

# ACCUSTART

## TECHNICAL SPECIFICATIONS

- Voltage 115 VAC, 50/60 Hz (230 volts available at no additional charge.)
- Relay contact rating 120 VAC @ .3 amperes, 30 VDC @ 1 ampere
- 1 year warranty

## ACCUSTART COMES COMPLETE WITH:

- 36" cable for connection to welding control
- Keylock switch to prevent setting changes
- (2) 1/4" poly tubing x 1/4" NPT male fittings
- (1) 36" long 1/4" green poly tubing
- (1) 36" long 1/4" red poly tubing
- Instruction/Installation Manual



Proper tip force is very important in the formation of a resistance weld. Accustart easily connects to the pressure switch input terminals on any brand resistance welding control.

Tip force should be reached before the 1st half cycle of the weld current flows. This tip force should not rise above the necessary force during the weld.

The Unitrol Accustart using the latest microcomputer technology contains a differential pressure transducer. As it subtracts back pressure from the welder's air cylinder, the effects of flow control or internal air cylinder leakage will be detected and prevent welding until proper tip force has been reached.

### - Tip force too low:

- Excessive Heat
- High Expulsion (sparks)
- Large poor looking welds
- Drastic reduction in electrode life

### - Tip force too high:

- Inadequate heat
- Brittle welds
- Limited nugget penetration

MODEL	DESCRIPTION	DIMENSIONS
9580	Waits until differential air pressure equals value shown in the set pressure window of the system. At that time, a relay contact is closed to satisfy the pressure switch circuit in the existing weld control .	8" x 3 1/2" x 5"
9581	Waits until differential air pressure equals value shown in the set pressure window of the system. At that time, a relay contact is closed to satisfy the pressure switch circuit in the existing welding control. The unit also compares a differential air pressure to the value shown in the high limit window of the system. If the pressure exceeds this value, a second relay contact closes for 1 second while an alarm sounds. Simultaneously, an indicator light glows and remains on until the next weld starts.	8" x 3 1/2" x 5"
9582	All functions of the 9581 accustart plus a built in electronic air pressure setting system that automatically sets the pressure to match teh value shown in the set pressure window. Unit comes compelte with a remote 1/2" air regulator and air pressure gauge.	11 1/2" x 3 1/2" x 5"