



UNITROL SOLUTIONⁱ

Resistance Welding Controls

Main: 844-WSI-WELD • International: +1-216-475-5629 • www.WSIWELD.com

UNITROL
SOLUTIONⁱ

IN-STOCK and available from
WELD SYSTEMS INTEGRATORS



THE NEXT GENERATION OF RESISTANCE WELDING CONTROLS IS HERE!



Introducing the
SOLUTIONⁱ
POWERFULLY **INTUITIVE**

If you can push a (YES) and (NO) button, you can use every feature like a pro.

THE UNITROL SOLUTIONⁱ

in-tui-tive (in tū'i tiv) *adj.*

1. Using or based on what one feels to be true even without conscious reasoning; instinctive.
2. Easy to use and understand.

The “**i**” stands for “**i**ntuitive”

POWERFULLY **INTUITIVE**

The **SOLUTIONⁱ** is a full featured highly accurate resistance welding control that is very easy to use. In fact you can set up and use this control without looking at a direction book!

It is that intuitive.

Here's how it works:

- It asks questions and you answer by pushing the YES or NO button.
- It asks you to enter numbers and then tells you what to do next.
- You tell it the type of metal you are welding and the thinnest sheet being joined. It will set up an **RWMA welding schedule** ready to use.
- It has a MASTER SETUP button. When pushed it walks you through all user-settings with clear English instructions. This is very useful when first installing a control.
- It tells you the required air pressure regulator setting for the part you are welding.
- It tells you the recommended welder transformer tap switch position for each part.*
- It waits until the proper ELECTRODE FORCE has been reached before starting each weld and eliminates the need for SQUEEZE TIME.*
- It checks ELECTRODE FORCE again at the end of the weld to be sure that you have not made a brittle weld by having ELECTRODE FORCE that is too high.*
- It keeps the electrodes closed when any weld fault is detected and tells you how to reset it.
- It tells you when to dress electrodes.

And it does all of the above in clear English, without any codes.

The **SOLUTIONⁱ** includes an SD card so you can:

- Copy welding programs for backup
- Enter welding programs from a PC
- Enter welding programs from another **SOLUTIONⁱ**
- Install updates



* **SOLUTIONⁱQC** control models only.

The **SOLUTION*i*** can select an **RWMA welding schedule**. You just enter the type of metal and gauge. The **SOLUTION*i*** does the rest.

For example, to weld 18 Gauge Galvanized Steel, follow the prompts:

```
CHOOSE MATERIAL:
LOW CARBON STEEL = 1
Want to change? PUSH
the YES or NO button
```

YES

```
CHOOSE MATERIAL:
LOW CARBON STEEL = 1
STAINLESS STEEL = 2
GALVANIZED STEEL = 3
ALUMINUM ALLOYS = 4
HSLA = 5
```

3

```
Thinnest Metal = 22GA
Want to change? PUSH
the YES or NO button
```

YES

```
Thinnest Metal = 22GA
After entering data
press YES
```

1

8

YES

```
GALVANIZED STEEL 18G
WELDING SCHEDULE = 827
Proceed? Push
The YES or NO button
```

YES

SINGLE

```
PROGRAM 827 IS READY
Set TRANSF. TAP to 3
Set PRES. REG. 56psi
```

The **SOLUTION*i*** asks questions in **full English** and prompts the user as to how to enter information.

```
CHOOSE MATERIAL:
LOW CARBON STEEL = 1
Want to change? PUSH
the YES or NO button
```

Tell the control what type of metal you are welding plus the gauge, and it loads an RWMA schedule.

It tells you how to set the transformer tap switch and air pressure regulator.

```
PROGRAM 437 IS READY
Set TRANSF. TAP to 2
Set PRES. REG. 56psi
```

```
TIP FORCE = 0653LB
To open ELECTRODES
push the YES button
```

It reads the electrode force and makes sure it is not too low or too high.

A PARTS COUNTER keeps track of finished weldments.

```
PROGRAM 27 IN USE
00,170 LEFT IN BATCH
01,340 PARTS MADE
```

```
BATCH is completed.
Press the YES button
to start a new batch
```

The BATCH COUNTER tells you when a job is finished and stops the welder

The HEAT STEPPER lets you know when it is time to dress electrodes.

```
HEAT STEPPER EXPIRED
Dress ELECTRODES
Then press YES
to Reset Stepper
```

```
WELDS per PART = 016
After entering data
Press YES
```

After entering the number of welds made on each part you can count finished weldments.

It walks you through the simple steps to setting up CONSTANT CURRENT.

```
SET TRANSF. TAP TO 1
Place Metal Between
Electrodes and
close FOOT SWITCH
```

```
Can't Start
Without Selecting
SINGLE, NOWELD, REPEAT
00,012 Parts Made
```

It reminds you to push a WELD, NO WELD, or REPEAT button.

Self tunes AVC line voltage compensation with a few keystrokes.

```
LINE VOLTAGE CALIB.
Line Voltage is
Enter and Press YES
```

PROGRAM 827 is factory loaded as a good starting welding program for this gauge and material. After welds are tried, the program can be adjusted as needed. The control will even recommend changing the **TRANSFORMER TAP** switch position if needed. The changed program will now be the default for this gauge and material.

SOLUTIONⁱ Specification Chart

FUNCTION	DESCRIPTION	RANGE
Weld Programs	Each program is a complete RWMA Schedule including Forge Delay, Pulsation, and Special Sequences for welding galvanized steel and other coated metals.	700 Customer Set 100 RWMA Preset
Display	Bright blue vacuum fluorescent, full alpha/numeric.	80 Characters
Welds Counter	Keeps track of welds made.	1-65,500
Parts Counter	Keeps track of finished parts made.	1-65,500
Batch Counter	Stops welder when batch is completed.	1-999
Master Setup Program	Quick setup of system programs using Wizard Tutorial .	-
AVC	Automatic line voltage compensation. Maintains welder output with variations of incoming line voltage.	1% Max. Variation with +/-10% Line Voltage Change
Keyboard Lock	Prevents unauthorized changes in welding schedules or setup values.	3 Security Levels
Heat Stepper	Computerized curve for welding galvanized steel. Just enter total welds and last heat % increase.	999 Welds
Tip Force Calculator	Displays required pressure regulator setting needed to produce requested electrode force.	0-99 psi
Line Service	Single selector wire to match line voltage. Keypad entry for line frequency.	115V - 575V 50/60Hz
Dual Program	Assigns any weld schedule to one of two initiation inputs.	-
Initiation Modes	Single level, dual level, anti-tiedown; holding or momentary.	-
Low Water Flow	Input from external water flow switch.	-
Light Curtain	Input for light curtain, factory programmed.	-
Soft Touch Function	Exclusive UNITROL operator pinch point protection safety system. Requires Soft Touch hardware kit.	-
SD Slot	Copy programs, install programs, modify operating system.	-
Anti-tiedown Initiation	Requires closing of two hand switches within 1 second to start weld.	-
Pressure Transducer*	Starts weld when selected electrode force has been reached. Locks electrodes on part at end of weld if force exceeds customer-set limit to prevent cold welds.	0-99 psi
Current Monitor*	Compares RMS current to program high/low range. Locks electrodes closed if out of range.	10KA - 200KA
Constant Current*	Accurately provides program-selected secondary current. Current values are directly entered in amps.	0-200KA +/-1% Range F.S.
Communication Port*	Export of weld results; upload / download schedules.	RS-232 or RS-485
Electronic Pressure Regulator**	Automatically sets pressure regulator to provide program-selected electrode force.	0-99 psi

* included with SOLUTIONⁱQC controls

** optional feature

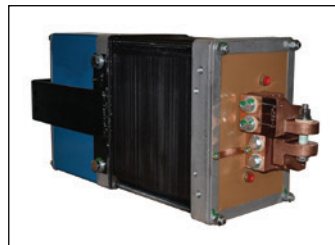
Diverse inventory with immediate shipping and unmatched customer service

Weld Systems Integrators (WSI) specializes in high-quality spot and projection resistance welders with single-phase AC and DC, and three-phase DC and MFDC power supplies. Our standard and custom welders include:

- Rocker Arm Spot Welders
- Capacitor Discharge Welder
- Seam Welders
- XY Welders
- Manual, Partial, or Fully-Automated Multi-Gun Weld Automation
- Press Type Welders
- Bench Welders
- Door Welders
- Turntable Welders

We work with trusted partners to stock a diverse inventory of consumables, spare parts and accessories. This includes electrodes, portable spot welding guns, controls, chillers, transformers and more. And we support our equipment with excellent customer service, training, welding lab testing and contract engineering.

TECNADirect.com, a division of WSI, is a stocking master distributor of TECNA welders, tool balancers and accessories. Along with BALANCERSDirect.com, our dedicated to balancers website, we maintain an IN-STOCK inventory at our Warrensville Heights, OHIO location.



Contact your WSI Representative TODAY!



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