Precaution and corrective action of wire tangling

When handling wire. “Please do not release wire-end and loosen wire winding.”

When storing wire. ”Please do not put spool as shown in Fig.1.”
- If you release wire-end, it will be a cause of wire tangling.
- If you put spool as shown in Fig.1, it will be a cause of loosen wire winding.
- If tangling happens to wire, it will be cause of AWF error and wire breakage.

<Precautions when handling EDM wire>
(1) When setting spool and wire in the machine
① Please do not detach wire-end label and anti-rust paper when setting spool in the machine.
② Please hold wire (near wire-end label) by your finger when detaching wire-end label.(Fig.2)
③ Please do not release wire-end when setting wire in the machine.
(2) When detaching spool from machine.
① Please do not loosen wire winding.
② Please hold wire-end on spool flange by tape.(Fig.3)
(3) When storing wire
① Please rewind anti-rust paper on the spool, because it is necessary for preventing discoloration of wire.
② Please put spool into Hitachi EDM wire carton box.
③ If you store wire for a long time, wire straightness become big, therefore we recommend you to use wire as soon as possible.
   * If discoloration and rust happens to wire, it will be a cause of wire breakage.
   * If wire straightness becomes big, it will be a cause of AWF error.
(4) When changing spool and using wire feeding machine(Autoloader)
① Please pay attention to wire tension setting.

<Wire tangling check method>
If you find loose wire winding or released wire-end, please check the wire winding status and make a corrective action.
① When wire winding become loose or complicated tangling, please hold the wire with your finger and cut tangling area.(Fig.4)
② Unwind wire until wire-end will be single.
③ Turn spool and unwind wire slowly as shown in Fig.5.
④ In case wire is tangled, you can find a point where wire is crossing.
<Wire tangling corrective action>
① When you find a point where wire is crossing, please hold it with your finger and push the wire-end to make slack of wire.
② Hold slack of wire with your finger and withdraw wire-end from where wire is crossing. (Fig.6)
   (In case wire-end is far from a point where wire is crossing, please cut slack of wire.)
③ Please confirm that wire tangling is resolved.
④ If tangling is not resolved, please continue the corrective action again.

Fig.4

Wire is crossing

Fig.5

Push wire

Fig.6

Fig.7