



**WTC MACHINERY** Engineered to perform. Built to last.

WTC Machinery is a global leader in designing and building machinery and tooling for heavy equipment repair facilities.

## CR10 Roller & Idler Rebuilder

### Rebuild worn idlers and rollers more efficiently.

WTC Machinery's CR10 Roller Idler Rebuilder is the modern, efficient way to rebuild worn idlers and rollers. Two high amperage weld heads, each with its own power source, assure high deposition rates with both circumferential (stringer) and oscillate (cross) welding methods.

### Easy Flange Welding

The simple, straightforward controls make operation a cinch. The CR10's standard power yoke tilts up to 45 degrees in both directions, to facilitate flange welding. The high capacity wire holders, flux hopper and included flux recovery system provide uninterrupted welding for the biggest orders.

An optional jib crane, "J" hooks and lifting tongs allow the CR10 to work without forklifts or building cranes, and an optional water system eliminates bore shrinkage when welding assembled rollers.



### Specifications:

Maximum Workpiece Weight:	2000 lbs (910 kg)
Maximum Workpiece Diameter:	52 inches (1320 mm)
Maximum Workpiece Width:	26 inches (660 mm)
Welding Torches:	2 x 600 Amps
Wire Barrel Size:	Weight - 2 x 1,200 lb (540 kg)
Outside Diameter:	24 in (628 mm)

Will also work with 120 lb wire spools

### Electrical

Electrical Supply:	77 kW
Standard Voltages:	Three Phase
	208V / 60 Hz
	220V / 50 Hz
	230V / 60 Hz
	380V / 50 Hz
	415V / 50 Hz
	460V / 60 Hz



**CR-10 Idler/Roller Welder Specifications**

**MACHINE DIMENSIONS**

	<b>Weight</b>	<b>Width</b>	<b>Height</b>	<b>Length</b>
<b>Main Welder</b>	5000 lbs (2270 kg)	90 in (2,3 m)	130 in (3,3 m)	80 in (2,0 m)
<b>Power Supplies (X 2)</b>	800 lbs (370 kg) each	24 in (0,7 m)	36 in (0,9 m)	42 in (1,1 m)
<b>Flux Recovery Pump</b>	200 lbs (90 kg)	19 in (0,5 m)	30 in (0,8 m)	37 in (1,0 m)
<b>Water Cooling System (Optional)</b>	150 lbs (70 kg)	15 in (0,4 m)	27 in (0,7 m)	30 in (0,8 m)

Operating Temperature Range ..... 40° to 110° F (4° to 43° C)

**WORKPIECE DIMENSIONS**

Maximum Weight.....2000 lbs (910 kg)  
 Maximum Diameter..... 52 inches (1320 mm)  
 Maximum Width ..... 26 inches (660 mm)

**MACHINE SUPPLY**

**Compressed Air Requirement** - 80 to 120 p.s.i. (5,5 to 8,3 atm) 5.0 ft<sup>3</sup>/min (0,15 m<sup>3</sup>/min)

**WELDING POWER SUPPLIES**

Two Welding power supplies -

<b>Output</b>	<b>Power Requirements - (26.0 kVA each)</b>	
	<b>Voltage</b>	<b>Current</b>
Maximum Current .....600 Amperes	230 Volts	113.0 Amperes each
Maximum Voltage ..... 50 Volts	380 Volts	69.0 Amperes each
Duty Cycle..... 100%	460 Volts	56.5 Amperes each
	Other voltages available	

**FLUX RECOVERY SYSTEM**

	<b>Power Requirements - (1½ Hp 1.1 kW)</b>	
	<b>Voltage</b>	<b>Current</b>
Flux Pump Type..... 2-Lobe "Roots" Type		
Flux Hopper Capacity..... 4900 in <sup>3</sup> (81 liters)	230 Volts	5.4 Amperes
	380 Volts	3.0 Amperes
	460 Volts	2.7 Amperes
	Other voltages Available	

**WIRE PAY-OUT PAK**

Two Pay-out Paks -

Capacity sized for all popular welding wire barrel containers

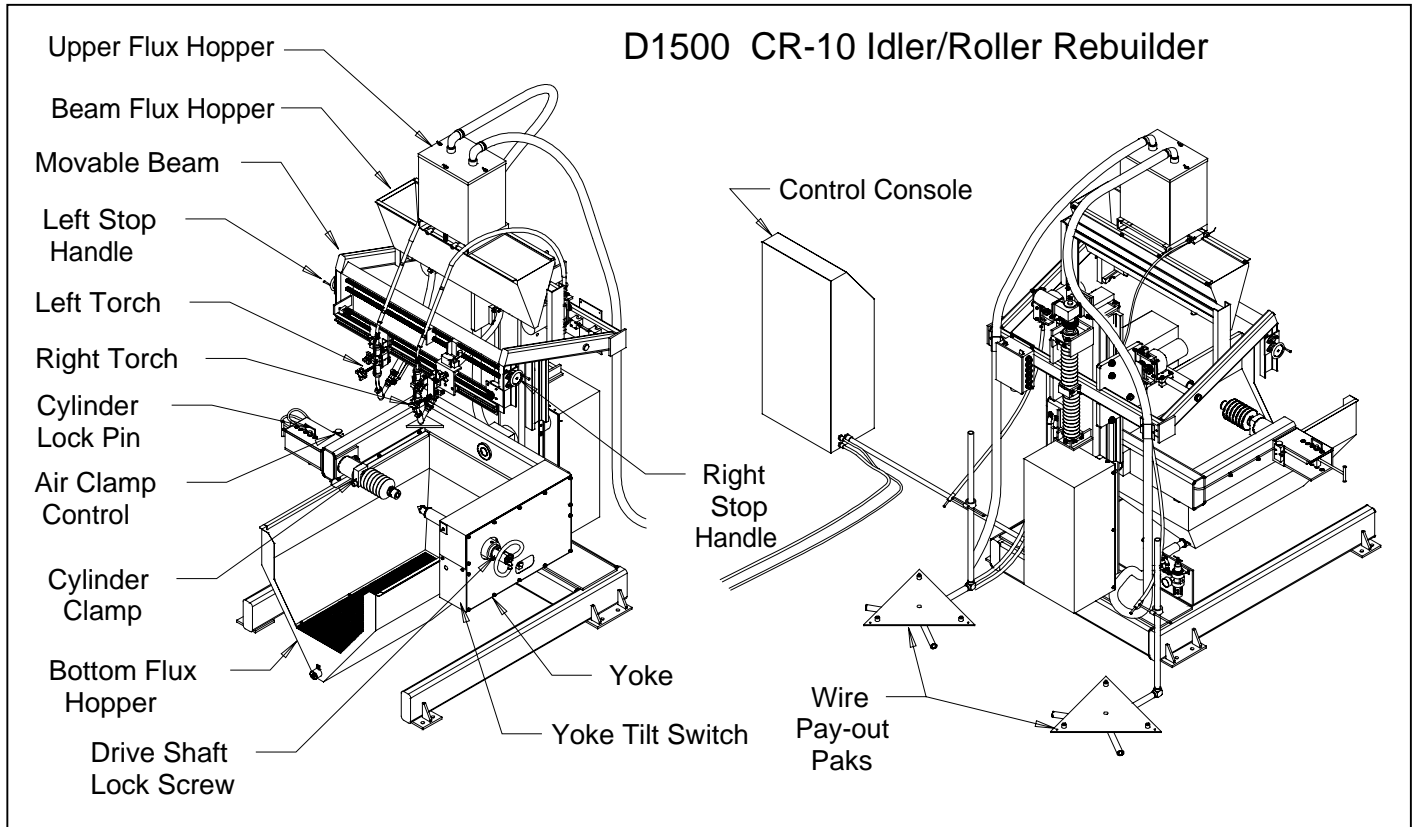
Maximum Wire Barrel Diameter ..... 24 in (628 mm)  
 Minimum Wire Barrel Diameter ..... 6 in (152 mm)  
 Maximum Wire Barrel Weight ..... 1200 lb (540 kg)

**WATER COOLING SYSTEM (Optional)**

Used in roller service, the Water Cooling System transfers heat from the roller currently being welded to next roller to be welded. This eliminates bore shrinkage, and shortens pre-heat time. The included Adapter Kit allows use with most undercarriage types.

**SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE**

**Control Identification**



**AIR CLAMP CONTROL** - controls the air clamp to hold the idler or roller in place. Pressing down on the control clamps the workpiece (idler or roller), pulling up releases the workpiece.

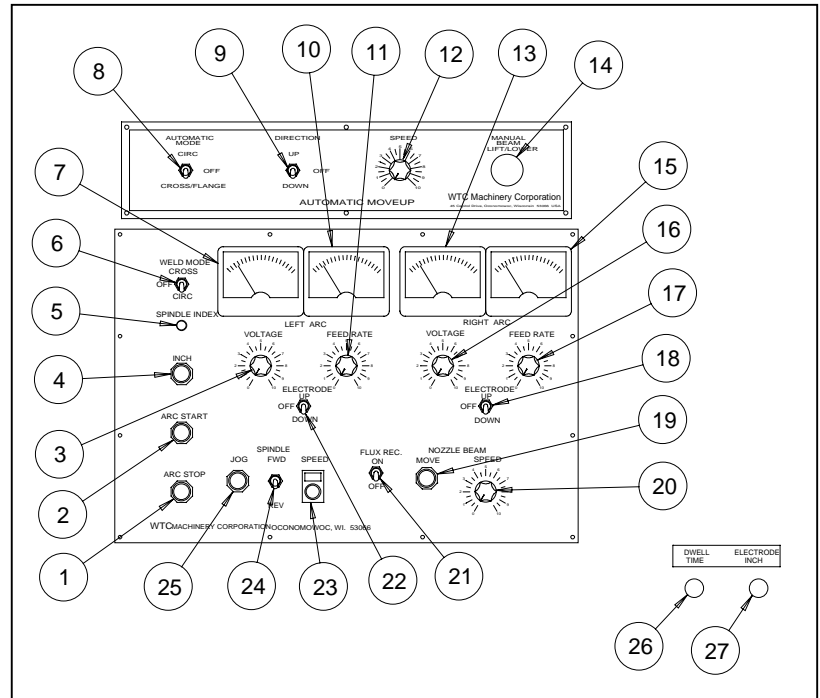
**LEFT STOP HANDLE** - sets the point at which the torches will stop traveling left, either in CIRC Mode step-over, or in CROSS Mode travel

**RIGHT STOP HANDLE** - sets the point at which the torches will stop traveling right, either in CIRC Mode step-over, or in CROSS Mode travel

**YOKE TILT** - tilts the yoke and workpiece clockwise or anti-clockwise.

**Control Identification (Continued)**

- 1) ARC STOP - Stops the welding cycle
- 2) ARC START - Starts the welding cycle
- 3) LEFT VOLTAGE - Controls the voltage of the Left Torch Head
- 4) INCH - Manually moves the Left and Right welding wire
- 5) SPINDLE INDEX - Lights at the Step-over point
- 6) WELD MODE - selects the welding mode :  
 CIRC (Circumferential or Stringer) Mode constantly turns the idler or roller beneath the torch heads. Once every revolution the torches step to the left or right to overlap the previous weld bead.



CROSS Mode moves the torch heads left and right over the roller or idler. At each end of the torch travel, the idler or roller turns briefly, overlapping the previous weld bead.

- 7) LEFT VOLTMETER - Displays the voltage of the Left Torch Head
- 8) MOVEUP AUTOMATIC MODE - selects the Moveup mode  
 CIRC Mode raises the Beam and torch heads when the torches reach the right or left End-of -Travel  
 CROSS/FLANGE raises the Beam and torch heads at the Spindle Index Point
- 9) MOVEUP DIRECTION - selects the direction the Beam moves, or turns the Moveup off.
- 10) LEFT WIRE FEED METER - shows the speed of the wire feeding through the Left Torch Head. This is directly related to the Amps of the Left Torch
- 11) LEFT FEED RATE - sets the speed of the Left welding wire once the welding arc is established. This is directly related to the Amps at the Left Torch Head.
- 12) MOVEUP SPEED - sets the speed the torches move up and down. It also controls how far the torches move in the Automatic Modes; a higher speed will mean a larger automatic moveup.
- 13) RIGHT VOLTMETER - Displays the voltage of the Right Torch Head
- 14) MANUAL BEAM LIFT/LOWER -This moves the torches close to or away from an idler or roller. Pulling out on the pushbutton starts the torches moving. Pushing in on the pushbutton stops the torches.
- 15) RIGHT FEED RATE - sets the speed of the Right welding wire once the welding arc is established. This is directly related to the Amps at the Right Torch Head.
- 16) RIGHT VOLTAGE - Controls the voltage of the Right Torch Head

***Control Identification (Continued)***

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- 17) RIGHT FEED RATE - sets the speed of the Right welding wire once the welding arc is established. This is directly related to the Amps at the Right Torch Head.
- 18) RIGHT ELECTRODE UP/OFF/DOWN - selects the direction of the right welding wire. Welding happens in the DOWN position
- 19) NOZZLE BEAM SPEED - sets how fast the left and right troches move from side-to-side
- 20) NOZZLE BEAM MOVE - manually moves the left and right troches from side-to-side
- 21) FLUX RECOVERY ON/OFF - starts and stops the flux recovery system
- 22) LEFT ELECTRODE UP/OFF/DOWN - selects the direction of the left welding wire. Welding happens in the DOWN position
- 23) SPINDLE SPEED - sets the speed the idler or roller rotates
- 24) SPINDLE FWD/REV - selects whether the idler rotates forward (top away from the front) or reverse (top towards the front)
- 25) SPINDLE JOG - manually rotates the idler or roller
- 26) DWELL TIME (on the control console's right side) - sets how long a period the idler or roller rotates a each end of CROSS Mode travel
- 27) ELECTRODE INCH - sets how fast the left and right welding wire travel before an arc is struck. This is set to a meter reading of 30 for welding, but increased to allow faster loading of new wire.



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## **MANUFACTURERS/BENEFICIARY'S WARRANTY CERTIFICATE WTC MACHINERY, LLC WARRANTY**

WTC MACHINERY, LLC warrants its products to be free from defects in material and workmanship under normal use and service for a period of twelve (12) months after date of shipment. WTC MACHINERY, LLC undertakes to be responsible for any defect that may arise due to faulty raw materials, design, workmanship and defective parts and to replace them without extra cost. Freight charges are the customer's responsibility. Our warranty is not transferable.

WTC MACHINERY, LLC shall have the option of requiring the return of all parts claimed defective. Parts proved to be defective, due to defect in workmanship and/or material, shall be either repaired or replaced free of charge, F.O.B. our designated factory. All parts warranty claims are subject to inspection by WTC MACHINERY, LLC and acceptance at the factory

Our warranty does not obligate us to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts and the removal and/or remounting of the parts repaired or replaced under this warranty, unless specifically authorized in writing by WTC MACHINERY, LLC. All parts returned to the factory must be shipped freight prepaid; no collect freight will be accepted by the factory. Forms authorizing such returns for inspection must accompany all returns.

This warranty shall not apply to products not manufactured by WTC MACHINERY, LLC. Outside purchased equipment and accessories (not of WTC manufacture) are warranted only to the extent of the original equipment manufacturer's warranty and subject to their allowance to WTC MACHINERY, LLC. In this respect, our warranty obligations must conform and be limited to the warranty extended to WTC MACHINERY, LLC by its suppliers as extended to the customer.

We shall, in no event, be liable for consequential damages or contingent liability arising out of the failure of any unit or part to operate properly, or that is subject to:

- Ordinary operating wear, abuse, misuse, or overloading;
- Repairs or alterations by parties other than WTC MACHINERY, LLC;
- The use of improper fluids, contaminated fluids or improper filtering;
- The use of improper voltage hookup in the electrical connections of any equipment;
- Negligence, accident or damages due to deterioration during periods of storage by the purchaser prior to installation and operation;
- Damages occurred in shipment after leaving factory en route to customers' delivery point, as title to equipment passes to customer when loaded onboard for shipment, f.o.b. factory, and customer must place his own claim against damaged goods directly to the shipping company and not against WTC MACHINERY, LLC, its factory, or any of its personnel.
- Damages due to circumstances beyond the control of WTC MACHINERY, LLC and in connection with fulfilling any obligation under this warranty.

To the maximum extent permitted by applicable law, in no event shall WTC Machinery, LLC be liable for indirect, special, incidental or consequential damages resulting from personal injury, loss of business profits or business interruption from the use of its products, or from the inability to use its products.

This warranty is exclusive and is in lieu of all other expressed and implied warranties, including but not limited to implied warranties or merchantability and fitness for a particular purpose. WTC MACHINERY, LLC shall not be subject to any other obligations or liabilities whatsoever with respect to equipment manufactured or supplied by WTC MACHINERY, LLC, or services rendered to it.