

"GV 640B MF multi-spot" welding system



The task:

The GV 640B dishwasher inner drum consists of a 3-sided shell and a welded-on rear wall. The rear wall is attached in the correct position to the shell, which has been bent into a U-shape, by spot welding.

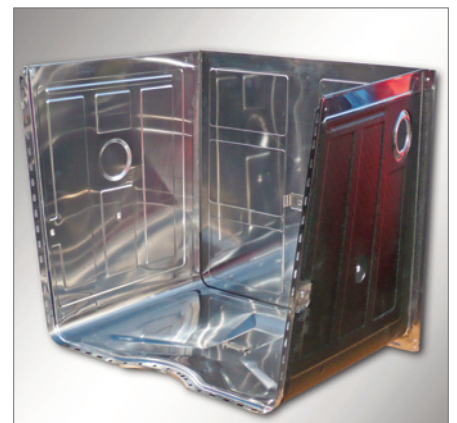
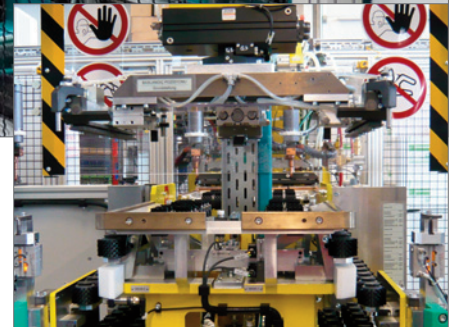
The conntronic solution:

The machine is built as a reversing 2-station turntable system with integrated MF welding technology. Four servo-motor driven welding cylinders with their own MF transformer are used for each hood side (left, right and roof).

Technical data of the system:

Space requirements WxDxH:	4800x3000x2400 mm
System cycle time:	≤21 s
Electrode force:	Each 9 kN at 6 bar
Welding technology:	BoschRexroth

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