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

GB3

SOLID STATE CYLINDER SWITCH

70mm BORE PNEUMATIC CYLINDER, SINGLE ROD 1/4" NPT OR G1/4 PORTS

CHROMED CYLINDER ROD IS ELECTRICALLY INSULATED FROM MOUNTING SURFACE

CLASS 2 COPPER SHUNT ADAPTER

GB2

REGULATOR (NPT OPTION ONLY)

50mm BORE PNEUMATIC CYLINDER, SINGLE ROD 1/8" NPT OR G1/8 PORTS

CLASS 2 COPPER FLAT/SMOOTH SWIVEL HEAD (TWO SIZES)

CLASS 2 COPPER KNURLED SWIVEL HEAD

CLASS 2 COPPER PROJECTION SWIVEL HEAD
** A minimum of 10mm stroke to go is recommended for all applications.
GB2 DIMENSIONS

50mm BORE PNEUMATIC CYLINDER

4X C’BORE FOR M6 OR 1/4“ SHCS

Ø3/4“ CHROMED CYLINDER ROD ELECTRICALLY INSULATED FROM MOUNTING SURFACE

1/8“ NPT OR G1/8 PORTS

15.0 WRENCH FLATS

16.0 WRENCH FLATS

1/2-20 THREAD

OPTIONAL REGULATOR: SEE NOTES BELOW

PORT LOCATION

1/8“ NPT OR G1/8 PORTS

MOUNTING SURFACE

184

119

OPTIONAL SOLID STATE CYLINDER SWITCH

4X M8x1.25 - 6H \( \phi \) 16.00

2X \( \phi \) 8.00 P.F. \( \phi \) 12.00

APPROX. WEIGHT: 6.2 LBS

REGULATOR NOTES:
1. FOR NPT OPTION ONLY
2. MINIMUM OUTPUT FORCE IS 45lbf @ 16 PSI
GB3 DIMENSIONS

<table>
<thead>
<tr>
<th>UNIT STROKE</th>
<th>UNIT WEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>25mm</td>
<td>11.5 LBS</td>
</tr>
<tr>
<td>32mm</td>
<td>11.5 LBS</td>
</tr>
<tr>
<td>50mm</td>
<td>12.5 LBS</td>
</tr>
<tr>
<td>75mm</td>
<td>13.0 LBS</td>
</tr>
<tr>
<td>100mm</td>
<td>13.5 LBS</td>
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</tbody>
</table>

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

(SEE WELKER SWITCH CHART)

4X Ø8.5 DRILL THRU FOR THRU BOLT MOUNTING

2X ¼" NPT or G1/4 PORTS

70mm BORE SINGLE ROD AIR CYLINDER

Ø1 3/8" CHROMED CYL ROD ELECTRICALLY INSULATED FROM MOUNTING SURFACE

SOLID STATE CYLINDER SWITCH OPTION

MOUNTING SURFACE

OAL = 250 + STROKE

PORT LOCATION

UNIT WEIGHTS**
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

(DO NOT SCALE DRAWING)