

CHOOSING THE RIGHT SOFT TOUCH SYSTEM

SOFT TOUCH can only be used when connected to Unitrol controls. Because of liability concerns, SOFT TOUCH cannot be connected to other brands.

Successful operation of a SOFT TOUCH system requires three things:

1. The SOFT TOUCH kit has to be selected to exactly match the requirements of the particular welder. Use the **SOFT TOUCH SELECTION SHEET** for this purpose. If you cannot match the welder with the chart, contact Unitrol for assistance.
2. For installation of the HEAVY WEIGHT #9181-34G and #9181-34W options, **the system will not operate unless the ram can fall smoothly by gravity when air is removed from the cylinder.** This often means adjusting the ram guides or cam rollers and lubricating the welding cylinder. In cases with older cylinders that have not been serviced in a long time (or ever), rebuilding the cylinder might be required to replace very stiff piston and shaft seals.
3. Material that will be welded does not contain coatings that will affect continuity reading. See below for more on this.
4. Once the control has been installed, directions for setting the SOFT TOUCH sensor board must be followed carefully. This only requires the use of a small screwdriver and a digital voltmeter.

CHECK MATERIAL TO BE WELDED *BEFORE* QUOTING

SOFT TOUCH depends on reading electrical continuity between the electrodes. If the material being welded has a coating that does not easily conduct electricity, the SOFT TOUCH sensor will not consistently see continuity, and the system will not operate successfully.

Material that might cause problem include HOT ROLLED STEEL (that has not been pickled), wire that has a drawing soap or wax coating, metal with oxide coatings, and rusty metal.

If in doubt, submit some sample coupons of the material being welded to Unitrol for evaluation before quoting a system.

SOFT TOUCH FOR OTHER UNITROL CONTROLS

1. **SIMPLICITY:** To specify SOFT TOUCH to be connected to this control, change the first four option numbers from 9181 to 9161. All other details remain the same.
2. **SOLUTION-2:** One SOFT TOUCH assembly can be used for each welding electrode. Contact Unitrol for assistance.
3. **FREQUENCY CONVERTER (9380 SERIES CONTROLS):** To specify SOFT TOUCH to be connected to this type of weld control, change the first four option numbers from 9181 to 9381. All other details remain the same.
4. **THREE PHASE DC SECONDARY (9480 SERIES CONTROLS):** To specify SOFT TOUCH to be connected to this type of weld control, change the first four option numbers from 9181 to 9481. All other details remain the same.

OLDER UNITROL CONTROLS

SOFT TOUCH can be added to any existing UNITROL control. Contact Unitrol and provide the serial number of the control. We will let you know what cost is involved to add SOFT TOUCH.

UNITROL SOFT TOUCH SELECTION SHEET

Use the following steps to select the appropriate SOFT TOUCH option to match your customer's welder:

| TYPE OF WELDER | ELECTRODES CLOSE SMOOTHLY BY GRAVITY* THEN, FORCE BETWEEN ELECTRODES IS MORE THAN 50LBS | ELECTRODES DO NOT CLOSE SMOOTHLY BY GRAVITY* IF A PRESS WELDER, RAM WEIGHS LESS THAN 50LBS | RAM WEIGHS LESS THAN 50LBS AND FALLS QUICKLY BY GRAVITY* |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------|
| PRESS OR PROJECTION WITH 5" DIAMETER OR <u>SMALLER</u> STANDARD CYLINDER | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34W. This includes all required valves. Parts kit only = #9181-34G. If their existing solenoid valve does not have an external pilot, add solenoid valve #9181-34T | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34Y. This includes all required valves. Parts kit only = #9181-34G. If their existing solenoid valve does not have an external pilot, add solenoid valve #9181-34T | #9181-34H . This includes a parts kit easily installed by the customer. |
| PRESS OR PROJECTION WITH 5-1/2" DIAMETER OR <u>LARGER</u> STANDARD CYLINDER | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34W + #9181-34D. This includes all required valves. Parts kit only = #9181-34G. If their existing solenoid valve does not have an external pilot, add valve #9181-34T | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34Y + #9181-34D. This includes all required valves. Parts kit only = #9181-34G + 9181-34D. If existing solenoid valve does not have an external pilot, add valve #9181-34TD | N/A |
| ROCKER ARM WITH 5" DIAMETER OR <u>SMALLER</u> CYLINDER - PRESS OR PROJECTION WELDER WITH FIXTURE TYPE CYLINDER (SavAir, Grossel, OHMA, etc.) | NA | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34Y. This includes all required valves. Parts kit only = #9181-34G. If their existing solenoid valve does not have an external pilot, add valve #9181-34T | NA |
| ROCKER ARM WITH 5-1/2" DIAMETER OR <u>LARGER</u> CYLINDER | NA | <ol style="list-style-type: none"> Pre-plumbed (recommended for smoother installation) = #9181-34Y + #9181-34D. This includes all required valves. Parts kit only = #9181-34G + 9181-34D. If their existing solenoid valve does not have an external pilot, add valve #9181-34TD | NA |

*When air is removed from the lower port of the welder cylinder