

Volvo Car Corporation Approved Spot Welder

GYS

Gyspot inverter BP.LC



Gyspot Inverter BP.LC

Technical Data

Mains connection:

Nominal voltage	3 x 400 V, 50 Hz
Fuses	32 A (Circuit breaker)
Connecting cable	4 x 10 mm ²

Machine performance:

Nominal power at 50 % duty cycle	18 kVA
Short circuit current	13 000 A
Maximum current	16 V
Pressure min./max.	3 / 8 bar
Cooling water	3l / min.
Electrode force max.	380 daN (4 bar) 550 daN (8 bar)

Construction:

Dimensions L x W x H	800 x 650 x 2050mm
Weight approx.	140 kg
Protection	IP 21
Insulation class	F
Cooling	WF
Certification	CE



Volvo Car Spot Welding Specification

Spot welding machine

Volvo aftermarket test procedure OK

Base requirement

Welding controller (direct current)

Welding current minimum
(measured at the electrodes) 9 kA

Shall have constant welding current controller

Shall have current pulsing program

Shall have up-slope control

Spot welding gun

Equipped with C gun

Working depth minimum 300 mm

Electrode opening minimum 100 mm

Electrode pressure minimum
with all arm sets. 240 daN
(measured at 6 bars air pressure)

Welding duration adjustable:
- Low limit 0
- High limit minimum 1,2 s

Volvo Car Corporation Approved Spot Welder

GYS

Gyspot inverter 125L-C



Gyspot Inverter 125L-C

Technical Data

Mains connection:

Nominal voltage	3 x 400 V, 50 Hz
Fuses	32 A (Circuit breaker)
Connecting cable	4 x 10 mm ²

Machine performance:

Nominal power at 50 % duty cycle	18 kVA
Short circuit current	12 500 A
Maximum current	16 V
Pressure min./max.	3 / 8 bar
Cooling water	3l / min.
Electrode force max.	380 daN (4 bar) 550 daN (8 bar)

Construction:

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