



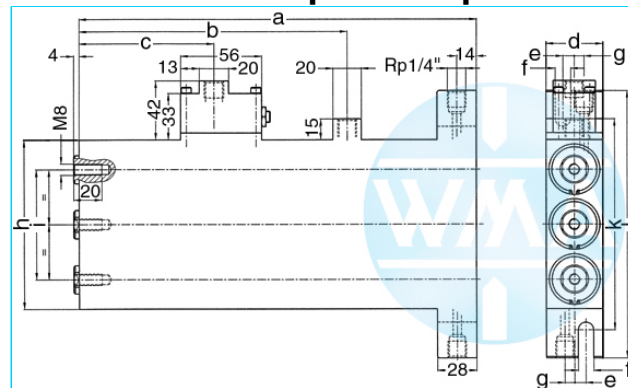
Welding cylinder

Triplex 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	90	60	115	150	0.26 kN	108.111.124.025.050.20
60	20	358	248	107	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.060.20
70	30	408	288	127	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.070.20
80	20	418	288	127	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.080.20
90	40	488	348	157	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.090.20
100	30	498	348	157	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.100.20
110	40	548	388	177	30	7	11	7	90	60	115	150	0.26 kN	108.111.124.025.110.20

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	120	78	150	190	0.45 kN	108.111.124.032.050.20
60	20	358	248	107	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.060.20
70	30	408	288	127	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.070.20
80	20	418	288	127	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.080.20
90	40	488	348	157	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.090.20
100	30	498	348	157	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.100.20
110	40	548	388	177	40	8	11	7	120	78	150	190	0.45 kN	108.111.124.032.110.20

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	120	78	150	190	0.51 kN	108.111.124.034.050.20
60	20	358	248	107	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.060.20
70	30	408	288	127	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.070.20
80	20	418	288	127	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.080.20
90	40	488	348	157	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.090.20
100	30	498	348	157	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.100.20
110	40	548	388	177	40	8	11	7	120	78	150	190	0.51 kN	108.111.124.034.110.20

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-Triplex-1



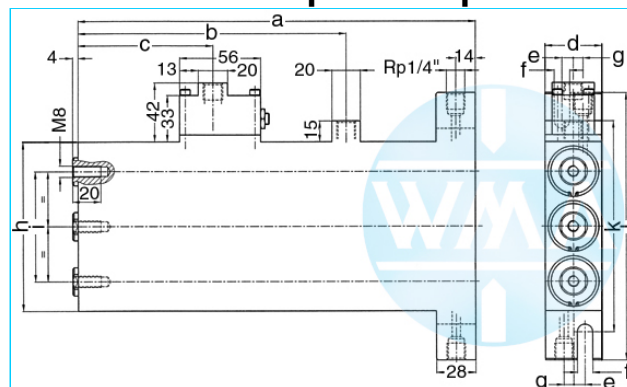
Welding cylinder

Triplex 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	150	100	174	210	0.6 kN	108.111.124.038.050.30
60	20	358	248	107	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.060.30
70	30	408	288	127	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.070.30
80	20	418	288	127	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.080.30
90	40	488	348	157	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.090.30
100	30	498	348	157	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.100.30
110	40	548	388	177	48	10	13	8	150	100	174	210	0.6 kN	108.111.124.038.110.30

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	152	100	174	210	0.84 kN	108.111.124.044.050.30
60	20	358	248	107	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.060.30
70	30	408	288	127	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.070.30
80	20	418	288	127	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.080.30
90	40	488	348	175	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.090.30
100	30	498	348	175	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.100.30
110	40	548	388	177	52	10	13	8	152	100	174	210	0.84 kN	108.111.124.044.150.30

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	107	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.050.30
50	20	358	248	107	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.060.30
65	30	408	288	127	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.070.30
80	20	418	288	127	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.080.30
100	40	488	348	157	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.090.30
130	30	498	348	157	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.100.30
150	40	548	388	177	70	10	13	8	210	140	234	260	1.5 kN	108.111.124.058.110.30

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

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Cylinder-Triplex-2



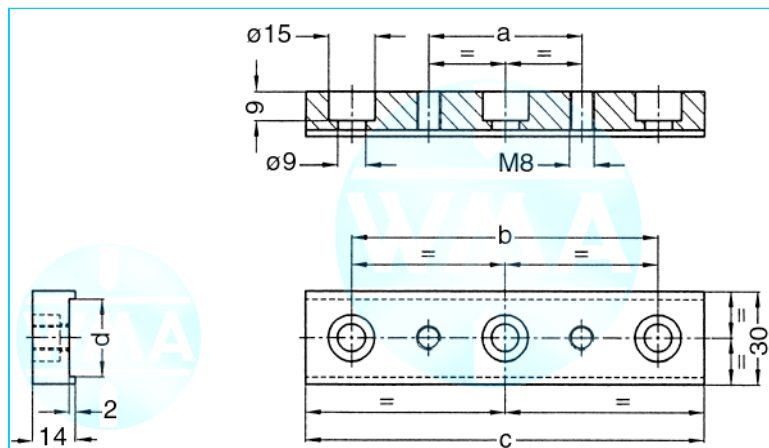
Welding cylinder

Triplex with retract and working stroke

Version: 2011-01

Holding plate for Triplex cylinder

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

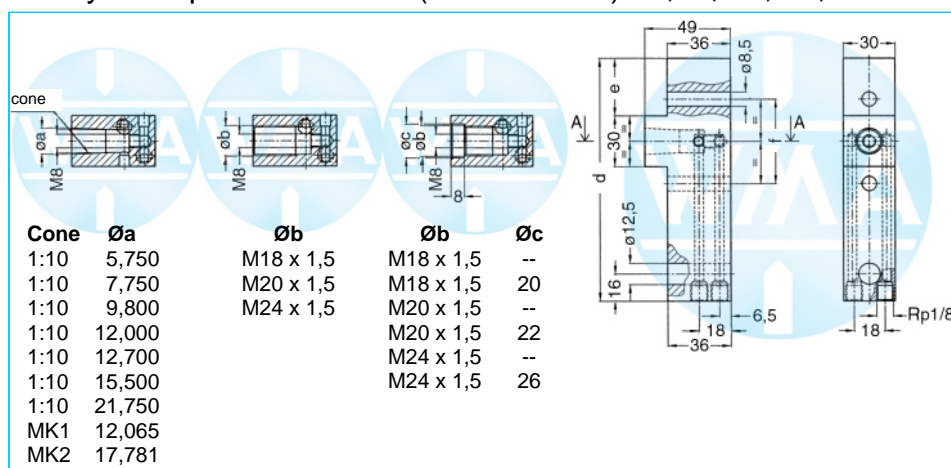


Piston diameter

	a	b	c	d
25	--	60	80	17
32, 34	50	78	98	17
38, 44	50	100	130	25
58	50	140	170	25

Electrode holder for Triplex cylinder

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



Cone	$\varnothing a$	$\varnothing b$	$\varnothing b$	$\varnothing c$
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	119	25	60
32, 34	143	34	50
38, 44	175	50	50
58	224	70	50

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Cylinder-Triplex-3