

CALIBRATION OF 9580 & 9581 ACCUSTART

The ACCUSTART is factory calibrated prior to shipment to display values 1psi **higher** than the actual pressure input. This is done to prevent a long delay at the start of each weld while the ACCUSTART is waiting for the last "drop" of air to fill the welder's cylinder.

If field calibration is ever needed, perform the following steps. For this to be a meaningful calibration, be sure that the air pressure gauge used as your standard is at least accurate to .5%fs.

1. Turn switch on ACCUSTART to BYPASS position.
2. Remove upper white metal cover.
3. Turn the ACCUSTART switch to ON. The display should now light up.
4. Set the welder control to NO WELD.
5. Set the ACCUSTART to 99 psi. This will prevent the welder from cycling during the calibration steps below.
6. Set the welder air regulator to exactly 5 psi.
7. Hold the welder initiation switch closed to keep the welding electrodes closed.
8. Read the pressure on the ACCUSTART. It should read 6 psi (1 psi **higher** than the actual value). If it is another value, adjust the **ZERO** multi-turn potentiometer located on the upper right corner of the transducer board (as viewed from inside the enclosure) until it reads a solid 6 psi.
9. Now increase the pressure regulator to exactly 80 psi. The readout should show 81 psi (1 psi **higher** than the actual value). If it is another value, adjust the **SPAN** multi-turn potentiometer located next to the ZERO pot until it reads a solid 81 psi.
10. Repeat steps 9 and 10 until the values remain constant.
11. All values between these two points should now be calibrated to display a value 1psi **higher** than the actual input pressure.
12. Turn the ACCUSTART switch to BYPASS, install the cover, and turn the switch back to the ON position. Your ACCUSTART should now be ready for use.

UNITROL ELECTRONICS, INC.
702 LANDWEHR ROAD
NORTHBROOK, IL 60062
847-480-0115