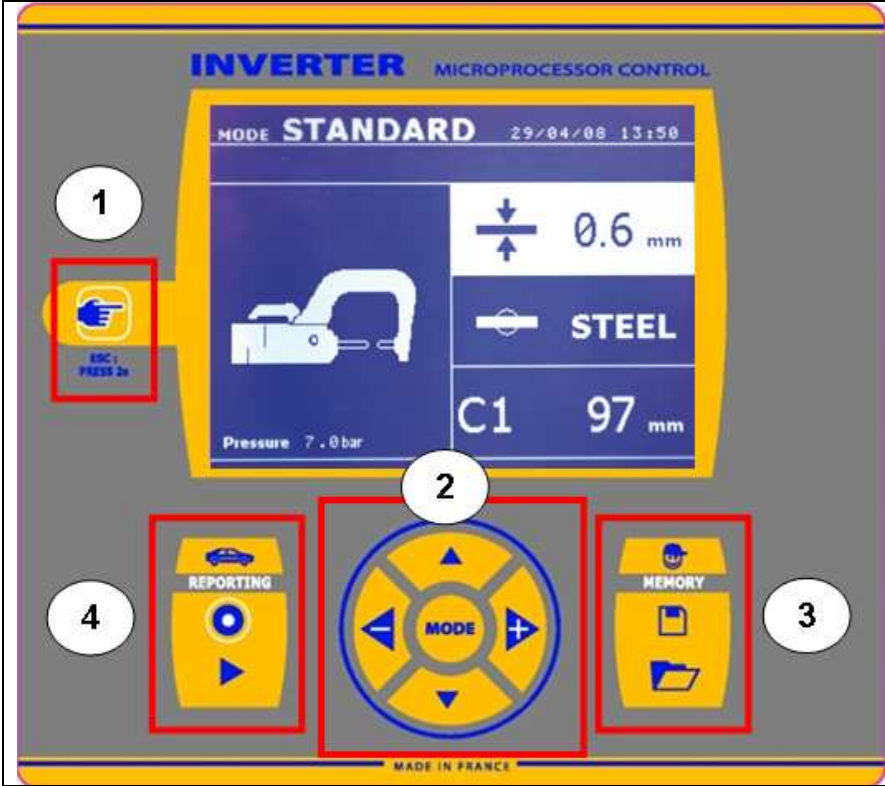





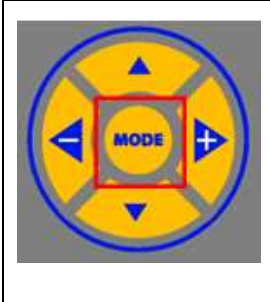
**QUICKGUIDE FOR GYSPOT BP, PTI and 100R MENUS**

**General presentation of the keypad**



1. Key  : allows to come back at any time to the NORMAL welding mode.
2. Keys to navigate through the Menus and select values.
3. Keys related to the saving of the user welding parameters.
4. Keys related to the saving of traceability reports.

**General settings selection**



This menu enables to select :

- the language (French, English, German, ...)
- the date and time
- switch ON or OFF the BEEP alert

Press the UP and DOWN keys to select the requested value. Press the MODE key to validate the choice.







Press the MODE key more than 2 seconds

**Mode selection (3 choices)**

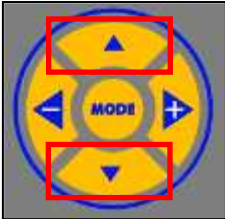





- Press the MODE key
1. STANDARD MODE (to use automatic adjustments)
  2. MANUAL MODE (to use car maker data)
  3. MULTI MODE (to specify the characteristics of each sheet)

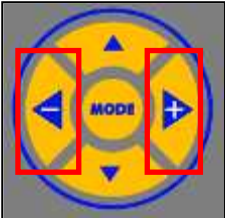

**Tool selection**

					
	1	2	3	4	5
Press the ESC key	1. C clamp 3. X clamp	2. C clamp adjustment (to change arms)	4. X clamp adjustment (to change arms)		5. Single sided gun

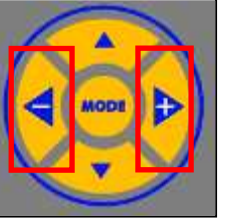

**Navigating through welding parameters (3 choices) – Example in STANDARD mode**

				<p>The selected parameter is highlighted in white</p> <ol style="list-style-type: none"> <li>1. Sheet thickness</li> <li>2. Type of steel</li> <li>3. Arm used</li> </ol>
Use the UP and DOWN keys to change from one parameter to the next				

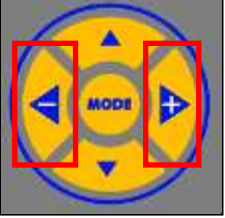

**Sheet thickness selection (9 choices)**

		<p>Select the sheet thickness amongst the following preset values :</p> <p>0.6mm, 0.8mm, 1.0mm, 1.2mm, 1.5mm, 1.8mm, 2.0mm, 2.5mm, 3.0mm</p>
Press ( - ) and ( + ) keys to change the sheet thickness		

**Type of steel selection (4 choices)**

		<p>Select the type of steel amongst the following preset possibilities :</p> <ol style="list-style-type: none"> <li>1. STEEL : coated steels</li> <li>2. HSS</li> <li>3. UHSS</li> <li>4. BORON</li> </ol>
Press ( - ) and ( + ) keys to change the type of steel		

**Arm selection**

		<p>Select the arm used :</p> <p>C arms : from C1 to C5</p> <p>X arms : from X1 to X10.</p>
Press ( + ) and ( - ) keys to change from one arm to the other		


**MANUAL mode**

		<p>In this mode, the welding parameters can be entered manually by the user :</p> <p>Welding current ( I ) : from 1 kA to 13 kA                  Welding time ( T ) : from 80 ms to 850 ms                  Electrode force ( F ) : from 100 daN to 550 daN                  Type of arm : from C1 to C5, from X1 to X10.</p>
<p>Press the UP and DOWN keys to switch from one welding parameter to the next                  Press ( - ) and ( + ) keys to change each welding parameter</p>		

**MULTI Mode**

		<p>In this mode, the characteristics of each sheet can be entered.</p> <p>By default, the third sheet is not selected. To enter parameters for the third sheet, highlight the sheet thickness and press the ( - ) or ( + ) key to make the parameters appear on the screen.</p>
<p>Press the UP and DOWN keys to switch from one welding parameter to the next                  Press ( - ) and ( + ) keys to change each welding parameter</p>		




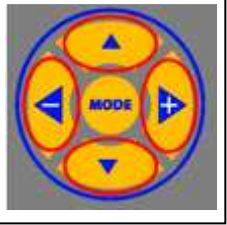



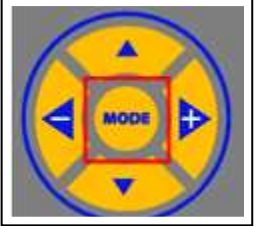


**SPOT COUNTER**

	<p>A welding spot counter allows to inform the user when the caps mounted on the arms are worn out. When 200 welding spots have been performed with the same caps, the message « do control caps » appears on the screen. The user should then change the caps, and reset the spot counter by pressing more than 2 seconds, when the screen shown left is displayed, the  key.</p>
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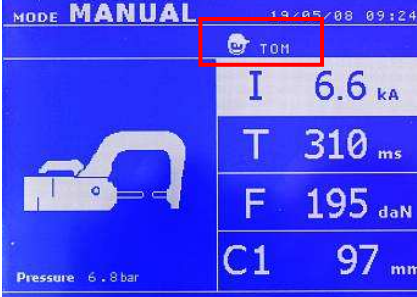


**SINGLE SIDED GUN Mode**

		<p>A NORMAL and MANUAL modes are also available in SINGLE SIDED GUN mode. In NORMAL mode, the welding current and welding time are defined by the machine depending on the sheet thickness selected. In MANUAL mode, the user can select the welding current and welding time.</p>
<p>Available tools : Star, Impact, Graphite Pen, Stud, Rivet and washer, Nut, Thumb wheel, and Single-sided welding</p>		





Saving user welding parameters

		<p>Press the  key : the screen shown left appears.</p> <p>Press the UP and DOWN keys to select a letter or a number : letters from A to Z, and numbers from 1 to 9 can be selected. Use the ( + ) and ( - ) keys to enter the next character, or come back</p>
		<p>Pressing the  key validates the program name.</p> <p>Note : Pressing briefly the  key allows to erase the complete name.</p>
		<p>The program then appears in the list of saved programs.</p> <p>Press the  key to come back to the welding mode.</p>


Recall a user program

		<p>Press the  key : the list of saved programs appears on the screen.</p> <p>Use the UP and DOWN keys to highlight the required program. Press the  key to select the program.</p>
		<p>The logo  appears followed by the name of the program on the top right hand side of the screen.</p> <p>The saved user welding parameters are called back on the screen. Pressing the  key during 2 seconds allows to come back to NORMAL mode.</p>

Erasing a user program


		<p>Press the  key : the list of saved programs appears on the screen. Highlight the program to erase.</p> <p>Pressing briefly the  key allows to erase the selected program.</p>
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**Saving a report**



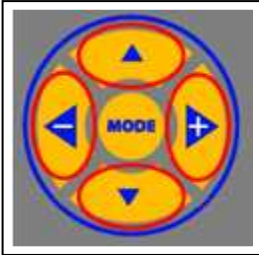
19/05/08 09:25

Name of report



Press the  key : the screen shown left appears on the screen.


Press the UP and DOWN keys to select a letter or a number : letters from A to Z, and numbers from 1 to 9 can be selected.




19/05/08 09:26


Name of report

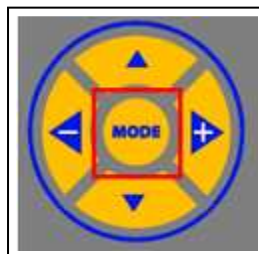
1 1 3 A M Z 3 5



Use the ( - ) and ( + ) keys to enter the next character, or come back to the previous one.

Note : Pressing the  key allows to erase the complete name.


Pressing the  key saves the report name and starts the record.





19/05/08 09:26

MODE STANDARD

113AMZ35



The logo  appears, followed by the name of the report, on the top left hand side of the screen.




Pressure 6.5 bar

0.6 mm

STEEL

C1 97 mm


The characteristics of the welding spots performed from now on will be saved in this report.





19/05/08 09:26

MODE STANDARD


113AMZ35



When the job is finished, stop the record by pressing the  key.

The logo  and the name of the report disappear from the screen.


**Read the contents of a report**





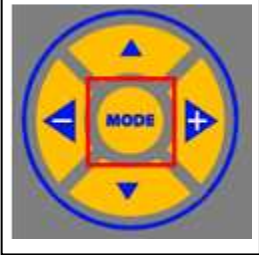
19/05/08 09:28


113AMZ35

N°	X/C	I (kA)	F (dB)	Observation
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	
0.0.4.0.1	C1	6.5	190	

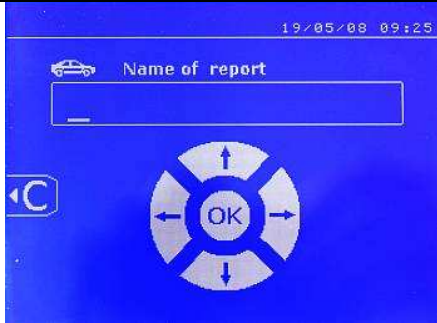
Press key  to display the contents of the existing reports.


Use  and  keys to display the requested report.

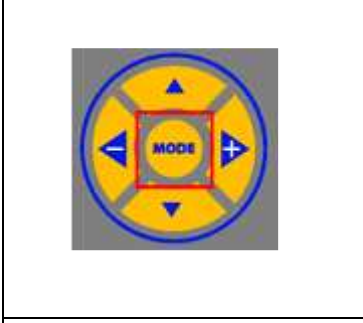


Press the  key allows to exit the report reading mode.


Resuming an existing report

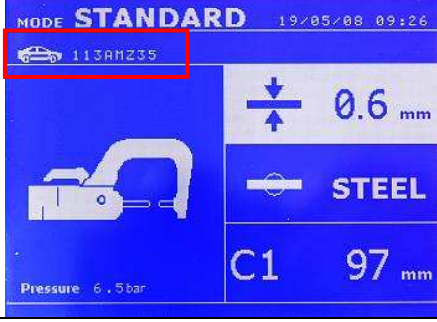


Press the  key : the screen shown left appears.




Type the name of the report corresponding to the job the user wants to resume.

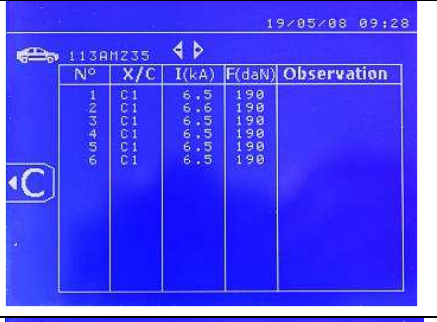
Press the  key to start recording.



The name of the report appears on the top left hand side of the screen. The characteristics of the welding spots performed from now on will be saved after the previous ones. No data is erased.

To recall the name of the report without having to type it in again, it is possible to visualise the report, and then press the MODE key to exit the report reading mode. When pressing the RECORD key, the name of the last selected report will appear on the screen. Validate this name by pressing the  key.

Erasing a report



Press the  key to visualise the recorded reports.

Use  and  keys to display the requested report.



Press the  key to erase the requested report : the sign  appears on the screen.

Pressing the  key a second time will erase the report.