



**ErreBi**  
SHOP

Soluzioni Custom  
in tempi record

**RBEW2105**

**Fully Automatic Double Head Crimp Machine**

**User Manual**



# 1. Warnings

Here may cause injuries and safety, life safety precautions, please follow the instructions noted here.

## **Pay attention to**

Precautions and restrictions that may cause damage to the equipment and equipment during operation shall be carefully handled in order to prevent wrong operation.

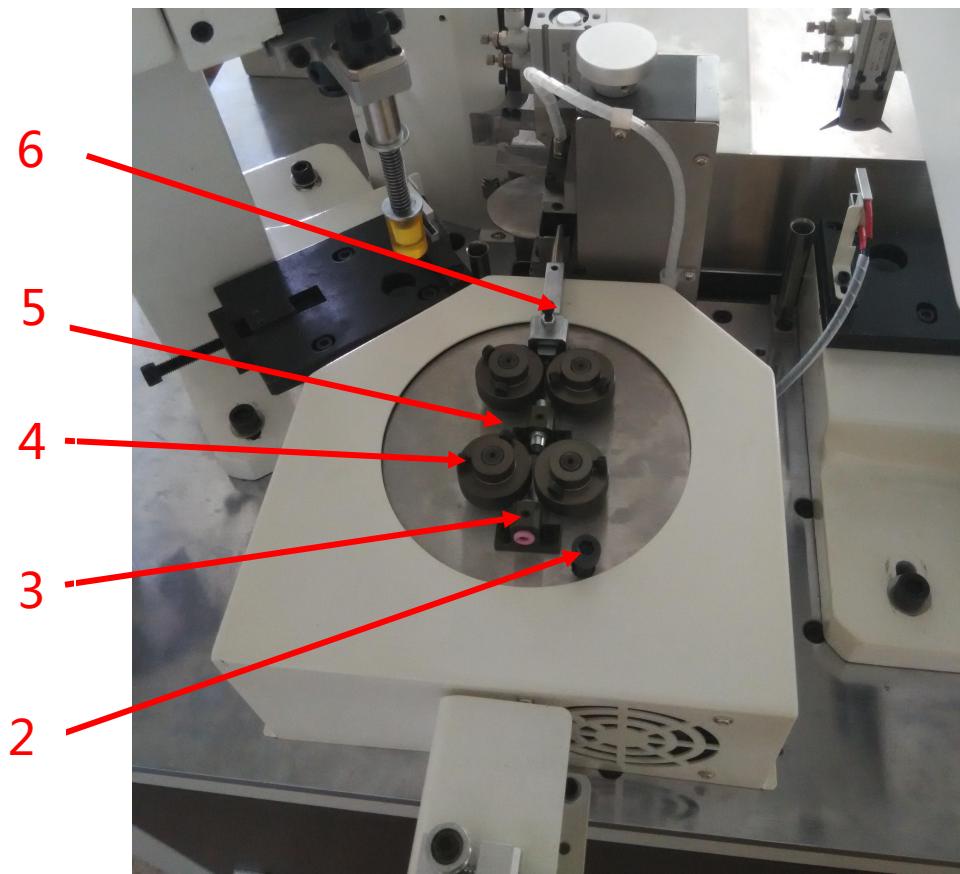
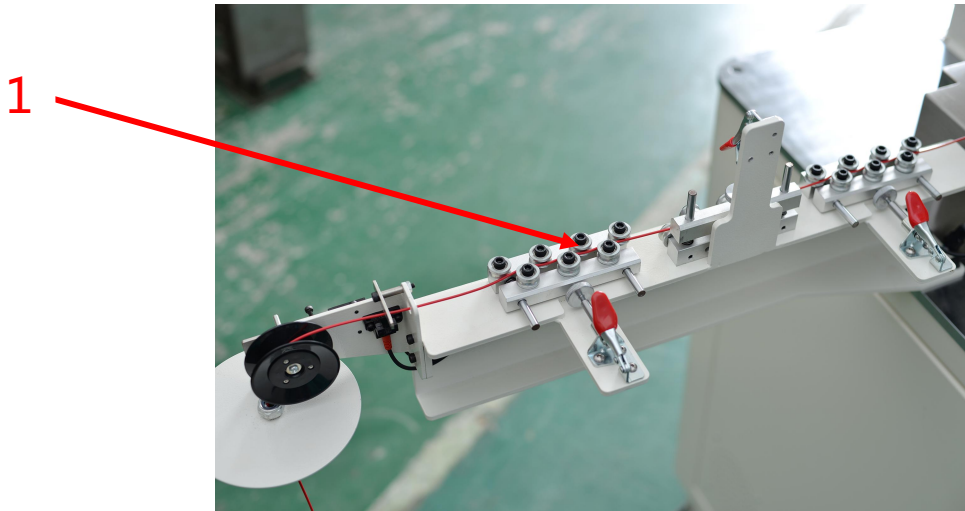
## **Safety precautions**

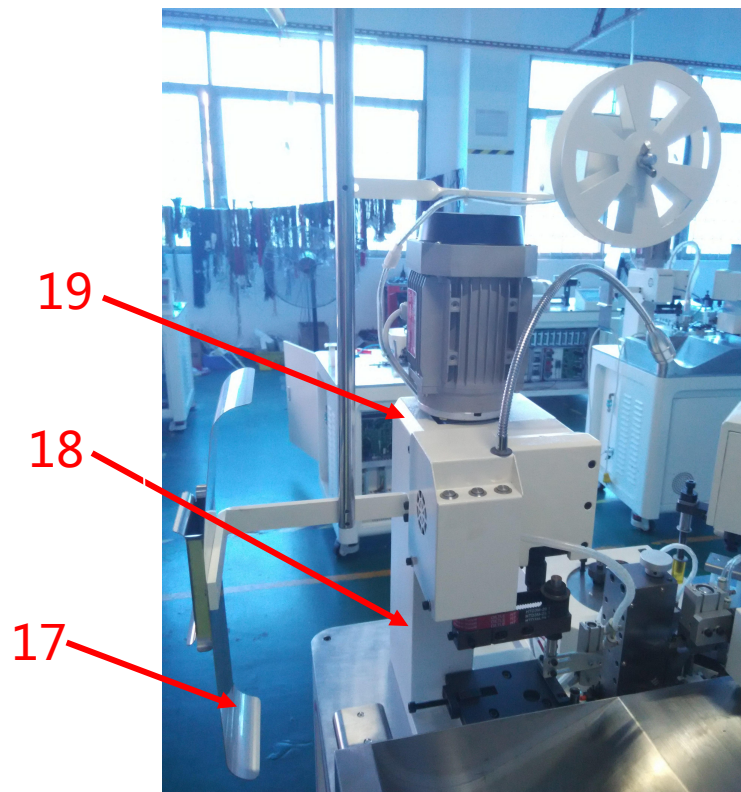
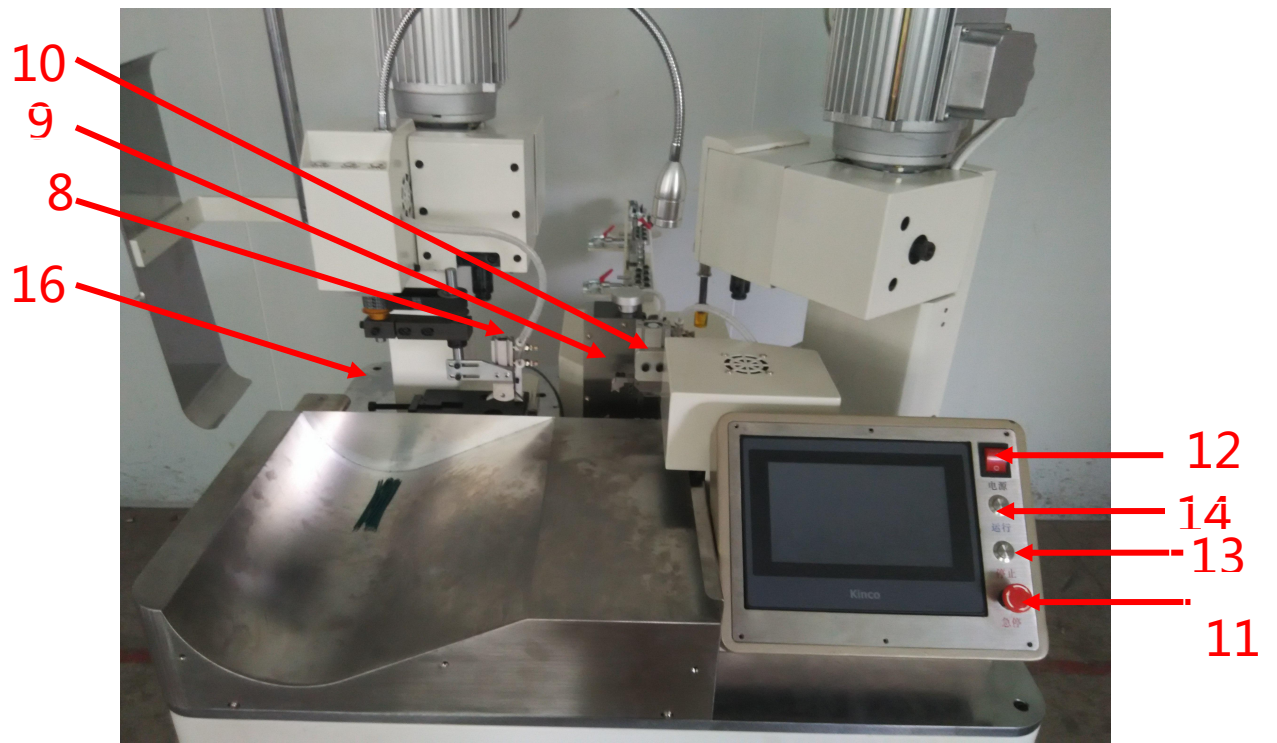
In installation, operation, maintenance , always read before you check this manual. In addition, only qualified personnel can assemble line work. The equipment is regularly maintained. The safety precautions in the manual are classified as (warn) gentle (pay attention to)

**Warn:** said the possibility of a hazardous condition, such as neglect may cause death or major injury accident personnel.

**Pay attention to:** a possible danger situation , If not promptly excluded, may cause minor or minor injuries and damage to machinery and equipment. Therefore, you should read the instructions in detail and use the equipment. Please submit the instruction to the final user , To make the most use of it。 general considerations: The equipment in the factory have done a complete function test after unpacking.

## 2. Overview





1-Straightener: correction device of wire harness, the vertical direction of the straight wire harness

2-Wire feed wheel adjustment knob: adjust the gap between the wire feed wheel, so that two wheels just press the cable to be processed

3-Inlet wire: the wire passes through the hole 。

4-Wire feeding wheel: when rotating the wire forward and back, with the knife to pull head peeling action。

5-Catheter: wire into the turret front guide wire; at the end of the catheter back to the origin, make the line and are processed in order to harness the dislocation, tail skin。

6-Tool: cutting and peeling the cutting line。

8-Take out the wire clip: transfer the processed cable to the discharge box 。

9-Clip line: cutting peeling good cable sent to the terminal to make tools。

10-After stripping: tail clip 。

11-Emergency stop button: press the emergency stop button, automatic opportunity to stop immediately, will not finish a complete action 。

12-The start button to start the machine.。

13-Stop button: press this button, go through a cycle of automaton

action will automatically stop 。

14-Run button: when the automaton is in the inching mode, press this button. The automaton runs one action: in the automatic mode, the automaton will run automatically

15-Man machine interface: operate the machine by touching touch screen 。

16-Discharge box: the place where the cable is disposed 。

17-Baffle plate: correction device terminal, the terminal vertically downward 。

18-Terminal die adjustment: upper die down 。

19-Terminal frame: terminal placed in the terminal rack 。

### 3. Operation Steps

- Mechanized Operation

1. The wire is shown in Figure 1 according to the tool with mouth .
2. The terminals placed in the terminal rack, the terminal chain passes through the block plate as shown in figure three to the terminal die.

Before the equipment is officially started, attention should be paid to the following technical points :

1. Adjust the position of the catheter base when the wire passes through the entry hole, the feed wheel, the catheter, When the outlet wheel is observed, is it in a straight line?
2. Ask the gap between the gap between the two lines into the observation wheel and wire wheel, the outer clearance must be smaller than the wire diameter.
3. With one hand grabbed the wire, a little hard to pull, if not pull out that line wheel clearance and pressure are appropriate .

- Electric Operation

- 1) The first operation

1. Check whether the power supply AC220V 50HZ
2. The outlet is a grounding wire, grounding machine
3. Whether the power cord is intact, check whether there is no crack glue, whether the connection line is dropped or not

4. Check the operation of the machine is part of a foreign body
  5. Need to add lubricating oil parts, to check whether or not need to add lubricating oil
  6. Connect the power supply, the pressure is above 0.4MPa
- 2) power-on:
    1. A plug with a wire
    2. Start the emergency stop switch and turn on the air pressure switch to ensure the air pressure
  - 3) Validation of operating conditions
    1. The cutting knife is installed
    2. Check the wires for each part
  - 4) Running around
    1. Open the operation screen, enter the startup screen, select the inching mode on the touch screen, press the running button, the automaton will perform the action step by step, and adjust the action of each part
    2. Single step for the entire movement of the separation action, single step action can complete all the processes, the basic automatic is intact, such as abnormal occurrence, indicating that the automatic operation speed is too fast or have written parameter settings conflict.

5) an automatic operation mode

1. Open the touch screen operation screen, enter the start screen, switch the inch mode to automatic mode, press start

2. The automatic operation to ensure that each parameter value is correct

6) end of job

1. Set the number reached after the machine stops automatically, and will pop up window display to set the number of, can be determined by the operation in the picture is eliminated, and the interval after a period of time the machine will continue to operate, the time interval in the function setting screen in the number set to pause: if the total production, the machine will automatically stop and pop-up window display

2. If you need to complete the work after can directly press the start button to start work, if not in a long time can turn off the machine power supply

## 4. Start Page

[简体中文] press to change to Chinese

[English] press to change to English

[进入系统] press to enter home page

## 5. Home Page

2022-12-08  
10:33:44  
Fully Automatic Double Head Crimping Machine  
Cur.Pr0. 0  
Name

Total Set 0 Total Count 0 Batch Set 0 Batch Count 0 UPH 0

Motor Jog Back Feed Step  
Air Jog  
Crimp Set  
Speed Set End 0.00 mm Dia 0.00 mm Head 0.00 mm Cycle  
Time Set Strip 0.00 mm Retract 0.00 mm Strip 0.00 mm Auto  
Check Sensor Reset  
I/O Monitor Start Stop Pause E-Stop

[Cur. Pro.] the current program No.

[Name] program name

[Total Set] set the total quantity

[Total Count] current total quantity counted

[Batch Set] set the batch quantity

[Batch Count] current batch quantity counted

[UPH] estimated unit per hour - auto calculated by machine

[Back] press to back (pull out) the wire

[Feed] press to feed the wire

[Length] wire total length, including stripping part

[End] wire back stripping length

[Dia] enter wire diameter (smaller value, blades cut deeper)

[Head] wire front stripping length

[Strip] pull-off length

[Retract] the retract distance after blades cut into the depth as set in [Dia], which is to avoid hurting the wire inner copper

[Start] press to start production

[Stop] press to stop production

[Pause] press to pause the production

[Step] press to change to step mode, machine will work step by step under step mode

[Cycle] press to change to cycle mode, machine will work cycle by

cycle under cycle mode

[Auto] press to change to auto mode, machine will do automatic production under auto mode

[Reset] press to reset all the mechanical parts

[E-Stop] press to do emergency stop

[Motor Jog] press to enter Motor Jog Page

[Air Jog] press to enter Air Jog Page

[Crimp Set] press to enter Crimp Set Page

[Speed Set] press to enter Speed Set Page

[Time Set] press to enter Time Set Page

[Check Sensor] press to enter Check Sensor Page

[I/O Monitor] press to enter I/O Monitor Page

## 6. Crimp Set Page

Front crimping <input type="button" value="OFF"/>	Back crimping <input type="button" value="OFF"/>
Insulation Crimp Position <input type="text" value="0.00"/> mm	Insulation Crimp Position <input type="text" value="0.00"/> mm
Crimp Swing <input type="text" value="0.00"/> mm	Crimp Move Position <input type="text" value="0.00"/> mm
Swing Sensor <input type="text" value="0.00"/> mm	Move Detect Position <input type="text" value="0.00"/> mm
Crimp Advance <input type="text" value="0.00"/> mm	Crimp Advance <input type="text" value="0.00"/> mm
Crimp Delay <input type="text" value="0.000"/> s	Crimp Delay <input type="text" value="0.000"/> s
Swing Delay After Crimp <input type="text" value="0.000"/> s	Swing Delay After Crimp <input type="text" value="0.000"/> s
Guide Tube Benchmark <input type="text" value="0.00"/> mm	Put Wire Pos <input type="text" value="0.00"/> mm
Tube Retract After Crimp <input type="text" value="0.00"/> mm	Discharge Position <input type="text" value="0.00"/> mm
Pre-feed Position <input type="text" value="0.00"/> mm	<input type="button" value="Middle strip"/>
Pre-feed Length <input type="text" value="0.00"/> mm	<input type="button" value="Special"/>
	<input type="button" value="Retrun"/>
	<input type="button" value="Press and Hold to Show the Explanatory Note"/>

[Front crimping on/off] press to turn on/off the front crimp unit

[Insulation Crimp Position] the crimp position on wire insulation

- front crimp - larger value for more insulation crimp

- back crimp - smaller value for more insulation crimp

[Crimp Swing] the swing position to crimp unit after wire strip process

[Swing Sensor] swing to optical fiber sensor position to detect terminal (note: terminal should move across the optical fiber sensor)

[Crimp Advance] crimp the terminal before wire reach the crimp position (0-50)

[Crimp Delay] delay the terminal crimp after wire reach the position (0.1)

[Swing Delay After Crimp] delay the swing after crimp (0.05)

[Guide Tube Benchmark] guide tube to crimp unit distance (larger value closer distance, 10-12)

[Tube Retract After Crimp] retract the guide tube after front crimp to avoid crash with applicator

[Pre-feed Position] swing to pre-feed position to avoid tangle in blades

[Pre-feed length] pre-feed length after wire reach pre-feed position to avoid tangle in blades

[Back crimping on/off] press to turn on/off the back crimp unit

[Crimp Move Position] move the wire to crimp position after strip process

[Move Detect Position] terminal detect position by optical fiber after crimp (note: terminal should move across the optical fiber sensor)

[Put Wire Pos] finished product drop position on stacker

[Discharge Position] terminal detect position after back crimp (for special wires and terminals)

[Middle strip] press to enter Middle Strip Page

[Special] press to enter Special Page

[Return] press to return to Home Page

## 7. Troubleshooting

order number	abnormal phenomena	fault analysis	Re-solvent
1	Normal work fetch-up	<ol style="list-style-type: none"> <li>1, Quantity arrival</li> <li>2, Abnormal terminal detection</li> <li>3, Wire knotting</li> <li>4 , Barometric depression</li> </ol> Barometric depression	<ol style="list-style-type: none"> <li>1, Qing Ling button cleared</li> <li>2 ,Adjust fiber position</li> <li>3, Finishing wire</li> <li>4 ,The air pressure is above 0. 4MPa</li> </ol>
2	The incision tilts when tangent	<ol style="list-style-type: none"> <li>1 , The wire itself is too curved, the purchase of straightener</li> <li>2, No edge is the center conductor</li> <li>3When the end of the head is tilted, check whether the pipe mouth is too close to the cutter</li> </ol>	<ol style="list-style-type: none"> <li>1, Top line pressure screw</li> <li>2, Adjust rack clearance</li> <li>3, With the suitable size of the wear plate line</li> </ol>
3	The skin can't be peeled or peeled  Cut wire continuously	<ol style="list-style-type: none"> <li>1, The knife cut off value, stripper value is not set</li> <li>2, tool wear or breakage</li> </ol>	<ol style="list-style-type: none"> <li>1, The knife cut off value is set to value the wire stripping knife</li> <li>2, change tools</li> </ol>
4	Length length vary	<ol style="list-style-type: none"> <li>1, Wire feeding wheel clamping wire, slip</li> <li>2 , The whole line is too stressed</li> <li>3, Wire feed wheel wear</li> </ol>	<ol style="list-style-type: none"> <li>1, Adjust the adjusting knob of wire feed wheel,</li> <li>Pull the wire, the wire feeding wheel just</li> <li>Thread pressing</li> <li>2, ditto</li> <li>3, The replacement of wire feeding wheel</li> </ol>
5	Turn on the machine, the power does not start	<ol style="list-style-type: none"> <li>1, Set number may be zero</li> <li>2 , The origin of the induction induction switch is not in place</li> <li>3, The emergency stop knob is not turned on</li> </ol>	<ol style="list-style-type: none"> <li>1, The cleared</li> <li>2 ,Check whether the inductive switch in each motor is abnormal or not. Lock the screw 3 and open the emergency stop button</li> </ol>

6	The machine is reset back to the origin.	Among them, there is the origin induction, no induction in place	Check the origin of induction switch, ensure each switch induction without exception
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## 8. I/O Hookup

input end	outlet end
X0 : Start button	Y0 : Rear cylinder
X1 : Stop button	Y1 : Translation clamp cylinder
X2 : [計] reset switch	Y2 : Arm clamp cylinder
X3 : Emergency stop	Y3 : scavenging
X4 : The origin of the knife	Y4 : Front crushing cylinder
X5 : reserve	Y5 : After crushing the cylinder
X6 : Translation origin	Y6 : Wire stamping
X7 : After the clip origin	Y7 : Front receiving machine
X8 : Swing arm origin	Y8 : After receiving machine
X9 : The origin of the arm	Y9 : buzzer
X10 : Pressure detection	Y10 : Spare
X11 : Wire inspection	Y11 : Spare
X12 : Wire inspection	Y12 : Before you hit the terminal

X13 : reserve	Y13 : After playing the terminal
X14 : Back fiber detection	Y14 : reserve
X15 : After the sensor terminal	Y15 : reserve
X16 : Front fiber detection	
X17 : Front terminal sensor	
X18 : Front feed induction	
X19 : After the delivery of induction	