

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
#1 Jumbo Kit	KASTALLOY BUILD UP KIT (Jumbo Size) This material is intended for all grades of Cast Iron and chemically heat treated (nitrided or tufftrided) high performance forged steel and billet steel. No pregrinding necessary for cast or steel Kit contents: 30 lbs (13.61kg) wire 75 lbs (34.02kg) flux	.030" (.76mm) .035" (.89mm) .045" (1.14mm) (Specify diameter when ordering)	20	834.75
#1 Sample Kit	KASTALLOY SAMPLE KIT Kit contents: 2 lbs (.9kg) wire - 20 lbs(6.8kg) flux	.035" (.89mm)	20	75.00
#5, #7, #8 Kit	UNIVERSAL BUILD UP KITS 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	569.00
#6 Kit	HIGH PERFORMANCE KIT 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	616.00
#1135A Kit	FORGED STEEL (work dia. 3" /76 mm or less) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	20 - 25	556.95
#1145B Kit	FORGED STEEL (work dia. 3" /76mm or more) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.045" (1.14mm)	20 - 25	556.95

GLEASON SPECIALITY JOURNAL BUILD UP KITS

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
#316ELC Kit	FOOD SERVICE GRADE STAINLESS STEEL Kit contents: 30 lbs (13.61kg) wire 75 lbs (31.75kg) flux	.035" (.89mm)	30	834.75
#1635E Kit	INDUSTRIAL/MARINE GRADE NON-FOOD SERVICE STAINLESS STEEL Kit contents: 30 lbs (13.61kg) wire 75 lbs (31.75kg) flux	.035" (.89mm)	30	834.75
#2035K Kit	HEAT TREATABLE GEAR STEEL Kit contents: 20 lbs (9.07kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	60	926.75

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

