



PRODUCTION ENGINEERING

888-654-WELD (9353)

www.resistanceweldsupplies.com

CHOOSING THE RIGHT SOFT TOUCH SYSTEM

SOFT TOUCH can be used with most standard weld controls.

Successful operation of a SOFT TOUCH system requires three things:

First – Select the proper SOFT TOUCH for your welder type. The SOFT TOUCH kit has to be selected to exactly match the requirements of the particular welder you are using. Use the SOFT TOUCH Selection Sheet for this purpose. If you cannot match the welder with the chart, contact Production Engineering for assistance. For example: when installing 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, rebuilding the cylinder might be required to replace very stiff piston and shaft seals.

Second – Must confirm the material to be welded does not contain coatings that will affect continuity reading. (See below for more on this.)

Third - 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

Please Note: 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 sample coupons of the material being welded to Production Engineering for evaluation before quoting a system.

SOFT TOUCH FOR UNITROL CONTROLS

- 1. SIMPLICITY Control:** 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 Control:** One SOFT TOUCH assembly can be used for each welding electrode. Contact Production Engineering 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.

SOFT TOUCH FOR OTHER BRAND WELD CONTROLS

SOFT TOUCH can be added to most existing weld controls. Contact Production Engineering and provide the control brand, model and serial number. We will let you know what cost is involved to add SOFT TOUCH.