



**GREWIN INDUSTRIAL GROUP CO.,LTD.**

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**NAME: GW-729 Enamelled wire stripper Cutting Machine**



**SPECIFICATION**

Product name	Enamelled wire stripper Cutting Machine	Cutting toleranxe	(0.2±0.002*L)mm
Size	W430*D450*H250mm	Transmission wheel	High quality rubber wheel
Power supply	AC220V(or 110V)	Cutter	White steel
Power	200-350w	Type of thread trimming	Enamelled yarn enamelling bar copper wire
Peeling length	1-60mm	Thread cutting length	10m long
Stripping ability	L=80mm,over 2000PCS/hour		

**Paint scraper user guide**

Program 00-99 are the same function, each serial number program can maintain a processing parameter, parameter changes do not need to keep, directly press the run, do not press the exit key, the whole use is not prompted to press the exit key never press.

Press the up or down selection key to select each parameter, keep pressing the number 0 to clear the current parameter, and then press the number on the keyboard to enter the parameter.

Each program has corresponding F1 parameters, modified according to processing requirements, F1 parameters are not common to each program, each modification is only relative to the current program.

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### **Key surface introduction**

F1: paint scraping parameter Settings

Paint scraper distance 1:192

Refers to the distance between the cutting edge and the three paint scrapers. If the front painting position is longer, the value is increased, and if it is shorter, the value is reduced.

Startup delay: 0.7 seconds

Refers to the time when the paint scraper starts from low speed to the highest speed, if the time is too long, the fine copper wire may be scratched at the starting position. If the time is too short, it may not be clean to scrape the past, observe the scraping effect change.

Stop delay: 0.7 seconds

Refers to the stop time of the paint scraper from high speed to low speed, and observes the change of the paint scraping effect with the wire feeding speed.

### **Program display interface**

Program: The serial number of processing Settings, from 00 can be set to 99, each set a specification after the program will automatically save, do not need to press any key to save.

**Speed:** 00-09,00 slowest, 09 fastest.

**Wire end:** the distance from the front of the copper wire.

**End of wire:** the distance behind the copper wire.

**Wire length:** the total length of the processed copper wire, including both ends.

**Cutting speed:** the upper and lower speed of the cutting tool, the larger the diameter of the copper wire, the slower the speed, the smaller the diameter of the copper wire, the speed can be accelerated.

**Output:** Production counter, modifiable.

**Wire feed speed:** the speed of the copper wire forward when the paint is not shaved, speed 00-09 can be selected, if the copper wire behind is relatively heavy or curved, then slow down accordingly.

Paint scraping speed: the speed of the copper wire moving forward when painting, under normal circumstances, the value is 00, so the paint scraping effect is relatively stable, and the copper wire can be easily scraped to speed up the speed.

### **Gap adjustment**

Adjusting the knob can make the conveying wheel press or relax the copper wire, press the copper wire after the hand with a little force can not move, you can also observe whether the total length of the processed copper wire is consistent, inconsistent, there may be no compression, if the length is consistent, the looser the better, the wheel wear reduction.

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### **Dial speed knob**

This knob is to adjust the rotating speed of the paint scraper, the finer the copper wire, the slower the speed, as long as the effect can be scraped, the slower the better, otherwise it is easy to pull the copper wire. Thicker copper wire increases speed, and the knob can be rotated multiple times.

### **Preparation before starting**

1. Install the straightener and adjust the center of the roller.
2. Put the copper wire to be processed through the straightener roller, and then pass the paint scraper device through the rubber wheel to the knife edge, and observe whether the copper wire is in a straight line, if not the position can be corrected.
3. Adjust the gap adjustment, so that the four yellow rubber wheels press the copper wire, and the four rubber wheels of the 1mm copper wire just touch. As long as the total length is the same, there is no need to press harder.
4. Set the processing parameters, adjust the speed knob appropriately, and press the run key to test the line. If the scraping position is inconsistent, the scraper distance in F1 can be changed. The tightness of the conveyor wheel or straightener may lead to the deviation of the scraping position.

### **Internal parameter setting**

#### **1. Step parameter modification:**

Hold down the exit and Stop keys at the same time, and then put the exit and then put the stop to appear another screen. Step parameter: The larger the value, the shorter the wire comes out, and the smaller the value, the longer the wire. Press the Stop key to save the parameters.

#### **2. Adjust the depth of the cutting tool:**

- 1, hold down the 'exit' and '8' keys at the same time, and then release the 'exit' first, and then release the '8', another interface appears.
- 2, at this time directly press the keyboard number to enter the password :53838345, and an interface appears.
- 3.there is a 'knife step', change the 'knife step' value can be, the larger the value, the deeper the knife cut, the smaller the value, the shallower the knife cut, it is best to change 10~20 numbers each time, press the stop key after the change!

#### **3.Program initialization**

Hold down the Exit and 0 keys at the same time, then play exit and then play 0, wait a few seconds, the program will be restored to the factory value.

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**FACTORY:**

We-GREWIN INDUSTRIAL GROUP is expert in winding machines lines for 28Years. Our Grewin have ISO9001:2015,CE approvals,Machines'Patents,"high-tech enterprises"by the government.



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