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GW-7T Mute Terminal Machine



1. GW-terminal machine function introduction:

(1) Summary

GW-1.5/2.0/3.0/4.0/6.0/8.0T terminal machine is a high-speed semi-automatic terminal machine, this machine is suitable for OPT horizontal mold, straight mold, single grain mold, 2000#, 950# mold, the whole machine performance is more stable. The machine is simple to operate, easy to maintain, designed for high output and

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low maintenance manufacturers to save the cost waste of production during the fault period, and the appearance is beautiful, the operation is simple and easy to understand.

(2) Introduction

GW-1.5/2.0/3.0/4.0/6.0/8.0T super silent terminal machine, using high-tech frequency conversion technology, electronic accurate positioning, the motor starts to work when crimping, less noise than the traditional terminal machine, and power saving, convenient and quick mode adjustment, to avoid the traditional terminal machine clutch, electromagnet and other common faults.

(3) Function

The machine is suitable for OPT horizontal mold, straight mold, single grain mold, 2000#, new energy mold 950# mold, etc.

- ☐ Stable voltage, high speed, high accuracy.
- ☐ Computer terminal, DC terminal, single terminal, joint terminal.
- ☐ Light structure, easy to move the workplace, small operation sound.

(4) Specifications

Model	GW-1.5/2.0/3.0/4.0/6.0/8.0T
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Capacity	1.5/2.0/3.0/4.0/6.0/8.0KG
Route	30mm
Power Supply	220V/50HZ/60HZ
Weight	35/50/-/85/-/-KG
Work Efficiency	6000 times/hour

2. Structure

Front view



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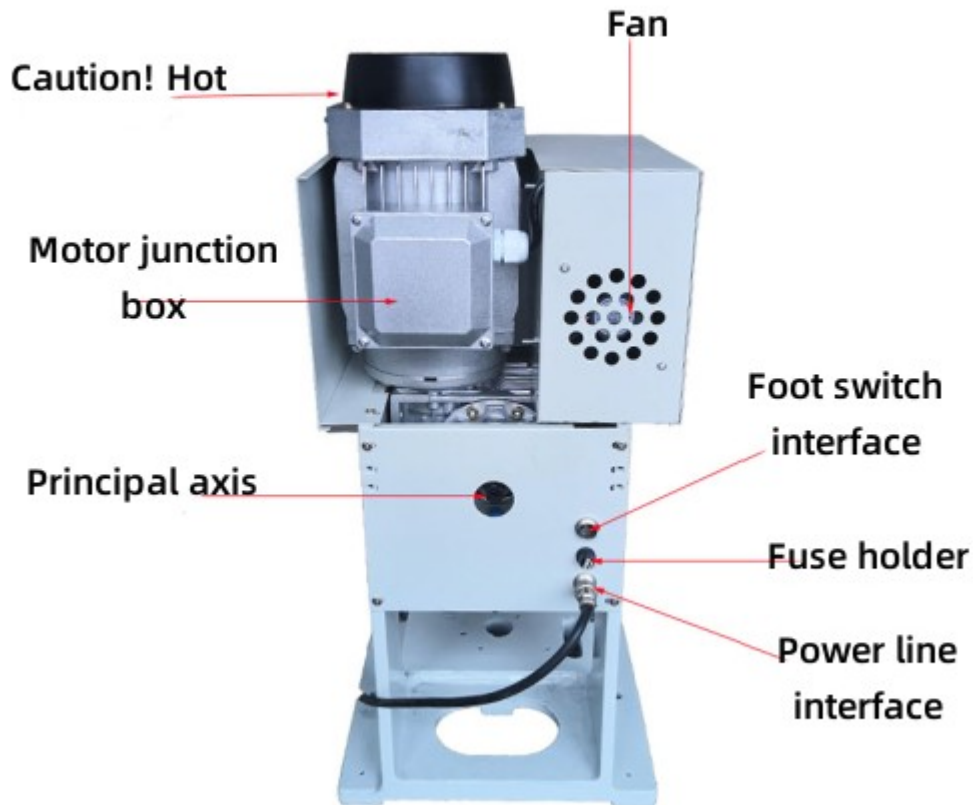


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Back display



Risk of burns:

You must not touch the motor with your hand for a long time to avoid burns.

Danger of electric shock:

If there is a danger of electric shock by touching the electrified part, do not touch the motor or power line interface with wet hands, if there is leakage phenomenon, let professionals repair.

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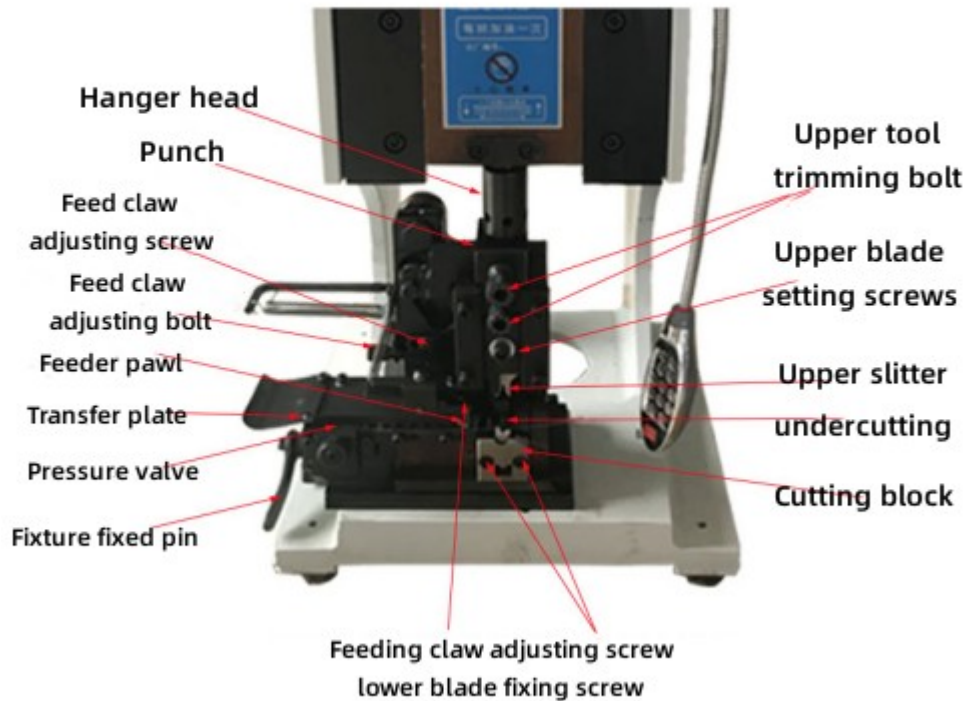


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Fixture detail drawing



Instructions:

- (1) Adjust the feeding claw stroke in a wide range.
- (2) Adjust the feeding claw stroke in a small range.
- (3) Vertically adjust the feeding claw so that the same material belt hole is in the same transverse position.

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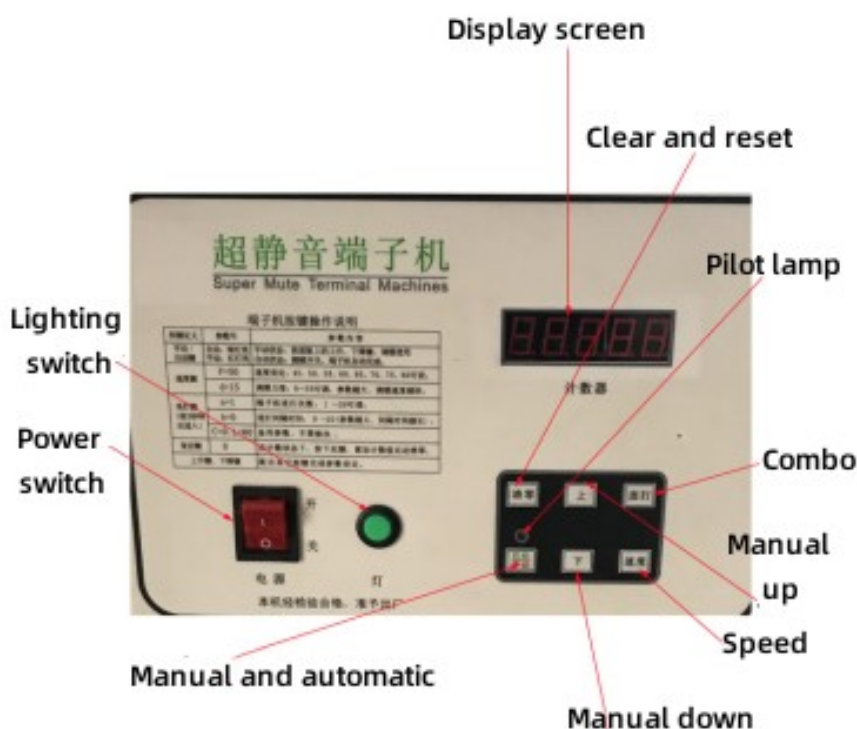


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3. Operation instructions:



- 1) Power switch: On indicates that the terminal machine is turned on, off indicates that the terminal machine is turned off.
- 2) Lighting: click to turn on, repeat to turn off.
- 3) Display screen: When the terminal machine is in operation, the number of times used is accurately counted.
- 4) Zeroing: Clear the counter. Reset: When the power is turned on, the machine does not work properly. Use the reset key to restore the machine to normal work.
- 5) Indicator: red indicates manual, green indicates automatic.
- 6) Automatic/manual: Switch between automatic and manual.
- 7) Manual upward: When the indicator light is red, hold down the key with your

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hand and move the slider upward.

8) Manual down: When the indicator light is red, hold down the key with your hand and move the slider down.

9) Even play: hold down the even play key for 5-10 seconds, N=01 will appear on the display screen, which means that the terminal press the switch to play once, if you want to play 5 times set N=5, press the manual up key is plus, press the manual down key is minus.

10) Speed: Press the speed key and a number between F=40-80 will appear on the display. F=40 indicates the slowest speed and F=80 indicates the fastest speed. If you need to set the speed, press the manual button.

4. Precautions:

- (1) The wrench must be removed when starting the power switch.
- (2) The punch must be adjusted to the highest position before starting.
- (3) Avoid hitting several terminals.
- (4) Confirm whether the voltage is normal (please install a regulator) to ensure the life of the machine.
- (5) For the sake of safety, ensure that both hands leave several machines before starting the power switch.
- (6) When the operator adjusts the mold, the machine must be in a manual state (that is, the indicator light is red).

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(7) Troubleshooting and maintenance

- A. Foot switch is bad, replace it.
- B. Check the proximity switch when continuous calls occur.
- C. Blown fuse, replace it.
- D. Slow mechanical action, oil 1-3 times a day to the slider oil hole, mechanical working environment temperature (-2-50°).
- E. Motor failure (smoke, odor), pay attention to the motor voltage.
- F. The mold card master can not slide up and down, turn the spindle tail screw with a wrench, so that the spindle drives the slide block down
- G. Drive the punch, see whether the riveting knife is hurt, scratch the terminal stuck on the knife.
- H. Cutter replacement:

Note: Please put the machine in the manual state when changing the knife.

- a. The overall height adjustment of the mold: loosen the punch pressing screw, turn the adjusting screw with a small round rod (there are 6 holes on the circumference), clockwise for the upper, counterclockwise for the lower (each turn of a equal hole 0.25 mm), adjust the punch to the appropriate position, and then lock the punch pressing screw (that is, adjust the core crimping height).
- b. The upper outer knife and the upper inner knife drop adjustment: PVC press the height of the fine-tuning section, loosen the screw on the knife, pull out the rotation axis, there are a total of eight indicators, the larger the number, the PVC blade height

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lower, each indicator height difference of 0.1mm, adjusted to the appropriate position (that is, adjust the wire skin crimping height).

c. Feed part adjustment:

- ① Press the up and down key to move the slider to the highest point, release the pressure valve, rotate the feed adjusting screw clockwise, counterclockwise forward, and send the terminal to the center of the blade.
- ② Adjust the slide sheet to the appropriate position and the adjustment is complete.

5. Exception protection and handling

Display code	Code meaning	Treatment method
E-0	Hardware protection	Check for short circuit
E-0U	Overvoltage	Overvoltage of supply
E-LU	Undervoltage	The power supply voltage is too low. Procedure
E-0H	Driver overheat	Check whether the fan in the exhaust vent of the power box stops

6. Fixture debugging and installation

(1) Blade mounting

Terminal machine blade generally has 4 pieces (upper inner knife, upper outer knife,

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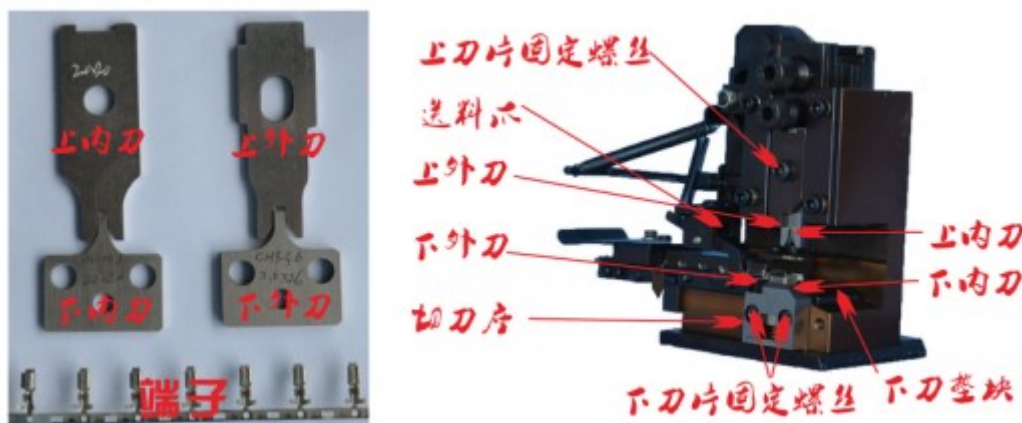


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lower inner knife, lower outer knife)



After loosening the fixing screws of the upper and lower knives, place the blade in the position shown in the figure above (the opening of the upper and lower inner knives is smaller than the opening of the outer knives, do not install the inner knives and the outer knives in the opposite direction). When installing the upper blades, pay attention to the opening of the blade, and adjust the drop between the upper and upper inner knives according to your terminals and wires. Generally, the opening of the outer knife should be higher than the opening of the inner knife, and then re-lock the screw of the upper and lower knife to complete the blade installation. When installing the blade, be sure to align it, and do not press other things next to it to prevent the blade from being broken.

After the blade is installed, the front and rear positions of the lower tool die need to be adjusted to ensure that the upper tool die is aligned with the lower tool die when it is pressed down by the punch. First set the terminal to manual mode and press "up" or "Down". At the same time, observe whether the upper and lower

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knives are aligned from the right side. If they are not aligned, move the lower tool pad inward or outward to align the upper and lower knives. The method of moving the lower tool pad position is to loosen the fixing screws on both sides (Figure A), and twist the adjustable screw in the middle to move forward and backward. Move to the appropriate position and then lock the fixing screws.

After the above steps are completed, it is also necessary to adjust the stroke of the punch, and when the upper and lower blades are at the lowest point, the gap between the upper and lower blades is just crimped terminals to be crimped. If you only need to fine-tune the stroke of the upper knife, pull out the "drop fine-tuning" knob in the figure, and rotate the knob to the appropriate position. (Principle: The stroke fine-tuning knob is a polyhedron, and the height of each face is not the same, so as to adjust the stroke). If you need to greatly increase or decrease the stroke, first loosen the "fixing screw 1" and "fixing screw 2" in the figure below, and then insert the hex wrench with the appropriate size into the "stroke adjustment hole, turn counterclockwise to increase the stroke (let the upper blade fall lower), and reduce the stroke clockwise (note: clockwise and counterclockwise need to be viewed from the bottom up). While adjusting the stroke, press the "Down" or "Up" button in manual mode to lower the punch to the lowest point, check the gap between the upper and lower knives until the gap is suitable, and then lock the two fixing screws.

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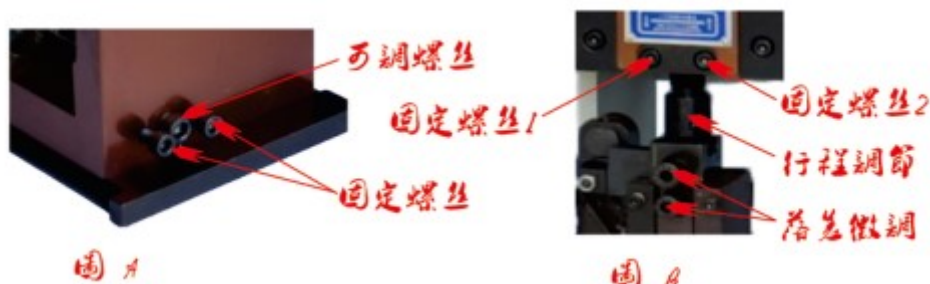
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(2) Through the terminal

After the blade is adjusted, the terminal can be inserted into the mold. The terminal should be fixed on the discharge rack first. The guide plate, the feed board, the terminal cutter, and the following side will explain how to insert the terminal into the feed board and the cutting knife:

Remove the feed plate positioning screw on the side of the terminal and remove the feed plate cover (as shown in Figure 1 below).



Remove the fixing screw in the above figure, that is, you can lower the feed cover plate (as shown in Figure 2), and then insert the feed belt of the terminal into the edge of the feed plate (as shown in Figure 3), clamp the feed cover plate to the end of the terminal (as shown in Figure 4), push the feed cover plate, push the

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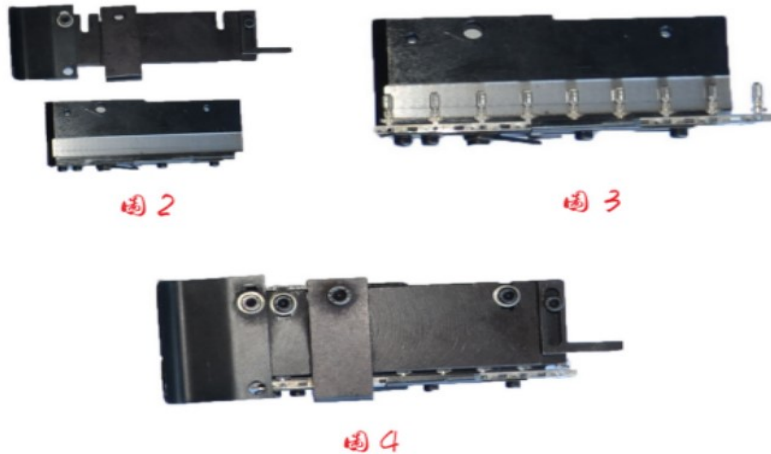


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terminal to the most edge of the feed plate, and then lock the screw of the feed cover plate. Pay attention to the foot of the terminal wire cover on the outside of the cover plate. The rest is inside the cover.



Put the cover plate back into the machine, and use the terminal material belt to pass through the cutting hole (as shown in the following figure), move the board forward and backward, so that the terminal tail is tight to the knife (the purpose is to press the upper and lower knife to the appropriate position of the terminal), and then lock the fixing screw of the material plate, the material return claw is used to locate the position of the wire and the material return. The return sheet should be close to the position of the blade, but it can not be pressed by the blade. After adjusting the position of the return sheet, you can let the top of the line reach the return sheet each time you put the wire, improving work efficiency and accuracy.

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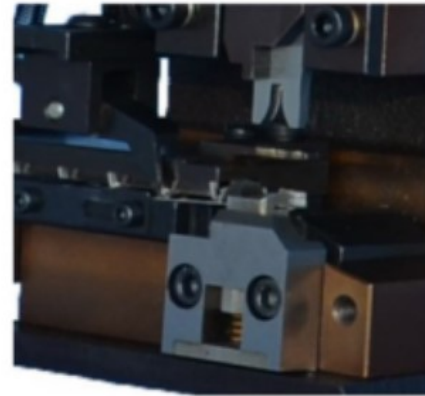
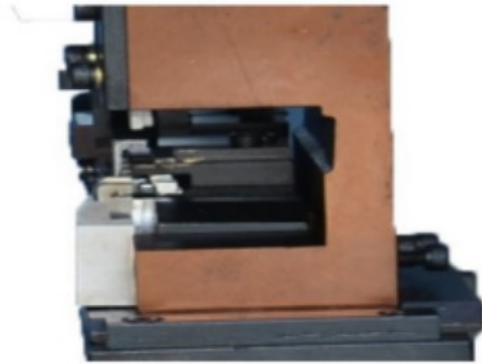
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(3) Feed adjustment

Loosen the "feed claw fixing screw" so that the "feed claw" can be inserted into the center of the terminal material belt hole, then lock the feed grab fixing screw, rotate the "crimp valve" to make it in the falling state (the purpose is to press the terminal and not let the end move, the terminal must be put down when you start crimping the terminal, otherwise the terminal will move), and then adjust the punch to the highest point in manual mode. Pull a terminal directly under the blade, manually press it down, and then push the punch to the highest point. Observe whether the terminal pushed is directly under the blade. If not, loosen the adjusting screw and manually adjust the adjusting screw so that the terminal is directly under the tool die, and then lock the adjusting screw. Then adjust the position of the slide sheet so that the terminal just exposes the material belt of the next terminal as the hole where the feeding claw is located (as shown in the figure). The feeding claw is in the square hole, and the slide sheet should cover the other holes to expose the square hole of the next terminal.

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At this point, the adjustment of the mold has been completed, you can put the wire into the position shown in the following figure, in manual mode to crimp a terminal to see how the effect is, the effect is not ideal, can be adjusted according to the above instructions. If the effect is satisfactory, you can switch to automatic mode and use the foot switch to work.

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