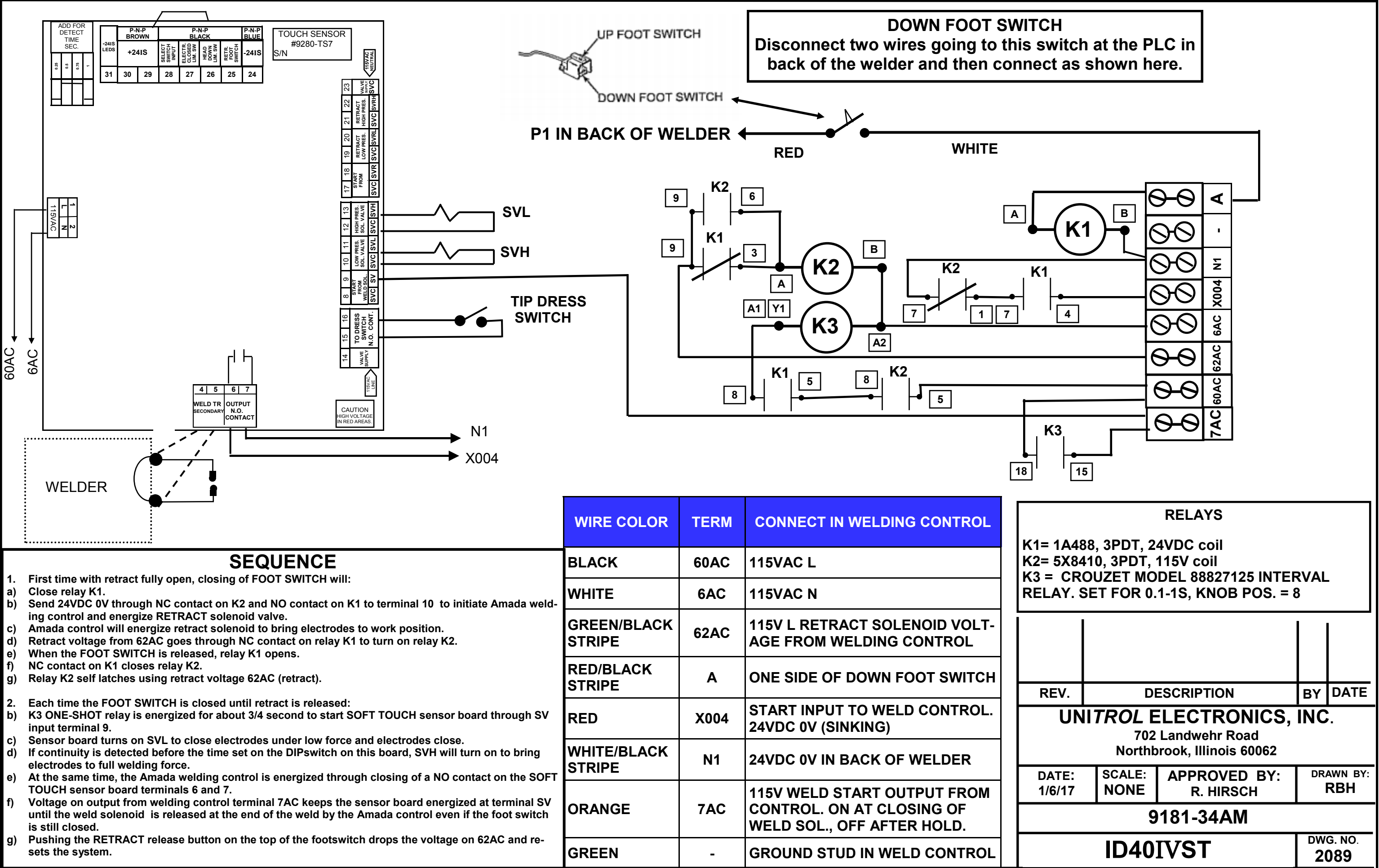


2. Each time the FOOT SWITCH is closed until retract is released:

b) K3 ONE-SHOT relay is energized for about 3/4 second to start SOFT TOUCH sensor board through SV
input terminal 9.

c) Sensor board turns on SVL to close electrodes under low force and electrodes close.

d) If continuity is detected before the time set on the DIPswitch on this board, SVH will turn on to bring
electrodes to full welding force.

e) At the same time, the Amada welding control is energized through closing of a NO contact on the SOFT
TOUCH sensor board terminals 6 and 7.

f) Voltage on output from welding control terminal 7AC keeps the sensor board energized at terminal SV
until the weld solenoid is released at the end of the weld by the Amada control even if the foot switch
is still closed.

g) Pushing the RETRACT release button on the top of the footswitch drops the voltage on 62AC and re-
sets the system.

RELAYS

K1= 1A488, 3PDT, 24VDC coil

K2= 5X8410, 3PDT, 115V coil

K3 = CROUZET MODEL 88827125 INTERVAL
RELAY. SET FOR 0.1-1S, KNOB POS. = 8

REV.

DESCRIPTION

BY

DATE

UNITROL ELECTRONICS, INC.

702 Landwehr Road

Northbrook, Illinois 60062

DATE:
1/6/17

SCALE:
NONE

APPROVED BY:
R. HIRSCH

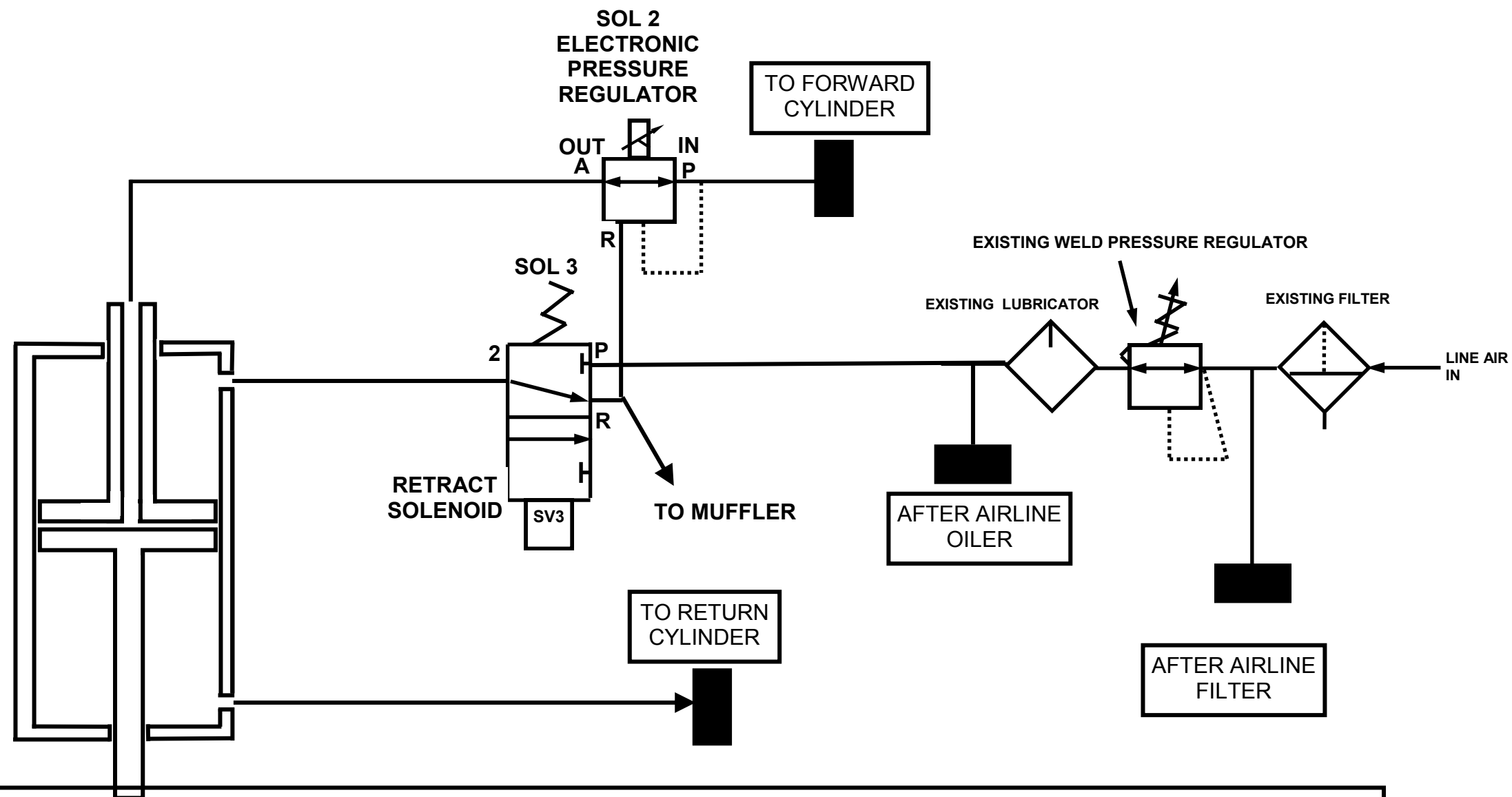
DRAWN BY:
RBH

9181-34AM

ID40IVST

DWG. NO.
2089

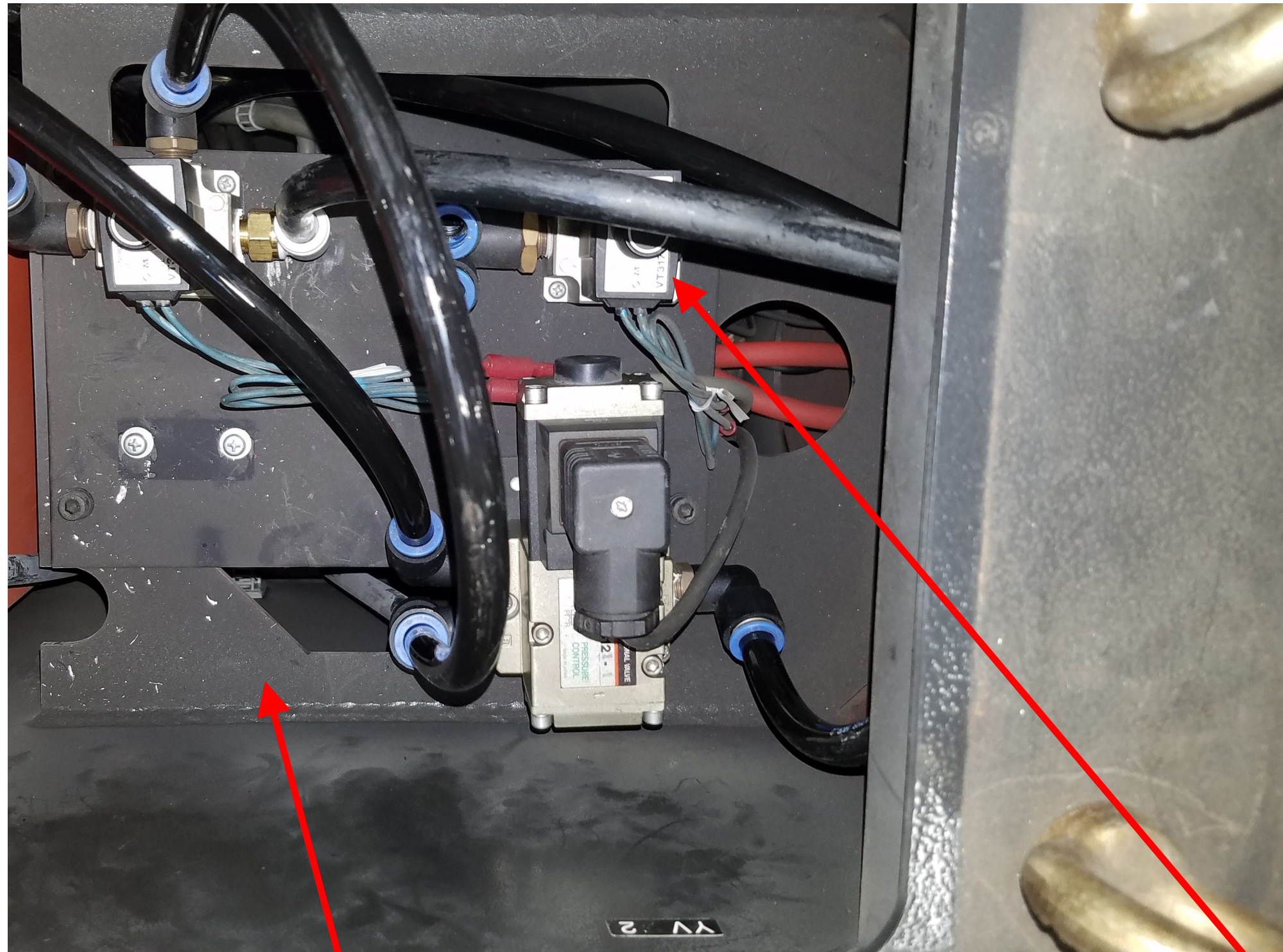
STAND ALONE SOFT TOUCH HOOKUP, 9181-34AM, ID40IVST.pub



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 and ID40IVST			
PNEUMATIC HOOKUP			DWG. NO. 2087



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.