

(CE, ISO9001)

Coaxial Wire stripping machine

MODEL: EW-06F

User Manual





Security Notice

Thank you very much for purchasing Automatic Wire Cutting & Stripping Machine EW- Series. EASTONTECH is a famous high-tech enterprise which has been engaged in developing, manufacturing and marketing of wire harness processing equipment. Free maintenance during one year and lifetime free technical support!

1. Read this user manual carefully before using the machine, avoid any accident and prolong the service life of the machine.
2. Put the machine on the table which can bear the weight at least 60kgs. Check the feet of the machine are stable on the table and make sure it's working smoothly when working.
3. Check the power supply before starting machine (Power supply AC110/220V 60/50Hz). Power plug has to be connected to a grounded receptacle. Once breakdowns occurred, it can avoid electric shock injury to the operator and lower down the loss.
4. Setting correct parameters and testing the machine before production.
5. One-year warranty. (From the date stamped in the invoice) Please contact us directly if machine cannot work properly or any problems caused by quality or misoperation.

Important note: Add engine oil to the oiling hole on the top of the knife rack every day to make sure machine work properly and prolong product lifespan.

Main Structure of Wire Stripping Machine



1. **Stop button:** Press this button to stop all current operations of the wire stripping machine.
2. **Start button:** Start the wire stripping machine and let the equipment perform the wire stripping task according to the preset program.
3. **Touch screen:** Through the touch screen, the operator can intuitively set various parameters of the wire stripping machine, such as stripping length, stripping depth, etc. At the same time, the touch screen can also display the operating status of the equipment in real time, which is convenient for the operator to monitor the operation of the equipment and make timely adjustments.
4. **Protective cover:** The protective cover is installed at the key part of the wire stripping machine to prevent the operator from accidentally contacting the high-speed running parts when the equipment is running, effectively reducing the risk of injury to the operator and ensuring personal safety during the operation.
5. **Rotating mechanism:** This mechanism drives the cutter to rotate during the stripping process to achieve uniform stripping of the cable's outer insulation layer, ensure the consistency of the stripping effect, and improve the quality and efficiency of the stripping.
6. **Grabbing clamp:** The grabbing clamp is used to firmly fix the coaxial cable to be stripped, ensuring that the cable will not move during the stripping process, maintaining a stable processing position, and providing a guarantee for accurate stripping.

Technical Specification

Model	EW-06F	Display mode	Color touch screen
Appearance size	580X180X295	Opening method	Foot pedal/manual/rod
Working power supply	AC220V50H2	power	400W
Peeling length	0.1mm-48	Stripping diameter	Φ0.5mm-Φ8mm
Minimum stripping depth	0.01mm	Weight	22/25KGS
Maximum number of peeling layers	9 layer	Drive mode	Motor/ball screw drive
Centering piece	2piece	Blade	2piece
Working environment	0-50 degrees dryness is appropriate	Thread clamping device	Automatic centering, program control

Main screen

The screenshot shows the main control interface for a coaxial cable stripping machine. At the top, it displays 'Shutdown 88.88', 'Coaxial cable stripping machine', and 'A 19:09:50'. Below this are four large buttons: 'Start' (green), 'Stop' (red), 'Reset' (blue), and 'Count cleared' (grey). The main area contains several input fields and buttons: 'Program : ABCDEFGHIJK' (with '999' in a red box), 'layer : 9', 'Delay : 99.999', 'Total : 99999999', 'Output : 99999999', and a 'Clear' button. There are also 'Auto' and 'Push-on starter' buttons. At the bottom, there are four more buttons: 'Start screen', 'Parameter screen', 'Manual screen', and 'Program copy'.

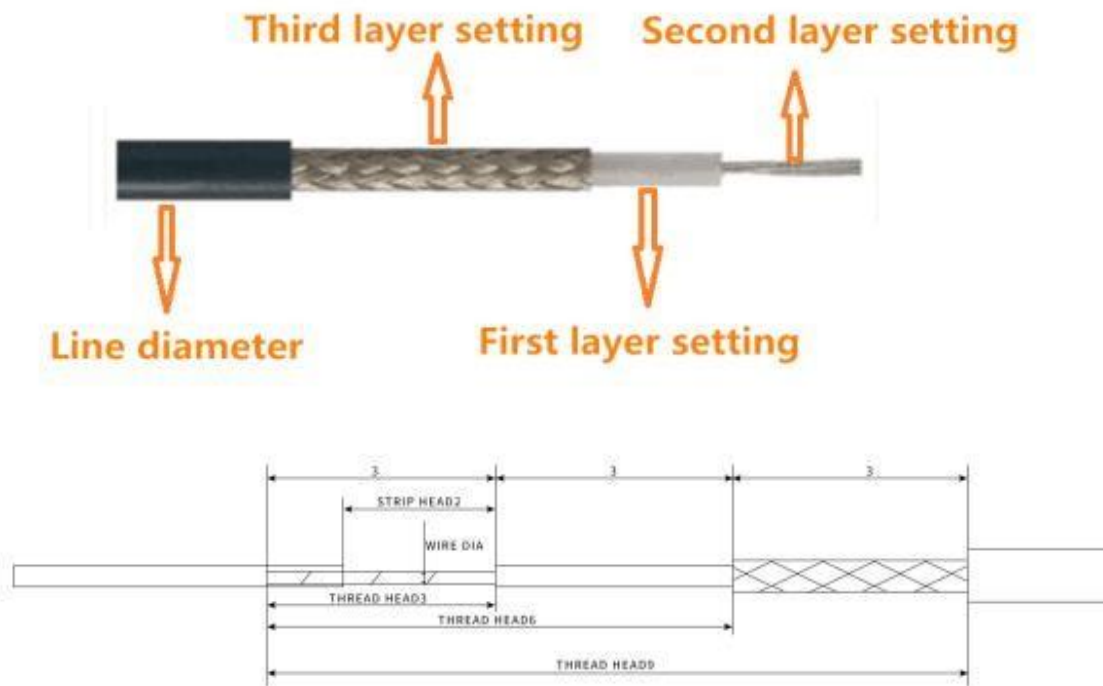
- 1) **Start**
- 2) **Stop**
- 3) **Reset**
- 4) **Count cleared**
- 5) **Program:** save data. Continuation: automatic running after 1 program completed without further setting. Eg. 1 means machine will stop for 1 second for another round of working.
- 6) **Layer:** When the number of stripping layers is set, it will automatically display the number of processed layers for easy identification.
- 7) **Total:** total needed production qty
- 8) **Output:** batch qty.
- 9) **Auto:** Shift from auto /manual mode.
- 10) **Push-on starter:** choose start mode, 0 = press touch screen start; 1= pedal start.
- 11) **Start screen:** Return to the screen when the power is turned on.
- 12) **Parameter screen:** setting parameter.
- 13) **Manual screen:** Each action can be observed by entering this screen, which is convenient for manual adjustment, knife change or card line usage.
- 14) **Program copy:** Copy the existing program data to another program: can copy 00-99

Parameter screen

Auto advance speed	▶ 9	Line diameter	▶ 9.99	Don't exchange
Auto feed speed	▶ 9	Open the clamp	▶ 9.99	
Auto clamp speed	▶ 9	Number of plies	▶ 9	quick-wear part
Auto peel speed	▶ 9	Closed knife delay	▶ 9.999	Main screen
Pull wire skin speed	▶ 9	Shake switch	Close	Detailed setting
Rotary cutter speed	▶ 999	Blowing switch	Close	
Assing time	▶ 9.999			

- 1) **Auto advance speed:** control blades moving forward speed, the larger of the number is , the faster it works.
- 2) **Auto feed speed:** (0-9) the speed of the knife holder when cutting off the wire or cutting the wire jacket. The thicker the wire, the slower speed should be, otherwise the tool will be damaged.
- 3) **Auto clamp speed:** (0-9) the speed of clamp when clamping the wire ; The thicker the wire, the slower speed should be, otherwise the clamping will hit to eccentric.
- 4) **Auto peel speed :**(0-9) the speed of blade when cutting off the wire and pull the jacket ; the greater the data, the faster the speed; the wire thicker, tighter, and longer strip, the slower the stripping speed, otherwise peeling will occur. And seriously damage the tool.
- 5) **Pull wire skin speed:** (0-9) the speed of cutter head when rotates.
- 6) **Rotary cutter speed:** control blades head rotary speed,the larger of the number is , the faster it rotates. Normally set it 45-55.
- 7) **Assing time:** the time for blowing air to the blades. The larger of the number is , the longer it blow air.
- 8) **Line diameter:** It is the outer diameter of the wire, if the OD is 5mm, we set it 4.5mm.
- 9) **Open the clamp:** (0-12.2) the distance between clips, normally set it the max. 12.2.
- 10) **Number of piles:** number of stripping layers, max 9. **Closed knife delay:** delay the time for the blades closing to protect the blades.
- 11) **Shake switch:** the blade reverses a few revolutions after peeling off each layer of skin to shake off the waste.
- 12) **Blowing switch:** the switch for blowing.
- 13) **Closed knife delay:** delay the time for the blades closing to protect the blades.
- 14) **Shake switch:** the blade reverses a few revolutions after peeling off each layer of skin to shake off the waste.
- 15) **Blowing switch:** the switch for blowing.

Wire stripping parameter setting and debugging



Name Layer	Thread head	Strip head	Wire dia.	Retract	Cutting time	Rotary strip
First Layer	6	7	0.6	0.1	0.2	0
Sec. layer	3	2	0.3	0.1	0.2	0
Third layer	9	10	0.9	0.1	0.2	0

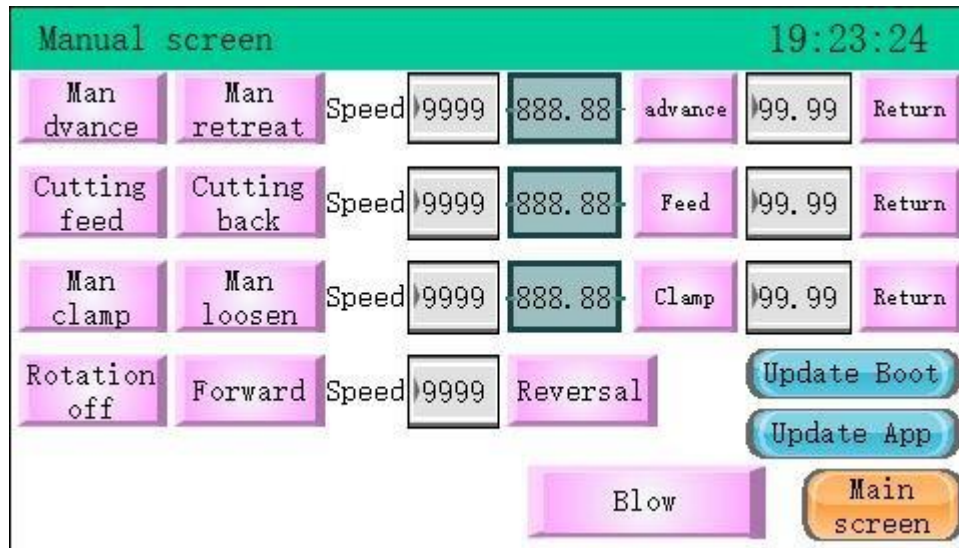
- As shown in the figure above, first set the first layer "thread head" setting 6, the second layer "thread head" setting 3, and the third layer "thread head" setting 9, then the machine automatically runs the path: 6,3, 9. Finally back to the beginning of the head stripping. You can also set the first layer "thread head" setting 3, the second layer "thread head" setting 6, and the third layer "thread head" setting 9, then the machine automatically runs the path: 3, 6, 9 and finally Back to the beginning of the stripping. You can also set the first layer "thread head" to 9 and the second layer "thread head" to 3. The third layer "thread head" is set to 6, then the automatic path of the machine is: 9,3,6 and finally back to the starting point of stripping.
- If there are 9 layers of wires, you need to set the required parameters in 9 setting screens. After setting, return to the main screen and press reset to start.

Detailed Setting

This page is to set each layer stripping parameters. The layer function is boosted from the main page NO. 10 (Number of piles) . The sequence that blades work is according to : first-second-third- forth...-Ninth. (Please noted that this does not necessarily go with from cable Jacket layer to inner core layer sequence. Generally we set the first layer stripping according to the diameter with shielding.

The screenshot shows a control panel for 'First layer settings'. At the top, the title 'First layer settings' is on the left and the time '19:40:33' is on the right. Below the title bar, there are several adjustable parameters, each with a numeric input field and a unit: 'Wire head' (99.99 mm), 'Wire diameter' (9.99 mm), 'Stripping length' (99.99 mm), 'Knife return' (9.99 mm), and 'Cutting time' (9.999 s). There are also three buttons: 'Main screen' (orange), 'Parameter screen' (green), and 'Next layer' (purple). A 'Close' button is next to the 'Rotary stripping' label. The 'Rotation direction' is set to 'Forward'.

1. **Wire head:** the length of the first wire segment to be stripped
2. **Stripping length:** wire insulation length that the blades strip off; half stripping, stripping length < wire head
3. **Cutting length:** Blades rotary cutting time. The larger number it sets, the longer it rotates.
4. **Rotary direction:** Blades head rotary direction, 0=clockwise , 1=counter-clockwise
5. **Wire Diameter:** The depth that the blades cut into the wire. The smaller of the number is, the deeper it cuts.
6. **Knife Return:** After cutting and pulling off the wire insulation, the blades will open up as to protect the blades.
7. **Rotary Stripping:** For special wires.
8. Total 9 layers of setting same as above for each layer.



Manual Screen :

Video reference : <https://youtu.be/sQLKfCBOJ44>

How to change blades and blades protectors

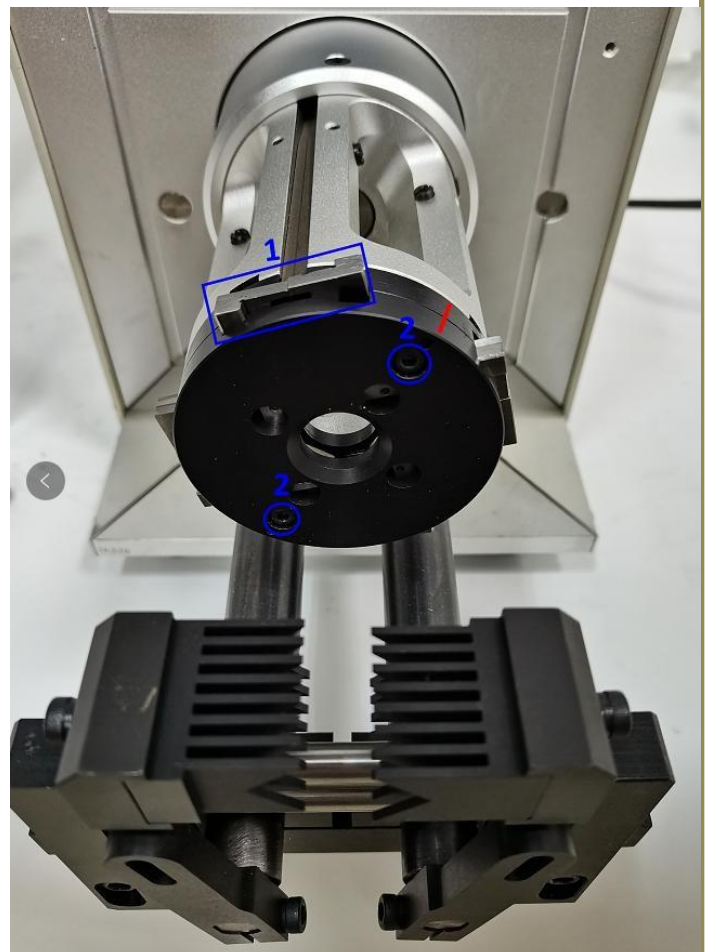
Step 1 Cutting back -- to open blades backwards as Pos.1.

Step 2 Man retreat-- to retreat blades lead screw backwards to leave enough space to unload the blades assembly.

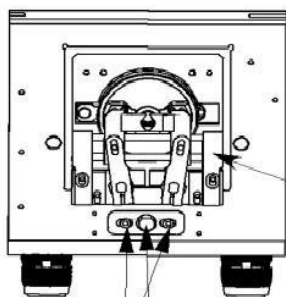
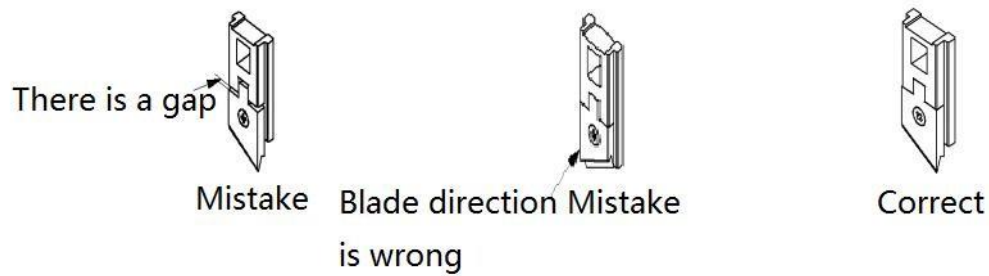
Step 3 Marking ---Make a marking in screw area like the red line to make sure correctly loading the blades assembly back after changing blades.

Step 4 Open and change ---Loosen the two screws marked in Pos. 2 to change the blades.(first half plate is for blades protectors; second plate half is for blades.

Step 5 Assembly blades back -- Match the marked line area back in Pos.2 and assembly back. (may need to close blades gradually by Cutting feed.)



How to replace the blade and debug common problems



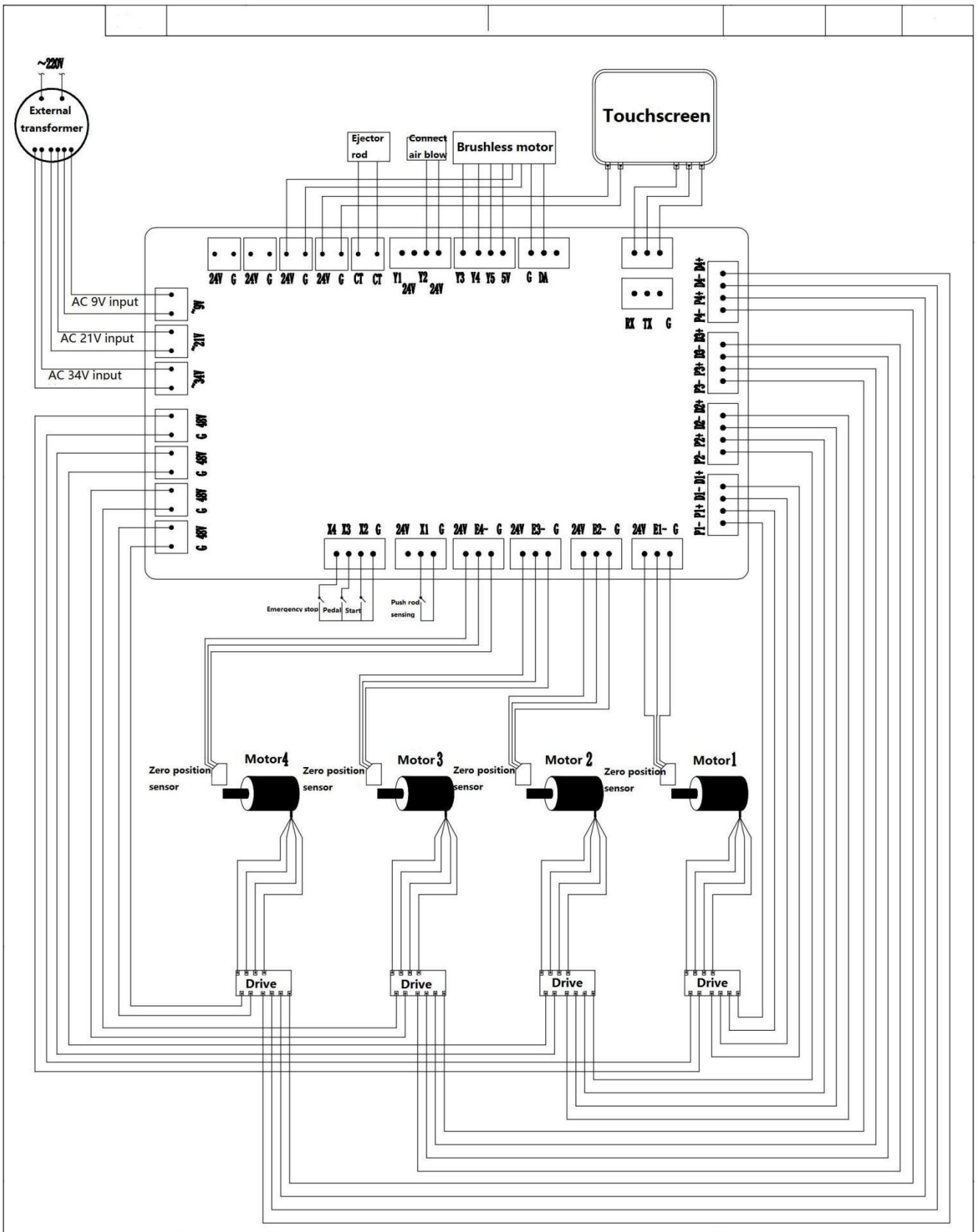
(Gripper center adjustment lever)
Finely adjust here to the left, and the gripper moves to the right.
Finely adjust here to the right, and the gripper moves to the left.

Tool change: Click the manual forward and reverse speed (3000) in the previous picture "Screen 6". When we change the blade, we need to use manual forward or reverse, move the cutter head to the appropriate position and then click manual retraction, and retract it as far as possible, which is convenient for changing the blade; when installing, install the blade and positioning piece on the knife slide, install it into the slide seat, and install the slide seat back to

the cutter head. Note: Install the blade in the correct direction as shown in the above picture: the blade is inside, the positioning piece is outside, use manual advance or retraction to adjust the knife, and the knife slide should be flexible in the tool holder.

Correction jaws: In the "manual screen" above, manually move forward, manually move backward, and manually clamp, and manually loosen to set a parameter (1000-5000), and loosen to the appropriate position according to the forward, backward, and clamping. Install the correction rod (pen refill) on the jaws, and then let the cutter head move to the position close to the tip of the correction rod. If it is eccentric up or down, loosen the jaw seat to move up and down, move the jaw seat so that the tip of the correction rod and the center of the cutter head are aligned, and lock the jaw seat screw; if it is eccentric to the left or right, loosen the jaw center adjustment rod screw to adjust, the center adjustment rod shifts to the left or right, the center adjustment rod shifts to the left, and the jaw shifts to the right, until it is adjusted. Note that it is only suitable for a small amount of eccentric.

Electrical diagram



						Date 2017/08/29	Proportion 1:1.5
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Semi-automatic wire stripping machine wiring diagram

Maintenance

1. Maintenance video: https://youtu.be/ewd0_GdvXGE

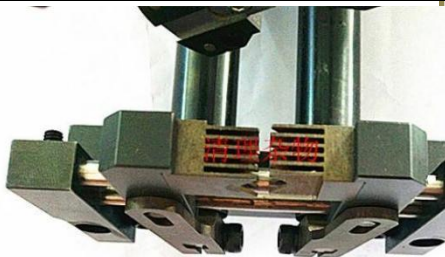
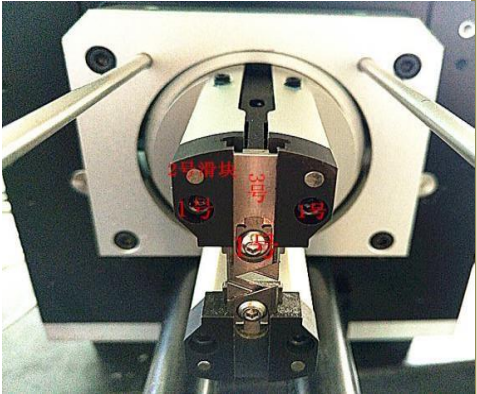
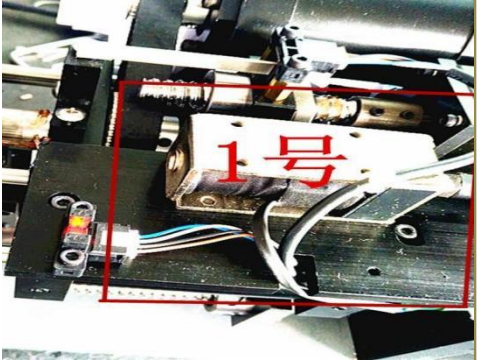
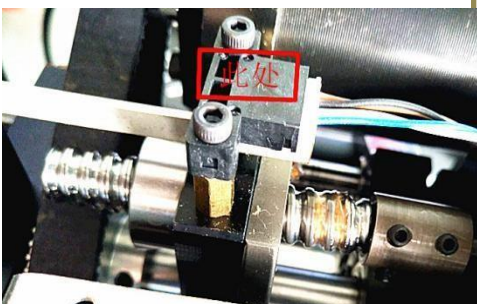
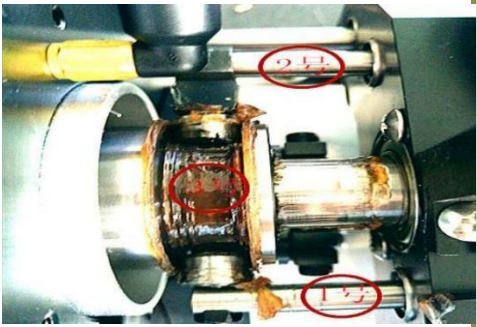
- a. Daily cleaning the cable wastes around the blades
- b. Add grease oil periodically such as SKF brand in attachment.



Points of Attention

- 1) **Power:** AC220, 50~60HZ. (110V for North America regions) Please use stable power source.
- 2) **Working environment:** Place the machine in a workshop with room temperature 0-45°C and good air flow, free from powder pressure, corrosion, chemicals, strong electromagnetic field.
- 3) Don't share same power with machines of heat electromagnet.
- 4) Before working, please lubricate the blades movement parts. When temperature goes lower, please use anti-freeze oil.

EW-06F Maintenance

1	Clamp cleaning	After each use, the operator should use a small brush or air gun to clean the debris on the jaws, otherwise the jaws will be eccentric.	
2	Cleaning the Slider Blades	First, remove the No. 1 screw; remove the slider seat; remove the slider and the auxiliary blade; ④ Use an air gun to clean up the debris and then reinstall it. It must be installed in place, otherwise it will be difficult to strip the wire.	
3	Whole machine cleaning	First open the case cover to check if there are any wires or dust. If there are any, clean them up immediately. Do not knock off the connecting wires of the machine. It is best to clean them once a month.	
4	Sensor cleaning	Pay attention to check each sensor of the machine. If there is flying dust, it must be cleaned up, otherwise it cannot be reset and affects the stability of the machine. Clean it once a month.	
5	Clean the inside of the machine and fill it with oil	After cleaning, please add appropriate lubricating oil once a month.	

FAQ

1. The ejector does not move: the "ejector mode" is not selected as the starting method or is not sensed.
2. The mesh layer cannot be cut cleanly: there is a gap in the blade and the blade needs to be replaced;
3. the clamping claw or the cutter head is eccentric.
4. The display system is not reset: the parameters are not set, causing damage to the flying dust sensor.
5. The thread end is of different lengths: When starting with the ejector pin, if the operator uses the ejector pin with different strength, its length will be different, causing the thread to be of different lengths.
6. The thread cannot be clamped tightly: Check whether there is rubber in the clamp, and if so, clean it.
7. Continuous startup: Check the linkage to see if there is input data.
8. Note: There are slight differences between the actual machine and the structure diagram in this manual. If there are any unexpected situations, please notify our company separat.



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.