

SR-072A (Parallel Gap)

SR-071A (Opposed)

SR Series

Servo Motor Driven Weld Heads

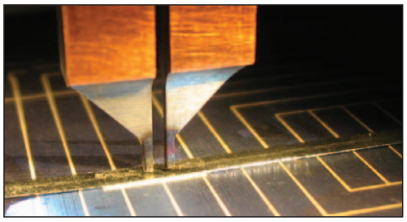
- Programmable speed and positions
- Controlled servo motor actuation eliminates overforce
- Extremely low-end force control (0.25 lbs)
- "Soft Touch" part clamping
- Displacement and force options communication
- Unitip and blade thermode option

Designed for use in automation or benchtop welding, AMADA WELD TECH's SR 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.

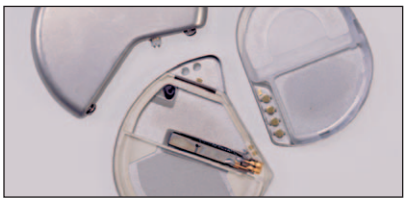
KEY FEATURES

- 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

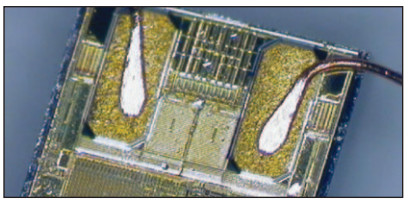
TYPICAL APPLICATIONS



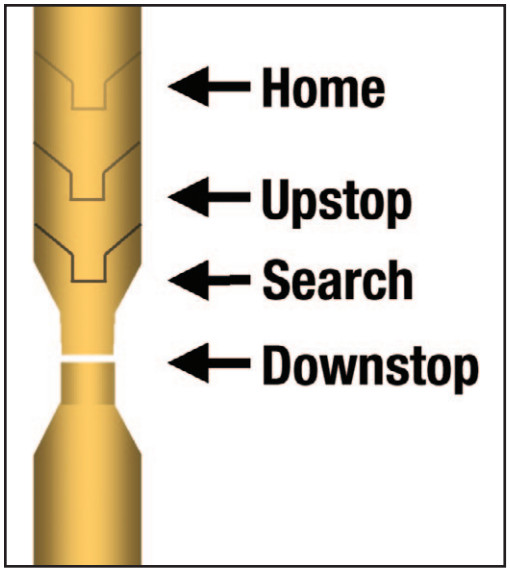
Solar cell



Pacemaker interconnects



0.002 in diameter magnet wire to gold pad



SERVO MOTOR DRIVEN WELD HEADS

Programmable electrode positions – accurate to 0.004 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	SR-071A	SR-072A
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. (0.004 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	SR-071A	SR-072A	Controller
Dimensions (W x D x H)	3.14 in x 8.5 in x 11.8 in (80 mm x 216 mm x 300 mm)	4.7 in x 15.9 in x 10.6 in (120 mm x 404 mm x 270 mm)	2.5 in x 9.6 in x 6.1 in (63.5 mm x 243.8 mm x 154.9 mm)
Weight	7.7 lbs (3.5 kg)	16 lbs (7.3 kg)	6.6 lbs (3 kg)

AMADA

USA Headquarters and Western Technical Center
AMADA WELD TECH
1820 S. Myrtle Ave. • Monrovia, CA 91016 US • T: (626) 303-5676
info@amadaweldtech.com • www.amadaweldtech.com
ISO 9001:2015 Certified Company • 24/7 Repair Service: 1-866-751-7378

AMADA WELD TECH (Eastern Technical Center)
High Point, North Carolina
T: (941) 544-5762
southsales@amadaweldtech.com

AMADA WELD TECH (Midwest Technical Center)
Detroit, Michigan
T: (248) 313-3078
midwestsales@amadaweldtech.com

AMADA WELD TECH GmbH
Puchheim, Germany
T: +49-89-839403-0
infode@amadaweldtech.eu

AMADA WELD TECH SHANGHAI CO., LTD.
Shanghai, China
T: +86-21-6448-6000
jwu@amadaweldtech.com.cn

AMADA WELD TECH KOREA CO., LTD.
Seoul, Korea
T: +82-31-8015-6810
sales@amadaweldtech.co.kr

AMADA TAIWAN CO., LTD.
Taipei, Taiwan
T: +886-3-328-3511

AMADA (THAILAND) CO., LTD.
Bangkok, Thailand
T: +66-2170-5900
info@amada.co.th

AMADA VIETNAM CO., LTD.
Ha Noi, Vietnam
T: +84-24-6261-4583
thuyet@amada.co.jp

AMADA WELD TECH INDIA PVT., LTD.
Bangalore, India
T: +91-80-4092-1749
info@amadaweldtech.in

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