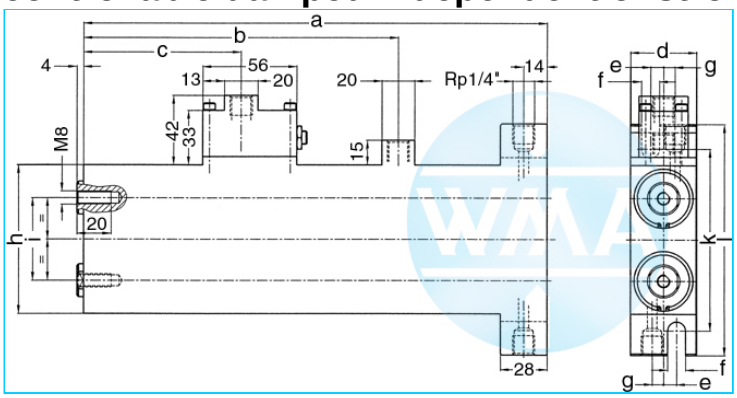
Welding cylinder

Duplex with retract and working stroke

Version: 2011-01

unilateral air connection, double-stage pressurized

controllable damped independent of stroke



Nominal size 025

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.050.20
60	**20**	358	248	107	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.060.20
70	**30**	408	288	127	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.070.20
80	**20**	418	288	127	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.080.20
90	**40**	488	348	157	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.090.20
100	**30**	498	348	157	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.100.20
110	**40**	548	388	177	30	7	11	7	80	50	100	130	0.17 kN	107.111.124.025.110.20

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

Nominal size 032

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.050.20
60	**20**	358	248	107	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.060.20
70	**30**	408	288	127	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.070.20
80	**20**	418	288	127	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.080.20
90	**40**	488	348	157	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.090.20
100	**30**	498	348	157	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.100.20
110	**40**	548	388	177	40	8	11	7	90	50	110	140	0.3 kN	107.111.124.032.110.20

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

Nominal size 034

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.050.20
60	**20**	358	248	107	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.060.20
70	**30**	408	288	127	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.070.20
80	**20**	418	288	127	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.080.20
90	**40**	488	348	157	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.090.20
100	**30**	498	348	157	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.100.20
110	**40**	548	388	177	40	8	11	7	90	50	110	140	0.34 kN	107.111.124.034.110.20

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

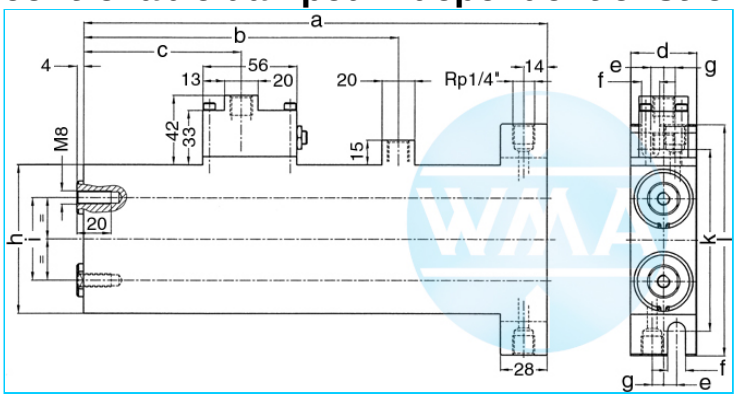
Welding cylinder

Duplex with retract and working stroke

Version: 2011-01

unilateral air connection, double-stage pressurized

controllable damped independent of stroke



Nominal size 038

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.050.30
60	**20**	358	248	107	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.060.30
70	**30**	408	288	127	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.070.30
80	**20**	418	288	127	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.080.30
90	**40**	488	348	157	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.090.30
100	**30**	498	348	157	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.100.30
110	**40**	548	388	177	48	10	13	8	100	50	124	160	0.4 kN	107.111.124.038.110.30

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

Nominal size 044

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.050.30
60	**20**	358	248	107	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.060.30
70	**30**	408	288	127	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.070.30
80	**20**	418	288	127	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.080.30
90	**40**	488	348	157	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.090.30
100	**30**	498	348	157	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.100.30
110	**40**	548	388	177	52	10	13	8	102	50	124	160	0.56 kN	107.111.124.044.110.30

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

Nominal size 058

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	**30**	348	248	107	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.050.30
60	**20**	358	248	107	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.060.30
70	**30**	408	288	127	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.070.30
80	**20**	418	288	127	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.080.30
90	**40**	488	348	157	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.090.30
100	**30**	498	348	157	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.100.30
110	**40**	548	388	177	70	10	13	8	140	70	164	190	1.0 kN	107.111.124.058.110.30

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

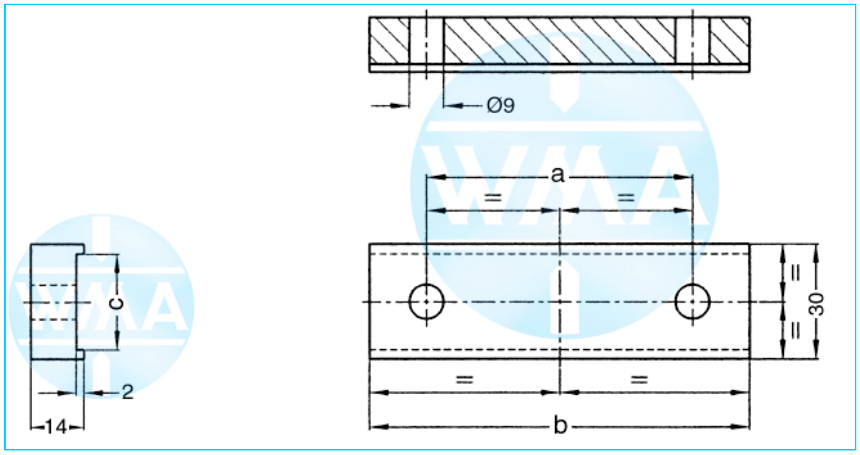
Welding cylinder

Duplex with retract and working stroke

Version: 2011-01

Holding plate for Duplex cylinder

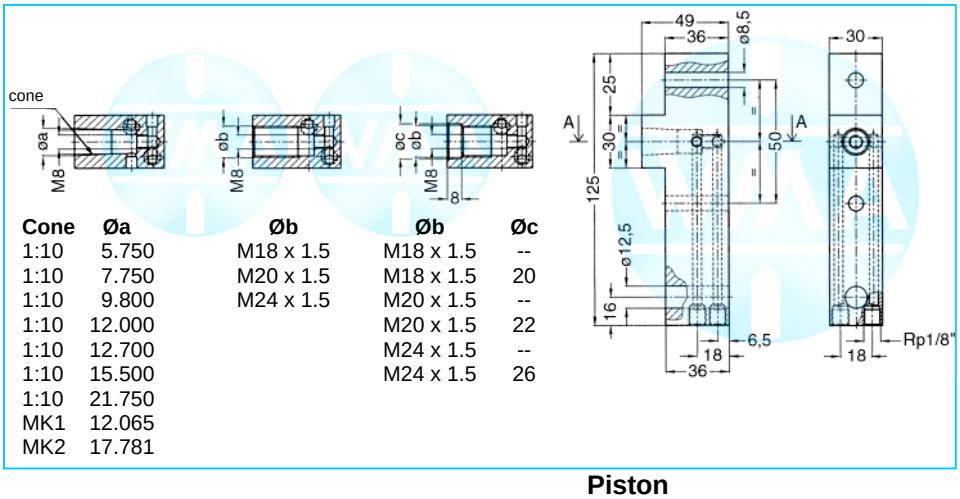
For Cylinder piston diameter (Nominal size) 25,32, 34, 38, 44 and 58 mm



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