

Operating & Maintenance Instructions

1000/1220 Hot Wire Strip Heater

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1. Installation & Electrical Supply

Upon receipt, carefully unpack the machine. Site the machine on a workbench of convenient height.

The machine is supplied with an IEC mains inlet on the left-hand side of the enclosure. An appropriate mains lead (fitted with a moulded on plug if possible) is supplied loose in the machine packaging. Connect the mains lead to the machine. Plug the machine into a suitable mains supply. The machine can be supplied in either 230V or 115V versions. Refer to the machine rating label if there is any doubt about the required electrical supply.

!!IMPORTANT!

The wires in this mains lead are coloured in accordance with the following code:

General

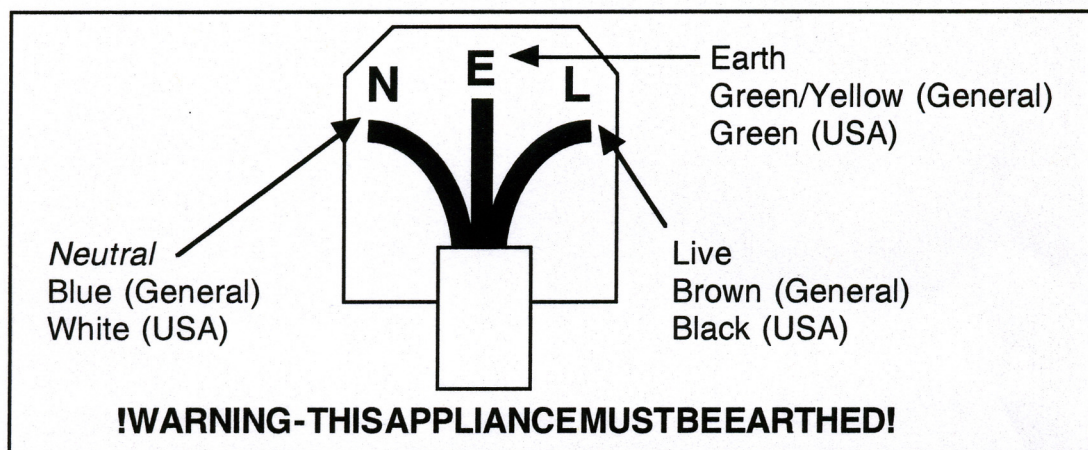
Green & Yellow
Blue
Brown

Earth

Neutral
Live(Hot)

USA

Green
White
Black



General

The green and yellow wire must be connected to the terminal marked with the letter E, or the earth symbol, or coloured green and yellow or green.

The blue wire must be connected to the terminal marked with the letter N, or coloured blue or white.

The brown wire must be connected to the terminal marked with the letter L, or coloured brown or red.

USA (115V)

The green wire must be connected to the green pin (the largest).
The white wire must be connected to the silver pin.
The black wire must be connected to the brass pin.



Warning - read instructions before installation and use.

If in doubt about electrical supply or connection refer to your supplier or consult a qualified electrician.

2. Setting Up

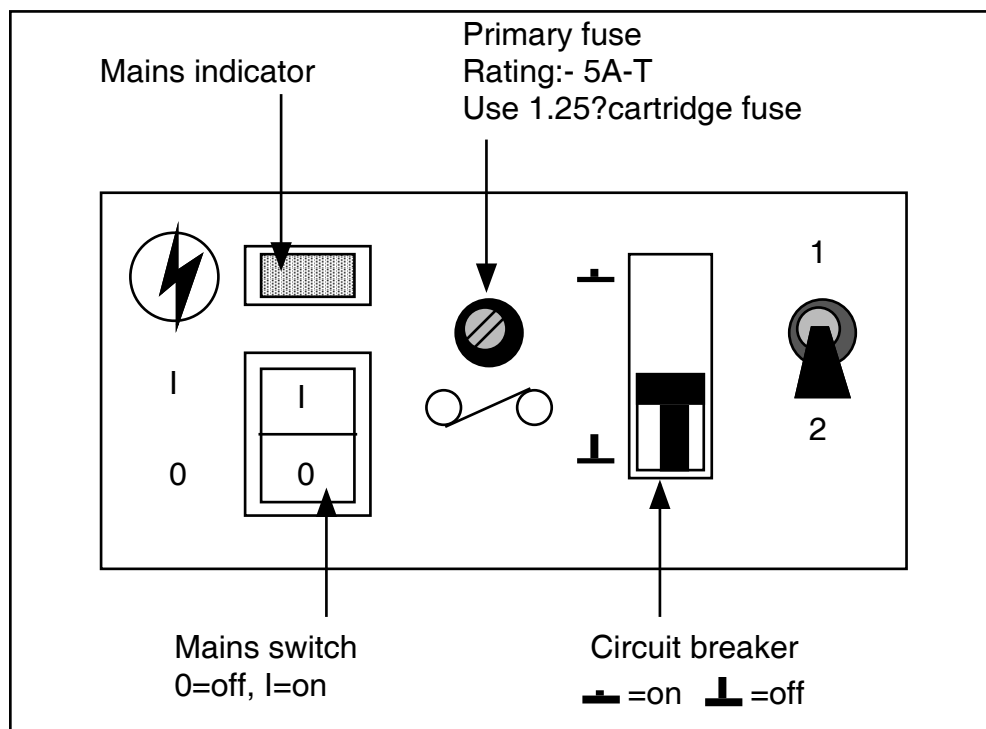
Once the unit is connected to an electrical supply the Green 'mains available' neon will illuminate.

Switch the main switch to the I position (O = off, I = on).

Switch the circuit breaker ON (This switch breaks power to the heater beam if there is an overload, short circuit or earth fault).

Switch the power selection switch to setting 2.

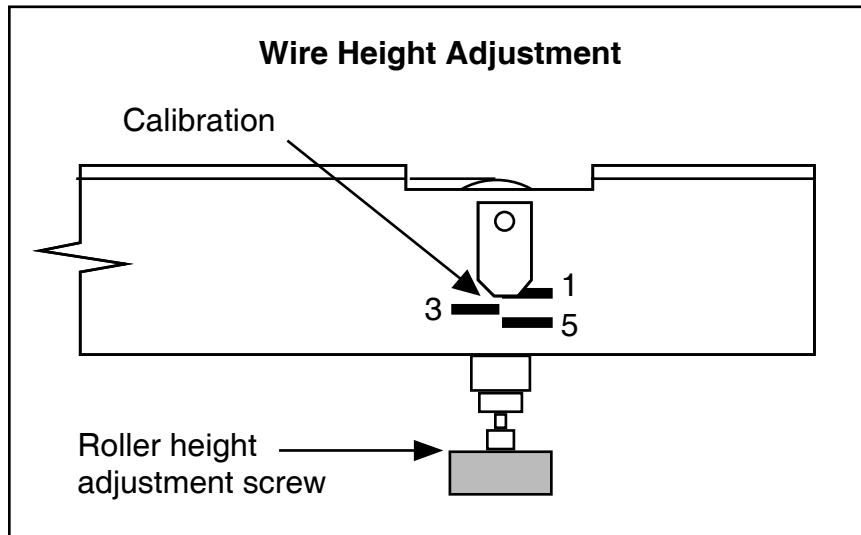
You will see the wires heating up, and the tensioning system absorbing the expansion.



Set the wire spacing by lifting the wires into the required groove. If only one wire is needed, the other can be removed, along with its tensioning spring.

Always switch off the heating wires prior to making an adjustment.

Always hold the wires by the unheated portion, i.e. outside the wire rollers.



Use the height adjustment screws on the underside of the heater beam to set the wire height to its required position. One turn of the height adjuster = 0.8mm (1/32"). Generally, the thicker the material being heated, or the larger the radius of the bend desired, the larger the gap between the wires, and between

the wires and the work.

Set the workstop to the required position.

Adjust the red bend angle stops located at either end of the table to their required position and lock using the handwheels. The calibration of the bend angle stop is for guidance only, as the material thickness and bend radius will affect the exact bend angle produced.

3. Folding a Sheet

Lift the yellow clamp bar and pull towards the front of the machine to lock in the up position. Load a suitable piece of material against the workstop, lift the clamp bar, push towards the rear of the machine and drop down, clamping the material.

Using the printed information on the control panel as a guide, heat the material until it has softened along the bend line. Once the material is ready to form, pull the bend angle stop up using the handles located at each side of the machine. Once at the set position the arms attached to the handle will drop into locating notches, setting the bend angle. Switch off the heating wires.

Once the material has cooled lift the bend angle stop handles to release the stop, and return it to its lowered position.

Lift the clamp bar and remove the folded piece of material.

There may be instances where the clamp bar interferes with the heating of components. In these situations the clamp bar can be removed by taking out the four Pozidriv screws securing the clamp bar to its supporting legs.

4. Maintenance

There is no regular maintenance required on this unit, other than to re-tension or replace the heating wires when necessary. A coil of 20SWG Ni-Chrome heating wire is supplied underneath the heater section of each machine for this purpose. Should there be any problems or queries regarding your hot wire strip heater, please refer back to the manufacturers or their local distributor.