

resistance welding Weld Checkers®

- Multi-Function Weld Monitors
- Weld Thru Current & Force
- Miniature & Handheld Weld Checkers
- Electronic Force Gauges
- Displacement Monitors
- PC Data Collection
- High Speed Printers
- Large Selection of Toroidal Coils



Monitor & Checker Deliverables

- Lower scrap rate
- Improved process control
- ISO 9000 Data collection
- Decreased machine downtime
- Accurate machine set up
- Weld optimization and Design of Experiments (DoE)
- Welding process diagnostics

Why Monitor?

Resistance welding derives its ability to form a proper weld nugget from the simple formula for heat: $H = I^2 \times R \times T$, where "I" is the current, "R" is the resistance, and "T" is the time. The ability to keep these variables within predefined limits allows the process to be maintained. Weld consistency can vary over time due to a number of variables, which affect the heat delivered to the weld. The changes can result in:

- Poor quality welds
- Machine downtime
- High maintenance costs
- Lost revenue

Miyachi Unitek's range of checkers provide the ability to monitor the variables that result in changes in weld heat such as current and time. Other factors that affect weld quality can also be monitored, such as voltage, displacement and force.

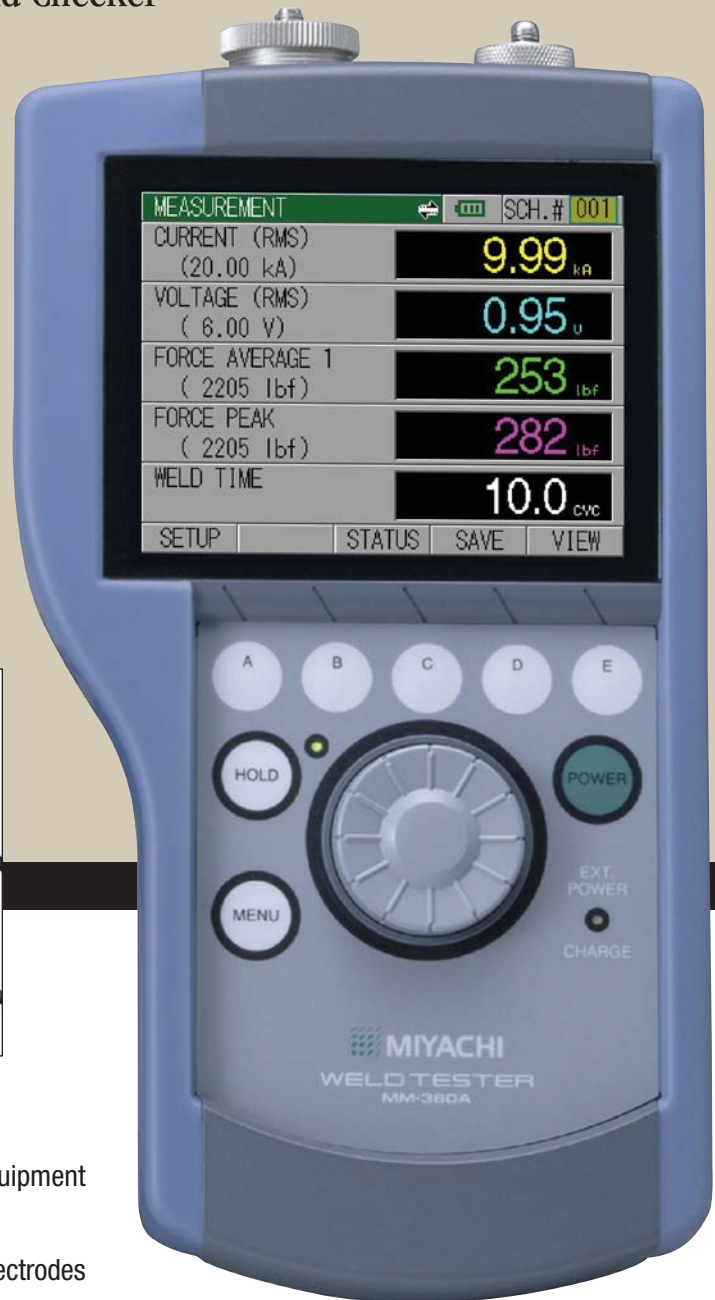


Next Generation Hand-held Portable Weld Checker

MM-380

Key Features

- Measures current, voltage and force, resistance, weld time
- Weld-through sensor
- Easy screen-menu navigation
- Intuitive waveform and data analysis
- Printer and RS232 output



Measure current, voltage and force

Understand, optimize and benchmark your process and equipment

Weld through sensor

Measure force, current and voltage simultaneously at the electrodes

Easy screen navigation

Scroll through and select menus with rotary dial

Waveform and data analysis

Precise graphical displays of waveform time and amplitude

Printer option

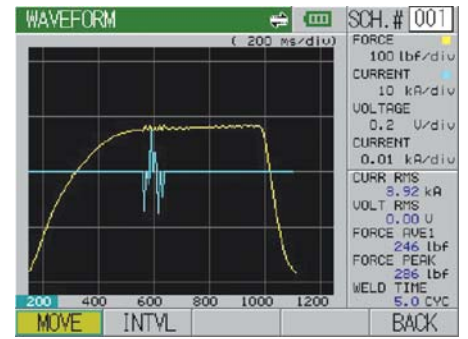
Instant screen prints and waveforms

RS232 output

Color screen capture and data collection through COM port



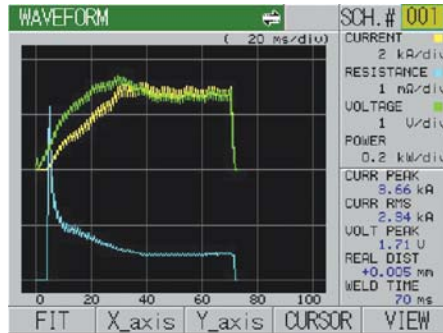
Drop-down Menu Navigation



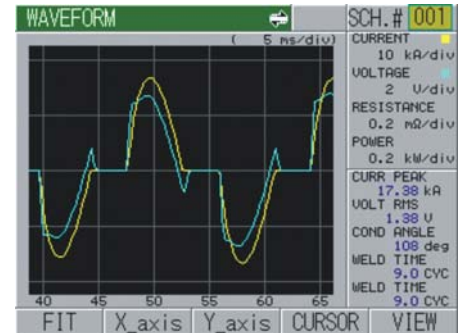
Force and Current Timing

DATE	TIME	SCH	CURRENT (RMS)
~ 06/15	16:28:54	001	10.00 kA
~ 06/15	16:28:46	001	10.03 kA
~ 06/15	16:28:39	001	9.94 kA
~ 06/15	16:28:33	001	10.13 kA
06/15	16:28:27	001	9.82 kA
06/15	16:28:22	001	9.69 kA
06/15	16:28:16	001	8.70 kA
06/15	16:28:10	001	8.22 kA
06/15	16:26:50	001	7.93 kA

Weld History



Current, Voltage and Resistance



Zoom of Current and Voltage

ACCESSORIES



SPECIFICATIONS

Current Range	0.010 to 200.0kA
Force Range	MA-770A-01: 55 to 1102 lbf, (25 to 500 kgf) MA-771A-01: 110 to 2204 lbf, (50 to 1000 kgf) MA-520: 1.10 to 22.04 lbf, (0.50 to 10.00 kgf) MA-521: 11.0 to 220.4 lbf, (5.0 to 100.0 kgf) MA-522: 110 to 2204 lbf, (50 to 1000 kgf)
Voltage Range	0.30 to 20.0 Volts
Current Measurement Time	AC Current, Cycles: 0.5 to 600.0 Cycles at 60 Hz ; AC Current, ms: 1 to 2000 ms DC Current, Cycles: 0.5 to to 120.0 Cycles at 60 Hz; DC Current, ms: 1 to 2000 ms
Force Measurement Time	1 to 6000 ms
Measurement Mode for Voltage and Current	Arithmetic Mean RMS or Maximum, (Peak)
Data Output	RS-232 and Optional External Printer
Number of Schedules	127
Dimensions Inches (mm) H x W x D	9.9 x 5.5 x 2.2 (252 x 140 x 56) Excluding Protrusions
Weight Lbs (kg)	2 (0.9)
Power Requirements, (AC Adapter)	100 - 240 VAC, 50/60Hz
Battery Operation Time	Approximately 2 hours with 1 battery, 4 hours with 2 batteries. 1 battery included.

Next Generation Machine Mounted Weld Monitor

MM-370

Key Features

- Measures current, voltage, force and displacement, resistance, weld time
- Set limits for all parameters
- Comprehensive machine I/O
- Easy screen-menu navigation
- Built-in printer and RS232/485 output



ACCESSORIES



SPECIFICATIONS

Current Range	0.010 to 200.0kA
Force Range (MM-370A-00-01 Only)	MA-770A-01: 55 to 1102 lbf, (25 to 500 kgf) MA-771A-01: 110 to 2204 lbf, (50 to 1000 kgf); MA-520: 1.10 to 22.04 lbf, (0.50 to 10.00 kgf) MA-521: 11.0 to 220.4 lbf, (5.0 to 100.0 kgf); MA-522: 110 to 2204 lbf, (50 to 1000 kgf)
Displacement Range	GS-1613A: 0 - 10mm, 1 micron accuracy; GS-1630A: 0 - 30mm, 1 micron accuracy GS-1000A: 0 - 100mm, 10 micron accuracy
Voltage Range	0.30 to 20.0 Volts
Current Measurement Time	AC Current, Cycles: 0.5 to 600.0 Cycles at 60 Hz ; AC Current, ms: 1 to 2000 ms DC Current, Cycles: 0.5 to 120.0 Cycles at 60 Hz; DC Current, ms: 1 to 2000 ms
Force Measurement Time	1 to 6000 ms
Measurement Mode for Voltage and Current	Arithmetic Mean RMS or Maximum, (Peak)
Data Output	Data can be acquired using the built-in printer or standard RS-232/RS-485 port.
Number of Schedules	127
Dimensions Inches (mm) H x W x D	10.6 x 6.8 x 11.4 (269 x 172 x 290) Excluding Protrusions
Weight Lbs (kg)	11 (5)
Power Requirements	100 to 240 VAC, 50/60Hz, 0.7 Amps

Pocket Weld Testers

MM-315B current/time

Key Features

- Simple current measurement in the palm of your hand
- For AC and Inverter power supplies
- Measures current, cycles, milliseconds and conduction degrees
- Impulse memory, 9 welds
- Rechargeable batteries or AC
- Includes coil, charger and carrying case
- Easy-view LCD
- Memory function for easy recall of impulses

Specifications

Power Supply	Rechargeable battery and AC charger
Current Sensor	Toroidal coil (see table in this brochure)
Current Range	1.00-9.99A, 5.0-49.9kA
Time Range	1 – 99 cycles or 0.01 – 0.80 sec
Conduction Angle	30° – 180°
Dimensions W x D x H In (mm)	2.95 x 1.18 x 6.7 (75 x 30 x 170)
Weight Lbs. (Kg)	1.1 (0.5)



The perfect pocket size troubleshooter.

Electronic Force Gauge



Portable force setting and verification tool.

MM-601A

Key Features

- Simple and accurate handheld force measurement
- Hold and zero functions
- One touch tare setting
- Rechargeable batteries or AC
- External I/O for analog out and measurement hold
- Easy-view LCD
- Analog force output

Specifications

Power Supply	Rechargeable battery and AC charger
Force Sensor	MA-520 max: 9.50 kg (20.9 lbs.) MA-521 max: 95.0 kg (209 lbs.) MA-522 max: 950 kg (2094 lbs.)
Accuracy	±3% full scale
Measurement Speed	Approx. 4 times per second
Dimensions W x D x H In (mm)	2.95 x 1.18 x 6.7 (75 x 30 x 170)
Weight Lbs. (Kg)	1.1 (0.5)

Toroidal Coil Specifications



- For use with all current monitors.

MB-400K	400mm long 1.0 x sensitivity, 5 In. I.D.* (127mm)
MB-800K	800mm long 1.0 x sensitivity, 10 In. I.D. (254mm)
MB-29F	10 x sensitivity, 1 1/8" I.D. (29mm)
MB-35E	1.0 x sensitivity, 1 3/8" I.D. (35mm)
MB-45F	10 x sensitivity, 1 3/4" I.D. (45mm)
MB-60E	1.0 x sensitivity, 2 3/8" I.D. (60mm)
MB-500-15	500mm long 1.0 x sensitivity, 3" I.D. (76mm)

Extension cables for toroidal coils are optional.

*Inner Diameter

Force Sensors & Accessories

Force and Current Sensors



Part Number	Description	Product
MA-520	Force sensor 0.20-9.50kg (0.44-20.9 lbs.)	MM-601A, MA-770A-01, MA-771A-01
MA-521	Force sensor 2.0-95.0kg (4.4-209 lbs.)	MM-601A, MA-770A-01, MA-771A-01
MA-522	Force sensor 20-950kg (44.1-2094 lbs.)	MM-601A, MA-770A-01, MA-771A-01

Accessories

Part Number	Description	Product
145-013	Rechargeable battery, 1.2V 500MAH (4 required for checker)	MM-315B, MM-601A
TP-50KM-A60	Printer paper, 60mm x 25mm (W x L)	MM-370A, MM-380A Optional Printer
18-042-01	Toroidal coil extension (specify length)	All Checkers

Data Collection Software – Winwedge®

Taltech™ Winwedge software can be used to collect data from most checker models. Miyachi Unitek has written some front-end programs that accept basic data to start you on the road to process control and data collection. Exports data directly into Microsoft Excel®

Applicable Models	MM-122A*, MM-370A, MM-380A
Part Number	10-900-02

*MM-122A has its own software – MA-716A

Monitor and Checker Selection Table

MODEL	MM-122A	MM-315B	MM-370A	MM-380A	MM-601A
Current	✓	✓	✓	✓	–
Voltage	–	–	✓	✓	–
Time	✓	✓	✓	✓	✓
Force	–	–	✓	✓	✓
Displacement	–	–	✓	–	–
Schedules	31	–	127	127	–
Stand-Alone	✓	–	✓	–	–
Hand Held	–	✓	–	✓	✓
Pocket	–	✓	–	–	✓
Communications	232/485	–	232/485	232	–
Printer	Option	–	✓	Option	–
Battery Powered	–	✓	–	✓	✓
Line Powered	✓	✓	✓	✓	✓

Ordering Information

Part Number	Description
MM-122A	Weld Checker AC/DC/CD current (RMS and PEAK), cycles/mS. counter, data output (RS-232/485),31 measuring schedules. Current 0.100-1.999KA, 1.00-19.99KA, 10-199.9KA 1 x coil, sold separately
MM-315B	Weld Checker, pocket-size, AC/DC current, memory up to 9 impulses. Measure conduction angle, cycles, and RMS current. Dual range: 1-9.99 and 5-49.9 kA Includes MB-500-15 coil, battery charger, carrying case.
MM-370A-00-00	Weld Checker with current, voltage, power, resistance, time. Toroidal coil and voltage sense cable included.
MM-370A-00-01	Weld Checker with current, voltage, power, resistance, force, displacement, time. Toroidal coil and voltage sense cable included. Displacement sensor sold separately
MM-370A-KIT 1	Weld Checker with GS-1630A 30mm displacement sensor. Toroidal coil included.
MM-380A-KIT 1	Weld Checker with charger, voltage measuring cable and MB-800K toroidal coil. Case sold separately.
MM-380A-KIT 2	Weld Checker with charger, voltage measuring cable, MB-800K toroidal coil, printer, wheeled case.
MM-380A-KIT 3	Weld Checker with charger, voltage measuring cable, MB-800K toroidal coil, printer, wheeled case, 1100lb weld thru sensor.
MM-380A-KIT 4	Weld checker with charger, voltage measuring cable, MB-800K toroidal coil, printer, wheeled case, 2200lb weld thru sensor.
MM-601A	Weld pressure gauge, analog output, hold output. Includes: battery charger and carrying case. Force sensor sold separately. Requires MA-520, MA-521 or MA-522.

Your Local Representative



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