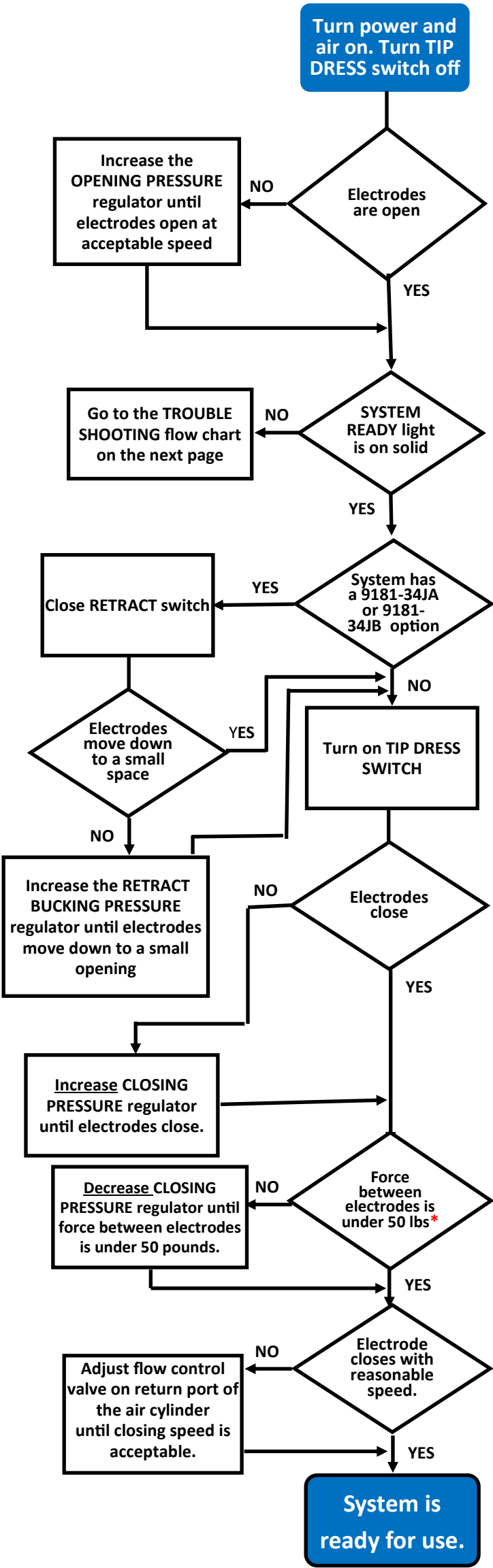
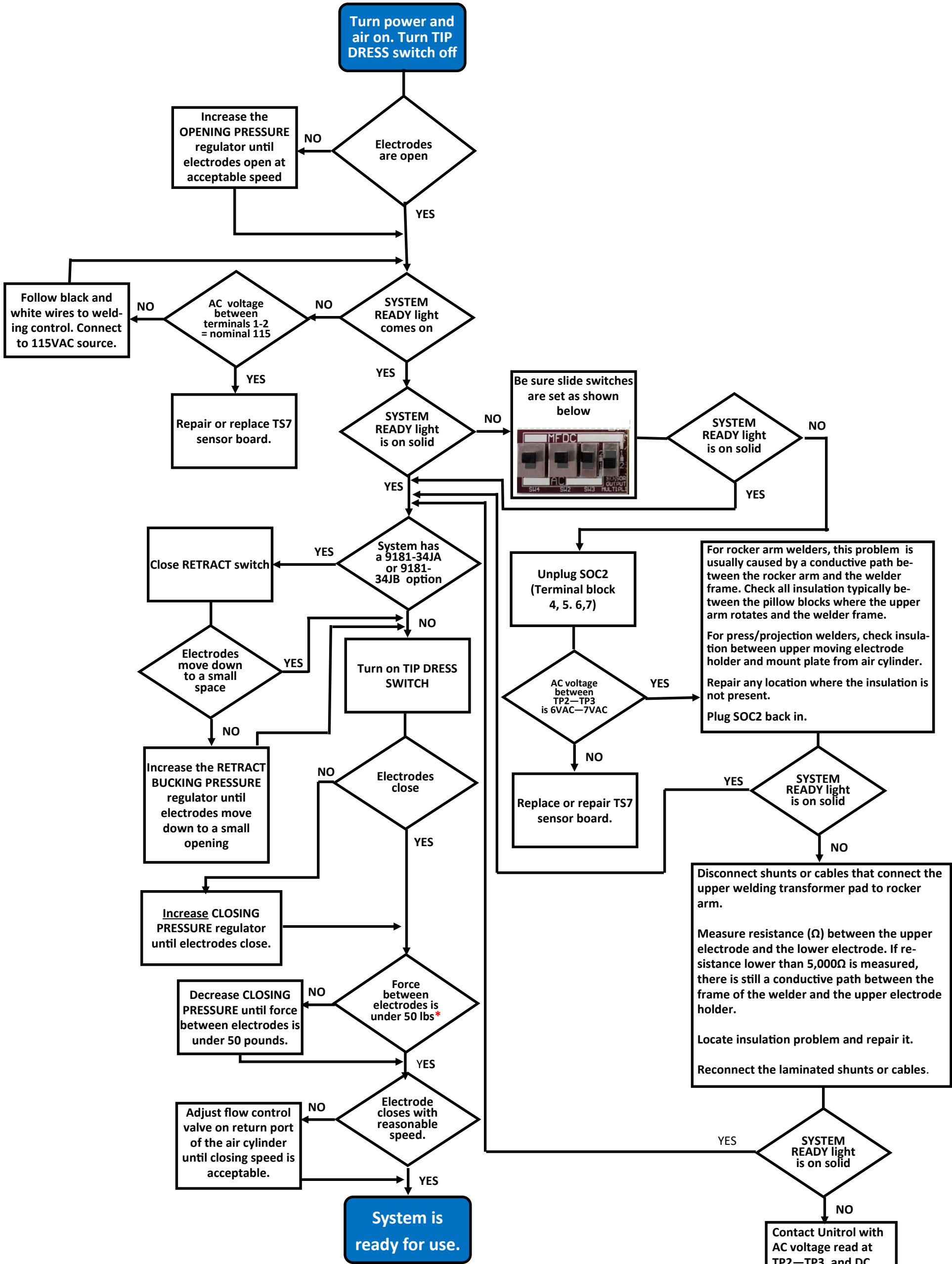


STAND-ALONE SOFT TOUCH **INITIAL STARTUP** FLOW CHART  
LIGHT WEIGHT WELDING MACHINES WITH MFDC CONTROLS  
MODELS 9181-34YM/24DC and 9181-34YM/115



\* If you don't have a tip force measuring instrument, place a wooden office pencil between the electrodes and turn on the TIP DRESS switch. Set the force so that the electrode indents 1/16" or less.

STAND-ALONE SOFT TOUCH **TROUBLE SHOOTING** FLOW CHART  
LIGHT WEIGHT WELDING MACHINES WITH MFDC CONTROLS  
MODELS 9181-34YM/24DC and 9181-34YM/115



\* If you don't have a tip force measuring instrument, place a wooden office pencil between the electrodes and turn on the TIP DRESS switch. Set the force so that the electrode indents 1/16" or less.