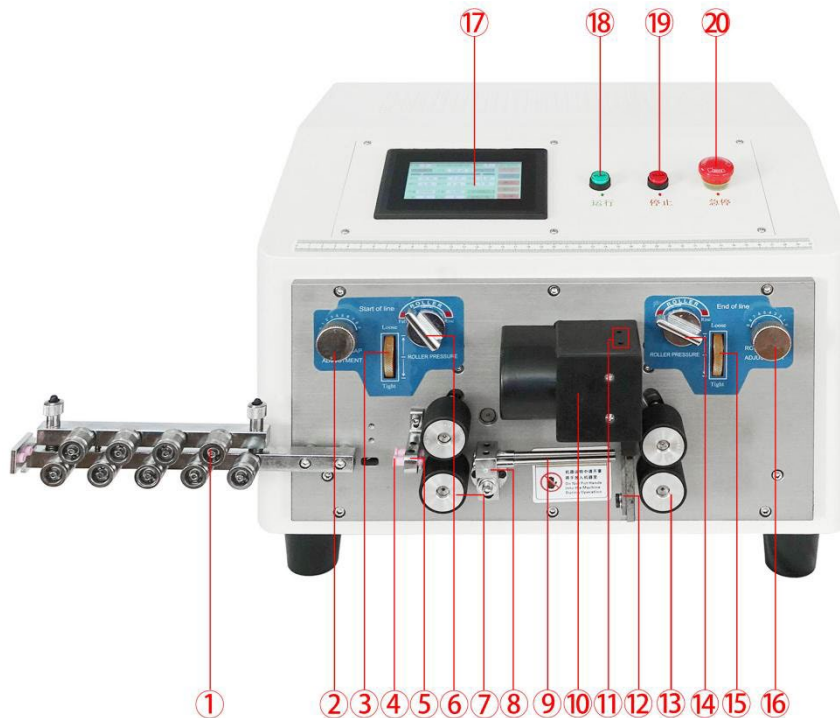


OPERATION MANUAL

Full-automatic Computer Wire Stripping Machine



Part One: Overview



1. Straightening frame: wire straightening effect.
2. Pressure adjusting knob of the cable-in wheel: adjust the pressure between the two wheels of the cable-in wheel, pull out the knob to rotate clockwise to increase the pressure, and rotate it counterclockwise to decrease the pressure, adjust to the appropriate pressure and push it in to fix it.
3. Gap adjustment knob of the wire feed wheel: The gap between the feed wire wheel is increased when it is turned up, and the gap is reduced when it is turned down. The gap between the two wheels is pressed against the wire harness, and it is best to not let the wire harness slip.
4. Cable entry hole: The wire rod penetrates into the cable entry hole and enters the cable entry wheel.

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5. Inlet hole seat: fixed catheter, move up and down to adjust the center position of the catheter and blade.
 6. Feeder wheel lift function: rotate the feeder wheel counterclockwise, and rotate the feeder wheel clockwise.
 7. Wire feed wheel: The motor drives the wire feed wheel to rotate so that the wire material moves forward and backward, and cooperates with the function of the wire feed and stripping head of the knife holder.
 8. Pipe seat: fixed catheter function, can be adjusted up and down so that the front and rear rollers and catheter become a center line.
 9. Pipe: The wire penetrates into the catheter and enters the knife edge to fix the wire, at the center of the upper and lower knife edges.
 10. Knife holder assembly cover: protect debris from entering the knife holder assembly.
 11. Tool holder oil hole: add a small amount of lubricating oil every day to ensure that the tool holder is lubricated
 12. Blade: It is divided into upper and lower pieces, the upper part of the short device and the lower part of the long device. The two pieces are one piece. The upper and lower blades are vertical when the device is installed.
 13. Outgoing wheel: The motor drives the outgoing wheel to rotate to make the wire harness move forward and backward, and cooperates with

the function of exiting and stripping the knife holder.

14. The outlet wheel lifting function: rotate the outlet wheel clockwise, and rotate the outlet wheel counterclockwise.

15. Outlet wheel clearance adjustment knob: The clearance of the outlet wheel increases when it is rotated upward, and decreases when it is rotated downward.

16. Outlet wheel pressure adjustment knob: adjust the pressure between the two wheels of the outlet wheel, pull out the knob to rotate counterclockwise to increase the pressure, turn clockwise to decrease the pressure, adjust the appropriate pressure and push it inward to fix it.

17. Display: adjust the parameters of the wire to be processed.

18. Start: When the data input is completed without error, press [Start] to make the machine work.

19. Stop: Press [Stop] to stop the machine.

20. Emergency stop: When the machine is in working state, press [Emergency Stop], the machine will stop working urgently.

▼ Note that before the power is turned off, no matter the machine is working or stopped, the blade cannot be approached by hand.

Part 2: Operation of the computer

Picture 1

PRO. CUTTING & STRIPPING MACHINE UPH:

LENGTH mm

- 1.1. Program: store parameters from 0-99 program serial numbers.
- 1.2 UPH: to wait.
- 1.3. FORWARD: Thread the thread into the cable entry hole until the cable entry roller. Press the [Thread entry] roller to automatically feed the thread forward.
- 1.4 REVERSE: Press [Return] wheel to automatically retreat the line backward.
- 1.5. SINGLE STEP / SINGLE CYCLE / Full automatic: Press the start button to run a single action in the case of inching, press the start button to run a complete action in the test machine, and press the start button to continue the operation in the fully automatic case.
- 1.6. Start: When the data input is completed without error, press [Start] to make the machine work.

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- 1.7. Stop: Press [Stop] to stop the machine.
- 1.8. Reset: Make each part of the machine return to the origin.
- 1.9 Emergency stop: When the machine is in working state, press [Emergency Stop], the machine will stop working urgently.
- 1.10. Length: The total length of the cutting wire, the unit is mm.
- 1.11. Strip Len: The required length of the wire end.
- 1.12. Strip Off: The length of the stripping of the wire at the tip of the wire. If the stripping parameter is less than the threading parameter, it is called half stripping. If the stripping parameter is greater than the threading parameter, it is called full stripping.
- 1.13. Strip Len: the required length of the end of the wire.
- 1.14. Strip Off: The length of the stripping of the rubber at the end of the wire. If the tail stripping parameter is less than the wire tail parameter, it is called half stripping.
- 1.15. Cutter dia: refers to the cutting section of the number of steps transmitted by the knife holder drive motor, and controls the cutting depth of the wire end and the tail. Then, the smaller the upper and lower knife openings, the deeper the cutting depth. The opening distance of the upper and lower knife edges is calculated in millimeters. The diameter of the core wire of the wire is mm, and the diameter of the wire is entered as much as mm.

1.16. Cutter Back: Refers to the blade cutting into a certain depth and retreating to a certain size to avoid the core wire being scratched. The size of the retreat is determined according to the thickness of the wire rubber. The thicker the rubber is, the larger the retreat is. ~ 5.0mm.

1.17. Set Count: refers to the total output of set work. The input data cannot be less than the quantitative input data. If the data is less than the quantitative data, the machine will not work.

1.18. Finished: cumulative production quantity.

1.19. Set Batch: how many parameters the machine operates and how many times the machine automatically stops. If you enter 100 machines to 100 times, it will automatically stop. Enter 0 for no quantitative data, the machine will not automatically stop, and the data will reach the set total amount. Downtime.

1.20. Batch Delay: When the machine reaches the specified amount, how many seconds will it delay, and it will start automatically and continue to run.

Manual setting

The interface consists of a light green rectangular area containing several controls:

- CUTTER**: A white input box followed by **FORWARD**, **REVERSE**, and **DATUM** buttons, and a small green indicator light.
- CUTTER CLOSE**: A white input box followed by **TEST**, **JOG**, and **OFF** buttons.
- AIR BLOW**: A button labeled **OFF**.
- WHEEL LIFT**: A button labeled **OFF**.
- SLITTING**: A button labeled **OFF**.
- PIPE**: A button labeled **OFF**.
- OUT CLAMP**: A button labeled **OFF**.
- OUT SLID ARM**: A button labeled **OFF**.
- RETURN**: A large green button at the bottom center.

2.1. Cutter: Press the forward button to close the upper and lower blades. As the number in the square increases, press the back button to open the upper and lower blades.

As the number in the grid decreases, when the spacing between the upper and lower blades is 0 points, confirm that the number in the grid is the reference data, and return to zero to detect the return to the origin.

2.2. Cutter Close: Confirm the reference point of the upper and lower cutters, and enter this parameter into the grid.

2.3. Air Blow: Blow off the thread on the blade.

2.4. Pipe: The catheter swings up and down to prevent the tail of the wire from hitting the catheter.

Parameter settings:

PIPE OFF	ROLLER SPEED	<input type="text"/>	%	
WHEEL OFF	CUTTER SPEED	<input type="text"/>	%	
WIRE LACK OFF	STRIP SPEED	<input type="text"/>	%	MID STRIP
CUT RUBBER OFF	CUT DOWN SPD	<input type="text"/>	%	IO MONITOR
SLID ARM OFF	AIR BLOW TIME	<input type="text"/>	S	PROGRAM
LENGTH MODIFY	STRIP POS	<input type="text"/>	mm	
	FAST MODE	OFF		RETURN

Picture 3

3.1 Roller speed: refers to the motor feed roller speed of 00-99, 00 is the slowest and 99 is the fastest.

3.2. Cutter speed: refers to the cutting speed of the knife holder driven by the motor, the speed is 00-99, 00 is the slowest and 99 is the fastest.

3.3 Strip speed: refers to the speed at which the rubber peels off. The slower the speed, the greater the peeling force, and the faster the speed, the smaller the peeling force.

3.3. Cut Down SPD: Refers to the speed at which the upper and lower blades touch the wire until cutting, the speed is 00-99, 00 is the fastest, and 99 is the slowest.

3.4 Air Blow time: Each blowing time is adjustable.

3.5. Pipe: The pipe swings up and down to avoid the tail of the wire colliding with the catheter.

3.6. Wheel: not

3.7. Wire Lack: automatic shutdown when the wire is missing.

3.8. Cut Rubber: if the wire skin falls on the blade, turn on the function to cut the wire skin to avoid overlapping the second action to cut the wire.

Length correction

SET LENGTH mm

ACTUAL LENGTH mm

MODIFY LENGTH

RETURN

Picture 4

4.1. Set length: Enter the total length parameter set in [Picture 1].

4.2. Actual length: Enter the actual total length data for processing.

4.3. Modify length: Press the modified total length to automatically modify the total length parameter.

MIDDLE STRIP

POS01	<input type="text"/>	WINDOW	<input type="text"/>	MIDCUT OFF
POS02	<input type="text"/>	WINDOW	<input type="text"/>	DIA MODIFY
POS03	<input type="text"/>	WINDOW	<input type="text"/>	<input type="text"/>
POS04	<input type="text"/>	WINDOW	<input type="text"/>	LENGTH MODIFY
POS05	<input type="text"/>	WINDOW	<input type="text"/>	<input type="text"/>
POS06	<input type="text"/>	WINDOW	<input type="text"/>	
POS07	<input type="text"/>	WINDOW	<input type="text"/>	NEXT
POS08	<input type="text"/>	WINDOW	<input type="text"/>	RETURN

MIDCUT: on / off

5.1. DIA MODIFY: when the middle stripping wire and the copper wire are too tight to be stripped, the cutting depth of the middle stripping can be slightly increased.

For example, 0.1 means 0.1+ 【Picture 1】 wire diameter.

5.2. LENGTH MODIFY: the last end is provided with a liner on the top, and the total length can be finely adjusted to remove the liner.

5.3. POS 01: The length of the cut wire from the wire to the first place in the middle; Stripping: The peeling distance from the first place in the middle.

5.4, POS 02: The length of the skin cut from the top of the wire to the second place in the middle; Stripping: The stripping distance from the second place in the middle.

Printing settings (optional):

PRINTING	<input type="button" value="OFF"/>	PRINT POS.HEAD	<input type="text"/>
PRINT DIST.	<input type="text"/>	PRINT POS.END	<input type="text"/>
PRINT START DELAY	<input type="text"/>	PRINT LOOP NUM.	<input type="text"/>
PRINT HOLD TIME	<input type="text"/>	PRINT LOOP DIST.	<input type="text"/>
PRINT CHAR LENGTH	<input type="text"/>		
<input type="button" value="RETURN"/>			

1. Coding switch: turn on/off the coding function.
2. Nozzle distance: distance from nozzle to cutter.
3. Inkjet code signal start: The wire stripping machine gives the inkjet printer a start delay command, and the reference value is 0 S.
4. Coding signal delay: When the inkjet printer receives the [Start Coding] command, the delay is turned off. The reference value is 0.05S.
5. Printing character length: the total length of printing characters.
6. Head-end printing position: from the thread end to the starting position of printing.
7. End coding position: from the end of the line to the end of coding.
8. Number of printing cycles: the length between head printing and tail printing. Set the number of printings and the system will automatically divide the distance equally.

9. Circular printing distance: the length between head-end printing and tail-end printing, set the number of printings, and the system automatically calculates the printing distance of each character (this parameter is automatically calculated and cannot be modified).