CMW Hydraulic Equalizing adapter units are used to equalize the weld force when two or more welds are required simultaneously. The equalizing action is developed in a closed hydraulic system and is accomplished by hydraulically interconnecting two or more units. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.
HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES
18-826 COMPLETE #1 SIZE "NU-TWIST" ASSEMBLY

18-801 Adapter Sub-Assembly (Page 48)
18-82167-22 #10-24 x 7/8 Lg. Soc.head cap screw (Included in shunt assembly)
18-10050 Water nipples fit standard 3/8 hose
18-82165 Flexible shunt
18-82617-1 Washer
18-82616 Shunt Bar
18-82614-1Seal
18-82167-13 1/4-20 x Lg. Soc. head cap screw
18-80150 Adapter Nut
18-10061-5 Electrode seal
18-80110 Adapter Base
18-8262 Shunt Sub-Assembly (Included are two 18-82167-22 cap screws shown above)
18-8261 Hydraulic Unit Assembly
18-82613 Retaining Screw
18-82622 Insulator
18-10060-6 "O" Ring Seal

18-826 Complete #1 size "NU-TWIST"
Hydraulic assembly see page 52 for 5RW cap electrode, 4 RW, & 5 RW electrode complete #1 size assemblies

Phone: 866-634-8884 Fax: 866-239-6995 Email: cmw@cmwinc.com
HYDRAULIC EQUALIZING ADAPTERS AND ASSEMBLIES

CMW Hydraulic Equalizing adapter units are used to equalize the weld force when two or more welds are required simultaneously. The equalizing action is developed in a closed hydraulic system - and is accomplished by hydraulically interconnecting two or more units. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.

18-827 #2 SIZE UNIT WITH "NU-TWIST"® SHOWN

<table>
<thead>
<tr>
<th>Complete Unit Part No.</th>
<th>Unit Size.</th>
<th>Electrode Attachment</th>
<th>Height A</th>
<th>Mean Height B</th>
<th>Mean Electrode Base Height C</th>
</tr>
</thead>
<tbody>
<tr>
<td>18-827</td>
<td>#2</td>
<td>NU-TWIST</td>
<td>1-13/16</td>
<td>1-49/64</td>
<td>3-53/64</td>
</tr>
</tbody>
</table>
CMW Hydraulic Equalizing adapter units are used to equalize the weld force when two or more welds are required simultaneously. The equalizing action is developed in a closed hydraulic system - and is accomplished by hydraulically interconnecting two or more units. We recommend using fire resistant hydraulic fluid compatible with BUNA "N" such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.

TWO #1 OR #2 SIZE HYDRAULIC UNITS MOUNTED TO CUSTOMER’S DESIRED ELECTRODE SPACING.*

<table>
<thead>
<tr>
<th>Assembly Unit Part No.</th>
<th>Unit Size</th>
<th>&quot;T&quot; Connector Shank Dia. B</th>
<th>Base Plate Length C</th>
<th>Base Plate Width D</th>
<th>Spacing* (Specify on Order A)</th>
<th>Max. Recommended Weld Force Per Electrode LBS</th>
<th>Mean Height to Electrode Base E</th>
</tr>
</thead>
<tbody>
<tr>
<td>18-846 18-84601-01</td>
<td>#1</td>
<td>None 1&quot;</td>
<td>6</td>
<td>3</td>
<td>1-1/32&quot; to 5&quot;</td>
<td>1000</td>
<td>3-13/64</td>
</tr>
<tr>
<td>18-84601-02 18-84601-03</td>
<td>1-1/4&quot; 1-1/2&quot;</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(12,000 Amps @ 10% duty cycle)</td>
<td></td>
</tr>
<tr>
<td>18-847 18-84701-01</td>
<td>#2</td>
<td>None 3&quot;</td>
<td>7-1/2</td>
<td>3-1/2</td>
<td>1-3/4&quot; to 6&quot;</td>
<td>2000</td>
<td>3-61/64</td>
</tr>
<tr>
<td>18-84701-02 18-84701-03</td>
<td>1-1/4&quot; 1-1/2&quot;</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(16,000 Amps @ 10% duty cycle)</td>
<td></td>
</tr>
</tbody>
</table>

Note:
1. Multiple units of 2-8 can also be supplied on custom designed base plates with or without "T" Connectors.
2. Units may be modified with adapters for RW tapered caps and electrodes.
Part No. 18-836 (shown below) is a typical assembly using two 18-826 assemblies set up as a complete self-contained unit for making two spot welds at one time. This unit is so arranged as to allow the center distances to be readily adjusted from 1-3/32” centers to 2-1/4” centers or by rearrangement of the same parts centers maybe adjusted from 2-1/4” to 3-1/2”. This setup also include facilities for filling and bleeding the hydraulic units. “T” Mounting 18-83614 is available to order for assembly 18-836. We recommend using fire resistant hydraulic fluid compatible with BUNA “N” such as HOUGHTO-SAFE #620, 1120 or equivalent. Consult your local industrial lubricant distributor.

<table>
<thead>
<tr>
<th>Assembly Part No.</th>
<th>Hydraulic Unit Size</th>
<th>Electrode Attachment</th>
<th>Adjustable Spacing Range</th>
<th>“T” Connector</th>
<th>Max. Recommended Weld Force Per Electrode LBS</th>
</tr>
</thead>
<tbody>
<tr>
<td>18-836</td>
<td>#1</td>
<td>#1 NU-TWIST</td>
<td>1-1/32 - 2-1/4</td>
<td>NONE</td>
<td>1000 (12000 AMPS @ 10% Duty Cycle)</td>
</tr>
</tbody>
</table>

* Partial disassembly, rearrangement of plates, and bleeding of unit will be necessary to switch centerline ranges.
** Customer must specify dimensions desired.
*** Other attachments available on request.