

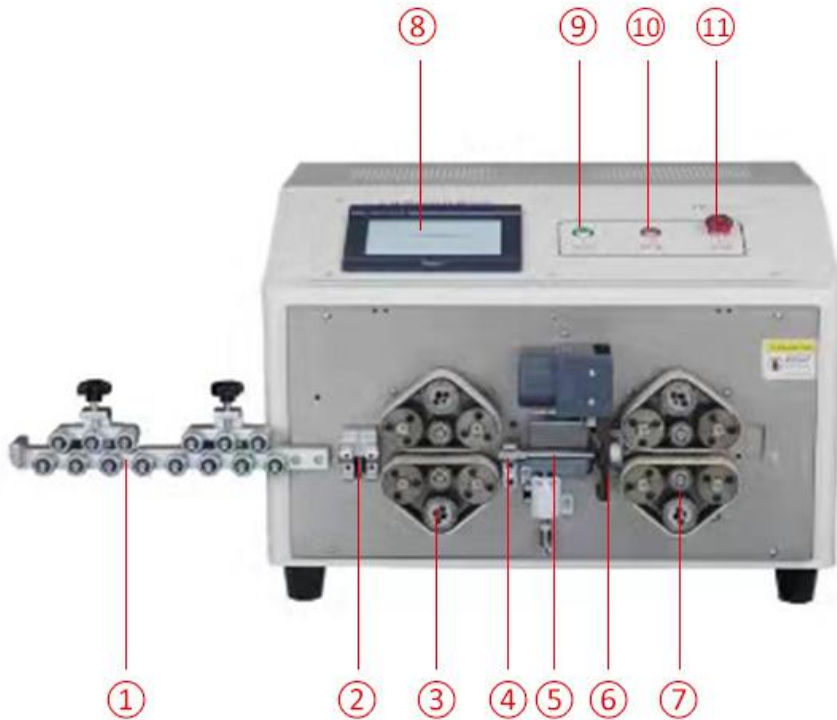
Wire stripping machine EW-3055

User manual



Function	Wire cutting, double-end stripping, inner core stripping
Wire range	OD 3-10mm
Strip cores	2/3/4/5/6/7/8
Cutting length	0.1mm-99999.9mm
Stripping length	Outer line: head:0.1-250mm tail: 0.1-70mm Core line: head:0.1-15mm tail: 0.1-15mm
Stripping accuracy	Silent hybrid stepper motor 0.01mm
Intermediate strip	Can be customized
Capacity	1100 pcs/ h (L=500mm)
Blade material	Imported tungsten steel/high-speed steel
Air supply	0.5-0.8Mpa
Power	AC110V/220V 50/60HZ
Dimension	650mm*580mm*460mm
Weight	70kg
Remark function	Automatic entry / exit, timing start, jog adjustment

Part One: Overview of Mechanical Outline



1. Straightening frame: Wire straightening effect.

2. Wire Lack Monitor: Automatic alarm when the line is missing.

3. Inlet wheel: Wire feed wheel to rotate to make the wire go forward and backward, and cooperates with the wire feeding and stripping of the knife holder.

4. Pipe: The wire penetrates into the catheter and enters the knife edge, and the wire is fixed at the center of the upper and lower knife edges.

5. Knife holder assembly cover: Protect debris from entering the knife holder assembly.

6. Blade: It is divided into upper and lower pieces, the upper part is short and the lower part is long. The upper and lower blades are vertical when the device is installed.

7. Outlet wheel: The motor drives the wire exit wheel to rotate the wire harness forward and backward, and cooperates with the function of the wire exit and tail stripping of the knife holder.

8. Display: Adjust the parameters of the wire to be processed.

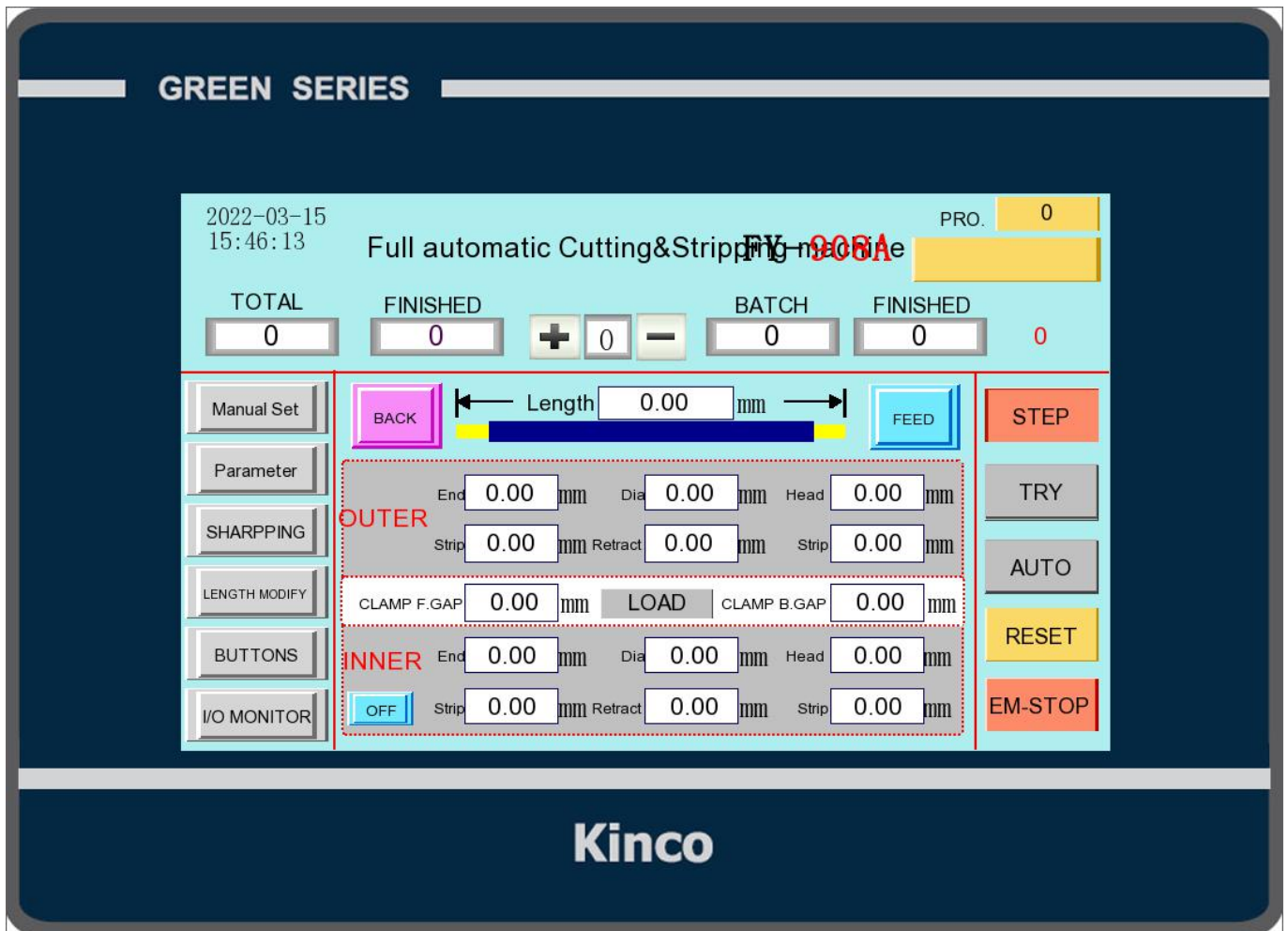
9. Start: Make the machine work when the data input is completed without error.

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

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

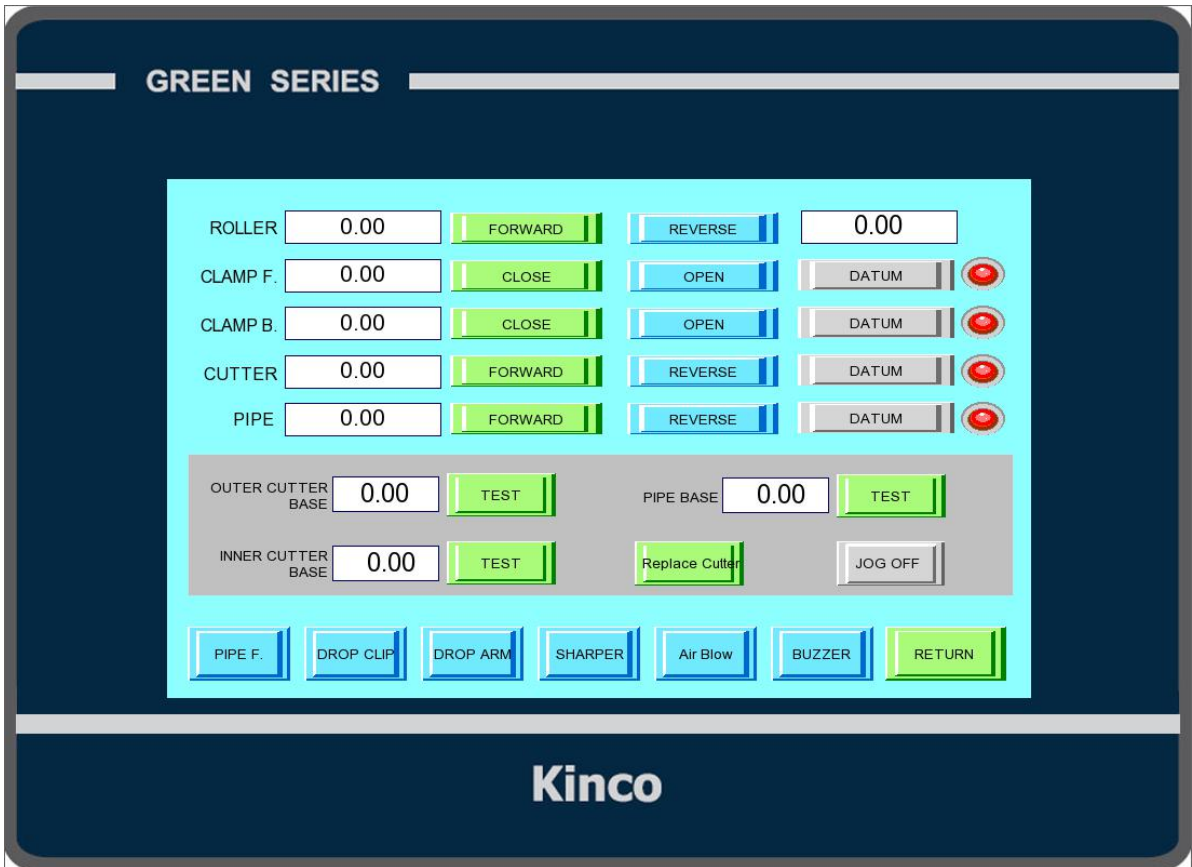
▼ Note that before the power is turned off, no matter the machine is working or stopped, the blade cannot be approached by hand.

I. Parameter Setting

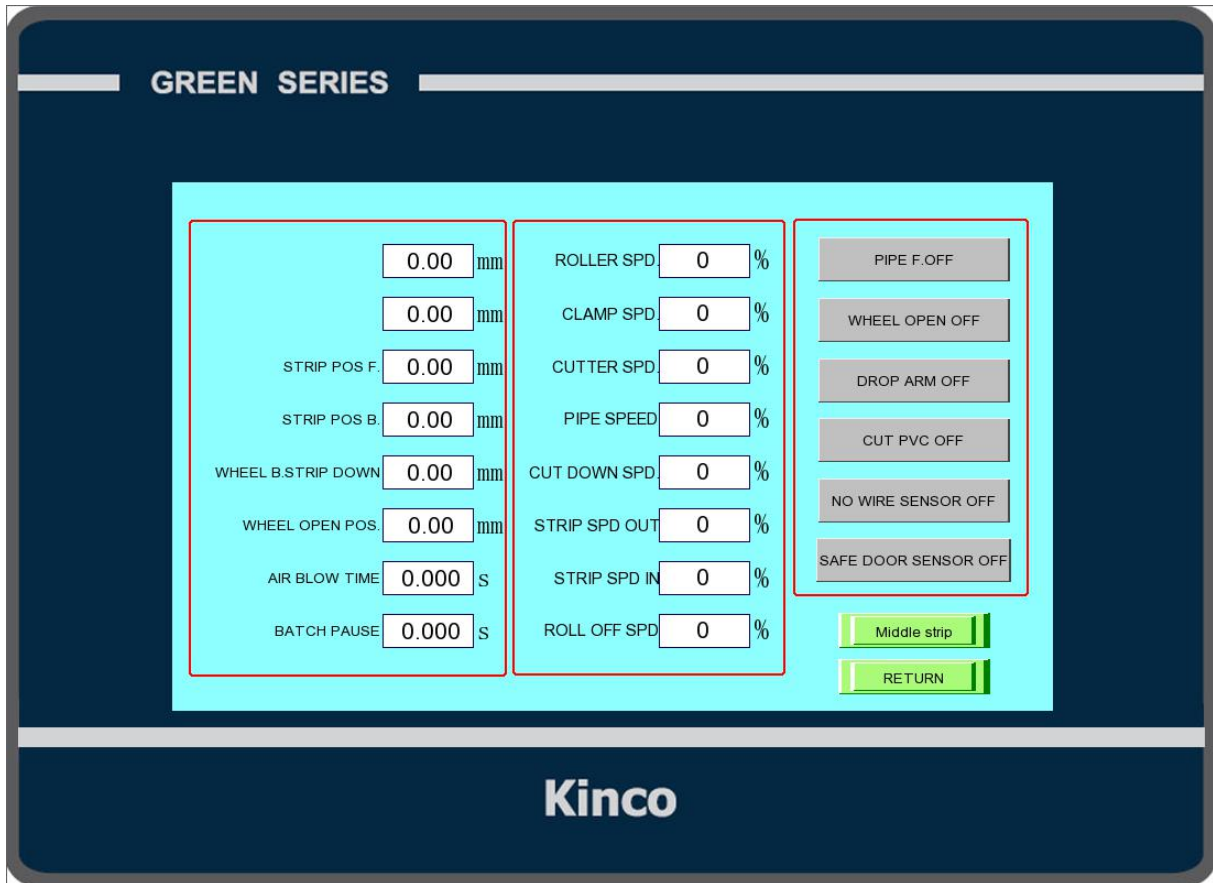


- a) Total: total output
- b) Finished: Cumulative production quantity.
- c) +: Press once to increase the count by 1.
- d) -: Press once to decrease the count by 1.
- e) Batch: set the single batch production.
- f) Finished: Quantifies the count in each batch.
- g) Length: The total cutting length.

- h) Outer and Inner Head/end: stripping length of the wire head and end side.
- i) Strip: Half strip length of head and end side.
- j) Outer and Inner Dia.: The outer jacket and inner jacket diameter.
- k) **Retract**: the retract distance after blades cut into wire, and this is to avoid hurting the inner coppers. The value is usually equal to the jacket(insulation) thickness.
- l) Manual/Try/Auto: In the case of single step, press the start button to run a single action; in the case of trial, press the start button to run a complete action; in the case of automatic, press the start button to run continuously.
- m) Start: Press the [start] key to make the machine work when the data is entered correctly.
- n) Stop: Press stop to stop the machine.
- o) Reset: Make each part of the machine return to the origin.
- p) EM-stop: When the machine is in working condition, press [E-stop] the machine will stop working urgently.
- aa) Feed: press and hold to feed the wire.
- ab) Back: press and hold to feed the wire.
- ac) Program: 0-99 can save programs.



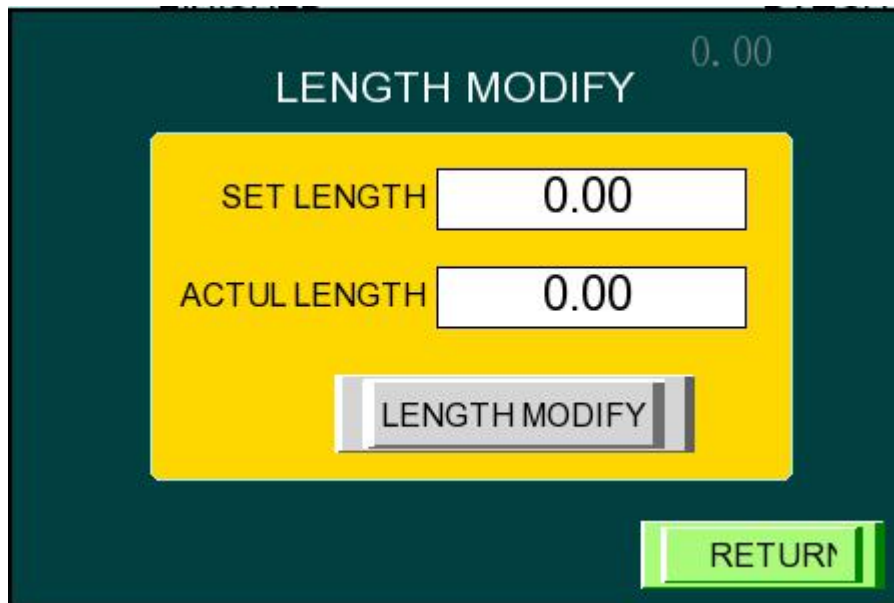
- a) Manually drive the motor forward/backward position, return to zero reset the origin position.
- b) PIPE BASE: Identify the pipe reference point and enter this parameter in the box.
- c) TEST: Single action test whether the tool value is normal.



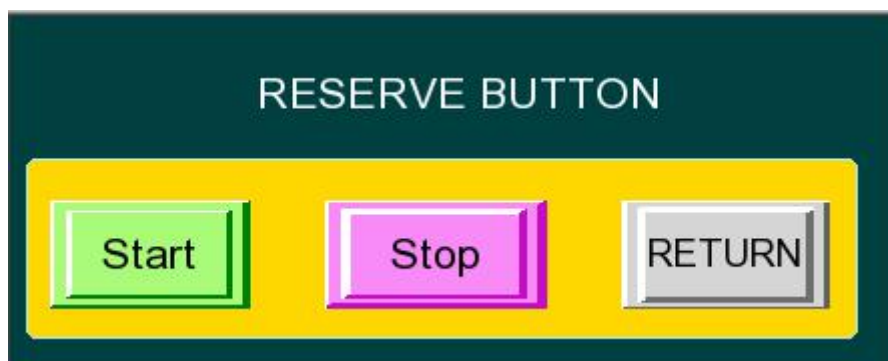
- STRIP POS F.: When the front end is stripping, the upper and lower rollers are pressurized to increase the stripping strength.
- STRIP POS B: When the back end is stripping, the upper and lower roller is pressurized to increase the stripping strength.
- WHEEL STRIP DOWN: The height at which the front wheel is raised when the wire is removed, the height added to the clearance between the front wheels.



- a) SHARP POS: From thread head to line position.
- b) SHARP LENGTH: Length of the front and rear ends from the beginning to the end of the line.
- c) SHARP DIA: Open the upper and lower knife edges when wiring.
- d) CUTTER SPD: Speed at which the cutter cuts into the core wire after wiring.
- e) ROLLER SPD: The speed of feeding roller.



- a) Setting length: Enter the length parameter set.
- b) Actual total length: input the actual total length data of machining.
- c) Length Modify: press to modify the length.



The reserve button to start the machine and stop the machine.

Part 3: Solutions to failures

Failures	Solutions
The thread can't be peeled off	<ol style="list-style-type: none"> 1. Check the cutting depth of the thread, if it is too shallow, you need to reduce the wire diameter. 2. The upper and lower gaps of the wire feed roller are too large, and the adjustment becomes small. 3. The head stripping data is too small and needs to be increased.
The end of the line cannot be stripped	<ol style="list-style-type: none"> 1. Check the cutting depth of the wire tail, if it is too shallow, the wire diameter needs to be reduced. 2. The upper and lower gaps of the outlet roller are too large, and the adjustment becomes small. 3. The tail stripping data is too small and needs to be increased.
The surface of the wire is too embossed	<ol style="list-style-type: none"> 1. First determine whether the embossing is caused by the in-line wheel or the out-line wheel. 2. If it is a wire entry wheel, increase the adjustment clearance of the wire entry wheel. 3. If it is the outlet wheel, increase the outlet wheel adjustment gap.
Line head and tail stripped with a slope	<ol style="list-style-type: none"> 1. The distance between the front end of the catheter and the knife edge is too far, and it needs to be adjusted to get closer. 2. Adjust the position of the catheter or the catheter with a small diameter so that the wire is straight when passing through the catheter and the knife edge on-line.
The copper wire at the end of the thread is slightly longer	<ol style="list-style-type: none"> 1. The wire diameter is too small, the knife cuts the copper wire, and it is taken out when peeling. The wire diameter needs to be increased. 2. The tool withdrawal data is too small and needs to be increased .
Cut the core at the end of the thread	<ol style="list-style-type: none"> 1. The wire diameter data is too small. Increase the wire diameter and try again until the wire core copper wire is not damaged.
Wires are not cut together	<ol style="list-style-type: none"> 1. Slow down the cutter speed and try again. 2. The blade becomes dull, you need to remove the blade and replace it with a new one. 3. When the upper and lower blades are closed, there is a gap in the plane, and it is necessary to reinstall the blades to make the upper and lower blades tight.
The actual length does not match the set value	<ol style="list-style-type: none"> 1. There is stolen goods in the roller drive, which needs to be cleaned up. 2. Check if the wire is placed at a position where resistance is encountered during wire feeding. 3. The transmission belt of the incoming roller is too loose and needs to be tightened. 4. There is paraffin on the surface of the wire, which causes the roller to slip on the wax. Please wash 4 with gasoline or banana water Scroll wheel .

<p>Wheel not working</p>	<p>1. Check whether the parameter line length has the data to be processed.2、 Check whether the timing belt is broken. 3. Check whether the wheel drive is normal (green light is normal, red light is abnormal).</p>
<p>Tool holder is not functioning properly</p>	<p>1. Check whether the cutter drive is normal (green light is normal, red light is abnormal). 2. Check whether the gear of the knife holder is stuck or the gear is broken. 3. Whether the slider of the tool post has not been lubricated for a long time, resulting in excessive friction resistance. 4. Check whether the origin of the IO monitoring cutter is green when the origin is returned. If not, the sensor is broken.</p>
<p>START not work</p>	<p>1. Check if there is any input to set the total amount. 2. Check whether the count has reached the set total amount, and clear the count to zero</p>