

# GLEASON STATEMENT OF POLICY

**EFFECTIVE:** January 1, 2006    **SUPERSEDES:** All previous price lists    **PRICES STATED:** In US Dollars

**FREIGHT POLICY:** F.O.B. Winona, Minnesota 55987 (USA)

**DOMESTIC TERMS:**

**SUPPLIES** - Credit Card, Net 30 days after invoice date for approved accounts. Interest at maximum rate permitted by law will be charged on delinquent accounts. Delinquent account balance may be charged to credit card. Terms of payment are not based on receipt of shipment as transportation delays are beyond our control.

**IN-STOCK MACHINES** - (M-2) 10% down payment with order, Net balance due upon set up and training.

**NON-STOCK MACHINES** - (M-3, GFO-12, GFO-32, SPM-3) 50% down payment with order, Net balance due upon set up and training.

**EXPORT TERMS:**

**SUPPLIES** - Credit Card, Wire Transfer or L/C prior to shipment.

**MACHINES** - 10% with order on In-Stock Models (M-2); 50% with order on Non-Stock Models (All other models); Net balance due by Wire Transfer or Irrevocable L/C, Paid at Sight, Confirmed through a USA Bank prior to shipment. Banking charges to the account of the buyer. Contact Gleason for L/C instructions.

**MINIMUM ORDERS:** \$20.00. Please give Model Number when ordering machines.

**PRICES:** Prices shown do not include any State or Local Excise, Sales or Occupational Taxes. Prices subject to change without notice.

**SHORTAGE CLAIMS:** Any claims for shortages or loss must be reported within 10 days of receipt of shipment. Claims for shipping loss or damage should be handled directly with the carrier.

**RETURN OF GOODS:** Goods may not be returned to the factory without written approval.

**NOTE:** We reserve the right to make continuing changes in our products without incurring any obligation on units previously sold. Product specifications, design, prices, and terms are subject to change without notice.

Gleason Engineering Industries, Inc.  
accepts these credit cards:



**LIMITED WARRANTY**

Gleason Engineering Industries, Inc., (hereinafter "GEII") warrants products manufactured and sold by it to be free from defects in material and workmanship for a period of 24 months from the date of shipment, except that parts sold for the repair or replacement of existing equipment will only be warranted for a period of 90 days from the date of installation.

If, upon inspection by GEII, any warranted product shall prove defective in materials or workmanship during the warranty period, that product shall be repaired or replaced at GEII's option if the buyer, at its sole expense, returns the products to GEII. Such repair or replacement shall be GEII's sole obligation and the buyer's exclusive remedy under this warranty.

This warranty supersedes all prior oral or written agreements, statements, promises, advertising or representations. **THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER REPRESENTATIONS AND WARRANTIES, EXPRESS OR IMPLIED, AND GEII EXPRESSLY DISCLAIMS AND EXCLUDES ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION OF THE FACE HEREOF.**

GEII's liability in contract, in tort (negligence, strict liability, or any other theory), under any warranty, or under any other legal or equitable theory of whatever type, shall not exceed the purchase price paid by buyer, and under no circumstances shall GEII be liable for special, indirect, incidental or consequential damages. The amount of the purchase price of the equipment is determined in part by the fact that buyer has agreed to so limit seller's liability.

No action arising out of any transaction under this agreement may be brought by purchaser more than one year after the cause of action has accrued.

Some states do not allow an exclusion or limitation of consequential or incidental damages, so the above limitation of liability may not apply to you.

**WARNING!**

Equipment offered in this price list is potentially dangerous, especially in the hands of untrained personnel. Always be certain that the operator is trained in its operation and has read, studied and understands all operational instructions and warnings supplied with this equipment. If any of this material is unclear, contact the factory for clarification before use. Additional copies of Operators Manuals and Warning Decals are available from the factory. Failure to follow the warnings may result in property damage and personal or fatal injury. **Wear Safety Glasses.**

**Gleason Engineering Industries, Inc.**

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# Gleason Engineering Industries, Inc.

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Effective

## PRICE LIST

January 1, 2006

### GLEASON PROCESS CRANKSHAFT WELDING MACHINES

MODEL	DESCRIPTION	PRICE
<b>M-2</b>	8" (203mm) Chuck, 8" (203mm) Stroke, 22" (558mm) Swing, 48" (1219mm) Carriage Travel -- Turning crankshafts end for end, the machine will handle crankshafts up to 96" (2438mm). Maximum crank weight 600 lbs (272kg) Boxed Dimensions 96" (2438mm) L x 48" (1219mm) W x 72" (1828mm) H Boxed Shipping Weight 2400 lbs (1088kg) 300 Amp Output Power Supply	<b>32,995.00</b>
<b>M-3B</b>	13" (330mm) Chuck, 12.25" (311mm) Stroke, 28" (711mm) Swing, 104" (2641mm) Carriage Travel -- Turning crankshafts end for end, the machine will handle crankshafts up to 208" (5283mm). Maximum crank weight 4000 lbs (1814kg) Boxed Dimensions 192" (4876mm) L x 78" (1981mm) W x 84" (2133mm) H Boxed Shipping Weight 5500 lbs (2494kg) 500 Amp Output Power Supply	<b>65,500.00</b>

**PLEASE SPECIFY VOLTAGE**

**AMPERAGE REQUIRED**

208/230/250V OR 380/415/440V 50/60 Hz 3 Phase

M-2/30 Amps M-3B/50 Amps

### Standard Equipment Included With M-2 & M-3B

- |  |  |
|--|--|
| 1 Operational Manual   | 1 Slag Tray  |
| 1 Electronic Step Over System / E.S.O.                             | 1 Trough Heat Shield   |
| 1 Voltage Micro Adjust Circuit / MAVC-2                            | 1 Flux Dam With Extra Shield                                       |
| 1 Electronic Weld Deposit Height Meter                             | 1 Flux Valve Swivel Bearing Lock Screw                             |
| 1 High Volume Low Pressure Flux Pump System                        | 1 Crankshaft Leveling Height Gauge (Chromed)                       |
| 1 Flux Dust Control System (M-2 Only)                              | 1 Set Up Bar (Chromed)   |
| 1 Electronic Weld Deposit Width Meter                              | 1 Torch Angle Gauge  |
| 1 Dual Wire Spool Dust / Humidity Proof Cabinet                    | 1 Blow Gun   |
| 1 Dual Electrode Wire Feed Circuit                                 | 1 Torch - Curved   |
| 1 Semi-Auto Oil Hole Bumper Circuit                                | 1 Torch - Straight   |
| 1 Automatic Torch Lock   | 1 Torch Jam Nut  |
| 1 Digital Automatic Surface Speed Indicator Circuit                | 1 Single Buss Bar  |
| 1 Electronic Wire Speed Control                                    | 1 Dual Buss Bar  |
| 1 Automatic Flux Gate  | 1 Outlet Conduit Spring Liner (Single High Speed)                  |
| 1 Power Booster Circuit  | 2 Outlet Conduit Spring Liner (Dual)                               |
| 1 Automatic Stroke Indicator                                       | 1 Torch Spring Liner (For Curved Torch)                            |
| 1 Motorized Torch For Automatic Thrust Build Up                    | 1 Torch Ridged Liner (For Straight Torch)                          |
| 1 Crankshaft Hardness Tester                                       | 1 Outlet Wire Feed Conduit (Single)                                |
| 1 Digital Infra-Red Pyrometer                                      | 2 Outlet Wire Feed Conduit (Dual)                                  |
| 1 Air Rotary File & 2 Carbide Burr Tips (1 Tapered / 1 Round)      | 2 Inlet Wire Feed Conduit (Dual)                                   |
| 1 Heating Torch - Rosebud Torch Handle W/ Torch Head               | 6 Contact Tips .040" I.D.  |
| 1 Gleason Process #1 Kastalloy Universal Build Up Kit (.035" Wire) | 6 Contact Tips .044" I.D.  |
| 1 Gleason Process 2235HD Diesel Build Up Kit                       | 6 Contact Tips .060" I.D.  |
| 1 Gleason Process 2245HD Diesel Build Up Kit (M-3 Only)            | 6 .060" I.D. Curved 30° Tip For Thrust Weld                        |
| 1 Calipers 6"  | 6 .060" I.D. Curved 15° Tip For Journal Weld                       |
| 1 Chuck Wrench   | 1 Crankshaft End Support (M-3 Includes 2 End Supports)             |
| 1 1/8" Allen Wrench  | 2 Crankshaft End Support Roller Bearings (M-3 Includes 4 Bearings) |
| 1 5/16" Allen Wrench   | 2 1 Amp Fuses  |
| 4 Chuck Lock Knobs   | 2 3 Amp Fuses  |
| 3 Reverse Jaws   | 2 15 Amp Fuses   |
| 1 Flux Chute   | 1 300 Amp Safety Fuse (M-3 500 Amp Safety Fuse)                    |
| 1 Flux Chute Lock Collar   | 2 Operator Light Bulbs   |
| 2 Flux Pump Liners 1-1/2"  | 2 Oil Hole Bumper Magnetic Bumper Arrows                           |
| 1 Flux Pump Filter Hose  | 1 Pair Safety Glasses  |
| 1 Flux Cleaning Sieve  | 1 Pair Of Diagonal Cutters   |
| 1 Chipping Hammer (Pre - Sharpened)                                | 1 1 oz. Nicheck Nitride/Tufftride Test Fluid.                      |

# GLEASON OVENS & CRANKSHAFT STRAIGHTENING PRESS

MODEL	DESCRIPTION	PRICE
<b>GFO-12</b>	<b>GLEASON HEAT TREATING / CLEANING OVEN</b>	<b>33,900.00</b>
<b>GFO-32</b>	<b>GLEASON HEAT TREATING / CLEANING OVEN</b>	<b>46,500.00</b>

## MACHINE FEATURES

- The combination ovens provide a HEAT CLEANING mode for crankshafts, heads, blocks, etc. and a HEAT TREATING mode to process crankshafts to proper Rockwell "C" hardness when using the GLEASON PROCESS.
- These units feature a sealed primary heating chamber with a modulating burner, two stage controlled air flow system, separate afterburner, temperature control/recording system, over temperature water suppression system, and self-supporting refractory lined stack. This unit typically holds temp to  $\pm 2 F^{\circ}$  which is necessary for success of the process.

## SPECIFICATIONS

	<b>GFO-12</b>	<b>GFO-32</b>
Inside Dimension Over Cart (LxWxH)	72" x 20" x 20" (1829mm) x (508mm) x (508mm)	96" x 24" x 24" (2438mm) x (609mm) x (609mm)
Volume	12 Cubic Feet	32 Cubic Feet
Cart Load Capacity	3,000 lbs	3,600 lbs
Design Charge Weight	1,000 lbs	1,500 lbs
Operating Temperature	Primary 100 F – 1400 F Secondary 1200 F – 1400 F	Primary 600 F – 850 F Secondary 1200 F – 1400 F
Burner Capacity	Primary 200,000 BTU Secondary 200,000 BTU	Primary 200,000 BTU Secondary 200,000 BTU
Afterburner Combustible Rating	7 lbs/hr	7 lbs/hr
Oven Plus Stack Height	15 ft	16 ft
Floor Space Required	4 ft x 15 ft	4 ft x 20 ft
Boxed Dimensions	144" L x 60" W x 60" H (3657mm) x (1524mm) x (1524mm)	144" L x 72" W x 78" H (3657mm) x (1828mm) x (1981mm)
Boxed Shipping Weight	4,200 lbs (1905kg)	4,700 lbs (2131kg)
<b>UTILITIES</b>		
Natural Gas at 6" – 8" WC	Max. Cap. 400 CFH Normal Cap. 250 CFH	Max. Cap. 400 CFH Normal Cap. 250 CFH
Propane at 6" – 8" WC	Max. Cap. 200 CFH Normal Cap. 125 CFH	Max. Cap. 200 CFH Normal Cap. 125 CFH
Electrical 220 or 380V/3 Ph/50/60 Hz	11 Amps	11 Amps
Water 3/4" Connection	40 PSI Min.	40 PSI Min.

<b>SPM-3</b>	<b>HEAVY DUTY CRANKSHAFT STRAIGHTENING PRESS</b>	<b>32,995.00</b>
<b>SPM-3B</b>	<b>HEAVY DUTY CRANKSHAFT STRAIGHTENING PRESS 24" (609mm) Bed Extension</b>	<b>33,995.00</b>

## MACHINE FEATURES

- Remote located hydraulic pump and all electrical controls mounted on movable hand truck.
- Push button operated automatic motorized overhead crankshaft clamping system holds crankshaft down while hydraulic ram pushes up, allowing access topeen the inside of connecting rod journal to be straightened.
- Special roller end support design to allow placement of hydraulic ram directly under #1 rod journal without interference.
- Two stage hydraulic pump provides rapid movement of ram to save time.
- Air peening hammer included.
- Motorized hydraulics.
- SPM-3 features all components from OTC, the finest name in hydraulics.

## SPECIFICATIONS

	<b>SPM-3</b>	<b>SPM-3B</b>
Max. length of workpiece	108" (2743mm)	132" (3352mm)
Max diameter of workpiece	12" (304mm)	12" (304mm)
Max. swing of workpiece	24" (609mm)	24" (609mm)
Machine Dimensions	131" L x 61" W x 74" H (3327mm) x (1549mm) x (1879mm)	155" L x 61" W x 74" H (3937mm) x (1549mm) x (1879mm)
Boxed Dimensions	145" L x 73" W x 85.5" H (3683mm) x (1854mm) x (2171mm)	169" L x 73" W x 85.5" H (4292mm) x (1854mm) x (2171mm)
Boxed Shipping Weight	536 Cubic Feet 2700 lbs (1224kg)	610 Cubic Feet 3000 lbs (1360kg)
Max. Hydraulic Ram Pressure	110,000 lbs (49,895kg)	110,000 lbs (49,895kg)
Electrical	220V/1 Phase/20 Amps/50/60 Hz	220V/1 Phase/20 Amps/50/60 Hz

# GLEASON MASTER PARTS LIST

Part #	Description	Price	Part #	Description	Price
MA-11	Chipping Hammer	30.00	SP-22C	Flux Pump Liner (Used with 1 - 1/2")	20.00
MA-12	Templestick 450° F	12.50	SP-22E	Flux Pump Outlet Nipple 1-1/4" or 1-1/2" (Specify Size)	45.00
MA-13	Templestick 150° F	12.50	SP-23	Drive Wheel Complete	156.00
MA-14	Templestick 750° F	12.50	SP-24	Flux Gate Rubber Valve Seat	15.00
MA-20	Templestick 250° F	12.50	SP-37	Vertical Torch Bar Block	225.00
MA-15	Calipers 6" (To determine diameter of journal)	40.00	SP-39	Air Cylinder Flux Gate Assembly	263.00
MA-16	Measuring Tape (Adhesive Backed)	20.00		Contains flux gate, inspection plate, air cylinder, and hoses mounted	
MA-18	Height Gauge	225.00	SP-40	Air Lock Assembly	275.00
MA-18A	M-2 Centering Gauge (chromed)	325.00		Contains airlock, locking pin, eccentric	
MA-29	M-2 Set Up Bar (chromed)	195.00	SP-42B	M-2 Ground Strap W/Locking Collar	225.00
MA-19	Torch Angle Gauge	279.00	SP-43	Flux Pot Tank (M-2)	570.00
MA-21	Nicheck - Nitride/Tuffride Indicating Fluid (2 oz.)	50.00	SP-44	Flux Dam Magnet W/2 Shields	75.00
	Contains enough solution for up to 500 individual check		SP-44A	Flux Dam Shield	22.00
MIC-1	Micro Adjust Rheostat (1 OHM or 2 OHM)	182.00	SP-44B	Flux Dam Magnet	38.00
MIC-1A	Micro Adjust Drive Dogs	65.00	SP-44C	Bumper Arrow Magnet (White)	35.00
MIC-1B	Micro Adjust Filters (5 Per Pkg)	15.00	SP-44D	Bumper Arrow Magnet (Red)	35.00
P-1	Orange Spray Paint	25.00	SP-44E	Bumper Arrow Magnet (Green)	35.00
SP-4	Dual Wire Feed Roll 1/2" I.D. .030", .035", and .045"	75.00	SP-46	Torch Gear Rack Bar	350.00
SP-4C	Wire Feed Roller Adj. Collar	5.50	SP-47	Wire Feed Repair Kit	199.00
SP-5	Outlet Wire Guide - (All Models)	72.00		Contains dual wire feed roll, pressure roller, and wire feed cylinder	
SP-6	Outlet Wire Guide Tip - (All Models)	62.00	SP-48	Flux Timer Cam	85.00
SP-7	Outlet Wire Feed Conduit Assy.	41.00	SP-49	Flux Filter System	175.00
SP-8	Outlet Wire Feed Spring Liner Single 36"	18.00	SP-49A	Flux Pump Paper Cartridge Filter	29.50
SP-8A	Outlet Wire Feed Spring Liner - Dual	14.00	SP-49B	Motorized Flux Filter System	149.00
SP-8B	Outlet Wire Feed Spring Liner - Dual M3	14.00	SP-59	Solid Brass Flux Sieve for Strain Cleaning Flux	72.00
SP-9	Torch Spring Liner Flexible W/ Curved Torch SP-12	14.00	TR-1B	Control Transformer (M1/M2 Models)	410.00
SP-9A	Torch Liner Rigid W/ Straight Torch SP-13	18.00	TR-4	Control Transformer (M3/WRG-III)	560.00
SP-9B	Torch Liner Rigid W/ Straight Torch SP-13a	18.00			
SP-10	Inlet Wire Feed Conduit (M1 & M2)	259.00	<b>WELDING CONTACT TIPS</b>		
SP-11	Inlet Wire Feed Conduit (M3 & M4)	479.00	SP-040	.030" Wire Size (.040" I.D.) Straight Contact Tip	3.00
SP-12	Torch-Curved	45.00	SP-044	.035" Wire Size (.044" I.D.) Straight Contact Tip	3.00
SP-13	Torch - Straight	45.00	SP-044C	.030" Wire Size (.044" I.D.) Curved 15° Contact Tip	4.29
SP-13A	Torch - Straight With 15/16" 24 Thread	45.00		for #1 Kit - Steel only #5 Kit - Cast & Steel #7 & #8 Kit	
	For spring loaded contact tips (To be used with SP-060A)		SP-044F	.030" Wire Size (.044" I.D.) Curved 15° Falls Tip	4.25
SP-13B	Heat Shrink Tube for all Torches	3.20		for #5 Kit	
SP-16	Buss Bar Complete Single	175.00	SP-060	.045" Wire Size (.060" I.D.) Straight Contact Tip	3.00
SP-16A	Buss Bar Complete Double	225.00	SP-060A	.045" Wire Size (.060" I.D.) Spring loaded Straight Contact Tip. Must be used with SP-13A Torch	18.75
SP-17	Torch Jam Nut	75.00	SP-060C	.035" Wire Size (.060" I.D.) Curved 15° Contact Tip	4.29
SP-18A	Flux Tube (Flux Chute Slides Over)	78.00		for #1 Kit - 2235D Radius & Journal Kit	
SP-18M	Flux Chute-Modified	112.00	SP-060T	.030" & .035" Wire Size (.060" I.D.) Curved 30° Thrust Contact Tip	4.29
SP-19	Flux Chute Collar	42.00	SP-075	.062" Wire Size (.075" I.D.) Straight Contact Tip	4.00
SP-20	Flux Volume Valve	55.00	SP-075C	.045" Wire Size (.075" I.D.) Curved 15° Contact Tip	4.29
SP-21	Blue Flux Pump Valve Complete	225.00	SP-075T	.045" Wire Size (.075" I.D.) Curved 30° Thrust Contact Tip	4.29
SP-21A	Rubber Seals For Pump Valve - 1 - 1/4" (2)	35.00			
SP-21B	Flux Hose (1" I.D.) (WRG Models)	72.00			
SP-21C	Flux Hose (7/8" I.D.) (MM Models)	67.00			
SP-21E	Rubber Seals For Pump Valve - 1 - 1/2" (2)	35.00			
SP-22	Flux Pump Liner (Used with 1 - 1/4")	20.00			
SP22A	Flux Pump Inlet Nipple 1-1/4" or 1-1/2" (Specify Size)	45.00			

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accepts these credit cards:



**SUPPLIERS OF CRANKSHAFT REBUILDING MACHINERY AND JOURNAL BUILDUP MATERIALS**

# GLEASON MASTER PARTS LIST

Part #	Description	Price	Part #	Description	Price
AC-1	Air Cylinder Flux Gate & Rubber Valve Seat	125.00	EM-9	Flux Pump Gear Motor	175.00
AC-2	Air Cylinder Rotation Lock (Brass)	135.00	EM-10	Fan & Motor Assy (M1/M2 Models)	135.00
AC-3	Wire Feed Pressure Air Cylinder	82.00	EM-11	Fan & Motor Assy (M3 Models) 60Hz	547.00
AC-6	Air Solenoid 3 Way (Old Style)	175.00	EM-12	Fan & Motor Assy (M3 Models) 50Hz	547.00
AC-13	Air Reg. & Gauge For Flux Pump	75.00	EM-13	Rotation Gear Motor	692.00
AC-15	Torch Air Lock Cylinder	95.00	EP-14	Step Over/Bumper Timer-Eso Electronic Type	125.00
AC-15B	Torch Lock Air Cylinder Brass Adj. Knob	98.00	EP-15	Bumper Circuit Relay	72.00
AC-16	Air Solenoid 4 Way (Old Style)	260.00	ER-1	Rheostat Travel Horizontal	75.00
AC-19	Air Regulator Gauge & Filter Complete	125.00	ER-2	Rheostat Wire Speed Control	75.00
AC-20	Air Solenoid 3 Way (New Style-No Manifold)	225.00	ER-3	Rheostat Vertical Motorized Torch	75.00
AC-22	Air Solenoid 4 Way (New Style-No Manifold)	325.00	ER-4	Rheostat Travel Balance-Non Eso Equipped	75.00
BB-1	Pressure Roller (Wire Feed)	42.00	ER-5	Resistor Fixed	47.00
BB-4	End Support Roller Bearing (1)	42.00	ES-1	Line Switch	27.00
BB-5	Dancing Frame Linear Bearing	123.00	ES-1A	Power Booster Switch	27.00
BB-5A	Dancing Frame Linear Bearing Shaft (M-2) 1" x 14"	98.00	ES-2	Power Switch	43.00
E-1	Step Over Timer-Old Style	224.00	ES-2A	Rotation Switch	47.00
E-2	Spindle Brushes 3 Included (WRG M3 Models)	75.00	ES-3	Wire Feed Switch	59.00
E-2A	Spindle Brushes 2 Included (M1, M2 Models)	50.00	ES-4	Jog Switch	59.00
EA-1	D.C. Voltmeter (0-50)	253.00	ES-5	Horizontal Direction Switch	59.00
EA-2	D.C. Ampmeter (0-500)	253.00	ES-5A	Vertical Direction Switch	59.00
EC-1	30 Amp Contactor	135.00	ES-6	Radius-Journal Switch	40.00
EC-2	40 Amp Contactor	170.00	ES-7	Rapid Rotate Switch	45.00
ED-1	500 Amp Rectifier	1025.00	ES-7A	Rotate Reverse Switch	45.00
ED-1B	Clip Cell For 500 Amp Silicon Bridge Rectifier	92.00	ES-8	Push Button Carriage Release Switch	25.00
ED-2	3 Amp Rectifier (See Silicon Bridge Pn #Ed-4)	95.00	ES-9	Roller Micro Switch	59.00
ED-3	1 Amp Rectifier (See Silicon Bridge Pn #Ed-4)	85.00	ES-10	Voltage Selector Switch (M1/M2 Light Duty)	325.00
ED-4	Silicon Diode Bridge-30 Amp Replaces Selenium Rectifier #ED-2 & ED-3	75.00	ES-11	Voltage Selector Switch (M/3 Heavy Duty)	365.00
EF-1	1/2 Amp Fuse	2.96	ES-12	Tippett Switch Neon (Wrg Models)	44.00
EF-2	3 Amp Fuse	2.96	ES-13	Push Button Boot	7.25
EF-3	10 Amp Fuse	2.96	ES-14	Toggle Switch Boot	7.25
EF-4	Fuse Holder	4.50	ES-15	Black Pointer Knob	8.50
EF-5	500 Amp Fuse For 500 Amp Power Supply	27.99	ES-17	Wire Feed Switch 3 Pole	59.00
EF-6	1 Amp Fuse	2.96	ES-18	Bumper Circuit Button	27.00
EF-7	300 Amp Fuse For 300 Amp Power Supply	27.99	ES-19	Air Switch To Engage Horizontal Traverse Motor	95.00
EL-1	Panel Light Amber	10.25	ET-1	Transformer Variable (Rotation Variable)	275.00
EL-2	Panel Light Red	10.25	ET-1A	Variable Replacement Brush	35.00
EL-3	Operator Light Bulbs	13.50	FB-3	Flux Valve Swivel Bearing Assembly	277.50
EM-1	Wire Feed Gear Motor Single Wire (Low Speed)	375.00	GR-1	Torch Rack Gear	45.00
EM-2	Wire Feed Gear Motor Double Wire (Low Speed)	395.00	MA-1	Gleason Oil Hole Putty (11oz Tube) 6 month shelf life	36.00
EM-2A	Wire Feed Gear Motor (High Speed) Single 4 Wire	425.00	MA-1A	Oil Hole Carbon Plug Rod 1/4"	2.05
EM-2B	Wire Feed Gear Motor (High Speed) Double 4 Wire	425.00	MA-1B	Oil Hole Carbon Plug Rod 5/16"	2.05
EM-2C	Brush Holder Caps For Gearmotor	23.00	MA-1C	Oil Hole Carbon Plug Rod 3/8"	2.05
EM-2E	Wire Feed Gear Motor Double 2 Wire	475.00	MA-2	Hardness Tester Rockwell Hardness of shaft before and after weld	149.50
EM-3	Horizontal Travel Step Over Gear Motor & Gear Motor Assy. (Old Style)-Non Eso Equipped	412.00	MA-3	Gauss Gauge Detects magnetic field in shaft	283.00
EM-3A	Step Over Gear Motor-Electronic Step Over (Eso) Motors - 4 Wire	475.00	MA-4	Pyrometer F°/C° Digital Pre-heating & post heating shaft/measures temperature	199.99
EM-4	Wire Feed Motor Or Horizontal Travel Motor	165.00	MA-4A	Pyrometer F°/C° Analog Pre-heating & post heating shaft/measures temperature	950.00
EM-5	Armature For EM-4 Motor	195.00	MA-6	Thermo Couple For Pyrometer	175.00
EM-6	Brushes For EM-4 Motor	46.00	MA-7	Extension Arms For Pyrometer	116.00
EM-6A	2 Wire Rotation Motor Brushes (1 Pair)	30.00	MA-8	Air Rotary File (Drills out oil hole w/ carbide burr tip)	208.00
EM-7	Torch Gear Motor Motorized	375.00	MA-8A	Carbide Burr Tip-Tapered	42.99
			MA-8B	Carbide Burr Tip-Ball	42.99
			MA-9	Heating Torch Oxy-Acet.	175.00

# GLEASON CRANKSHAFT JOURNAL REBUILDING KITS

## Passenger Car Kits

Non-Heat Treated under HRC 30

Each kit welds approximately 150-175 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
<b>#1 Jumbo Kit</b>	<b>KASTALLOY BUILD UP KIT (Jumbo Size)</b> This material is intended for all grades of Cast Iron and chemically heat treated (nitrided or tufftrided) high performance forged steel and billet steel. <b>No pregrinding necessary for cast or steel</b> Kit contents: 30 lbs (13.61kg) wire 75 lbs (34.02kg) flux	.030" (.76mm) .035" (.89mm) .045" (1.14mm) (Specify diameter when ordering)	20	748.99
<b>#1 Sample Kit</b>	<b>KASTALLOY SAMPLE KIT</b> Kit contents: 2 lbs (.9kg) wire - 15 lbs(6.8kg) flux	.035" (.89mm)	20	50.00
<b>#5, #7, #8 Kit</b>	<b>UNIVERSAL BUILD UP KITS</b> For most passenger car shafts incl. Cast iron & mild forged steel under HRC 30. Kit contents: 30 lbs (13.61kg) wire 70 lbs (31.75kg) flux	.030" (.76mm)	20 Steel 45 Nod. Iron	499.99
<b>#6 Kit</b>	<b>HIGH PERFORMANCE KIT</b> For chrome molly steel forgings, billet steel racing applications. Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.035" (.89mm) .045" (1.14mm) (Specify diameter when ordering)	30	587.99
<b>#1135A Kit</b>	<b>FORGED STEEL</b> (work dia. 3" /76 mm or less) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	20 - 25	559.00
<b>#1145B Kit</b>	<b>FORGED STEEL</b> (work dia. 3" /76mm or more) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.045" (1.14mm)	20 - 25	559.00

## GLEASON SPECIALITY JOURNAL BUILD UP KITS

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
<b>#316ELC Kit</b>	<b>FOOD SERVICE GRADE STAINLESS STEEL</b> Kit contents: 30 lbs (13.61kg) wire 70 lbs (31.75kg) flux	.035" (.89mm)	30	649.99
<b>#1635E Kit</b>	<b>INDUSTRIAL/MARINE GRADE NON-FOOD SERVICE STAINLESS STEEL</b> Kit contents: 30 lbs (13.61kg) wire 70 lbs (31.75kg) flux	.035" (.89mm)	30	748.99
<b>#2035K Kit</b>	<b>HEAT TREATABLE GEAR STEEL</b> Kit contents: 20 lbs (9.07kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	60	799.99

OPERATING INSTRUCTIONS ARE INCLUDED INSIDE EACH KIT.

Do not use any other combination of flux or wire other than is supplied with Kit

Any substitution will change the chemistry and may result in serious problems or crankshaft breakage

# GLEASON CRANKSHAFT JOURNAL REBUILDING KITS

## Diesel Kits

### Heat Treated Induction Hardened Forged Steel Crankshafts Non-Fillet Hardened Over 30 HRC

These kits are intended for use on crankshafts that are induction hardened on journal area only.  
Each kit welds approximately 75 – 100 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
# 2235HD Kit	<b>DIESEL KIT</b> (Work dia. 3" /76 mm or less) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.035" (.89mm)	30 RADIUS 52 JOURNAL	920.00
# 2245HD Kit	<b>DIESEL KIT</b> (Work dia. 3" /76 mm or more) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.045" (1.14mm)	30 RADIUS 52 JOURNAL	920.00
# 2235HD/25 Kit	<b>DIESEL KIT WITH 25 lb. RADIUS WIRE</b> (Work dia. 3" /76 mm or less) Kit contents: 25 lbs. (11.34kg) Radius wire 12.50 20 lbs. (9.07kg) Journal wire 25 63 lbs. (28.58kg) flux 13.80	.035" (.89mm)	30 RADIUS 52 JOURNAL	1050.00
# 2245HD/25 Kit	<b>DIESEL KIT WITH 25 lb. RADIUS WIRE</b> (Work dia. 3" /76mm or more) Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.045" (1.14mm)	30 RADIUS 52 JOURNAL	1050.00
# 4 MARINE OUTBOARD Kit	<b>MARINE OUTBOARD</b> (Work dia. 3" /76 mm or less) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.035" (.89mm)	30 RADIUS 65 JOURNAL	920.00
# 4 MARINE OUTBOARD Sample Kit	<b>OUTBOARD SAMPLE</b> (Work dia. 3" /76 mm or less) Kit contents: 1 lbs. (.45kg) Radius wire 2 lbs. (.90kg) Journal wire 15 lbs. (6.80kg) flux	.035" (.89mm)	30 RADIUS 65 JOURNAL	50.00

## Special Application Diesel Kits

### Heat Treated Induction Hardened Forged Steel Crankshafts Fillet Hardened Over 30 HRC

These kits are intended for use on crankshafts that are induction hardened on journal and radius/thrust area. Each kit welds approximately 75 – 100 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
# 2235HD CAT Kit	<b>DIESEL KIT</b> (Work dia. 3" /76 mm or less) This kit contains special "RADIUS 26" WIRE FOR WELDING FILLET HARDENED RADIUS Kit contents: 25 lbs. (11.34kg) Radius wire 348.25 20 lbs. (9.07kg) Journal wire 600.00 100 lbs. (45.36kg) flux 379.00	.035" (.89mm)	30 RADIUS 55 JOURNAL	1,327.00
# 2245HD CAT Kit	<b>DIESEL KIT</b> (Work dia. 3" /76 mm or more) This kit contains special "RADIUS 26" WIRE FOR WELDING FILLET HARDENED RADIUS Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 100 lbs. (45.36kg) flux	.045" (1.14mm)	30 RADIUS 55 JOURNAL	1,327.00

**OPERATING INSTRUCTIONS ARE INCLUDED INSIDE EACH KIT.**

**Do not use any other combination of flux or wire other than is supplied with Kit**

**Any substitution will change the chemistry and may result in serious problems or crankshaft breakage**

# GLEASON QUALITY ELECTRODE WIRE & FLUX

## Electrode Wire

WIRE #	WEIGHT	WIRE DIA.	PRICE
#1 .....	30 lbs. (11.34kg) .....	.030" / .035" / .045" .....	486.60
		(.76mm / .89mm / 1.14mm)	
#5 .....	30 lbs. (13.61kg) .....	.030"(.76mm) .....	249.50
#6 .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	348.25
#7 .....	30 lbs. (13.61kg) .....	.030"(.76mm) .....	249.50
#8 .....	30 lbs. (13.61kg) .....	.030"(.76mm) .....	249.50
1135A .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	212.50
1145B .....	25 lbs. (11.34kg) .....	.045"(1.14mm) .....	212.50
1635E .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	486.60
2035K .....	20 lbs. (9.07kg) .....	.035"(.89mm) .....	575.00
2235D RADIUS/10 .....	10 lbs. (4.54kg) .....	.035"(.89mm) .....	85.00
2235D RADIUS/25 .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	212.50
2235HD JOURNAL .....	20 lbs. (9.07kg) .....	.035"(.89mm) .....	600.00
2235HD JOURNAL .....	20 lbs. (9.07kg) .....	.035"(.89mm) .....	600.00
2245D RADIUS/10 .....	10 lbs. (4.54kg) .....	.045"(1.14mm) .....	85.00
2245D RADIUS/25 .....	25 lbs. (11.34kg) .....	.045"(1.14mm) .....	212.50
2245HD JOURNAL .....	20 lbs. (9.07kg) .....	.045"(1.14mm) .....	575.00
2235D RADIUS/26 .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	348.25
2245D RADIUS/26 .....	25 lbs. (11.34kg) .....	.045"(1.14mm) .....	348.25
2255HD JOURNAL .....	20 lbs. (9.07kg) .....	.035"(.89mm) .....	575.00
2255HD JOURNAL .....	20 lbs. (9.07kg) .....	.045"(1.14mm) .....	575.00
316 ELC .....	25 lbs. (11.34kg) .....	.035"(.89mm) .....	475.00
#4 OUTBOARD JOURNAL .....	20 lbs. (9.07kg) .....	.035"(.89mm) .....	600.00

## Submerged Arc Flux

FLUX #	FULL KIT CONTAINS	PRICE/LB.	PRICE
#1 .....	70 lbs. (31.75kg) .....	3.57 .....	249.90
#5 .....	70 lbs. (31.75kg) .....	3.57 .....	249.90
#6 .....	63 lbs. (28.58kg) .....	3.97 .....	250.11
#7 .....	70 lbs. (31.75kg) .....	5.20 .....	249.90
#8 .....	70 lbs. (31.75kg) .....	3.57 .....	249.90
1135A .....	63 lbs. (28.58kg) .....	5.50 .....	327.60
1145B .....	63 lbs. (28.58kg) .....	5.50 .....	327.60
1335C .....	63 lbs. (28.58kg) .....	5.20 .....	327.60
1635E .....	63 lbs. (28.58kg) .....	3.57 .....	224.91
1735F .....	63 lbs. (28.58kg) .....	5.05 .....	318.15
2035K .....	63 lbs. (28.58kg) .....	3.75 .....	236.25
2235D .....	63 lbs. (28.58kg) .....	3.79 .....	224.91
2245D .....	63 lbs. (28.58kg) .....	3.79 .....	224.91
2235D-CAT .....	100 lbs. (45.36kg) .....	3.79 .....	357.00
2245D-CAT .....	100 lbs. (45.36kg) .....	3.79 .....	357.00
5560D .....	63 lbs. (28.58kg) .....	4.75 .....	236.25
#4 OUTBOARD .....	63 lbs. (28.58kg) .....	3.79 .....	246.96
316 ELC .....	63 lbs. (28.58kg) .....	3.57 .....	224.91