



## HB Series Threading Instructions (Weight Style Tensioner) GUIDES

Starting from when machine is unloaded, cleaned and Ready to spool

### Step one:

Turn on "wire prepare" on the hand pendant or virtual panel.

Un-thread wire guides.

Run wire drum to the right-hand stop adjusted within an inch or so from the right-hand side and stop with switch simultaneously.

**BE SURE TO SLIDE THE LEFT LIMIT FULLY TO THE LEFT**

### Step two:

Lock tensioner in furthest down position.

Install the wire spool on the shaft, finger tight, label towards the machine.

### Step three:

Place wire on the top of the drum, under the tab and turn drum 2-3 turns to get wire "straightened up" on the drum.

Make sure wire is rolling on guide roller under the spool of wire!

Turn the drum on LOW speed until the wire is at the desired amount on the drum, typically about 1-2" from the far-left side. (Tip: Lightly apply pressure with your finger on a supply wire spool when you stop it to help stop it from unspooling too much extra wire.)

### Step four:

Wind extra wire back onto wire spool until the wire is pulling straight and even with the drum. Cut wire and attach to the left fixing tab on the drum. Cut remnant.

**ADJUST THE LEFT LIMIT TO WHERE THE PHYSICAL LIMIT SWITCH IS SLIGHTLY TOUCHING THE INTERFERENCE BUMPER!**

Remove the plastic supply wire spool.

### Step Five:

Place the hand-crank in the drum and turn 30 times **Counter-clockwise**.

Remove hand-crank!

Place Tensioner in Middle locked position.

Thread machine normally from the top, making sure wire is centered on ALL roller guides, tensioner, and through your guides.

Attached wire to drum tab.

**\*\*Tip:** use a small magnet to hold the wire on the upper head while you work on threading the guides. Pull yourself 3-4 feet of extra wire to use while threading.

Make sure guides are snugged up.

### Step six:

Slowly roll drum back about 1.5 turns to verify rollers are still good and the wire is "straightened up".

Gently release tensioners and make sure the lock pin is in the out position so it can't re-lock. Turn drum several rotations to verify straight spooling onto the drum.

Run the wire drum to the left limit on LOW speed, making sure there is roughly 3/8" or slightly more wire still left when it reverses directions.

Run drum and adjust the left-hand limit, if necessary, with a finger ready on the switch!

The right-hand limit is normally adjusted properly, but always double check before going into high-speed mode!

### Step seven:

Verify the tensioner is running in the middle range of the travel, if it's at the top or bottom of the travel, un-hook wire from right side of drum and re-center the tensioner.

Tip: Always make sure you start on a new carbide position with every wire change over to prevent wire breaks.

**Contact Us With any Questions or Supply Needs**

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