



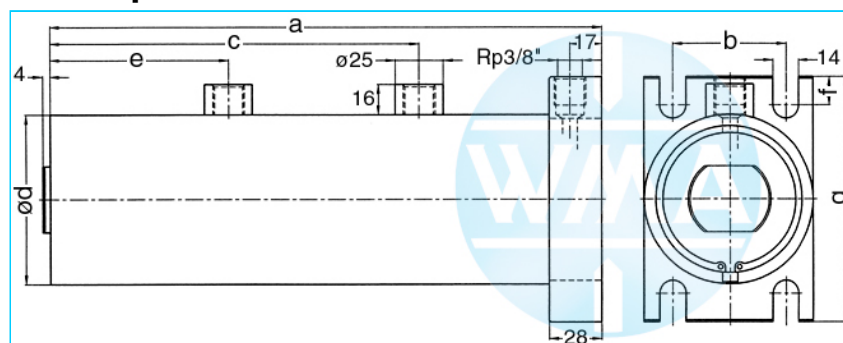
Welding cylinder

Ground plate, retract and working stroke

Version: 2011-01

unilateral air connection,
double-stage pressurized

undamped



Nominal size 070

S	WS	a	b	c	d	e	f	g	Force*	Order-number
50	30	419	60	293	90	143	15	130	0.72 kN	101.114.124.070.050.
60	20	429	60	293	90	143	15	130	0.72 kN	101.114.124.070.060.
70	30	479	60	333	90	163	15	130	0.72 kN	101.114.124.070.070.
80	20	489	60	333	90	163	15	130	0.72 kN	101.114.124.070.080.
90	40	559	60	393	90	193	15	130	0.72 kN	101.114.124.070.090.
100	30	569	60	393	90	193	15	130	0.72 kN	101.114.124.070.100.
110	40	619	60	433	90	213	15	130	0.72 kN	101.114.124.070.110.

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

Nominal size 080

S	WS	a	b	c	d	e	f	g	Force*	Order-number
50	30	419	70	293	100	143	17,5	140	0.95 kN	101.114.124.080.050.
60	20	429	70	293	100	143	17,5	140	0.95 kN	101.114.124.080.060.
70	30	479	70	333	100	163	17,5	140	0.95 kN	101.114.124.080.070.
80	20	489	70	333	100	163	17,5	140	0.95 kN	101.114.124.080.080.
90	40	559	70	393	100	193	17,5	140	0.95 kN	101.114.124.080.090.
100	30	569	70	393	100	193	17,5	140	0.95 kN	101.114.124.080.100.
110	40	619	70	433	100	213	17,5	140	0.95 kN	101.114.124.080.110.

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

Nominal size 090

S	WS	a	b	c	d	e	f	g	Force*	Order-number
50	30	419	80	293	110	143	20	150	1.2 kN	101.114.124.090.050.
60	20	429	80	293	110	143	20	150	1.2 kN	101.114.124.090.060.
70	30	479	80	333	110	163	20	150	1.2 kN	101.114.124.090.070.
80	20	489	80	333	110	163	20	150	1.2 kN	101.114.124.090.080.
90	40	559	80	393	110	193	20	150	1.2 kN	101.114.124.090.090.
100	30	569	80	393	110	193	20	150	1.2 kN	101.114.124.090.100.
110	40	619	80	433	110	213	20	150	1.2 kN	101.114.124.090.110.

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

Complete the Order-number:

Example: **101.114.124.070.060.???** 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



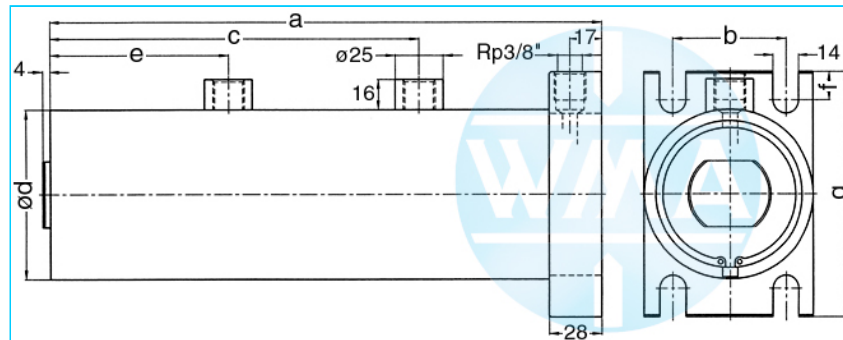
Welding cylinder

Ground plate, retract and working stroke

Version: 2011-01

unilateral air connection,
double-stage pressurized

damped independent of stroke



Nominal size 070

S	WS	a	b	c	d	e	f	g	Force*	Order-number
50	30	419	60	293	90	143	15	130	0.72 kN	101.114.125.070.050.
60	20	429	60	293	90	143	15	130	0.72 kN	101.114.125.070.060.
70	30	479	60	333	90	163	15	130	0.72 kN	101.114.125.070.070.
80	20	489	60	333	90	163	15	130	0.72 kN	101.114.125.070.080.
90	40	559	60	393	90	193	15	130	0.72 kN	101.114.125.070.090.
100	30	569	60	393	90	193	15	130	0.72 kN	101.114.125.070.100.
110	40	619	60	433	90	213	15	130	0.72 kN	101.114.125.070.110.

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

Complete the Order-number:

Example: 101.114.125.070.060.??? No. Force connection (S.3).?? No. Cylinder rod (S.4)

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Cylinder-Ground plate-2



Welding cylinder

Ground plate, retract and working stroke

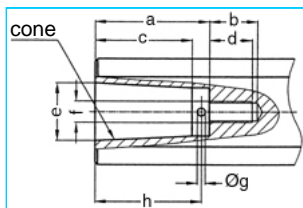
Version: 2011-01

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.

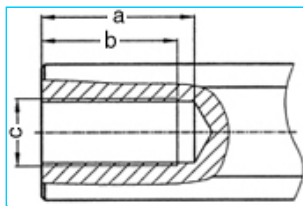
Example: 101.114.125.070.060.201.?? No. Cylinder rod (S.4)

Internal cone



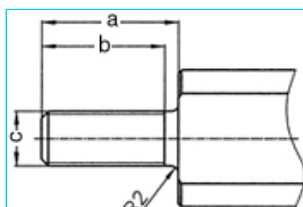
a	b	c	d	e	cone	f	g	h	No.
33	18	27.0	16	17.780	MK2	M8	3	30	101.
42	18	35.5	16	21.806	MK3	M8	3	39	102.
42	18	35.5	16	21.750	1:10	M8	3	39	103.

Female thread



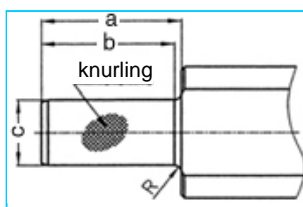
a	b	c	No.
45	40	M20 x 1.5	201.
62	58	M20 x 1.5	202.

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 ¹⁷	1 x 0.2 DIN 82	2	401.
42	42	25 ¹⁷	1 x 0.2 DIN 82	-	402.

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Cylinder-Ground plate-3



Welding cylinder

Ground plate, retract and working stroke

Version: 2011-01

Cylinder rod

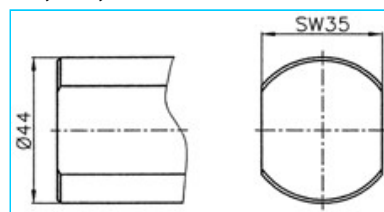
flattened and rotation locked

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

Example: 101.114.125.070.060.201.00

For piston diameter

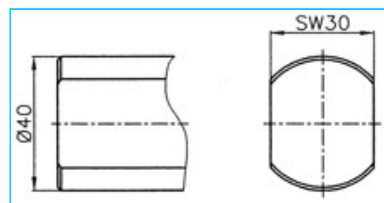
70, 80, 90



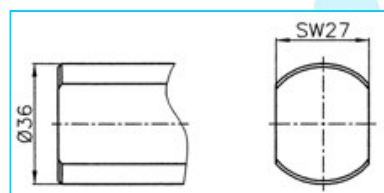
No. 00

For piston diameter

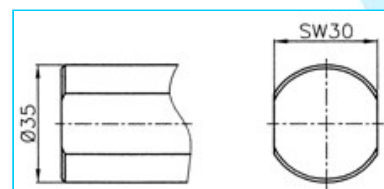
38, 44, 58



No. 01



No. 02



No. 03

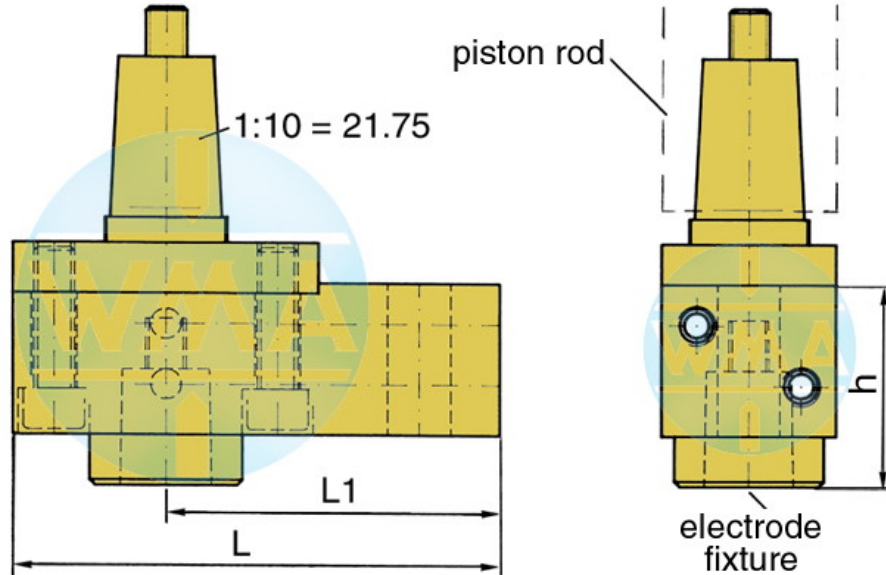


Welding cylinder

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!

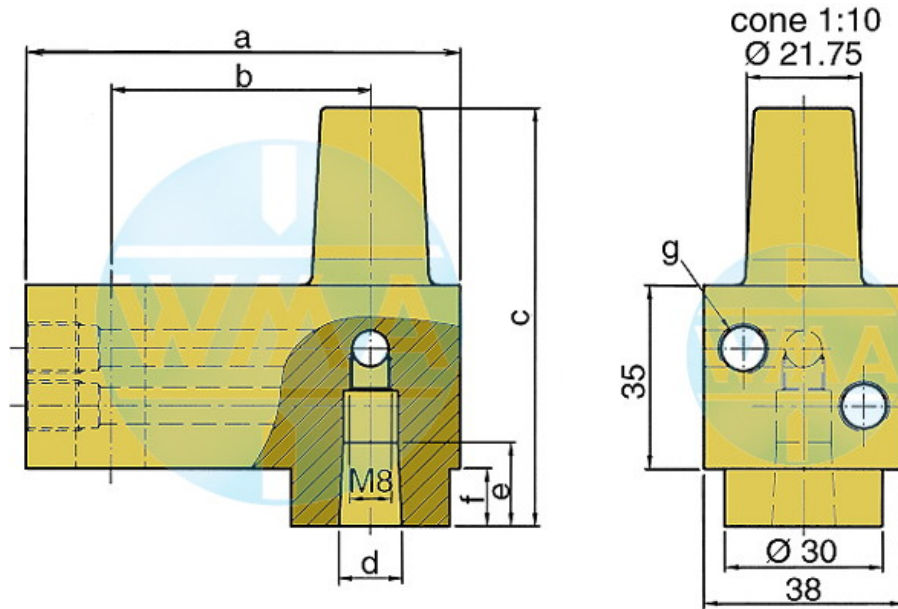


Welding cylinder

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