



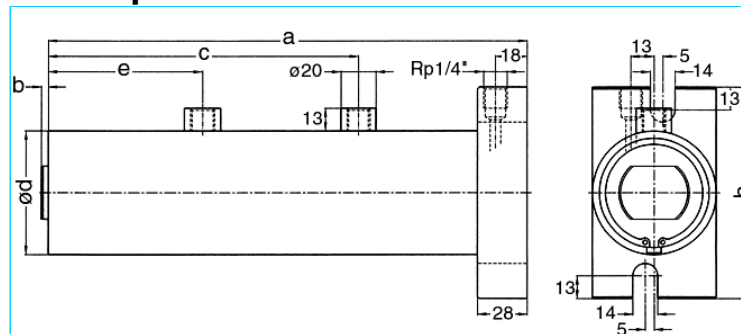
# Welding cylinder

with ground plate, retract and working stroke

Version: 2011-01

unilateral air connection,  
double-stage pressurized

undamped



## Nominal size 038

S	WS	a	b	c	d	e	h	Force*	Order-number
36	30	369	4	254	48	126	98	0.2 kN	101.111.124.038.036.
50	20	379	4	254	48	126	98	0.2 kN	101.111.124.038.050.
65	30	429	4	294	48	146	98	0.2 kN	101.111.124.038.065.
80	20	439	4	294	48	146	98	0.2 kN	101.111.124.038.080.
100	40	509	4	354	48	176	98	0.2 kN	101.111.124.038.100.
130	30	519	4	354	48	176	98	0.2 kN	101.111.124.038.130.
150	40	569	4	394	48	196	98	0.2 kN	101.111.124.038.150.

S = retract, WS = working stroke, \*at 1 bar pressure

## Nominal size 044

S	WS	a	b	c	d	e	h	Force*	Order-number
36	30	369	4	254	55	126	105	0.28 kN	101.111.124.044.036.
50	20	379	4	254	55	126	105	0.28 kN	101.111.124.044.050.
65	30	429	4	294	55	146	105	0.28 kN	101.111.124.044.065.
80	20	439	4	294	55	146	105	0.28 kN	101.111.124.044.080.
100	40	509	4	354	55	176	105	0.28 kN	101.111.124.044.100.
130	30	519	4	354	55	176	105	0.28 kN	101.111.124.044.130.
150	40	569	4	394	55	196	105	0.28 kN	101.111.124.044.150.

S = retract, WS = working stroke, \*at 1 bar pressure

## Nominal size 058

S	WS	a	b	c	d	e	h	Force*	Order-number
36	30	369	4	254	70	126	120	0.5 kN	101.111.124.058.036.
50	20	379	4	254	70	126	120	0.5 kN	101.111.124.058.050.
65	30	429	4	294	70	146	120	0.5 kN	101.111.124.058.065.
80	20	439	4	294	70	146	120	0.5 kN	101.111.124.058.080.
100	40	509	4	354	70	176	120	0.5 kN	101.111.124.058.100.
130	30	519	4	354	70	176	120	0.5 kN	101.111.124.058.130.
150	40	569	4	394	70	196	120	0.5 kN	101.111.124.058.150.

S = retract, WS = working stroke, \*at 1 bar pressure

**Complete the Order-number:**

Example: 101.111.124.044.050.??? **No. Force connection (S.3).?? No. Cylinder rod (S.4)!**

We reserve the right to make changes which are in the interest of technical progress.

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Cylinder-Ground plate-1



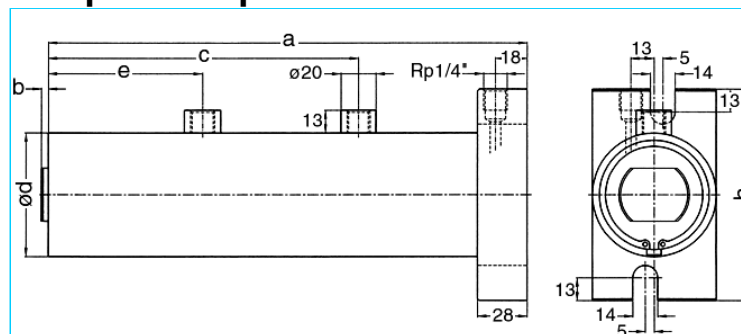
# Welding cylinder

with ground plate, retract and working stroke

Version: 2011-01

unilateral air connection,  
double-stage pressurized

damped independent of stroke



## Nominal size 044

S	WS	a	b	c	d	e	h	Force*	Order-number
36	30	369	4	254	55	126	105	0.28 kN	101.111.125.044.036.
50	20	379	4	254	55	126	105	0.28 kN	101.111.125.044.050.
65	30	429	4	294	55	146	105	0.28 kN	101.111.125.044.065.
80	20	439	4	294	55	146	105	0.28 kN	101.111.125.044.080.
100	40	509	4	354	55	176	105	0.28 kN	101.111.125.044.100.
130	30	519	4	354	55	176	105	0.28 kN	101.111.125.044.130.
150	40	569	4	394	55	196	105	0.28 kN	101.111.125.044.150.

S = retract, WS = working stroke, \*at 1 bar pressure

## Nominal size 058

S	WS	a	b	c	d	e	h	Force*	Order-number
36	30	369	4	254	70	126	120	0.5 kN	101.111.125.058.036.
50	20	379	4	254	70	126	120	0.5 kN	101.111.125.058.050.
65	30	429	4	294	70	146	120	0.5 kN	101.111.125.058.065.
80	20	439	4	294	70	146	120	0.5 kN	101.111.125.058.080.
100	40	509	4	354	70	176	120	0.5 kN	101.111.125.058.100.
130	30	519	4	354	70	176	120	0.5 kN	101.111.125.058.130.
150	40	569	4	394	70	196	120	0.5 kN	101.111.125.058.150.

S = retract, WS = working stroke, \*at 1 bar pressure

**Complete the Order-number:**

Example: 101.111.125.058.050.??? **No. Force connection (S.3).?? No. Cylinder rod (S.4)!**

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Cylinder-Ground plate-2



# Welding cylinder

with ground plate, retract and working stroke

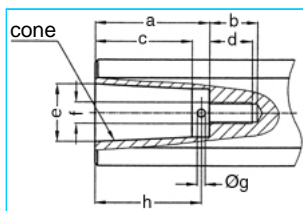
Version: 2011-01

## Force connection

Write the number (with point) from the selected Force connection direct behind the Order-number of the cylinder and complete the whole Order-number with the chosen number of the Cylinder rod.

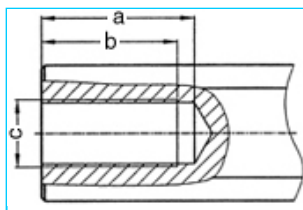
**Example:** 101.111.124.044.050.103.?? No. Cylinder rod (S.4)

### Internal cone



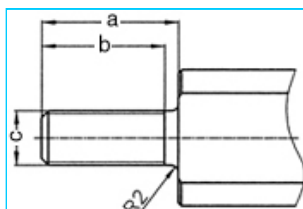
a	b	c	d	e	cone	f	g	h	No.
33	18	27.0	16	17.780	MK2	M8	3	30	101.
42	18	35.5	16	21.806	MK3	M8	3	39	102.
42	18	35.5	16	21.750	1:10	M8	3	39	103.

### Female thread



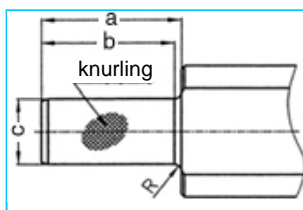
a	b	c	No.
45	40	M20 x 1.5	201.
62	58	M20 x 1.5	202.

### Male thread



a	b	c	No.
40	36	M16 x 1.5	301.
40	36	M20 x 1.5	302.
40	36	M24 x 1.5	303.

### Knurl



a	b	c	Knurling	R	No.
42	40	20 <sup>17</sup>	1 x 0.2 DIN 82	2	401.
42	42	25 <sup>17</sup>	1 x 0.2 DIN 82	-	402.

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Cylinder-Ground plate-3



# Welding cylinder

with ground plate, retract and working stroke

Version: 2011-01

## Cylinder rod

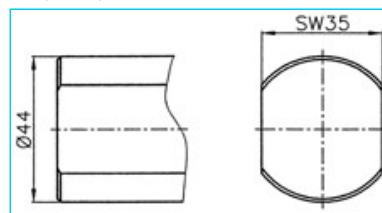
flattened and rotation locked

Complete the Order-number with the selected number of the chosen cylinder rod.

**Example: 101.111.124.044.050.103.02**

### For piston diameter

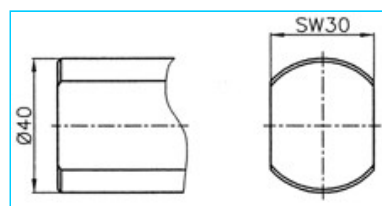
70, 80, 90



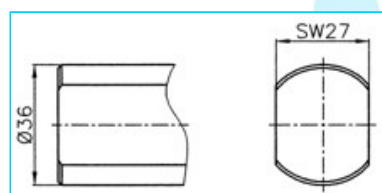
**No. 00**

### For piston diameter

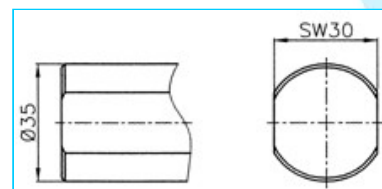
38, 44, 58



**No. 01**



**No. 02**



**No. 03**

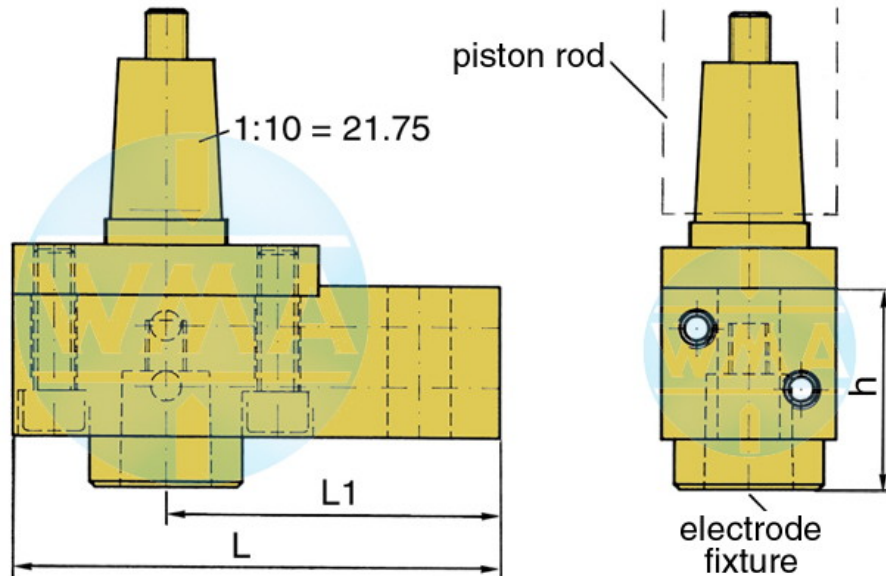


# Welding cylinder

with ground plate, retract and working stroke

Version: 2011-01

## Electrode holder for welding cylinders



Piston Ø	L	L1	Water connection
38	95	65	possible on both sides
44	95	65	possible on both sides
58	110	80	possible on both sides
70	110	80	possible on both sides
80	120	90	possible on both sides
90	120	90	possible on both sides

## Available cones for the electrode fixture

cone	Ø d	h
1 : 10	9.8	39
1 : 10	12.0	39
1 : 10	12.7	39
1 : 10	15.5	39
1 : 10	15.75	39
1 : 10	17.75	50
1 : 10	19.0	50
MK 1	12.065	39
MK 2	17.781	50

Further cones available on request!

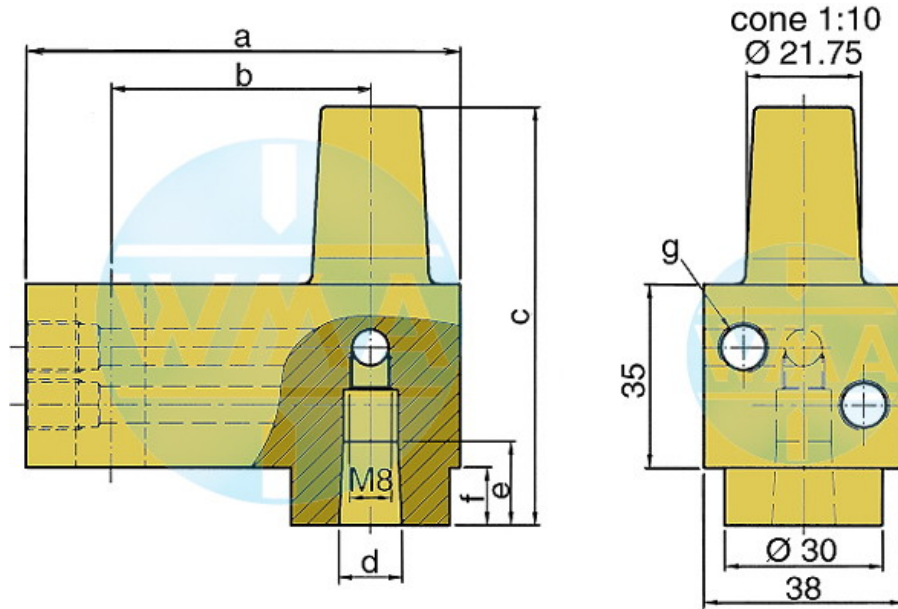


# Welding cylinder

with ground plate, retract and working stroke

Version: 2011-01

## Electrode holder



This electrode holder is main used in welding machines with variable and fast-change electrode shafts.

a	b	c	d	e	f	g	Order-number	
82	49	80	1:10=12.00	16	16	11	M10 x 1 or R 1/8"	L60051080-000
82	49	80	MK1	16	16	11	M10 x 1 or R 1/8"	L60091080-000
82	49	80	1:10=15.75	20	20	11	M10 x 1 or R 1/8"	L60131080-001
82	49	80	1:10=18	20	20	11	M10 x 1 or R 1/8"	L60061080-000
82	49	80	MK2	20	20	11	M10 x 1 or R 1/8"	L60101080-000
82	49	90	1:10=21.75	31	31	21	M10 x 1 or R 1/8"	L60221080-000
82	49	90	MK3	31	31	21	M10 x 1 or R 1/8"	L60111080-000
97	64	90	1:10=21.75	31	31	21	M10 x 1 or R 1/8"	L60221090-000
97	64	90	MK3	31	31	21	M10 x 1 or R 1/8"	L60111090-000
107	74	90	1:10=21.75	31	31	21	M10 x 1 or R 1/8"	L60221090-001
107	74	90	MK3	31	31	21	M10 x 1 or R 1/8"	L60111090-001

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Cylinder-Ground plate-6