



# Tool Operating Manual

i04619069

## 1U-9600 Welding Group (U.S. and Canada) 1U-9601 Welding Group (All other countries)

SMCS Code: 0599; 0679

Caterpillar Products  
All

## Table of Contents

Introduction .....	1
Literature Information .....	2
Safety Section.....	2
General Information Section .....	2
Operation Section.....	2
Maintenance Section .....	3
Service Parts Section.....	3
Safety Icon Nomenclature .....	3
Personal Protection/Important Information.....	3
Prohibited Action.....	3
Hazard Avoidance.....	3
Safety Section .....	3
General Information .....	4
Introduction.....	4
Additional Contact Information.....	5
Setup Procedure.....	5
Selecting Power Setting of Base Unit .....	5
Position the Base Unit.....	6
Weld Head Assembly.....	6
Weld Torch Assembly .....	7
Assemble the Torch.....	8
Splicing Teflon Liners .....	10
Welding Procedure .....	10
Prepare Welding Surface .....	10
Position Weld Torch.....	10
Final Preparation and Welding.....	10
Weld Completion.....	11
Disassembly .....	12
Other Features .....	12
Maintenance and Repair.....	12
Check for Wear .....	12
Fuses .....	13
1U-9633Transformer .....	13

1U-9602Magnets.....	13
Top Casting.....	14
Speed Control Assembly.....	14
Drive Motor.....	14
Head and Clutch Assembly .....	15
Disassembly and Assembly .....	15
1U-9603Head and Clutch Unit .....	16
Disassembly .....	16
Assembly and Adjustment.....	18
1U-9634Drive Motor .....	19
1U-9632Gear and Clutch Assembly .....	19
Disassembly .....	19
Check for Proper Operation.....	19
Final Adjustment .....	20
1U-9628Brush Housing .....	21
Disassembly .....	21
Brush Assembly and Spring Adjustment.....	21
9U-5134Brush Housing .....	22
Disassembly .....	22
Brush Assembly and Spring Adjustment.....	23
1U-9616Speed Control Assembly .....	23
Metric Tap and Die Sets .....	23
Parts Listing .....	24
Base Assembly .....	24
1U-9633Transformer Assembly .....	25
1U-9610Coil Cord .....	26
Transmission Housing Assembly .....	26
1U-9616Speed Control Assembly .....	28
Torch Assembly .....	30
Miscellaneous Parts.....	31
Warranty .....	31
Troubleshooting.....	32
Weld Parameters .....	33
Potentiometer Settings .....	33
Instructions for Use of Charts.....	33
Weld Torch Settings .....	36

## Introduction

### Important Safety Information