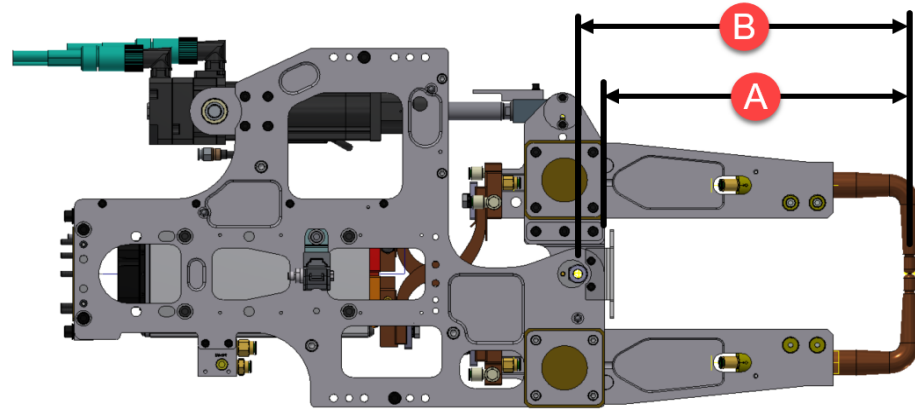




## FlexGun™ Ultra/Ultra HC



Max. Angle of Opening [deg]	Actuator Plane to Weld Plane [mm]
21	220

### Ultra P and Ultra P HC Maximum Tip Force Rating Vs. Throat

Useable Throat Depth "A" [mm]	Pivot to Weld Point "B" [mm]	Gun Ratio	Approx. Tip Opening [mm]	10 mm Pitch Servo Actuator <sup>1</sup>		5 mm Pitch Servo Actuator <sup>1</sup>	
				Max. Weld Force [kN]	Max. Weld Force [lbf]	Max. Weld Force [kN]	Max. Weld Force [lbf]
250	285	0.77	102	5.1	1154	8.90	2000
275	310	0.71	111	4.7	1061	8.76	1970
325	360	0.61	129	4.1	914	7.55	1697
375	410	0.54	147	3.6	802	6.63	1490
425	460	0.48	165	3.2	715	5.91	1328
475	510	0.43	183	2.9	645	5.33	1198
525	560	0.39	201	2.6	587	4.85	1091
575	610	0.36	219	2.4	539	4.45	1001
600	635	0.35	228	2.3	518	4.28	962

<sup>1</sup>Weld actuator has built in water cooling.

All weld force ratings are subject to change depending on arm, electrode and cap requirements for specific applications.

8.9 kN [2000 lbf] limit is based on typical standard cap geometries, electrode lengths and library arm designs. Higher forces may be possible with special engineering considerations.

The Ultra P gun style is optimized for a 5 mm pitch actuator.