

KAPPA SERIES QUICK REFERENCE GUIDE

I. Applying power

- 1) Connect power cord from the back of your Kappa to an appropriate outlet.
- 2) Turn unit on by actuating the power switch (back panel above power cord).

Note: Assure that the emergency stop push button is not depressed.

II. Parameters

- 1) Press the "Main" function button.
- 2) Press F4 (Parameters).
- 3) Lift plastic shield.

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- 4) Push up on Black switch used for raising feed rollers. (Located on front panel left of rollers) Close shield, press enter.
- 5) Lift shield and rotate punched disk to the appropriate hole to allow selected wire to pass freely.
- 6) Select appropriate swiveling and stationary wire guides to accommodate your target wire. (Note: No tools are required to remove guides)
- 7) Feed wire through wire feed-in hole and into the wire straightener. (Note: Adjust straightener to appropriate level. The wire straightener may not be

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available on some machines). Next, feed the wire through the punched disk, the swiveling and stationary wire guides, and out through the right side of the machine.

8) Close the safety shield.

9) Using arrow keys, move cursor to roller pressure. Use the + and - keys to increase/decrease pressure. (Note: Appropriate roller pressure will vary from wire to wire. A good value to start with is 50, then adjust up or down according to the needs of the application).

10) Cursor down to the wire check and select off.

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- 11) Move cursor back up to roller gap and press start. (Note: Machine will automatically select your roller gap.)
- 12) Turn your wire check back on.
- 13) Cursor down to adjust speeds and wire acceleration if necessary. (Note: A good value to start at is 50, then adjust up or down according to the needs of the application).

III. Configuration

- 1) Press F4 to enter the Configuration screen.

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2) Select units of measure and cross section to desired settings.

IV. Teach






1) Press F2 to enter the Teach screen. (Note: An information box is provided on this screen to inform you of what input field you are in. The input range may also be indicated where applicable)

2) The cursor will now be selecting overall length. Input your wire length value and press enter. (Note: Every time you hit enter on this screen the program will step you through to the next required entry.)

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3) Now select your processing type for side 1. Press the + key to select the type of processing required for side 1. Now enter your stripping requirements.

Types of processing

NO	Cutting only	
HS	Stripping with half pull-off	
FS	Stripping with full pull-off	
PS	Stripping with multiple cuts	
IM	Intermediate stripping	

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4) After side 1 is complete, repeat the above step for side 2.

5) Now set your:

CRS=> Wire Cross Section, core wire (AWG or mm2)

DST=> Delta Stripping Value (Correction value for the cutting depth. "-" value for deeper cuts, "+" for shallower cuts, use the "+" or "-" keys to adjust your values).

DWB=> Delta Wayback (Blades open after cut before pull-off begins to prevent damage to stranded wires during insulation pull-off).

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V. Production

- 1) Press F1 to enter the Production screen.
- 2) Cursor down to Total Pieces. Enter total number of pieces desired. Press Enter.
- 3) Cursor down to Batch Size. Enter total number of pieces desired. Press Enter.
- 4) Press start to begin production. (Note: The actual piece count or actual batch count can be reset to zero by pressing rst [F6]).