



## 70 Series Servo Motor Driven Weld Heads

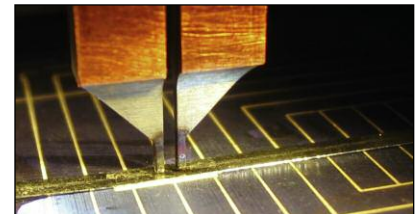
- Programmable speed and positions
- Controlled servo motor actuation eliminates overforce
- Extremely low-end force control (0.25 lbs)
- “Soft Touch” part clamping
- Displacement and force options communication
- Unitip and blade thermode option

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.

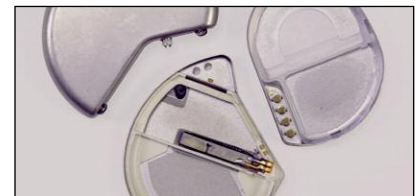
### KEY FEATURES

- 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

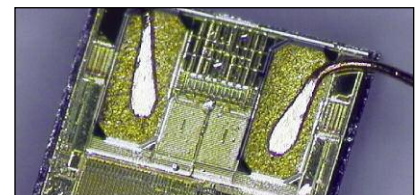
### TYPICAL APPLICATIONS



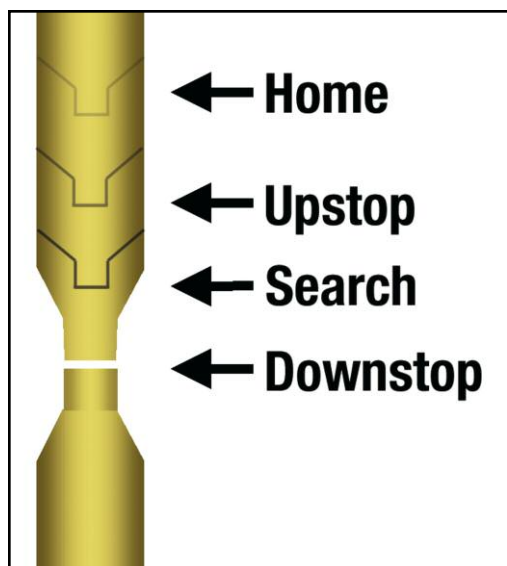
*Solar cell*



*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 – 16 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)



### AMADA MIYACHI AMERICA, INC.

1820 S. Myrtle Ave. • Monrovia, CA 91016 US  
T: (626) 303-5676 • F: (626) 358-8048  
info@amadamiyachi.com • www.amadamiyachi.com  
ISO 9001 Certified Company • 24/7 Repair Service: 1-866-751-7378

#### AMERICAS

AMADA MIYACHI  
AMERICA (Midwest Office)  
Detroit, Michigan  
T: (248) 313-3078  
midwestsales@amadamiyachi.com

AMADA MIYACHI DO  
BRASIL LTDA.  
São Paulo, Brasil  
T: +55-11-4193-3607  
antonio.ruiz@amadamiyachi.com

#### EUROPE

AMADA MIYACHI  
EUROPE GmbH  
Munich, Germany  
T: +49-89-839403-0  
info@amadamiyachi.eu

#### ASIA

AMADA MIYACHI CO., LTD.  
Isehara, Japan  
T: +81-4-7125-6177  
sales@miyachi.com

AMADA MIYACHI  
SHANGHAI CO., LTD.  
Shanghai, China  
T: +86-21-6448-6000  
jwu@msc.miyachi.com

AMADA MIYACHI  
KOREA CO., LTD.  
Seoul, Korea  
T: +82-31-8015-6810  
dykim@mkc.miyachi.com

AMADA MIYACHI  
TAIWAN CO., LTD.  
Taipei, Taiwan  
T: +886-2-2585-0161

AMADA  
(THAILAND) CO., LTD.  
Bangkok, Thailand  
T: +66-2170-5900  
info@mtl.miyachi.com

AMADA  
VIETNAM CO., LTD.  
Ha Noi, Vietnam  
T: +84-4-6261-4583

AMADA MIYACHI  
INDIA PVT., LTD.  
Bangalore, India  
T: +91-80-4092-1749  
info@miyachiindia.com

AMADA MIYACHI  
AMERICA (Mexico Office)  
El Paso, Texas  
T: (915) 881-8765  
mxsales@amadamiyachi.com

Specifications subject to change without notice. Copyright© 2018 AMADA MIYACHI AMERICA, INC. The material contained herein cannot be reproduced or used in any other way without the express written permission of AMADA MIYACHI AMERICA, INC. All rights reserved.

follow us on:

