

Meet the Needs of the SMT Age

Please read this user manual carefully before running



S-HY210 Auto wire stripping machine



USER MANUAL



Catalog

1. Operation instructions;
2. Wire cutting paradigm

The system Chinese English swap (Turn off the power ,also press the

key  + , then open the power supply)

1. Operation instructions

Control panel



The operation of this system interface consists of a liquid crystal display of 23 buttons and a 192x64 dot matrix composition, each of the following key functions will be introduced:



In the standby mode, each short press once, machine execution step, cyclic; continuous press more than about 0.5 seconds, the machine will automatically run a cycle; the role of the buttons on the transfer machine is very big;



In the standby mode, press this button, the machine starts to work;



In the working status, press this button, the machine will complete the work after shutdown;

In the standby mode, press this button, the machine will perform a reset action; in the working status, press this button, the machine to stop, and then perform a reset action;



In data input state press this button, enter the numbers 0; press this key in the standby mode, the machine will enter the stripping parameter setup state;



In data input state press this button, enter the numbers 1; press this key in the standby mode, the machine will enter the stripping speed setting state;



In data input state press this button, enter the numbers 2; press this key in the standby mode, the machine will enter the twisting line parameter setup state;



In data input state press this button, enter the numbers 3; press this key in the standby mode, the machine will be based on the current functionality into the corresponding function setting screen;



In data input state press this button, enter the numbers 4; press this key in the standby mode, the total amount of Qing 0;



In data input state press this button, enter the numbers 5; press this key in the standby mode, the count of 0;



In data input state press this button, enter the numbers 6; press this button in standby mode, forward switch machine working mode;



:

In data input state press this button, enter the numbers 7; press this button in standby mode, backward switching machine working mode;



:

In data input state press this button, enter the numbers 8; press this key in the standby state, the machine will enter production set status;



:

In data input state press this button, enter the numbers 9; press this key in the standby state, the machine will enter the function setting screen;



:

In data input state press this button, eliminate the input data; in the standby mode short press this button, the total output and the number of all the clear 0; in the standby mode long press the button for 5 seconds, so stripping data restore to factory condition



:
pressing the key in the parameter setting ,per set parameters state data add 1;
press this button in the non parameter setting state, knife value add 1;



:
pressing the key in the parameter setting ,per set parameters state data
reduction 1; press this button in the non parameter setting state, knife
value reduction 1;



:
press this key in the parameter setting state, the current modified data give
up on a data into an object modified; press this button in the non
parameter setting state, retracting minus 1 or manual feed line (can set);



:
press this key in the parameter setting state, the current modified data to give
up, the next data into an object modified; press this button in the non
parameter setting state, retracting plus 1 or manual back line (set);



:

press this key in the parameter setting state, the modified data is saved and written to the EEPROM, and will be the next data into an object modified;



:

press this key in the parameter setting state, exit the parameter setup state; screen, arranged in the function of multi segment peeling setting screen, system settings screen. Press this key, return to the job picture;

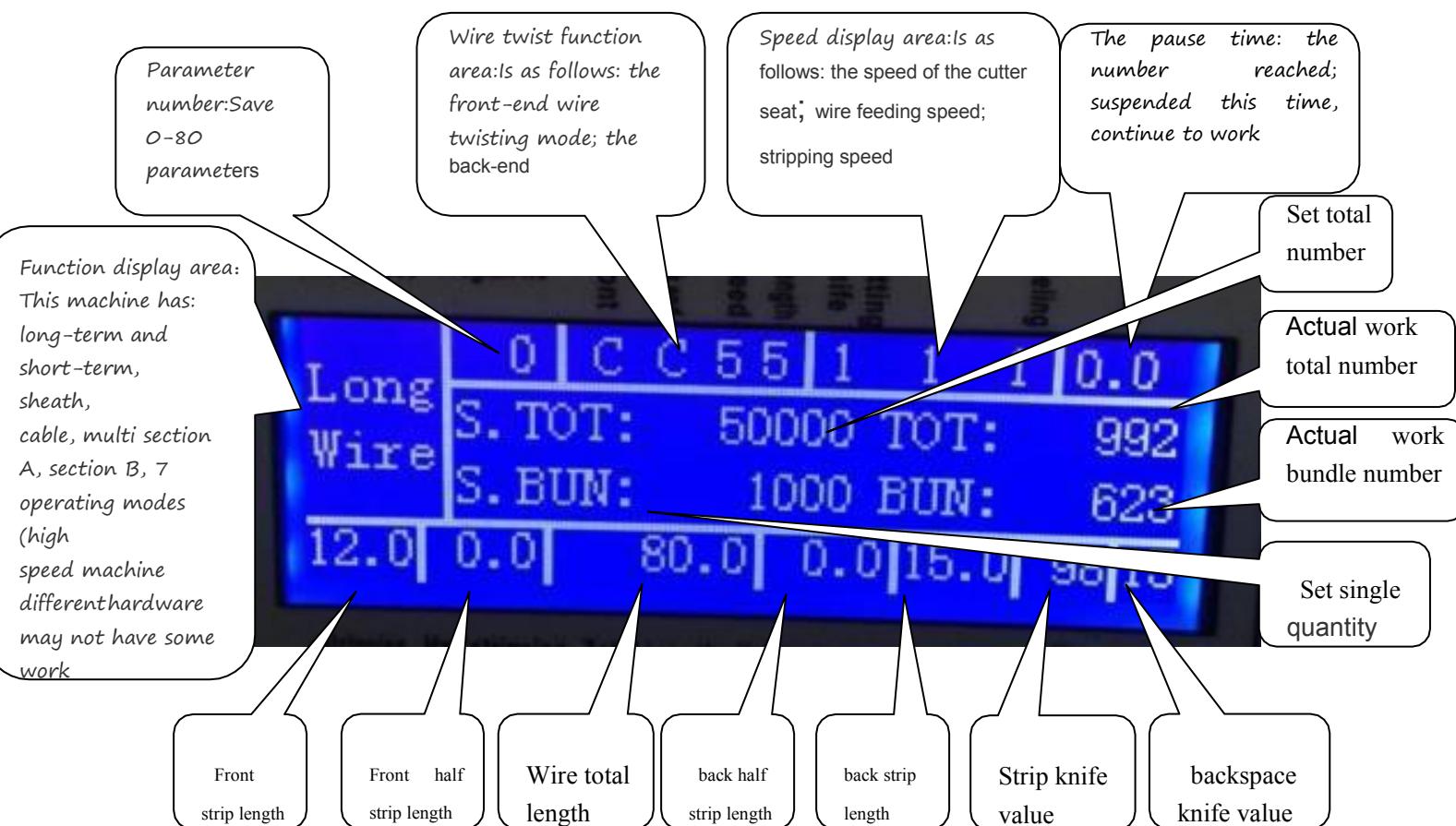




:

In the standby screen, press the button, enter the system setup screen, before entering, need to enter the password; in function settings screen, multi segment peeling setting screen, system settings and so on the screen, press the button, enter the parameter setup state;

Work screen::

After power on, the screen display the boot screen, about three seconds after the screen will display; the machine running, the screen must be the picture on; otherwise, the machine can not start;




Wire stripping machine parameter settings: standby (not cut line), press the button; the front length parameter start flashing, then you can directly enter numbers, if the input error, can press  key to remove the input digital after re input; then press  button to save, and parameters of a flicker, until the front end, front length half stripping, total length, rear half stripping, rear end length, knife, knife back to complete all input values; Parameter setting; press will flicker parameters forward a; press the key will flicker parameters after the shift a; can be set according to exit the parameter at any time, to return to the standby state;

Stripping speed settings: machine standby (not cut line), press the



button; the cutter speed parameter start flashing, then



you can directly enter numbers, if the input error,  can press the key to remove the input digital after re input; then press the button to save, and parameters of a flicker, until the cutter speed and the wire feeding speed, stripping speed and pause time of all input complete;

Parameter setting; press will flicker parameters forward a; press the key will flicker parameters after the shift a; can be set according to exit the parameter at any time, to return to the standby state;

Output settings: machine standby (not cut line), press the



button to set the parameters; total began to flicker,



then you can directly enter numbers, if the input error, can press the key to remove the input digital after re input; then press the button to save, and parameters of a scintillation, until the set, the total the number of all input complete;

Parameter setting; press button will flash forward a parameter; press



the will flicker parameters after the shift a; can be set according to exit the parameter at any time, to return to the standby state;

Wire twisting machine settings: standby (not cut line), press the



button; scintillation front-end wire twisting mode, press





and then press the






button to save, and parameters of a scintillation,



until the front twisting line mode, the back-end twisting line mode input is completed, according to the previous method input twisting line speed,

twisting line strength; parameter setting;  button will flash forward a

parameter; press  key will flicker parameters after the shift a; can be set according to exit the parameter at any time, to return to the standby state;

Program number set: machine standby (not cut line), press  key parameter; program began to flicker, then you can directly enter numbers, if the input error, can

press  key to remove the input digital after re input; then press the  button to save, to return to the standby state;

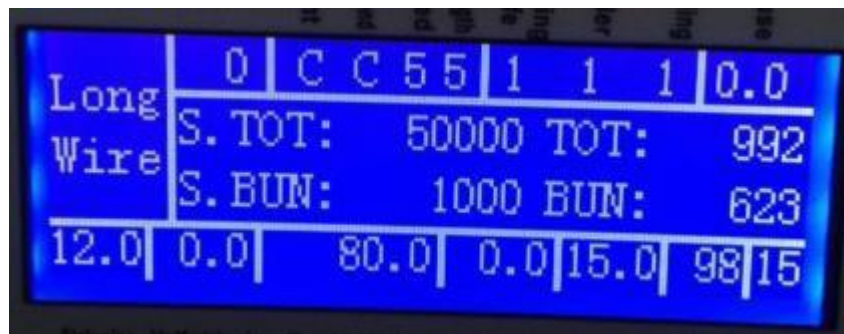
Working mode transform: machine standby (not cut line), press the key,   switching mode; the system has 7 working modes: long, short, flat cable (discharge), the multi section A

(section 15), the multi section B (section 15), sheath (each end of 3 layer), high speed (three blades);

Working mode description:

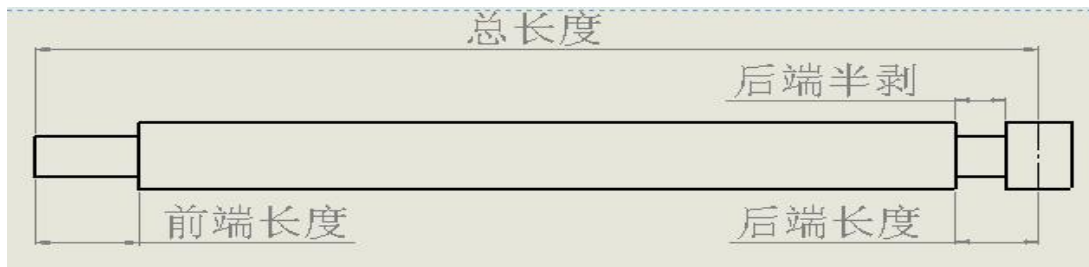
This machine is a multifunctional wire cutting machine, a total of 7 kinds of wire stripping and cutting process, explain the following pictures respectively:

Long line model:(greater than 38mm)



The model with the traditional 220 wire cutting machine function consistent, can install wire twisting device to increase the twisting line function, wire length relation as below, just press

the method introduced above the input size can be required, the mode *press* key features are not available;



short line mode(less than 38mm)



The Machine of this pattern and long-term basic same, just stripping machine movements are not the same; and no twisting line function;



the mode  key into the picture below;



When short-term intermediate leaving skin is longer, the front length may be more than set length is short, can be modified by setting here.

The short-term action sequence: first peeling (front + rear end length) - > send line (length) - > push skin (back end length) - > cut


ribbon cable mode:



Machine of this pattern and long-term basic same, just in the wire feeding machine when more twisting line function; the mode press the function *press* key to the flat cable function setting screen:



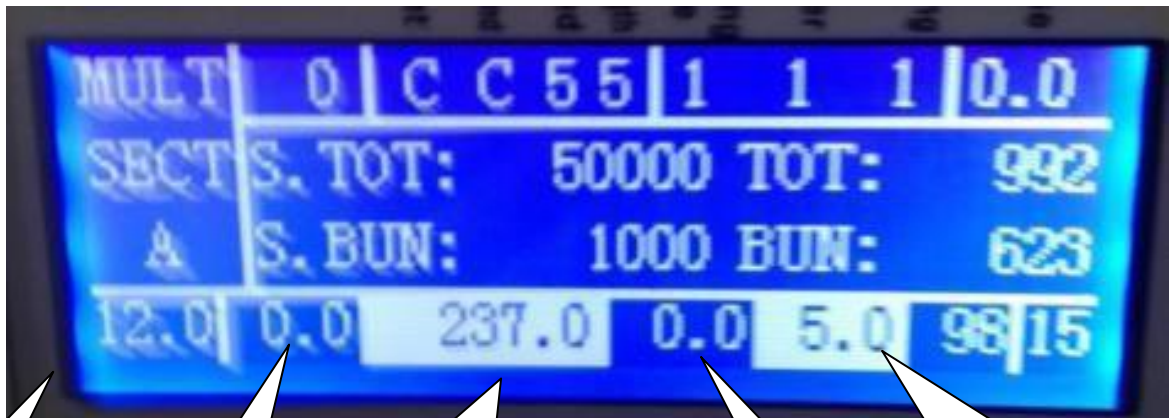
Press the button  to start setting parameter, setup is complete,

press the  key to return to work the picture

The multi section model:

Multi section mode is divided into multiple segments A and multi segment B two work modes;

Multi section A work mode when images are as follows:



Front end strip length


Front end half-strip length

The total length of wire, no need to set the program will Hen according to end all calculated length

back end half-strip

The back end length, need to set, the will automatically be last stripping length as a back end .



This mode is not twisted line function; press  function button to enter the following wiring function setting screen:


The first section length:
length of stay of leather
rubber, behind

The first section setting
peeling length: i.e. stripped
rubber part

The first section of
the settings before
pushing the

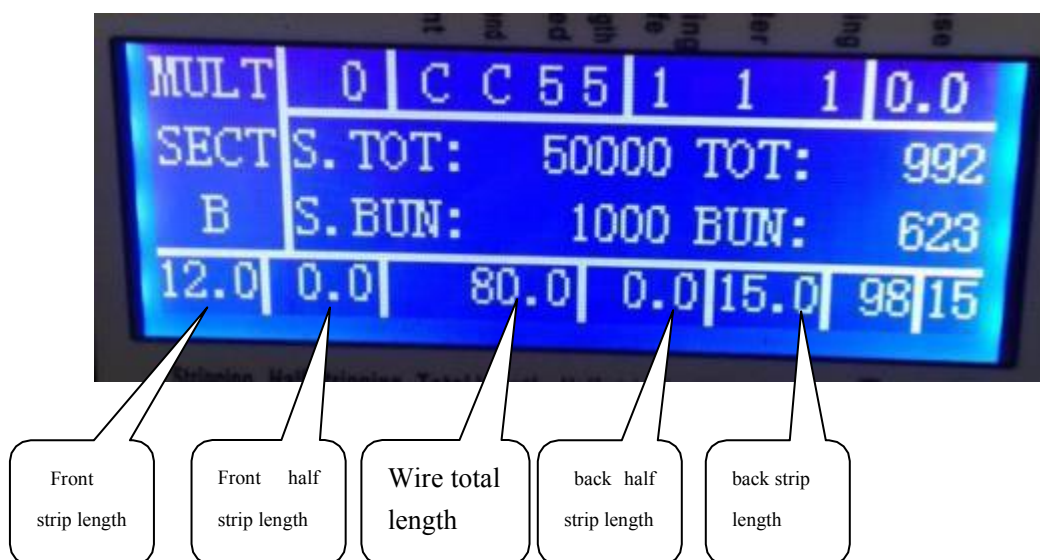
Multisection setting					
1#	PVC	10.0	STR	5.0	FWD 0.0
2#	PVC	10.0	STR	5.0	FWD 0.0
3#	PVC	10.0	STR	5.0	FWD 0.0



Press the  button to start setting, until all the parameters input complete;

Description: in this multi section model, the total length of wire is equal to the length of each section and plus front length, the program has automatic calculation and highlighted, so set the total length, length of back end all have no meaning; the length of the back end for the final end length! Also no need to set, when the required length of all the setup is complete, the next section is set to 0 can be! In this multi section mode, round round do not use; we can wire roller removed, this model is particularly suitable for short paragraph (less than 50mm) wire processing;

Multi section B work mode when images are as follows:



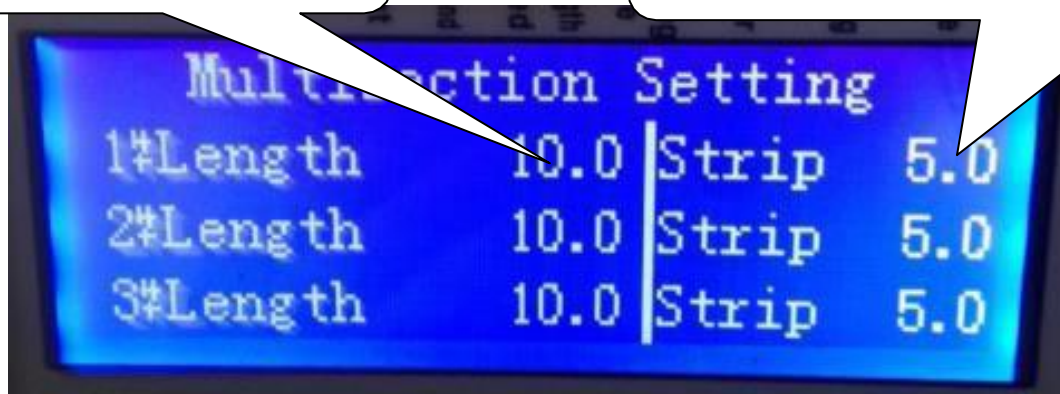
This mode is not twisted line function; press the function press key



to the following wiring function setting screen:


The first section length: namely the first incision position, and so on, the length of each segment is cut position

The first section setting peeling length: namely the cutter lower after cutting, peeling length;



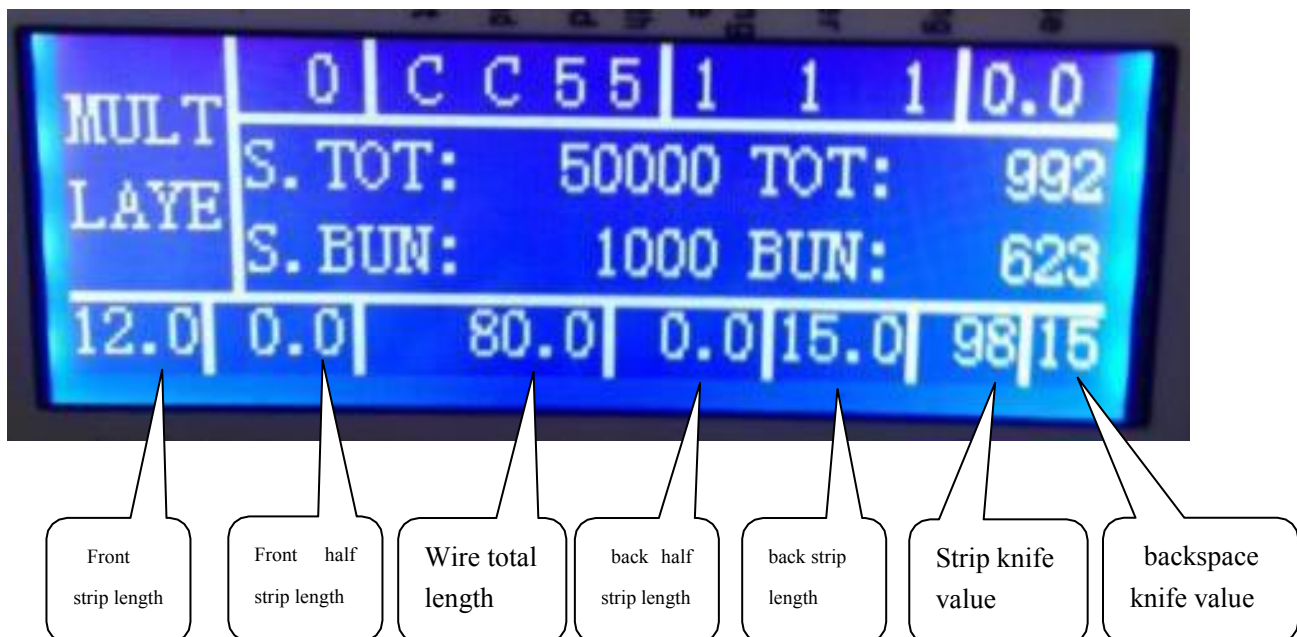
In the non parameter setting state, press, upward or downward view setup parameters of 1-15 segment;




Press the  button to begin setup, until all the parameters input complete;

Description: in this multi section mode, when the required length of all the setup is complete, the next section is set to 0 can be! In this multi section mode, to use the outlet roller peel back end length,

The cover cable model:





This mode is not twisted line function; press the  button to enter the following sheath function setting screen

LEN	3.0	0.0	0.0	2.0
HAL	0.0	0.0	0.0	0.0
KNI	74	0	0	74

Callouts from the diagram:

- The front second stripping length
- The front third stripping length
- The back-end third stripping length
- The back-end second stripping length

Text boxes on the left:

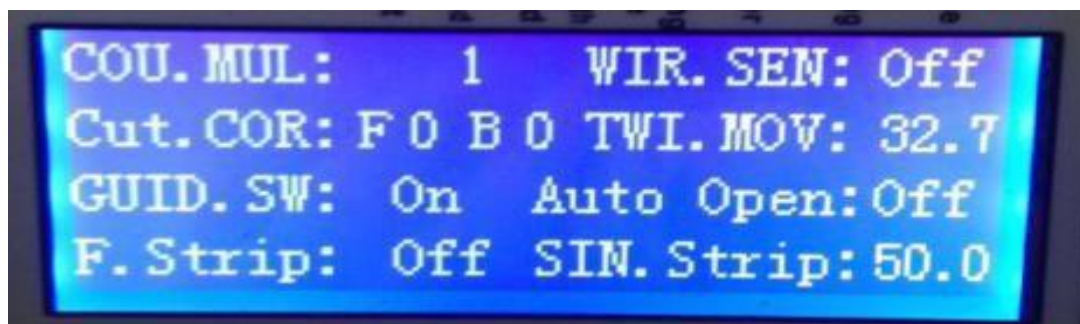
- Setup of each section
- Set the value of
- Set the knife back of each paragraph

Description: in the sheath model, the program first first peeling, after second times to third times peeling, peeling, so the length of each a skinning knife and value can be


adjusted, which can be the first decortication, second time stripping wire; and also the first time stripping core wire, second time stripping the outer skin; the first peeling knife value before and after the end of the same, second times, third times the value of the knife before and after adjusted separately; if the front as long as the stripping layer two, as long as any one of the length adjustable to zero can! Every time the stripping length equal to the length of the incision thread;

The function setting screen:

In the standby mode, press the  key forward into the picture in the display screen; the machine can not start, work, press  key can return to work the picture;





Parameter settings: press the  key to begin setup, input until all the parameters to complete; the following illustrate the practical significance of each function:

Counting multiple: namely multiple of each work cycle automatically count; if set to 2, then the machine every time, the count value plus 2;

Before the torsional offset: set twisting line, peeling the front end, sent to the twisted wheel distance;

Automatic lifting wheel is also useful to, send line, if the delivery line front-end stripping export more than before torsion offset, lifting wheel cylinder decreases, in order to save after delivering the line delay time;


Catheter switch: whether to use the catheter function, when set to off, cut off the line, conduit keeps positive position unchanged, the front wheel will front wire retracted intraductal opened the back end of the line

S-HY210 Auto wire stripping machine

Automatic lifting wheel: whether the use of automatic lifting a function;

Front end stripping: whether the use of front-end desquamate function; (F7-1 function
consistent with 220 older machine)

Single stripping: set the multi section model, the single biggest stripping length;
The system setup screen

Standby mode key is press  forward into the picture; enter the password '10010011' enters the picture; the picture display, the machine can not start work, press the button can return to work the picture;

Parameter settings: press the button to start setting, until all the parameters input complete;



Note the stripping set:

set number of stripping parameters, total length must be greater than the front end length + back-end length; otherwise the work when the machine may be out of control;

the use of communication control of the machine, must ensure that the machine in the display screen and the work of non parameter setup state; otherwise the communication control is invalid;

use the appropriate speed operation;

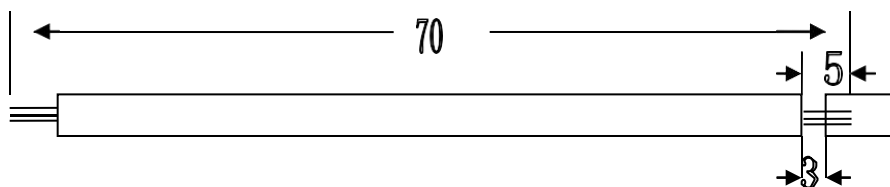
work in the picture and the non parameter setting, can be directly   on

the knife, key setting value; set the knife back press   keys, with no downtime;

if the four running lights flashing, that set the parameters of the time, not to start the machine;

Twisting line settings: front torsion offset parameters is designed for short-term twisting line function and the establishment, meaning when the machine off when the front wheel, distance twisted wire line feeding to the rear; sometimes the short-term can be installed to blade after twisting line wheel, then this parameter set is small, there may be short-term torsion linear function; the general line is set to 32.5, no need to change according to the actual distance; short-term adjustment of blade and twisted wire wheel; (can use the single step operation mode of operation to the step, if the wire feeding more than twisted wire wheel, can reduce the parameters, and can increase the;

wire cutting example



(1)、 the long-term pattern


will be placed in the middle of the wire is arranged on the roller, roller gap adjustment to just to contact wire and then down 2 big cases;

2、 set the size of:

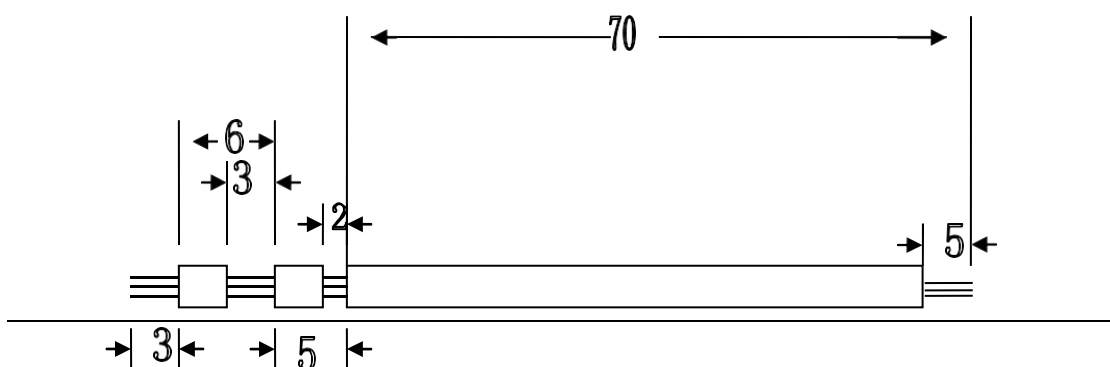
- (1)、 set up front length 3
- (2)、 set up front half strip 0;
- (3)、 the total length of 70;
- (4)、 The rear half stripping, set 3;
- (5)、 The back end, set the length of 5

3、



press and hold the  for more than 0.5 seconds, automatic stop carrying a line after the machine, see knife value is appropriate, directly on the bond, until satisfied correction;

(2)、 the multi section peeling (multi section A)



1、 ;




will be placed in the middle of the wire is arranged on the roller, roller gap adjustment to just to contact wire and then down 2 big cases;

2、 set the size of:

- (1)、 set up front length 3;
- (2)、 The front half stripping set 0;
- (3)、 The set of 1 length 3;
- (4)、 The 1 section, set before pushing 0;

- (5)、 The 1 section, set before pushing 0;
- (6)、 set 2 length 3;
- (7)、 set 2 peeling, 2
- (8)、 2 before pushing 0;
- (9)、 set 3 length 65;
- (10)、 set 3 stripping, 5;
- (11)、 set 4 length 0;

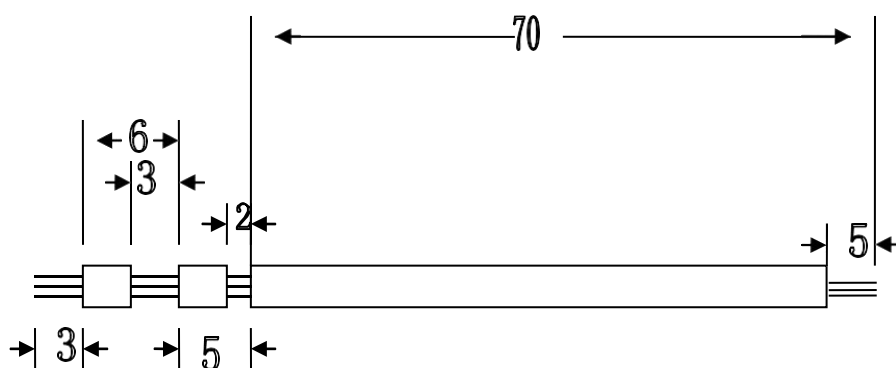
3、

press  key for more than 0.5 seconds, automatic stop carrying a line after the
machine, see knife value is appropriate, directly   key to revise, until
satisfied correction;

Description:

if the fourth set to 0, the program that you just cut 3 sections, and so on; if you want to peel 15 section, 15 section length will be all set to;
 in the multi segment peeling mode, twisting line function is invalid;
 if sometimes wire support focus on large, may push skin difficulties, made skin mouth slants small, then to compensate by setting the front push;

the multi section peeling (multi section B)






will be placed in the middle of the wire is arranged on the roller, roller gap adjustment to just to contact wire and then down 2 big cases;

set the size of:

- (1)、 set up front length $3+3+2=8$

- (2)、 The front half stripping set 0
- (3)、 The setting for a total length of 84;
- (4)、 The rear half stripping, set to 0;
- (5)、 The back end, set the length
- (6)、 set 1 section length 9
- (7)、 set 1section stripping 3;
- (8)、 set 2section stripping 14;
- (9)、 set 2section stripping 2
- (10)、 set 2section stripping 0

2、

press  key for more than 0.5 seconds, automatic stop carrying a line after the machine, see knife value is appropriate, directly   key to revise, until satisfied correction;

3、

if the fourth section set to 0, the program that you just cut 3 sections, and so on; if you want to peel 15 section, 15 section length will be all set to;

4、

in the multi segment peeling mode, twisting line function is invalid;

Adjustable machine skills: _____

1、

if sometimes length at the two ends of the wire stripping and relatively long or rubber support efforts to a larger cause peeling because of difficult, can consider to use the sheath model two or three peeling; like the front of length 120, can be set to the sheath model, the first segment length of 40; second segment length of 80; the third section length 120; three section knife the same value; rear end similar to peeling, so completely no problem;

2、

multi segment peeling if each segment length is relatively short, recommend the use of lifting mode off wheel, or recommend the use of lifting wheel open mode;

3.

If the wire diameter is larger, can the cutter stroke adjustable large, otherwise the wire feeding may easily block line;

if not carefully opened the twisting line function and machine and no wire twisting device, can be in the boot long press the emergency stop and hold the +2 button until the machine automatically restarts after twisting line function can be forced to close;