



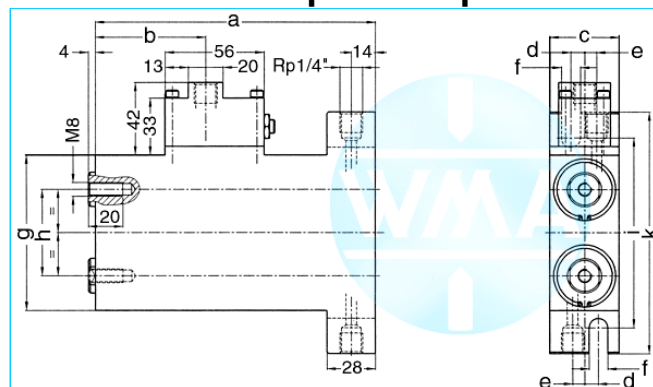
Welding cylinder

Duplex

Version: 2011-01

unilateral air connection,
double-stage pressurized

controllable damped independent of stroke



Nominal size 025

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.036.20
50	188	77	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.050.20
65	218	92	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.065.20
80	248	107	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.080.20
100	288	127	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.100.20
130	348	157	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.130.20
150	388	177	30	7	7	11	80	50	100	130	0.17 kN	107.110.121.025.150.20

*at 1 bar pressure

Nominal size 032

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.036.20
50	188	77	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.050.20
65	218	92	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.065.20
80	248	107	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.080.20
100	288	127	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.100.20
130	348	157	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.130.20
150	388	177	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.032.150.20

*at 1 bar pressure

Nominal size 034

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.036.20
50	188	77	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.050.20
65	218	92	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.065.20
80	248	107	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.080.20
100	288	127	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.100.20
130	348	157	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.130.20
150	388	177	40	8	7	11	90	50	110	140	0.3 kN	107.110.121.034.150.20

*at 1 bar pressure

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

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Cylinder-Duplex-1



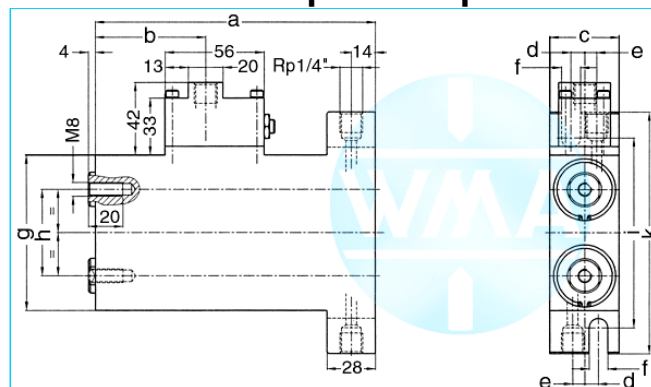
Welding cylinder

Duplex

Version: 2011-01

unilateral air connection,
double-stage pressurized

controllable damped independent of stroke



Nominal size 038

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.036.30
50	188	77	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.050.30
65	218	92	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.065.30
80	248	107	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.080.30
100	288	127	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.100.30
130	348	157	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.130.30
150	388	177	48	10	8	13	100	50	124	160	0.4 kN	107.110.121.038.150.30

*at 1 bar pressure

Nominal size 044

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.036.30
50	188	77	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.050.30
65	218	92	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.065.30
80	248	107	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.080.30
100	288	127	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.100.30
130	348	157	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.130.30
150	388	177	52	10	8	13	102	50	124	160	0.56 kN	107.110.121.044.150.30

*at 1 bar pressure

Nominal size 058

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	160	63	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.036.30
50	188	77	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.050.30
65	218	92	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.065.30
80	248	107	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.080.30
100	288	127	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.100.30
130	348	157	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.130.30
150	388	177	70	10	8	13	140	70	164	190	1.0 kN	107.110.121.058.150.30

*at 1 bar pressure

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Cylinder-Duplex-2



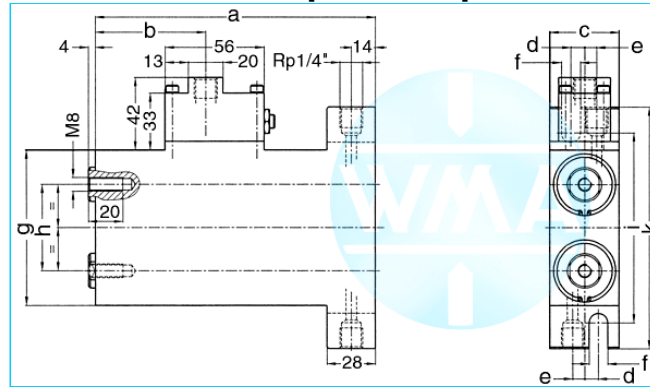
Welding cylinder

Duplex

Version: 2011-01

unilateral air connection,
three-stage pressurized

controllable damped independent of stroke



Nominal size 025

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.036.20
50	259	148	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.050.20
65	304	178	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.065.20
80	349	208	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.080.20
100	409	248	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.100.20
130	499	308	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.130.20
150	559	348	30	7	7	11	80	50	100	130	0.23 kN	107.110.131.025.150.20

*at 1 bar pressure

Nominal size 032

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.036.20
50	259	148	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.050.20
65	304	178	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.065.20
80	349	208	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.080.20
100	409	248	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.100.20
130	499	308	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.130.20
150	559	348	40	8	7	11	90	50	110	140	0.42 kN	107.110.131.032.150.20

*at 1 bar pressure

Nominal size 034

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.036.20
50	259	148	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.050.20
65	304	178	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.065.20
80	349	208	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.080.20
100	409	248	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.100.20
130	499	308	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.130.20
150	559	348	40	8	7	11	90	50	110	140	0.48 kN	107.110.131.034.150.20

*at 1 bar pressure

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Cylinder-Duplex-3



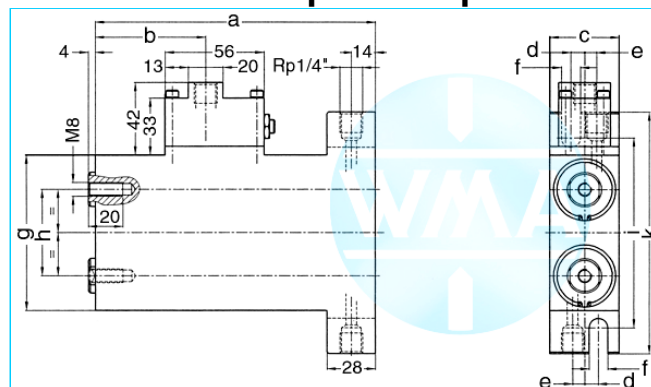
Welding cylinder

Duplex

Version: 2011-01

unilateral air connection,
three-stage pressurized

controllable damped independent of stroke



Nominal size 038

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.036.30
50	259	148	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.050.30
65	304	178	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.065.30
80	349	208	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.080.30
100	409	248	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.100.30
130	499	308	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.130.30
150	559	348	48	10	8	13	100	50	124	160	0.56 kN	107.110.131.038.150.30

*at 1 bar pressure

Nominal size 044

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.036.30
50	259	148	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.050.30
65	304	178	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.065.30
80	349	208	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.080.30
100	409	248	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.100.30
130	499	308	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.130.30
150	559	348	52	10	8	13	102	50	124	160	0.78 kN	107.110.131.044.150.30

*at 1 bar pressure

Nominal size 058

Stroke	a	b	c	d	e	f	g	h	i	k	Force*	Order-number
36	217	120	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.036.30
50	259	148	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.050.30
65	304	178	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.065.30
80	349	208	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.080.30
100	409	248	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.100.30
130	499	308	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.130.30
150	559	348	70	10	8	13	140	70	164	190	1.44 kN	107.110.131.058.150.30

*at 1 bar pressure

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Cylinder-Duplex-4



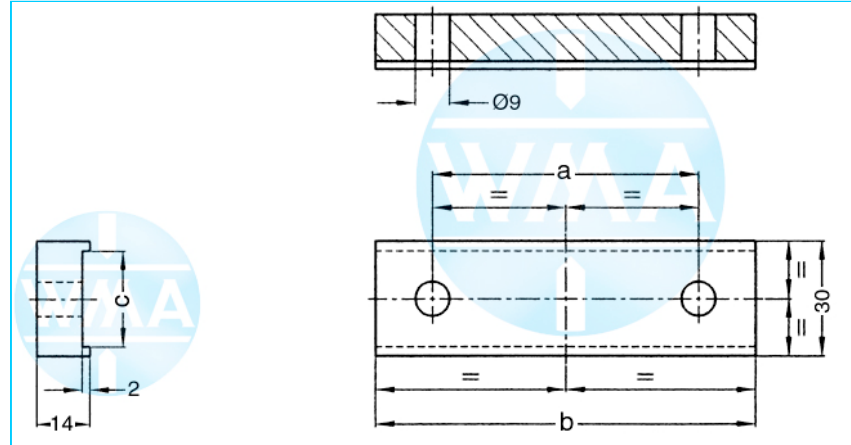
Welding cylinder

Duplex

Version: 2011-01

Holding plate for Duplex cylinder

For Cylinder piston diameter (Nominal size) 25,32, 34, 38, 44 and 58 mm

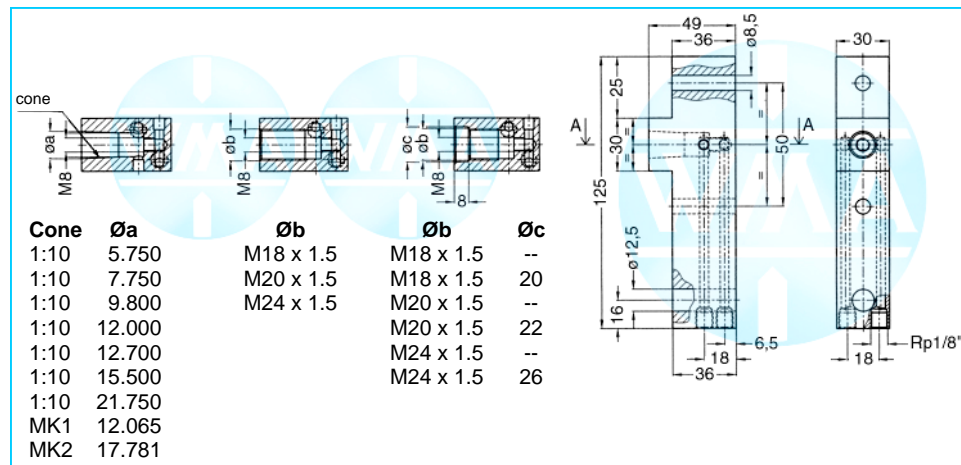


Cylinder piston diameter

Cylinder piston diameter	a	b	c	Order-number
25, 32, 34	50	80	17	
38, 44	50	80	25	
58	70	100	25	

Electrode holder for Duplex cylinder

For Cylinder piston diameter (Nominal size) 25,32, 34, 38, 44 and 58 mm



Cone	Øa	Øb	Øb	Øc
1:10	5.750	M18 x 1.5	M18 x 1.5	--
1:10	7.750	M20 x 1.5	M18 x 1.5	20
1:10	9.800	M24 x 1.5	M20 x 1.5	--
1:10	12.000		M20 x 1.5	22
1:10	12.700		M24 x 1.5	--
1:10	15.500		M24 x 1.5	26
1:10	21.750			
MK1	12.065			
MK2	17.781			

Piston diameter

Piston diameter	d	e	f
25, 32, 34, 38, 44	125	25	50
58	154	35	70

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Cylinder-Duplex-5