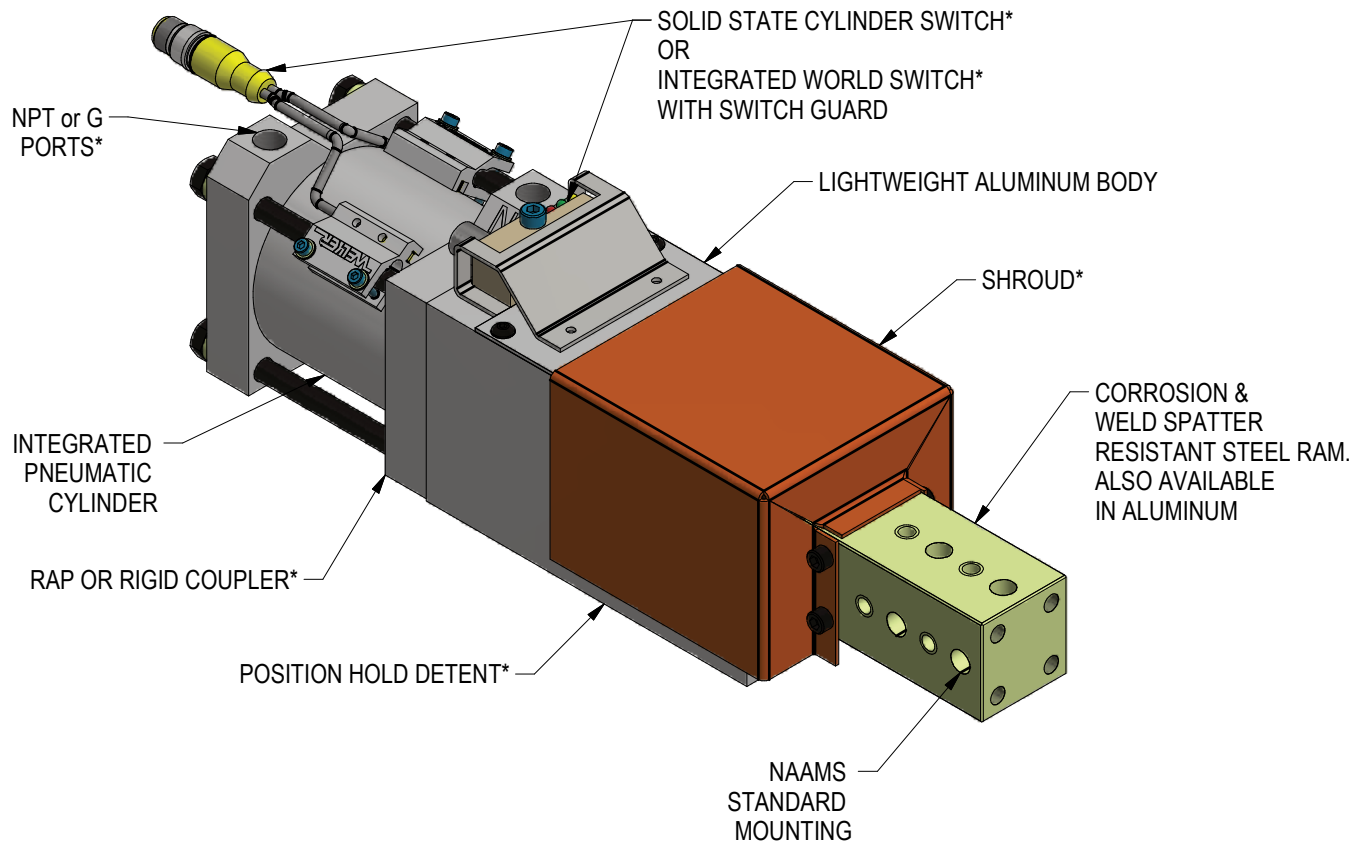


UB4 SERIES GOLD LINE SHOT PIN



SHOT PIN APPLICATIONS:

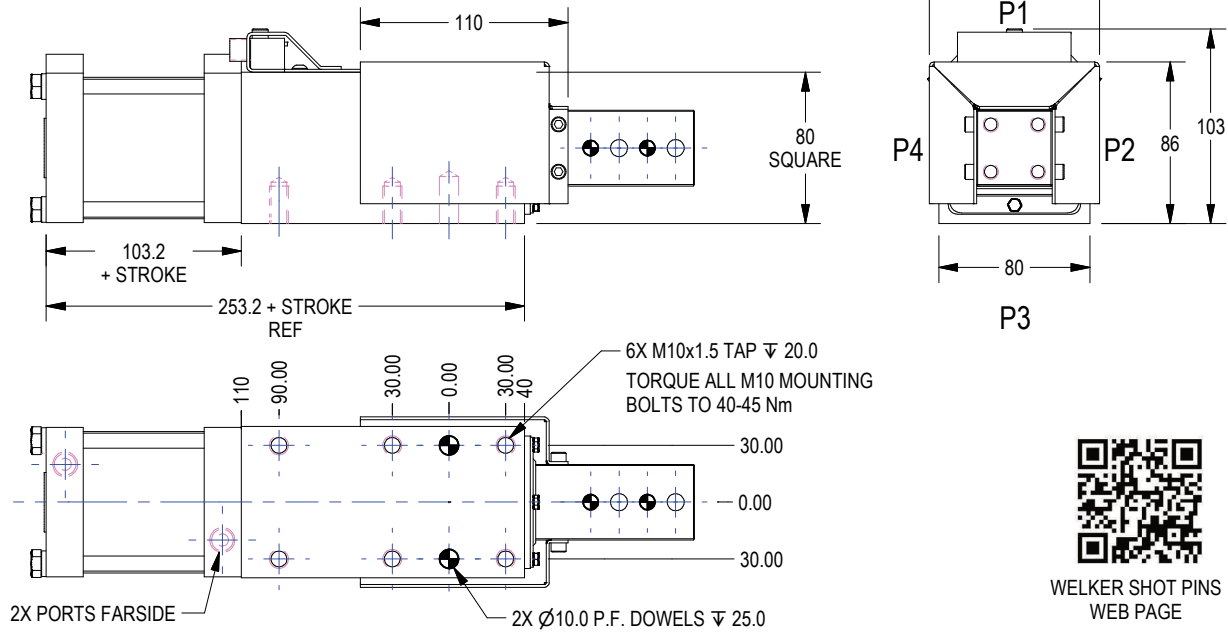
RETRACTABLE LOCATING PINS
PART STOPS
PROBE SLIDES
WEDGE LOCKS
STRAIGHT CLAMP
LARGE PART METERS

*OPTIONAL

**NO LUBRICATION
REQUIRED**

RELEASED 5/20/20

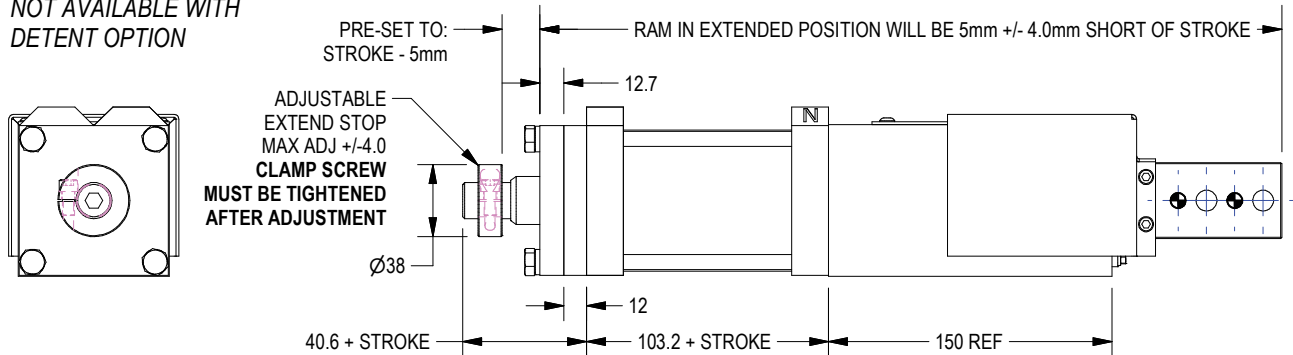
GENERAL DIMENSIONS



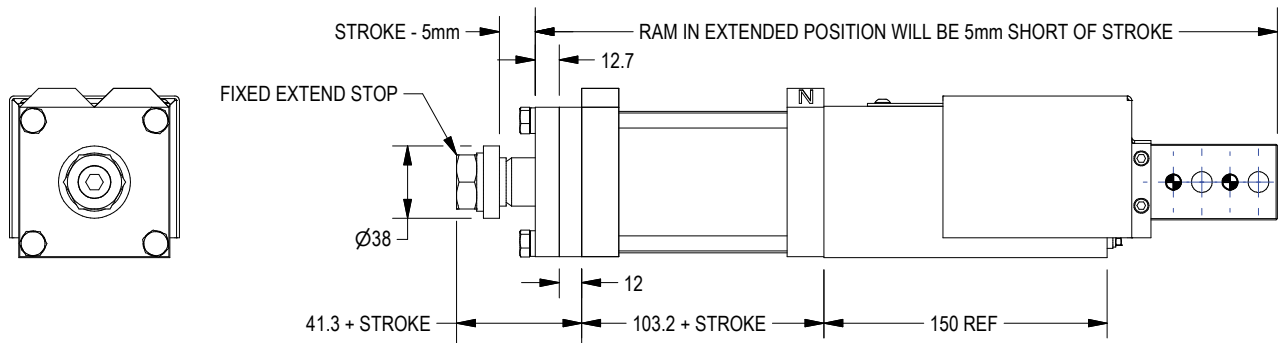
WELKER SHOT PINS
WEB PAGE

DOUBLE ROD CYLINDER WITH EXTEND STOP OPTION "E"

NOT AVAILABLE WITH
DETENT OPTION



DOUBLE ROD CYLINDER WITH EXTEND STOP OPTION "G"



NOMINAL RAM	PNEUMATIC BORE	PORTS	PUSH Sq.In.	PULL Sq.In.
40	70	1/4" NPT OR G1/4	5.97	3.49

RECOMMENDED OPERATING PRESSURE:
60-80 PSI, FLOW CONTROLS NOT REQUIRED

UNIT WEIGHTS (WEIGHTS SHOWN VARY WITH OPTIONS)				
ACTUATOR	RAM	25mm STROKE	50mm STROKE	75mm STROKE
01/02	STEEL	18 lbs	18.5 lbs	19.1 lbs
01/02	ALUMINUM	13 lbs	13.5 lbs	14 lbs
03/04	STEEL	19.4 lbs	20 lbs	25.2 lbs
03/04	ALUMINUM	14.5 lbs	15 lbs	21 lbs

SHEET 3

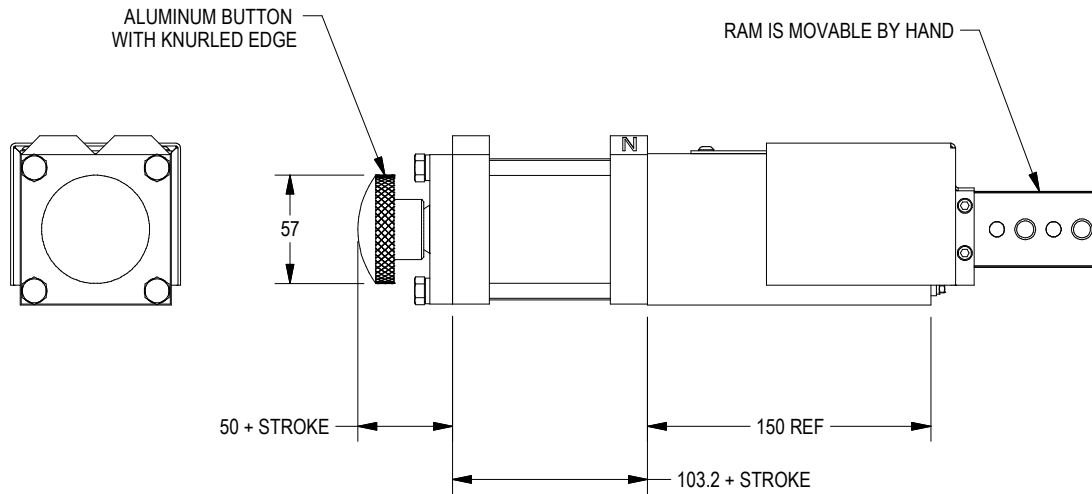
(DO NOT SCALE DRAWING)

WELKER

ENGINEERED PRODUCTS

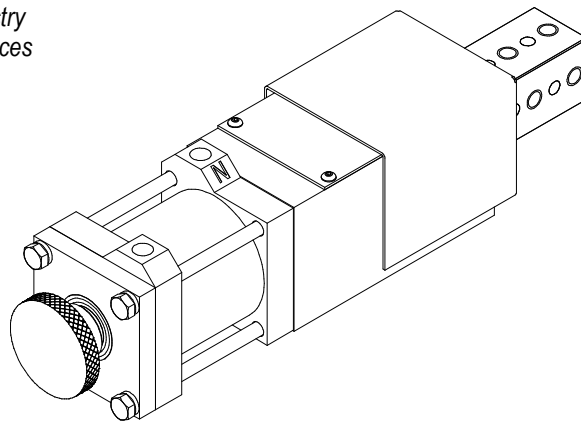
(800) 229-0890 www.welkerproducts.com

OPTIONS



DOUBLE ROD CYLINDER WITH PALM BUTTON OPTION "P" LOOSE BODY FOR MANUAL OPERATION

Manual Operation Note:
Loose body units are
not held to industry
standard tolerances



(DO NOT SCALE DRAWING)

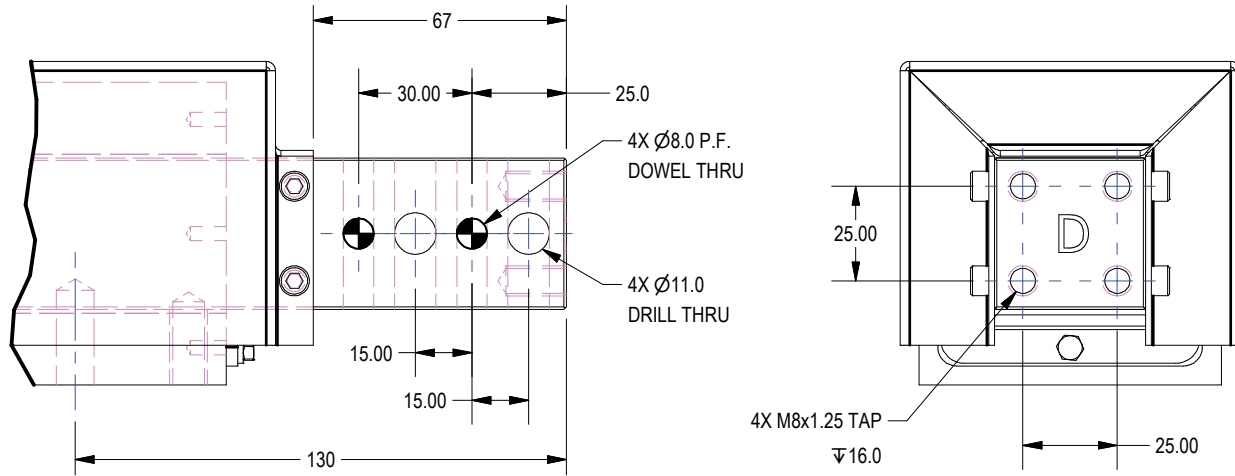
WELKER

ENGINEERED PRODUCTS

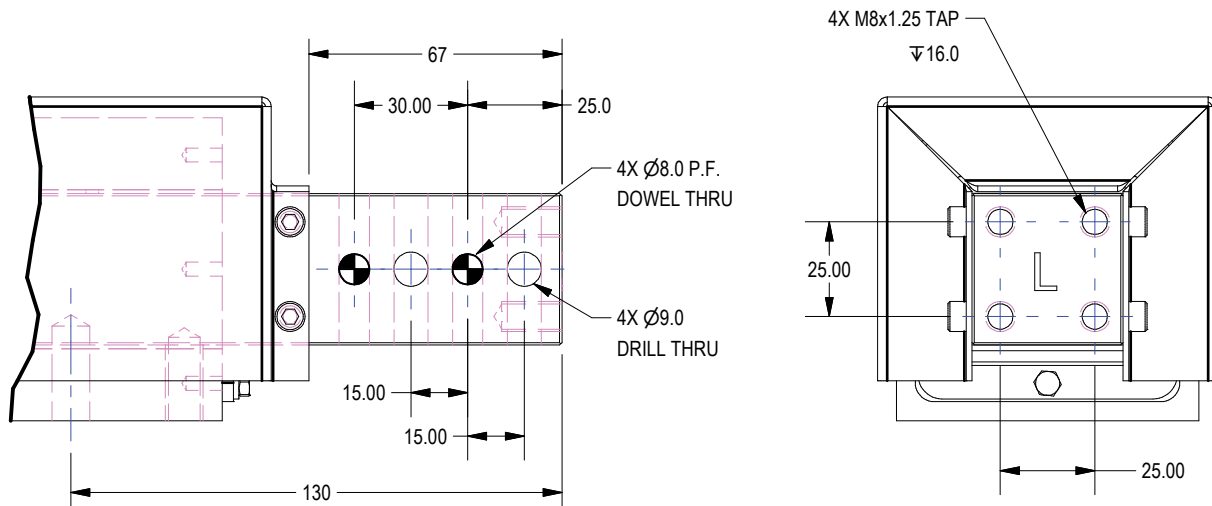
(800) 229-0890 www.welkerproducts.com

STANDARD RAM OPTIONS

(SEE SUPPLEMENTAL RAM SHEET FOR NON-STANDARD RAM OPTIONS)



RAM STYLE 'D'



RAM STYLE 'L'

(DO NOT SCALE DRAWING)

WELKER

ENGINEERED PRODUCTS

(800) 229-0890 www.welkerproducts.com

DETON OPTION

U
B
4
N
0
2
5
B
0
1
0
D
A
E
1
A
0
0
0

Detent
(Steel ram only)

0 None

D Detent

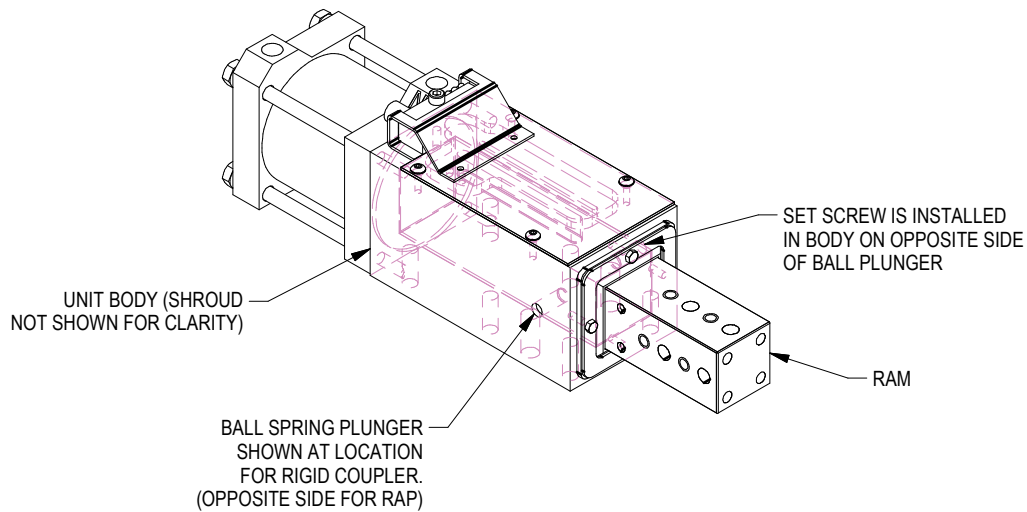
NOT AVAILABLE WITH ADJUSTABLE STOP OPTIONS E, F, S

DETON OPTION IS A BALL SPRING PLUNGER INSTALLED IN UNIT BODY TO ASSIST WITH HOLDING THE RAM IN EXTENDED POSITION (ONLY) WITH LOSS OF AIR PRESSURE.

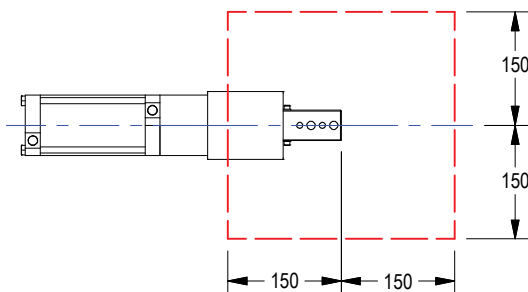
DETON IS NOT DESIGNED TO HOLD GEO LOCATION WITH LOSS OF AIR PRESSURE.

DETON OPTION WILL CAUSE VISIBLE LINES IN THE RAM'S EXTERIOR COATING.

BALL SPRING PLUNGER IS A WEAR ITEM AND WILL NEED TO BE REPLACED AT RECOMMENDED INTERVALS.



NOTE: IF RAP/RIGID COUPLER IS SWITCHED IN THE FIELD, THE BALL PLUNGER AND SET SCREW MUST BE SWITCHED TO OPPOSITE SIDES.



DETON OPTION EFFECTIVE WEIGHT LIMIT IS 24 LBF FOR VERTICAL APPLICATIONS.

MOUNTED TOOLING MUST BE WITHIN APPROVED APPLICATION RADIUS FROM END OF RAM.

(DO NOT SCALE DRAWING)

WELKER

ENGINEERED PRODUCTS

(800) 229-0890 www.welkerproducts.com

Welker UB4 Series Shot Pin Technical Information

Body Mounting: Square ram packages are high precision full contact plane bearing units and therefore must be mounted to a flat surface. **Mounting surfaces must be flat within .002" (0.05mm).**

Ram Mounting: Square ram shot pin units use a standard NAAMS L-Block pattern with 15mm spacing. Spacing allows mounting of 3 and 4 hole pin retainers and L-blocks to the ram. Through holes can be tapped and fitted with standard thread inserts.

Shrouds: Safety orange steel shrouds are available for additional protection. Shrouds prevent undesirable buildup of contamination from welding and machining applications. Welker specifically recommends shroud usage in MIG, TIG and arc welding applications. Shrouds should only be removed if clearance problems exist and conditions permit. Consult Welker.

Wipers: The wiper is the only maintenance item on Welker pin units. It is a custom molded moly impregnated urethane wiper. Welker recommends changing the wiper yearly. Specific applications may require more or less frequent wiper service.

Stroke: The stroke accuracy of shot pins is limited to that of the cylinder. Normal cylinder stroke accuracy is $\pm .015"$ (0.38mm). For adjustable and repeatable "end of stroke" conditions, see extend stop options. Rap couplings cause the unit to be less than the nominal stroke of the cylinder. The 40mm ram units have a 2mm rap. The rap allows the cylinder to accelerate without load, acting like a slide hammer. The impact of the coupler helps free tooling from a bound condition, similar to a dowel puller. Most applications using a pneumatic shot pin should have rap couplings while most hydraulic shot pin applications should use a rigid coupler. Rigid couplers must be used on all extend and retract stop units.

Welker cylinders do not require lubrication.

Switch: UB4 is available with World Switch or cylinder switch.

Repeatability: Shot pin units utilize a full contact bearing surface for high repeatability. Repeatability within $\pm .002"$ (0.05mm) part to part is achievable.

Wear: Defined as variance in position under load over time. Shot pin tests indicate maximum wear of .002" wear at 3 million cycles.

Loading and Deflection: Maximum deflection is $\pm .005"$ and is measured at the **end of the ram** up to the specified strokes and up to the loads and distances as shown below. Longer extensions can be used at lower tolerances and loads. Pins mounted closer to the body exhibit less deflection. For applications with longer strokes and higher loads, consult Welker.

