Steps of loading the wire on to the machine

1. Set the wire running speed with 3(the lowest speed is 3, and the highest speed is 0) on the computer as follows:

2. Move the limited blocks to two ends.

The limited block

Press the top one to make the drum move from left to right(or rotating direction from forward to backward)

1 for cutting ; 0 for loading the wire

Switch for starting or stopping the wire.

Press the bottom one to make the drum move from right to left(or rotating direction from backward to forward)

3. Make the wire drum move to the following position:

make the drum move to this position(the left end near to the the pulley)
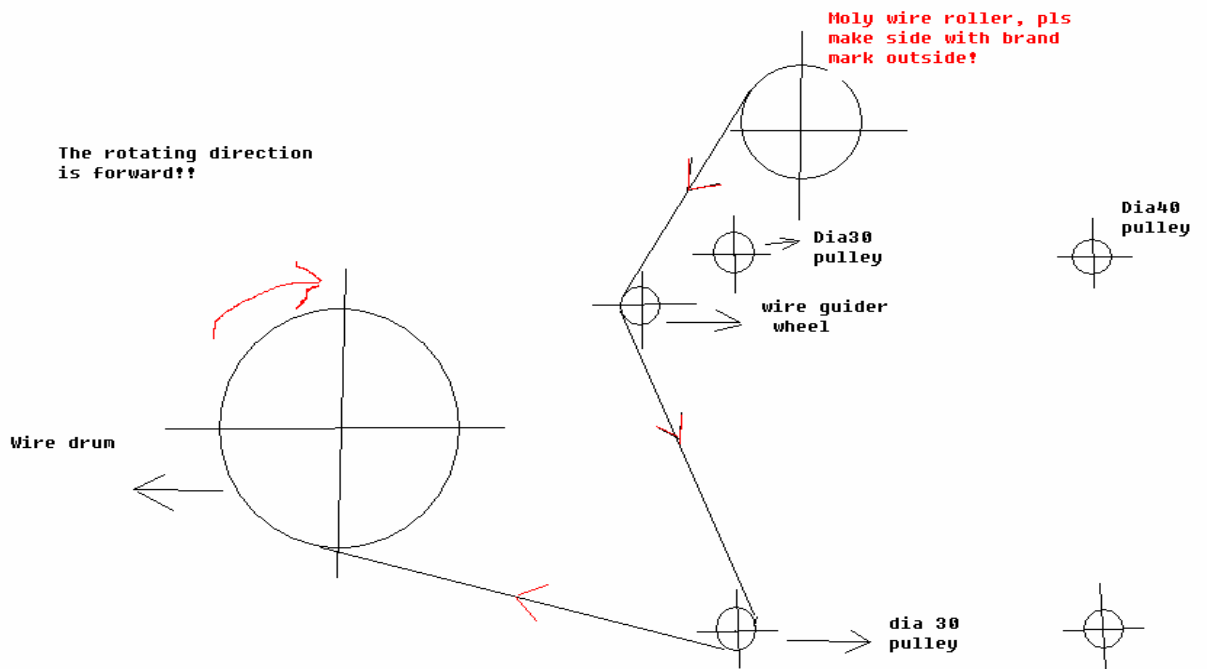
2010/07/06 10:38
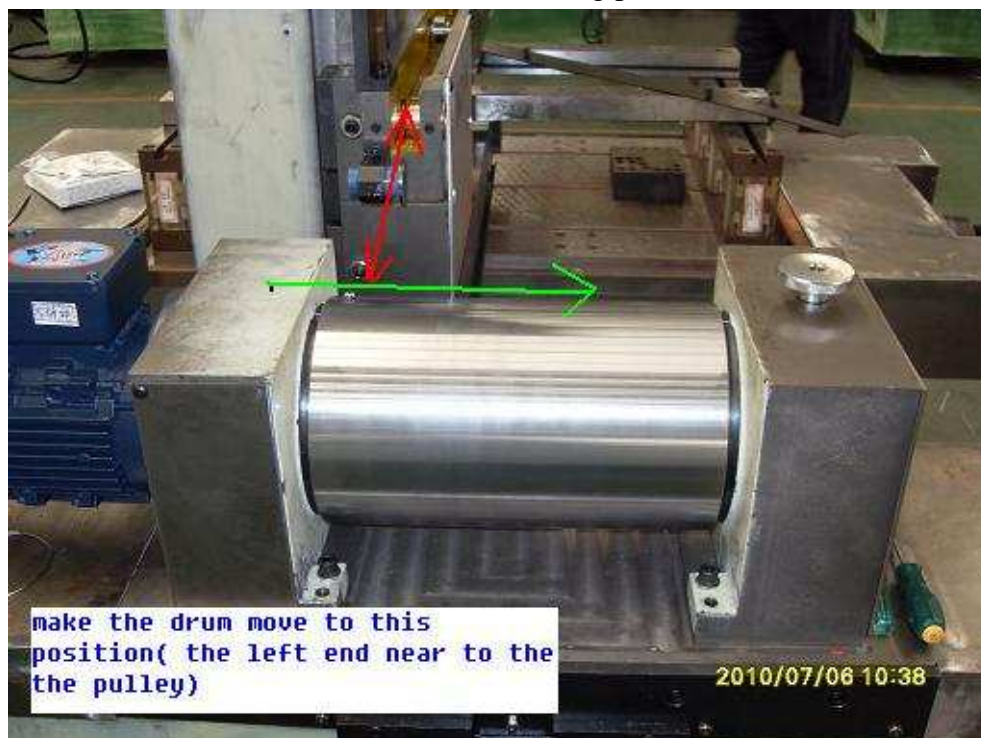
4. Load wire on the wire drum as follows
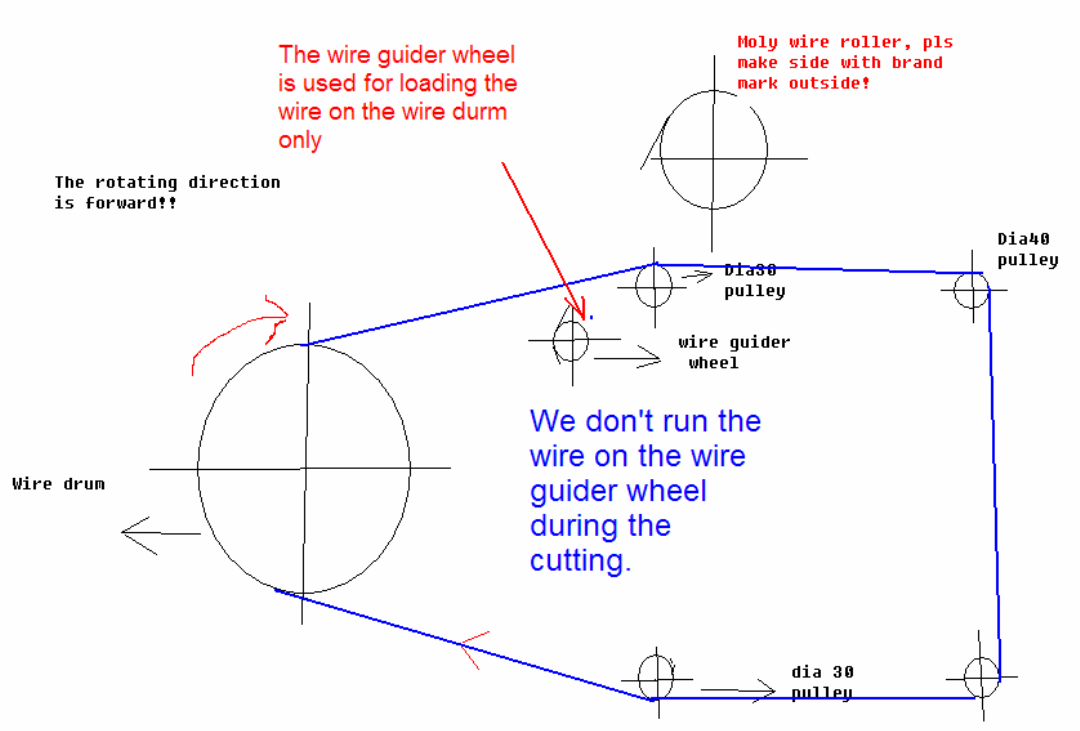
Please note:

A. makes the roller side with the brand mark outside!

B. The rotating direction of the wire drum is forward!

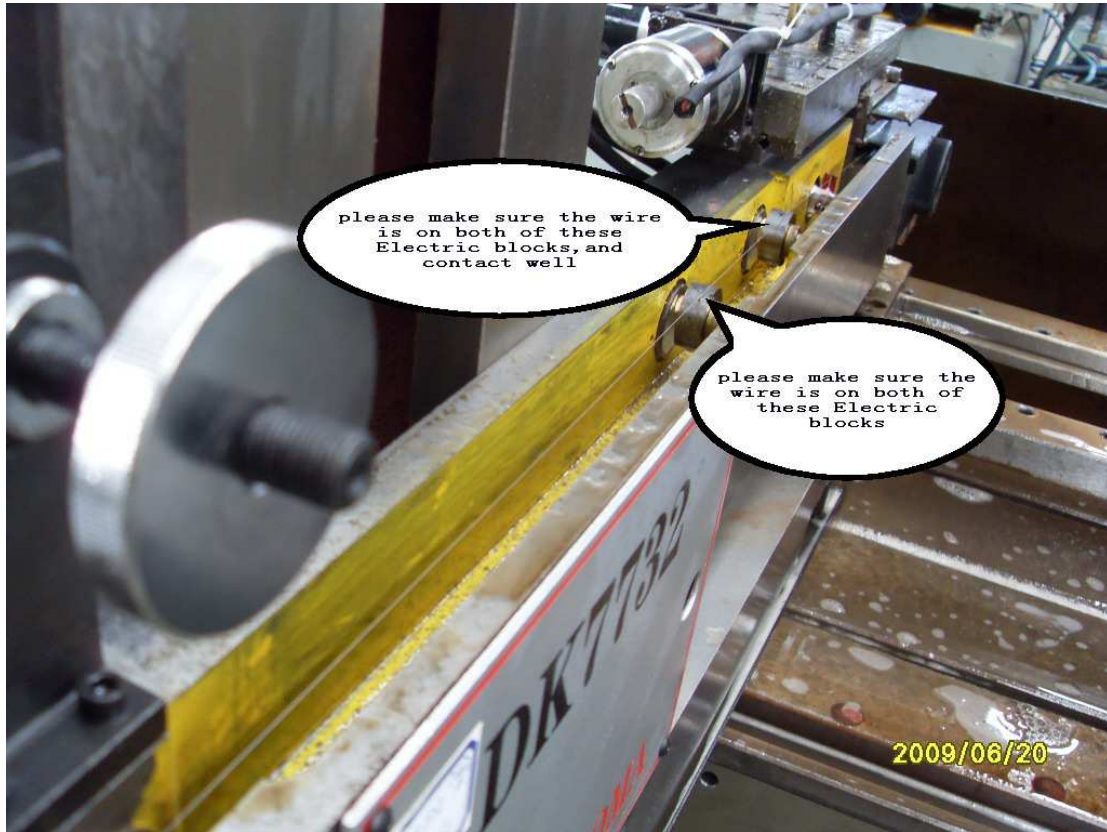C. Fix the wire end to the wire drum firstly (the wire drum side near to the motor!)

Moly wire roller, pls make side with brand mark outside!

The rotating direction is forward!!

Dia40 pulley

Dia30 pulley

wire guider wheel

Wire drum

dia 30 pulley

5. Arranging the wire on all pulleys as follow:

The wire guider wheel is used for loading the wire on the wire durm only

Moly wire roller, pls make side with brand mark outside!

The rotating direction is forward!!

Dia40 pulley

Dia30 pulley

wire guider wheel

We don't run the wire on the wire guider wheel during the cutting.

Wire drum

dia 30 pulley

5. Fix the wire end on the right side of the drum.(make sure the wire on all pulleys and electrical blocks as follows:

6. Make the wire drum move to the position that we start to load the wire firstly, then reset the wire running speed with faster speed (1 or 0), tension the wire with the hand wheel manually. (Before tensioning the wire, please press the bottom switch to make sure the rotating direction is forward). When you tension the wire, please use the almost the same power, at the same time, pay more attention to the wire end. Stop drum when the wire near to the end.

7. After the first time tensioning, if the wire is still loose, please repeat tensioning 2 or 3 times.

8. When you finish the tensioning the wire, please fix the limited switch to make sure the wire drum move between the two limited ends.