

# STAND-ALONE SOFT TOUCH SELECTION CHART

<b>TYPE OF WELDER</b> ▼	ELECTRODES CLOSE SMOOTHLY BY GRAVITY*  THEN, FORCE BETWEEN ELECTRODES IS <u>MORE</u> THAN 50LBS		ELECTRODES DO <u>NOT</u> CLOSE SMOOTHLY BY GRAVITY* OR PRESS WELDER: FORCE BETWEEN ELECTRODES IS <u>LESS</u> THAN 50LBS*	
	1Ø AC	MFDC	1Ø AC	MFDC
<b>PRESS OR PROJECTION</b> WITH UP TO 8" DIAMETER STANDARD CYLINDERS	9181-34WB-#	9181-34WM-#	9181-34YB-#	9181-34YM-#
<b>PRESS OR PROJECTION</b> WITH 9"-12" DIAMETER STANDARD CYLINDERS	9181-34WB1-#	9181-WM1-#	9181-34YB1-#	9181-34YM1-#
<b>ROCKER ARM</b> WITH UP TO 8" DIAMETER STANDARD CYLINDERS  or  <b>PRESS OR PROJECTION</b> WITH DUAL AND TRIPLE PISTON CYLINDERS	-	-	9181-34YB-#	9181-34YM-#
<b>ROCKER ARM</b> WITH 9" – 12" DIAMETER CYLINDERS	-	-	9181-34YB1-#	9181-34YM1-#

**# = solenoid valve voltage: 115, 24DC, 24AC**

- **When all air on the welder has been exhausted**

# STAND-ALONE SOFT TOUCH OPTIONS

## RETRACT (HIGH LIFT)

These options protect against pinch point injury when bringing the electrodes out of RETRACT and to the WORK POSITION. While spacing between electrodes in the WORK POSITION is typically ½", the spacing is adjusted by the operator or setup person and can be very small if not done correctly. Since a normal RETRACT system closes electrodes using full line air pressure, any body part caught between the electrodes will be severely injured.

The SOFT TOUCH RETRACT options bring the electrodes down to the WORK POSITION (small opening between electrodes) with low force. This low force remains until the **first** weld is started and continuity between the electrodes is detected. At that time the full RETRACT force is turned on and remains until RETRACT is released. It is offered in two models:

**9181-34JA:** For use in RETRACT systems that have a **3-level foot switch** to both turn on and latch the RETRACT and also then start the weld. This option **includes a proximity switch** and bracket to be installed on the welder. The proximity switch should be adjusted to close when the system is in the lowered WORK POSITION.

**9181-34JB:** For use in RETRACT systems that have a **separate foot switch** to turn on the RETRACT function. A proximity switch is not required and is not supplied with this option.

## TIMED DELAY

**9181-34BPA:** This option is used when welding material that has high-resistance coatings such as titanium oxide. It is also useful when parts have heavy non-conducting coatings, such as drawing compounds, which will prevent continuity between the electrodes. The option includes a faceplate with a high-security key switch and two LED indicators. The switch can be set for **CONTINUITY** or **TIMED DELAY**.

## LIMIT SWITCH

**9181-34LSA:** This option is used when redundant systems are required. The option includes a proximity switch with bracket to be mechanically set to close when the electrodes are less than ¼" apart. The SOFT TOUCH system will not bring the electrodes to full welding force until both this proximity switch is closed **and** continuity is detected.

**9181-34LSB:** This option provides a selector plate with a high-security key switch and two LED indicators. It is used to allow welding of material that has poor conductivity or has poor-conducting coatings. The proximity switch acts as a **depth switch**. It is set to close when the electrodes are less than ¼" apart. The switch allows selection between **continuity** and **depth switch** as needed when welding various materials.

## **115V VOLTAGE SOURCES:**

- 9181-34TECNA:** This option is for use with TGEENA welding controls. It includes a 115VAC transformer and two line fuses factory wired into the main control cable. Input can be 230VAC or 460-VAC. The output of the SOFT TOUCH system is changed from Normally Open to Normally Closed to match the TECNA second-stage initiation scheme.
- 9181-34/115:** This option is used for welding controls that do not have a 115VAC source. It includes a 115VAC transformer with two line fuses factory wired to the main control cable. Input can be 230VAC or 460VAC.
- 9181-34AM-ID40ST:** This option is required when installing SOFT TOUCH on a welder that has an Amada/Miyachi ID40ST welding control. It includes a relay system to handle the unique initiation sequence of that control.
- 9181-34AM-ID40IVST:** This option is required when installing SOFT TOUCH on a welder that has an Amada/Miyachi ID40IVST welding control. It includes a relay system to handle the unique initiation sequence of that control.