Digital Control Coil Winding Machine

Operation Manual VER. CNC-200A

WH-761
WH-762
WH-763
WH-764
WH-751
WH-752
WH-800
WH-800I

TÜV CERT
DIN EN ISO 9002
Zertifikat: 09100 89244

CE

CAUTION

Before operating machine, please read this manual clearly.

The warranty limitation of winding machine extends to the first twelve (12) months beginning on the machinery shipping date. If the product has been subject at abnormal use ,improper installation, the consumer shall have no coverage under this limited warranty.

WARNING

To prevent fire or electric shock by accident, please don't let the machine get wet.

To avoid getting electric shock, please don't open the machine case without authorization. Only qualified service engineer can repair the equipment.

PACKAGE CONTAINS

Every package of machine should have following components.

1.Main structure of machine.....
.....1 SET

2.Operation manual .....1 BOOK

3.Tools box..... ..1 SET

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PREPARATION BEFORE OPERATION

INSTRUCTION FOR MACHINE TYPE

WH-761

One-spindle digital high-speed winding machine. It can make one product at one time.

It has one set of wire barrel, tension and spread structure.

WH-762

Two-spindles digital high-speed winding machine. It can make two products at one time.

It has two sets of wire barrel, tension and spread structure.

WH-763

Three-spindles digital high-speed winding machine. It can make three products at one time.

It has three sets of wire barrel, tension and spread structure.

WH-764

Four-spindles digital high-speed winding machine. It can make four products at one time.

It has four sets of wire barrel, tension and spread structure.

WH-751

One-spindle digital winding machine. It can make one product at one time.

It has one set tension and spread structure.

WH-752

Two-spindles digital winding machine. It can make two products at one time.

It has two sets tension and spread structure.

WH-800

One-spindle digital winding machine. It can make one product at one time.

There is insolation tape and margin tape device with this model.

It has one set tension and spread structure.

WH-800i

Two-spindles digital winding machine. It can make two products at one time.

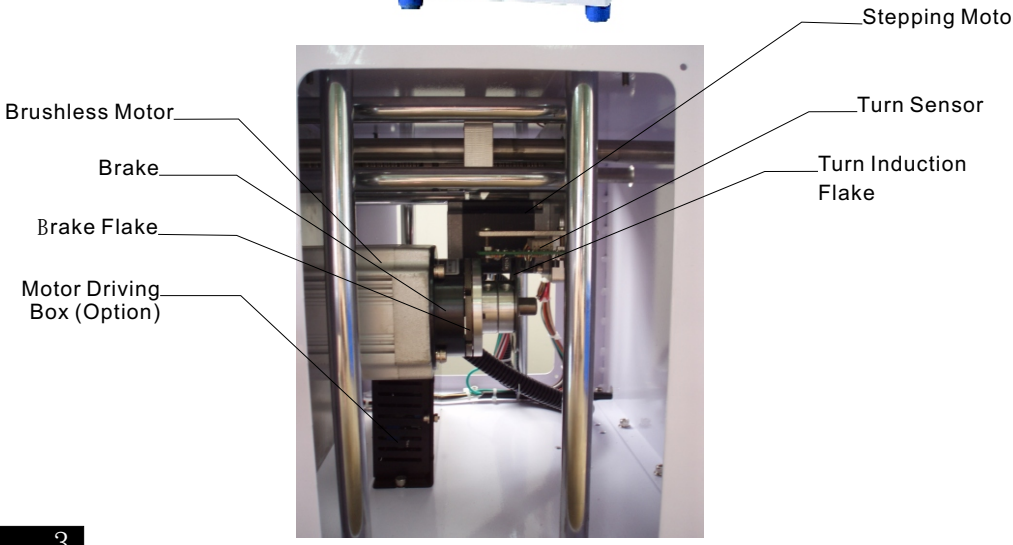
There is insolation tape device with this model

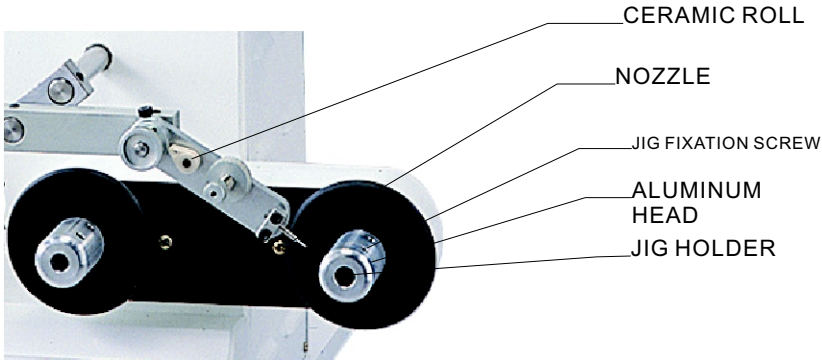
It has two sets tension and spread structure..

DETAILS FOR THE STRUCTURE

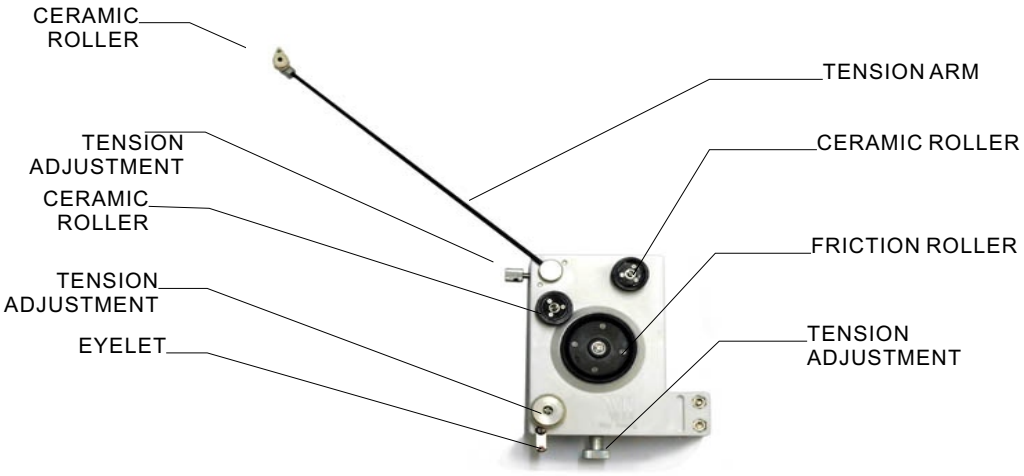
Please use the tools and accessories in the toolbox to finish making up the machine. The details for the structure is as follows.

WH-761～764

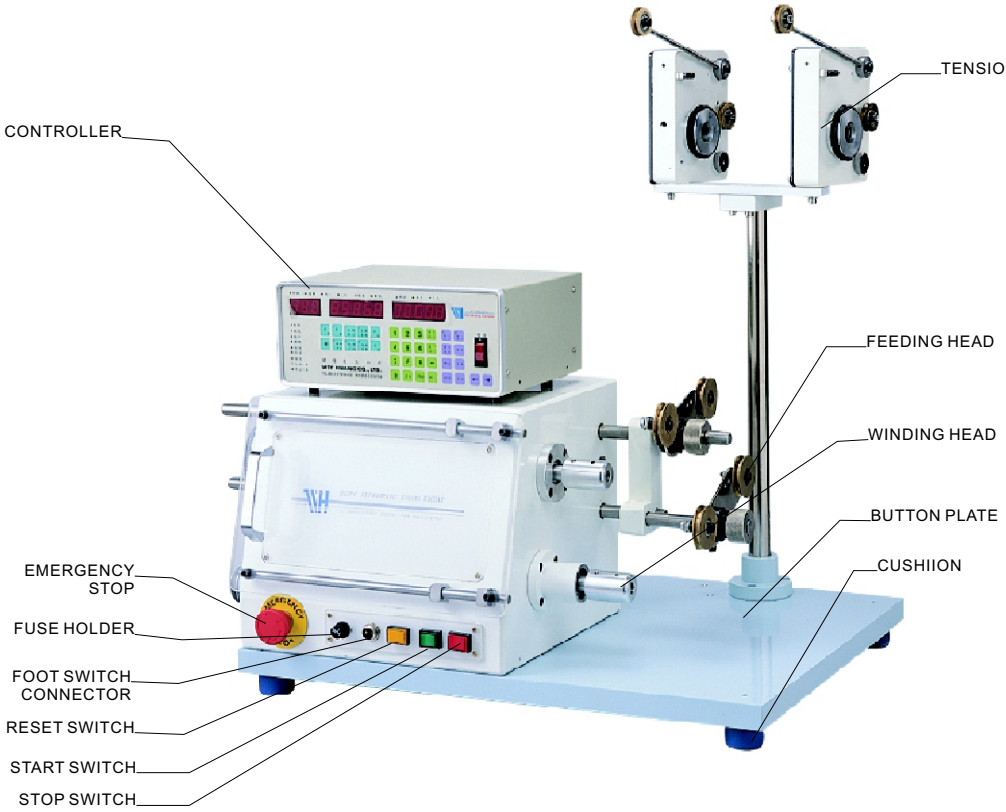


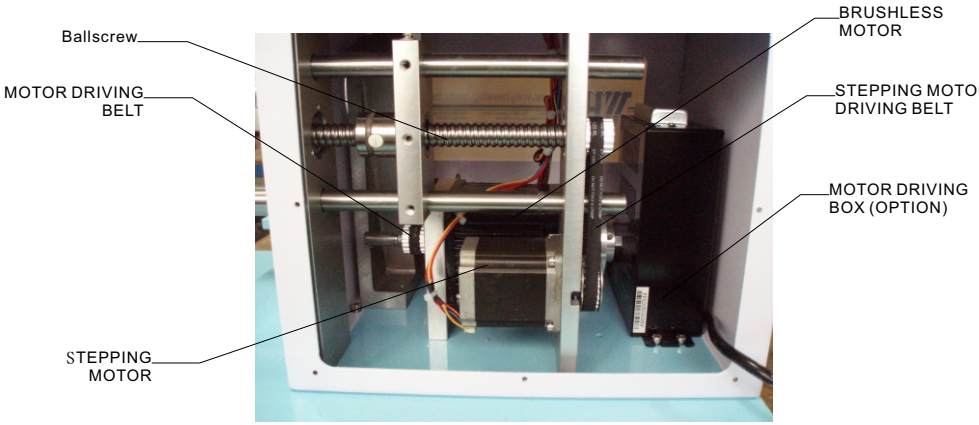


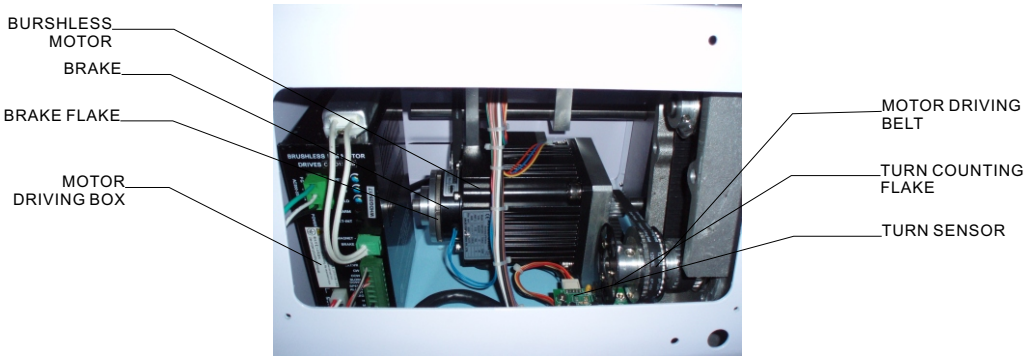
FEEDER HEAD & WINDING HEAD



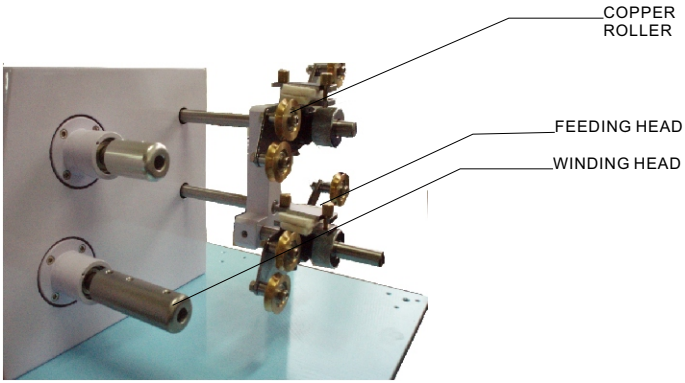
TENSION


TENSION
CONTROLLER
FEEDING HEAD
WINDING HEAD
BUTTON PLATE
CUSHIION
EMERGENCY STOP
FUSE HOLDER
FOOT SWITCH CONNECTOR
RESET SWITCH
START SWITCH
STOP SWITCH

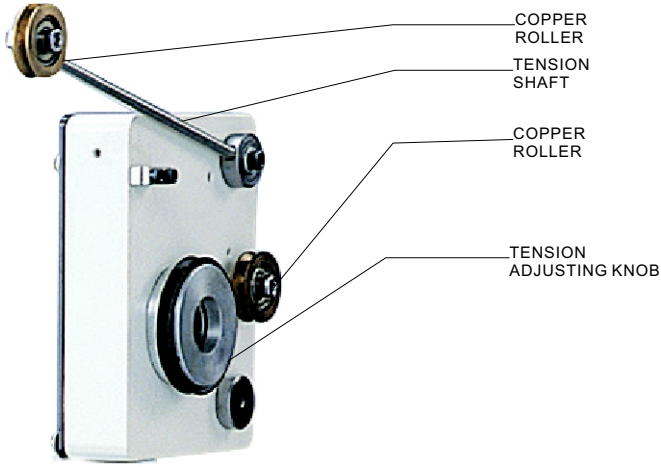

Ballscrew
MOTOR DRIVING BELT
STEPPING MOTOR
BRUSHLESS MOTOR
STEPPING MOTOR DRIVING BELT
MOTOR DRIVING BOX (OPTION)



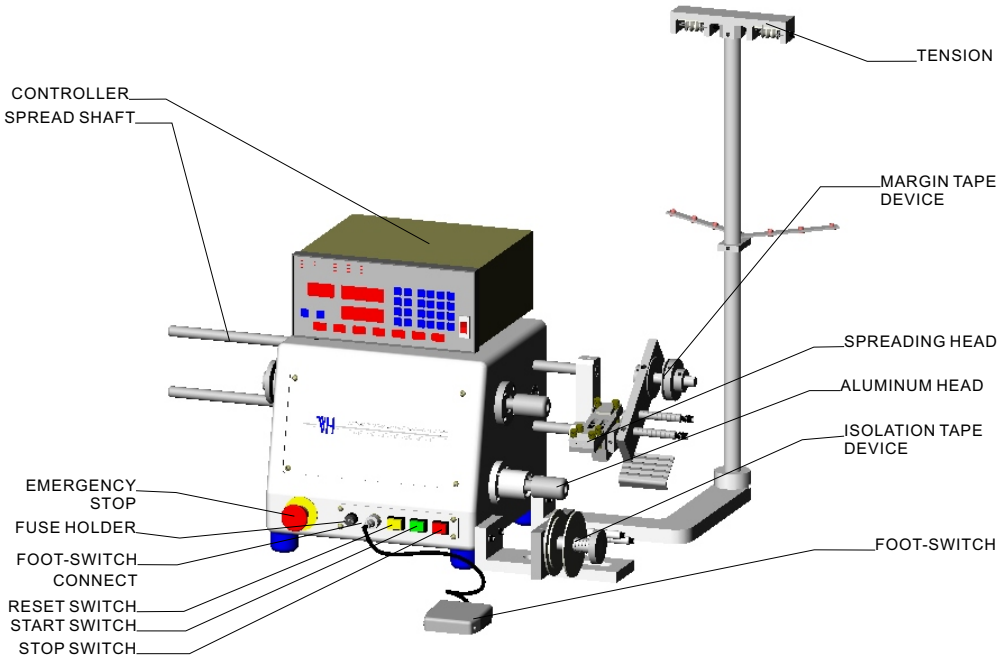
DRIVING STRUCTURE

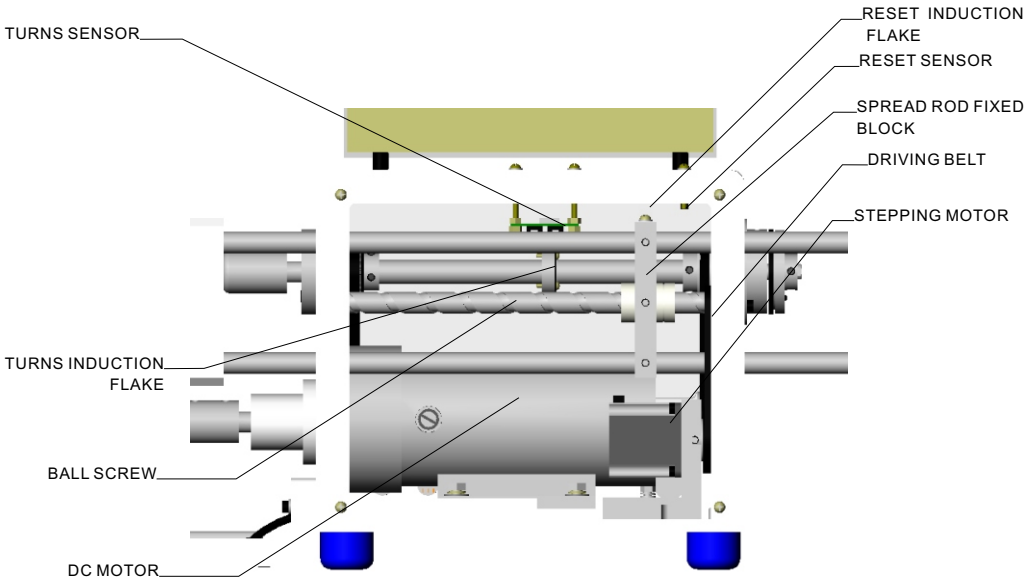


FEEDING HEAD & WINDING HEAD

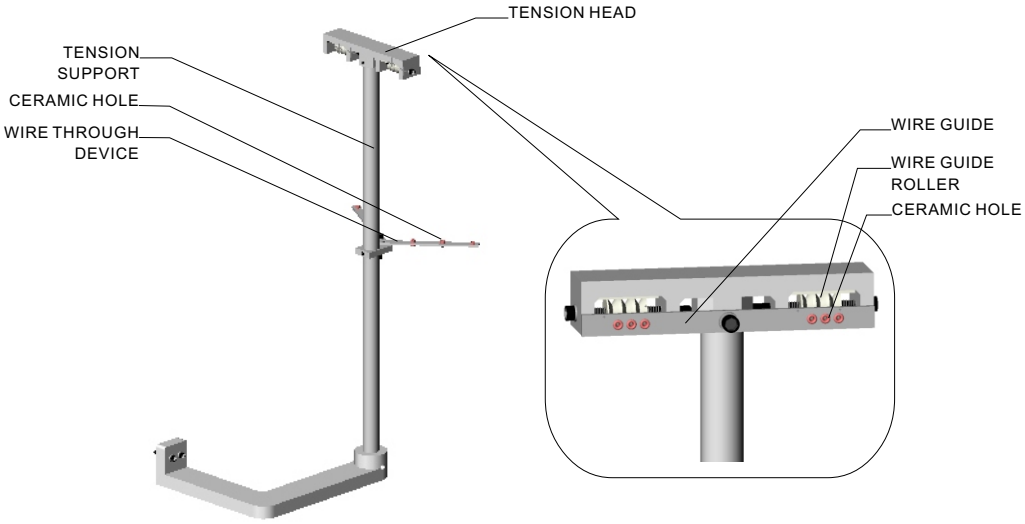


TENSION

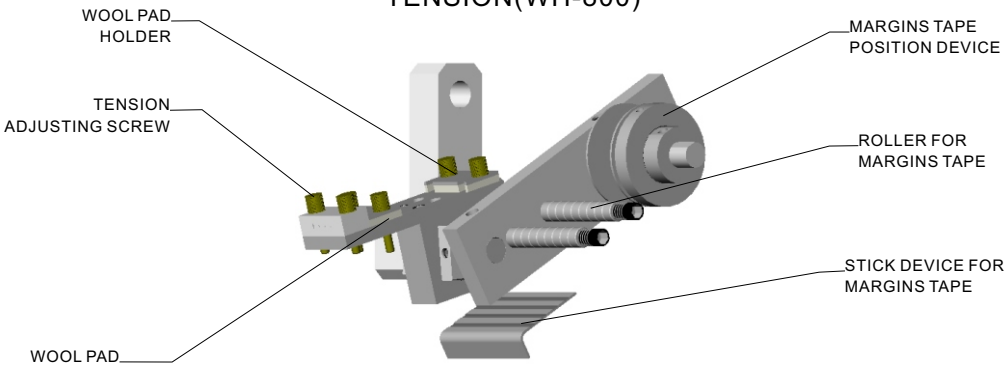

TENSION
CONTROLLER
SPREAD SHAFT
MARGIN TAPE DEVICE
SPREADING HEAD
ALUMINUM HEAD
ISOLATION TAPE DEVICE
EMERGENCY STOP
FUSE HOLDER
FOOT-SWITCH CONNECT
RESET SWITCH
START SWITCH
STOP SWITCH
FOOT-SWITCH


TURNS SENSOR
RESET INDUCTION FLAKE
RESET SENSOR
SPREAD ROD FIXED BLOCK
DRIVING BELT
STEPPING MOTOR
TURNS INDUCTION FLAKE
BALL SCREW
DC MOTOR

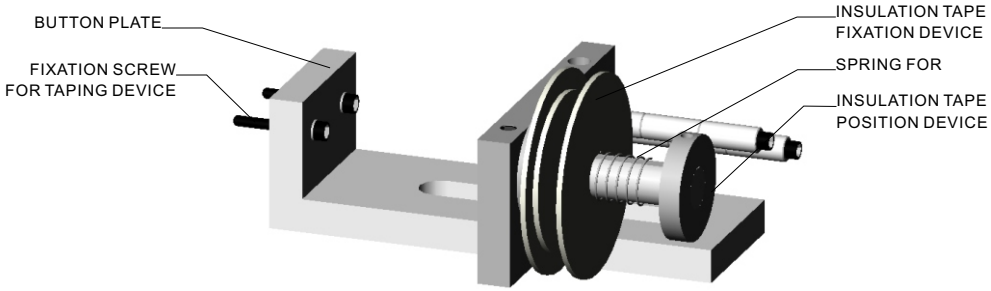
WH-800



TENSION(WH-800)



SPREAD HEAD & MARGIN TAPING DEVICE(WH-800)



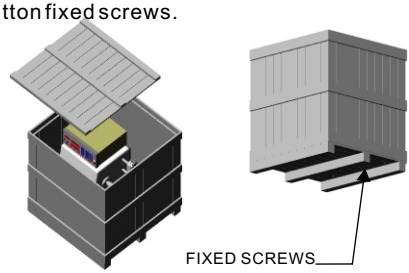
INSULATION TAPING DEVICE(WH-800)

INSTALL BEFORE OPERATION

MOVING & SETTING DOWN

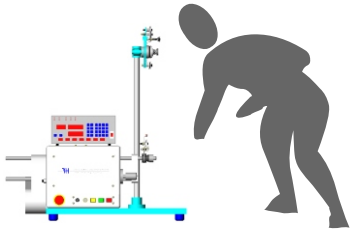
RELEASE THE PACKAGE

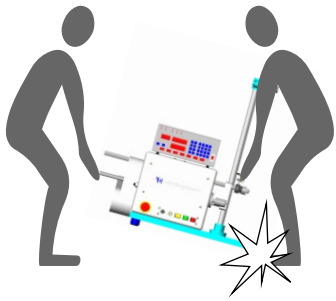
The machine is packaged with wooden case . Please be careful to release the upper cover of the wooden case, and then release the button fixed screws.

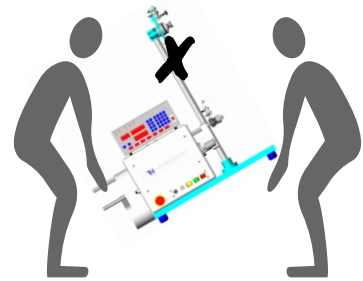


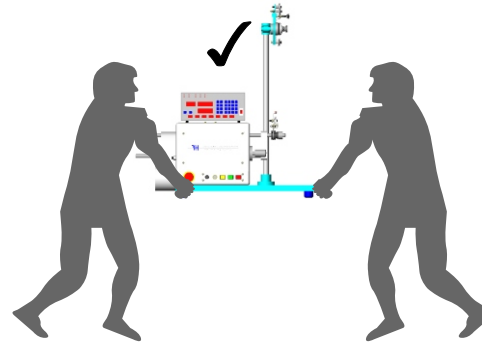
MOVE

When moving the machine, please especially pay attention to the safety problems. It needs two people to move the machine at the same time. When moving, you will have to keep the steady of the machine and watch out not to drop on the ground.



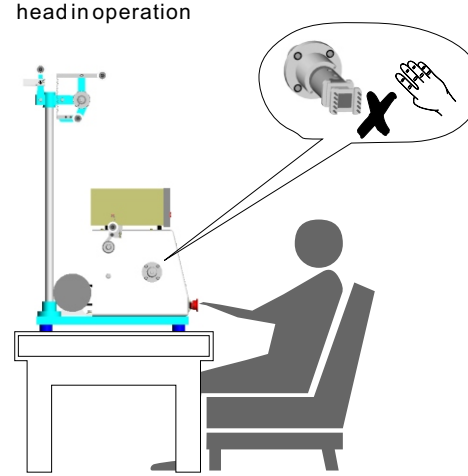






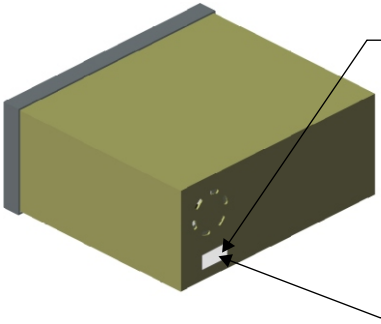
PUTTING DOWN

The machine need to set on a steady working table and the operator need to keep the safe distance away the machine. Be careful when operating and don't touch the winding head in operation



POWER SOURCE

Choice of voltage for AC 110V, 220V power source at 50/60 HZ for Wey Hwang winding machine. Please follow the instruction behind the controller get the right power source.



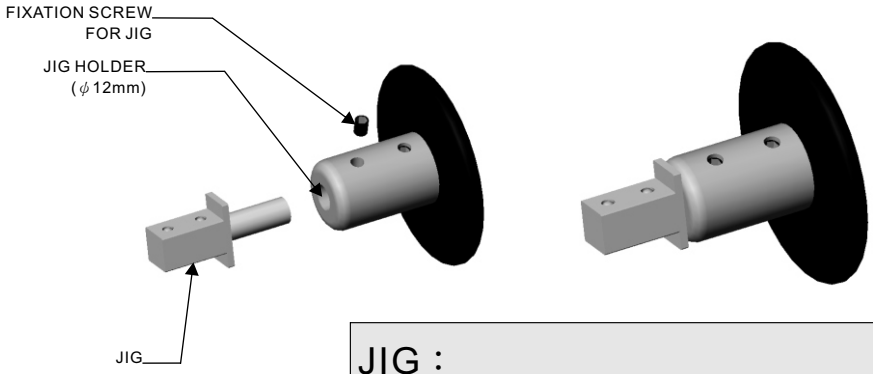
WARNING:

Wrong power source will damage the components.

And it might cause the danger of fire or electric

FIXATION FOR JIG

Following the instruction to put the jig on machine. Using the wrench in the toolbox to turn the screw tightly to fix the jig. (Jig is not the accessory with the winding machine.)



JIG :

JIG is using for fixing the bobbin on winding head. Different bobbin uses different jig. It's made according to the size of each bobbin. And it's not the accessory with the winding machine.

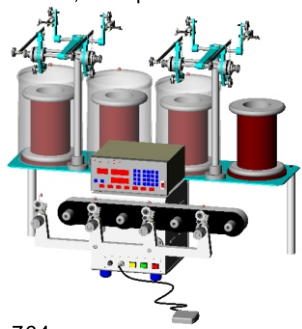
SET UP WIRE FEEDING SYSTEM

Follow step one to three, to put the wires on the machine.

1

WH-761~764:

Put wire and wire barrel in order on the barrel tray, let the wire cross the ceramic hole on the barrel lid, then put the lid on.



WH-761~764:

Put wire on the rubber plate, pull wire cross the ceramic hole on the barrel lid, then put the lid on.

2

Pull wire through wool pad to the end of the tension to fix on the tension. It's has three different setting ways (shown as the following pictures) by different wire size range.

DRAWING A

Largest tension, suitable for bigger wire size.

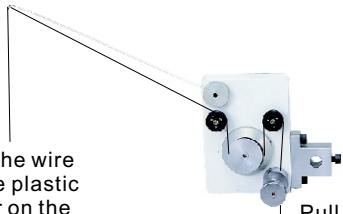
DRAWING B

Normal tension, suitable for middle wire size.

DRAWING C

Smallest tension, suitable for smaller wire size.

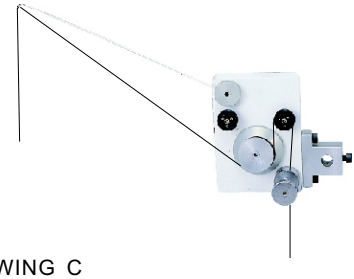
DRAWING A



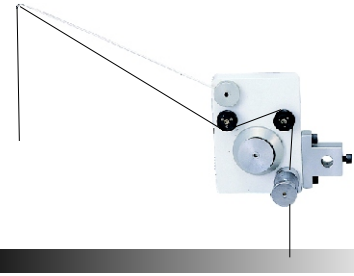
Pull the wire to the plastic roller on the spread head.

Pull the wire from the wire barrel.

DRAWING B

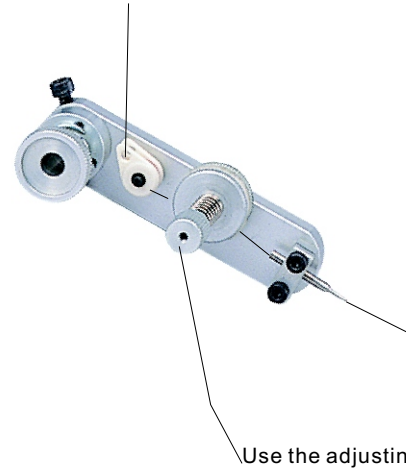


DRAWING C



3

Pull down the wire from tension and cross the ceramic roller and wool pad.



Use the adjusting screw to adjust wool pad.

WH-800 Follow the step one to four and set up the wire and tape on the machine.

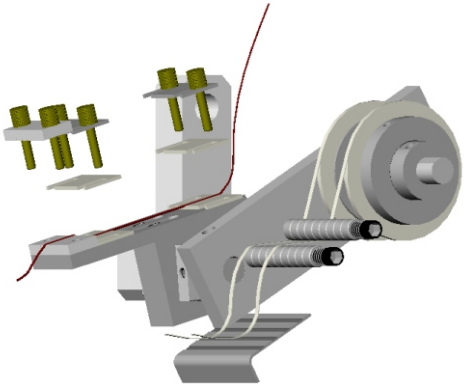
1

Arrange the wire in the back of the machine or on the ground and let the wire pass the middle through ceramic cavity and then pulled the wire to the tension head and pass through wire guide and wire rollers.

2

Loose the tension screws on the spread head and let the wire pass the front and back woolen pads. Choose the most suitable size wire cavity to let wire pass through and tighten the tension screws.

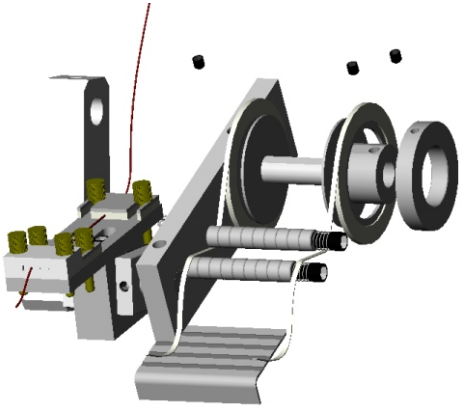
There are four size wire cavity. You can choose by the wire thinness or you can set in



3

Loose the fixed screws and then put the margins tape in the fixed cavity and adjust the suitable place to fix it.

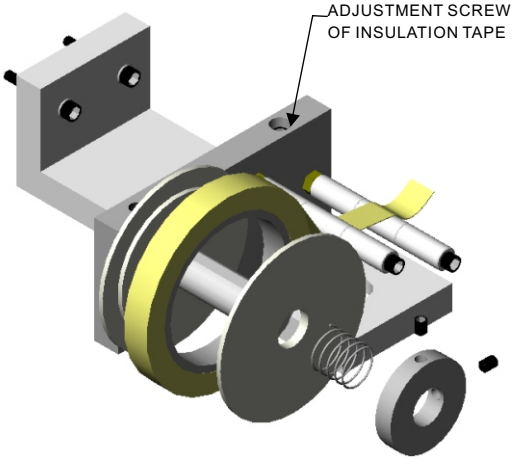
The margins tape is wound between the bobbin both size, so the distance should be adjusted by different product.



4

Loose the fixed screws and then put the insulation tape in the fixed cavity and adjust the suitable place to fix it.

The insulation tape is wound between the bobbin, so the distance should be adjusted by different product.



BASIC OPERATION

OPERATION FOR CONTROLLER

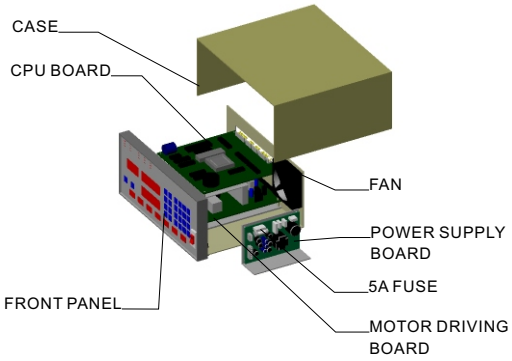
MAIN FEATURE

Digital winding machine uses the CWC-01 winding machine controller. Have following features.

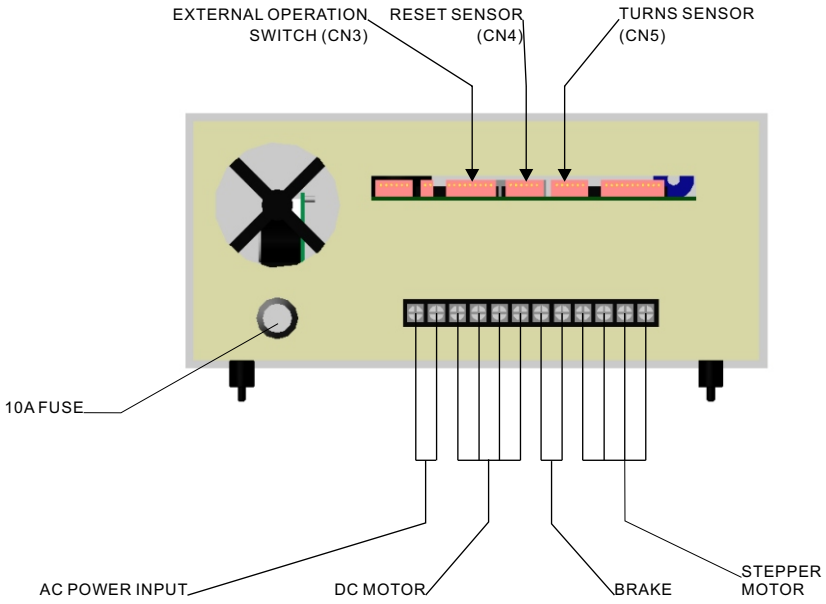
- ◆ Microprocessor design, easy for program-setting handing.
- ◆ Winding speed can be specified using the front panel keyboard, resulting in easy programming of multi-step, multi-speeding setting.
- ◆ Stepper motor driving by electric current circuit has high-speed spreading and high sensitive.
- ◆ Large memory capacity, capable of storing up to 999 step program with off-power memory retention.

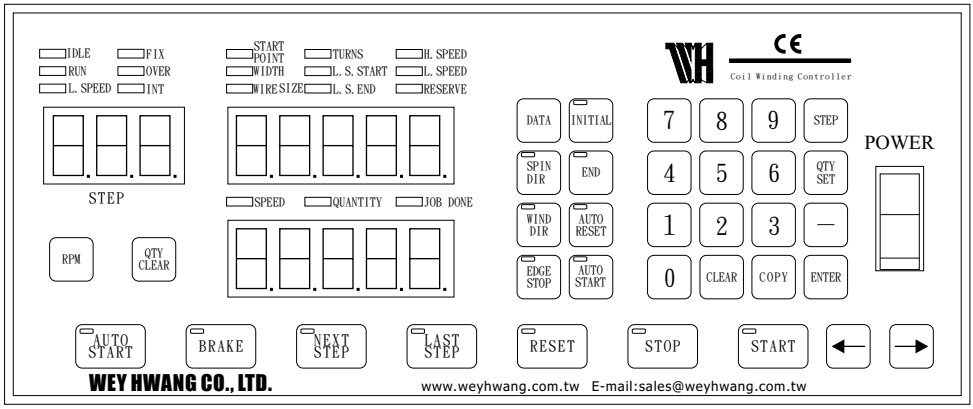
COMPONENT OF CONTROLLER

CWC-01 controller has following parts :



THE CONNECTOR DRAFT BACK OF THE CONTROLLER BOX





BUTTON:

0 ~ 9 : 10 Key; for entering numerical values.

STEP : Enter into "Edit" Mode.

QTY SET : Specify target production quantity.

— : During programming, back to previous step.

ENTER : During programming, memorize data.

CLEAR : During programming, reset current data to zero.

COPY : During programming, copy data of previous step into current parameter.

INITIAL : Specify starting step in memory.

END : Specify end step in memory.

DATA : During programming, select internal function item. During operating, switch the display for total turns or the position of spreading shaft.

SPIN DIR : During programming, selecting guiding direction. Choose moving forward or backward.

WIND DIR : During programming, select winding direction. Choose winding counter-clockwise or anti-clockwise.

EDGE STOP : During programming, select whether or not to stop at the two edges.

AUTO RESET : During programming, select whether to have auto-reset function for start point or not.

AUTO START : During programming, select whether to have auto-start function.

RPM : Switch display for piece counting and RPM.

QTY CLEAR : Clear the piece counter to zero.

AUTO : Switch between auto and non-auto mode.

BRAKE : Select whether brake will function during stop.

NEXT STEP : During pause mode, skip current step to next step.

LAST STEP : During pause mode, back to the previous step.

RESET : At any mode, stop current operation and back to ready mode.

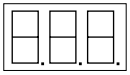
STOP : Pause during winding.

START : Restart during pause mode.

← : While stop, adjusting the position of spreading head.

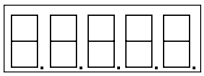
→ :While stop, adjusting the position of spreading head.

Digital Display:



Step Display:
Shows current step number for winding or programming.

Parameter Display:
During programming, shows the edit data. Or shows the exact winding turns or spindle position under pause mode.



Piece Counter Display:
Shows the piece counting or speed of machine (RPM).

Status Indications:

IDLE:
Lit means in ready mode; not lit means in winding or programming progress. Flash means under pause mode..

RUN:
Lit means in winding progress;

L. SPEED:
During winding , lit means low speed winding; not lit means high speed winding.

FIX:
Lit means spreading shaft is fixing the start point. Or reset to the original point.

OVER:
Lit means winding is speeding, spreading shaft and winding spindle is out of synchronization.

SPEED:
Lit means the piece count display shows the winding speed (RPM)..

QUANTITY:
Lit means the piece count display shows the piece counting.

JOB DONE:
Will light while reaching the setting quantity.

CONFIGURATION SETTING

In the idle mode, press the following key pads, the parameter display will show the configuration setting for the item. If you don't want to change the setting, press [ENTER] returning to the ready mode. If you want to change the setting, please press [−] at first then input the new setting number, after finishing changing the setting number, press [ENTER] returning to the idle mode.

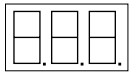
Configuration setting for every item is as following: (the following settings are for f668 edition, other editions maybe have a little bit different.)

CHOICE OF OPERATING MODE: [STEP] [DATA] [0]

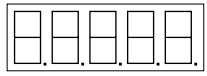
Getting into the configuration mode, parameter display will display eight digits representing eight configuration selections respectively.

Changing the setting mode, please press [−] at first, after the stop showing on the parameter display, press [1] ~ [8] to change the original setting. Finishing changing the setting mode press [ENTER] to returning to the idle mode.

For each number means :



8 7 6



5 4 3 2 1

WARNING:

The incorrect setting up may cause the irregular operation and result in the breakdown.

If you are not the pro operator, don't set up by yourself.

1 −**POSITION SPEED**: the speed at which the spreading shaft is moving when positioning the starting position or returning to the zero position. Pressing [1] key to select.
0 is high speed and 1 is low speed.

2 −**MOVING INCREMENT**: travel increment of spreading shaft. Pressing [2] key to select.
1 is 1:1, 2 is 2:1, 4 is 4:1.

3 −**ORIGINAL POSITION**: selecting the original position of spreading shaft and turns counting mode. Pressing [3] key to select.
0 represents having original position and the absolute counting mode.
1 represents having no original position and the relative counting mode.

4 −**EDGE STOP**: when the spreading position reach to the edge, to select slow down the speed or not. Pressing [4] key to select.
0 represents not to slow down the speed.

5 – **BRAKE SELECTION**: When the spreading speed turning low speed from high speed, to select brake for a short period or not. Pressing [5] key to select.
0 is don't have to brake.
1 is needed to brake for a short period.

6 – **TURN'S UNIT**: Parameter display displays the turns, select the turn's unit. Pressing [6] key to select.
0 represents 0.1 turn for turn's unit.
1 represents 1 turn for turn's unit.

7 – **MEASUREMENT UNIT**: Select the spreading shaft measurement unit. Pressing [7] key to select.
0 represents the metric system, all the measurement unit concern about the spreading shaft is mm.
1 represents the inch system, all the measurement unit concern about the spreading shaft is inch.

8 – **STARTING MODE**: Select for foot switch operating mode. Pressing [8] key to select.
0 represents the single starting; after starting foot switch is always on, release the foot switch the machine will stop.
1 represents the double starting; after starting release the foot switch the machine will keep on working, pressing foot switch again the machine will stop.

THE LIMITATION OF SPREAD SHAFT MOVING: [STEP] [DATA] [3]

The limitation value is the maximum moving range of spread shaft. After setting the value, when the spread shaft moving to the edge of limitation the machine will stop and display the error information, then reset into the ready mode. Setting the limitation value, except the numerical key, it also can use the [LAST STEP] and [NEXT STEP] key to set the limitation value. When the limitation value is [999.99], it's no limitation for spread shaft moving.

THE RESET FUNCTION OF SPREAD SHAFT: [STEP] [DATA] [4]

This function is using for setting the auto reset function of spread shaft, when the machine has done several products. The setting range is [0~99]. When the setting value is [0], the spread shaft will not auto resetting.

SPEED LIMITATION: [STEP] [DATA] [5]

Set the value of high speed & low speed to prevent the feeder head lose the synchronisation during winding. This value should set according to the speed of motor equip with machine.
[STEP] [DATA] [5] [5] High speed limitation
[STEP] [DATA] [5] [5] [5] Low speed limitation

THE SETTING OF BRAKING TIME: [STEP] [DATA] [6]

This function is using for setting the continued braking time of the brake. The maximum value is [9.9] seconds.

FEEDER HEAD RESET SPEED: [STEP] [DATA] [7]

Set the speed of feeder head when reset to origin point. The range of setting is [0-99]. 0 is lowest speed and 99 is fastest speed.

FEEDER MOVING UNIT: [STEP] [DATA] [8]

Min moving unit of feeder head, this value is setting according to the specification of motor, ball screw & the ration of motor pulley. The standard setting value is [2.00]

Rate of Acceleration / Deceleration: [STEP] [DATA] [9]

Provides variable acceleration, to optimise the winding cycle, can be set for slow acceleration for fine wire sizes allowing greater maximum speed. The range of this setting is [0.0 fast 9.9 slow].

ERROR MESSAGE

While operating each function, the controller will stop if the controller inspects any unusual situation. Then displays the error message.

The meanings of error message are as follows:

Err-0:Tthe data in the memory lost will inspect while starting.
Err-1:The start position is bigger than the limitation of the spread shaft, will inspect while setting the starting position.
Err-2:While winding, the position of spread shaft moving forward is over the limitation position.
Err-3:While winding, the position of spread shaft moving backward is over the reset sensor.
Err-8:Quantity reached error. This function is invalid when the quantity set as '0"
Err-P:Password error. Must enter the correct password before accessing the edit mode.

WINDING DATA SETTING

CNC-200A contains 999 steps memory. By defining the "region", users can effectively manage the memory. Various winding parameters can be stored in different regions and can be retrieved instantaneously. Following the steps 1-3, to program the winding parameter. (as the

1 MEMORY RANGE SELECTION :

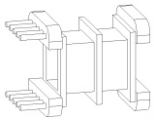
Determine the range for the winding step. It has to specify the starting step and the ending step.

Specifying starting step:
[INITIAL] (start step number) [ENTER] (the range is 0~999)

Specifying ending step:
[END] (end step number) [ENTER] (the range is 0~999)

When programming the step number, the ending step number must be larger than the starting step number, or the winding operation will not start. If during programming, the displayed step number is the desired number, just press the [ENTER] key. If a wrong number is entered, simply press [CLEAR] to zero the value and reenter the correct number.

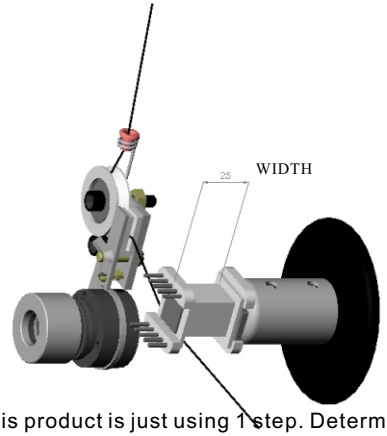
The machine contains 999 memory steps. The step is different by different product. If one bobbin has two sections (as the draw), it needs 2 steps.



例 EXAMPLE

The bobbin is as the draw:

Winding parameter:
WIRE SIZE: AWG NO. 28 0.32MM
WINDING TURNS: 800 TURNS
WIDTH: 25MM



This product is just using 1 step. Determine to use step [11] storing the data of the product.

Starting step:
[INITIAL] [1] [1] [ENTER]

Ending step:
[END] [1] [1] [ENTER]

2 PROGRAMMING OF PARAMETER

In idle mode, press [STEP] [ENTER] invokes the programming mode for the winding parameter.

Step display shows the starting step
The parameter indicator [start point] lit.

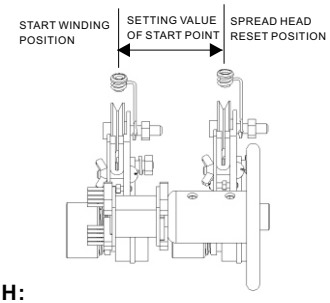
The starting position will display at the parameter display. The starting position can be changed by pressing the numerical key followed by [ENTER] ; or pressing the [ENTER] key if no change is necessary.

After setting the starting position, the step number in the step display will automatically increase by one. Continue with the starting position selection for the next step. When the step number larger than the ending step number, the step number will restore to the starting step number and indicator light will change from parameter to width. Repeat the same procedure using numerical keys and the [ENTER] key, all winding parameter for each step can thus programmed.

Explain for each winding parameter:

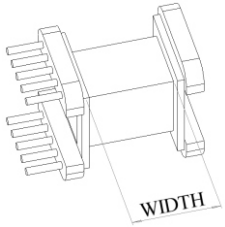
START POINT:

The starting position of spread shaft, the position is calculated by the distance from end of spread shaft. The range is 0~999.99mm.



WIDTH:

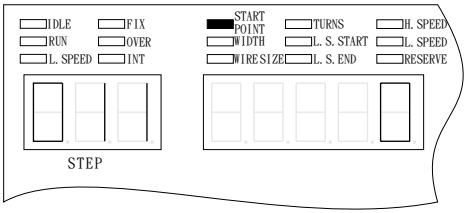
The width for spreading wires. The range is 0~999.99mm.



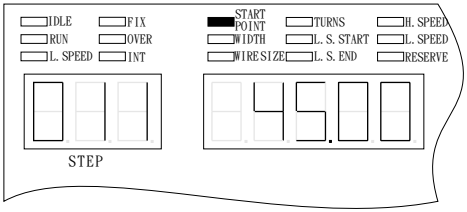
例 EXAMPLE

Press [STEP] [ENTER] invokes the programming mode for the winding parameter.

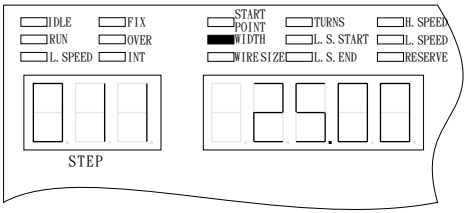
After pressing [ENTER] , the step display will show [11]. (it's the starting step setting before.) the parameter indicator [start point] will lit means that entering the programming of winding parameter. The parameter display will show the setting value of starting position.



ENTERING THE START POINT: [4] [5] [0] [0] [ENTER]
(assuming the starting position value is 45mm entering 4500, because of decimal.)

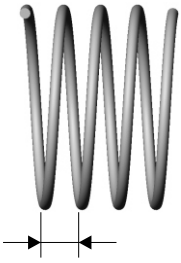


ENTERING THE WIDTH: [2] [5] [0] [0] [ENTER]
(the width is 25mm entering 2500,because of decimal.)



WIRE SIZE:

The diameter of wire (winding closely) or the moving distance of spread shaft for each turn (winding apart). The setting range is [0~9.999] mm.



WIRE SIZE

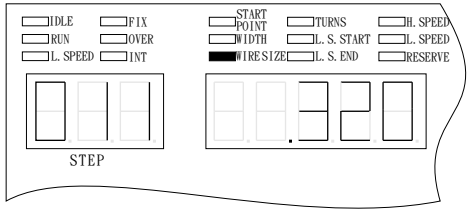
TURNS:

The total winding turns. The setting range can choose [0.0~9999.9] turns or [0~99999] turns.

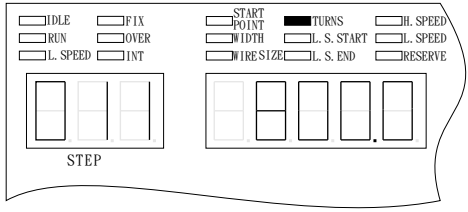
L. S. START:

The turns winded by low speed after starting. Setting range is [0~999.9] turns.

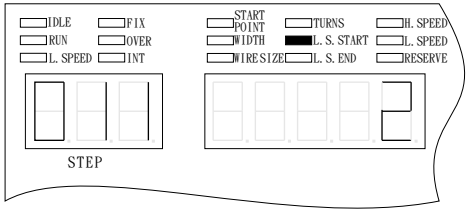
ENTERING THE PITCH: [3] [2] [0] [ENTER]
(winding closely, the wire size is 0.32mm entering 320, because of decimal.)



ENTERING THE TURNS: [8] [0] [0] [0] [ENTER]
(the total winding turns are 800 turns entering 8000, because of decimal.)



ENTERING THE L.S.START: [2] [ENTER]
(setting the L.S.START turns by actual situation, the normal setting is 2~5 turns. Entering 2.)

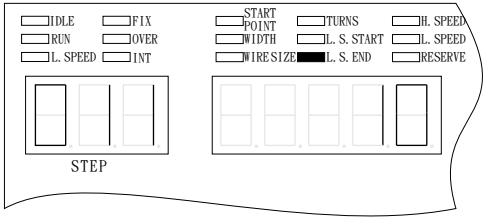


L. S. End:

The turns winded by low speed before stop. Setting range is [0~999.9] turns.

ENTERING THE E.SLOW: 1 0 ENTER

(the speed faster needs more turns for e.slow. To make the machine stop accurately. It depends on the actual effect of brake. Entering 10 turns.)

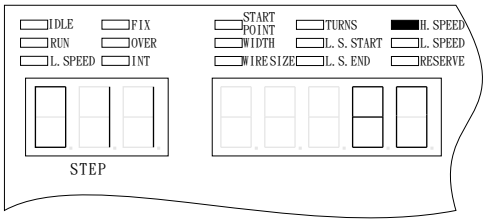


High speed:

The speed for high-speed winding. Setting range is [0~99%].

ENTERING HIGH SPEED: 8 0 ENTER

(entering the percentage of the highest rpm, adjusting by different product. Entering 80.)

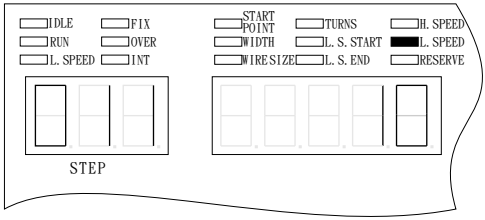


LOW SPEED:

The speed for low-speed winding. Setting range is [0~99%].

ENTERING LOW SPEED: 1 0 ENTER

(entering the percentage of the highest rpm, it depends on the effect of brake. The common setting value is smaller than 10. Entering 10.)



While programming the winding parameter, the following functions are also available:

CLEAR To change the current value to zero.

COPY To copy the content of the previous step to the current step; invalid when programming the first step.

— To go back to the previous programming step.

DATA To cycle among the 9 parameter.

SPIN DIR To change guiding direction.

WIND DIR To change winding direction.

EDGE STOP To change two-end stop selection.

AUTO RESET To change auto return selection.

AUTO START To change auto start selection.

Each time when change the options, ENTER key must pressed to effect the change. Using the above procedure, all the winding parameter and options of each step can be set and checked. When finishing programming, press DATA key once and get out of programming mode and go into idle mode.

Spreading guidance setting function:

While setting the starting position and width, it's also can press the ◄ and ► key to let the spread shaft moving to guide the setting of the position expect the numerical keys.

Setting the starting position, the present position of the spread shaft is the setting value.

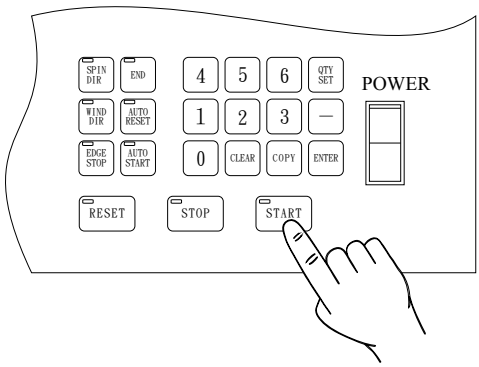
Setting the width, the controller will calculate the width automatically, according to the present position and the starting position of the spread shaft. And the controller will make out the winding direction.

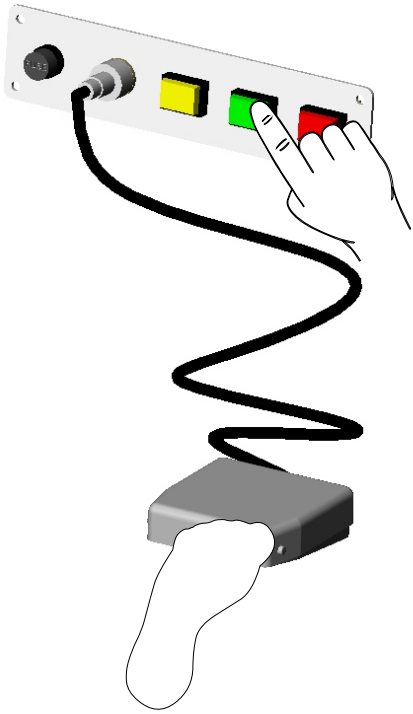
CAUTION:

THE SETTING OF CONTROLLER IN THIS OPERATION MANUAL IS BY USING CE-02 VERSION. OTHER VERSION DO NOT SUPPORT PART OF THE FUNCTION OR THERE WILL BE

3 START WINDING

Finished the program setting, go back to idle condition, then you can press START on the controller or the [start] button on the machine or the foot switch to start winding.



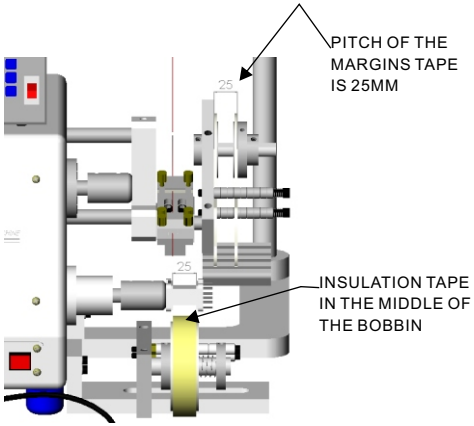


WH-800 TAPE SETTING

WH-800 is the one spindle digital winding machine and can collocate with insulation tapper and margins tappers. It is especially suitable for those products which are more wire layers and insulation layer. You can wire the insulation tape, secondary wire and margins tape in the process of the production and after finishing the primary wire.

1 INSTALL TAPE

Please follow P.12 to set up the insulation tape and margins tape. You need to adjust the margins tape between the bobbin and ajust the insulation tape in the middle of the



2 CONTROLLER SETTING

For example:
Primary wire 150 turns
Insulation tape 2 turns
Secondary wire 200 turns
Margins tape 5 turns

A--RANGE OF STEPS
- It needs five steps.
- 1.Wire primary wire.
- 2.Wire first insulation tape.
- 3.Wire secondary wire.
- 4.Wire secondary insulation tape.
- 5.Wire margins tape.

B--START POINT
- 1.Follow P.18 to set start point.
- 2.Insulation tape fixed, not necessary.
- 3.Follow P.18 to set start point.
- 4.Insulation tape fixed, not necessary.
- 5.Let tape match on the bobbin.

C--WIDTH
- 1.Set the actual value of width.
- 2.Not necessary.
- 3.Set the actual value of width.
- 4.Not necessary.
- 5.Setting value "0".

D--WIRE SIZE
- 1.Set the actual value of wire size.
- 2.Not necessary.
- 3.Set the actual value of wire size
- 4.Not necessary.
- 5.Setting value "0".

E--TURNS
- 1.Setting value "150".
- 2.Setting value "2".
- 3.Setting value "200".
- 4.Setting value "2".
- 5.Setting value "5".

F--L.S. START
- 1.Setting value "2"-"5".
- 2.Setting value "2".
- 3.Setting value "2"-"5".
- 4.Setting value "2".
- 5.Setting value "5".

G--L.S. END
- 1.According actual situations.
- 2.Setting value "0"
- 3.According actual situations.
- 4.Setting value "0"
- 5.Setting value "0"

H-H. SPEED
- 1.According actual situations.
- 2.Setting value < "10"
- 3.According actual situations.
- 4.Setting value < "10"
- 5.Setting value < "10"

I-L. SPEED
- 1.According actual situations.
- 2.Setting value < "10"
- 3.According actual situations.
- 4.Setting value < "10"
- 5.Setting value < "10"

J--SPIN DIR
- 1.According actual situations.
- 2.Not necessary.
- 3.According actual situations.
- 4.Not necessary.
- 5.Not necessary.

K--WIND DIR
- 1.According actual situations.
- 2.Setting clock-wise.
- 3.According actual situations.
- 4.Setting clockwise.

MACHINE OPERATION

THE OPERATION PROCEDURE

Following steps one to five to operate the winding machine.

1 TO INSTALL THE WIRE AND THE BOBBIN HOLDER:

Put the wire into the wire barrel, install the wire from the tension to spread head. (consult P.7 preparation before operating.)

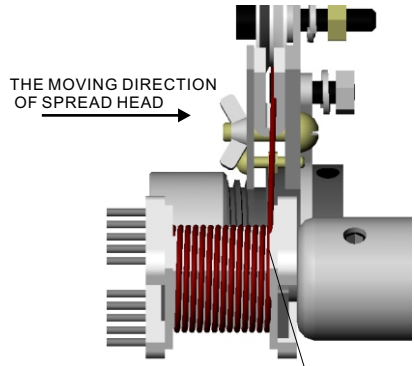
2 PROGRAMMING WINDING PARAMETER:

Select the step for winding. (consult P.17 programming winding parameter.)

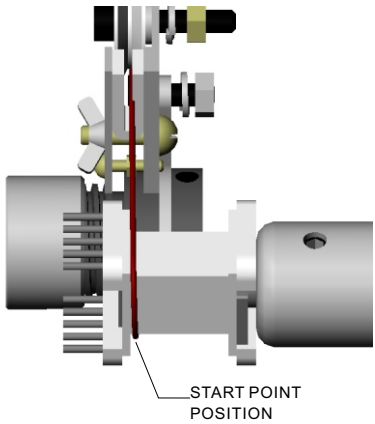
3 REVISING WINDING PARAMETER:

Make some samples to revise the winding data. The winding data is adjusted according to the actual winding situation. (WH-762,WH-763,WH-764 can make samples by only one spread head at the first. Then the other heads can be adjusted synchronously after revising the data.)

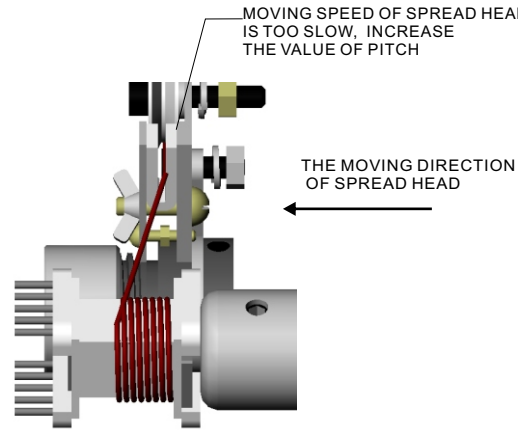
REVISING THE WIDTH:



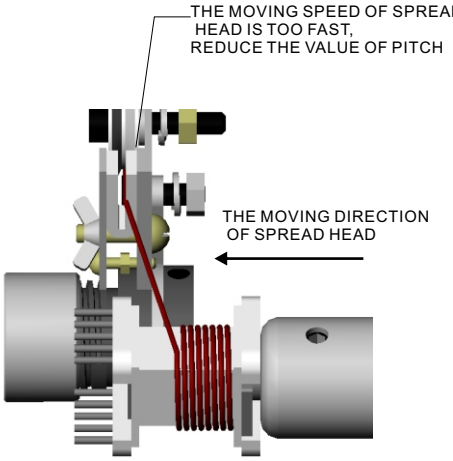
REVISING THE STARTING POSITION:



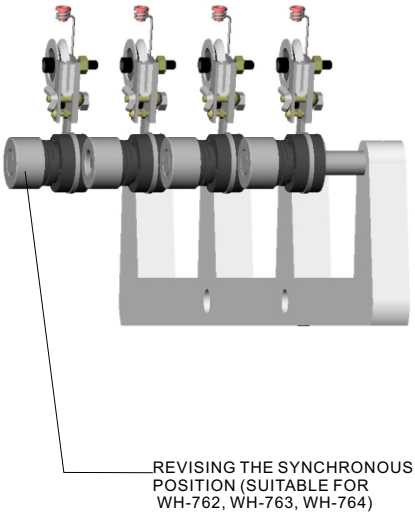
REVISING THE WIRE SIZE:



REVISING THE WIRE SIZE:



4 REVISING THE SYNCHRONOUS POSITION (SUITABLE FOR USE BY WH-762, WH-763, WH-764)



5 REGULAR OPERATING:

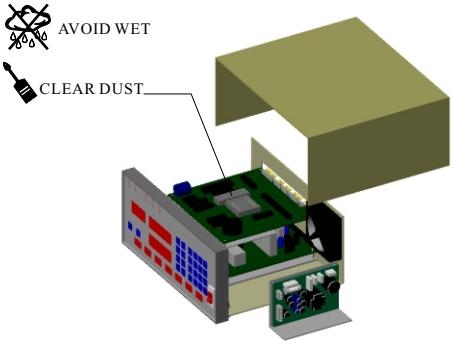
When winding samples, revise properly the winding data to make the machine wind product perfectly. (WH-762,WH-763,WH-764 can be adjusted synchronously). Then can make the machine operate regularly.

Winding different products can use other steps to set the winding data. Keep the original setting for winding the same product next time. Recording the step of different products. Next time, winding the same product just need to set the starting step and ending step. After making some samples, the machine can operate regularly. To short the settings time and increase the efficiency.

MAINTENANCE

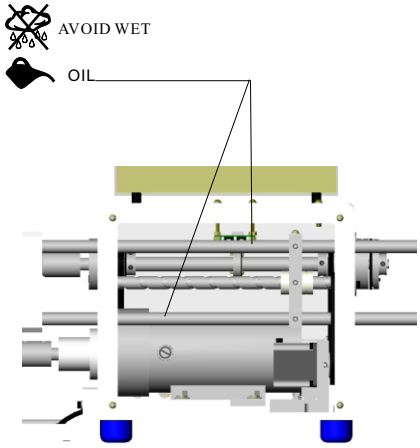
CONTROLLER

The CWC-01controller is a micro electronics product should clean the dust in the controller on a regular time and prevent the controller get wet. Please clean the case with a clean soft cloth.



COMPONENTS

The machine components should keep dry to prevent the components from being rusty. The spread shaft should keep lubrication and lubricate on a regular time. (Other components should not lubricate.)



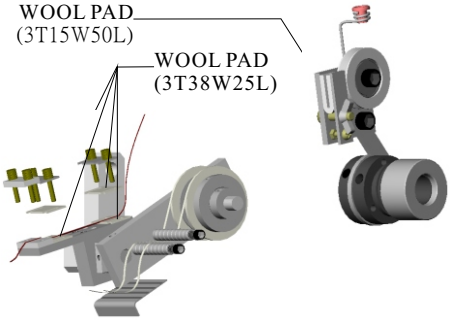
REPAIR

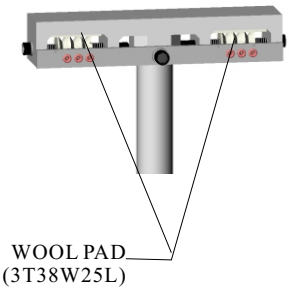
CONSUMABLE

The consumable replacement of the machine are wool pad, brake flake, and belt, etc. The consumable replacement will waste on the normal wear and tear. To keep the good quality of products, you should check the condition of consumable components usually and to eliminate the unsuitable components.

WOOL PAD

The wool pad used for tension and spread head.





BRAKE FLAK

The worn flake of brake will effect the efficacy of brake. The distance between brake and the flake is about 0.3mm.

The proceduce for making replacement of the flake:

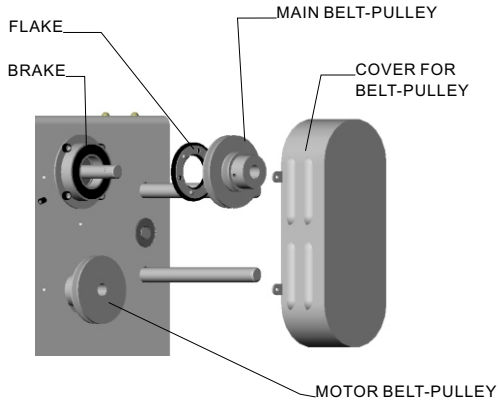
1.Take off the protection cover of belt pulley.

2.Take off the belt

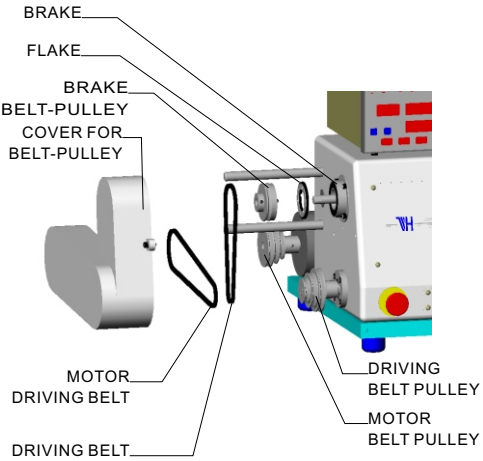
3.Take off the belt pulley.

4.Take off the worn flake of brake.

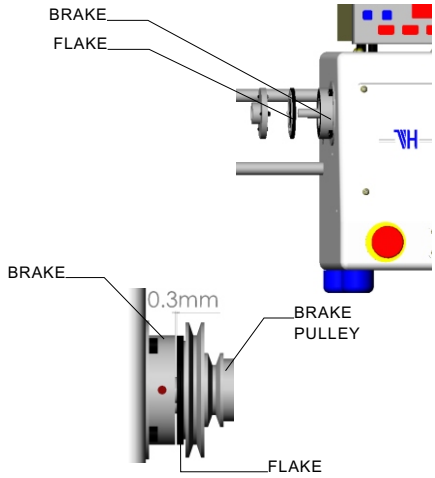
WH-761～764



WH-751.752



WH-800



DRIVING BELT

The driving belts of WH-761～764 are as follows
:

1.MAIN DRIVING BELT.....V- BELT K18

2.SPREAD DRIVING BELT
.....TIMING BELT 108XL

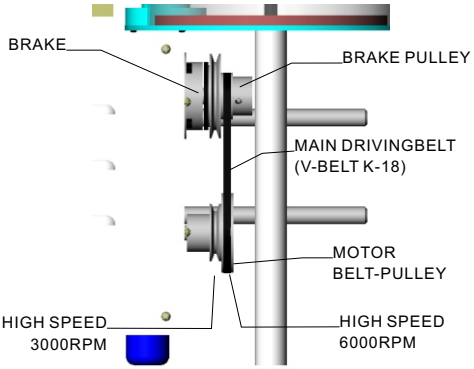
3.DRIVING BELT FOR WINDING SPINDLE

WH-761	.....NONE	
WH-762	....TIMING BELT 220XL	1 PCS
WH-763	....TIMING BELT 230XL	1 PCS
	.....TIMING BELT 200XL	1 PCS
WH-764	....TIMING BELT 230XL	1 PCS
	.....TIMING BELT 200XL	2 PCS

1.Main driving belt: V- BELT K18

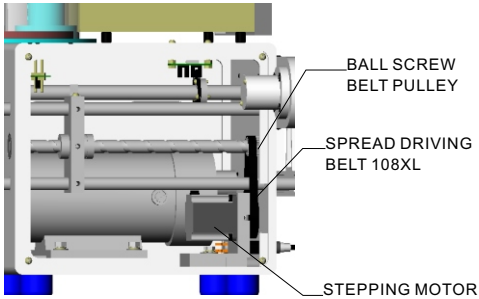
It is set on the brake pulley and motor pulley and there are two position to set.

A. HIGH SPEED 3000RPM

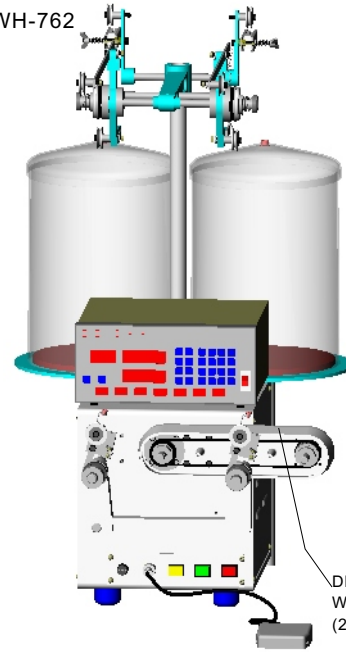


2.SPREAD DRIVING BELT:
.....TIMING BELT 108XL

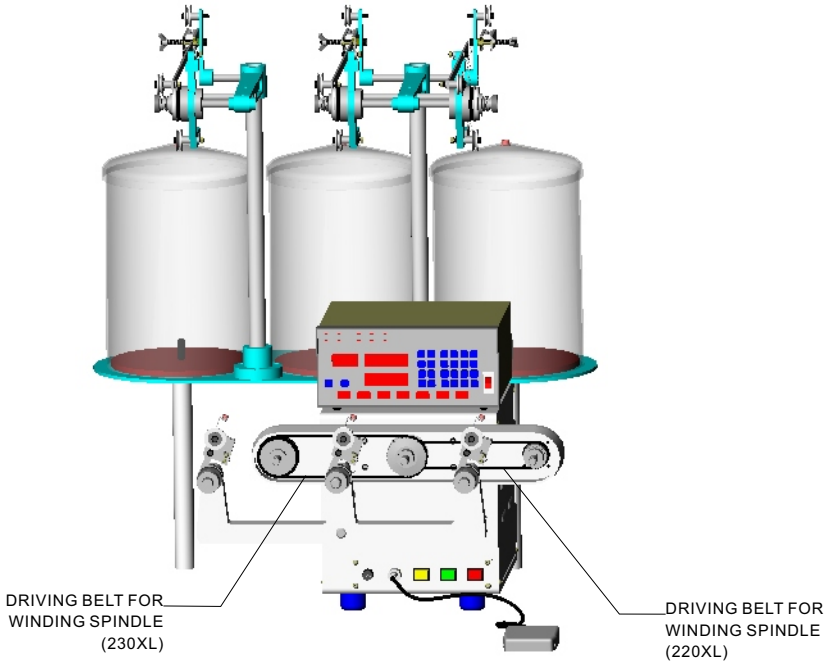
3.DRIVING BELT FOR WINDING SPINDLE:
TIMING BELT. FOR WH-762,763,764.



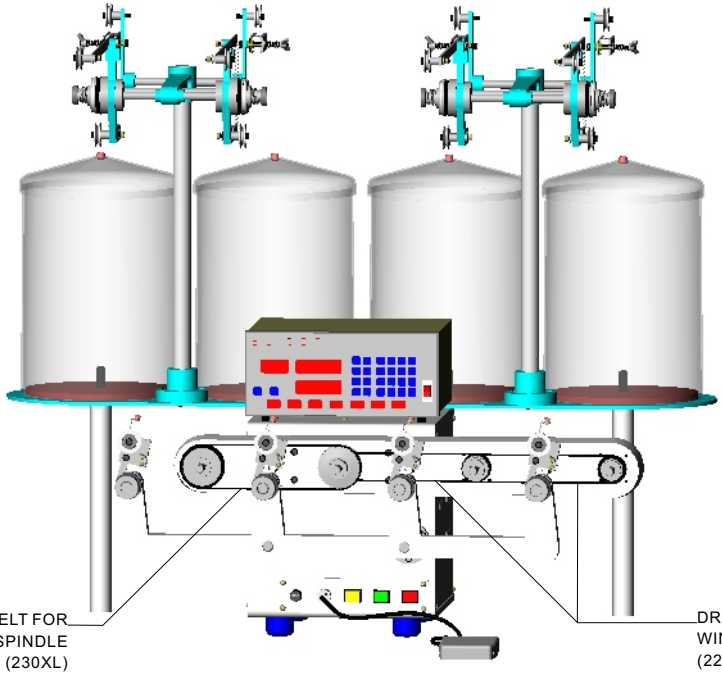
WH-762



WH-763



WH-764



BELT FOR WH-751,752,800:

WH-751 :

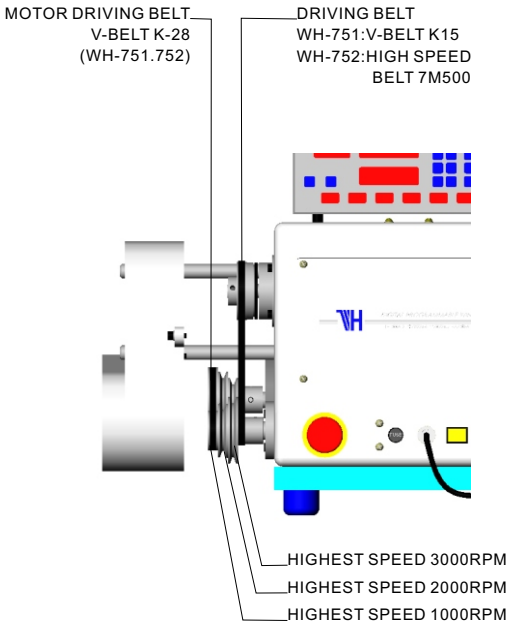
1.DRIVING BELT.....V-BELT K15
2.MOTOR DRIVING BELT.....V-BELTK28
3.SPREAD DRIVING BELT
.....TIMING BELT 120XL
4.WINDING BELT.....NONE

WH-752 :

1.DRIVING BELT
.....H.SPEED BELT 7M500
2.MOTOR DRIVING BELT.....V-BELTK28
3.SPREAD DRIVING BELT
.....TIMING BELT 120XL
4.WINDING BELT
.....TIMING BELT 136XL

WH-800 :

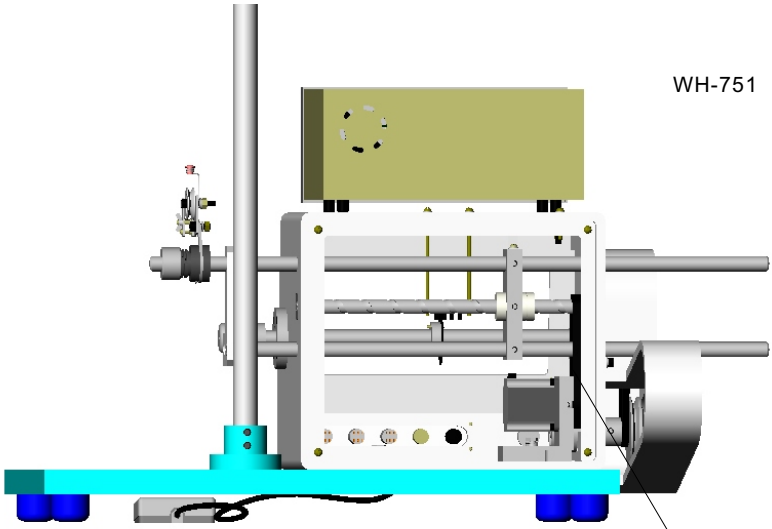
1.DRIVING BELT.....NONE
2.MOTOR DRIVING BELT.....V-BELT K15
3.SPREAD DRIVING BELT
.....TIMING BELT 120XL
4.WINDING BELT
.....TIMING BELT 136XL



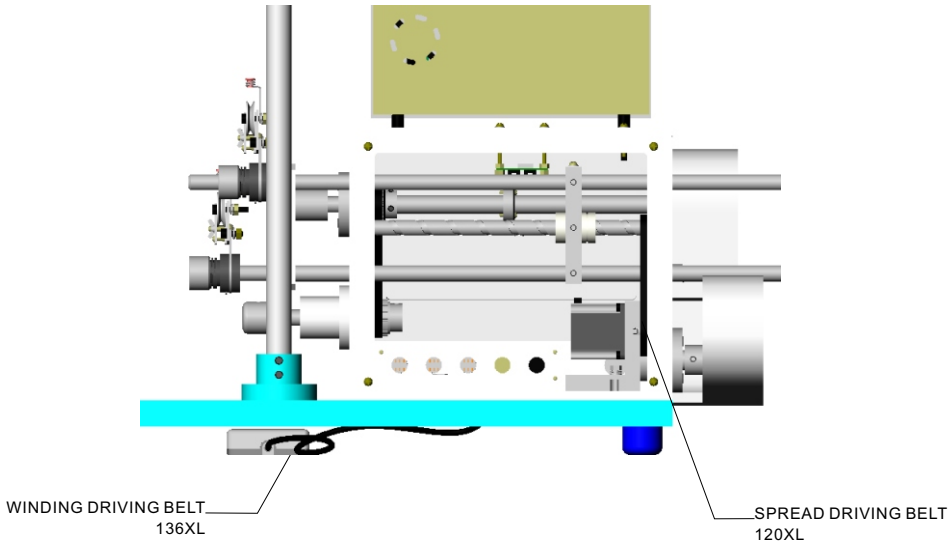
3.SPREAD DRIVING BELT：TIMING BELT 120XL。

4.WIND DRIVING BELT：TIMING BELT 136XL。（ONLY FOR WH-752)。

WH-751



WH-752



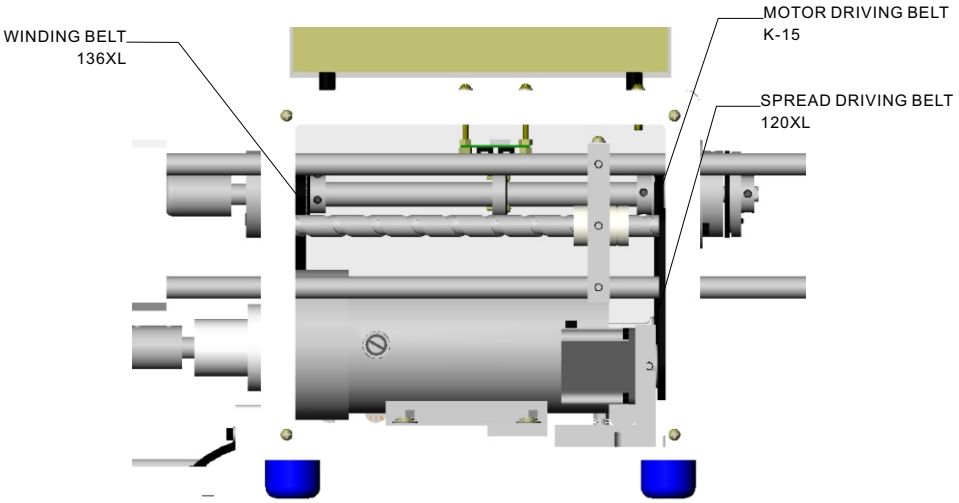
WH-800：

1.MOTOR DRIVING BELT.....V-BELT K15

2.SPREAD DRIVING BELT.....TIMING BELT 120XL

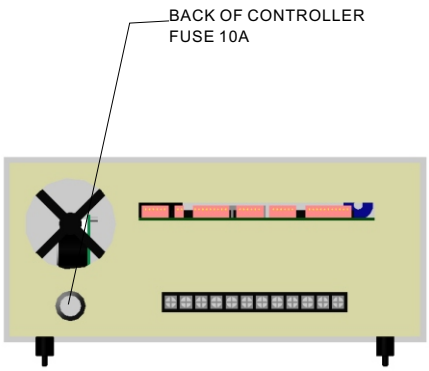
3.WINDING BELT.....TIMING BELT 136XL

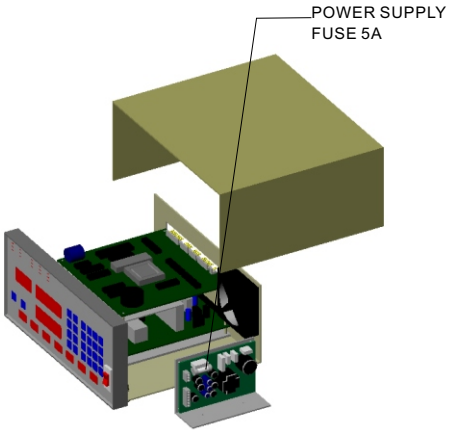
WH-800



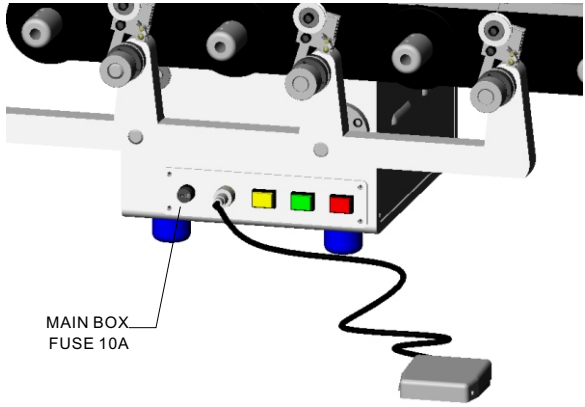
FUSE

There are three place with fuse. Please use the same specification of the original fuse if they are damaged and necessary to replace.

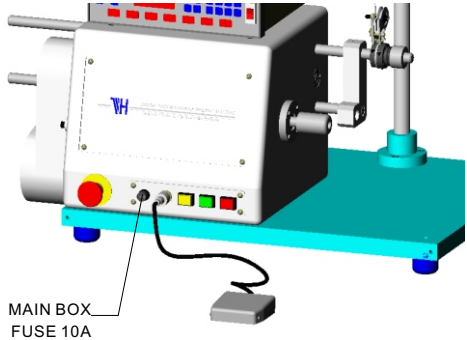




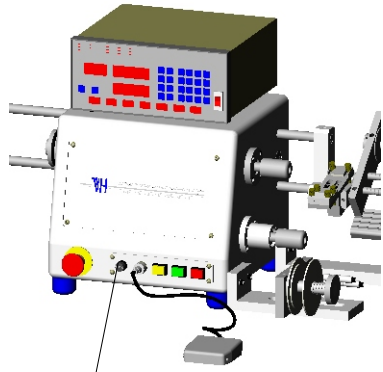
WH-761～764



WH-751.752



WH-800



TROUBLE SHOOTING GUIDE

If the machine perform as described in these operating instructions, check the following guide.

	Probably Reason	Trouble shooting guide
No power reaction	1. Plug loose. 2. Dose not turn on power. 3. Fuse burn out. 4. Power supply board of controller burn out.	1. Check plug with right power source. 2. Turn power on. 3. Change fuse. (P.30) 4. Replace power supply board of controller.
Machine does not reset, but winding automatically while power on.	1. Connector behind controller fall. 2. Reset sensor is broken. 3. Controller is out of order.	1. Check connector behind controller. (P.13) 2. Replace reset sensor. (P.3, P.5, P.7) 3. Send controller back for repair.
Controller is power on, but spread head doesn't move	1. Setting data is wrong. (The value of turn is 0 or the value of low speed is too small.) 2. Connector behind controller fall. 3. Main belt or driving belt fall or	1. Check the winding data. (P.17) 2. Check connector behind controller. (P.13) 3. Replace main belt or driving belt. (P.26)
Spread head doesn't move.	1. Setting data is wrong. (The value of pitch is 0.) 2. Connector behind controller fall. 3. Spread head driving belt fall or break.	1. Check winding data. (P.7) 2. Check connector behind controller. (P.13) 3. Replace the driving belt. (P.26) 4. Change stepper motor.
Turn counting is wrong. 1. Actual turns are different with display. 2. Winding turns are different with setting value.	1. Turn induction flake loose. 2. Turn sensor is broken. 3. Controller is out of order.	1. Tighten the turn induction flake. (P.3, P.5, P.7) 2. Replace turn sensor. (P.3, P.5, P.7) 3. Send controller back for repair.
	1. Brake time is too short. 2. Brake flake is over worn.	1. Reduce high speed or increase the value of L.S. TURN. (P.7) 2. Change the flake of brake.

Service available at following address:
Taipei: e-mail: sales@weyhwang.com.tw
TEL: +886-2-22984001 FAX: +886-2-22984005
Address: No.31, Wu-Quan 8th Rd., Wu-Ku Industrial Park, New Taipei City, Taiwan, ROC
Hong Kong: e-mail: hongkong@weyhwang.com.tw
TEL: +852-27931840 FAX:+852-23427007
Address: 11/F, Flat B, Fully Ind. Bldg., No.6, Tsun Yip Lane, Kwun Tong, Kowloon, Hong Kong
Dongguan / China: dongguan@weyhwang.com.tw
TEL: +86-769-81381418、28、38 FAX:+86-769-81381832
Kunshan / China: kunshan@weyhwang.com.tw
TEL: +86-512-57773000 FAX:+86-512-57773100

SPECIFICATION & OPTIONAL ACCESSORY

SPECIFICATION

Specification for WH-761,762,763,764

Main POWER :
220V 50/60HZ

MAIN MOTOR :
BRUSHLESS MOTOR / 6000RPM

MOTOR
SINGLE PHASE

PITCH RANGE :
0～9.999mm

TRAVERSE DISTANCE :
0～100mm

WIND DIAMETER :

WH-761	100mm
WH-762	100mm
WH-763	100mm
WH-764	100mm

WIRE SIZE :
TENSION TYPE A
0.03mm～0.25mm
TENSION TYPE B
0.06mm～0.4mm
TENSION TYPE C
0.3mm～0.6mm

MEMORY :
999 STEPS

SPINDLE NO. :

WH-761	1 SPINDLE
WH-762	2 SPINDLES
WH-763	3 SPINDLES
WH-764	4 SPINDLES

WEIGHT :

WH-761	45 KGS
WH-762	50 KGS
WH-763	55 KGS
WH-764	60 KGS

DIMENSION :

WH-761	45(L)*67(W)*100(H)cm
WH-762	50(L)*67(W)*100(H)cm
WH-763	75(L)*67(W)*100(H)cm
WH-764	100(L)*67(W)*100(H)cm

Specification for WH-751,752,800,800i

MAIN POWER :
220V 50/60HZ

MAIN MOTOR :
WH-751
BRUSHLESS MOTOR / 3000RPM
WH-752,800, 800I
BRUSHLESS MOTOR / 6000RPM

PITCH RANGE :
0～9.999mm

TRAVERSE DISTANCE :
WH-751: 300mm
WH-752,800, 800I: 100MM

WINDING DIAMETER :

WH-751	200mm
WH-752	100mm
WH-800	100mm
WH-800I	100mm

WIRE SIZE :

WH-751	0.5mm～3.0mm
WH-752	0.5mm～1.6mm
WH-800	0.8mm～1.0mm
WH-800i	0.03mm ～0.6mm

DEPENDING ON TENSION TYPE

MEMORY :
999 STEPS

SPINDLE NO. :

WH-751	1 SPINDLE
WH-752	2 SPINDLE
WH-800	1 SPINDLE
WH-800I	2 SPINDLE

WEIGHT :

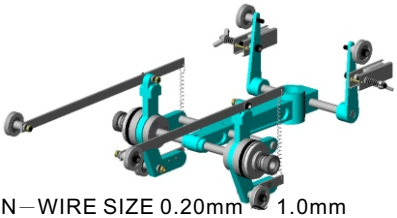
WH-751	55 KGS
WH-752	55 KGS
WH-800	37 KGS
WH-800I	37 KGS

DIMENSION :

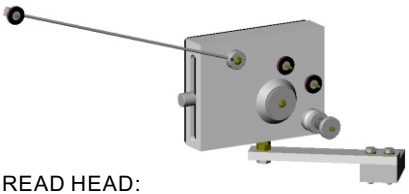
WH-751	52(L)*70(W)*60(H)cm
WH-752	65(L)*70(W)*60(H)cm
WH-800	52(L)*70(W)*60(H)cm

Optional accessory for WH-761,762,763,764

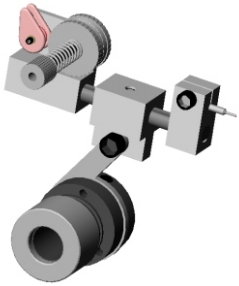
TENSION :
OLD TYPE－WIRE SIZE 0.20mm ～ 1.0mm



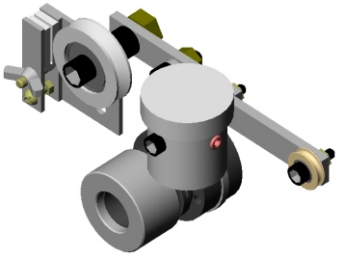
THIN－WIRE SIZE 0.20mm ～ 1.0mm



SPREAD HEAD:
NOZZLE －WIRE SIZE 0.03mm ～ 0.6mm。

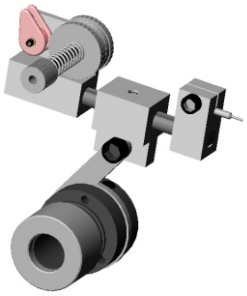


ALCOHOL BATH FEEDER HEAD

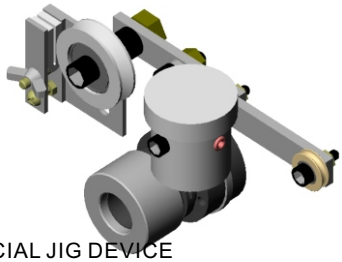


Optional accessory for WH-800

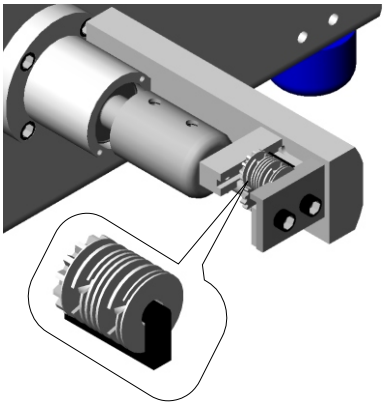
NOZZLE SPREAD HEAD－
WIRE SIZE 0.03mm ～ 0.6mm



ALCOHOL TYPE FEEDER HEAD



SPECIAL JIG DEVICE



WARRANTY

THE LIMITED WARRANTY

Wey Hwang Co., Ltd. Hereby sell one set of model: **WH-** digital winding machine, serial number: _____.

Wey Hwang Co., Ltd. are responsible for one year warranty from shipping date to DATE: **May/31/2015.** If the machine breaks down in normal use , then Wey Hwang Co., Ltd. Will provide replacement components free of charge. This warranty does not extend to any damage caused by flood, fire or any other accidental disaster.

CUSTOMER NAME:
ADDRESS:
COMPANY: Wey Hwang Co., Ltd.
SALES PERSON: Ellie Yang
DATE:

WARRANTY CONTENTS

1. Within the warranty period, Wey Hwang Co., Ltd. Will provide free replacement of the machine mechanical components and free maintenance of its electronic components, apart from its consumable components.
2. If the customer uses the components not provides by Wey Hwang Co., Ltd. or does not operate the machine as recommended in this operation manual, then any subsequent damage is not cover by this warranty.
3. The warranty only extends to the original machine and does not cover subsequent alterations.
4. The warranty is not transferable.
5. The warranty is only valid after it has been stamped by Wey Hwang Co., Ltd.; any alteration will invalidate the warranty.

INFORMATION

Information of our other products.

DIGITAL GEAR TYPE TOROID WINDING /TAPING MACHINE.
Automatic winding, spreading. Micro computer control wire size, pitch, angle.
Winding /taping head is changeable.

★ WH-300-G10S:10" gear type digital toroid winding machine. (Small gear)
★ WH-300-G10B:10" gear type digital toroid winding machine. (Big gear)
★ WH-300-G13:13" gear type digital toroid winding machine.
★ WH-300-T10S: 10"gear type digital toroid taping machine. (Small gear)
★ WH-300-T10B: 10"gear type digital toroid taping machine. (Big gear)
★ WH-300-T13: 13" gear type digital toroid taping machine.

DIGITAL TOROID WINDING MACHINE.
Automatic winding, spreading. Micro computer control wire size, pitch, angle.
Winding head of machine is changeable.

★ WH-900-B4: 4" belt type digital toroid winding machine.
★ WH-900-S4: 4" slide type digital toroid winding machine.
★ WH-900-B6: 6" belt type digital toroid winding machine.
★ WH-900-S6: 6" slider type digital toroid winding machine.

HOOK TYPE TOROID WINDING MACHINE.
Big wire size with small finished ID toroid coil..

★ WH-200: Digital type toroid hook winding machine..
★ WH-200A: Simple type toroid hook winding machine.

SIMPLE WINDING MACHINE

★ WH-700:Tape winder
★ WH-737:Manual winder
★ WH-710:Manual spread(front spindle) winding machine
★ WH-720:Manul spread (side spindle) winding machine
★ WH-730:Natural spread winding machine
★ WH-740:IFT coil winding machine

DIGITAL CONTROL COIL WINDING MACHINE:
Automatic winding, spreading. Micro computer control wire size, pitch, start point.

★ WH-761:1 front spindle digital type winding machine
★ WH-762:2 front spindle digital type winding machine
★ WH-763:3 front spindle digital type winding machine
★ WH-764:4 front spindle digital type winding machine
★ WH-751:1 side spindle digital type winding machine
★ WH-752:2 side spindle digital type winding machine
★ WH-800:1 side spindle digital type winding machine with taping device.
★ WH-800I:2 side spindle digital type winding machine.
★ WH-400: Air coil winding machine for self-bonding wire.

Wey Hwang Co., Ltd.

www.weyhwang.com.tw

WEY HWANG CO., LTD.
COIL WINDING MACHINE