

Overall Length Variations

› The following shows a list of things to check.

- Worn Rollers ?

Pay special attention to wear occurring on the center of the rollers.

- Wire straighteners too tight ?

Check for easy movement of wire through straightener (s).

- Too much tension on dereeler ?

Cut a few feet of wire from the spool of wire then hand feed the wire to the machine.

- Using wrong type of rollers ?

Overall Length Variations

- Standard Rollers - used with most insulations.
- Polyurethane Rollers - used with teflon and very fine insulations.
- Coarse Rollers - used for heavier & thicker insulations.
- Feed Speed too high ?
A high feed speed can cause slippage on the wire. Try decreasing this value.
- Roller gap set incorrectly ?
If the roller gap is too big then the wire will slip through the rollers. Adjust when necessary.

Overall Length Variations

- Is the drive shaft bent ?

Inspect the drive rollers for up and down movement, while the unit is processing the wire. If there is movement this may indicate a shaft is bent.

- Is roller pressure enough ?

Insufficient pressure will keep the wire from feeding properly. Too much pressure on roller will tend to flatten the insulation. Pressure adjustments are done on the front plate. There are two horizontally placed set screws that can be moved up to release pressure and down to increase pressure.