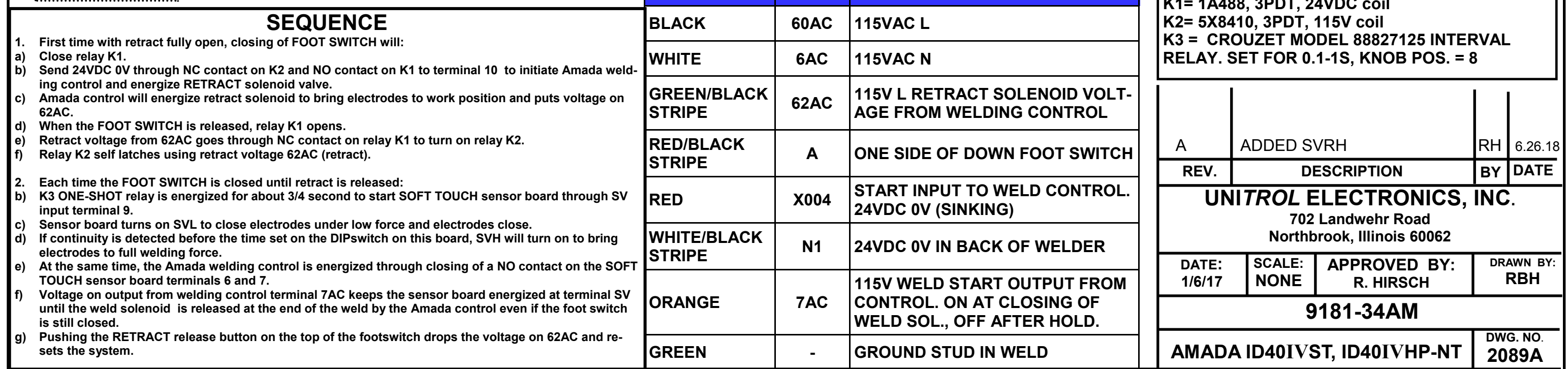
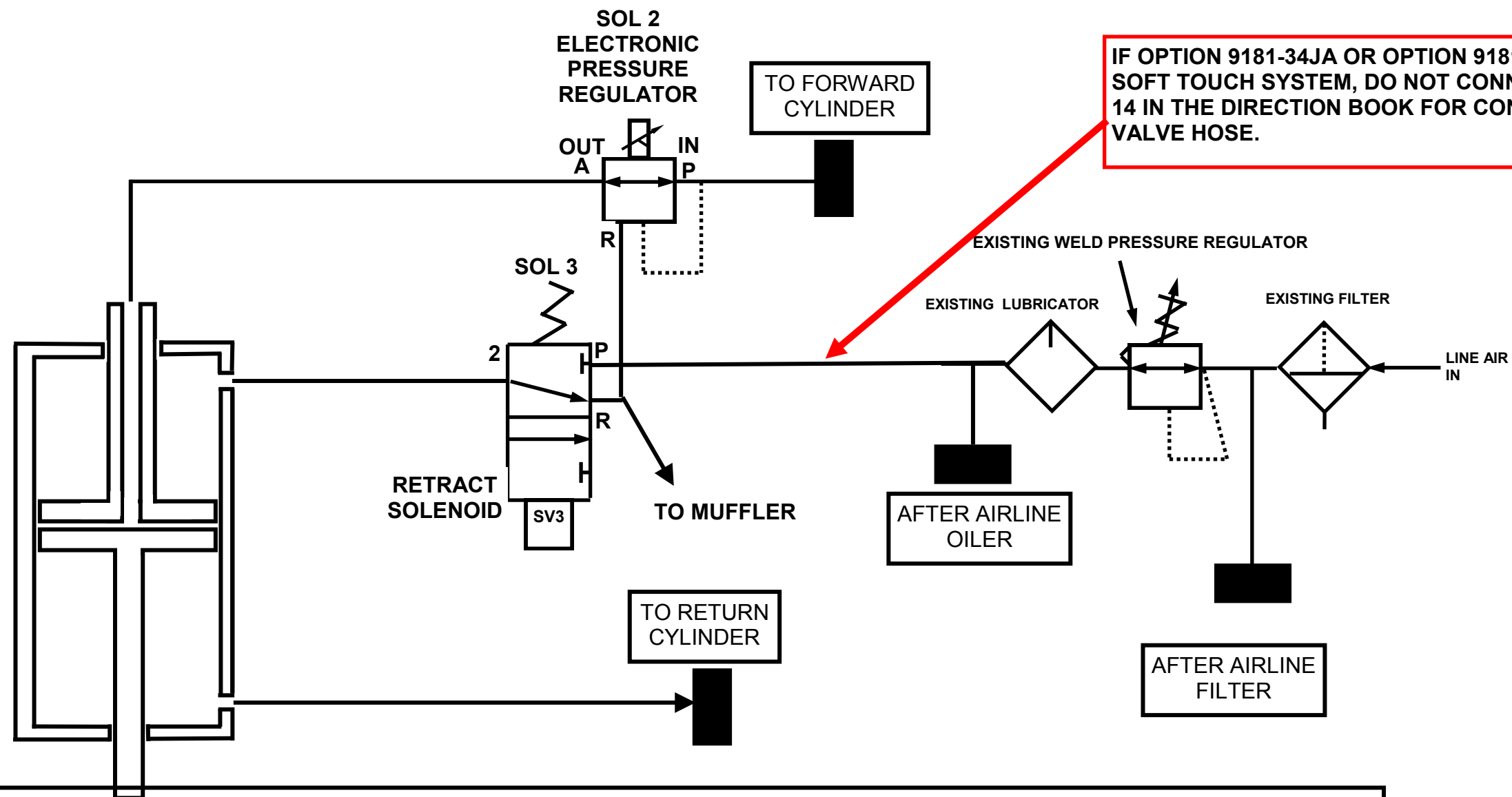


**SOFT TOUCH HOOKUP DIRECTIONS FOR
AMADA ID40IVST AND ID40IVHP-NT
RESISTANCE WELDING MACHINES
WITH 115VAC SOLENOID VALVES**

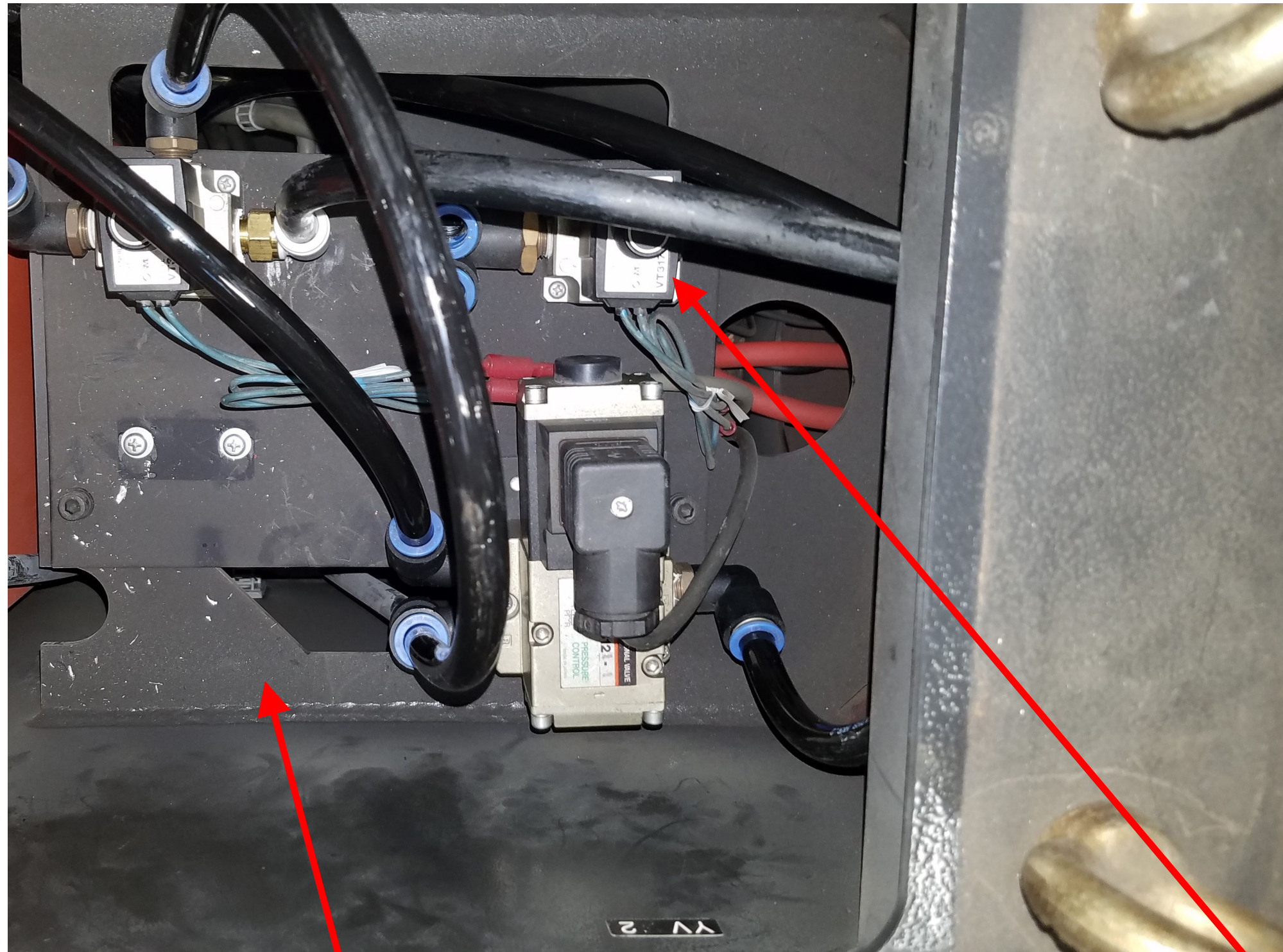




NOTES

- 1.If it is impossible to add a tee between the airline filter and pressure regulator, connect this line to “AFTER AIRLINE OILER”.
2. Remove the existing pressure regulator #9.
- 3.Remove the existing Remove tubing from the existing SOL1 (originally going to RETURN cylinder port)
4. Eliminate flow controls on top (forward) port and lower (return) port.

REV.	DESCRIPTION	BY	DATE
UNITROL ELECTRONICS, INC. 702 Landwehr Road Northbrook, Illinois 60062			
DATE: 12.16.16	SCAL E:	APPROVED BY: R. HIRSCH	DRAWN BY: RBH
AMADA ID40ST, ID40IVST, ID40IVHP-NT			
PNEUMATIC HOOKUP			DWG. NO. 2087A



REMOVE THE PRESSURE REGULATOR AND REMOVE PLUMBING FROM SOLENOID VALVE SOL1 (originally connected to lower port of cylinder). CONNECT TUBING AS SHOWN TO MATCH CIRCUIT ON FIRST PAGE.