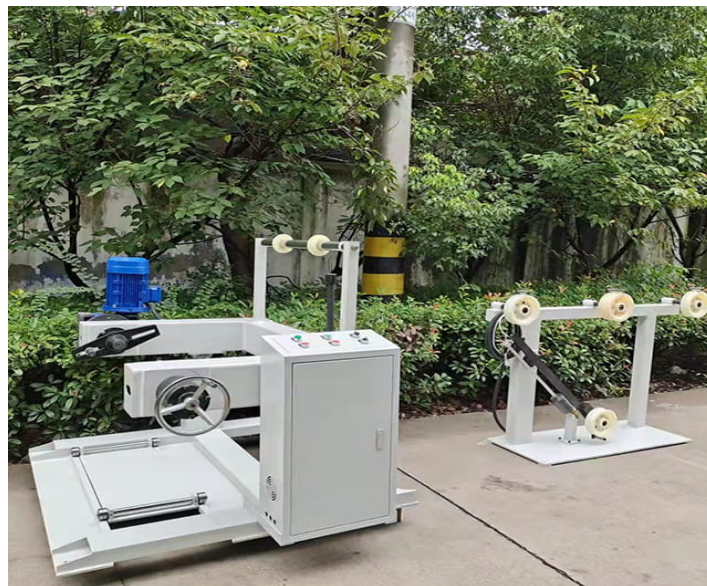


(CE, ISO9001)

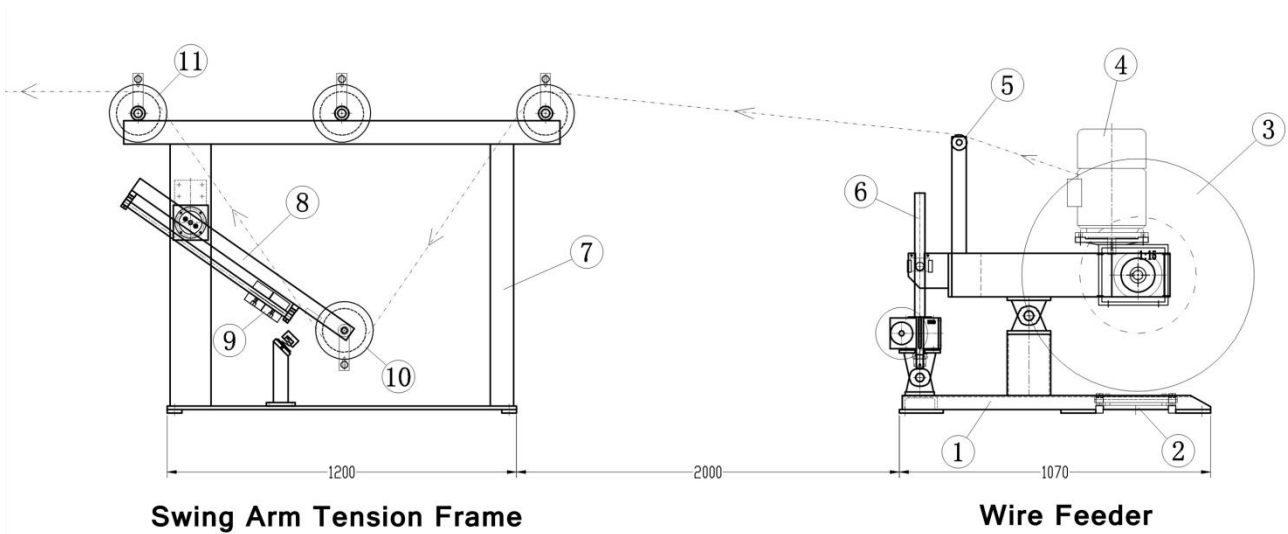
Operation Manual



Technical parameter

Model	EW-1450
Wire diameter	3-45mm
Wire tray size	OD 600-1250, width 550-950
Loading weight	1500kgs
Max. feeding speed	100m/min
Feeding motor power	5.5KW
N.W.	700kgs
Power supply	220V/50HZ

Structure



- | | | |
|------------------|----------------------|----------------|
| ① Pay-off rack | ② Loading skateboard | |
| ③ Wire Tray | ④ Pay-off Motor | |
| ⑤ Feeding Roller | ⑥ Lifting device | |
| ⑦ Tension Frame | ⑧ Swing Arm | |
| ⑨ Counterweight | ⑩ Tension Roller | ⑪ Guide Roller |

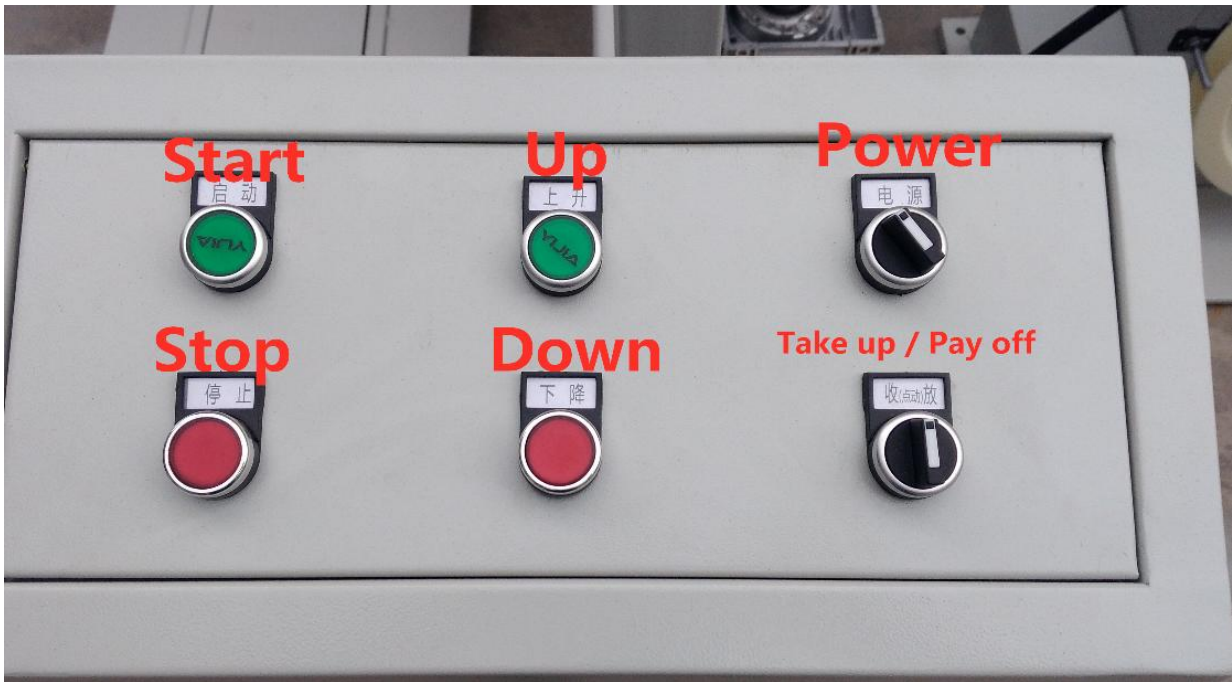
1. This machine is composed of an active pay-off machine and a swing arm tension frame.

2. Using 220V power supply, the power cord specification is 4 square millimeters.

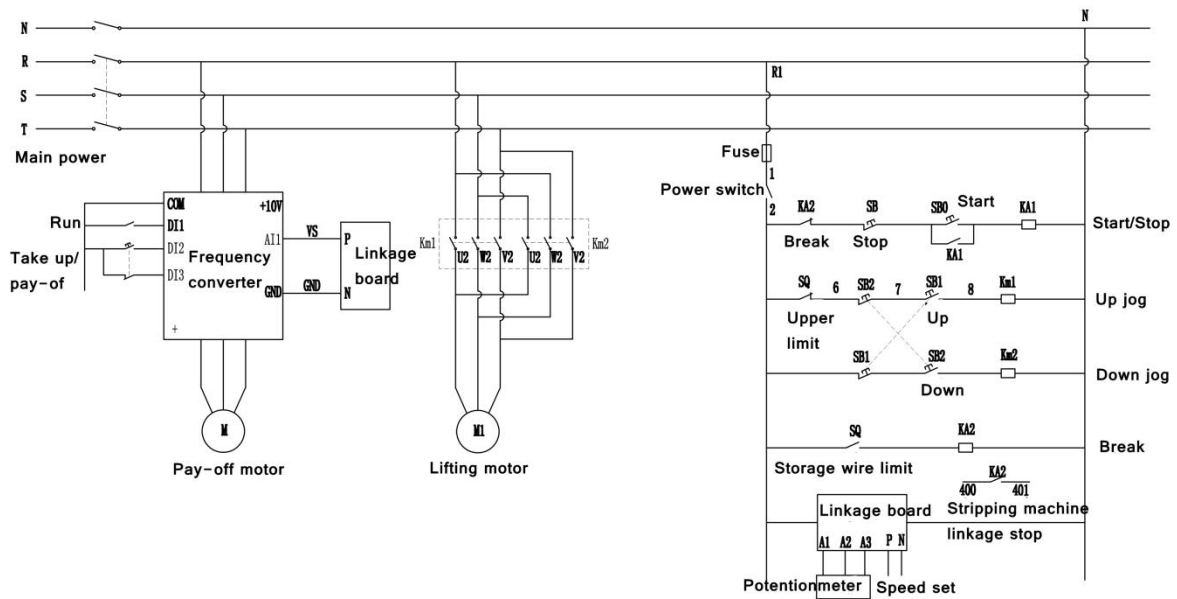
3. Ensure that the surrounding environment of the equipment is clean, free of dust, no corrosive chemicals, and no strong electromagnetic field interference. The working environment temperature is 10°C. Do not place it in extremely cold and extremely hot environments and keep well ventilated.

4. Lubricate and protect mechanical transmission parts regularly.

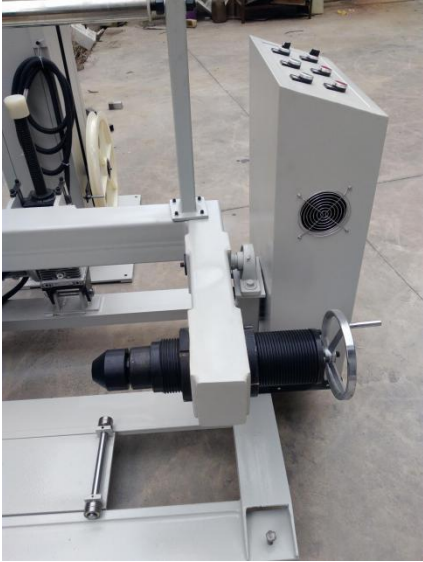
Button name



Electrical Drawing



Part of machine



Picture 1



Picture 2



Picture 3



Picture 4



Picture 5

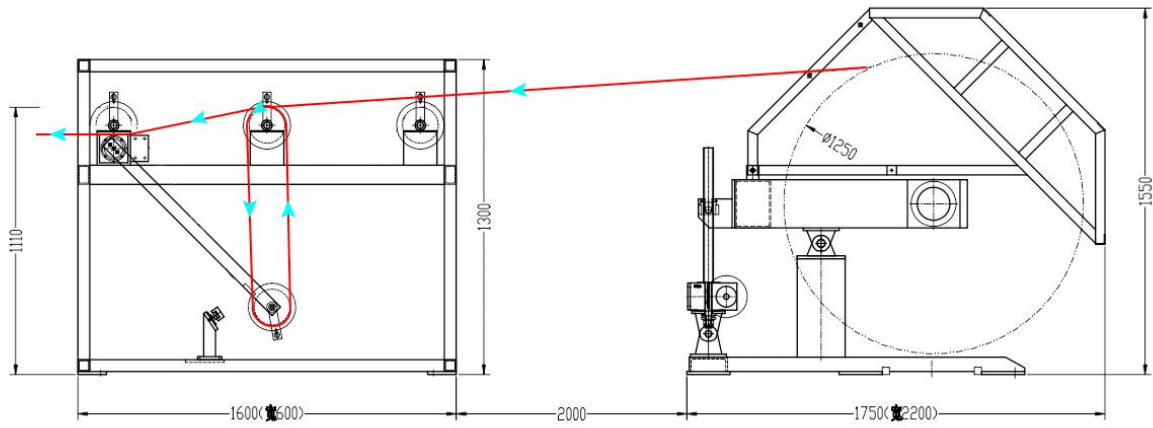


Picture 6

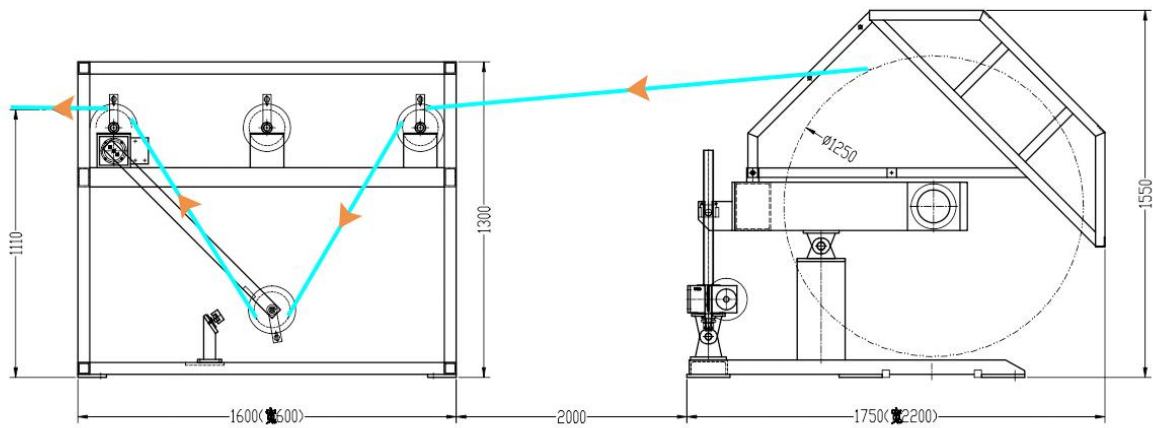
1	Wire tray clamping mechanism
2	Weight adjustment
3	Wire tray lifting mechanism
4	Electric box control panel
5	Spool loading and unloading skateboard
6	Main transmission part

Direction of feeding wire

Thin wire :



Thick wire :



Working Steps

1. Turn on the main power switch in the electric box
2. Turn the power switch clockwise to the on position (Picture 4)
3. Roll into the spool onto the skateboard, press and hold the down button to the proper position
4. When the spool shaft hole and the top head are in the same position, release the down button
5. Shake the handwheel by hand to clamp the spool (Picture 1), and pay attention to inserting the top pin into the spool
6. Long press the up button, the spool slowly lifts, until the spool rises and stops automatically.
7. Turn the retractable switch to the release position (Picture 4), release an appropriate amount of wires, release the retractable switch, thread the wire to the guide wheel of the swing arm tension frame, and connect it to the wire cutting machine
8. Press the start button, the automatic pay-off machine can work in conjunction with the cutting machine
9. According to different wire types, adjust the position of the weight block to adjust the tension of the wire (Picture 2)

Removal of the spool

1. Press the stop button, the pay-off machine stops working, turn the pay-off switch to the pay-up position, and put the wire on the spool (Picture 4)
2. Press the down button and slowly lower the wire reel to the ground. When the wire reel is lowered to the limit position, the lower limit switch of the wire reel will disconnect the power supply and stop the lifting motor (Picture 3)
3. Shake the handwheel to loosen the spool

Machine maintenance and maintenance

1. Before maintenance and repair, disconnect the power supply and clean the machine regularly
2. Add lubricating oil to the gear box and the screw regularly (Picture 3)

Wiring Instructions

① Try connect the power cord (3-phase 4-wire system, AC380V, 50Hz, fire wire R/S/T, neutral wire N, ground wire PE), turn on the power Switch, jog the up and down buttons to determine whether the action of the spool is correct, if the action is opposite, the lift limit sensor will lose its function, and the wire reel will not be able to limit the rise, which will easily cause a crash.

At this time, the fire wires of the power cord need to be interchanged, so that the up and down buttons of the wire reel are normally valid.

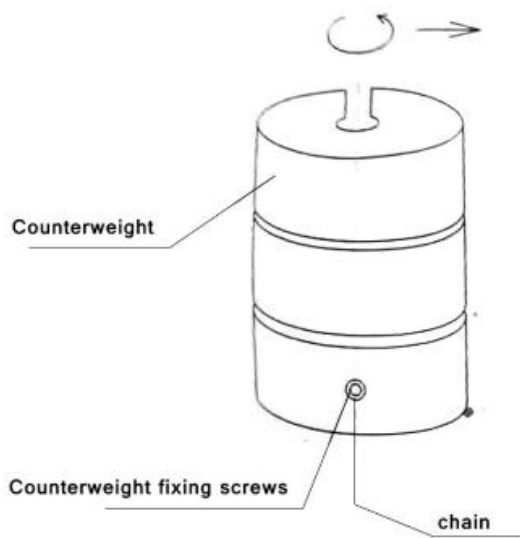
② The lead wires (5) of the tension frame are connected with the terminal row in the electric box according to the number, and the 400 and 401 interfaces are connected with the automatic machine, Linkage can be realized.

③ Press the start button, the button indicator light is on, and the pay-off machine enters the working state.

Note: The neutral line must be connected to the N port, and cannot be connected incorrectly, otherwise the linkage board will be burned.

Operate Instructions

1. Remove the counterweight on the chain and add it to the linear slider to increase the tension of the cable
2. Remove the counterweight on the linear slider and add it to the chain to reduce the tension of the cable
3. Rotate the counterweight on the chain 90°, and take out the counterweight to the right
4. Each piece of counterweight weighs about 2 kg
5. How to increase or decrease the counterweight depends on the test site conditions



The lifting screw should be greased regularly .