



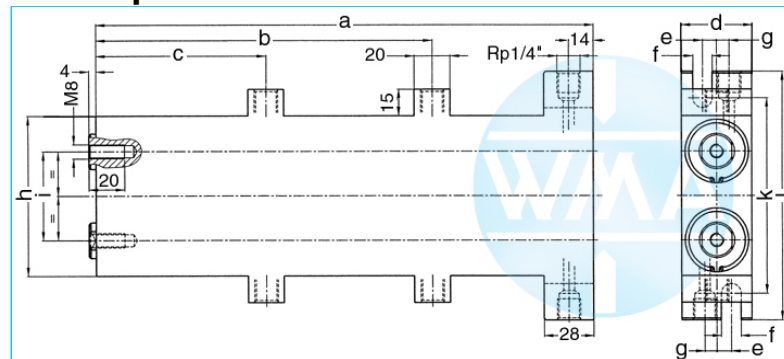
Welding cylinder

Duplex with retract and working stroke

Version: 2011-01

**bilateral air connection,
double-stage pressurized**

undamped



Nominal size 025

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	30	348	248	125	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.050.20
60	20	358	248	125	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.060.20
70	30	408	288	145	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.070.20
80	20	418	288	145	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.080.20
90	40	488	348	175	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.090.20
100	30	498	348	175	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.100.20
110	40	548	388	195	30	7	11	7	80	50	100	130	0.17 kN	107.121.124.025.110.20

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	125	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.050.20
60	20	358	248	125	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.060.20
70	30	408	288	145	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.070.20
80	20	418	288	145	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.080.20
90	40	488	348	175	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.090.20
100	30	498	348	175	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.100.20
110	40	548	388	195	40	8	11	7	90	50	110	140	0.3 kN	107.121.124.032.110.20

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	125	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.050.20
60	20	358	248	125	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.060.20
70	30	408	288	145	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.070.20
80	20	418	288	145	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.080.20
90	40	488	348	175	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.090.20
100	30	498	348	175	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.100.20
110	40	548	388	195	40	8	11	7	90	50	110	140	0.34 kN	107.121.124.034.110.20

S = retract, WS = working stroke, *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



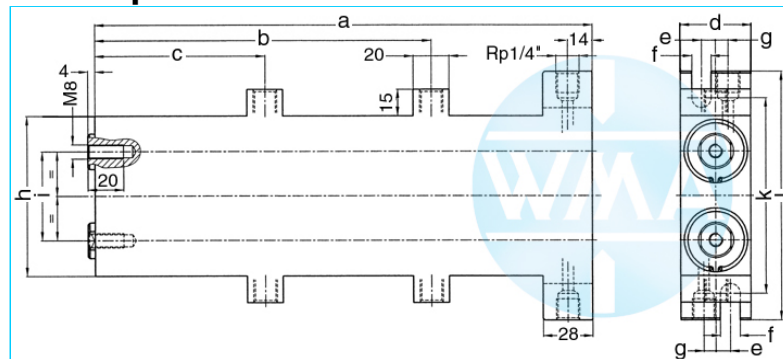
Welding cylinder

Duplex with retract and working stroke

Version: 2011-01

**bilateral air connection,
double-stage pressurized**

undamped



Nominal size 038

S	WS	a	b	c	d	e	f	g	h	i	k	l	Force*	Order-number
50	30	348	248	125	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.050.30
60	20	358	248	125	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.060.30
70	30	408	288	145	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.070.30
80	20	418	288	145	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.080.30
90	40	488	348	175	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.090.30
100	30	498	348	175	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.100.30
110	40	548	388	195	48	10	13	8	100	50	124	160	0.4 kN	107.121.124.038.110.30

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	125	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.050.30
60	20	358	248	125	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.060.30
70	30	408	288	145	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.070.30
80	20	418	288	145	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.080.30
90	40	488	348	175	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.090.30
100	30	498	348	175	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.100.30
110	40	548	388	195	52	10	13	8	102	50	124	160	0.56 kN	107.121.124.044.150.30

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
36	30	348	248	125	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.050.30
50	20	358	248	125	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.060.30
65	30	408	288	145	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.070.30
80	20	418	288	145	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.080.30
100	40	488	348	175	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.090.30
130	30	498	348	175	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.100.30
150	40	548	388	195	70	10	13	8	140	70	164	190	1.0 kN	107.121.124.058.110.30

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

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Cylinder-Duplex-2



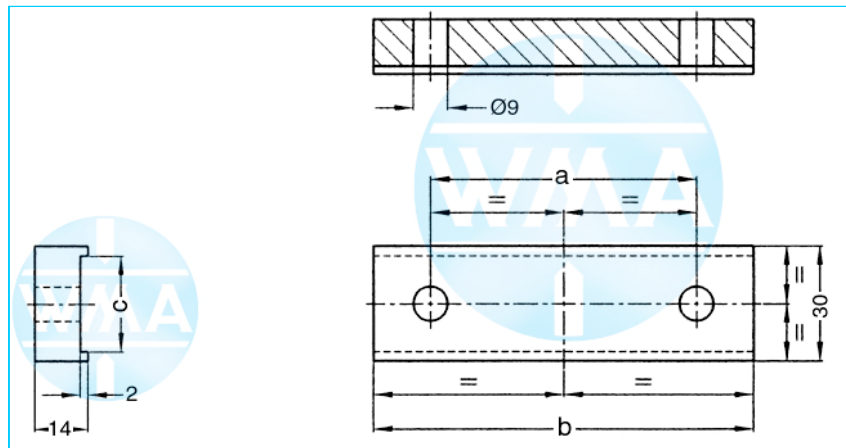
Welding cylinder

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

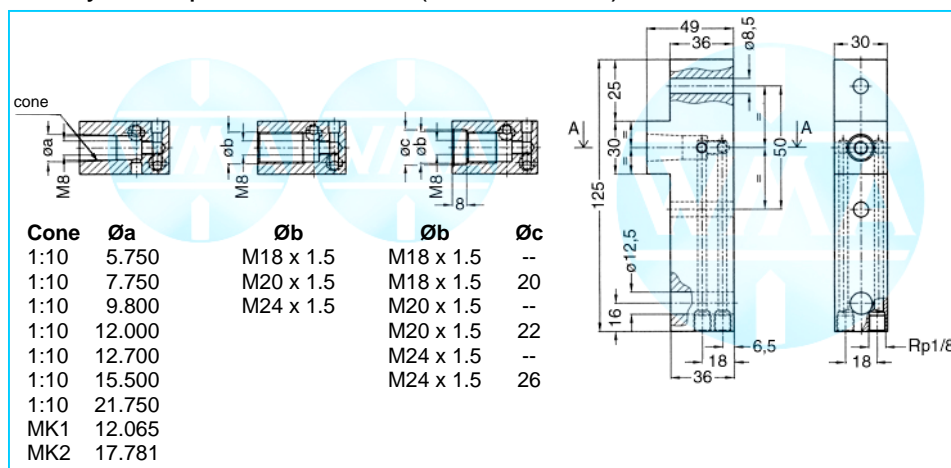


Cylinder piston diameter

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-3