KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD.
TEL/WhatsApp: +86 17622605414
Mail: admin@transformercoilwindingmachine.com
Web:www.transformercoilwindingmachine.com

NAME：KXV10-PLC Debugging, Troubleshooting and Maintenance



Adjustment of the Wire Pressing Plate

Adjust the pressure of the wire pressing located in the middle of the wire storage ring to ensure that the copper wire can pass smoothly between the wire blocking plate and the wire pressing plate. Therefore, the pressure of the wire pressing plate can be appropriate for the product operation.

Adjustment of Wire Storage and Winding Counters

a. The storage line counting is a proximity sensor, which is divided into two types: normally closed type and normally open type.

b. Adjust the normally closed sensor: when the sensor touches an object, the sensor light just does not light up.

c. Adjust the normally open sensor: the sensor light turns on when the sensor contacts an object.

d. Adjust the pin-pull sensor: According to the selected induction model, observe whether the induction light lights up when the sensor contacts the steel needle. After confirming that it is normal, tighten the screws.

e. Adjust the optical fiber sensor; when fixing the optical fiber, adjust the photoelectric regulator. When not close to the object, press the SET key to set it.

Adjustment of the Support Wheel

First install the eccentric fixed support wheel, use this wheel as the standard, use a leveler to adjust other support wheels, and adjust each support wheel to the same level.

Common fault causes and solutions:

1. Hang-up appears:

1-1. Confirm whether the line blocking plate is adjusted to the correct position

1-2. The wire pressing plate is pressed too tightly.

1-3. Belt tension is too large

1-4. The support wheels are not on the same horizontal plane

2. Injury line appears:

2-1. The belt adhesive force is too large

2-2. The surface of the line baffle is not smooth enough

2-3. The counting needle is too sharp.

2-4. The wire storage ring is not adjusted properly and is oscillating.

2-5. Winding speed is too fast

3. Disconnection occurs:

3-1. The thread blocking plate is not adjusted properly, causing the thread to break after hanging the thread or the support wheel to hang the thread and causing the

thread to break.

3-2. The connection between the line blocking plate and the line pressing plate is too tight.

3-3. The belt adhesive force is too large

3-4. Winding speed is too fast

4. The machine stops running:

4-1. The driver protects itself due to excessive torque.

4-2. The fuse is blown out

Special precautions during machine operation

1. It is forbidden to start the machine if the wire storage ring is not closed (open); when the machine is running when the wire storage ring is open, it will cause the wire storage ring to fly away from the machine and deform or even break.

2. After completing the product, the wire storage ring should be reset if it is no longer in production. Leaving the opening open for a long time may easily deform the ring.

3. When the clamp is not in use, the thimble needs to be pushed up

4. When the machine is not in use, the adhesive force of the belt should be removed.

Later maintenance of the machine

1. Things to note when using wire storage trough:

1-1. When the wire storage trough is not in use, you need to pay attention to rust prevention at all times and do not place it in a humid place.

1-2. The wire storage trough is made of special metal. Please handle it with care when using it. Do not bend or drop it.

1-3. When using the wire storage trough, the opening distance should not be too large, otherwise the upper side of the separated part of the wire storage trough will be prone to slight cracks.

Deformation, long-term operation will cause damage to the wire storage trough.

1-4. The separated part of the wire storage trough should not be too high than the iron core roller, otherwise the upper side of the separated part of the wire storage trough will easily become thin.

Micro deformation affects the quality of winding products

1-5. When using the support wheel that is matched with the cable storage trough, attention must be paid to the travel time of the cable storage trough due to deformation or damage to the surface of the rubber wheel.

Abnormal shaking may cause damage

1-6. When using the support wheel matched with the cable storage trough, attention must be paid to the absolute balance setting of the rubber wheel, such as incorrect assembly or use.

If incorrect, it will cause abnormal shaking and damage to the cable storage trough during operation.

1-7. For belt-type cable storage ducts, attention should be paid to the even pressure setting exerted by the transmission belt.

1-8. Before using each type of wire storage trough, pay attention to the applicable wire diameter range to avoid reducing the life of the wire storage trough or causing damage.

2. Preventing machine parts from rusting and treating the machine surface:

2-1. Try to avoid dust, oil mist and corrosive gases in the chassis to protect the motor and driver.

2-2. The machine should be wiped clean after get off work every day

2-3. Anti-rust oil should be applied regularly to some blackened parts on the machine head to prevent rust.

Packaging

Packaging Material: Carton/Wooden case with foam inside.

1. General package(Paper carton or plastic bag): For small equipped parts for Digital CNC Wire Coil Winding Machine, Package it with form and pack paper to guarantee unbroken during the transport.

2.Wooden case package: For larger scale Digital CNC Wire Coil Winding Machine ,we have special skilled carpenter, who would make the proper wooden case with exact thickness, density,length. The up arrow ↑marked on the outer wooden case. Buffer material would be put in the wooden case to prevent crack and shock.

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Market Area

We work closely with Southeast Asia, European, America, South America, Australia, New Zealand partners to provide local sales, support and service assistance for coil winding machines.

FACTORY:

KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD.

Founded in 1993, KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD. has been a well-known manufacturing excellent performance winding machines together with associated production and technology. KIOXIA LIGHT RING provide highly cost effective manufacturing solutions for the production of the wound components of all types such as transformers,chokes etc.

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KIOXIA LIGHT RING EQUIPMENT GROUP CO.,LTD.

Add: Building G, No.209 Zhonghuan East Road, Free Trade Zone (Airport Economic Zone), Tianjin