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 12/4/17
** A minimum of 10mm stroke to go is recommended for all applications.
GB2 DIMENSIONS

50mm BORE PNEUMATIC CYLINDER

1/8" NPT OR G1/8 PORTS

4X C'BORE FOR M6 OR 1/4" SHCS

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

15.0 WRENCH FLATS

16.0 WRENCH FLATS

1/2-20 THREAD

119 MOUNTING SURFACE

65 20

OPTIONAL REGULATOR: SEE NOTES BELOW

PORT LOCATION

30.00
15.00
25.00

68 3 75

70

4X M8x1.25 - 6H 16.00

2X Ø8.00 P.F. 12.00

45.00 CENT.

3/4" CHROMED CYLINDER ROD

ELECTRICALLY INSULATED FROM MOUNTING SURFACE

OPTIONAL SOLID STATE CYLINDER SWITCH

ELECTRICALLY INSULATED FROM MOUNTING SURFACE

 APPROX. WEIGHT: 6.2 LBS

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

DO NOT SCALE DRAWING
GB3 DIMENSIONS

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 (SEE WELKER SWITCH CHART)

MOUNTING SURFACE

OAL = 250 + STROKE

UNIT WEIGHTS**

<table>
<thead>
<tr>
<th>UNIT STROKE</th>
<th>WEIGHT</th>
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</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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</table>

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

<table>
<thead>
<tr>
<th>Series</th>
<th>GB2</th>
<th>GB3</th>
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</thead>
</table>

**Nose Option**

<table>
<thead>
<tr>
<th>Option</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>None</td>
</tr>
<tr>
<td>A</td>
<td>Copper shunt adapter with Flat Swivel head</td>
</tr>
<tr>
<td>B</td>
<td>Copper shunt adapter with Serrated Swivel head</td>
</tr>
<tr>
<td>C</td>
<td>Copper shunt adapter with Projection Swivel head</td>
</tr>
<tr>
<td>D</td>
<td>Copper shunt adapter with Small Flat Swivel head</td>
</tr>
</tbody>
</table>

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

**GB3 NOSE OPTIONS**

- **A**: Copper shunt adapter with Flat Swivel head
- **B**, **C**, **D**, **E**: Copper shunt adapters with different swivel heads

**Dimensions**

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

**GB2 NOSE OPTIONS**

- **A**: Copper shunt adapter with Small Flat Swivel head
- **B**, **C**, **D**, **E**: Copper shunt adapters with different swivel heads

**Dimensions**

- **LOCK WASHER**: M10x1.5 TAP THRU FOR SHUNT MOUNTING
- **DIA.: NOSE OPTION DIAMETER (mm)**
  - B: 38.1
  - C: 38.1
  - D: 38.1
  - E: 22.2