INDUSTRIAL EQUIPMENTS PVT. LTD.

CARTO 3T

3-Tier Welding Trolley with Gas Cylinder Holder

3 shelves | rear cylinder platform with 2 chains | 68 kg total load | braked swivel casters



USER MANUAL

Please read this manual carefully before installing and using the machine.

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Contents

1 Safety precautions 3

2 General description 4

3 Technical specifications 5

4 Assembly 8

5 Loading and use 9

6 Maintenance 11

7 Troubleshooting 12

8 Warranty 13

This manual describes the assembly, use and care of the Cruxweld CARTO 3T welding trolley. Read it before assembling and using the trolley and keep it for future reference. Cruxweld improves its products continuously; the contents of this manual may be revised without prior notice.

Signs used in this manual

Sign	Meaning
▲ **WARNING**	A potential hazard which may cause death or serious injury if it is not avoided.
▲ **CAUTION**	A hazard which may cause injury or damage to the trolley or the equipment on it if it is not avoided.
Note	Useful information for correct use.

1 Safety precautions

1.1 During assembly

- Assemble the trolley only as described in Chapter 4. Wrong assembly can make it unstable or weak.
- Wear safety glasses and work gloves; sheet-metal edges can be sharp.
- Work in a clean, well-lit area and keep other people away.
- Do not assemble the trolley when you are tired or under the influence of alcohol, drugs or medication.
- The rated load applies only to a correctly and completely assembled trolley with all bolts tight.

1.2 During use

> **▲ WARNING**
> Never load more than **68 kg in total** (welding machine, gas cylinder, cables, consumables and tools together). Spread the load evenly and keep it balanced. A sudden jolt or a load that shifts can briefly overload the trolley.

- Use the trolley only for carrying welding and cutting equipment, as described in this manual. It is not a toy and not a site barrow.
- Inspect the trolley before each use. Do not use it if any part is loose, bent or damaged.
- Use and park the trolley on a firm, dry and level floor. Lock the front casters before welding.
- Read the user manual of your welding machine before use.
- Keep the safety and rating labels clean and readable.

1.3 Gas cylinders

> **▲ WARNING**
> A falling gas cylinder can cause serious injury and can break the valve. Always stand the cylinder on the rear platform and secure it with **both** chains before moving the trolley. Follow the safety instructions of your gas supplier at all times.

- Close the cylinder valve before moving the trolley over long distances.
- Keep cylinders away from heat, sparks and the welding arc. Never strike an arc on a cylinder.
- On ramps, push the trolley rather than pulling it, and keep the cylinder on the downhill side.

2 General description

The Cruxweld CARTO 3T is a three-tier welding trolley that keeps a compact welding machine, its gas cylinder, cables, consumables and hand tools together on one mobile base. It is bolted together from sheet-steel shelves and rails with a black finish, and is supplied flat-packed.



Fig. 2.1 The CARTO 3T as a mobile welding station



Fig. 2.2 Machine, tool box and chained cylinder

2.1 Features

- **Three tiers:** a sloped top tray for the welding machine (the panel faces the operator), a centre shelf for consumables and accessories, and a bottom shelf for cables and the tool box. All shelves have lipped edges.
- **Cylinder holder:** a lipped rear platform carries the gas cylinder low between the rear wheels; two chains at two heights hold it against the back panel.
- **Side hooks:** two bolt-on hooks for the torch, earth lead and gloves.
- **Wheels:** two 178 mm solid rubber rear wheels and two 71 mm swivel casters (360°) with foot brakes.
- **Push handle:** a tubular loop handle at about 850 mm for steering the loaded trolley.
- **Open frame:** every shelf can be reached from both sides.

2.2 Suitable equipment

Compact inverter welding and cutting machines whose footprint fits the 450 × 275 mm top tray, for example the Cruxweld ARC200iS, ARC251iS, ARC300iS, DC TIG 200 HF, FINELINE 80 and compact MIG machines. Check the footprint and weight of your machine against the specifications, or ask Cruxweld to confirm the fit.

3 Technical specifications

Parameter	CARTO 3T
General	
Model	CARTO 3T
Type	3-tier welding trolley with gas cylinder holder
Construction	Bolted sheet-steel shelves and rails, black finish
Movement	Manual push, loop handle
Capacity	
Maximum total load	68 kg (150 lb)
Storage tiers	3 (sloped top tray + 2 flat shelves), all with lipped edges
Cylinder holder	Rear platform with 2 retaining chains
Accessory hooks	2, side mounted
Dimensions (approx.)	
Overall height (to handle)	850 mm
Top tray	450 × 275 mm
Middle shelf	395 × 275 mm
Bottom shelf	440 × 290 mm
Cylinder platform	255 × 290 mm
Wheels	
Rear wheels	2 × 178 mm (7 in) solid rubber, fixed
Front casters	2 × 71 mm (3 in), 360° swivel with foot brake
Weight and packing	
Net weight	10.8 kg
Gross weight	11.3 kg
Carton	73 × 31 × 9 cm, flat-packed
Assembly	Required; hardware and chains included

Shelf and overall dimensions are nominal and may vary by a few millimetres.



Fig. 3.1 Main dimensions in millimetres

3.1 Parts list

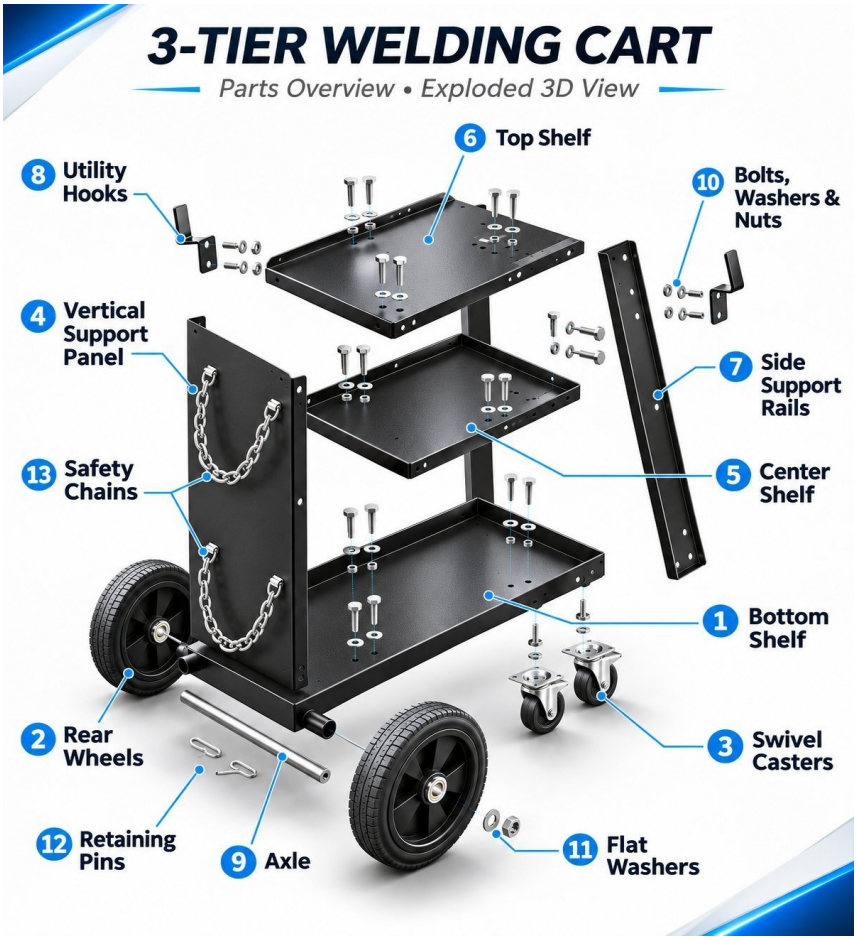


Fig. 3.2 Exploded view (numbers as in the parts list)

No.	Part	Qty
1	Bottom shelf	1
2	Rear wheel, 178 mm	2
3	Swivel caster with brake	2
4	Back panel / cylinder support	1
5	Centre shelf	1
6	Top shelf	1
7	Side support rail	2
8	Hook	2
9	Axle	1
10	Bolt, washer and nut set	33
11	Flat washer	4
12	Retaining (roll) pin	2
13	Chain	2

Not included: welding machine, gas cylinder, regulator, torch, cables and tools. These are shown in some photographs for illustration only.

> **Note:** If any part is missing or damaged when you unpack the carton, contact Cruxweld before assembling the trolley. Spare wheels, casters, chains, hooks and fasteners are available.

4 Assembly

Tools needed: a spanner and a screwdriver. Read Chapter 1 before you start. Identify all parts against the parts list (Fig. 3.2).

> **Note:** Fit all bolts and nuts only finger-tight until the trolley is complete; then tighten everything with the tools (step 9). This makes the holes easier to line up.

1. **Rear wheels.** Pass the axle (9) through the axle holes at the rear of the bottom shelf (1). Fit a rear wheel (2) on each end of the axle and secure each wheel with a flat washer (11) and a retaining pin (12).
2. **Front casters.** Bolt a swivel caster (3) under each front corner of the bottom shelf (1) with four bolts, washers and nuts (10) each.
3. **Side rails.** Bolt the lower ends of the two side support rails (7) to the sides of the bottom shelf (1). Check the hole positions so that the rails lean the right way, as in Fig. 3.2.
4. **Centre shelf.** Bolt the centre shelf (5) between the two side rails (7).
5. **Top shelf and hooks.** Place the top shelf (6) on the upper ends of the side rails. Hold a hook (8) over the holes on the outside of each rail, and pass the bolts through the hook, the rail and the top shelf. Fit the nuts.
6. **Back panel to bottom shelf.** Bolt the back panel (4) to the bottom shelf (1).
7. **Back panel to the upper shelves.** Bolt the back panel (4) to the centre shelf (5) and to the top shelf (6).
8. **Chains.** Fit the two chains (13) through the eyelets in the back panel (4), one at the upper and one at the lower position.
9. **Tighten.** Tighten all bolts and nuts firmly with the spanner and screwdriver. Check that the trolley stands square and that all four wheels touch the floor.



Fig. 4.1 Assembled trolley, rear angle with cylinder chains



Fig. 4.2 Side view with the chains fitted

> **▲ CAUTION**
> Re-tighten every bolt after the first week of use. Loose bolts reduce the load capacity and stability of the trolley.

5 Loading and use

5.1 Loading the trolley

1. Check that the welding machine, cylinder and accessories together weigh **no more than 68 kg**.
2. **Gas cylinder:** stand the cylinder on the rear platform against the back panel. Pass both chains around it and clip them, and adjust the chain length so that the cylinder cannot move. The lower chain alone is not enough.
3. **Welding machine:** place it on the sloped top tray with the control panel facing you. Keep the machine's air vents clear.
4. **Accessories:** consumables and the wire-feed or TIG kit on the centre shelf; cables and the tool box on the bottom shelf. Hang the torch, earth lead and gloves on the side hooks, coiled and not kinked.
5. Check that everything is secure and that the trolley is well balanced. If your machine is unstable on the top tray or does not fit it securely, do not use it on this trolley.



Fig. 5.1 Cylinder on the rear platform, held by the chains



Fig. 5.2 Side hook for leads and gloves

5.2 Moving and parking

- Release the caster brakes and push the trolley by the loop handle. Move slowly over thresholds, hoses and cables.
- On ramps, push rather than pull, and keep the cylinder on the downhill side.
- At the workplace, lock both front casters with the foot pedals before striking an arc.
- Use the trolley only on firm, level floors. It is a workshop trolley and is not designed for rough site ground.

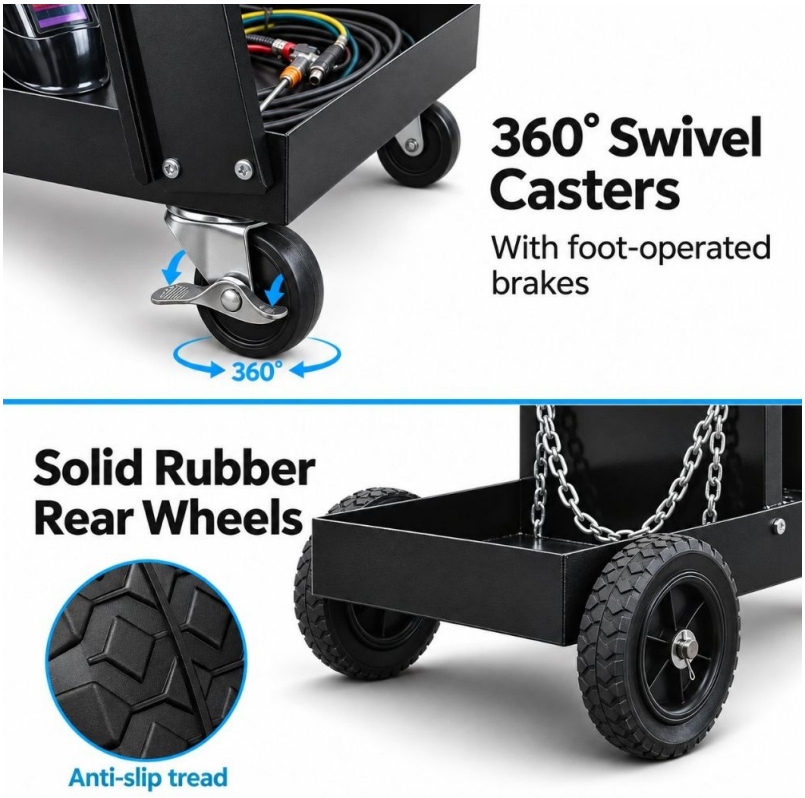


Fig. 5.3 Swivel casters with foot brakes and solid rubber rear wheels

6 Maintenance

Interval	Work
After the first week	Re-tighten all bolts and nuts.
Before each use	Check for loose, bent or damaged parts; check the chains and their clips.
Regularly	Tighten all bolts and nuts. Keep the wheels and casters free of dirt, chips, spatter and grease, and check that the caster brakes hold.
As needed	Wipe the trolley clean with a dry cloth. Touch up scratches in the finish to prevent rust.

Replace damaged parts only with genuine Cruxweld spare parts. Do not weld on or modify the trolley.

7 Troubleshooting

Fault	Possible cause	Remedy
Trolley wobbles or leans	Bolts loose; parts assembled in the wrong position	Check the assembly against Fig. 3.2 and tighten all bolts
Trolley does not roll straight	Rear wheel loose on the axle; dirt in a caster	Check the washers and retaining pins; clean the casters
Trolley moves while welding	Caster brakes not applied or worn	Lock both caster brakes; replace a caster whose brake does not hold
Cylinder moves on the platform	Chains too loose or only one chain used	Use both chains and shorten them until the cylinder is held firmly
Machine slides on the top tray	Machine too small or too large for the tray	Use a machine whose footprint suits the 450 × 275 mm tray; ask Cruxweld to check the fit

For spare parts or help, contact Cruxweld service and state the model and the date of purchase.

8 Warranty

Cruxweld warrants the CARTO 3T against defects in material and workmanship for the period stated on the quotation and invoice. During this period Cruxweld will repair or replace parts that are found to be defective due to faulty material or workmanship.

The warranty does not cover normal wear (wheels, casters, chains, finish), or damage caused by overloading, incorrect assembly, misuse, accidents, modification or lack of maintenance.

Model	CARTO 3T
Date of purchase	
Invoice no.	
Customer	
Dealer stamp	

For service and spare parts please contact:

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Cruxweld improves its products continuously. The technical data in this manual may change without notice.