

Increased Production Rate

Following are some troubleshooting hints on how you might be able to increase the production rate on your Komax machine:

- Check the return lock roller. Make sure its tension is sufficient so that the wire won't backup after the wire feed has stopped. Also don't set it too tight, you should be able to pull the wire with two fingers after the encoder.
- Check the settings for the encoder tension roller. The adjusting screw should stick out about 1/4 of an inch (if set too tight, stretching of the wire between the drive rollers and encoder wheel can occur).

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- Check for the gap between the driver rollers. Don't let the rollers bottom out.
- When terminating one end only, always do it on station number two side.
- Set the pullback stroke for the leading end gripper as short as possible - just enough for it to pull the slug off.
- Set the wire feed speed at 15 (if wire type permits).

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- The wire acceleration can be increased to speed up the feeding process (perhaps start out with number 5 and then increase until the desired setting has been reached). Some types of insulation will tend to slip between the drive rollers if the acceleration is too fast.
- Check the gripper pressure settings for slippage. If there is insufficient air pressure to the grippers, the unit will not be able to strip the wire properly.