



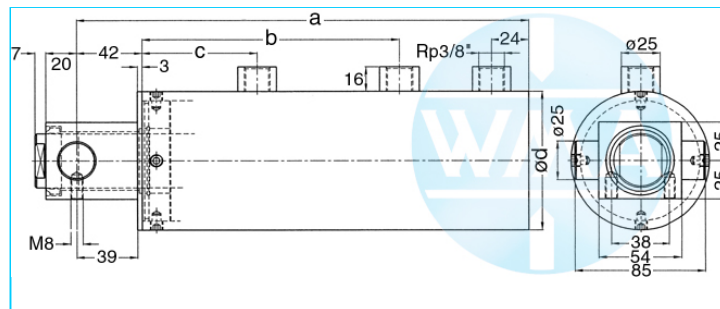
Welding cylinder

Pivot pin, with retract and working stroke

Version: 2011-01

unilateral air connection,
double-stage pressurized

undamped



Nominal size 070

S	WS	a	b	c	d	Force*	Order-number
36	30	457	288	138	90	0.72 kN	104.115.124.070.036.
50	20	467	288	138	90	0.72 kN	104.115.124.070.050.
65	30	517	328	158	90	0.72 kN	104.115.124.070.065.
80	20	527	328	158	90	0.72 kN	104.115.124.070.080.
100	40	597	388	188	90	0.72 kN	104.115.124.070.100.
130	30	607	388	188	90	0.72 kN	104.115.124.070.130.
150	40	657	428	208	90	0.72 kN	104.115.124.070.150.

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

Nominal size 080

S	WS	a	b	c	d	Force*	Order-number
36	30	457	288	138	100	0.95 kN	104.115.124.080.036.
50	20	467	288	138	100	0.95 kN	104.115.124.080.050.
65	30	517	328	158	100	0.95 kN	104.115.124.080.065.
80	20	527	328	158	100	0.95 kN	104.115.124.080.080.
100	40	597	388	188	100	0.95 kN	104.115.124.080.100.
130	30	607	388	188	100	0.95 kN	104.115.124.080.130.
150	40	657	428	208	100	0.95 kN	104.115.124.080.150.

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

Nominal size 090

S	WS	a	b	c	d	Force*	Order-number
36	30	457	288	138	110	1.2 kN	104.115.124.090.036.
50	20	467	288	138	110	1.2 kN	104.115.124.090.050.
65	30	517	328	158	110	1.2 kN	104.115.124.090.065.
80	20	527	328	158	110	1.2 kN	104.115.124.090.080.
100	40	597	388	188	110	1.2 kN	104.115.124.090.100.
130	30	607	388	188	110	1.2 kN	104.115.124.090.130.
150	40	657	428	208	110	1.2 kN	104.115.124.090.150.

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

Complete the Order-number:

Example: 104.115.124.090.050.???. 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-pivot pin-1



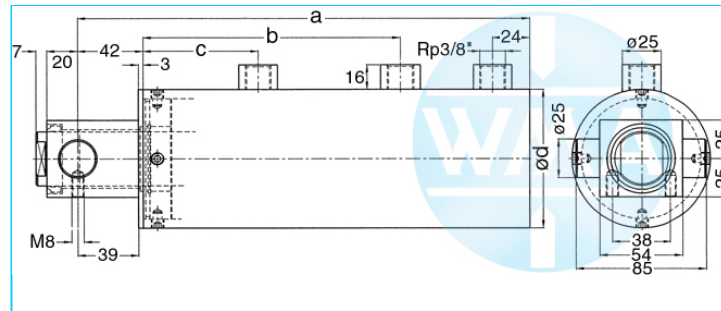
Welding cylinder

Pivot pin, with 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	Force*	Order-number
36	30	457	288	138	90	0.72 kN	104.115.125.070.036.
50	20	467	288	138	90	0.72 kN	104.115.125.070.050.
65	30	517	328	158	90	0.72 kN	104.115.125.070.065.
80	20	527	328	158	90	0.72 kN	104.115.125.070.080.
100	40	597	388	188	90	0.72 kN	104.115.125.070.100.
130	30	607	388	188	90	0.72 kN	104.115.125.070.130.
150	40	657	428	208	90	0.72 kN	104.115.125.070.150.

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

Nominal size 080

S	WS	a	b	c	d	Force*	Order-number
36	30	457	288	138	100	0.95 kN	104.115.125.080.036.
50	20	467	288	138	100	0.95 kN	104.115.125.080.050.
65	30	517	328	158	100	0.95 kN	104.115.125.080.065.
80	20	527	328	158	100	0.95 kN	104.115.125.080.080.
100	40	597	388	188	100	0.95 kN	104.115.125.080.100.
130	30	607	388	188	100	0.95 kN	104.115.125.080.130.
150	40	657	428	208	100	0.95 kN	104.115.125.080.150.

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

Nominal size 090

S	WS	a	b	c	d	Force*	Order-number
36	30	457	288	138	110	1.2 kN	104.115.125.090.036.
50	20	467	288	138	110	1.2 kN	104.115.125.090.050.
65	30	517	328	158	110	1.2 kN	104.115.125.090.065.
80	20	527	328	158	110	1.2 kN	104.115.125.090.080.
100	40	597	388	188	110	1.2 kN	104.115.125.090.100.
130	30	607	388	188	110	1.2 kN	104.115.125.090.130.
150	40	657	428	208	110	1.2 kN	104.115.125.090.150.

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

Complete the Order-number:

Example: 104.115.125.070.050.???. 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-pivot pin-2



Welding cylinder

Pivot pin, with retract and working stroke

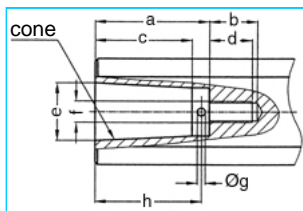
Version: 2011-01

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.

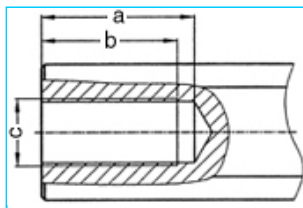
Example: 104.115.125.070.050.401.?? No. Cylinder rod (S.4)

Internal cone



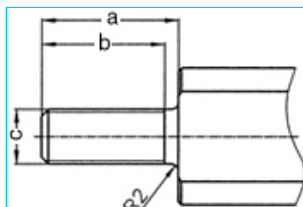
a	b	c	d	e	cone	f	g	h	No.
33	18	27.0	16	17.780	MK2	M8	3	30	101.
42	18	35.5	16	21.806	MK3	M8	3	39	102.
42	18	35.5	16	21.750	1:10	M8	3	39	103.

Female thread



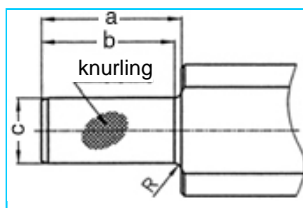
a	b	c	No.
45	40	M20 x 1.5	201.
62	58	M20 x 1.5	202.

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-pivot pin-3



Welding cylinder

Pivot pin, with retract and working stroke

Version: 2011-01

Cylinder rod

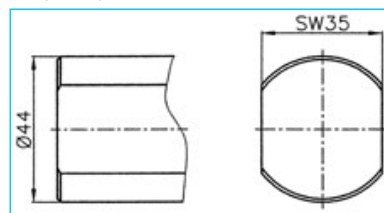
flattened and rotation locked

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

Example: 104.115.125.070.050.401.00

For piston diameter

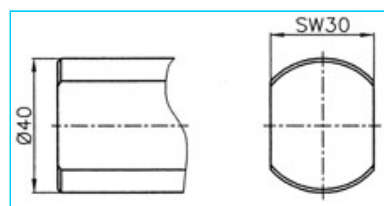
70, 80, 90



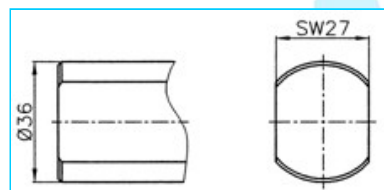
No. 00

For piston diameter

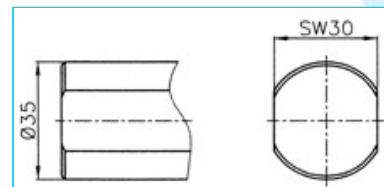
38, 44, 58



No. 01



No. 02



No. 03

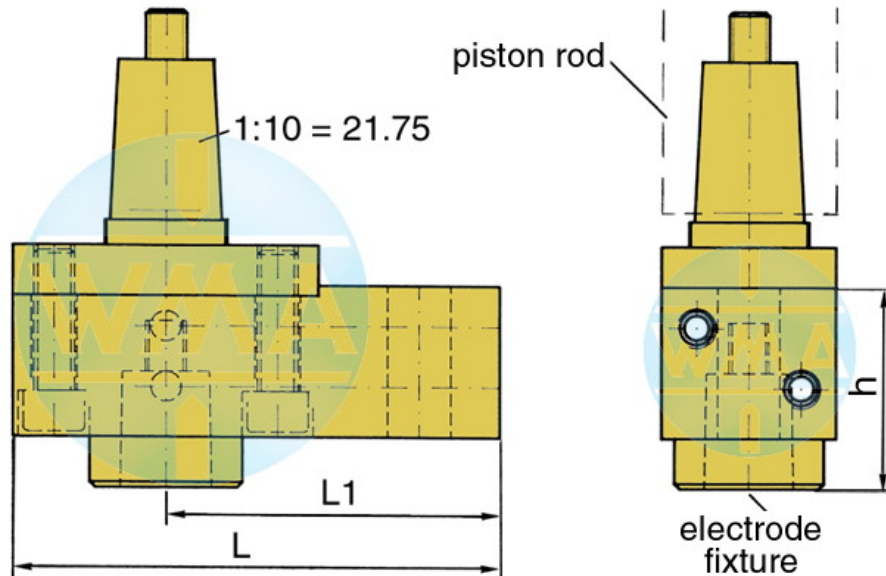


Welding cylinder

Pivot pin, with 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!

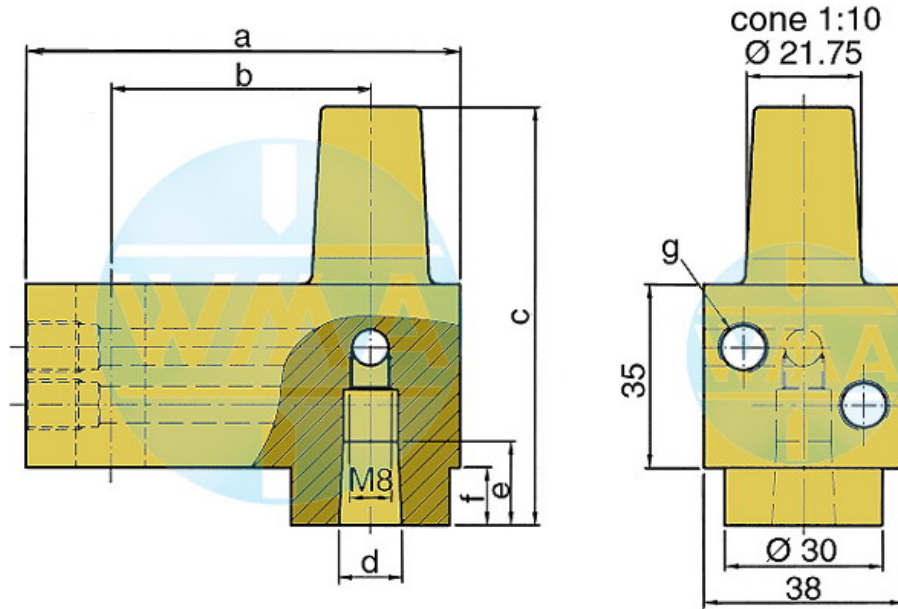


Welding cylinder

Pivot pin, with 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-pivot pin-6