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(CE, ISO9001)
EW Series Semi-automatic
Wire Crimping Machine
Operation Manual
(FOR EW-09)

Catalogue

1. Usage.....
2. Basic structure and main parameter.....
3. Main machine installment.....
4. Installment of conduction current board.....
5. Installment of terminal volume.....
6. Installment of terminal die.....
7. Installment of knife mold.....
8. Operation of crimping machine.....
9. Maintenance of crimping machine.....
10. Maintenance and instruction.....

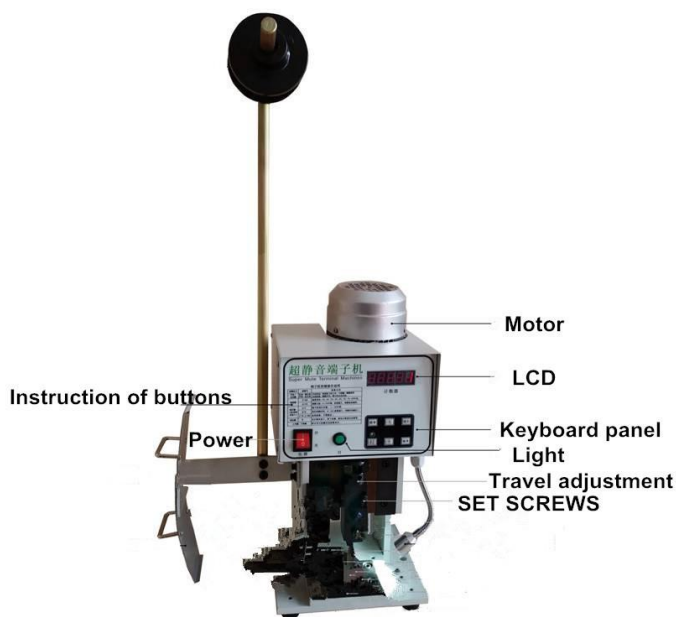
Usage

Super-mute terminal machine is the equipment which is designed and made for processing the connecting of the wires and terminals. The machine has the advantages of no noise, less consumption and easy operation. It can be allocated with OTP long mould, and adopts to connect varies of wires and terminals; also it is widely used in electronic, electric appliances, vehicles, aviation, apparatus fields and so on. The machine is designed for those factories which want the machine in the conditions of the high quality, low consumption, less maintenance. This type of machine has no noise in operation, which make the work environments peaceful and advanced. It is the best choice in the equipment of connecting machines.

Basic structure and main parameter

Basic structure

Super-mute terminal machine is made up of three parts, namely body of the machine, crimping part, electrical- control part. It gets ride of the traditional roller clutch to precision locate. The controlling parts all adopt the imported components to make the performance more perfect. It adopts of OTP cassette mold, which is more easy to change and install, and is widely uses.



Picture-1

2. Model and main parameter

外形尺寸 (mm) Outline dimension	350×390×500
重量 Weight	32-58Kg
公称压力(kn)Nominal pressure	1/1.5/2T
电源 Power	220V/50HZ
功率 Consumption	200W-300w
滑块行程 Stroke of the block	30mm
最大闭合高度 Max. closing height	150mm
闭合高度调节量 Closing adjustment height	10mm
压着次数 Crimping times	150/min

Main machine installment

- 1 The installment pictures
- 2 The crimping work table should be installed stable, firm and easy-operated high.
3. Drill a hole on the soleplate as requested, and lock the machine firmly on the table by bolt.
4. It must be used tri-core grounded power source, or connect the grounded line to the bolt.
5. When the power is on, the machine works smoothly, the installment of the main machine is finished.

The installment of guide board

There are both holes above the left and right of Terminal crimping machine for the installment of the guide board. Choose the different install direction, and use the different terminals.

The steps of the installment

1. Spin the support axle in the hole for installment of the guide board.
2. Wrest the set of the guide board in the screw on the other side of the guide board, after adjusting, fix it with screw cap.
3. Lock the guide board with screw.

Installment of guide board

Bolt

Board set of the guide

Support axle

Screw

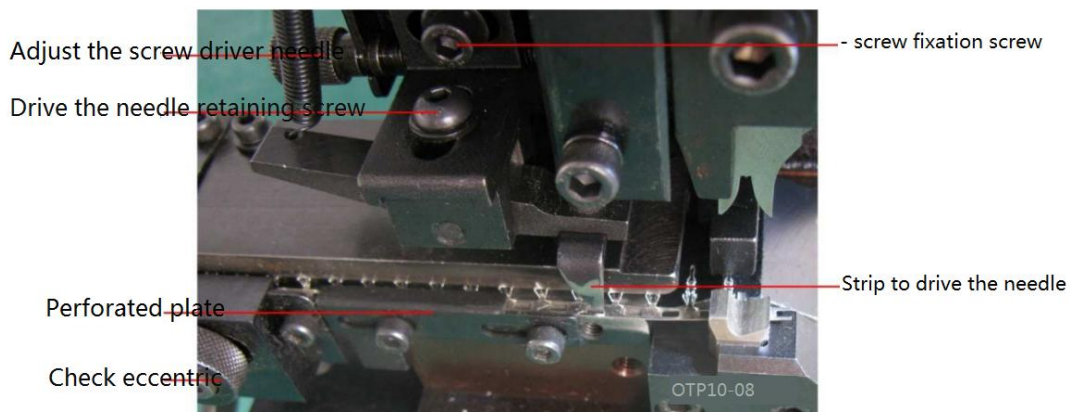
Guide board

Step

Manual

Indicator up /down

Installment of terminal roll



Picture-2

As the picture 2 shows, the location of the terminal cradle is determined by the feeding way of the pressure mold, the installment step as follows:

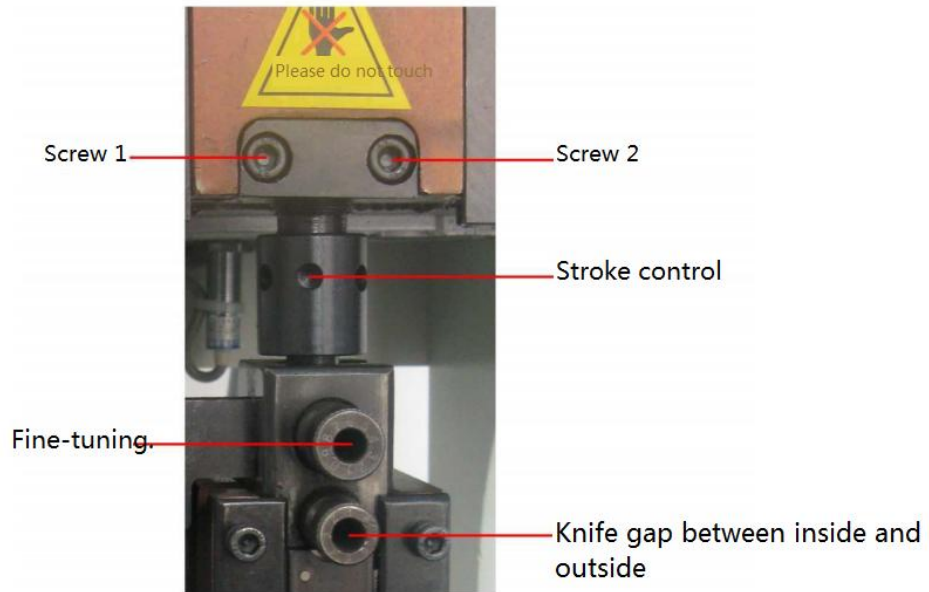
1. Insert the terminal cradle in the hole that is upper the machine, adjust it.
2. Encase the M8 bolt, in the two holes on the each side of the machine body, screw them and lock the cradle.
3. Encase the following parts one by one on the cradle: (1) fixed collar; (2) fixed spring; (3) top circle ;(4) terminal roller ;(5) top plate; after adjusting the terminal roller and fixed spring, use the M8 bolt to lock the fixed collar.
4. fixing the terminal roller pull out the terminals through guide board; enter into the mould to the feeding claws to hold the terminals.

Installment of terminal machine

Terminal fixed spring

Terminal roller
Terminal top plate
Terminal top circle
Terminal cradle
Terminal fix collar
M8bolt

Installment of terminal crimping die



- 1 Pull up the OTP mold block. Make the block set into crimping machine mold.
2. Use special block fix the mould on the machine.
- 3The effect of installment

Installment of crimping die

Shank

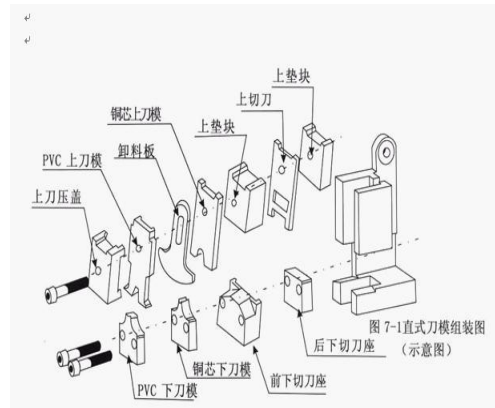
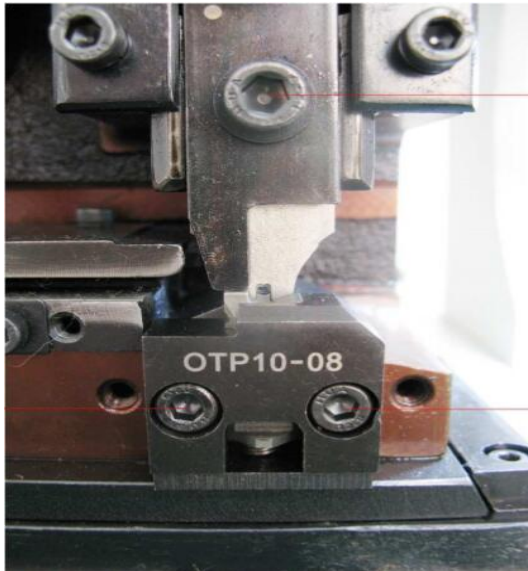
Mold block

Crimping machine

Mold block

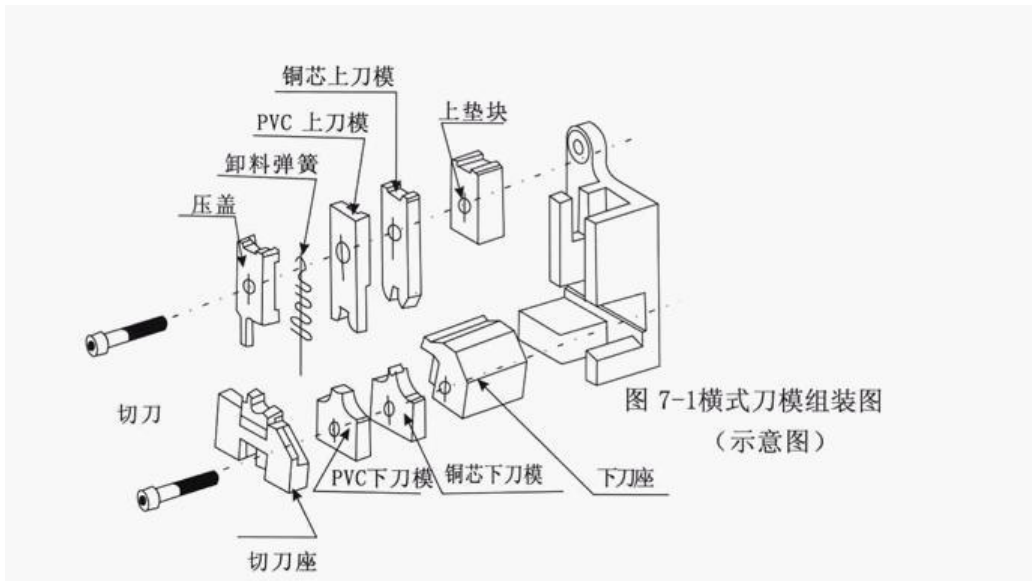
Installment of knife mold

Installment of the straight knife mould



- 1 The specification of the knife mold can change with the type of the terminals
- 2 Lock the up and down knife mold in the position showed in the picture by using bolt.

Installment of the horizontal knife mold



- 1 The specification of the knife mold can change with the type of the terminals
- 2 Lock the up and down knife mold in the position showed in the picture by using bolt.

The setting of the straight knife mold

Upper support block

Upper knife

Upper support block

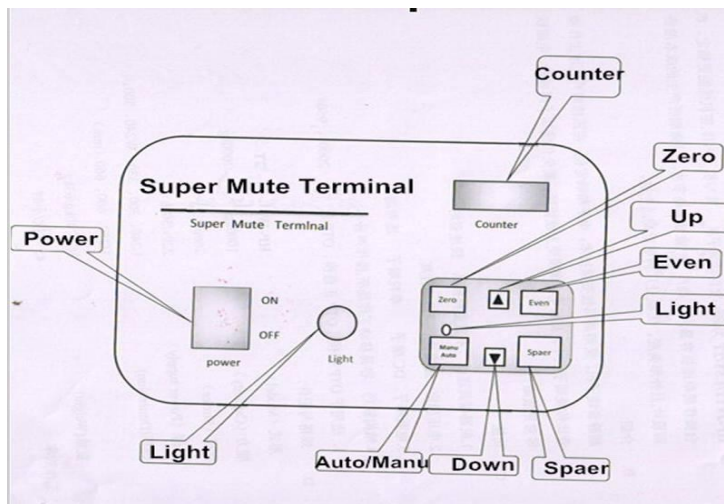
Copper core upper knife mold

Unloading material board
PVC upper knife mold
High knife capper
Back below knife set
Front below knife set
Copper core below knife mold
PVC below knife mold

Horizontal knife mold setting

Upper support block
Copper core upper knife mold
PVC upper knife mold
Unloading material spring
Knife capper
Knife
Below knife set
Copper core below knife mold
PVC below knife set
Cutter set

The operation of crimping machine



Preparation before running the machine

- 1 Check whether the crimping machine and the mold are installed firm, and whether the foot switch is firmly inserted in the electrical outlet.
- 2 Check whether the power source accordance to the specified voltage 220V and it

must install to ground wire.

3 Direct the terminals through the guiding board to the pressure mold until the knife mold parts.

Operation button

Counter

Indicator

Foot step

Manual

Up

Down

Adjustment mold and pressure testing

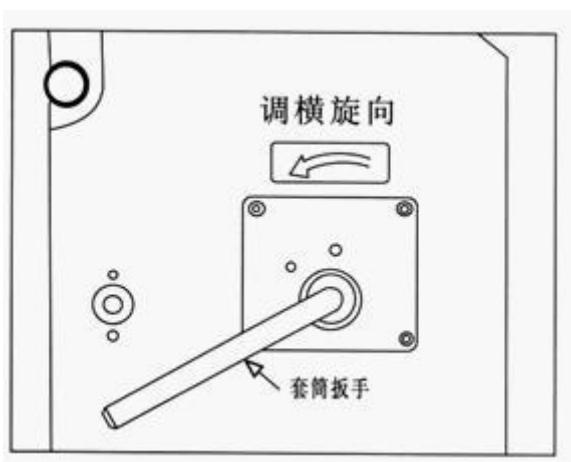
1 adjustment of crimping height of machine

(1) Turn on the power source of crimping machine, referring to picture 6, turn the switch to the manual adjustment position.

(2) Press down the adjustment button, make the main machine block drive the pressure mold block, and move from the choke point on the top to the choke point on the below. On the process of pressing, if you want to return back, and then press up the adjustment button.

(3) The crimping height of the adjustment knife mold

Crimping height adjustment



Low

High

Clamp board

Adjustment stick

Crimping mold block

Crimping machine block

M8 bolt

Crimping machine mold

Crimping height adjustment rod (pull the outward adjustment)

PVC height adjustment rod (pull the adjustment outward)

a Close the crimping bolt on the block

b Insert the adjustment stick to the hole of crimping machine mold and turn around, left turn will lower the crimping height, right turn will higher the crimping height. Adjust the height of the knife mold until the terminals conform to the command of riveting.

c Lock the crimping board bolt on the crimping machine.

d Continue to turn down the mold button until the block return and finish one work stroke. Then one terminal is crimped.

e Continue to crimping several terminal that conform to the command of riveting..

Adjustment of knife mold

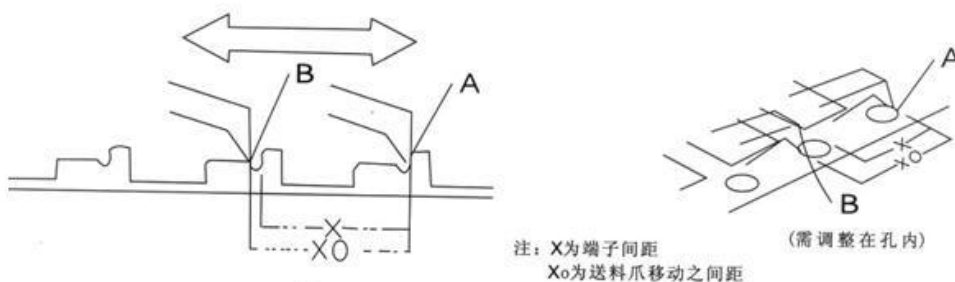
a

Full crimping height adjustment: pulling out crimping height adjustment rod. There are eight graduations on the rod. Based on the No.1 graduation, the larger the No. is, the lower position of the knife mold is. The height is differing of 0.08mm for each graduation.

b

PVC crimping height adjustment: pulling out PVC height adjustment rod and rotating. There are six graduations from 1 to 6 on the rod. Based on the No.1 graduation, the larger the No. is, the lower position of the knife mold is. The height is differing of 0.1mm for each graduation.

2. The adjustment of position feeding claw



When the upper knife mold is in the position of the choke point on the top, loose the

bolt on the feeding claw set, rotate the adjustment rod X, make the feeding claw aimed at terminal A position. The horizontal knife mold must adjust the front of the feeding mold in the hole.

PS: there are three holes on the feeding claw. When adjusting the position of feeding, you can change the hole.

Vertical knife mold feeding

Feeding claw

PS: X stands for the space between terminals.

XO stands for the space between feeding claw and horizontal knife mold

Feeding claw

(Need to adjust into hole)

(1) Adjust the upper knife mold to the choke point on the below, at this time the feeding claw is back to B, continue to press adjustment button and make the upper knife mold back to the choke point on the top, then the feeding claw pulls the terminal from B to A, the whole process of feeding is finished.

(2)、 Lock the bolt on the set, adjust the feeding place.

(3)、 If the top of the feeding claws have large excursion with the terminal belt, or the terminals are not fitting the hole timely, you can adjust the feeding board on pressure mold to match the position between the terminal belts and feeding parts.

Remark: Each time after adjustment, the sliding block should be returned back.

3. Exam before running

(1) Check whether there are dirties around the pressure mold.

(2)Put the switch to the foot step, try crimping several terminals; after they all meet the requirement, then it can running in the order. Otherwise you must adjust the crimping height again.

4. the machine is in working order.

a

Turn on the power, put the switch to the foot step, then it works smoothly.

b

Put the wire under the terminal crimping parts, that is the proper position between

below knife mold.

c

Step the foot switch, crimping block undershoots and rivet the terminals and wires; then mold feeding guide the next terminals to the crimping position of the knife mold.

D

Repeat the (2) and (3) steps, continue the riveting of the terminals and wires.

5. Finish work

a Put the switch to the middle.

b Cutting off the power.

c Clean the terminal waste material

d Clean the dirties on the surface.

Maintenance of crimping machine

1、 Daily maintenance of the crimping machine

(1) Every day before work, adds some lubricant to the gliding part of mold.

(2) Every day before work, adds some lubricant to the oil cup on the top of the crimping machine.

(3) Every month clean the copper runner in the sliding block of the crimping machine, and add lubricant again.

The step as follows:

a Loosen the two press board on the sliding block of the crimping machine.

b Take out the sliding block and the copper knot and clean them.

c after adding the lubricant, reset these parts back their places.

2. Examination and adjustment

(1) Every day before work, check whether the tie-in part is loose or not.

(2) Every day before work, run the machine for 5 minute, check whether there are problems when it's running.