EW-20S-3 Measure Length Wind Machine

User Manual

I. Overview

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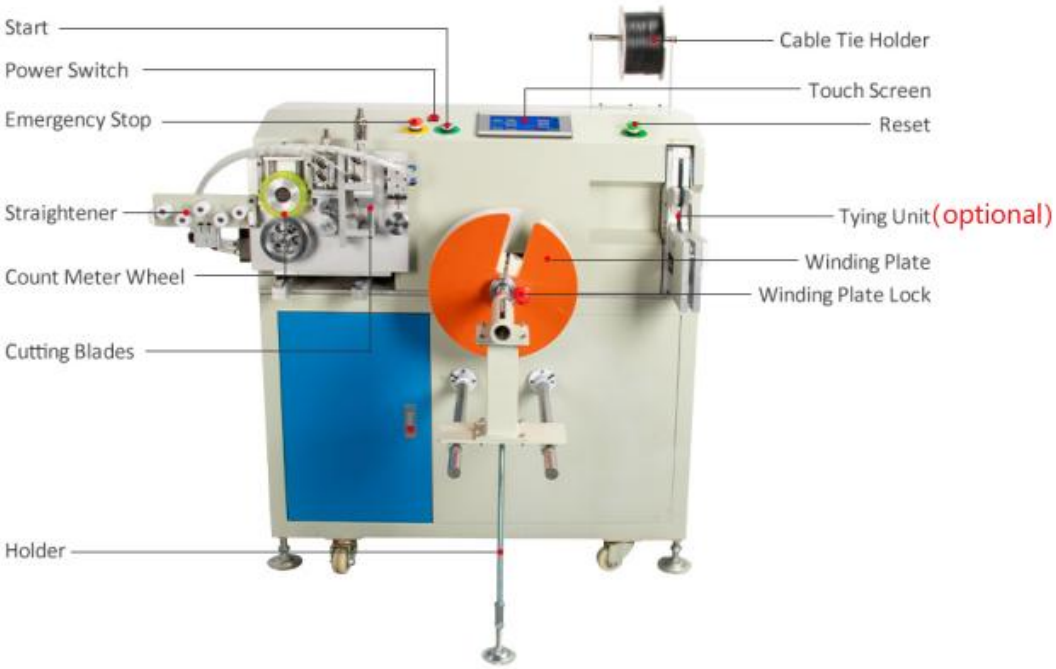
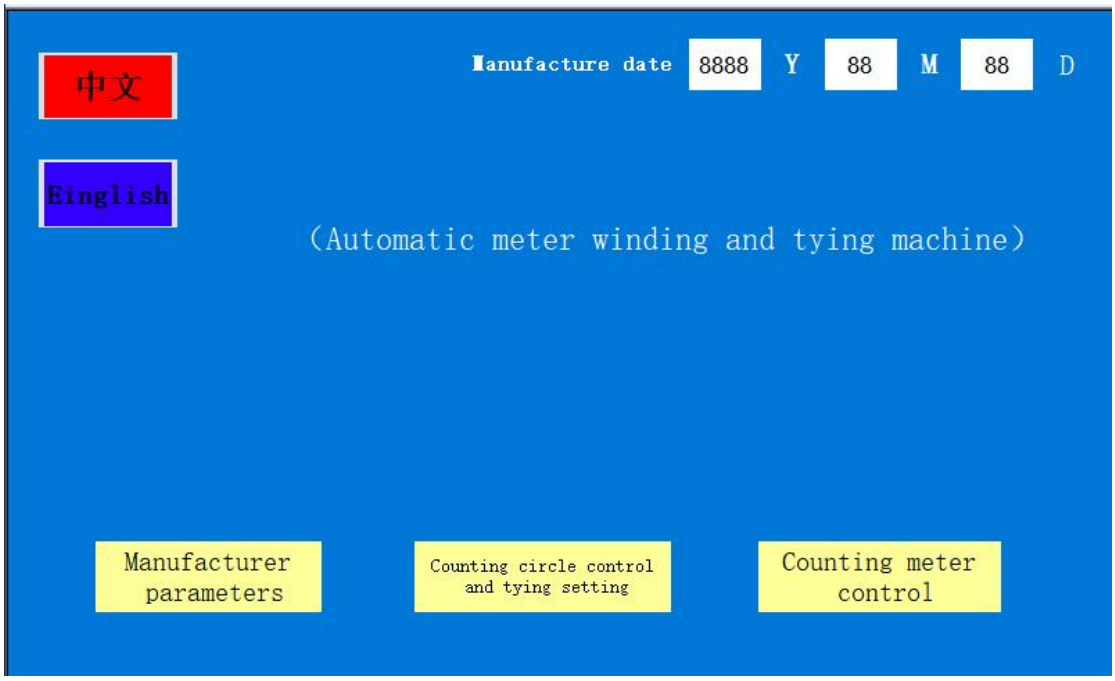


II. Home Page



[中文] press to change language to Chinese

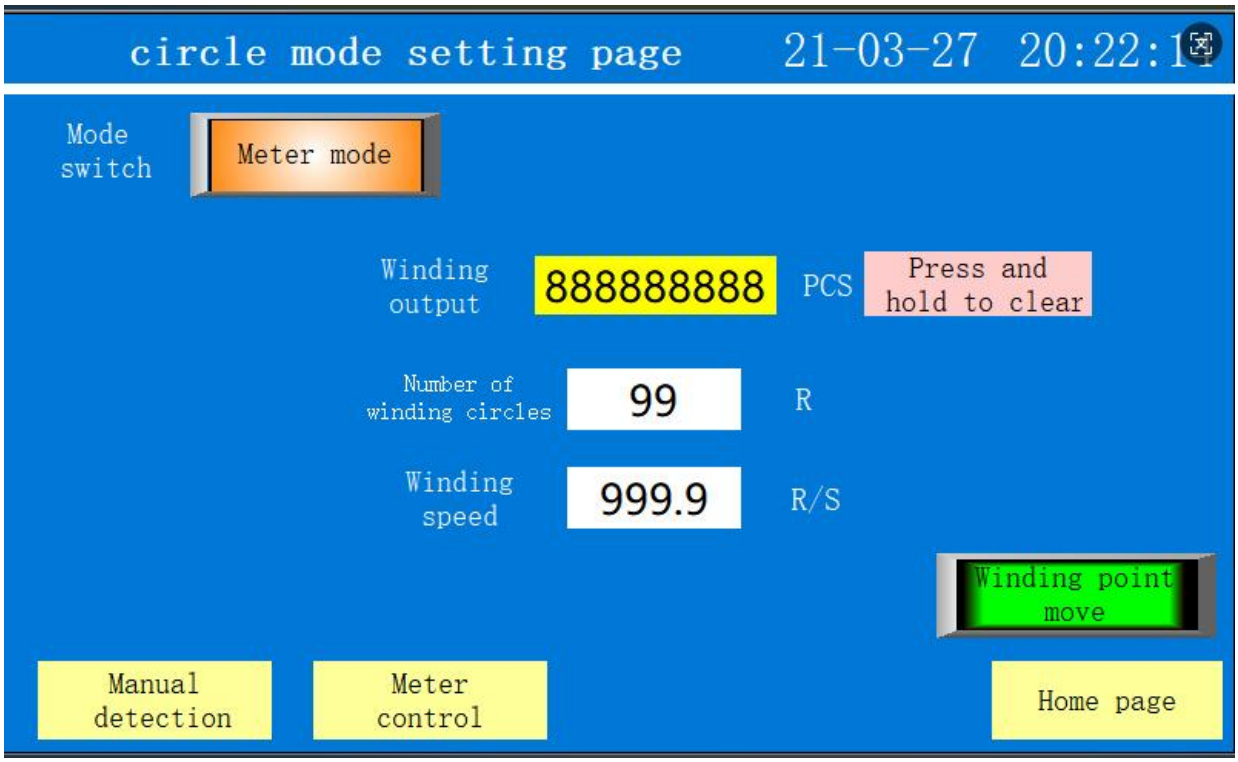
[English] press to change language to English

[Manufacturer parameter] system default data, please do not enter this page unless it is advised with password

[Counting circle control and tying setting] press to enter <u>coil mode (without length measure) page</u>

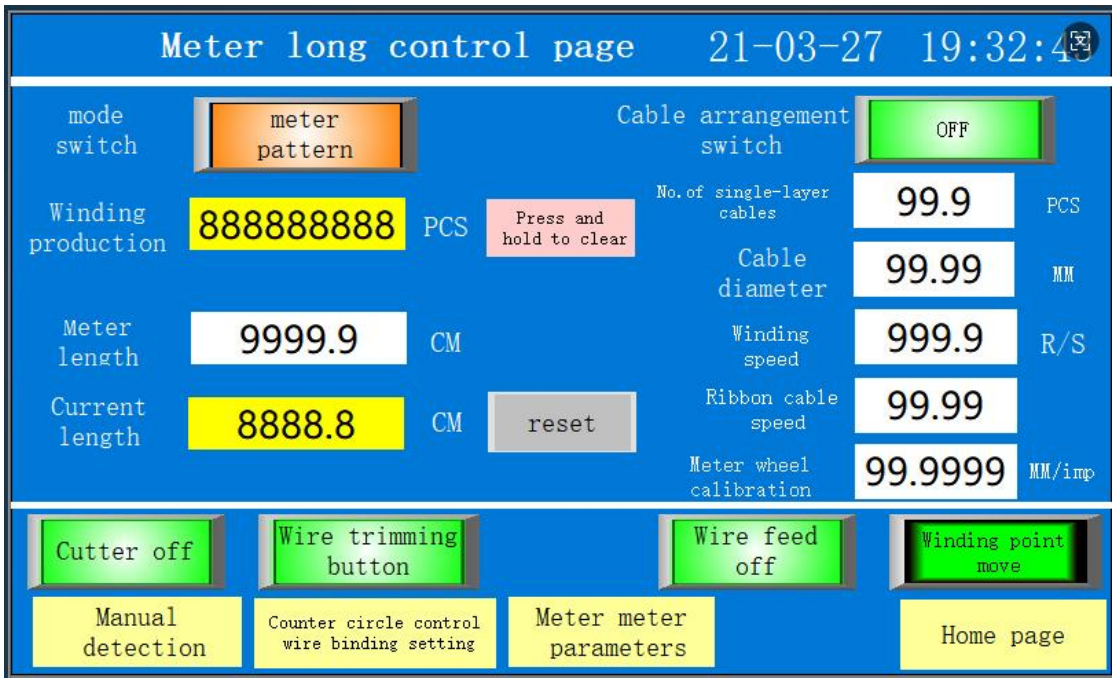
[Counting meter control] press to enter <u>coil + length measure mode page</u>

III. **Coil Mode Page**



Mode switch: meter mode switch
Winding otuput
Number of winding circles
Winding speed

IV. Coil + Length-measure Mode Page



[set the meter turn/stop] press and hold to change between coiling mode and coil+length-measure mode

[winding production : pcs] current finished coil quantity

[press and hold to clear] clear the value in [Coil qty: pcs]

[Measure length] set the winding length

[Current length] current winding length

[wire terimming button] Wire cutting button, manually cut the wire.

[Cutter on/off] turn on/off the blades cut function

[cable arrangement switch] turn on/off the row arrange function

[numner of single cable layers] set the row number on winding plate in accordance with plate width and cable dia.

[Cable diameter] set cable dia.

[winding speed] set winding speed

[ribbbon cable speed] the rotation speed of the arrangement motor. (factory value 1.2-1.3) can be increased or decreased according to actual needs. Two decimal places for fine adjustment.

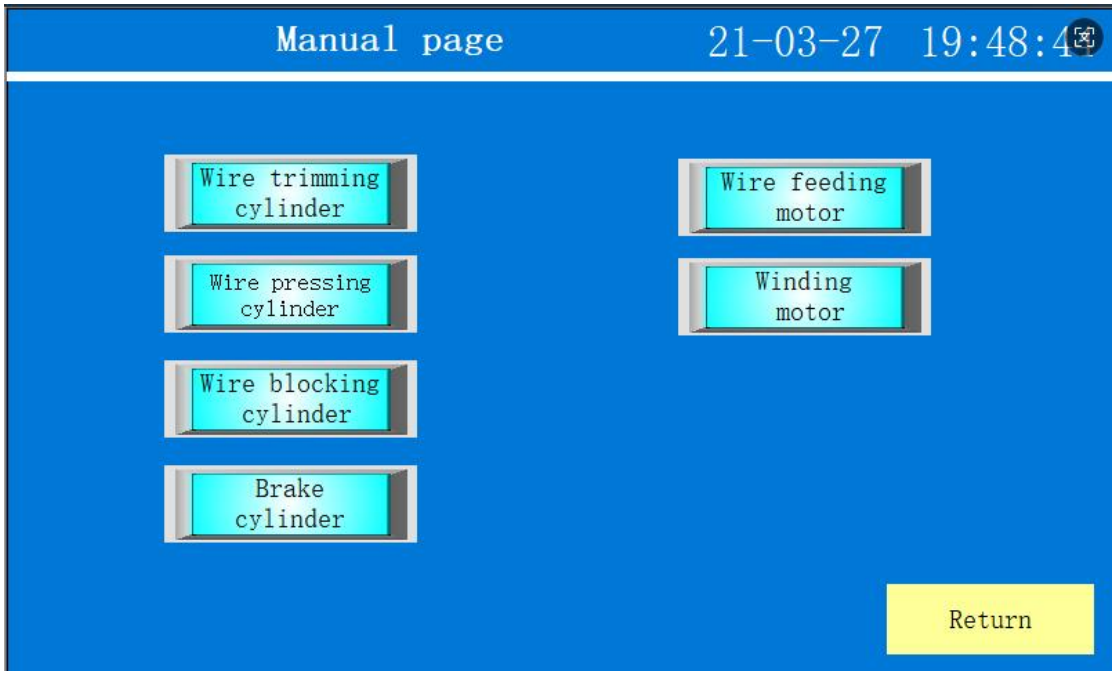
[Meter wheel calibration] That is, the length of one pulse of the meter counter. The meter error is modified (fine-tuned) here. The decimal point is fine-tuned to two places.

[Wire feed on/off] turn on/off the wire feed function (a certain length will be fed from length counter after single cycle work)

[winding point move] press to enter coil inch mode page

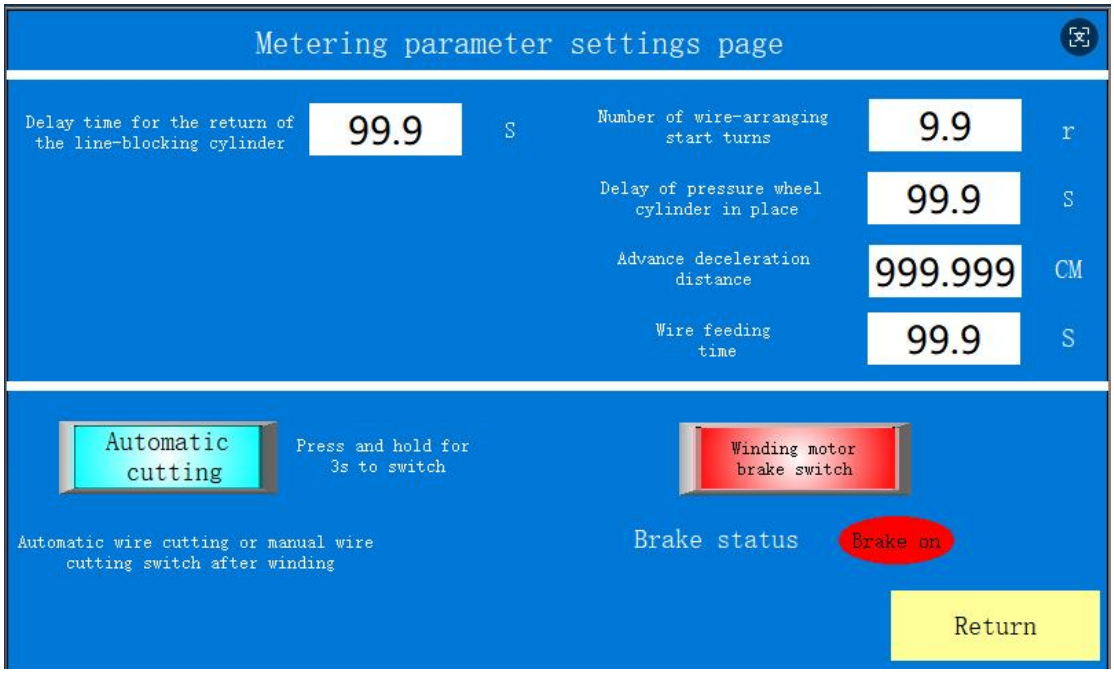
[Home page] press to enter home page

V. Manual Page



Manually test each motor

VI. **Length Measure Parameter Page**



[Delsy tine for the return ofthe line blocking cylinder] N/A

[number of wire-arranging start turn] set the wind time before machine start to arrange row

[delay of pressure wheel cylinder in place] set the brake time to reduce wind speed when coil is close to target length

[Advance deceleration distance] roller press time for blades cutting action after machine stop winding

[Wire feeding time] set the wire feed time after single cycle work is completed (set value larger to feed longer length wire to reach the winding plate)

TIPS:

Operation process:
Put the wire through the blade →
reset the length on the screen →
press the reset button →
the wire is automatically fed out a section. Hang the wire on the winding drum manually and pull the wire back and forth a little to make the wire close to the disc →
press the start button →
the machine starts to automatically count the meters and wind the wire →
stop cutting after reaching the meter limit and automatically feed a certain length of wire →
manually take the wire and tie it →
press the reset button to automatically reset the winding drum →
manually hang and pull it tight to the edge →
press start to start winding·····and so on.