



# TOOLOTS XB21CN Computer Stripping Machine User Manual

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**TOOLOTS XB21CN Computer Stripping Machine**



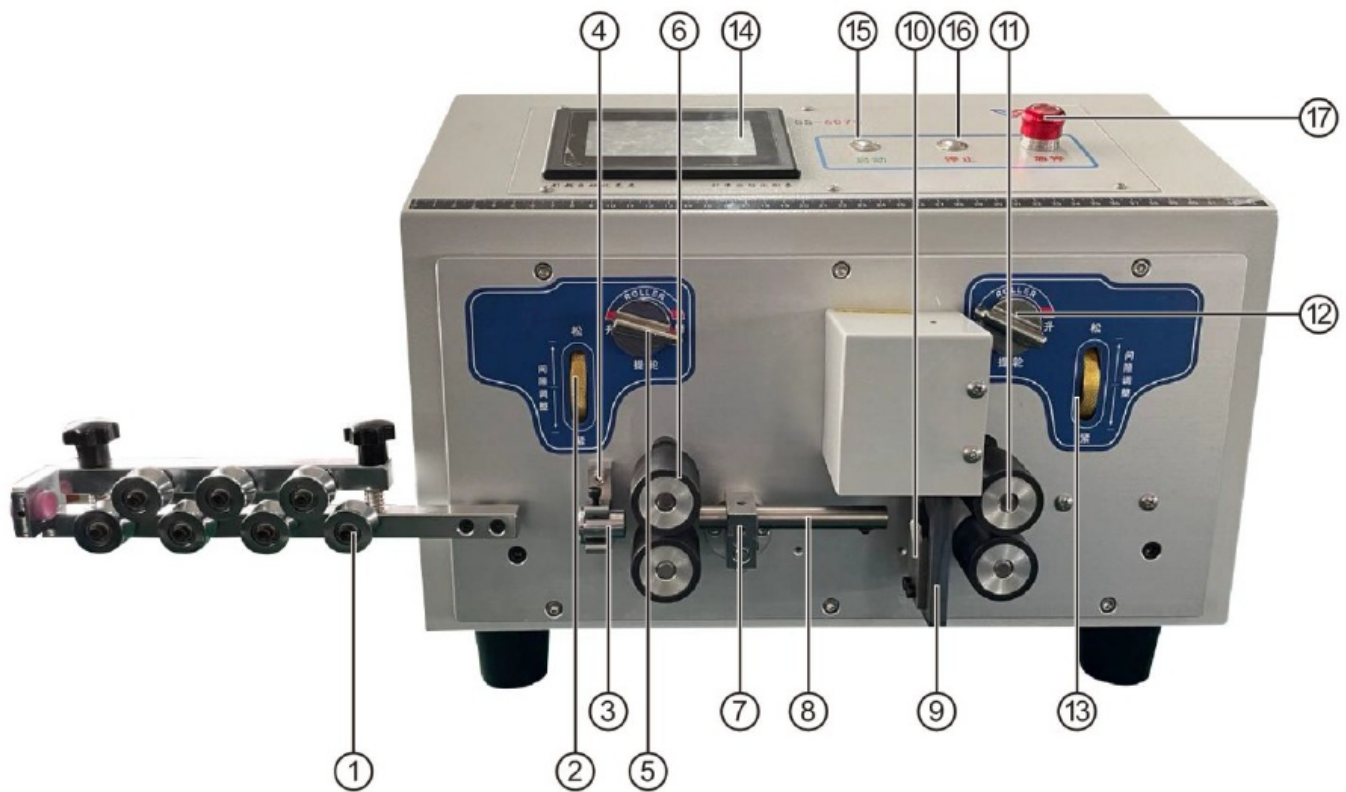
## Product Information

The product is a wire straightening and cutting machine that features a straightening frame, inlet wheel clearance adjustment button, catheter, tool carrier assembly cover, and blade. The catheter is responsible for guiding the wire through the conduit and fixing it in place while the blade cuts the wire into desired lengths. The machine also features a computer operating system with manual and parameter setting options, line length correction, and intermediate stripping settings. Additionally, the product comes with a troubleshooting guide to help users identify and resolve common issues.

## Product Usage Instructions

1. Ensure that the power is cut off before approaching the blade.
2. Adjust the inlet wheel clearance using the adjustment button to increase gear clearance and ensure that the roller and catheter are in a central line.
3. Guide the wire through the catheter and fix it in place using the upper and lower knife edges.
4. Protect the tool carrier assembly from sundries by covering it with the tool carrier assembly cover.
5. Cut the wire into desired lengths using the blade, which is divided into two with a short device above and a long device below.
6. Use the computer operating system to manually set or adjust parameters such as line length correction and intermediate stripping settings.
7. Refer to the troubleshooting guide provided to resolve common issues such as thread not coming off, heavy surface embossing of wire, and rollers not working properly.

## Outline of mechanical form



1. Straightening frame: wire straightening function.
2. Inlet wheel clearance Adjustment button: up into the gear clearance increased, down to reduce the rotating clearance, two-wheel clearance press wire harness, do not let wire harness skid is the best.
3. Feed Hole: The wire goes into the feed hole and into the feed wheel.
4. Inlet hole seat: fix the Catheter, and move up and down to adjust the center position of the Catheter and the blade.
5. Lifting action of thread feeder: Turn counterclockwise to raise the thread feeder, and clockwise to lower thread feeder.
6. Feed wheel: The Motor drives the feed wheel to rotate so that the wire goes forward and backward, cooperating with the tool carrier to feed the wire and strip the head.
7. Catheter Base: Fixed Catheter Role, can be adjusted up and down so that the front and back of the roller and catheter are into a central line.
8. Catheter: The wire goes through the conduit to enter the knife edge, fix the role of the wire, in the upper and lower knife edge of the central point.
9. Tool carrier assembly cover: Protects Sundries from entering the tool carrier assembly.
10. Blade: divided into two, its short device above, long device below, two for a pair of, the device when the upper and lower blade vertical, upper and lower blade edge for a central point, upper and lower blade wall can not have clearance.
11. Outlet Wheel: The Motor drives the outlet wheel to rotate so that the wire harness advances and retreats, cooperating with the cutter post outlet and stripping Tail Action.
12. Lifting function of thread outlet pulley: Rotate clockwise to raise the thread outlet roller, and rotate counterclockwise to lower thread outlet roller.
13. Outlet wheel clearance adjustment torsion: up rotating outlet wheel clearance increased, down rotating outlet wheel clearance reduced.

14. Display screen: adjust the parameters of the wire needed for processing.
15. Start: Press the start button to make the machine work when the data input is complete without error.
16. Stop Press Stop to stop the machine.
17. Emergency Stop: When the machine is in working condition, press [ emergency stop ] to stop the machine.

Note that you must not approach the blade with your hand before the power is cut off, whether the machine is working or not.

### Introduction of computer operation

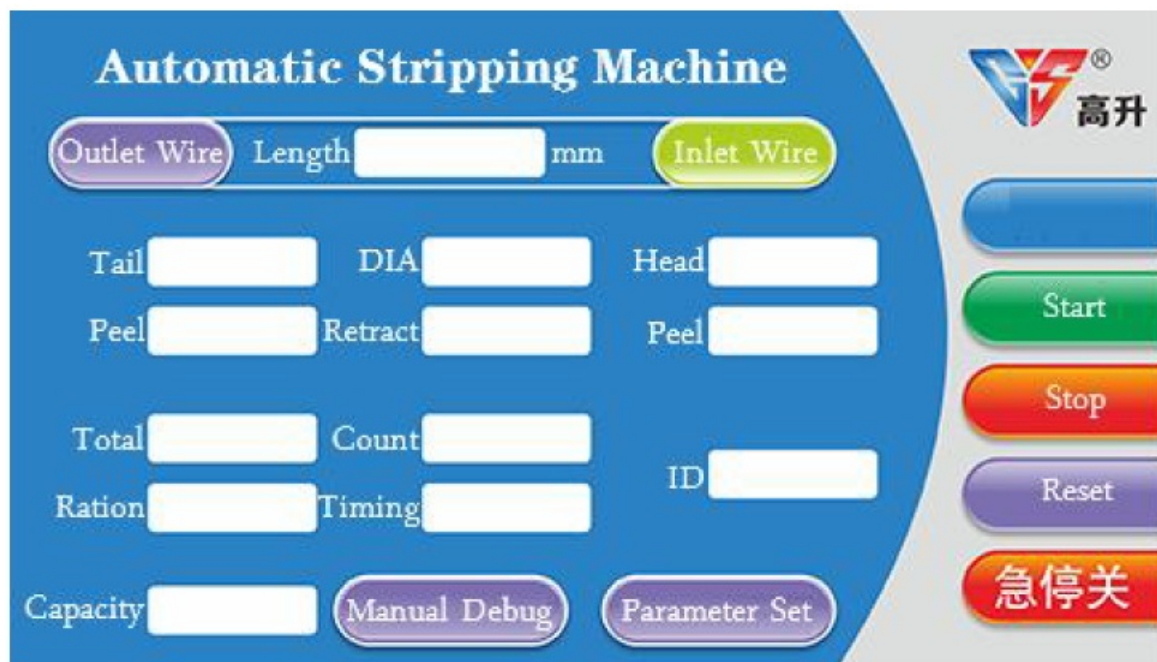
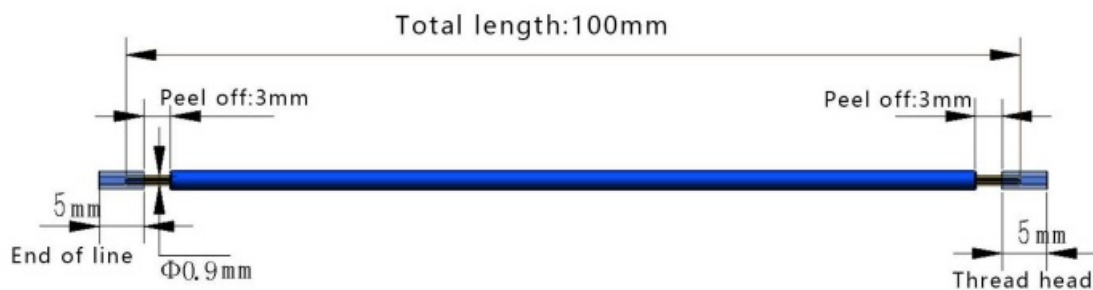


Figure 1

1. Program: By 0-99 Item Program Series number storage parameters.
2. Inlet wire: thread the wire through the wire hole until the incoming wire roller is, press the incoming wire roller to send the wire forward automatically.
3. Outlet wire: Press the [Outlet wire] wheel to automatically back out.
4. Auto/Single Step/Single Cycle: In the case of a single step, press the start button and the machine runs a single action. Press the start button in the test machine to run a complete action, In the case of automatic, press the start button and the machine will continue to run.
5. Start: Press the [ start ] key to make the machine work when the data input is complete without error.
6. Stop Press Stop to stop the machine.
7. Reset: Return each part of the machine to its original position.
8. Emergency Stop: When the machine is in working condition, press [ emergency stop ] to stop the machine.
9. Length(Total): the total length of the cut wire, in MM.
10. Thread head: The length of the end of the wire.]
11. Head stripping: If the stripping parameter is less than the parameter of the thread head, it is called half stripping. If the parameter of the thread head is more than the parameter of the thread head, it is called full stripping.
12. End of Line: The desired length of the tail end of the wire.

13. Capacity: The capacity of the machine running for 1 minute automatically calculates the production quantity for 1 hour.
14. Tail stripping: If the parameters of the wire tail are less than the parameters of the wire tail, it is called half stripping. If the parameters of the wire tail are more than the parameters of the wire tail, it is called full stripping.
15. Line diameter: The cutting cross-section of the step number of the motor driven by the tool holder controls the cutting depth at the end of the thread head. The larger the thread diameter parameter, the larger the upper and lower cutting opening. The shallower the cutting depth, the smaller the thread diameter parameter, the smaller the upper and lower cutting opening, and the deeper the cutting depth, the open distance of the upper and lower blades is calculated in millimeters. The diameter of the core wire of the wire is as many millimeters as that of the input wire.
16. Retreat: The size of the retraction depends on the thickness of the rubber sheet of the wire. The thicker the rubber sheet is, the smaller the retraction is, about 0.5 ~ 5.0 mm.
17. Set amount: Refers to the total output of set work, input data can not be less than the quantitative data input, such as data less than quantitative data machine will not work.
18. Count: Cumulative production.
19. Quantitation: input how many parameters the machine operates and how many times automatically stop, such as input 100 machine operation will automatically stop, input 0 for no quantitative data, the machine will not automatically stop, to achieve the set amount of data will stop.
20. Timing start: When the machine works to the specified amount of time, the number of seconds delay, automatic start to continue running.



## Manual setting

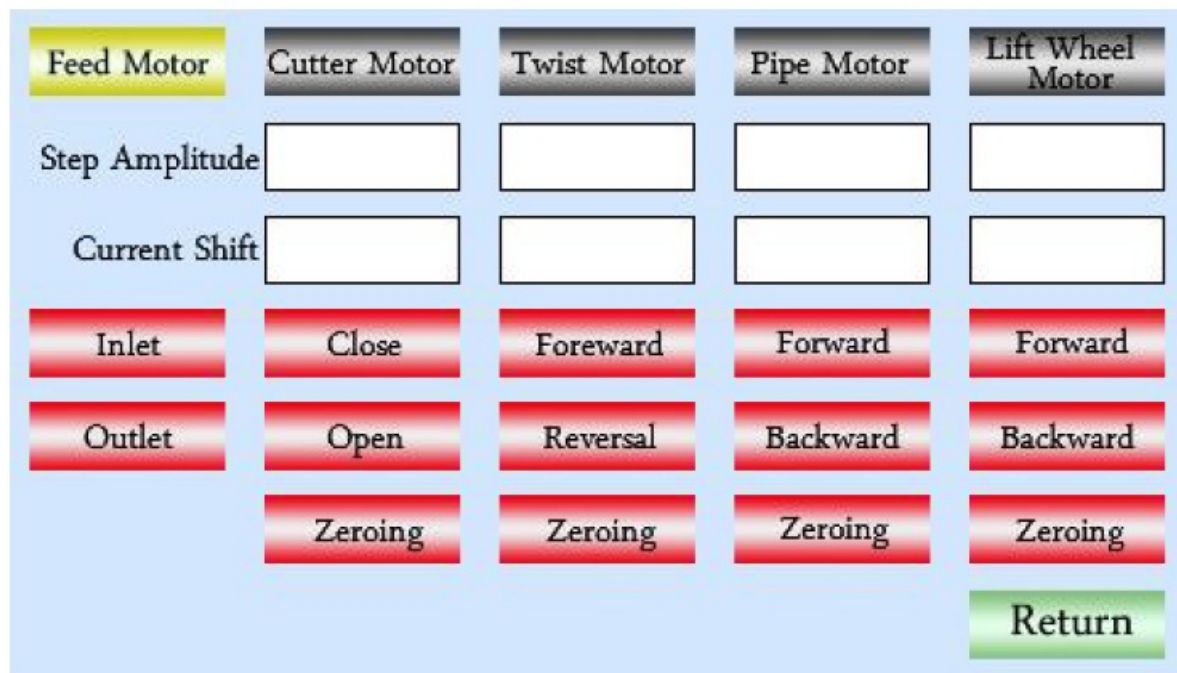


Figure 2

1. Feed Motor: Press the wire inlet key, the roller feeds the wire forward, and press the wire outlet key, and the roller moves back the wire.
2. Cutter Motor: Press the close key to close the thread cutter up and down, and press the open key to open the cutter up and down.
3. Step Amplitude: The larger the value, the larger the up and down movement position. Return to zero and tool induction to return to the origin.
4. Twist Motor: press the forward button to twist the thread in the forward direction, and press the reverse button to twist the thread in the reverse direction.
5. Pipe Motor: Press the forward button, the catheter is lifted up, and the catheter is lowered down when pressing the back button.
6. Lift Wheel Motor: Press the forward button, and the outlet wheel lifts up, press the back button, and the outlet wheel is pressed down.

### Parameter Setting

Feed Speed  %

Cutting Speed  %

Peeling Speed  %

Cut&Decelerate  %

Outlet Speed  %

**MID Peel Setup** **Return**

Figure 3

1. Feed Speed: Refers to the motor-driven roller feeding speed of 10-100, 10 the slowest and 100 the fastest.
2. Cutting speed: refers to motor drive tool carrier cutting speed, speed 10-100, 10 the slowest, 100 the fastest.
3. Peeling Speed: Refers to the peeling speed of the rubber. The slower the speed, the greater the peeling force, and the faster the speed, the smaller the peeling force.
4. Cut&Decelerate: Refers to the speed at that the upper and lower knife edges touch the wire until it is cut. The speed is 00-10, 00 is the fastest, and 10 is the slowest. The slower the speed, the greater the cutting force, and the faster the speed, the smaller the cutting force.
5. Outlet Speed: Refer to the wire stripping and removing speed, The larger the speed value, the faster the outgoing line; the smaller the speed value, the slower the outgoing line.

### Line length correction

Set-Up Length

Actual Length

**Correction**

Actual Line DIA

Diameter COEF

**Return**

Figure 4

1. Length value correction: The length value is the total length setting value. When there is a difference between

the total length setting value and the actual length of the processed line, just enter the actual length value of the processed line in the actual length value and press the red “correction” on the right key correction.

- Wire diameter value correction: The actual wire diameter is the size of the cutting edge. When the set wire diameter value and the cutting edge cutting size are different, the wire diameter coefficient can be corrected. The larger the input value, the larger the cutting edge cutting size, and the smaller the input, the value smaller.

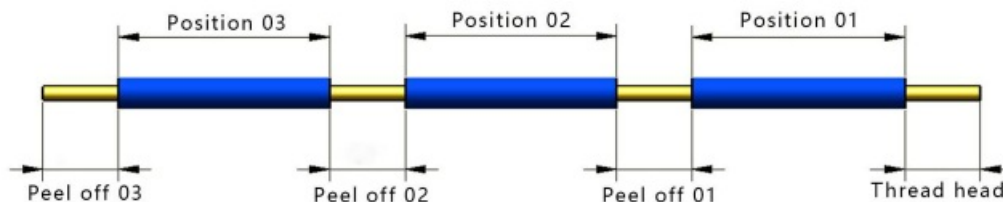
### Intermediate Stripping Setting

POS	Length	Peel Off	POS	Length	Peel Off
01			09		
02			10		
03			11		
04			12		
05			13		
06			14		
07			15		
08			16		

MID Peel Off
Return

Figure 5

- Position 01: The length of the wire to the first incision in the middle; Pelling: The first spelling distance in the middle.
- Position 02: Length of cutting from the top of the wire to the second in the middle; Peeling: The second peeling distance in the middle.
- Position 03: the length of the cut skin from the top of the wire to the third place in the middle; Peeling: The third peeling distance in the middle. And so on...



### troubleshooting


Questions	Solution
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The thread won't come off	<p>1 Check the head cutting depth, if too shallow, need to reduce the diameter of the line.</p> <p>2 The upper and lower clearance of the feeding roller is too large and the adjustment is too small.</p> <p>3 The header data is too small and needs to be enlarged.</p>
The end of the thread won't come off	<p>1 Check the cutting depth of the end of the line, if it is too shallow, reduce the diameter of the line.</p> <p>2 The upper and lower clearance of the outgoing roller is too large, and the adjustment is smaller.</p> <p>3 The data of tail stripping is too small and needs to be enlarged.</p>
The surface embossing of wire is too heavy	<p>1 First determine whether the embossing is caused by the incoming or outgoing line wheel pressure.</p> <p>2 If the line into the wheel, then the line into the wheel adjustment gap.</p> <p>3 If it is a line out of the wheel, then the line out of the wheel adjustment gap.</p>
The head and tail of a thread are peeled off at an angle	<p>1 The front end of the Catheter is too far away from the blade, so it needs to be adjusted.</p> <p>2 Adjust the position of the catheter or small diameter catheter, so that the wire through the catheter and knife is in a straight line.</p>
The copper wire at the end of the thread is slightly longer	<p>1 Wire diameter is too small, the knife cut to copper wire, peeling out, need to increase the wire diameter.</p> <p>2 Retreat data is too small, and needs to increase.</p>
Cut the core at the end of the thread	<p>1 If Wire diameter data is too small, increase wire diameter and retry, until do not damage the core copper wire.</p>
The wires are connected together without being cut	<p>1 Slow down the cutting speed and try again.</p> <p>2 Blade Blunt, need to remove the blade to replace the new blade.</p> <p>3 When the upper and lower blades are closed, there is a gap in the plane. It is necessary to reinstall the blades to make the upper and lower blades close.</p>

The actual length does not match the set value	<ol style="list-style-type: none"> <li>1 There's a stolen property on the wheel drive that needs cleaning up.</li> <li>2 Check the wire position to see if there is resistance to wire feeding.</li> <li>3 The belt of the incoming roller drive is too loose and needs to be tightened.</li> <li>4 The wire has paraffin on the surface, causing the roller to slip with wax. Please clean 4 rollers with gasoline or banana water.</li> </ol>
	<ol style="list-style-type: none"> <li>1 See if the parameter line length has the input data needed to process.</li> </ol>

The rollers don't work	<ol style="list-style-type: none"> <li>2 Check if the synchronous belt is broken.</li> <li>3 Check whether the wheel drive is normal (green light is normal, red light is abnormal).</li> </ol>
The tool carrier is not working properly	<ol style="list-style-type: none"> <li>1 Check whether the cutter drive is normal (green light is normal, red light is abnormal).</li> <li>2 Check whether the cutter rack gear is stuck or broken.</li> <li>3 Whether the tool Holder Slide Block is not oiled for a long time, resulting in too much friction resistance.</li> <li>4. See IO monitoring whether the cutter's origin back to the origin of the green light, such as not on the sensor is bad.</li> </ol>
Do not work according to the running key	<ol style="list-style-type: none"> <li>1 Check to see if there is an input set amount.</li> <li>2 Check to see if the count has reached the set total, and clear the count to zero.</li> </ol>

## Documents / Resources

	<p><b><a href="#">TOOLOTS XB21CN Computer Stripping Machine</a></b> [pdf] User Manual  XB21CN Computer Stripping Machine, XB21CN, Computer Stripping Machine, Stripping Machine</p>
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