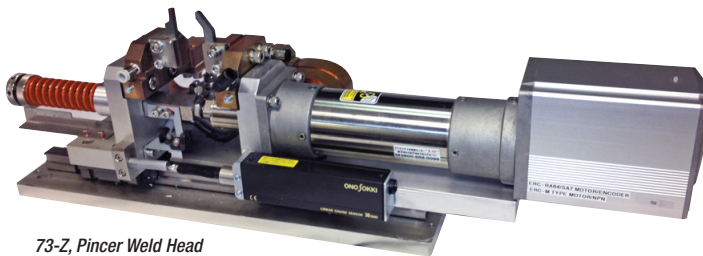


Model 73

Servo Motor Driven Weld Head



73 Opposed Weld Head



73-Z, Pincer Weld Head

- Programmable speed and positions
- Controlled servo motor actuation eliminates overforce
- Force range 15 lbs to 110 lbs.
- Durable and robust head design
- Displacement and force options
- Remote control I/O and PC communication

Designed for use in automation or benchtop welding, Miyachi Unitek's Model 73 and Model 73-Z weld heads offer fast, repeatable electrode motion control for a wide range of resistance welding applications. The Model 73 weld head is an easy-to-program, state-of-the-art servo motor controller that allows precise programming of electrode position and speed for up to 31 different weld schedules. The 73-Z pincer weld head has self centering electrode clamping and floating mechanism to ensure the part is centered between the electrodes every time.

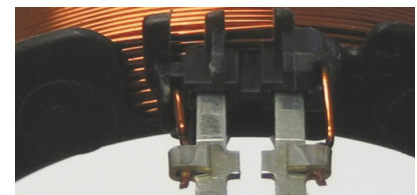
KEY FEATURES

- **Individual speed control** for “stroke to search” and “search to weld”
Good for automation – increases flexibility and throughput
- **Machine builder module** – A module option without a lower electrode or extrusion provides convenient machine mounting
- **31 schedules** – Write and save up to 31 motion schedules
- **Fast follow-up** – Less weld splash, more consistent welds
- **Overforce protection** – Ensures concise, repeatable force, less weld splash, reduced part deformation
- **Force independent of part height** – Constant applied force ensures weld repeatability
- **Easy programming** – Fast, efficient schedule adjustment
- **“Soft-touch” part clamping** – Minimizes impact force – allows verification of part alignment prior to welding

TYPICAL APPLICATIONS



Terminal connections for sensors

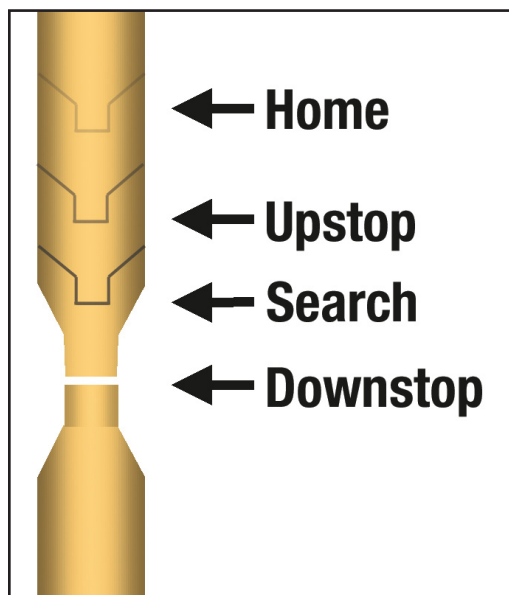


Magnet wire to tang termination



Joining of stamped sub-assemblies

SERVO MOTOR DRIVEN WELD HEAD



Programmable Electrode Positions – ACCURATE TO .004”

- The “Home” position allows for easy access during maintenance.
- The electrode is 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.
- The programmable “Downstop” inhibits welding if parts are not present.

SPECIFICATIONS

Model Number	73 Head/73-Z Head
Force Range Lbs.	15-110
Weld Force Method	Spring force setting
Actuation Method	Servo motor
Electrode Stroke Inches	1.75
Throat Depth Inches (mm)	3.9 (100) / N/A
Number of Schedules	31
Electrode Speed	Start point to Mid point - 8 selectable speeds by schedule (20-125mm/s) Mid point to Weld point - 4 selectable speeds by schedule (5 - 30mm/s)
Squeeze Time Setting	10 settings(0,10,20,30,40,50,60,70,80,90,100ms)
Hold Time Setting	8 settings (100,200,300,400,500,1000,2000ms,external END signal)
Power Supply	100-240VAC \pm 10%, 50/60Hz
Welding Current	7500A
Weight Lbs.	Head: 35.2, Controller: 6.6



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