

User Manual



Points for Attention of Safe Operation

First of all, thank you very much for buying our SWT Series Full-automatic Computer Wire Stripping Machine. For safe and correct operation of this machine, please read this operation manual carefully before operation.

I. Power Adapter: AC 220–250V, 50–60HZ. In order to provide a stable operating voltage, the user should select and use power voltage stabilizer so as to prevent this machine from being burned out caused by over-voltage.

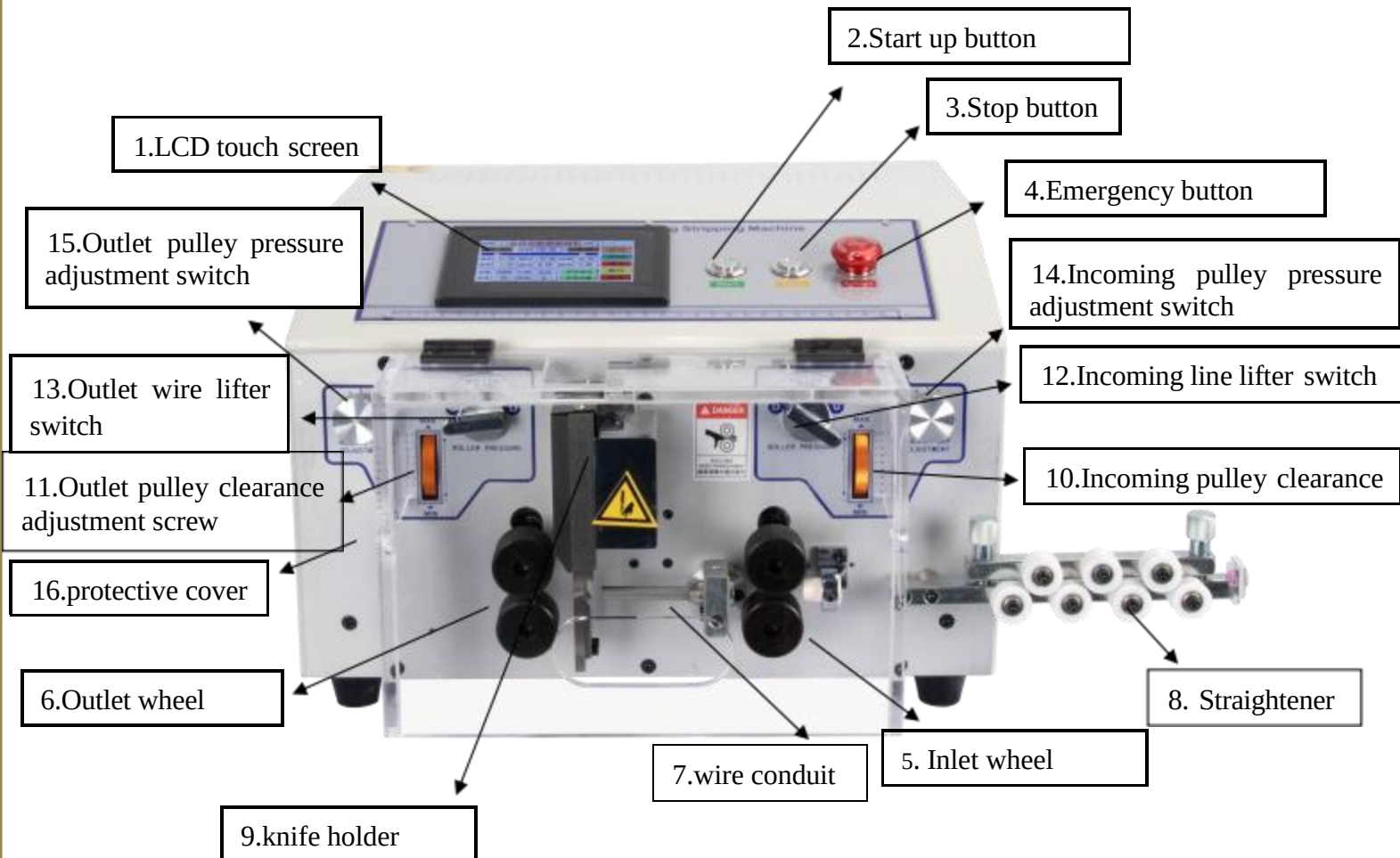
II. On operation this machine should be placed on a smooth and stable surface so as to prevent this machine from falling down and being damaged.

III. Don't use this machine near an area with stronger electromagnetic field so as to prevent this machine from being interfered.

IV. On operation don't place any objects on this machine, don't place this machine near corrosive chemicals, be sure to keep the operating environment dry, well ventilated and dustless, operating room temperature: 0–35°C.

V. On operation if bad effects of wire stripping or some faults appear, please read this operation manual for faults and clearances, if you still cannot solve the problems, please call our technical service telephone to realize the method of maintenance and repair. For your safety, please don't disassemble this machine by yourself for maintenance and repair.

Machine appearance and function description



Description of machine:

1.LCD touch screen: Display parameters, all parameters are input from this LCD touch screen

2.Start up button: When the machine is in reset state, Press this key to start the machine.

3.Stop button: When the machine is working, press this key, the machine will

stop after finishing the work.

4.Emergency button: When the machine is working, press this key, the machine stops instantly.

5.Inlet wheel: The rotation of the wheel drives the wire forward.

6.Outlet wheel: The rotation of the wheel drives the wire forward.

7. wire conduit: Wire is delivered through this conduit.

8.Straightener: Straighten the bent wire so that it enters the machine smoothly.

9. knife holder: Cutter device, wire cutting and stripping are completed by the knife holder.

10.Incoming pulley clearance : Adjust the gap between the top and bottom of the inlet pulley.

11.Outlet pulley clearance adjustment screw: Adjust the gap between the top and bottom of the outlet pulley.

12.Incoming line lifter switch: This switch can lift the incoming wire pulley in the air.

13.Outlet wire lifter switch: This switch can lift the outlet pulley in the air.

14.Incoming pulley pressure adjustment switch: Adjust the pressure tightness between the upper and lower pulleys.

15.Outlet pulley pressure adjustment switch: Adjust the pressure tightness between the upper and lower wheels

16.protective cover: Keep operator safety

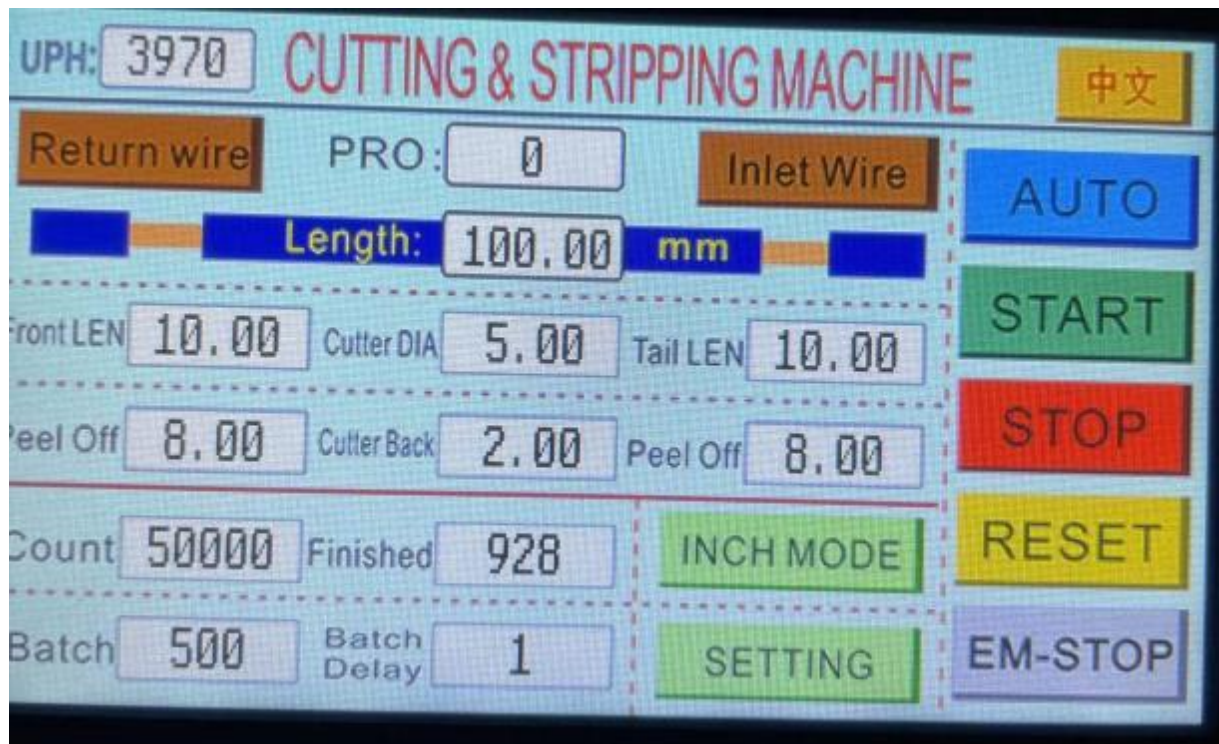
Control Panel Diagram Operation Instructions

Turn on the power, the LCD screen will display the picture as shown in the figure.



Chinese and English can be switched freely, please select "Chinese" or "ENGLISH" to enter the next page.

The following is the main page of parameter setting



The operation interface of this system consists of a 160×107 LCD touch screen. The following will introduce the function of each key:

Return wire: Press and hold this key, the wire can be transported through the wire inlet and the wire feeding wheel, and the wire can be withdrawn from the cutting edge, and can be freely adjusted as required.

Inlet wire : Press and hold this key, the wire can be conveyed to the cutting edge through the wire inlet under the transmission of the wire feeding wheel, and can be adjusted freely according to needs.

PRO : The program number. The parameters of the wire rods of various specifications that need to be processed are stored in different program numbers, so that they can be called out for use next time.

Length: Total length of cut and stripped wire (max 400m).

Front LEN: The length of the wire head to be stripped of the outer sheath; that is, the length of the copper wire to be removed from the outer sheath.

Peel off: When the stripping value is greater than the wire end value, it is full stripping, otherwise it is half stripping.

Tail LEN: The length of the wire tail stripped from the outer sheath; that is, the length of the copper wire exposed when the outer sheath is removed.

Cutter DIA: The depth that the cutter cuts off the outer skin when peeling the skin. The larger the thread length, the shallower the cut; the smaller the thread length, the deeper the cut.

Cutter Back: The parameter value that the cutter will return after cutting into the wire when peeling the outer skin; to ensure that the cutter is stuck on the wire skin to peel off the outer skin, the thicker the wire, the larger the retraction value, and the thinner the wire, the smaller the retraction. As per the material of wire can adjust the cutter back.

Count: Set the planned production quantity. When the wire processed by the machine reaches this value, the machine will automatically stop and give a prompt.

Finished: Displays the actual total quantity currently produced, when "Count"="Finished", The machine stops automatically.

Batch: Displays the currently produced quantity.

Definite time: When the machine runs to the set "batch" number, the machine will

pause for the set time. When set to "0", the machine does not start; A setting of "1" pauses for 1 second, a setting of "2" pauses for 2 seconds, and so on.

Auto/inch/single cycle: Press the start button in automatic mode, the machine will automatically run to the set value and then stop; Press the start button in the inch mode, the machine only works one step, press it to run one step.

Press the start button in single cycle mode, the machine runs for one cycle (cuts a wire).

Start : It has the same function as the green solid button on the operation panel. Press it once, and the machine will start until the processing quantity reaches the set total amount.

Stop : It has the same function as the yellow solid button on the operation panel. Press it once and the machine will stop automatically after processing the wire.

Reset: After setting the parameters, it must be reset once to start.

EM-Stop: It has the same function as the red solid button on the operation panel. Press it when the machine is working, and the machine will stop instantly; when the machine stops, the machine must be reset to start.

【Manual debugging】 page setting description

structure	Step Amplitude	Current Displacement	Inching Button			
Cutter	10	0.00	OPEN	CLOSE	DATUM	
Pipe	10	25.00	FORWARD	REVERSE	DATUM	
Twist	10	25.00	FORWARD	REVERSE	DATUM	
wheel rises	10	0.00	FORWARD	REVERSE	DATUM	
Cutter Max Stroke	41.50	Second Cutter Max Stroke	9.50	Pipe Start Stop POS	25.00	
Main Cutter Close Val	39.50					RETURN

- **Main Cutter Close Val** : Click the **[Close]** button , every time you press the knife edge to close a little bit, jog or long press the close button to make the knife edge close to the position where the upper and lower knife edges just bite.

Then input the value displayed in **[Current Displacement]** into the **[Main Cutter Close Val]** box.

- **【DATUM】** button: The cutter quickly returns to the reset state.
- **Cutter Max Stroke**:The value of the cutting stroke of the main tool is greater than the value 1 or 2 in the **[Main Cutter Close Val]** box.

【parameter settings】 Page Setup Instructions



Pipe on: The wire conduit can beat.

Wheel on : The outlet pulley can be lifted when stripping the wire head(The machine with the cylinder lift function has this function).

Wire lack off: After the machine is started, there is no wire in the front wheel, and the machine stops automatically.

Cut rubber off: After the machine is started, when peeling off the outer sheath, squeeze the clip to knock off the stripped waste skin.

Slid arm off: This function requires a robot hand to be installed.

Roller speed : The rotation speed of the incoming and outgoing wire pulleys can be adjusted from 1 to 100, with 1 being the slowest and 100 being the fastest.

Cutter speed: Set the running speed of the cutter, the adjustable range is 1-100,

1 is the slowest, and 100 is the fastest.

Strip speed : The speed of peeling off the wire sheath can be adjusted in the range of 1-100, with 1 being the slowest and 100 being the fastest.

Cut down speed : Set the cutter running speed when the cutter is cutting, the adjustable range is 1-100, 1 is the slowest, and 100 is the fastest.

Ejection speed: Set the running speed of the wire outlet wheel when the wire is discharged. The adjustable range is 1-100, 1 is the slowest, and 100 is the fastest.

【Length modify】 Parameter setting description

Set Length	100.00	MODIFY LENGTH
Actual Length	0.00	
Actual Cutter Dia	5.00	Factory Set
Cutter Dia Coefficient	1.000	
RETURN		

【Length modify】 : It is used to correct the error in the length of the actual processing wire.

Set length: Sets the value of the length of the line to be trimmed.

Actual length: The actual length value cut by the machine.

After entering this actual value , Press **【Length modify】** , the machine will cut a line with the same length as the set length.

Actual cutter Dia: Set actual wire diameter.

Wire diameter coefficient: In general, no need to set, the system defaults.

Factory set : Press this key to restore the parameters set by the machine to the original state. It is recommended not to press this key.

【Middle peel setting】 : Press and enter the following setting

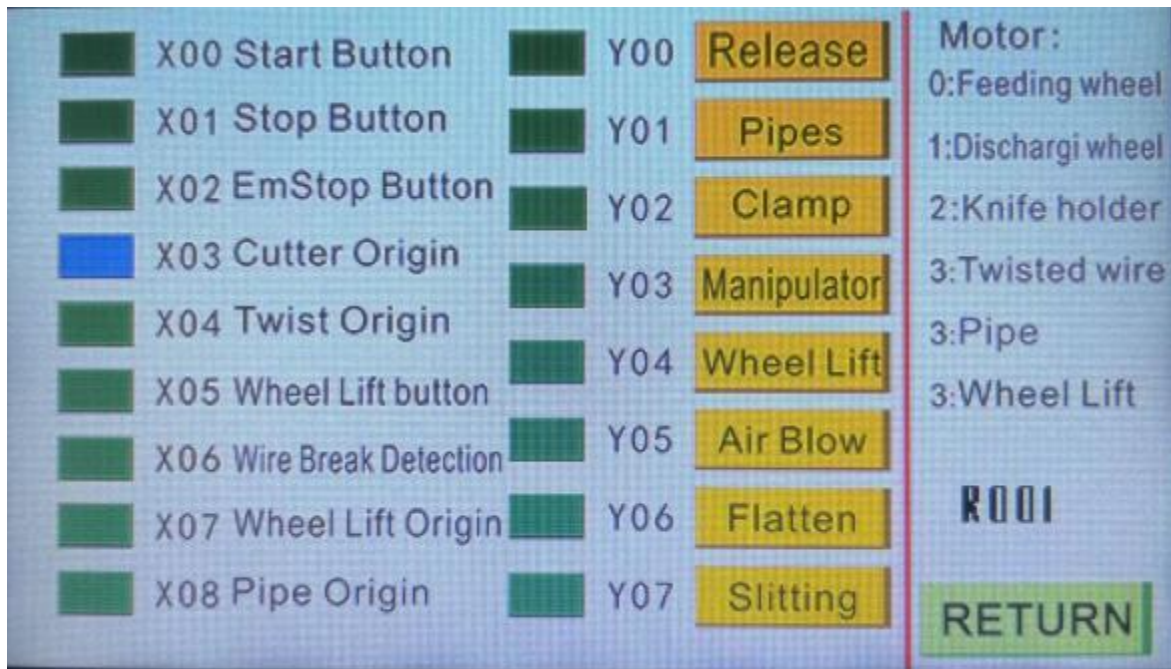
POS	Length	Cut Open	POS	Length	Cut Open
01	0.00	0.00	09	0.00	0.00
02	0.00	0.00	10	0.00	0.00
03	0.00	0.00	11	0.00	0.00
04	0.00	0.00	12	0.00	0.00
05	0.00	0.00	13	0.00	0.00
06	0.00	0.00	14	0.00	0.00
07	0.00	0.00	15	0.00	0.00
08	0.00	0.00	16	0.00	0.00
MID CUT OFF				RETURN	

【Mid cut on/ off】 In the open mode, the total length, line head and line tail length of the main page are associated. A total of 16 middle peels, 01 positions

【Length】 Enter the position of the first cut in the middle, **【Cut open】** is the distance drawn. For example : The total length is 200mm, strip 20mm at the

middle 100mm to expose the copper wire, that is, set 01 length = 100, strip = 20.

Press **【IO Monitor】** to enter the following setting page



Each IO monitoring point corresponds to each wiring point of the main board. Usually, the monitoring is turned on when the machine is abnormal to determine the problem.

Important Notes on Stripping Setup:

When debugging after inputting parameters, firstly switch the "automatic" mode to "jog" mode to test the wire first, and then switch to the "automatic" mode to formally process the wire after reaching the desired effect.

Trouble and solve

Trouble	Solve
Can't strip the head of wire	1.Check the cutting depth of the wire head, if the cutting mark is too shallow, adjust the diameter of the front wire to make it smaller. 2.If the gap of the wire feeder is too large, it is necessary to adjust the "feeding

	thread clamping depth" to reduce the wire feeder clearance to an appropriate position. Decrease the Grip Depth value to make the gap smaller. 3.Check whether the transmission belt of the wire feeder is dirty and needs to be cleaned.
Can't strip the end of wire	1.Check the cutting depth of the wire end. If the cut mark is too shallow, adjust the back end wire diameter to make it smaller. 2.If the clearance of the outlet pulley is too large, it is necessary to adjust the "clamping depth of the outlet wire" to reduce the clearance of the outlet pulley to an appropriate position. Decrease the Grip Depth value to make the gap smaller. 3.Check whether the drive belt of the wire outlet pulley is dirty and needs to be cleaned.
Crushing of the outer skin of the wire	1.First, judge whether the crushing comes from the incoming wire or outgoing wire, and replace the outer conveyor belt of the corresponding wheel.
The actual wire length is less than the set length	1.The wires themselves vary in thickness. 2.The drive belt is dirty and needs to be cleaned. There is wax on the surface of the wire, which causes the wax to slip on the drive belt. It needs to be cleaned with a brush and the outer surface of the drive belt should be cleaned with gasoline. 3.The pay-off frame is stuck, resulting in poor conveying wire.
Sometimes the head of the wire or the end of the wire cannot be stripped	1.The pressure of the incoming transmission belt is not enough, please check and adjust the "feeding thread clamping depth" to increase the pressure of the incoming transmission belt. The method is to reduce the depth of the clip line. 2.The pressure of the outgoing drive belt is not enough, please check and adjust the "clamping depth of the outgoing line" to increase the pressure of the outgoing drive belt. The method is to reduce the depth of the clip line.

A few strands of copper wire are longer at the end or end of the wire	1.The wire diameter at the front or rear end is too small, the cutter is too deep to cut the copper wire, and the copper wire is brought out when the wire is stripped, and it is necessary to increase the wire diameter and try again.
Sometimes the wires are connected together without cutting	2.Set the cutter speed to the slowest and try again. See if the upper and lower knife edges are closed over the critical point during operation。 3.Check that the gauge of the wire is within the range of the machine stripping square. 4.If the blade is dull, use a flat grind, or replace it.
The fan does not work after starting the machine, the screen doesn't display	1.The fuse in the power switch is burned out due to unstable voltage or illegal operation, and the fuse needs to be replaced (after turning on the power switch, it can be seen that there is a 5A fuse in the power switch). 2, If the fuse continues to burn after changing the fuse, you need to contact the after-sales service department or office of our company.
Cut slanted when tangent	1, The wire itself is too bent, and it needs to be straightened with a straightener. 2, The wire port is not facing the center of the knife edge. 3, When the head and tail of the thread are inclined, check whether the nozzle of the wire is too close to the tool.
Scratching the inner core when peeling	1. If the inner core and outer skin of the front end are scratched, then the wire diameter of the front end is too small, you need to increase the wire diameter and try again. 2.If the inner core and outer skin of the rear end are scratched, then the diameter of the rear end wire is too small, you need to increase the wire diameter and try again.

After-sales service commitment and accessories description

One year warranty, lifetime maintenance!

The company's series of automatic computer wire stripping machines carry out a one-year warranty. If the failure occurs according to the provisions of the factory,

the damaged parts will be replaced free of charge. After the one-year warranty period, the factory will continue to provide you with after-sale tracking service. If the device is damaged due to use failure, only the cost will be charged. The ownership of damaged parts replaced within the warranty period belongs to the factory.

The following situations are not covered by the warranty:

1. Damaged by the user due to improper transportation, installation, use and storage;
2. Damaged due to dismantling by the user or dismantling and repairing by a non-factory designated maintenance point;
3. Damage caused by accidental electricity, fire, flood, etc.;
4. Damaged due to failure to operate in accordance with the operation requirements in this manual;
5. Damaged due to irresistible reasons;

Spare parts

This machine is packed in carton foam. After unpacking, please take out the accessory packaging bag and check it, then place the machine on a stable work surface, and prepare a power socket that meets the requirements.

- 1.A stripping machine
- 2.A pack of hexagon socket tools
- 3.A copy of the manual
- 4.One power cord
5. 3 different pipes

Important Note

1. We offer 12 months' free maintenance service from the stamped purchase date.
2. During the warranty period, clients do not need to pay for any parts or service; but all freight costs caused by sending spare parts are at the buyer's expense (excluding consumable parts).
3. We only assure the warranty to the clients who originally purchased the machine from our company or our authorized agent. The warranty is void once the machine is on-sold, or otherwise traded to a new entity.
4. We are not responsible for any equipment fault occurred as follows:
 - a. Any equipment fault cause by not abiding by the operational requirements in the manual.
 - b. The operational environment in user's factory does not meet the minimum operational requirements set out in the manual (power instability, compressed air not dry and clean, etc.).
 - c. A non-professional operator dismantles the machine without permission, which then leads to equipment fault or damage.
 - d. Force majeure will be invoked for any extraordinary incidents at leads to equipment fault or damage.
 - e. Maintenance by 3rd parties, other than our authorized agent(s) will void the warranty.

Electrical diagram

Schematic diagram of electrical principle of 4-axis wire stripper control system

