



Model 72
(Parallel Gap)

Model 71
(Opposed)

70 Series Servo Motor Driven Weld Heads

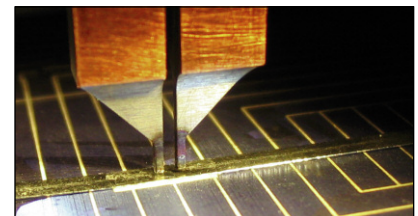
- Programmable speed and positions
- Controlled servo motor actuation eliminates overforce
- Extremely low-end force control (0.25 lbs)
- “Soft Touch” part clamping
- Displacement and force options communication
- Unitip and blade thermode option

Designed for use in automation or benchtop welding, Amada Miyachi America’s 70 Series **servo motor welding heads** offer fast, repeatable electrode motion control for a wide range of resistance welding applications. Two different models are available, each equipped with an easy-to-program, state-of-the-art servo motor controller that allows precise programming of electrode position and speed for up to 32 different weld schedules.

KEY FEATURES

- Write and save up to 32 motion schedules
- “Soft-touch” part clamping minimizes impact force and allows verification of part alignment prior to welding
- Fast follow-up means less weld splash and more consistent welds
- Individual speed control for “stroke to search” and “search to weld” increases flexibility and throughput; good for automation
- Overforce protection ensures concise repeatable force, less weld splash, and reduced part deformation
- Constant applied force - independent of part height - ensures weld repeatability
- Easy programming and fast, efficient schedule adjustment

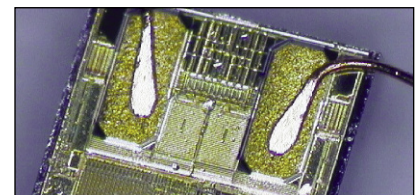
TYPICAL APPLICATIONS



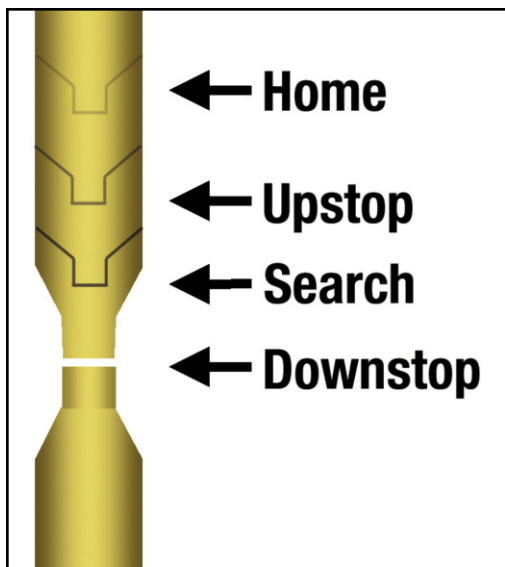
Solar cell



Pacemaker interconnects



0.002 in diameter magnet wire to gold pad



SERVO MOTOR DRIVEN WELD HEADS

Programmable electrode positions – accurate to .004 in

- “Home” position allows for easy access during maintenance
- Electrode in the “Upstop” position in the “Ready” state
- The first level of the footswitch moves the electrode down to the “Search” position at a programmable “Soft-touch” speed
- The second level of the footswitch applies the pre-set welding force, with no overforce
- Programmable “Downstop” inhibits welding if parts are not present

TECHNICAL SPECIFICATIONS

Model Number	Model 71	Model 72
Head type	Opposed	Parallel
Force range	0.25 – 8 lbs.*	0.25 – 8 lbs.* per electrode
Weld force method	Spring force setting	
Actuation method	Servo motor	
Electrode stroke	1.5 in max. (.004 in steps)	
Throat depth inches	4	8
Number of schedules	32 (selectable externally)	
Electrode speed	Start point – Mid point – 8 speeds adjustable by schedule (20-300 mm/s) Mid point – Welding point – 4 speeds adjustable by schedule (7.5-30 mm/s) 8 settings (100, 200, 300, 400, 500, 1000, and 2000 ms, external END signal)	
Power supply	100 - 220 VAC 50/60 Hz	
Welding current	3000 amps @ 2% DC	

*Force range dependent on which spring is used.

WEIGHT & DIMENSIONS

Model Number	Model 71	Model 72	Controller
Dimensions (L x W x H)	8.5 in x 3.14 in x 11.8 in (216 mm x 80 mm x 300 mm)	15.9 in x 4.7 in x 10.6 in (404 mm x 120 mm x 270 mm)	9.6 in x 2.5 in x 6.1 in (243.8 mm x 63.5 mm x 154.9 mm)
Weight	7.7 lbs (3.5 kg)	16 lbs (7.3 kg)	6.6 lbs (3 kg)



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