

# 产品说明书

Product Specifications

## NCPP-20H. 端子压着机

Numerical Control Crimping Machine

## Preface

Before using this machine, please read this book carefully, and make sure that you have paid enough attention to this book. By using this machine properly, you cannot only avoid accidents, but also prolong the life of the equipments. So please do give your attention to the operation. To make this machine work to its best, you should do as the below.

1. Please do read this book carefully and make sure that you have understood it well, and then you may carry on operation, maintenance as well as attendance.
2. If you want to transfer this machine to someone else, please transfer this book together.
3. Please keep this book where you can get at any moment, and put it in good condition.
4. We provide the customers with high standard service, 24-hour maintenance.
5. This machine has one-year guarantee (starting at the day of the assignment). During the guaranty period, if there are any problems caused by the quality, such as the machine cannot work soundly, or something abnormal happens while it is operating, please contact with our Maintenance Department or Sales Department for instant settlement.
6. Beware that the circumstances below are beyond maintenance.
  - a) Damages caused by improper use.
  - b) Damages caused by tearing down the machine wrongly.
  - c) Damages caused by using the improper voltage.
  - d) Damages caused by the force majeure.
7. Exceeding 1 year limited, we will charge you proper fee for changing the wearing parts and fittings.
8. You can either deliver the machine to our factory or ask our technicians to yours for repair. And their travel expense will be count on your if the maintaining happens beyond the guaranty.
9. You can contact us through Telephone Call, FAX, E-mail so that we may provide you with satisfied service.

## Safety handling

### SAFE HANDLING

The following: ⚠ The dangerous , ⚠ definition warned ⚠ Notice , ⚠ Consulting is as follows:

- ⚠ Injured dangerous situation;
  - ⚠ Warn: Expected wrong operation , will cause the dangerous situation of attention, sustaining a severe injury or slight injury;
  - ⚠ Notice: Expected wrong operation, will cause the dangerous situation that personnel sustain a slight injury or damage
  - ⚠ Consult: Precautions while having something to do and operating, maintaining.
- 2 , Please observe the warning item recorded of a book. The warning mark stuck on this plane is from warning very important project selected in the item.

### 1-1 BEFORE INSTALLING :

**⚠ WARN**

When hang the machine, Please confirm the machine rings become flexible to get up. In addition, when changing , please pay attention to the machine sloping to get up

### 1-2 BEFORE OPERATING:

- ⚠ WARN**
1. This machine assembles the end special-purpose machinery on the terminal station of electric wire. So should not use the one machine to carry on other pressure process.
  2. Don't transform machinery, transform control circuit, etc.
  3. Should not pull down the safety device or the back cover and change the position that is installed
  4. In order to guarantee the security, must put through the ground wire.

1-3 WHILE OPERATING:

**⚠ WARN**

- ⚠ Never operate the machine without the safety cover guard and back cover to prevent injury at hand and face.
- ⚠ At the starter motor, should make sure the Top Dead Point, in addition, must take down L-BOX WRENCH.
- ⚠ Switch off the machine and disconnect it from the main power line before to install the applicators or servicing the machine.
- ⚠ Regulate curl height of terminal, must disconnect power, and contact cutter directly to take care.
- ⚠ If two PAM phenomena take place while operating, Should stop operating immediately, and improve design with it.
- ⚠ While removing the waste material in the cutter, must disconnect the power, must use the manual tool to remove.

1-4 MAINTENANCE

**⚠ DANGEROUS**

Should pay special attention. When handle, Can't pull down and touch the control circuit. Otherwise have danger of getting an electric shock.

**⚠ WARN**

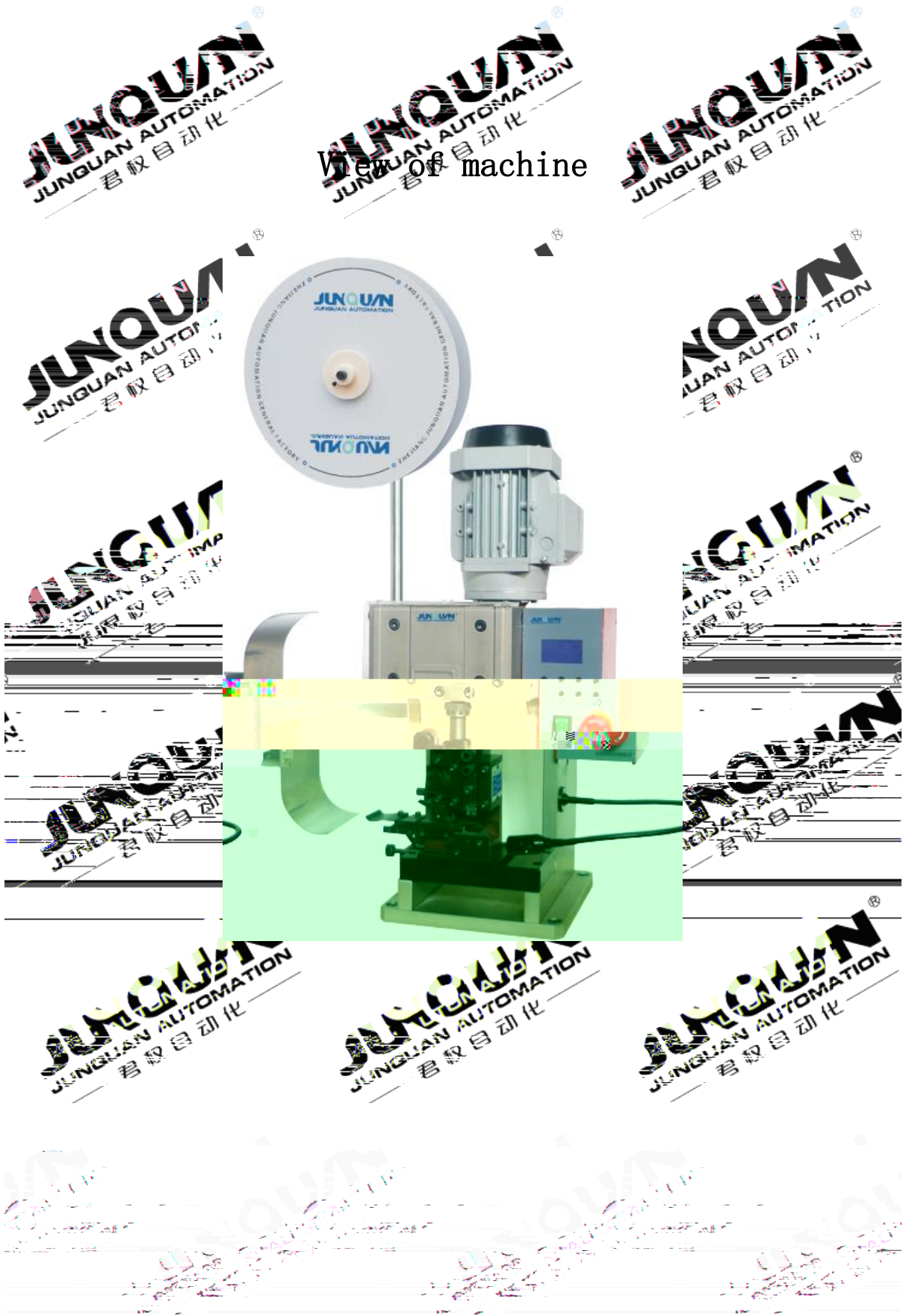
When just finishing the work, The temperature of the motor is still quite high, So should notice that don't touch with hands.

**NOTICE**

1. Should be regular maintenance, especially should confirm the interlocking (sensitive element of manual rocker arm) is normal.
2. In case of assistance on the electronic parts of the machine control to disconnect the machine from the power supply line and waiting 10 minutes after the led power is switching off before to remove the electrical box cover or operate on the clamps.
3. Hear belts and take the wheel to grit sound in the starter motor, Please adjust the elasticity of the belt in time.



View of machine



# Introduction of the external structure

		
<p>The front of electric control system</p>		
	<p>Button</p>	<p>Emergency stop switch</p>
		
<p>The behind of electric control system</p>	<p>Air outlet</p>	<p>Fuse</p>
		
	<p>Main power connector</p>	<p>Foot switch connector</p>
	<p>Main motor</p>	

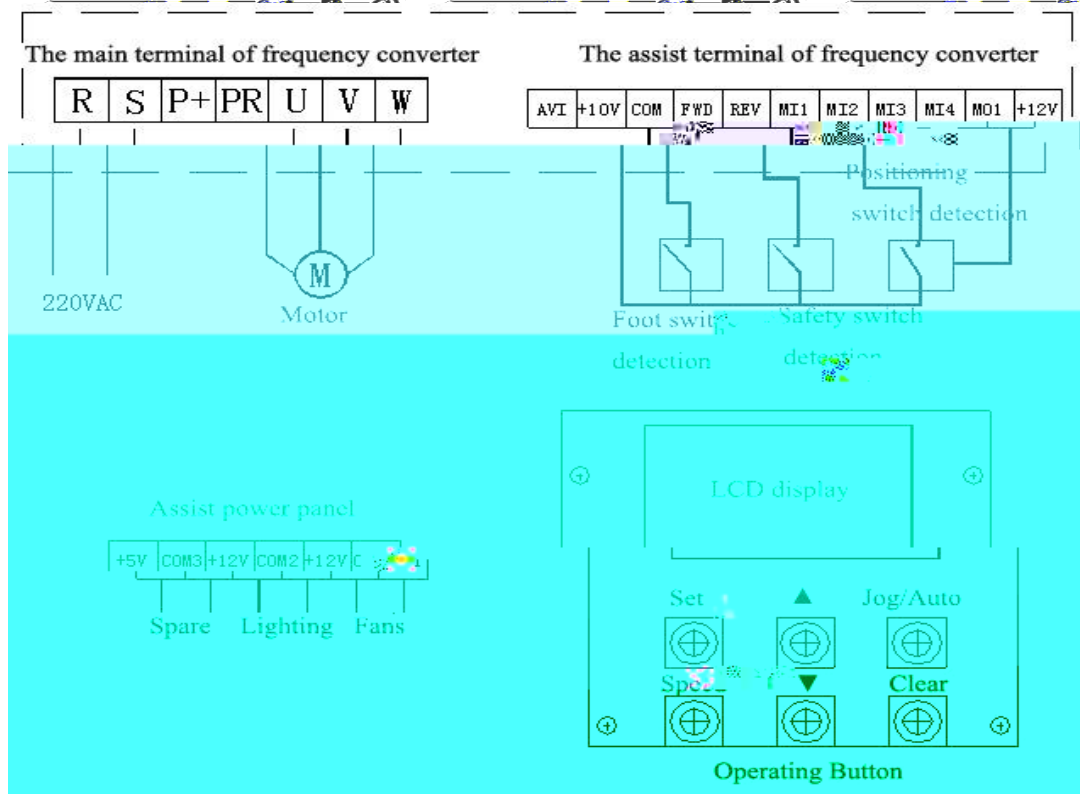
## operating instructions

### 1. Safety attentions

- 1) Power input end (R and S ) can't be connected in a wrong way with frequency converter output end (U, V and W) unless the frequency converter will be damaged.
- 2) frequency converter output end (U, V and W ) is not allowed to connect with relay ,compensating capacitor ,unless the frequency converter will be damaged .
- 3) The frequency converter must be connected with ground ,when off the power , it need time to release the high voltage in the machine ,so wait the LED light is completely extinguished then the maintenance can be carried out.

### 2 Wiring instructions

- 1) The power of operation controller comes from the host frequency converter ,user only need to insert the ten pin plug ,then display properly.
- 2) Connect the indicator light(power +12V) and fans (power +12V) as follow drawing.
- 3) The terminal operation controller of frequency converter have foot switch detection,safety switch detection and positioning switch detection,the full function are completed by frequency converter and operation panel .





## Operation button introduction

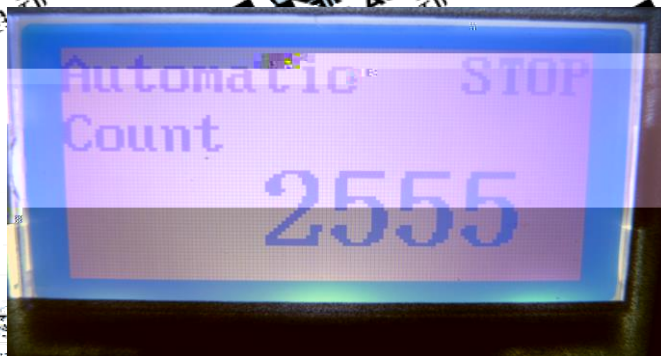
1. Automatic Interface  
(Manual Interface)



2. Operating Buttons



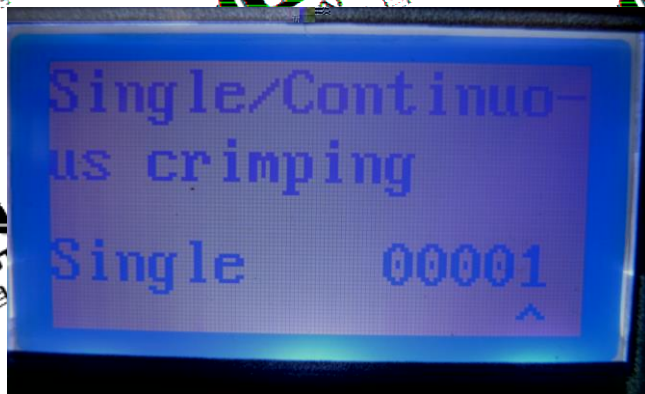
3. Manual Interface  
(Operation Button - Manual / Automatic Handover)





4. Press “Set” into the Setting interface(There are 5 items, should be press “SET” step by step) ,

1) No1 Setting:Single/Continuous crimping , Press  $\uparrow/\downarrow$  setting the quantity, the Range from 1-20 times , Single model Press setting 00001(that means Press 1 time foot switch only crimping 1 terminal , If setting 00002 Press 1 time foot switch crimping 2 terminal continuity)



2) No2 Setting: Setting the time of continuous crimping, If set the 2 or more quantity (must to set the time), for example setting 2 quantity and the time setting 1, Press the foot switch the machine will crimping 2 terminals and there is 1 second pause between crimping 2 terminal. Press the “Jog/Auto” to move the Cursor, the Rate from 0s to 20s



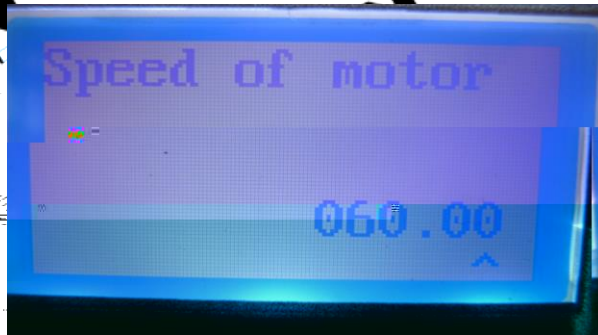
3) No3 Setting: the quantity of Processing Press  $\uparrow/\downarrow$  to setting the data Press “Jog/Auto” to move the cursor, the Range from 0-59999. In the Main interface show the processing quantity is reached, please press “Clear” 2 second it will Auto Resetting.



4) No.4 Setting: Display setting, Press ▲/▼ to setting 0:English;1:Chinese



5. Press “Speed” Key to Setting the frequency (Normal is 60Hz)  
 Press ▲/▼ to change it. After Setting ,press “Speed” back



6. Press Jog/Auto

1) The machine is default as “Auto” when turn on power.

2) “Jog “ status : Can press the ▲/▼ to adjust the punch position by motor corotate and reverse

turn

Auto status : The ▲/▼ are unavailing ,use the foot switch to work.

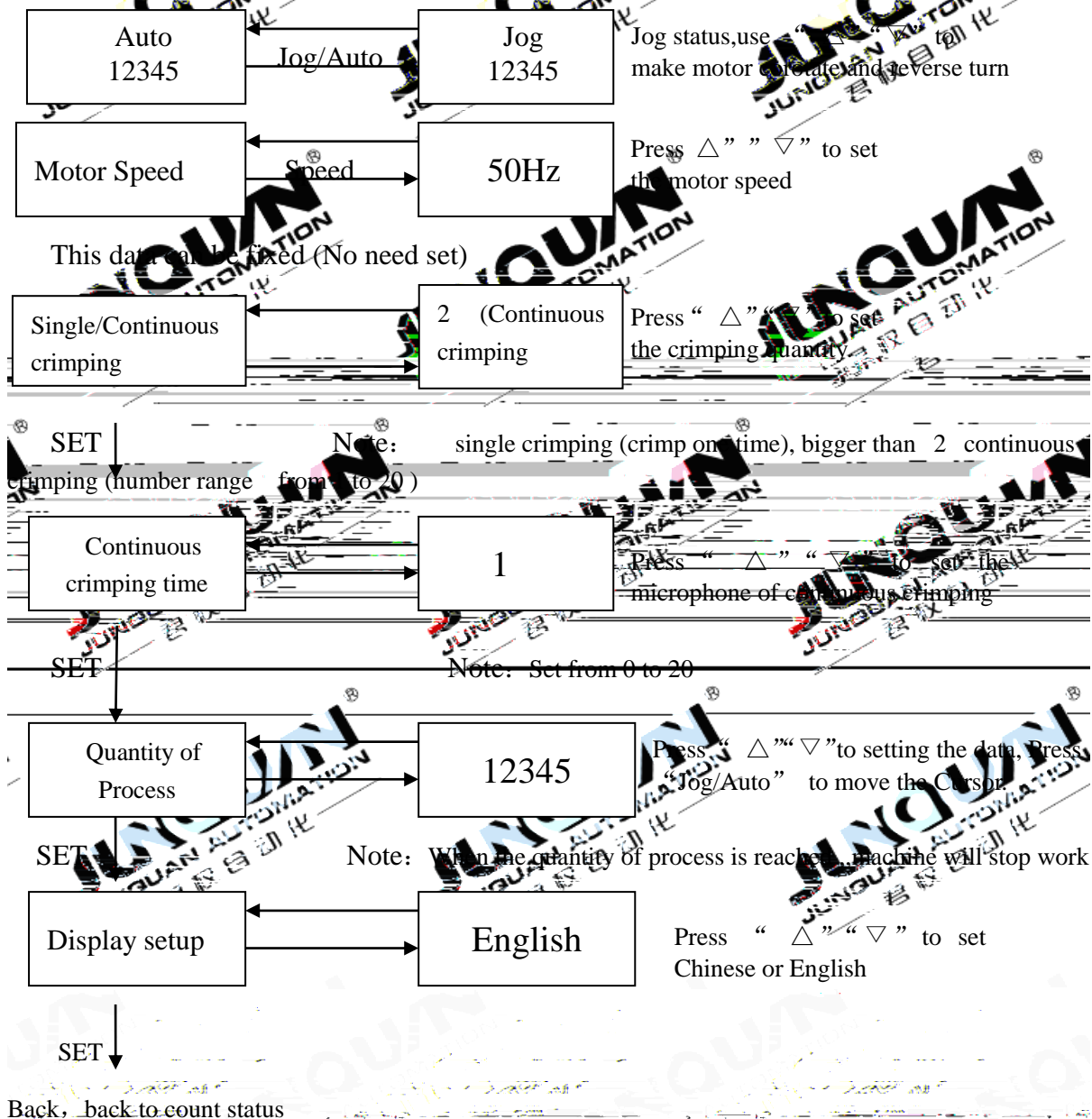
3) on Auto status ,this button Jog/Auto can be used as RESET ,it can clear the error when wrong action appear ,(for example , approach switch is unavailing) . Make the motor stopped, solenoid valve return to zero position .

7. Press Clear

On any status , press Clear , the count value will automatically return to zero,recount.

# Operating Instructions

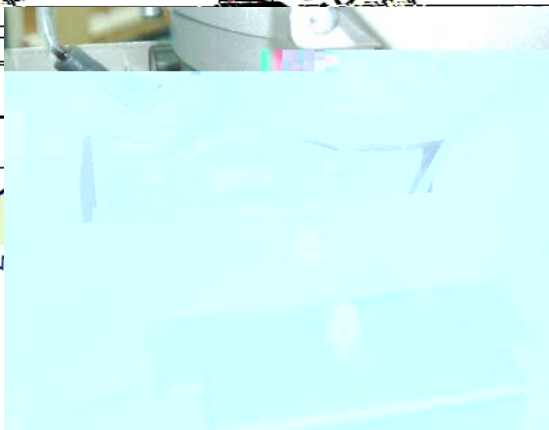
1. Accord to wiring drawing to connect, make correct then power on.
2. When power on, operation panel on, but status and flow 0.
3. After set the data, off power once, then restart, make the frequency converter back to original status, avoid wrong action.
4. The data of frequency converter have been set before, if every pls don't correction.





## Maintenance and clean

1. Before in air space, make sure the power of machine is off.
2. The machine and accessories must be used with normal load, to protect the environment and material, can't overload.
3. Wearing parts/guide block/slider/sliding bearing/ bearing
4. Check the above parts and change by qualified personnel after each 1000 hours work.
5. In order to maintain the machine works well, must clean equipment regularly with non corrosive detergent.
6. Don't use alcohol or alcohol clean the transparent protective cover (optional), only use water or soap to clean, otherwise damage shield.
7. Timely clean the areas of waste by brush, keep the crimping area cleanliness. Don't use the compressed air to clean the waste from brake.
8. Open the protective cover of the motor and clean every week.
9. Check the distance between the proximity sensor and cams, if it is 1.5mm after each 50000 times work.
10. Grease after 50 work hours using greaser (HP-R)





## Troubleshooting

Phenomenon	Reason	Solution
Machine can't start, the light of power is off	Fuse is damaged	Change the fuse
Machine can't start, the light of power is on	1. Emergency Stop Switch is locked 2. Control board is damaged. 3. The gap of the cam is closed to the sensor	1. Open Emergency Stop Switch 2. Contact with us to repair the board 3. Adjust the position of cam by manual wrench.
Machine can't braking and restart	Proximity switch is damaged or need adjust	Adjust or change the proximity switch
Machine can't braking, but can restart.	The circuit board of the machine is damaged.	Change the circuit board.

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