MH Weld Head Range

Designed specifically for more robust resistance and spot welding applications, AMADA WELD TECH's MH series weld heads are rugged, high performance machines particularly suited to applications such as motor armature fusing, welding automotive stamping, and nut welding.

KEY FEATURES

- Fast follow-up designs improve weld consistency and reduce material expulsion
- Rugged and hard wearing precision slides and solid construction provide long lifetimes
- Load cell and displacement options measure force and weld displacement for complete process benchmarking
- Pre-selected cylinder sizing optimizes force range to application
- Benchtop or pedestal mounting for manual or automated stations

TYPICAL APPLICATIONS

- Welding automotive stamping
- Magnet wire termination
- Nut welding
- Component frame construction
MH-1201A
Force Range: 70-265 lb
10 kA Secondary

KEY FEATURES
The MH-1201A head is an in-line weld head with spring follow-up, mounted to a rigid extrusion. Match to the 300 A inverter for light-to-medium welding applications.

- Integrated in-line spring for fast follow-up
- Precision linear bearings for long life
- Precision anti-rotation bearing ensures proper alignment of upper electrode assembly
- Optional displacement sensor mount
- Optional internal load cell
- Throat depth 2.9 inches

MH-1301A
Force Range: 97-393 lb
10 kA Secondary

KEY FEATURES
Integrated transformer inside head
The MH-1301A head has a solid welded frame with provision for an internal mounted transformer. The head features a cup style cylinder for fast follow-up, and has an optional lower electrode holder.

- Low friction cylinder for fast follow-up
- 3-inch stroke for easy part loading
- Lower T-slot platen for custom tooling
- Throat depth 8 inches
MH-1501C
Force Range: 141-1000 lb
24 kA Secondary

KEY FEATURES
The MH-1501C is a high performance weld head with the flexibility to optimize the force range to the application. Different cylinder options means that the head is always working in the best force and follow-up combination.

- Benchtop or pedestal options
- Low inertia ram with integrated accelerator for fast follow-up
- Ram mounted to slide with zero clearance ball bearings to ensure precise movement
- Many cylinder options for different force ranges
- 8 inch throat depth and height

FORCE RANGE OF MH-1501C WELD HEAD

<table>
<thead>
<tr>
<th>Force, 3 in cylinder at 20 psi</th>
<th>MH-1501C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Force, 3 in cylinder at 80 psi</td>
<td>565 lb (256 kg)</td>
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<tr>
<td>Force, 4 in cylinder at 20 psi</td>
<td>251 lb (114 kg)</td>
</tr>
<tr>
<td>Force, 4 in cylinder at 80 psi</td>
<td>1005 lb (456 kg)</td>
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</tbody>
</table>
# TECHNICAL SPECIFICATIONS

<table>
<thead>
<tr>
<th></th>
<th>MH-1201A</th>
<th>MH-1301A</th>
<th>MH-1501C</th>
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</thead>
<tbody>
<tr>
<td><strong>Electrode force at 20 psi</strong></td>
<td>97 lb (44 kg)</td>
<td>98 lb (44 kg)</td>
<td>See above</td>
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<tr>
<td><strong>Electrode force at 60 psi</strong></td>
<td>265 lb (120 kg)</td>
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</tr>
<tr>
<td><strong>Electrode force at 80 psi</strong></td>
<td>N/A</td>
<td>393 lb (178 kg)</td>
<td>See above</td>
</tr>
<tr>
<td><strong>Air cylinder size</strong></td>
<td>2.48 in (63.0 mm)</td>
<td>2.50 in (63.5 mm)</td>
<td>3 in, 4 in (80 mm, 100 mm)</td>
</tr>
<tr>
<td><strong>Electrode holders</strong></td>
<td>4RW, (#1 MT)</td>
<td>4RW, (#1 MT)</td>
<td>5RW, (#2 MT)</td>
</tr>
<tr>
<td><strong>Valve voltage</strong></td>
<td>115 VAC, 24 VDC Optional</td>
<td>115 VAC, 24 VDC optional</td>
<td>115 VAC, 24 VDC</td>
</tr>
<tr>
<td><strong>Electrode stroke</strong></td>
<td>1.4 in (36 mm)</td>
<td>3 in (76 mm)</td>
<td>4 in (100 mm)</td>
</tr>
<tr>
<td><strong>Throat depth</strong></td>
<td>2.9 in (74 mm)</td>
<td>8 in (203 mm)</td>
<td>8 in (203 mm)</td>
</tr>
<tr>
<td><strong>Max. secondary current</strong></td>
<td>10 kA</td>
<td>10 kA</td>
<td>24 kA *</td>
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</tbody>
</table>

*Higher current and force options available, please contact AMADA WELD TECH

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## WEIGHT & DIMENSIONS

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<tr>
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<th>Dimensions will vary with options ordered. Call AMADA WELD TECH.</th>
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<td><strong>Weight</strong></td>
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