



GREWIN INDUSTRIAL GROUP CO.,LTD.

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GW-90GZ Full Automatic Hook Winding Machine



GREWIN INDUSTRIAL GROUP CO.,LTD.

Add: The fourth floor A-A3 zone aviation business area,Dongli Distr,Tianjin,China.



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Machine Working Diagram



Alarm, the green light is on when it is working, and the red light is on when it is normal

Vibration plate, adjustable 633-1495 magnetic core universal

Incoming detection wheel

Display Screen

Wire wheel

Switch

Manual activation of the pause

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Equipment can be wound around product parameters

No.	Serial Number	Parameter	备注
1	Core Specifications	6*3*3-10*6*4	
2	Cable Length Requirements	Within 200CM	
3	Wire Diameter Requirements	0.25-0.65mm	
4	Production Capacity	0.8 seconds/circle	
5	Accessory Requirements	Replacement of magnetic core specifications requires replacement of guide rails and clips	
6	Other Accessories Required	If the wire diameter changes more than 0.2mm, the crochet hook model needs to be replaced	

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Equipment introduction

The company's GW-90GZ winding machine is mainly for small magnetic ring inductance winding, which can realize single and double wire parallel winding, and has the characteristics of high production capacity, stable performance, and high cost performance of the machine.

Equipment installation

1. After the equipment is disassembled, it is necessary to check whether there is a binding tie on the rotating part of the machine. If it needs to be disassembled, it is then connected to the air and plugged in.
2. In order to ensure the service life of the equipment, the air pipe connected to the machine must have clean air pressure after oil-free filtered water. To ensure that the solenoid valve and cylinder have a service life.
3. The power socket of the equipment must be connected with a ground wire to prevent lightning strikes or leakage.
4. The air intake pressure of the equipment must reach 0.5MPa.

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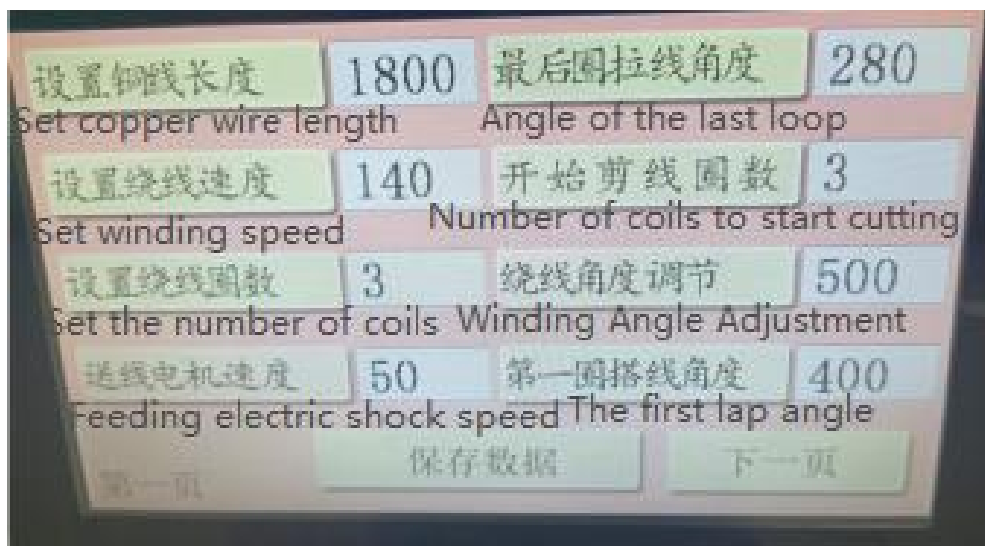
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Equipment system parameter setting



系统密码

168168



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1. Set the length of the copper wire: the actual required length of the product depends on the number of copper wires. The value of 100 is about 5MM long, which is set according to the required wire length of the product.

2. Set winding speed: The factory setting of winding speed is 50. The larger the number, the slower the speed, and the smaller the speed, the faster it is. Generally, it can be set to 50.

3. Set the number of coils: the value of the number of coils is the actual number of coils. If it is set to 10 coils, the machine will actually wind 10 coils.

4. Wire feeding motor speed: The factory setting of the wire feeding motor speed is 50. The larger the number, the slower the speed, and the smaller the speed, the faster it is. Generally, it can be set to 50.

5. Pulling angle of the last circle: This parameter is to adjust the position of the tail line after the product is wound. If no value is set, the position of the tail line will not be processed, that is, the position where the product comes out when the last circle of crochet is pulled down is the position.

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The set quantity The size is to adjust the position of the tail line. The larger the number is, the higher the position of the tail line will be brought up.

6. The number of coils to start trimming: set which coil to trim. It must be less than or equal to the number of coils, if it is greater than the number of coils, the thread will not be trimmed.

7. Multi-rotation angle of the first circle: This angle is used to set the line spacing gap between the first circle line and the second circle line.

8. Turn on and cut again: If this value is set to 0, this function will not be turned on, and if it is set to 1, this function will be turned on. It is mainly for products with thick threads, so as to prevent the thread from being cut once.

9. Number of turns for thread trimming and return to zero: This parameter is used to set the reset time of the thread feeding and thread trimming mechanism, and the set value of this number of turns should not be large.

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10. Multi-rotation angle of the middle circle: This parameter is mainly set for the higher size of the customer's product, which means that the top position of the product is set at an angle without winding.

11. Angle of crochet first turn: Generally, no value should be set for this parameter.

12. Double clip and single clip: If the parameter is set to 1, the clips of the two clip products work at the same time, and if it is set to 0, one clip and one clip work.

13. Suspended work quantity: This parameter is for the convenience of counting and packaging separately. If it is set to 500, the machine will alarm once after winding 500 products. Set to 0 to disable this feature.

14. Detect the number of copper wires: set to 2 to detect whether there is wire feeding, set to 0 to close this function. Set to 1 to detect only one line.

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Equipment maintenance

1. It is necessary to check the first piece of the wound product every day to check whether the wound product is defective or damaged.
2. Every 10 days or so, it is necessary to spray 3-5 times of anti-rust oil on the guide rail and slider of the machine for lubrication.
3. Regularly release the water in the filter connected to the outside of the machine, so as not to affect the service life of the cylinder and solenoid valve due to too much water in the air pipe.
4. Regularly clean the dust on the machine table.
5. When the machine is not in use, it is necessary to cut off the power, gas and dust protection in time.

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PRACTICAL APPLICATION :

TRAINING CUSTOMER TO OPERATE WINDING MACHNE :

1.All service engineers with 10 years experience are gotten special technology training, who can deal with various breakdown problem.

2.Guide the user to use accurately and how to maintain the Digital CNC Wire Coil Winding Machine.

Provide free consultation about production process technology of electronic products.

3.In order to guarantee the machine used normally, we'd have training on how to operate, use and maintain our product by English manual, video, guiding on line.

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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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FACTORY:

We-GREWIN INDUSTRIAL GROUP is expert in winding machines line s for 28 Years.

Our Grewin have ISO9001:2015,CE approvals,Machines'Patents,"high-te ch enterprises"by the government.



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