

# Specifying and ordering the Unitrol Solution® Welding Control is as easy as using it.

Just follow these easy steps to select a SOLUTION® that matches your welder:

1. Find the **primary voltage** of your welder in the **red** area of the chart below.
2. Move **downward** from this **primary voltage** and circle the blue box that includes the KVA as shown on the nameplate of your welder.
3. From this point, move to the **right** for the SOLUTION® Model Number in the column that lists the desired **circuit protection** and **cabinet style** (see photos at right). Note that circuit breakers are recommended for most production welding systems.

**EXAMPLE:** The correct single phase SOLUTION® controls with circuit breaker protection for a 50 KVA spot welder working at 460 volts are: #9180-810, 9180L-810, or 9180D-810 (depending on desired cabinet style).

4. Order this model number from your authorized Unitrol representative or distributor who will recommend control options. All components are carried in factory stock for fast delivery. We can usually handle one day emergency control needs for "down" situations.
5. Now get ready for the most unbelievable experience in resistance welding control today!

### SINGLE PHASE CONTROL SIZING CHART

WELDER PRIMARY VOLTAGE					MODEL NUMBERS			CABINET SIZE		
120V	240V	380V	460V	575V	With Circuit Breaker	With High Speed Fuse	Without Protection	A	B	C
					15-30KVA	30-60KVA	60-90KVA	90-120KVA	120-150KVA	9180-990 9180L-990 9180D-990
15-30KVA	30-60KVA	60-90KVA	90-120KVA	120-150KVA	9180-810 9180L-810 9180D-810	9180-810 9180L-810 9180D-810	9180M-810 9180M-810 9180M-810	20 20 20	30 30 30	9 9 9
11-22KVA	22-44KVA	44-66KVA	66-99KVA	99-132KVA	9180-620 9180L-620 9180D-620	9180-620 9180L-620 9180D-620	9180M-620 9180M-620 9180M-620	20 20 20	30 30 30	9 9 9
16-32KVA	32-64KVA	64-96KVA	96-128KVA	128-160KVA	9180-630 9180L-630 9180D-630	9180-630 9180L-630 9180D-630	9180M-630 9180M-630 9180M-630	24 24 24	34 34 34	9 9 9
21-42KVA	42-84KVA	84-126KVA	126-168KVA	168-210KVA	9180-640 9180L-640 9180D-640	9180-640 9180L-640 9180D-640	9180M-640 9180M-640 9180M-640	24 24 24	34 34 34	13 13 13

**COMPLETE 1Ø RETROFIT SYSTEMS WITHOUT POWER CABINETS**  
 For use with existing SCR Contactors ..... 9180-SC0, 9180M-SC0, 9180-S00  
 For use with existing Ignitron tubes ..... 9180-GC0, 9180M-G00, 9180-G00

### THREE PHASE CONTROL SIZING CHART

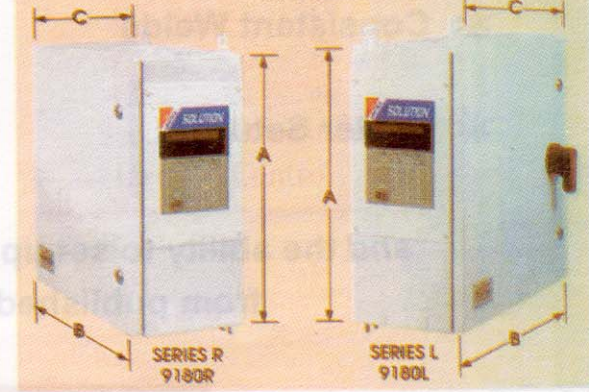
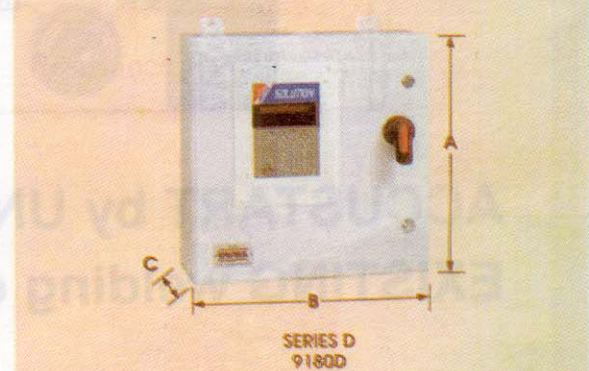
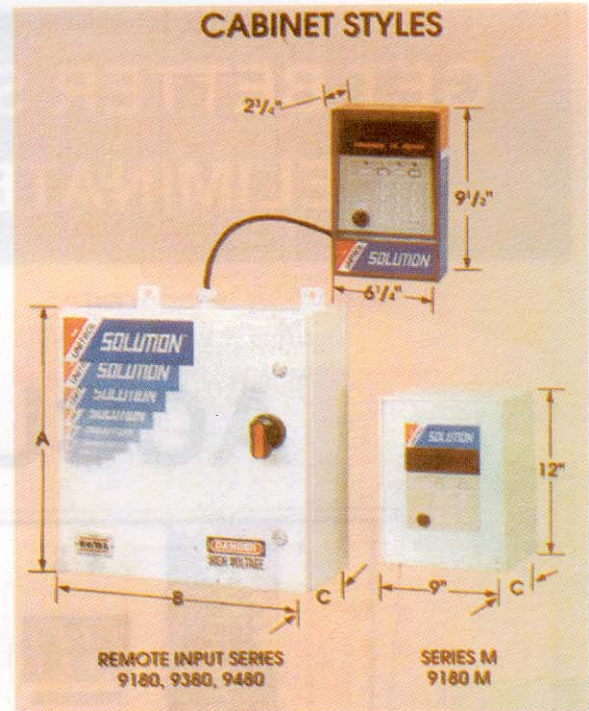
WELDER PRIMARY VOLTAGE				MODEL NUMBERS				CABINET SIZE		
208V	240V	277V	347V	FREQUENCY CONVERTER		D.C. SECONDARY		A	B	C
				With Circuit Breaker	Without Protection	With Circuit Breaker	Without Protection			
15-30KVA	30-60KVA	60-90KVA	90-120KVA	9380-610 9380-620 9380-630 9380-640	9380-600 9380-600 9380-600 9380-600	9480-610 9480-620 9480-630 9480-640	9480-600 9480-600 9480-600 9480-600	36 36 36 36	30 30 30 30	13 13 13 13

**COMPLETE 3Ø RETROFIT SYSTEMS WITHOUT POWER CABINETS**  
 Frequency Converter Control for use with existing SCR Contactors ..... 9380-S00  
 Frequency Converter Control for use with existing Ignitron Tubes ..... 9380-G00  
 30Ø D.C. Secondary Control for use with existing SCR Contactors ..... 9480-S00  
 30Ø D.C. Secondary Control for use with existing Ignitron Tubes ..... 9480-G00

### 5 YEAR WARRANTY

Your investment is protected by the exclusive Unitrol 5 year Limited Warranty. Factory labor and parts (excluding fuses) are fully covered for the first year. This warranty is extended for an additional 4 years on a Pro-Rata basis (exclusive of fuses, SCR, circuit breaker, and transducers).

Parts and Labor are FOB our factory. Warranty card included with each system gives full details of this limited warranty along with all other conditions of coverage.



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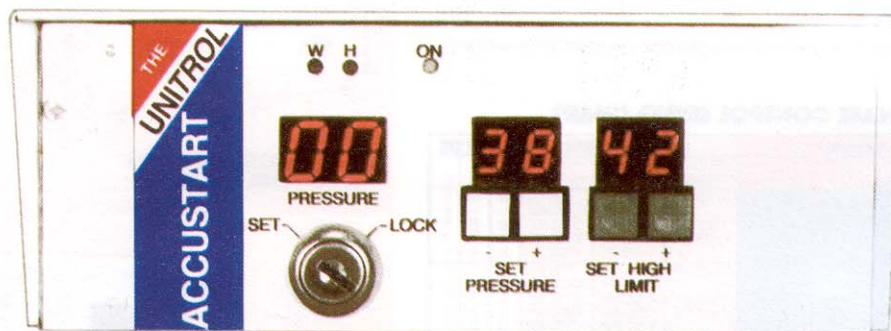
To order or for more information contact:  
**Z. J. INDUSTRIES, INC.**  
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 ADDISON, IL 60101  
 TEL. : (630) 543 - 6655  
 FAX. : (630) 543 - 6644



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**GET BETTER SPOT WELDS AND  
ELIMINATE EXPULSION**

# ACCUSTART



**ACCUSTART by UNITROL connects to your  
EXISTING welding control and gives you:**

- \* Consistent Welds
- \* Elimination of Expulsion (flash)
- \* Faster Setup
- \* Increased Electrode Life

*and the ability to set up weld parameters directly  
from published weld schedules*

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