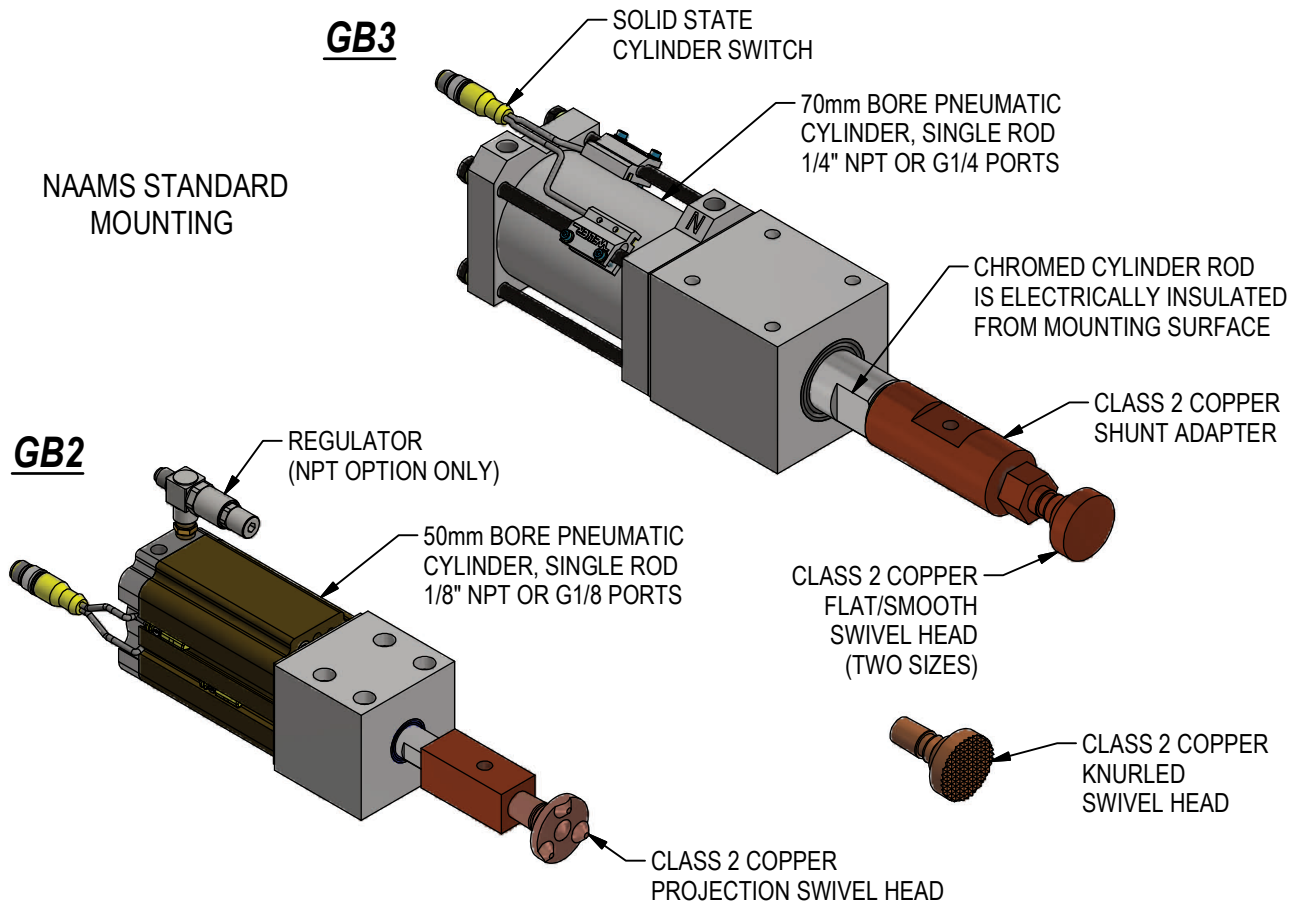


GROUND BLOCK RETRACT CYLINDERS

FOR ALL MIG & ARC WELDING APPLICATIONS IN FIXTURES, TRUNIONS, AND DIAL TABLES.
INSULATED GROUND BLOCK CYLINDERS ARE IDEAL FOR SINGLE-POINT WELDING.



- THE GB SERIES GROUND BLOCK CYLINDERS PRODUCE A CONSISTENT PRESSURIZED GROUND, EVEN AFTER SIGNIFICANT ELECTRODE WEAR, BY SHORT-STROKING THE CYLINDER 10mm. INCREASES WELD CONSISTENCY.
- RETRACTABLE GROUND BLOCKS ALLOW EASY PART REMOVAL OR TRANSFER.
- FITS STANDARD #2MT SWIVEL FOOT GROUND BLOCKS. BI-DIRECTIONAL BODY MOUNTING; FLOOR OR REMOTELY MOUNTED. LUBRICATION-FREE DESIGN.
- INEXPENSIVE COMPARED TO MACHINED GROUND BLOCKS.
- **RATED FOR 10,000 AMPS, MAX 30,000 AMPS**

REV 1/20/21

ORDERING INFORMATION

NOTE: ALL BOXES MUST BE FILLED IN FOR A COMPLETE PART NUMBER

	G	B		N							0	
Series	_____											
2	GB2											
3	GB3											
Stroke	_____											
025	GB2: 025 & 50mm (only)											
025	GB3: 025, 032, 050, 075 & 100mm											
Port Type	_____											
N	NPT Ports											
G	G Ports											
Port Location	_____											
1	"1" Shown (2, 3 or 4)											
Switch	_____											
00	No switch											
LX	See Welker Cylinder Switch Chart											
Nose Option	_____											
0	None											
A	Copper shunt adapter											
B	Copper shunt adapter w/ Flat Swivel head											
C	Copper shunt adapter w/ Serrated Swivel head											
D	Copper shunt adapter w/ Projection Swivel head											
E	Copper shunt adapter w/ Small Flat Swivel head											
Regulator	_____											
0	No Regulator											
R	Regulator: For NPT ports only (GB2 only) Minimum output force is 45lbf @ 16 PSI											

**** A minimum of 10mm stroke to go is recommended for all applications.**

	Switch	Part Number	Manufacturer	Description
Cylinder Switches	L3	SWITCH L3* L3 switch is weld field immune, comparable to World Switches. Dual sensor switch, 1 per cylinder	Welker	4-Wire, 4-Pin, DC (PNP) M12 X 1 Quick Disconnect
	L5	MK5113 Single sensor switch, 2 switches per cylinder	ifm Efector	3-Wire, 4-Pin, DC (NPN) M12 X 1 Quick Disconnect

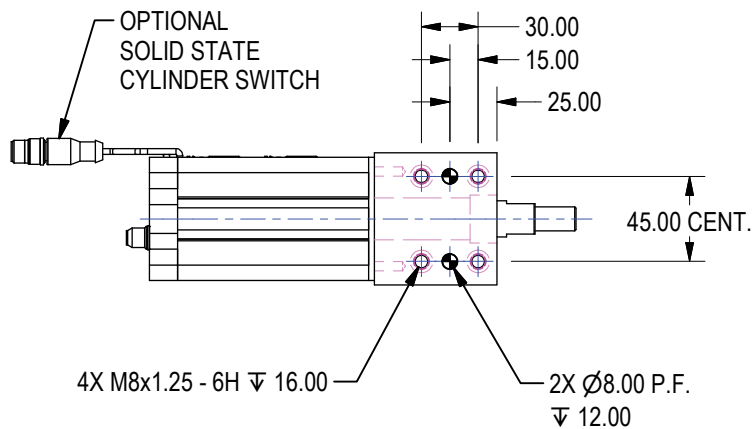
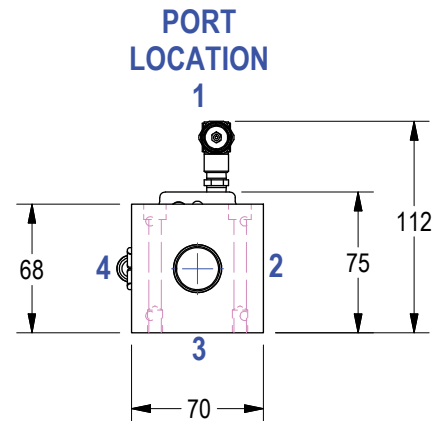
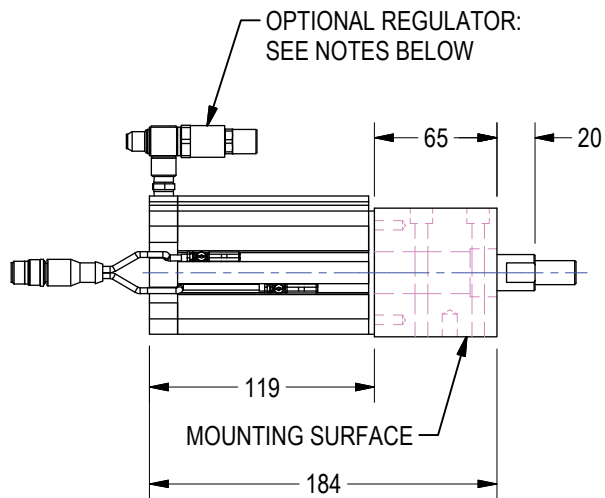
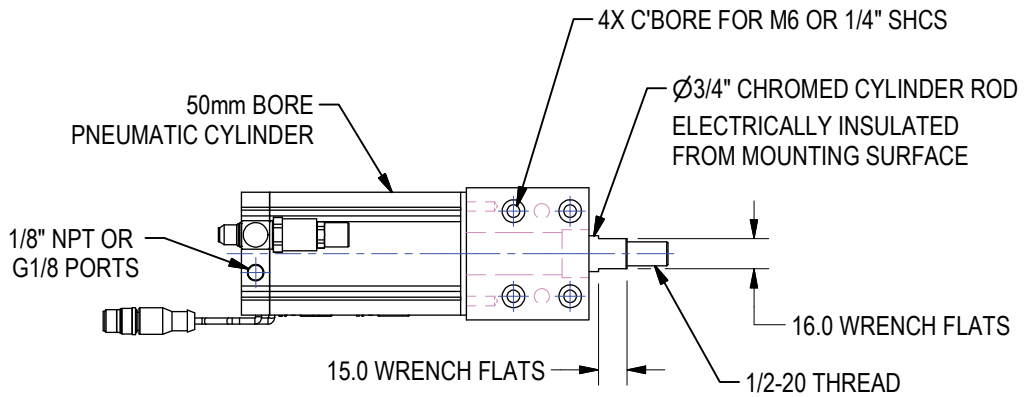
Standard Switch Option - All other options may affect price and delivery

*Note that some mid and low frequency DC resistance applications (i.e. aluminum resistance welding applications) may cause a fault. In these applications, it is recommended that the sensor be ignored/bypassed during the welding cycle.

(DO NOT SCALE DRAWING)



GB2 DIMENSIONS



APPROX. WEIGHT: 6.2 LBS

REGULATOR NOTES:

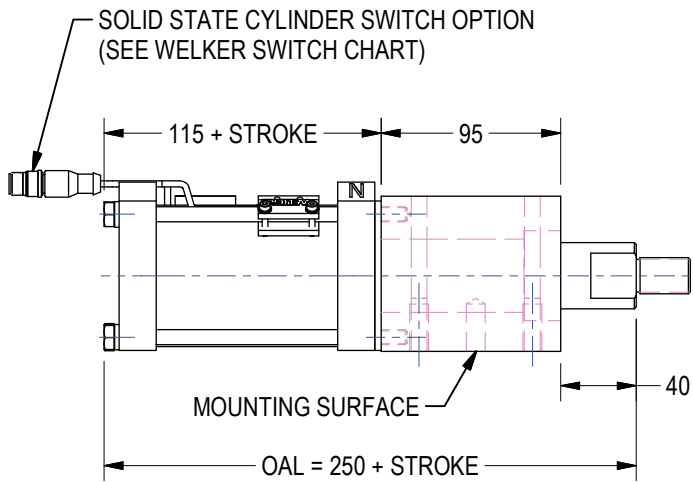
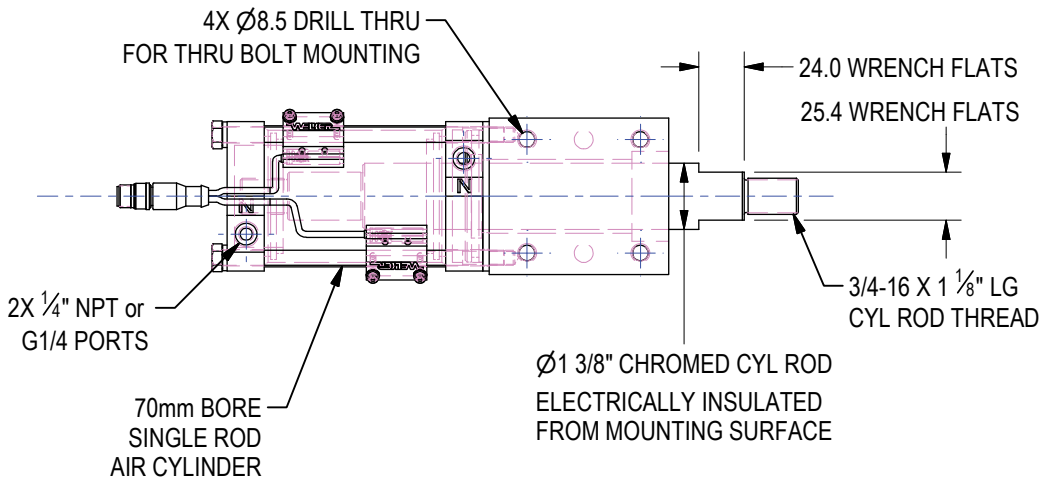
1. FOR NPT OPTION ONLY
2. MINIMUM OUTPUT FORCE IS 45lbf @ 16 PSI

(DO NOT SCALE DRAWING)

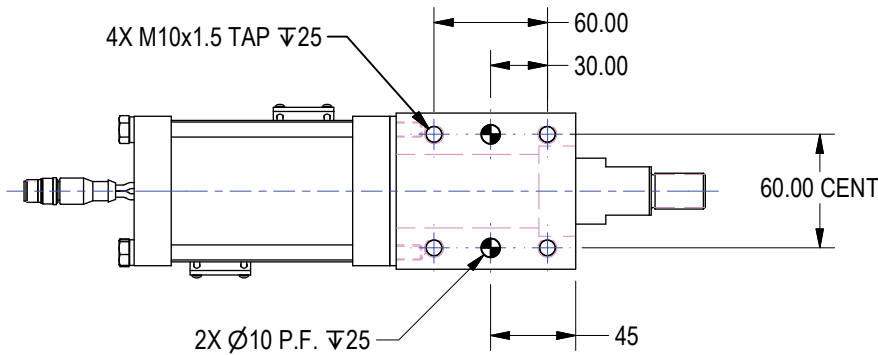
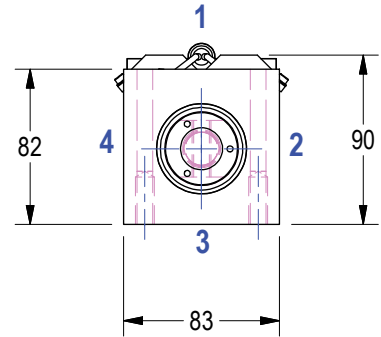
ENGINEERED PRODUCTS

248-528-2020 www.welkerproducts.com

GB3 DIMENSIONS



PORT LOCATION

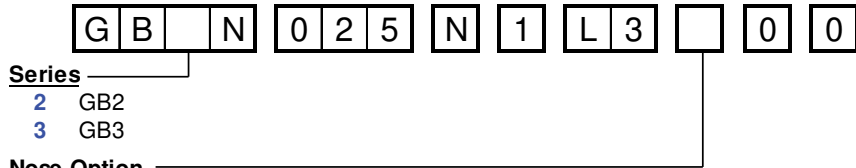


UNIT WEIGHTS**	
UNIT STROKE	WEIGHT
25mm	11.5 LBS
32mm	11.5 LBS
50mm	12.5 LBS
75mm	13.0 LBS
100mm	13.5 LBS

**WEIGHTS SHOWN ARE APPROXIMATE AND WILL VARY WITH OPTION SELECTION.

(DO NOT SCALE DRAWING)

NOSE OPTIONS



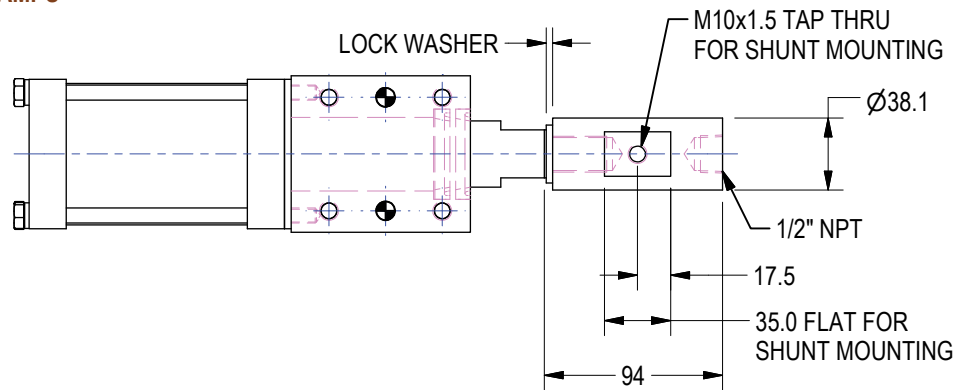
- Series**
- 2 GB2
 - 3 GB3

- Nose Option**
- 0 None
 - A Copper shunt adapter
 - B Copper shunt adapter w/ Flat Swivel head
 - C Copper shunt adapter w/ Serrated Swivel head
 - D Copper shunt adapter w/ Projection Swivel head
 - E Copper shunt adapter w/ Small Flat Swivel head

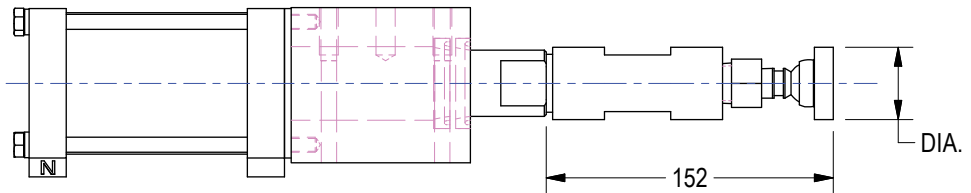
***SWIVEL HEADS ARE CLASS 2 COPPER
RATED FOR 10,000 AMPS
MAXIMUM 30,000 AMPS**



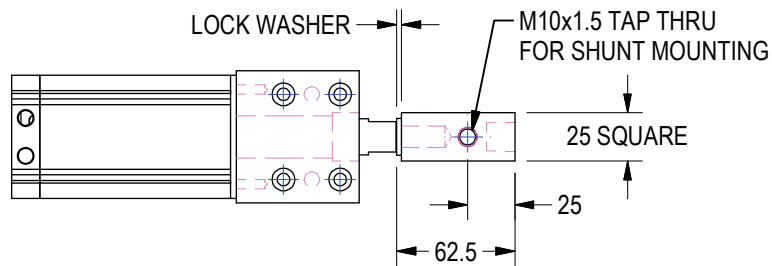
GB3 NOSE OPTION A



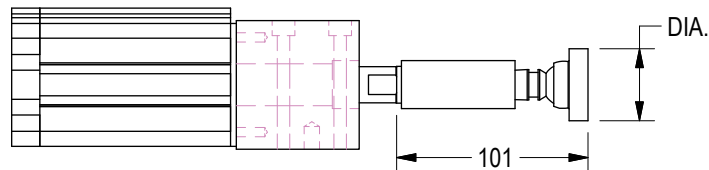
GB3 NOSE OPTIONS B, C, D, E



GB2 NOSE OPTION A



GB2 NOSE OPTIONS B, C, D, E



DIA.: NOSE OPTION DIAMETER (mm)			
B	C	D	E
38.1	38.1	38.1	22.2