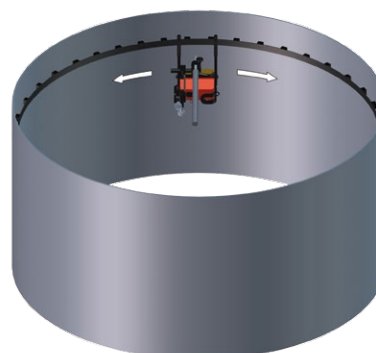
Welding with torch on opposite side of Flexible Track



Welding with torch alongside Flexible Track



Welding of convex geometry



Welding of concave geometry

Welding technology

Interface to welding Inverter

MIG-MAG








TIG

TIG-CW

Remote-Control Socket

Scope of delivery

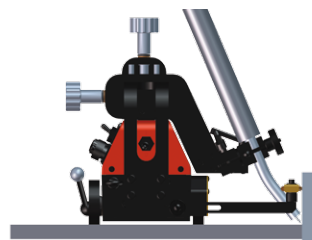
Please order separately

Order No.	Description	Order No.	Description
	TRAC WHEEL or TRAC WHEEL HS or TRAC WHEEL BATT		463.8011.0 TRAC Charger 220-240 V AC, 50/60 Hz
	463.8214.0 TRAC Power cord 230 V EU Cable length 3 m Only TRAC WHEEL and TRAC WHEEL HS		463.8013.0 TRAC Power supply 110-240 V AC / 18 V DC
	463.8010.0 TRAC Battery 18 V 5.2 Ah Only TRAC WHEEL BATT		463.8214.0 TRAC Power cord 230 V EU Cable length 3 m
	463.8041.0 TRAC Guide arm assembly with brass roller WL 2x		
	463.8212.0 TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m		
	463.8206.0 TRAC Long rod torch holder assy For torch-Ø 16-22 mm		

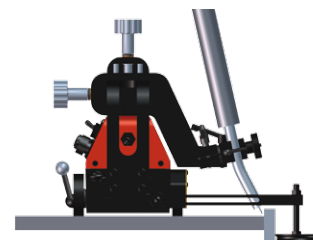
Applications and Accessories



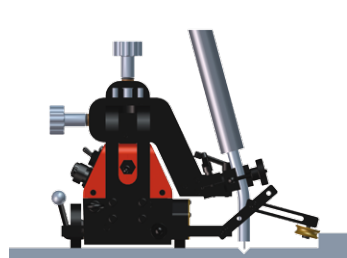
463.8040.0 - TRAC Follower arms for flex track WL



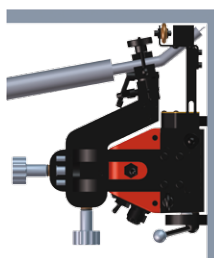
463.8041.0 - TRAC Guide arm with brass roller WL



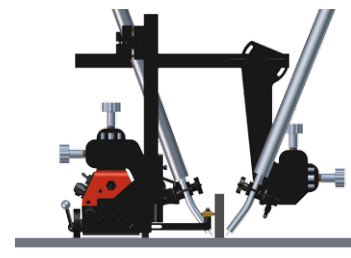
463.8042.0 - TRAC Edge following guide arms WL



463.8043.0 - TRAC Adjustable guide arms WL



463.8044.0 - TRAC Magnet guide arms WL




463.8023.0 - TRAC Dual torch mount

Accessories for LORCH TRAC WL, TRAC WL HS and TRAC WL BATT

Order No.	Description	Order No.	Description
	463.8020.0 TRAC WL Flexible track 185 cm (6 ft)		463.8023.0 TRAC Dual torch mount
	463.8021.0 TRAC Magnetic block for flex track Packaging: 10 units/package		463.8047.0 TRAC Cable anchor for torch package WL
	463.8022.0 TRAC Guide adjustment tool Parallel positioning of guide arm along welding seam possible		463.8048.0 TRAC Drive wheel WL
	463.8040.0 TRAC Follower arms for flex track WL Set with two guide arms		463.8010.0 TRAC Battery 18 V 5.2 Ah Included in scope of delivery with TRAC WL Batt
	463.8041.0 TRAC Guide arm assembly with brass roller WL		463.8011.0 TRAC Charger 220-240 V AC, 50/60 Hz To be ordered separately, not included with TRAC WL Batt
	463.8042.0 TRAC Edge following guide arms WL Set with two guide arms		463.8012.0 TRAC Charger 120 V AC, 60 Hz To be ordered separately, not included with TRAC WL Batt
	463.8043.0 TRAC Adjustable guide arms WL Set with two guide arms		463.8013.0 TRAC Power supply 110-240 V AC / 18 V DC To be ordered separately, not included with TRAC WL Batt, (without power cord)
	463.8044.0 TRAC Magnet guide arms WL Set with two guide arms		463.8200.0 TRAC Isolation tube For torch holder
	463.8045.0 TRAC Magnet block front		463.8201.0 TRAC Short rod assy
	463.8046.0 TRAC Magnet block back		463.8202.0 TRAC Long rod assy

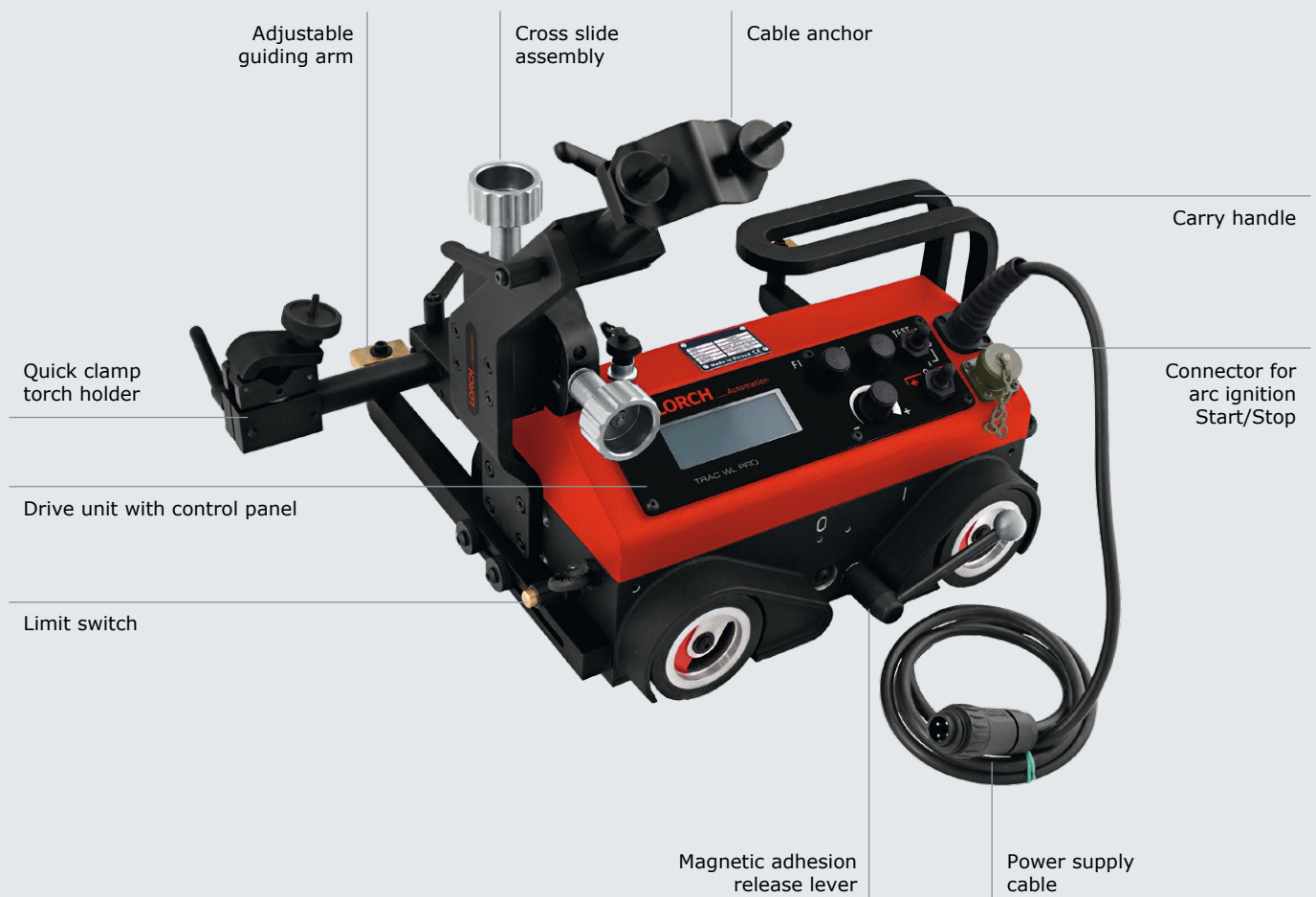
Accessories for LORCH TRAC WL, TRAC WL HS and TRAC WL BATT

	Order No.	Description		Order No.	Description
	463.8203.0	TRAC Short rod torch holder with clip Set incl. 463.8200.0, 463.8201.0, 463.8068.0, for torch-Ø 16-22 mm		463.8024.0	TRAC Fall arester
	463.8204.0	TRAC Long rod torch holder with clip Set incl. 463.8200.0, 463.8202.0, 463.8068.0, for torch-Ø 16-22 mm		463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m
	463.8205.0	TRAC Short rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0, for torch-Ø 16-22 mm		463.8214.0	TRAC Power cord 230 V EU Cable length 3 m
	463.8206.0	TRAC Long rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0, for torch-Ø 16-22 mm		463.8213.0	TRAC Power cord 115 V US Cable length 3 m
	463.8025.0	TRAC Torch extension arm		463.8215.0	TRAC Power cord 230 V AUS Cable length 3 m
	463.8207.0	TRAC Standard torch holder For torch-Ø 28-35 mm		463.8216.0	TRAC Power cord 115 V UK Cable length 3 m
	463.8208.0	TRAC Torch holder clamp For torch-Ø 22-35 mm		463.8501.0	TRAC WL metal box
	463.8209.0	TRAC Quick torch holder clamp 16-22 mm			
	463.8210.0	TRAC Cross slide assembly With two traverse axes, each 35 mm			
	463.8211.0	TRAC Cross slide assembly extended With two traverse axes, horizontal 35 mm and vertical 76 mm			

LORCH TRAC WHEEL PRO

Lorch Trac Wheel Pro is a portable and programmable welding carriage for extra challenging longitudinal and curved welding seams, both horizontally and vertically. Always when it comes to stitch welding and welding seams with larger dimensions, Lorch Trac Wheel Pro is the right choice.

Typical application areas are long metal structures such as trailer manufacturing and rail vehicles, shipyards and large tanks such as truck, oil and water storage tanks.



Features and Benefits

- 4-wheel-drive with magnetic fixation and active control for stable welding speed in all welding positions
- Constant and reproducible speed control facilitates consistent quality of welds
- Easy and flexible 3D torch adjustment allows optimal torch position
- Concave and convex curved welding seams for large tanks possible
- Comprehensive accessories for welding with two torches and a wide range of different seam geometries
- Easy connection with Lorch welding inverter via Lorch Plug&Weld
- Welder friendly programming and storage of up to 40 welding and oscillation programs
- Free adjustment of parameters such as total weld length, weld length, distance between welds and other allows flexible definition of welding sequence
- Increased travel speed inbetween welds saves time
- Reproducing the exact weld seam geometry avoids seam oversizing and reduces consumption of filler material
- The optional upgrade with the radial oscillator is great to produce weave welds and compensate positioning deviations of the workpieces



Specifications

TRAC WL PRO		
Order No.		453.0010.0
Welding position horizontal		PA, PB, PC
Welding position vertical		PF
Curved seam convex R min	(mm)	1.500
Curved seam concave R min	(mm)	1.500
Minimum workpiece thickness	(mm)	5
Ground clearance	(mm)	5
Pulling force horizontal	(N)	220
Pulling force vertical	(N)	150
Torch adjustment range (X/Y)	(mm)	35/35
Speed horizontal	(cm/min)	0-120
Speed vertical	(cm/min)	0-110
Voltage	(V)	230/115 Multivoltage
Power	(W)	25
Weight, net	(kg)	14
Dimensions (L/B/H)	(mm)	404x447x360

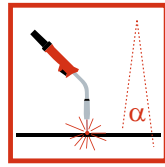
Application spectrum



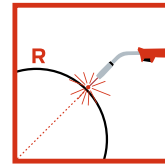
Continuous welding



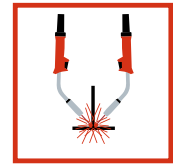
Stich welding



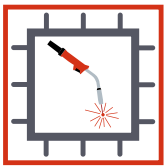
Oscillation radial



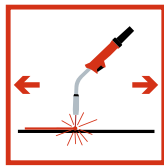
Convex curved welding



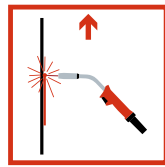
Dual torch welding



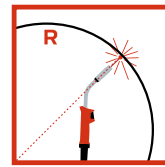
Program storage



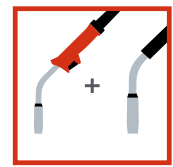
Horizontal welding



Vertical welding

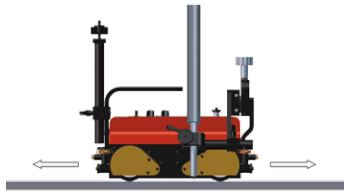


Concave curved welding

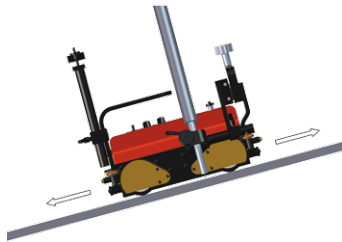


Manual or machine torch welding

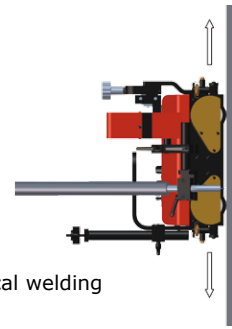




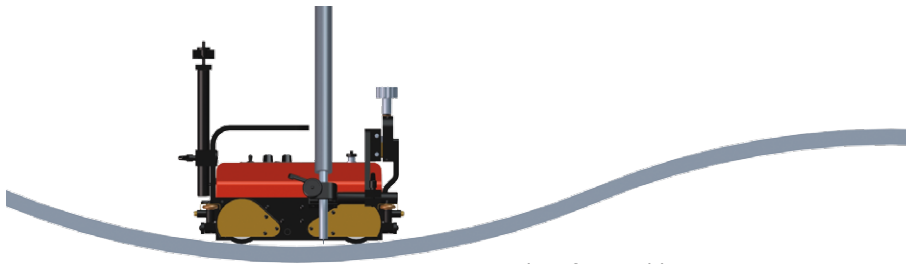
Horizontal welding



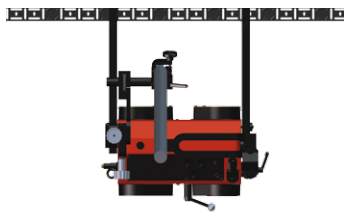
Oblique surface welding



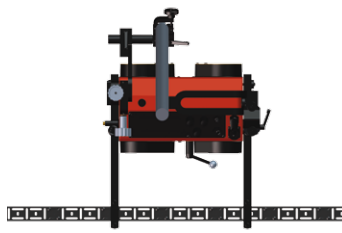
Vertical welding



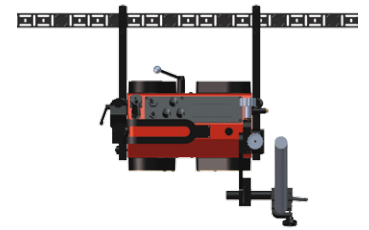
Curved surface welding



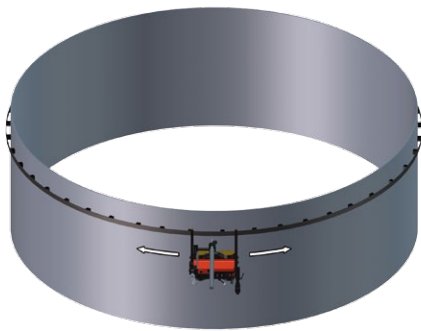
Welding with torch and Flexible Track on same side



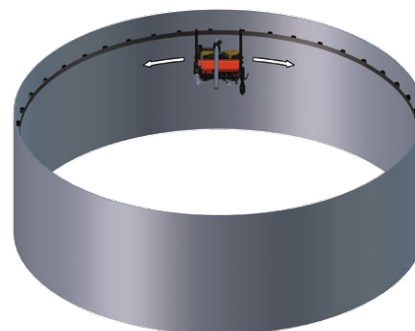
Welding with torch on opposite side of Flexible Track



Welding with torch alongside Flexible Track



Welding of convex geometry



Welding of concave geometry

Welding technology

MIG-MAG






TIG

TIG-CW

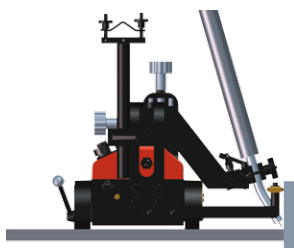
Interface to welding Inverter

Remote-Control Socket

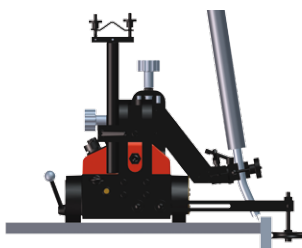
Scope of delivery

	Order No.	Description
		TRAC WHEEL PRO
	463.8214.0	TRAC Power cord 230 V EU Cable length 3 m
	463.8060.0	TRAC Guide arm brass roller WL PRO 2x
	463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m
	463.8205.0	TRAC Short rod torch holder assy Quick-lock set, for torch-Ø 16-22 mm

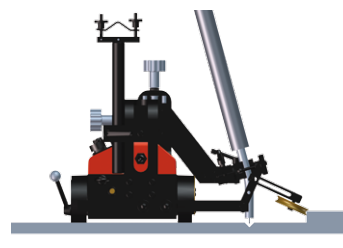
Applications and Accessories



463.8060.0 - TRAC Guide arm brass roller WL PRO



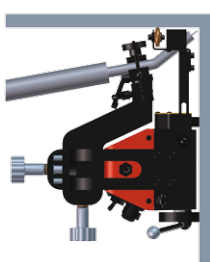
463.8061.0 - TRAC Edge following guide arms WL PRO



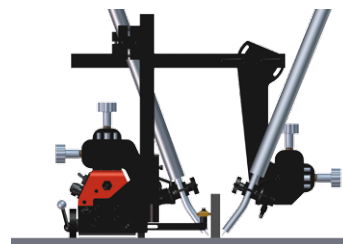
463.8062.0 - TRAC Adjustable guide arms WL PRO



463.8063.0 - TRAC Adjustable guide arms WL PRO



463.8064.0 - TRAC Magnet guide arms WL PRO



463.8023.0 - TRAC Dual torch mount

Optional Oscillator Unit

LORCH TRAC WL PRO can be upgraded with an optional oscillator unit for welding seams with larger dimensions and for compensating positioning errors of the workpieces.

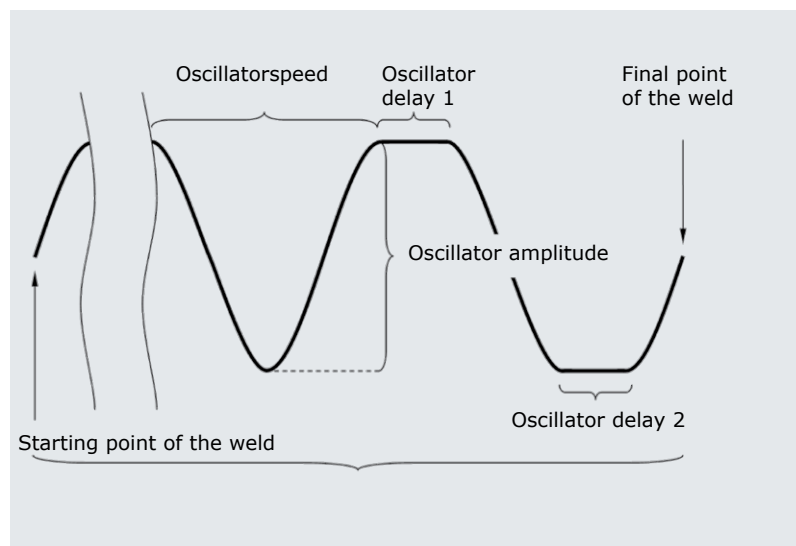
Please note:

Oscillator Add-On works with one torch only!



Specifications

TRAC WL PRO OSCILLATOR ADD-ON		
Order No.		453.0011.0
Oscillator amplitude	(mm)	1-30 mm (1-100%) @ Radius 150 mm
Oscillator speed	(cykles/min)	7 - 164 (1-100%)
Oscillation type		Radial (max. 11 degree)
Maximum torque	(Nm)	5
Power	(W)	12
Weight	(kg)	2

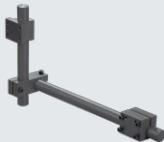





The oscillator features precise control of weave width, weave speed and dwell times.

Accessories for LORCH TRAC WL PRO

Order No.	Description	Order No.	Description
	463.8020.0 TRAC WL Flexible track 185 cm (6 ft)		463.8066.0 TRAC Lower rod clamp Only for Oscillator Add-On, Remove gear rack length 135 mm
	463.8021.0 TRAC Magnetic block for flex track Packaging: 10 units/package		463.8067.0 TRAC Torch holder rod clamp assy oscil Only for Oscillator Add-On, Incl. torch holder clamp 16-22 mm
	463.8022.0 TRAC Guide adjustment tool Parallel positioning of guide arm along welding seam possible		463.8068.0 TRAC Torch holder clamp 16-22 mm for oscillation
	463.8023.0 TRAC Dual torch mount		463.8069.0 TRAC Cable anchor WL PRO
	463.8060.0 TRAC Guide arm brass roller WL PRO		463.8200.0 TRAC Isolation tube For torch holder
	463.8061.0 TRAC Edge following guide arms WL PRO Set with two guide arms		463.8201.0 TRAC Short rod assy
	463.8062.0 TRAC Adjustable guide arms WL PRO Set with two guide arms		463.8202.0 TRAC Long rod assy
	463.8063.0 TRAC Follower arms for flex track WL PRO Set with two guide arms		463.8203.0 TRAC Short rod torch holder with clip Set incl. 463.8200.0, 463.8201.0, 463.8068.0, for torch-Ø 16-22 mm
	463.8064.0 TRAC Magnet guide arms WL PRO Set with two guide arms		463.8204.0 TRAC Long rod torch holder with clip Set incl. 463.8200.0, 463.8202.0, 463.8068.0 for torch-Ø 16-22 mm
	463.8065.0 TRAC Drive wheel WL PRO		463.8205.0 TRAC Short rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 for torch-Ø 16-22 mm

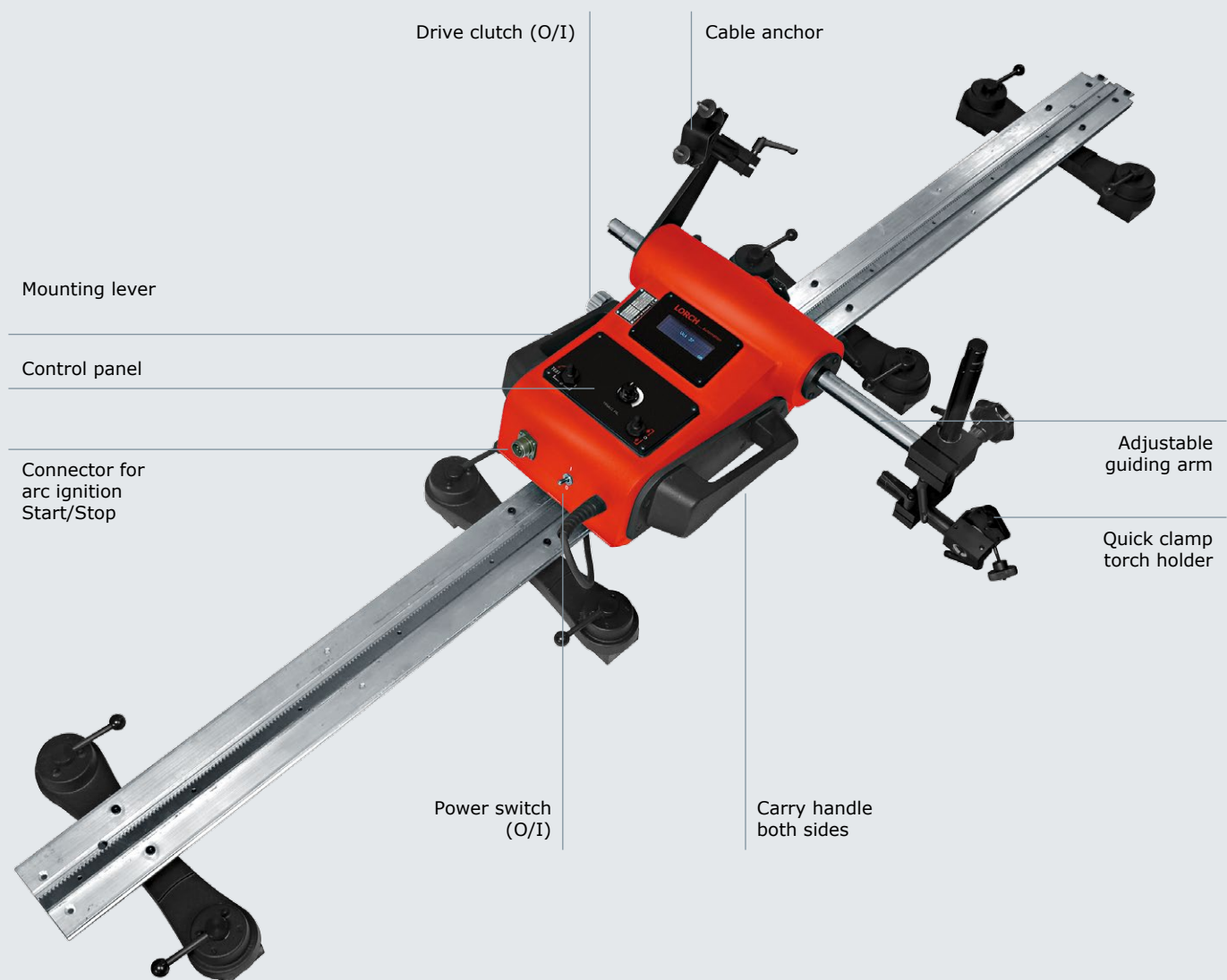
Accessories for LORCH TRAC WL PRO

	Order No.	Description		Order No.	Description
	463.8206.0	TRAC Long rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 For torch-Ø 16-22 mm		463.8213.0	TRAC Power cord 115 V US Cable length 3 m
	463.8025.0	TRAC Torch extension arm		463.8215.0	TRAC Power cord 230 V AUS Cable length 3 m
	463.8207.0	TRAC Standard torch holder For torch-Ø 28-35 mm		463.8216.0	TRAC Power cord 115 V UK Cable length 3 m
	463.8208.0	TRAC Torch holder clamp For torch-Ø 22-35 mm		463.8502.0	TRAC WL Pro Metal box
	463.8209.0	TRAC Quick torch holder clamp 16-22 mm			
	463.8210.0	TRAC Cross slide assembly With two traverse axes, each 35 mm			
	463.8211.0	TRAC Cross slide assembly extended With two traverse axes, horizontal 35 mm and vertical 76 mm			
	463.8024.0	TRAC Fall arester			
	463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m			
	463.8214.0	TRAC Power cord 230 V EU Cable length 3 m			

LORCH TRAC RAIL

LORCH TRAC RAIL and LORCH TRAC RAIL PRO are rail-based carriages for welding of long, continuous butt and fillet welds. Using rails the carriage and welding path can be defined independently from the workpiece geometry.

Typical application areas are trailer manufacturing, large tanks for oil, fuel and water storage, pressure vessels, overlay weldings, bridge girders, structural steel and towers, and shipyards.



Features and Benefits

- Slip-free motion via gear and gear rack produces premium quality welds
- Flexible and rigid rail types with magnetic or vacuum fixation facilitate broad applications
- Parameter setting via knobs and plain-text display ensures welder friendly usage
- Reproducing the exact weld seam geometry avoids seam oversizing and reduces consumption of filler material
- The Lorch TRAC RAIL PRO with integrated linear oscillation is great to produce weave welds and compensate positioning deviations of the workpieces
- The flexible adjustment of oscillation patterns allows to adapt the torch movement according to the respective welding position



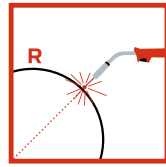
Specifications

		TRAC RL	TRAC RL PRO
Order No.		453.0020.0	453.0021.0
Oscillation		No oscillation	with oscillation
Welding position horizontal		PA, PB, PC	PA, PB, PC
Welding position vertical		PF, PG	PF, PG
Curved seam convex R min	(mm)	5.000	5.000
Curved seam concave R min	(mm)	5.000	5.000
Minimum workpiece thickness	(mm)	5 (Magnet)	5 (Magnet)
Pulling force horizontal	(N)	350	350
Pulling force vertical	(N)	150	150
Torch adjustment range (X/Y)	(mm)	35/35	35/35
Speed horizontal	(cm/min)	0-120	0-120
Speed vertical	(cm/min)	0-110	0-110
Voltage	(V)	230/115 Multivoltage	230/115 Multivoltage
Power	(W)	100	100
Weight, net	(kg)	20	20
Dimensions (L/B/H)	(mm)	441x670x362	441x670x362

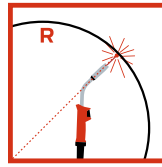
Application spectrum



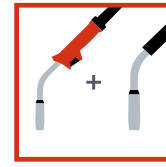
Continuous welding



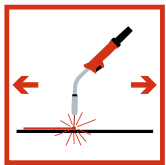
Convex curved welding



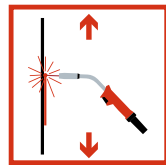
Concave curved welding



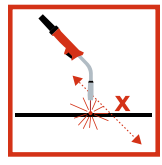
Manual or machine torch welding



Horizontal welding

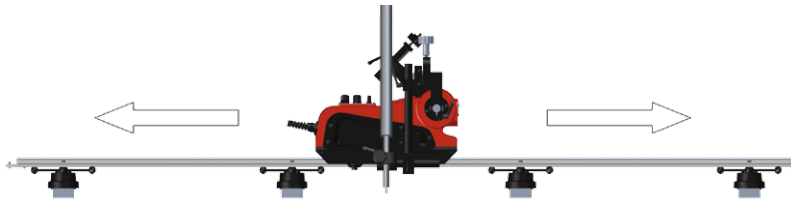


Vertical welding

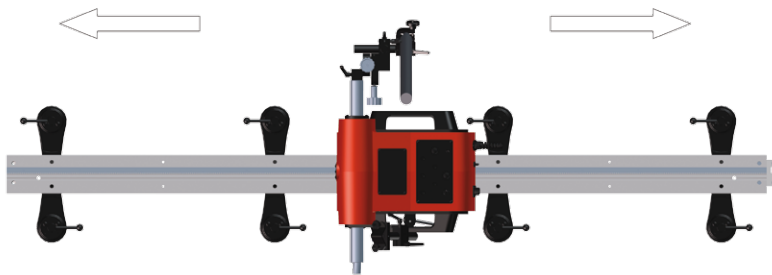


Oscillation motion linear, for trapezoid, triangular and linear patterns





TRAC RL on Flex Trac in horizontal position, mounted on flat surface



TRAC RL on Flex Trac in lateral position (7 Dual Magnet Units recommended)



TRAC RL on Flex Trac in vertical position



TRAC RL on Flex Trac, mounted on curved surface

Rail System: Lorch Flexible Track

Lorch Flexible Track enables usage on surface with a radius of curvature above 5 m. The rails can be extended as often as needed.

Recommended standard configuration:

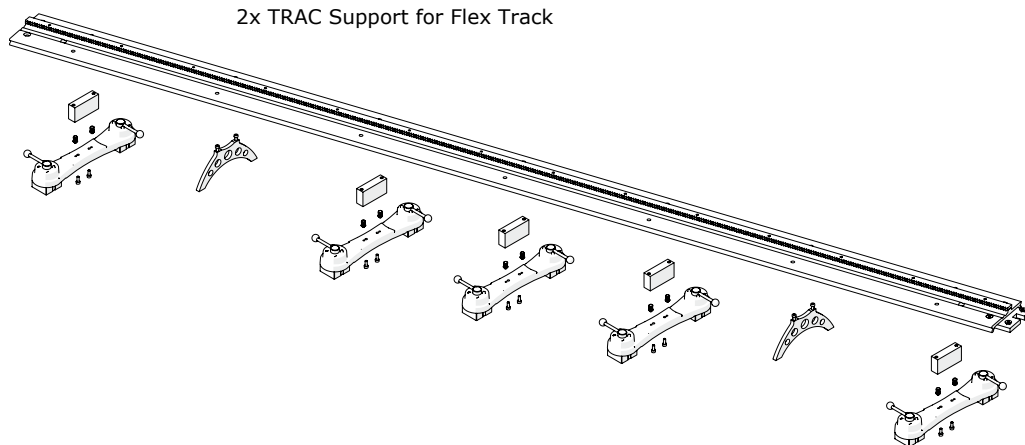
Track bundle 5x magnet

- 1 x TRAC RL Flex Track
- 5x TRAC Dual Magnetic Unit
- 5x TRAC Bracket for Flex Track
- 2x TRAC Support for Flex Track

For increased magnetic clamping force:

Track bundle 7x magnet

- 1 x TRAC RL Flex Track
- 7x TRAC Dual Magnetic Unit
- 7x TRAC Bracket for Flex Track



Order No.	Description
 463.8180.0	TRAC RL Flex track 2 m
 463.8181.0	TRAC Bracket for flex track
 463.8182.0	TRAC Track support alu for flex track
 463.8121.0	TRAC Track dual magnetic unit
453.9000.5	TRAC RL Flex track bundle 5x magnet Recommended configuration. Including 1x TRAC RL Flex track 2 m, 5x TRAC dual magnetic unit, 5x TRAC Bracket for flex track, 2x Track support alu for flex track
453.9000.7	TRAC RL Flex track bundle 7x magnet Recommended configuration. Including 1x TRAC RL Flex track 2 m, 7x TRAC dual magnetic unit, 7x TRAC Bracket for flex track

Rail System Extension: Lorch Rigid Track

Lorch Rigid Track is an extension for the Lorch Flexible Track System and converts the bending flexibility into a high bending stiffness. This way applications out of material are possible.

Recommended standard configuration:

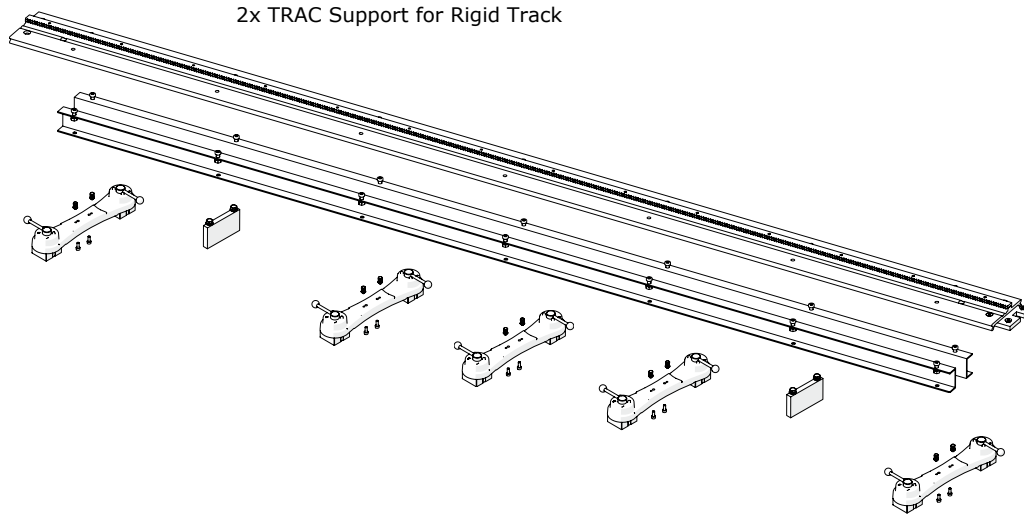
Track bundle 5x magnet

- 1x TRAC RL Flex Track
- 1x TRAC Rigid Track Support
- 5x TRAC Dual Magnetic Unit
- 2x TRAC Support for Rigid Track

For increased magnetic clamping force:

Track bundle 7x magnet

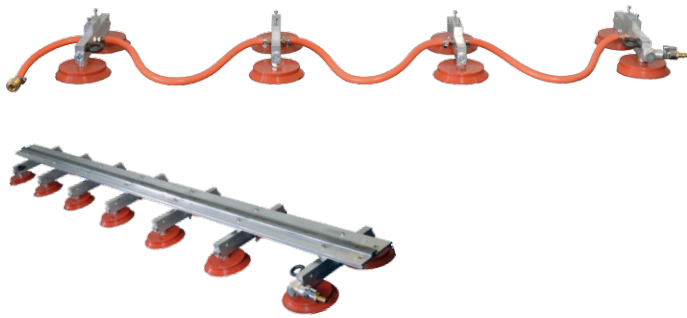
- 1x TRAC RL Flex Track
- 1x TRAC Rigid Track Support
- 7 x TRAC Dual Magnetic Unit



Order No.	Description
 463.8180.0	TRAC RL Flex track 2 m
 463.8183.0	TRAC Rigid track support 2 m
 463.8184.0	TRAC Support for rigid track
 463.8121.0	TRAC Dual Magnetic Unit
453.9010.5	TRAC RL Flex track bundle 5x magnet Recommended configuration. Including 1x TRAC RL Flex track 2 m, 1x TRAC Rigid track support 2 m, 5x TRAC dual magnetic unit, 2x Track support for rigid track
453.9010.7	TRAC RL Flex track bundle 7x magnet Recommended configuration. Including 1x TRAC RL Flex track 2 m, 1x TRAC Rigid track support 2 m, 7x TRAC dual magnetic unit

Rail System Extension: Lorch Vacuum Fixation

The Lorch Vacuum Fixation is applied for welding of stainless steel and aluminum, as these materials have no or weak ferromagnetic characteristics. The vacuum fixation may be combined both with Lorch Flexible Track as well as Lorch Rigid Track rail systems.



Order No.	Description	Order No.	Description
453.9020.7	TRAC RL Vacuum flex track bundle start 7 Set of 7 vacuum units and 1 flex track	453.9021.7	TRAC RL Vacuum flex track bundle 7x Set of 7 vacuum units and 1 flex track
453.9030.7	TRAC RL Vacuum rigid track bundle start7 Set of 7 vacuum units and 1 rigid track	453.9031.7	TRAC RL Vacuum rigid track bundle 7x Set of 7 vacuum units and 1 rigid track

Standard configuration for the first track (Incl. vacuum pump, supplying up to 21 modular vacuum units)

Standard configuration for additional tracks

Order No.	Description	Order No.	Description
463.8180.0	1x TRAC RL Flex Track, 2 m	463.8180.0	1x TRAC RL Flex track 2 m
463.8183.0	1x TRAC RL Rigid Track support, 2 m (only for Rigid Track)	463.8183.0	1x TRAC RL Rigid Track support, 2 m (only for Rigid Track)
463.8301.0	1x TRAC Vacuum pump with reservoir 230 V	463.8308.0	1x TRAC Silicon hose for unit connections
463.8303.0	1x TRAC Pump connection hose	463.8309.0	1x TRAC Shut-off valve set for entry unit
463.8309.0	1x TRAC Shut-off valve set for entry unit	463.8307.0	4x or 7x TRAC Modular vacuum unit
463.8307.0	4x or 7x TRAC Modular vacuum unit	463.8300.0	4x or 7x TRAC Bracket flex track vacuum unit
463.8300.0	4x or 7x TRAC Bracket flex track vacuum unit	463.8305.0	3x or 6x TRAC Track segment connection hose
463.8305.0	3x or 6x TRAC Track segment connection hose	463.8310.0	1x TRAC Threaded plug for end vacuum unit
463.8310.0	1x TRAC Threaded plug for end vacuum unit	463.8311.0	1x TRAC Copper seal 17x21x1,5 mm
463.8311.0	1x TRAC Copper seal 17x21x1,5 mm	463.8315.0	2x TRAC Safety eye bolt
463.8315.0	2x TRAC Safety eye bolt		

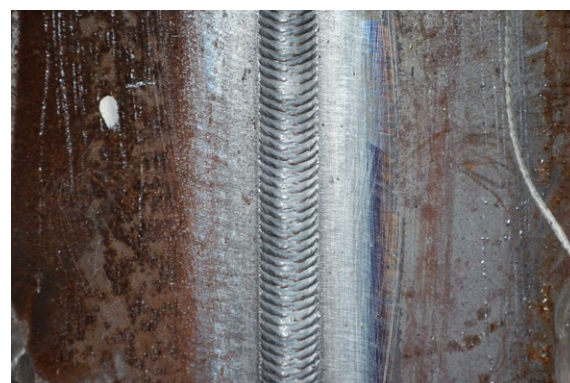
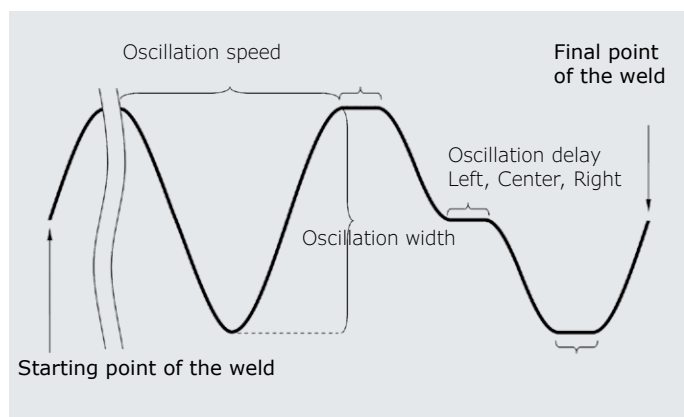
LORCH TRAC RAIL PRO with integrated linear oscillation

LORCH TRAC RAIL PRO with integrated linear oscillation is great to produce weave welds and compensate positioning deviations of the workpieces. The oscillator features precise control of weave width, weave speed and dwell times left/right and middle.



Specifications

TRAC RL PRO		
Oscillation		linear
Oscillation patterns		trapezoid, triangular, straight line
Oscillation width	(mm)	0 - 50
Oscillation motion path	(mm)	0 - 100
Maximum oscillator pulling force	(N)	100
Oscillation speed	(mm/min)	0 - 1500
Power	(W)	12
Oscillation delay at center and on ends	(s)	0 - 5



Welding and cutting technology

Interface to welding Inverter

MIG-MAG

TIG

TIG-CW

CUT
Oxy-fuel

Remote-Control Socket

Scope of delivery LORCH TRAC RL

Scope of delivery LORCH TRAC RL PRO

	Order No.	Description		Order No.	Description
		TRAC RAIL RL			TRAC RAIL RL PRO
	463.8100.0	TRAC Geared rack 540 mm For TRAC RL Length 540 mm Length Geared rack 480 mm		463.8202.0	TRAC Long rod assy
	463.8101.0	TRAC Geared rack 300 mm For TRAC RL Length 301 mm Length Geared rack 241 mm		463.8210.0	TRAC Cross slide assembly With two traverse axes, each 35 mm
	463.8188.0	TRAC Slide		463.8205.0	TRAC Short rod torch holder assy Quick-lock set, for torch-Ø 16-22 mm
	463.8154.0	TRAC Clamping block small		463.8069.0	TRAC Cable anchor WL PRO
	463.8205.0	TRAC Short rod torch holder assy Quick-lock set, for torch-Ø 16-22 mm		463.8214.0	TRAC Power cord 230 V EU Cable length 3 m
	463.8069.0	TRAC Cable anchor WL PRO		463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m
	463.8187.0	TRAC Gas manifold bracket		463.8504.0	TRAC RL Metal box
	463.8214.0	TRAC Power cord 230 V EU Cable length 3 m			
	463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m			
	463.8504.0	TRAC RL Metal box			















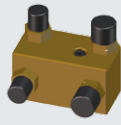


Accessories for LORCH TRAC RL and LORCH TRAC RL PRO

	Order No.	Description		Order No.	Description
	463.8100.0	TRAC Geared rack 540 mm For TRAC RL Length 540 mm Length Geared rack 480 mm		463.8187.0	TRAC Gas manifold bracket
	463.8101.0	TRAC Geared rack 300 mm For TRAC RL Length 301 mm Length Geared rack 241 mm		463.8188.0	TRAC Slide
	463.8102.0	TRAC Geared rack 700 mm For TRAC RL Length 707 mm Length Geared rack 647 mm		463.8154.0	TRAC Clamping block small
	463.8103.0	TRAC Geared rack 1000 mm For TRAC RL Length 1000 mm Length Geared rack 940 mm		463.8069.0	TRAC Cable anchor
	463.8180.0	TRAC RL Flex track 2 m		463.8200.0	TRAC Isolation tube For torch holder
	463.8121.0	TRAC Track dual magnetic unit		463.8201.0	TRAC Short rod assy
	463.8181.0	TRAC Bracket for flex track		463.8202.0	TRAC Long rod assy
	463.8182.0	TRAC Track support alu for flex track		463.8203.0	TRAC Short rod torch holder with clip Set incl. 463.8200.0, 463.8201.0, 463.8068.0, for torch-Ø 16-22 mm
	463.8183.0	TRAC RL Rigid Track support, 2 m		463.8204.0	TRAC Long rod torch holder with clip Set incl. 463.8200.0, 463.8202.0, 463.8068.0 for torch-Ø 16-22 mm
	463.8184.0	TRAC Support for rigid track		463.8205.0	TRAC Short rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 for torch-Ø 16-22 mm
	463.8185.0	TRAC Gear rack adjustment tool		463.8206.0	TRAC Long rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 for torch-Ø 16-22 mm
	463.8186.0	TRAC Transport attachment		463.8207.0	TRAC Standard torch holder 25-35 mm

Accessories for LORCH TRAC RL and LORCH TRAC RL PRO

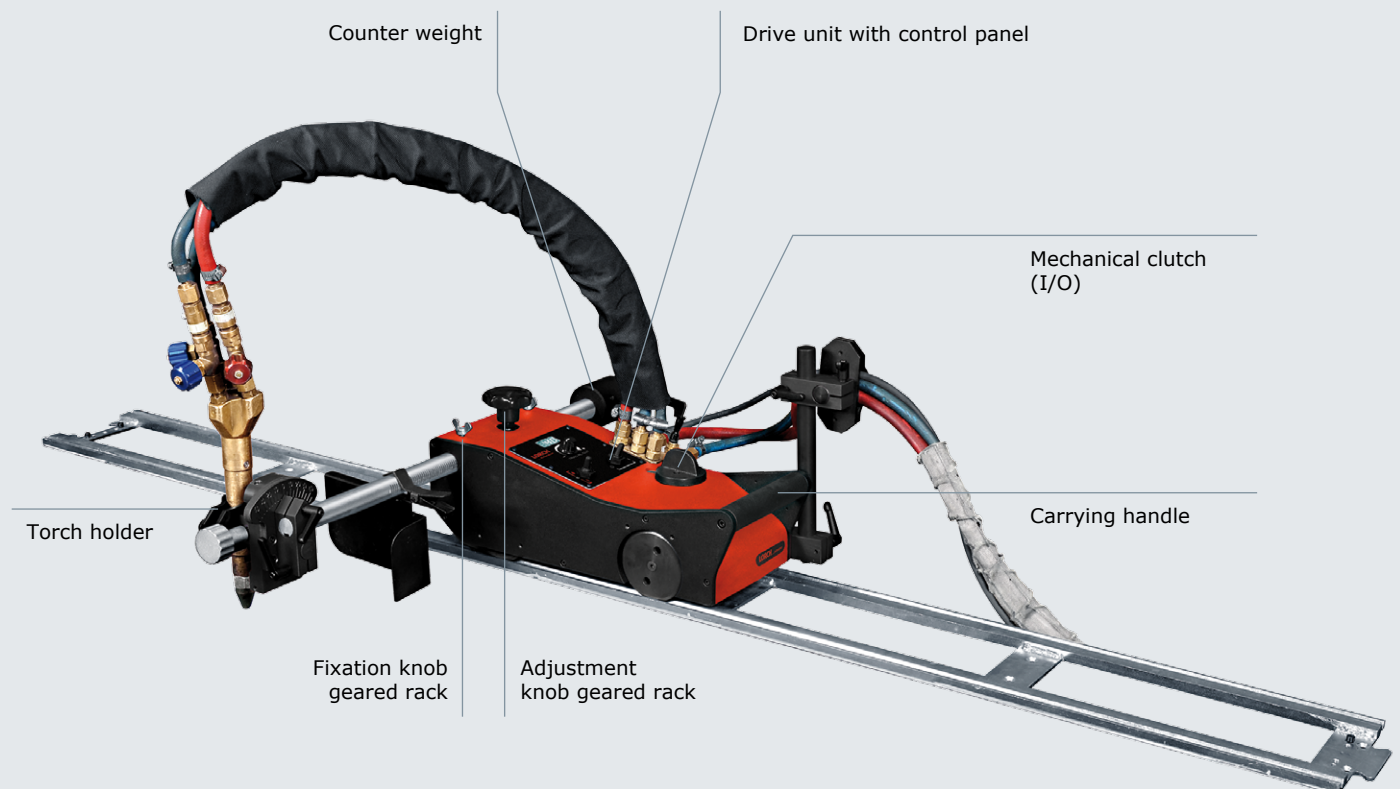
	Order No.	Description		Order No.	Description
	463.8208.0	TRAC Torch holder clamp 22-35 mm		463.8300.0	TRAC Bracket flex track vacuum unit
	463.8209.0	TRAC Quick torch holder clamp 16-22 mm		463.8301.0	TRAC Vacuum pump with reservoir 230 V
	463.8123.0	TRAC Standard torch holder angle adjust		463.8302.0	TRAC Vacuum pump with reservoir 115 V
	463.8068.0	TRAC Torch holder clamp 16-22 oscilla		463.8303.0	TRAC Pump connection hose
	463.8124.0	TRAC Slide rack holder		463.8304.0	TRAC 4-way vacuum manifold with hose
	463.8210.0	TRAC Cross slide assembly With two traverse axes, each 35 mm		463.8305.0	TRAC Track segment connection hose
	463.8211.0	TRAC Cross slide assembly extended With two traverse axes, horizontal 35 mm and vertical 76 mm		463.8306.0	TRAC Hose connector
	463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m		463.8307.0	TRAC Modular vacuum unit
	463.8214.0	TRAC Power cord 230 V EU Cable length 3 m		463.8308.0	TRAC Silicon cable for unit connections
	463.8213.0	TRAC Power cord 115 V US Cable length 3 m		463.8309.0	TRAC Shut-off valve set for entry unit
	463.8215.0	TRAC Power cord 230 V AUS Cable length 3 m		463.8310.0	TRAC Threaded plug for end vacuum unit
	463.8216.0	TRAC Power cord 115 V UK Cable length 3 m		463.8311.0	TRAC Copper seal 17x21x1,5 mm

Accessories for LORCH TRAC RL and LORCH TRAC RL PRO

	Order No.	Description		Order No.	Description
	463.8312.0	TRAC Cable tie		463.8112.0	TRAC Manifold 2x3 w/cut-off valve metric For oxy-fuel cutting
	463.8313.0	TRAC Connector with external thread		463.8113.0	TRAC Manifold 3/3 metric For oxy-fuel cutting
	463.8314.0	TRAC Quick connector		463.8114.0	TRAC Manifold 3/3 w/cut-off valve metric For oxy-fuel cutting
	463.8315.0	TRAC Safety eye bolt		463.8115.0	TRAC Manifold 2x2 1/4" For oxy-fuel cutting
	463.8104.0	TRAC Prec. torch-holder angle-hght adj		463.8116.0	TRAC Manifold 2x2 w/cut-off valve 1/4" For oxy-fuel cutting
	463.8105.0	TRAC Machine barrel torch holder 30 mm For oxy-fuel cutting		463.8117.0	TRAC Manifold 2x3 1/4" For oxy-fuel cutting
	463.8106.0	TRAC Machine barrel torch holder 35 mm For oxy-fuel cutting		463.8118.0	TRAC Manifold 2x3 w/cut-off valve 1/4" For oxy-fuel cutting
	463.8107.0	TRAC Precise machine torch holder 30 mm For oxy-fuel cutting		463.8119.0	TRAC Manifold 3/3 1/4" For oxy-fuel cutting
	463.8108.0	TRAC Precise machine torch holder 35 mm For oxy-fuel cutting		463.8120.0	TRAC Manifold 3/3 w/cut-off valve 1/4" For oxy-fuel cutting
	463.8109.0	TRAC Manifold 2x2 metric For oxy-fuel cutting		463.8503.0	TRAC RL CUT Metal box
	463.8110.0	TRAC Manifold 2x2 w/cut-off valve metric For oxy-fuel cutting			
	463.8111.0	TRAC Manifold 2x3 metric For oxy-fuel cutting			

LORCH TRAC RAIL CUT

Lorch Trac RL Cut is a rail-based carriage for cutting and beveling in various applications. Lorch Trac RL CUT is used for oxy-fuel cutting and Lorch Trac RL CUT HS (High Speed) for plasma cutting.



Features and Benefits

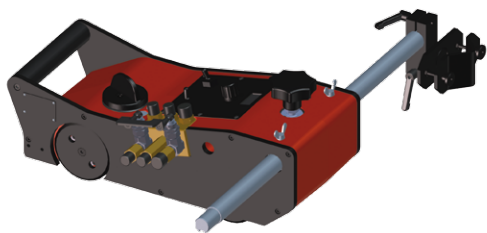
- Cutting and beveling up to 45°, also parallel by means of 2 torches
- 2 wheel drive with auto-braking unit for exact positioning
- Digital speed control system for high precision
- Quick drive release switch for easy re-positioning
- Flexible setup with expandable rail system or directly on the workpiece
- Wide assortment of optional accessories for variety of applications
- Rigid heat-proof design for long life time

Specification

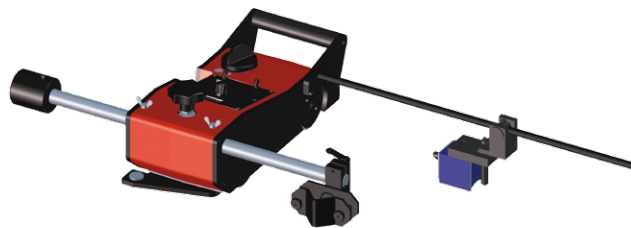


		TRAC RL CUT	TRAC RL CUT HS
Order No.		453.0030.0	453.0031.0
Cutting-position		horizontal	horizontal
Torch diameter	(mm)	28-35	28-35
Speed	(cm/min)	0-150	10-300
Voltage	(V)	230/115 Multivoltage	230/115 Multivoltage
Power	(W)	20	20
Weight, net	(kg)	16,8	16,8
Dimensions (L/B/H)	(mm)	473/655/185	473/655/185

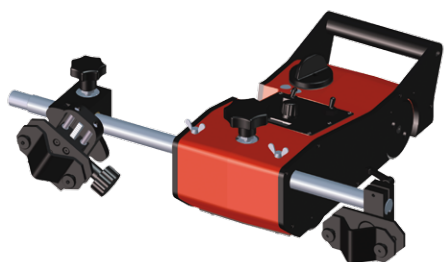
Application spectrum



Standard application



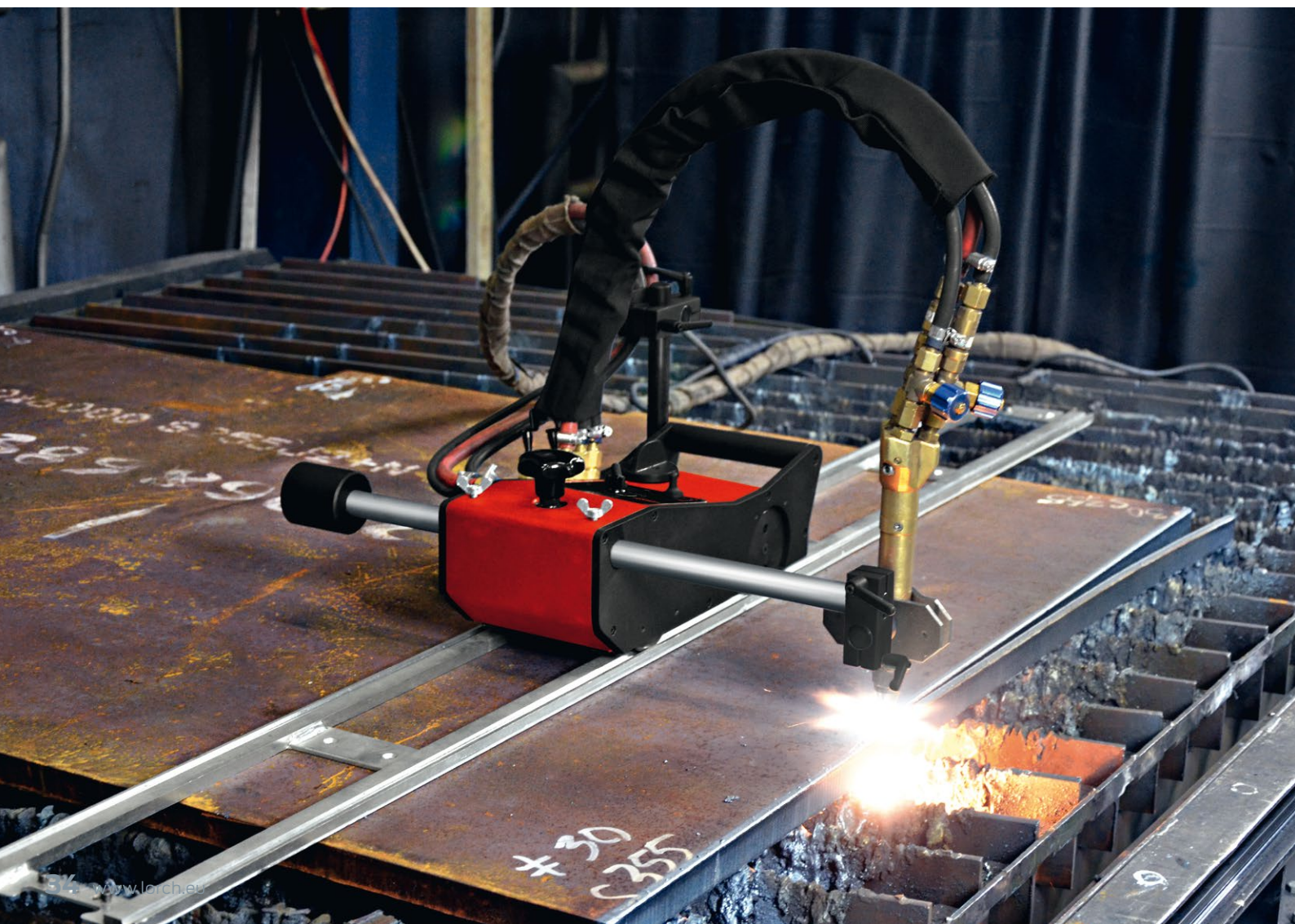
Circular cutting with circle cutting attachment

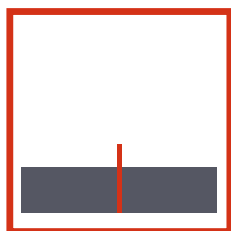


Dual torch assembly for simultaneous cutting and beveling of workpieces

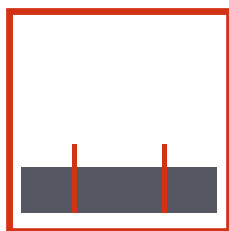


Cutting with heat protection shield

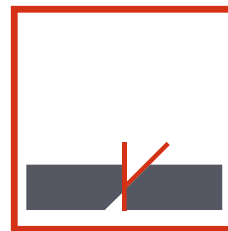




Straight cut



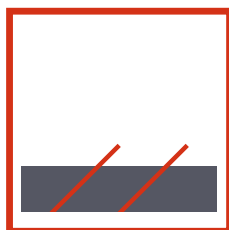
Straight cut with 2 torches simultaneously



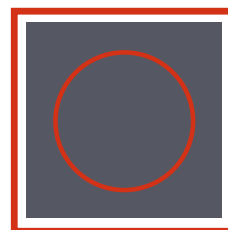
Cutting and beveling in one-shot process



Oblique cut








Oblique cut with 2 torches simultaneously

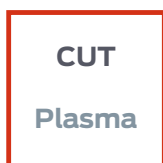


Circular cutting




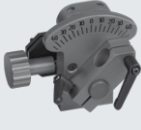
















Scope of delivery

Order No.	Description
	TRAC RAIL RL CUT or TRAC RAIL RL CUT HS
 463.8123.0	TRAC Standard torch holder angle adjust
 463.8100.0	TRAC Geared rack 540 mm For TRAC RL Length 540 mm, Length Geared rack 480 mm
 463.8150.0	TRAC Counterweight
 463.8214.0	TRAC Power cord 230 V EU Cable length 3 m

Cutting technology
















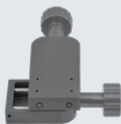
Accessories for LORCH TRAC RL CUT

	Order No.	Description		Order No.	Description
	463.8100.0	TRAC Geared rack 540 mm For TRAC RL Length 540 mm Length Geared rack 480 mm		463.8156.0	TRAC Cable anchor RL for hose-package
	463.8101.0	TRAC Geared rack 300 mm For TRAC RL Length 301 mm Length Geared rack 241 mm		463.8104.0	TRAC Prec. torch-holder angle-hght adj
	463.8102.0	TRAC Geared rack 700 mm For TRAC RL Length 707 mm Length Geared rack 647 mm		463.8105.0	TRAC Machine barrel torch holder 30 mm For oxy-fuel cutting
	463.8103.0	TRAC Geared rack 1000 mm For TRAC RL Length 1000 mm Length Geared rack 940 mm		463.8106.0	TRAC Machine barrel torch holder 35 mm For oxy-fuel cutting
	463.8150.0	TRAC Counterweight		463.8107.0	TRAC Precise machine torch holder 30 mm For oxy-fuel cutting
	463.8151.0	TRAC Large counterweight		463.8108.0	TRAC Precise machine torch holder 35 mm For oxy-fuel cutting
	463.8152.0	TRAC CUT Track 180 cm		463.8157.0	TRAC Circle cutting attachm 240-1000 mm
	463.8153.0	TRAC Roller supporter		463.8158.0	TRAC Circle cutting attachm 400-2500 mm
	463.8154.0	TRAC Clamping block small		463.8159.0	TRAC Plasma arc ignition
	463.8155.0	TRAC Clamping block large		463.8160.0	TRAC Arc ignition cable plasma Delivered without plug for the plasma power source

Accessories for LORCH TRAC RL CUT

Order No.	Description	Order No.	Description
	463.8109.0 TRAC Manifold 2x2 metric For oxy-fuel cutting		463.8119.0 TRAC Manifold 3/3 1/4" For oxy-fuel cutting
	463.8110.0 TRAC Manifold 2x2 w/cut-off valve metric For oxy-fuel cutting		463.8120.0 TRAC Manifold 3/3 w/cut-off valve 1/4" For oxy-fuel cutting
	463.8111.0 TRAC Manifold 2x3 metric For oxy-fuel cutting		463.8161.0 TRAC Heat protection shield left
	463.8112.0 TRAC Manifold 2x3 w/cut-off valve metric For oxy-fuel cutting		463.8162.0 TRAC Heat protection shield right
	463.8113.0 TRAC Manifold 3/3 metric For oxy-fuel cutting		463.8163.0 TRAC Heat protection shield bottom
	463.8114.0 TRAC Manifold 3/3 w/cut-off valve metric For oxy-fuel cutting		463.8121.0 TRAC Track dual magnetic unit
	463.8115.0 TRAC Manifold 2x2 1/4" For oxy-fuel cutting		463.8200.0 TRAC Isolation tube For torch holder
	463.8116.0 TRAC Manifold 2x2 w/cut-off valve 1/4" For oxy-fuel cutting		463.8201.0 TRAC Short rod assy
	463.8117.0 TRAC Manifold 2x3 1/4" For oxy-fuel cutting		463.8202.0 TRAC Long rod assy
	463.8118.0 TRAC Manifold 2x3 w/cut-off valve 1/4" For oxy-fuel cutting		463.8203.0 TRAC Short rod torch holder with clip Set incl. 463.8200.0, 463.8201.0, 463.8068.0, for torch-Ø 16-22 mm

Accessories for LORCH TRAC RL CUT

	Order No.	Description		Order No.	Description
	463.8204.0	TRAC Long rod torch holder with clip Set incl. 463.8200.0, 463.8202.0, 463.8068.0 for torch-Ø 16-22 mm		463.8212.0	TRAC Start-Stop arc ignition cable Allows connection with one or two welding inverters via remote control interface, cable length 6.5 m
	463.8205.0	TRAC Short rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 for torch-Ø 16-22 mm		463.8214.0	TRAC Power cord 230 V EU Cable length 3 m
	463.8206.0	TRAC Long rod torch holder assy Quick-lock set incl. 463.8200.0, 463.8201.0, 463.8209.0 for torch-Ø 16-22 mm		463.8213.0	TRAC Power cord 115 V US Cable length 3 m
	463.8207.0	TRAC Standard torch holder 28-35 mm		463.8215.0	TRAC Power cord 230 V AUS Cable length 3 m
	463.8208.0	TRAC Torch holder clamp 22-35 mm		463.8216.0	TRAC Power cord 115 V UK Cable length 3 m
	463.8209.0	TRAC Quick torch holder clamp 16-22 mm			
	463.8123.0	TRAC Standard torch holder angle adjust			
	463.8124.0	TRAC Slide rack holder			
	463.8210.0	TRAC Cross slide assembly With two traverse axes, each 35 mm			
	463.8211.0	TRAC Cross slide assembly extended With two traverse axes, horizontal 35 mm and vertical 76 mm			

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