

**IE-321**  
**RJ45 Crimping Machine**  
**Operator Manual**

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## A. Safety Regulations

Thank you for purchasing IE-321 RJ45 crimping machine. The machine operator is responsible for ensuring that every employee who uses the machine has received training in accordance with these operating instructions. We have fully considered the safety factors when designing the machine, but the operator still should read through the manual and understand the content. Special attention should be given during the whole work progress, including use, repair & maintain.

1. Reliable earth wire is required.
2. We suggest to use a voltage stabilizer.
3. Box cover and protection covers are not allowed to be unloaded during the processing. When unload the covers for maintenance, the operator have to switch off the power supply.
4. Users must use, repair, maintain this machine only after fully understanding the contents of this usage manual before using the machine.
5. Wrong operation will result in surprising trouble or shortening the service life of the product, lowering the functions.
6. Please deliver this user manual to the next proprietor, together with the machine, if this machine is transferred to other people.
7. Put this book where it can be reached at any time, in order to use it over a long period of time.

### ▼ ATTENTION

**Cut off power supply before repair & maintenance.**

<b>Model</b>	<b>IE-321</b>
<b>Power Supply</b>	<b>AC 220V, 50/60HZ</b>
<b>Power Consumption</b>	<b>0.1/H (no-load)</b>
<b>Crimping Force</b>	<b>200KG</b>
<b>Operation Mode</b>	<b>Pedal Switch, Single Action / Ejector Pin, Touch Switch</b>
<b>Applicable Jacks</b>	<b>2-10P (different moulds for different jacks)</b>
<b>Motor Power</b>	<b>120W</b>
<b>Dimension</b>	<b>417 x 216 x 330mm</b>
<b>Weight</b>	<b>15KG</b>

## Preparations

After receiving equipment, unpack the box and put the equipment on a stable work surface!  
Take out the power cord, pedal switch and relevant accessories.

1. Plug the power cord and the pedal switch into the corresponding jacks respectively, then tighten the nuts to fix them (as shown in Figure 1).
2. Plug the GB three-pin plug of power cord into a AC220V power outlet (as shown in Figure 2).



Figure 1. Connectors of Power Cord and Pedal Switch



Figure 2. GB Three-Pin Plug

**The connectors of power cord and pedal switch adopt the fool-proof design. The black wire with three-core connector is the power cord, and the gray wire with two-core connector is the connection of pedal switch.**

## Control Panel



**1 Switch:** The switch is divided into three steps corresponding to three modes or states, step 1 is the automatic mode, step 2 close is to close equipment, and step 3 is the inching mode.

Automatic Mode: Changing switch to the automatic mode, the equipment will make one crimping according to the selected start mode.

Close Equipment: Changing switch to the close step, the equipment will be closed, and the power indicator will be on.

Inching Mode: Changing switch to the inch step, then pressing the mould adjustment button, the equipment will move up and down in the inching mode (for testing of equipment .)

**2 Start Mode Switch:** It is divided into two start modes, the pedal start mode and the ejector pin touch start mode.

Pedal Start: change switch to the pedal start mode, press the pedal switch, the equipment will make one crimping.

Touch Start: change switch to the touch start mode, put the jackets into the mould, and put them in place with help of an ejector pin, the equipment will make one crimping.

**3 Mould Adjustment Button / Power Indicator:** pressing this button for one time in the inching mode, the equipment will make one crimping. **The power indicator will be on all the time** as long as the equipment is connected to power.

**4 Reset Fuse:** No fuse holder is needed. When a short circuit occurs for equipment, the tripping of safety switch will be initiated. The equipment can be connected to power by pressing the reset fuse button after troubleshooting.

## Start Using

### Start Using Equipment:

- 1 Change switch to the automatic mode, select the start mode according to the operation habit (Figure 3).
- 2 Put pedal switch under the working table and adjust the seat position for a run test of equipment.
- 3 Put the jacks to be crimped into the mould, press the pedal switch, put the jacks in place, and the equipment starts crimping. After crimping, check the first product according to the product requirements (Figure 4) (the step is unnecessary for an experimenter).



Figure 3. Step Selection

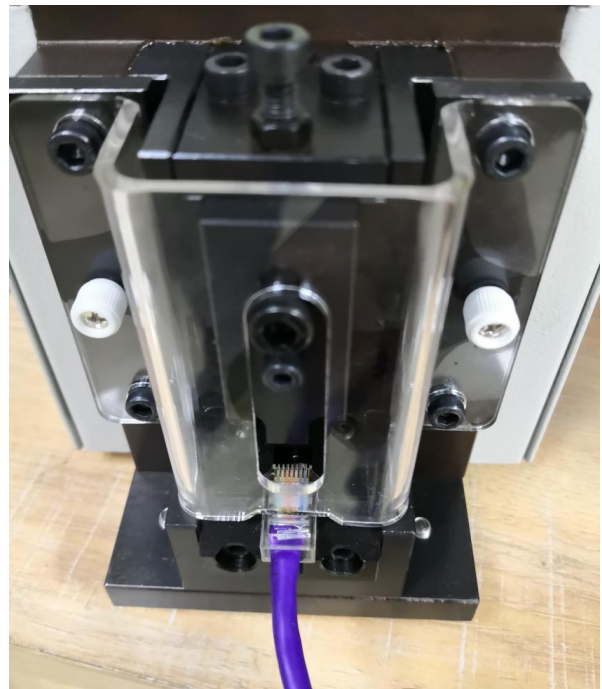


Figure 4. Put in Wires

## Crimping Height Adjustment

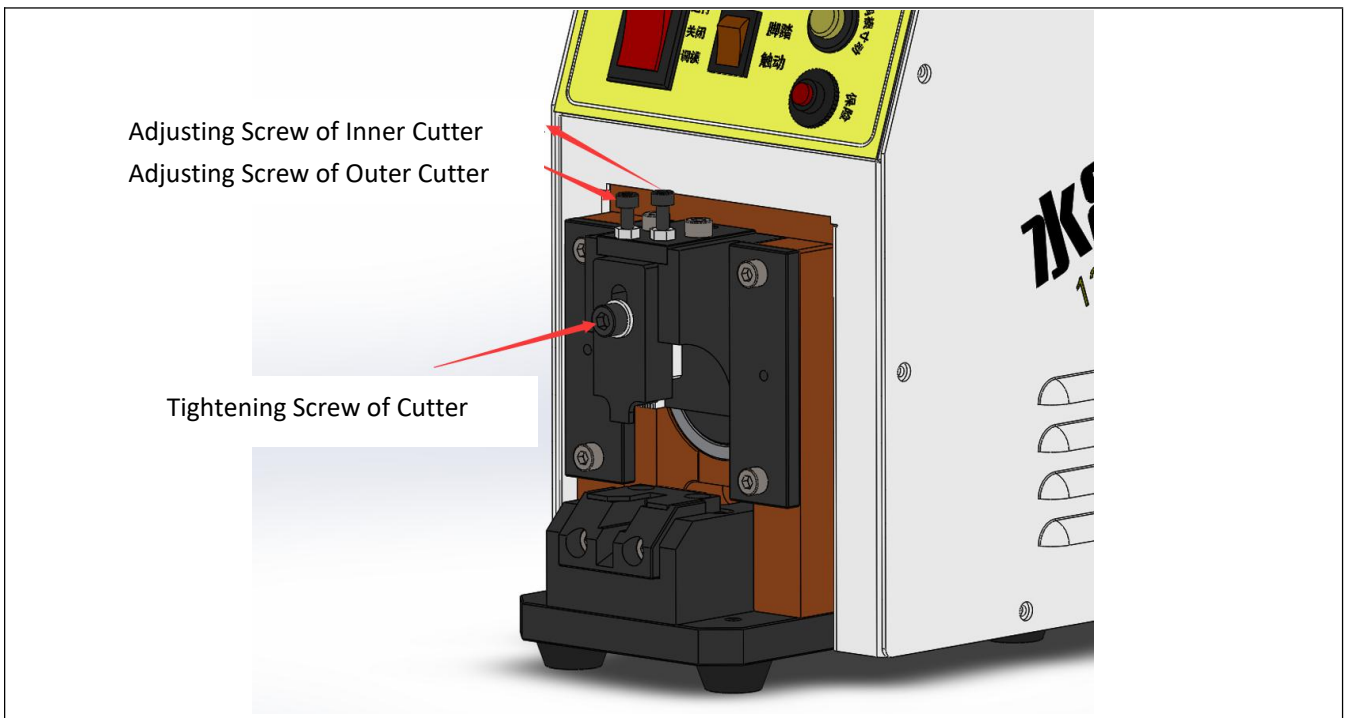


Figure 5. Screws

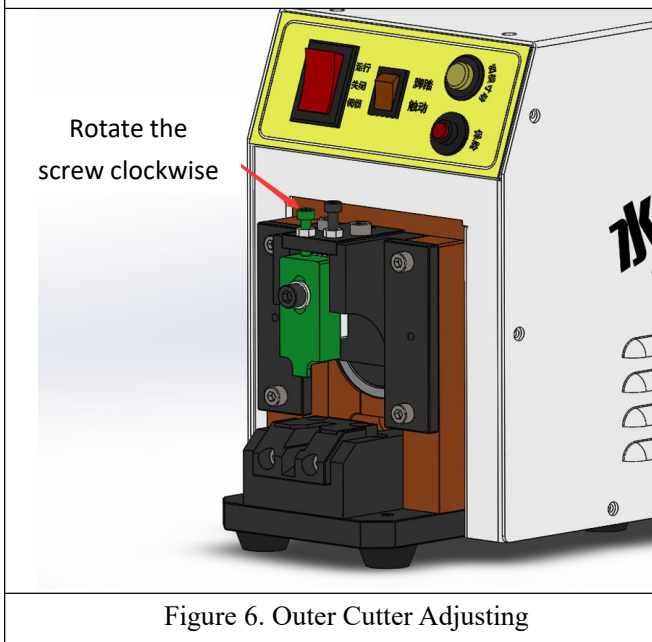


Figure 6. Outer Cutter Adjusting

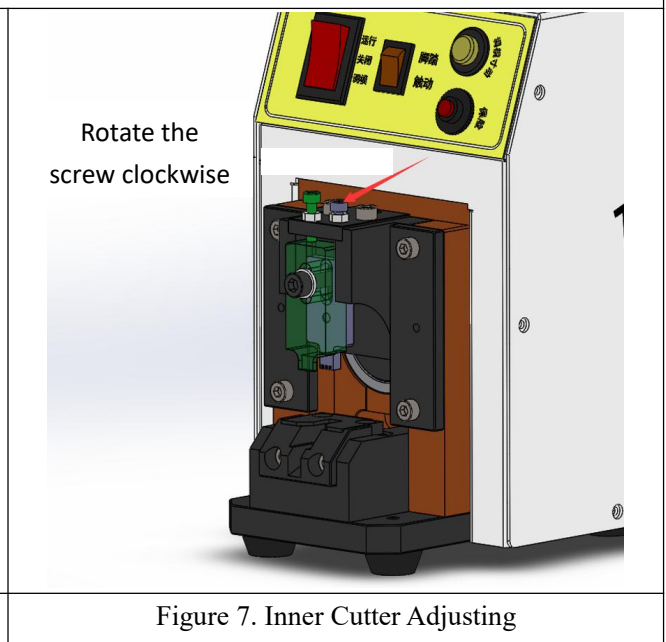


Figure 7. Inner Cutter Adjusting

**1: The cutter depth shall be correspondingly adjusted according to production requirements as shown in the figure above. Find the corresponding screw, loosen the nut, rotate the screw clockwise to make it extend downward, now the cutter will move downward, and the crimping depth will increase. Conversely, the crimping depth will decrease. **Note: the cutter tightening screw shall be firstly loosened for cutter depth adjustment. If you want to decrease the crimping depth, remember to push the cutter up before tightening the screw.****

## Mould Assembling & Disassembling and Replacement

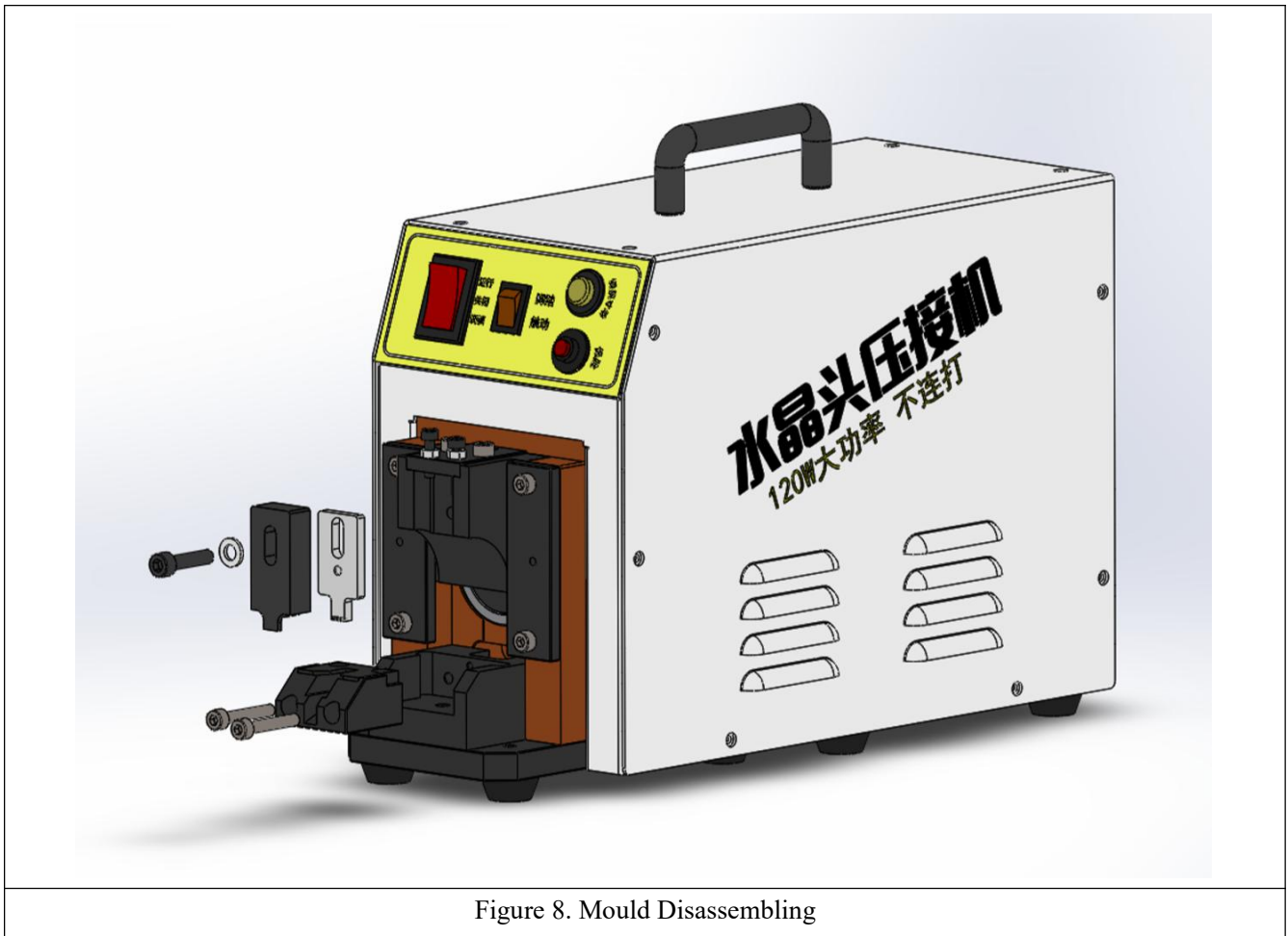


Figure 8. Mould Disassembling

### Cutter Assembling and Disassembling:

1. Loosen the corresponding screw and remove the screw and cutter in turn as shown in the figure above.
2. Assembling Order of Upper Cutter: tightening screw---upper crimping cutter---upper and inner cutter
3. Assembling Order of Lower Mould Base: tightening screw---lower mould base



## Replacement of Ejector Pin Microswitch

### Microswitch Replacement

1. Firstly place the equipment upside down(as shown in Figure 9), then loosen and remove the tightening screw at the bottom of equipment.

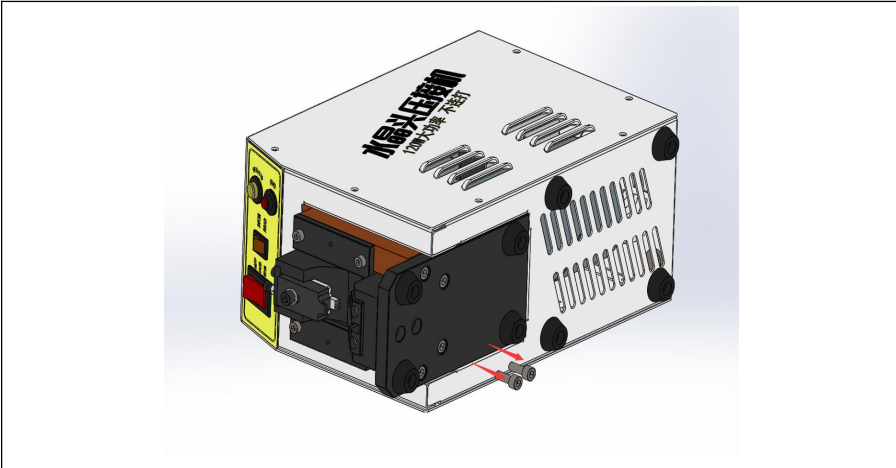


Figure 9. Loosen and remove the tightening screw at the bottom of equipment

2. Place the equipment in normal state, pull out the mould base (as shown in Figure 10). Loosen the Philip's head screw on the top of microswitch, remove the connecting wire with chromium iron, and remove the damaged microswitch.



Figure 10. Remove the base

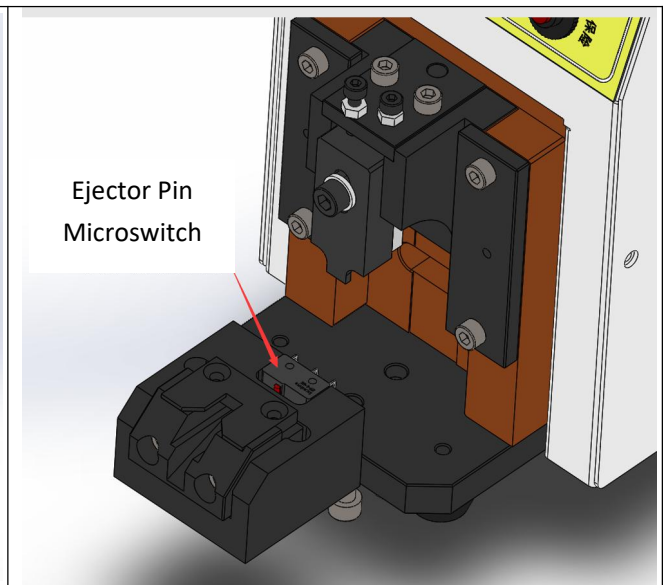


Figure 11. Replace the microswitch

3. Provided with a new microswitch, weld the connecting wire, tighten the Philip's head screw, straighten the wire, and push the mould base back to the clamping slot. Place the equipment upside down again, and tighten the tightening screw at the bottom of equipment.

**Note:** the connecting wire shall be straightened, and the extra wire shall be put in the case to protect it from being pressed by the returned mould base. In addition, please make sure that the welding spot is not contacted with the bottom seat to avoid power leakage!

## Position Switch and Delay Controller

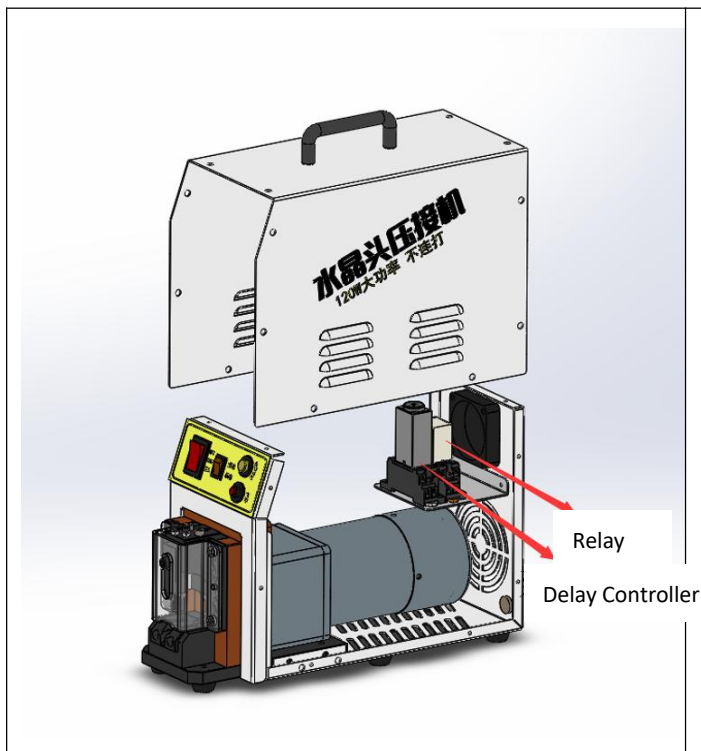


Figure 12. Delay Controller Combination

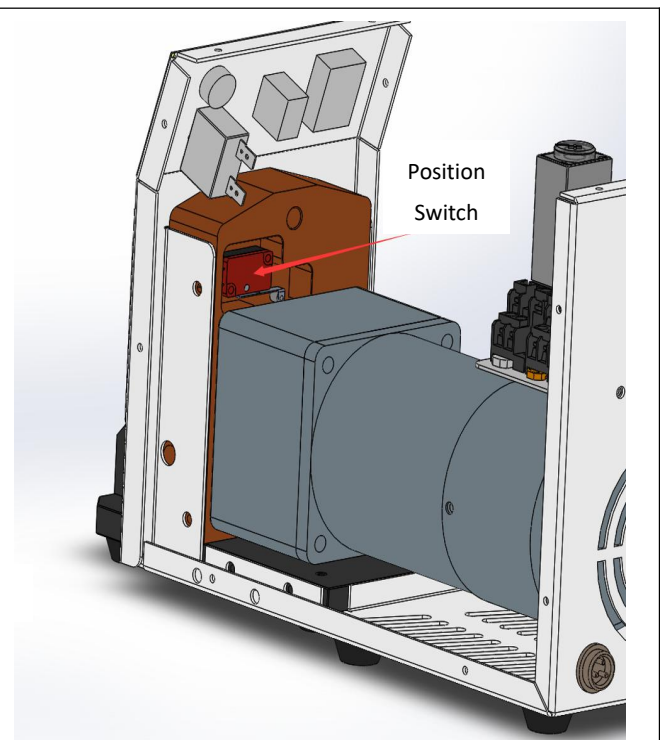


Figure 13. Position Switch

**Delay Controller Combination (Figure 12):** the control element to control the crimping times of equipment and whether the continuous stamping can be realized when the pedal switch keeps close.

If any electronic component of controller combination is damaged, the normal crimping of equipment also can be realized. If the pedal switch or the ejector pin switch keeps close, the equipment will keeps stamping until the switch is open.

**Position Switch (Figure 13):** to determine the start position and stop position of equipment. The switch is not controlled by the delay controller combination. If the stop position of eccentric cam changes due to motor brake pads worn, and the cam's clearance is incorrect because of its incorrect stop position or the position switch is damaged, the equipment will keep stamping!

### Summarize:

The switch failure and damage are the common faults of equipment, featuring as the continuous stamping of equipment. If continuous stamping occurs, the fault can be solved by checking or replacing the switch after investigation excluding the motor brake pads causes. Switches are the easily damaged components, especially the microswitch of ejector pin.