



Operating Instructions
Wire Stripping and Crimping Machine
MC 40

Keep for future use!

Safety	1 - 3
Basic information	1
Symbols	1
Hazards posed by the machine	1
Correct use	2
Hazard sources	2
Work stations	2
Safety fixtures	3
Approved operators	3
Warranty	3
Description	4 - 9
Basic unit MC 40	4
Retrofitting kits	5
Use	6
Control elements - overview	7
Control elements - function	8
Putting into operation	10
Operation	11 - 16
Wire stripping	11
Wire stripping and pressing	14
Retooling	17 - 19
Faults	20
Self-help	21 - 30
Spare parts	31 - 33
Technical data	34
Rating plate	34
EC Declaration of Conformity	35

Basic information

Knowledge and observation of the safety instructions is a prerequisite for the safe use and fault-free operation of the MC 40.

Your safety is at stake!

The safety instructions must be followed by **all** persons who work with the MC 40.

The rules and regulations (particularly those concerning accident prevention) which apply to the machine's place of use must also be observed.

Symbols

The following symbols are used in these operating instructions:



Designates a possible **accident and injury hazard** or possible **damage** to the MC 40.



Designates **use instructions**.

Hazards posed by the machine

The MC 40 is constructed in accordance with the recognised technical safety regulations and has undergone a safety inspection and acceptance.

It is fitted with safety fixtures.

However, incorrect operation or misuse still means possible hazards to

- The operator's life and safety,
- the machine.

The MC 40 may only be used

- for its intended purpose and
- when it is in a perfectly safe condition.

All persons involved in commissioning, operating and maintaining the MC 40

- must be suitably qualified and
- must precisely follow these operating instructions.

Correct use

The MC 40 is intended exclusively for wire stripping and crimping work.

Only wires and wire end sleeves with cross sections and sleeve lengths as outlined in the Chapter **Description**, section on **Use**, may be used.

Only the insulated wires intended for processing may be inserted into the insertion funnel on the MC 40. Never insert solid metal parts or similar objects. This would destroy the wire stripping blades.

Unauthorised conversions that go beyond retooling and also modifications to the MC 40 are prohibited for safety reasons.



Correct use includes observing all instructions and following the stipulated operating conditions.

Hazard sources

Only filtered compressed air with a maximum pressure of 6 bar may be used.

The MC 40 may only be used with the front door closed.

Before carrying out any work for which the front door must be opened (e.g. retooling, self-help), in operating pauses and when the machine is not in use, always pull out the mains plug and disconnect the unit from the compressed air. **Do not** pull on the compressed air hose to disconnect it.

Ensure that no foreign objects are inside the housing.

Work stations

For operation and storage, avoid

- damp or dusty places,
- places which are subjected to high temperatures, direct sunlight or low temperatures (operating range: 15 C to 35 °C).

Condensation can form if the machine is moved from a cold place to a warm place.

Before using the MC 40, open the front door and allow any condensation to evaporate.

Do not spill any liquids onto the MC 40.

Do not subject the MC 40 to strong vibrations and impacts.

Protect the compressed air hoses from heat, oil and sharp edges.

Safety fixtures

The MC 40 is switched off by

- the mains switch (0 pressed, mains lamp is off).
- pulling out the mains plug and disconnecting the compressed air.
- opening the front door (via the safety switch).

The front door is installed for the operator's safety. Under no circumstances may it be modified, removed or bypassed by conversions.

A plate points out the existing hazards.



Approved operators

Only authorised and instructed operators may work on the MC 40.

The operator is responsible with respect to third parties in the operating area.

The owner must

- make the operating instructions available to the operator and
- ensure that the operator has read and understood them.

Warranty

Our "General sales and delivery conditions" always apply. These are made available to the user no later than when the contract is concluded.

Warranty and liability claims relating to personal injury and material damage shall not be possible in the event of the following contraventions:

- Incorrect use of the MC 40.
- Unsuitable work stations.
- Incorrect use which exceeds that described in the operating instructions.
- Unauthorised structural modifications to the MC 40.
- Continuing to operate the MC 40 even though faults have been detected.
- Incorrectly carried-out repairs.



Use only original end sleeves and original spare parts.

Basic unit MC 40

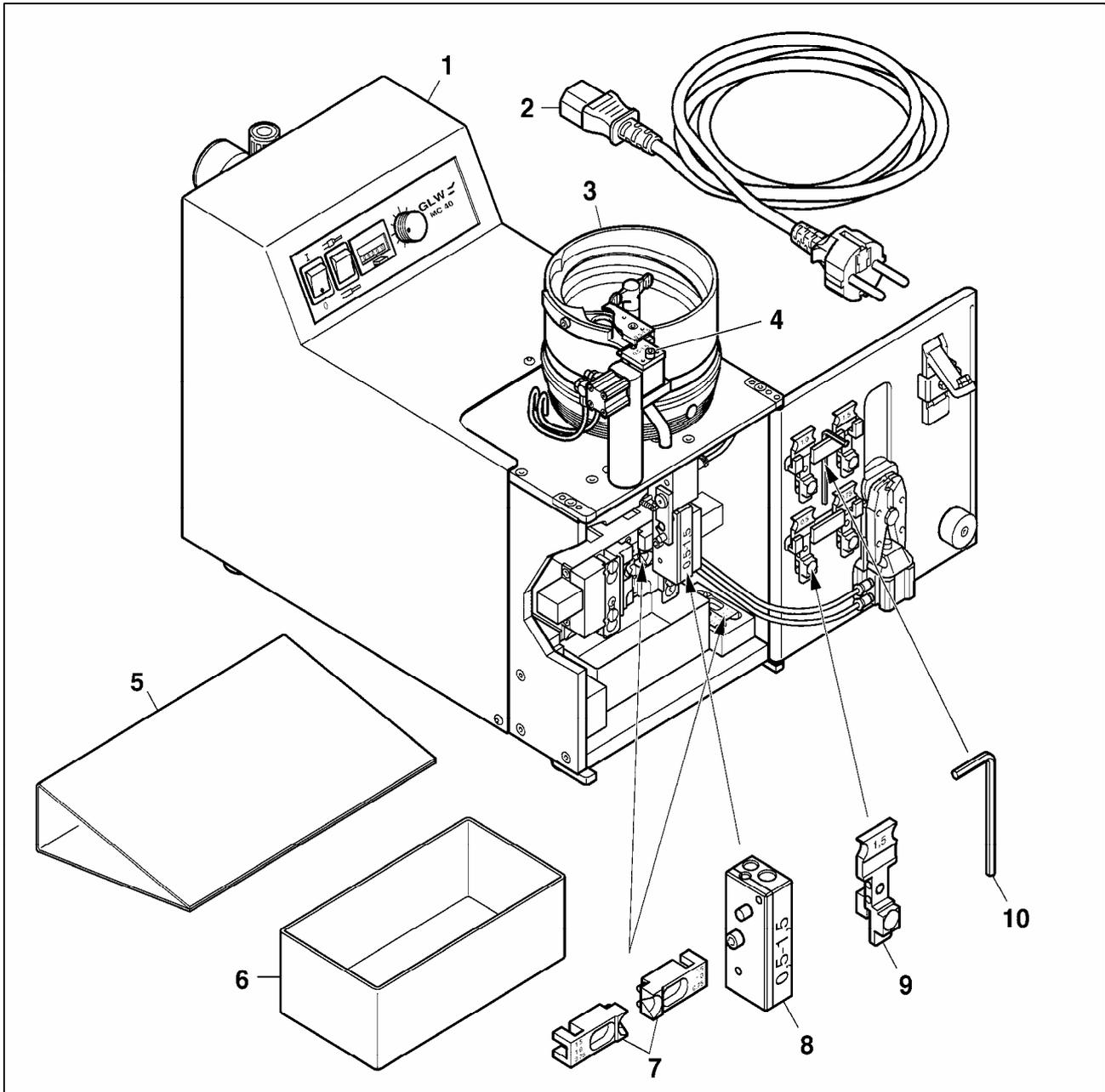


Figure 1

Basic Unit MC 40

1 MC 40	1 ea.	6 Waste box	1 ea.
2 Mains cable	1 ea.	7 Litz wire centring funnel	
3 Delivery drum 0.5 - 1.5	1 ea.	• 0.75/1/1.5 installed	1 Pair
4 Separator plate		• 0.5/0.75 retooling	
0.5 – 1.5 installed	1 ea.	8 Sleeve turning block 0.5 - 1.5	1 ea.
0.5 – 1.0 Retooling	1 ea.	9 Sleeve holder 0.5/0.75/1.0/1.5	1 ea.
5 Manual ,operating instructions.	1 ea.	10 Hexagon socket spanner 4 5/32"	

!

- The parts 9 have the same colour code as the ones for the wire end sleeves as outlined in the DIN colour series.
- The loose parts 7, 9, 10, 11 are packed in the waste box when the machine is delivered.

Retrofitting kits

Wires and wire end sleeves can be processed as shown in the table below with the basic unit MC 40 and the corresponding retrofitting kits.

- **Retrofitting kit 2.5 mm²**

The retrofitting kit consists of:

- Case (1)
- Delivery drum 2.5 (2)
- Sleeve turning block 2.5 (3)
- Litz wire centring funnel 2.5 (4)
- Sleeve holder 2.5 (5)
- Separator plate 2.5 (6)

Retrofitting is carried out as described in the chapter **RETOOLING**.

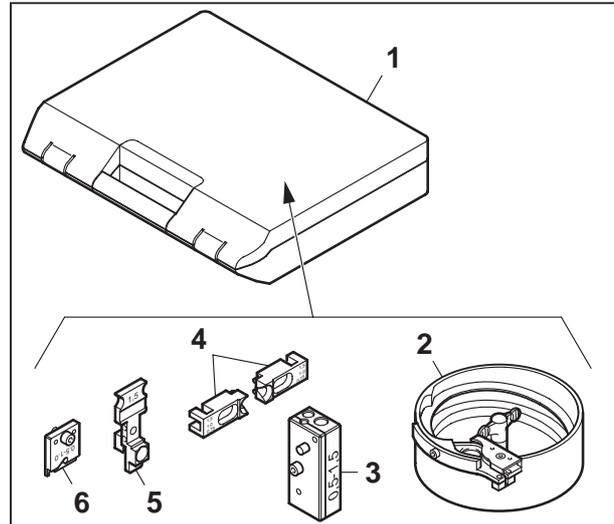


Figure 2

Retooling kit 2.5 mm

- **Retrofitting kit 0.25 / 0.34 mm²**

The retrofitting kit contains a comprehensive package.

Retrofitting is performed in accordance with the company leaflet.

- **Retrofitting kit 4.0 mm²**

The retrofitting kit contains a comprehensive package.

Retrofitting is performed in accordance with the company leaflet.

- **Start / pressing jaws**

Retrofitting with start bolts / pressing jaws 6 mm or 10 mm is performed in accordance with the company leaflet.

Use

The MC 40 can be optionally used to:

- strip wires fully automatically or
- strip wires fully automatically and press with the **Original GLW-Wire End Sleeves**.

Flexible wires of the classes 2, 5 and 6 as defined by DIN VDE 0295 and the wire end sleeves as loose products in accordance with DIN 46228, Part 4 are processed. Thanks to short cycle times (1.5 s) and easy cross section changing, the MC 40 is suitable for use in both workshops as well as in complex systems for preparing cables.

The following Original GLW- Wire End Sleeves can be processed with the MC 40:

Cross section mm ²	Sleeve length mm	DIN colour range	Notes
0.25 0.25	6 8	Yellow	Only with retrofitting kit 0.25 / 0.34 mm ²
0.34 0.34	6 8	Turquoise	
0.50* 0.50 0.50*	6 8 10	White	With the basic unit MC 40 and suitable start bolts / pressing jaws.
0.75* 0.75 0.75*	6 8 10	Grey	* Start bolts / pressing jaws for a stripping / sleeve length of 8 mm are installed in the basic unit MC 40.
1.00* 1.00 1.00*	6 8 10	Red	The start bolt and the pressing jaws must be changed for stripping / sleeve lengths of 6 mm or 10 mm.
1.50* 1.50 1.50*	6 8 10	Black	
2.50	8	Blue	
4.00	10	Grey	Only with retrofitting kit 4.0 mm ²

Control elements – Overview

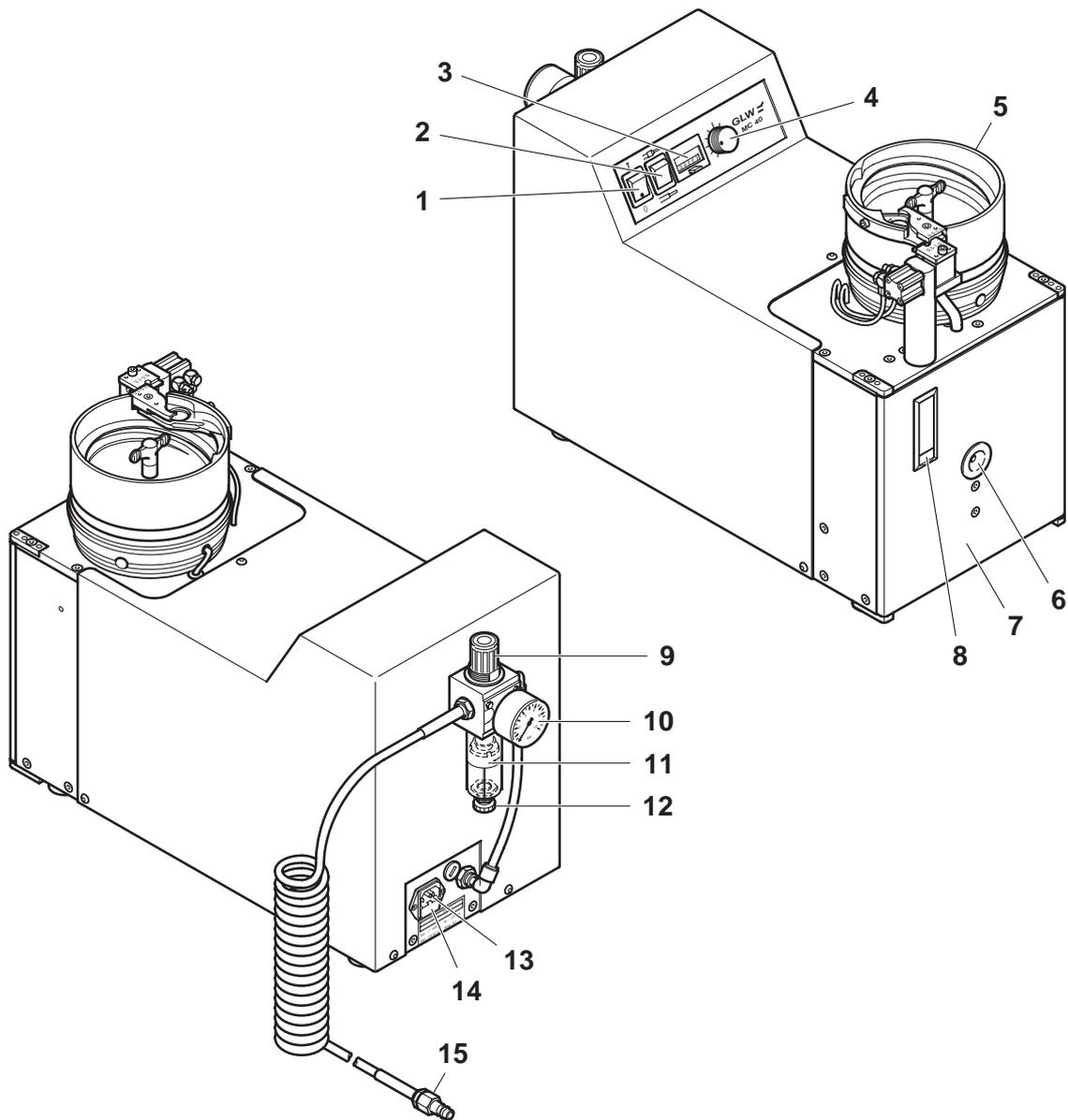


Figure 3 Control elements

- | | |
|----------------------------|-----------------------------|
| 1 Mains switch | 9 Air pressure controller |
| 2 Preselector switch | 10 Pressure gauge |
| 3 Counter | 11 Water separator |
| 4 Delivery drum controller | 12 Drainage valve |
| 5 Delivery drum | 13 Mains connection |
| 6 Insertion funnel | 14 Mains fuses |
| 7 Front door | 15 Compressed air connector |
| 8 Door lock | |

Control elements – Function

1 Mains switch

This switches the power supply for the MC 40 on (1 pressed) or off (0 pressed).
When switched on, the mains lamp integrated in the mains switch lights up.

2 Preselector switch

Select the operating mode:

-  pressed → strip wire and press with wire end sleeve
-  pressed → strip wire

3 Counter (00000 to 99999)

The counter shows the number of processing operations (stripping or stripping and pressing).
The Reset button integrated in the counter enables the counter to be manually reset to 0.

4 Delivery drum controller

The delivery drum controller allows the feed speed of the wire end sleeves in the delivery drum to be set.

Left stop min. → stepless → right stop max.

5 Delivery drum

Storage container for wire end sleeves.

Filling quantity max. 500 ea.

The delivery drum is only in operation in “stripping and pressing” mode (preselector switch  pressed).

The drum delivers continuously after switching-on with the mains switch.

The delivery drum is switched off for approximately 15 s after every crimping operation.

6 Insertion funnel

The wire being processed is guided into the MC 40 through the insertion funnel.

Processing begins automatically after insertion is complete.

7 Front door

This protects the operator against the moving parts in the MC 40.

The MC 40 operates only when the front door is completely closed.

8 Door lock

This locks the front door.

The front door is opened by pressing in the lower segment and is closed by pressing on the upper segment.

9 Air pressure controller

Adjustment of the operating air pressure, 5 bar. To adjust, pull up the controller and adjust the air pressure by turning it to the right (+) or left (-). Press the controller down when the air pressure is 5 bar.

10 Pressure gauge

This displays the air pressure set with the air pressure controller.

11 Water separator

Container for condensation water.

It must be emptied if the filling level reaches the marking Δ_{\max} .

12 Drainage valve

This empties the water separator.

13 Mains connection

Appliance connection for the mains cable.

14 Mains fuses

Miniature fuses M 400 / 250 C integrated in the mains connection.

Internal fuse → Operational fuse.

External fuse → Reserve.

15 Compressed air connection

Appliance connection to the compressed air supply.

1. Selecting the installation location

- The installation location must be level and horizontal.

! The conditions in the chapter **SAFETY** (the Work stations section) must be observed.

2. Define the cross section

- Depending on the cross section used, it is possible to fit the MC 40 with different retooling kits.
- Open the front door (1).
- The retooling kits are shown in Figure 23.
- Tool the MC 40 as described in the chapter **RETOOLING, steps 2 to 7**.
- Close the front door (2).

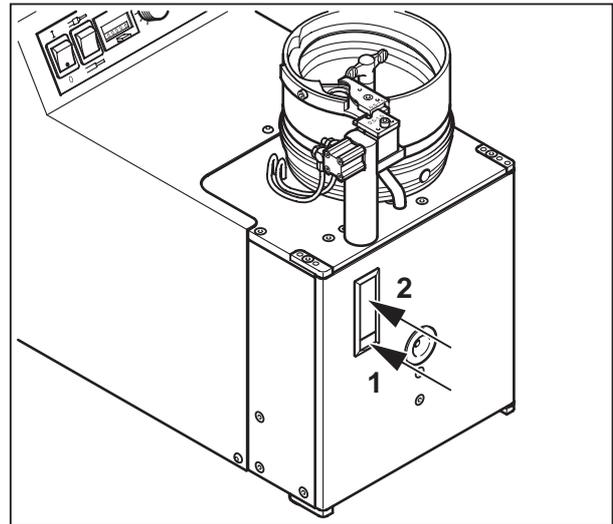


Figure 4 Opening the front door

3. Connecting the MC 40

- Check the compressed air supply:

! min. 4 bar, max. 6 bar filtered air.

- Connect the compressed air port (1) to the compressed air supply.
- Check the air pressure on the pressure gauge (2):
Operating pressure 5 bar, min. 4 bar.
- Set the air pressure as required. To do this, pull up the air pressure controller (3), set the air pressure to 5 bar by turning (4) to the right (+) or left (-) and then press down the controller (5).
- Connect the mains plug (6) to the mains connection of the MC 40 and the earthing pin plug (7) to the mains socket.

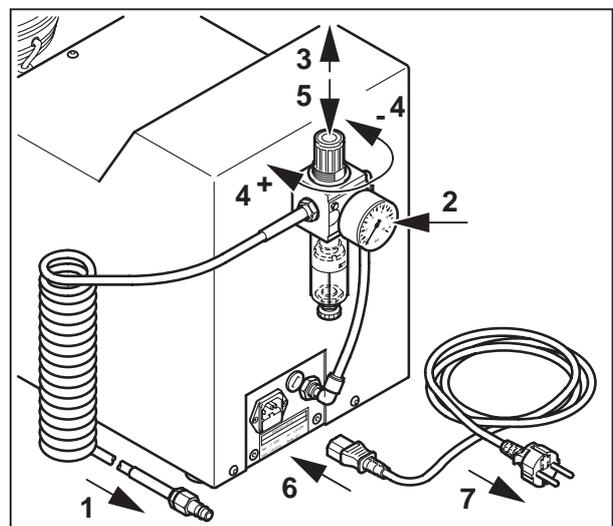


Figure 5 MC 40 connection

You can then continue with **OPERATION**.

WIRE STRIPPING

1. Check the sleeve holder

- Open the front door (1).
- Check whether the sleeve holder and litz wire centring funnels are inserted for the wire cross section used. If necessary, set them in accordance with the chapter **RETOOLING**, **step 1 and 2 and 4 to 6**.
- Check whether the sleeve holder (2) is free of wire end sleeves.

Before working on the MC 40, pull out the mains plug and disconnect the compressed air.

- Close the front door (3).

2. Align the wires

- Before working, it is necessary to align the wires so that they are approximately straight.

3. Cut the wires to size

- Cut off the wires cleanly and straight.

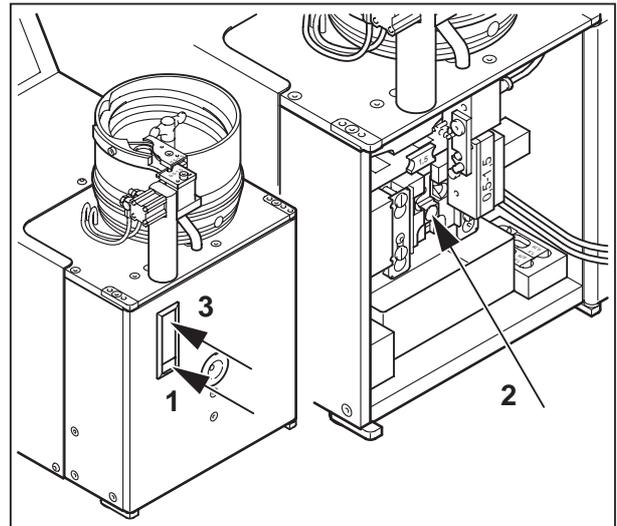


Figure 6 Check the sleeve holder

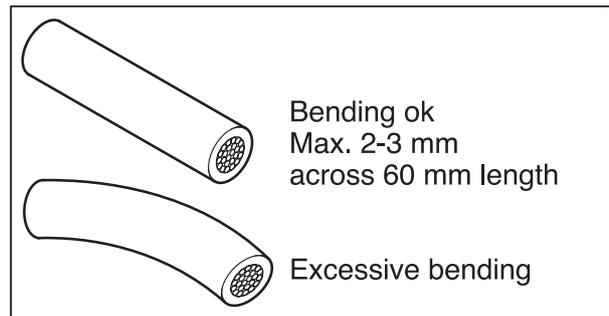


Figure 7 Align the wires

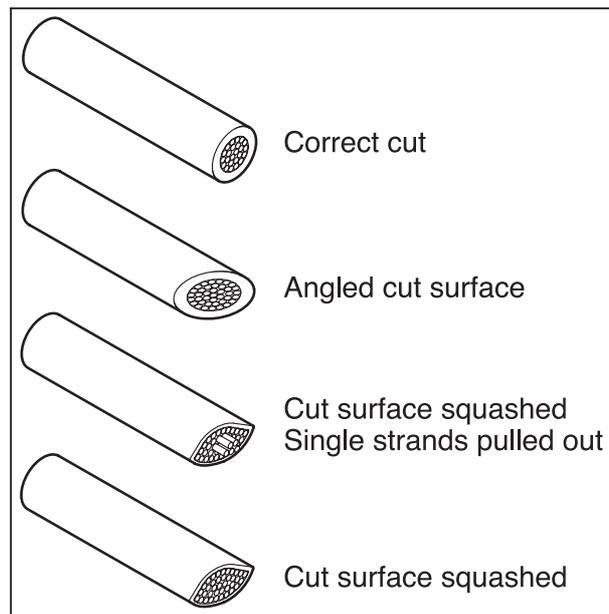


Figure 8 Cut wires to length

4. Strip the wires

- Read off the counter (1) as necessary and reset it to zero.
- Switch the preselector switch (2) to "strip". (press .
- Switch on the MC 40 with the mains switch (3) (press I, the mains lamp lights up).
- Push the wire (4) in a straight line as far as it will go into the insertion funnel and keep it under slight tension during stripping.
- The stripping process runs automatically.
- After the MC 40 comes to standstill, pull out the wire (5) in a straight line.

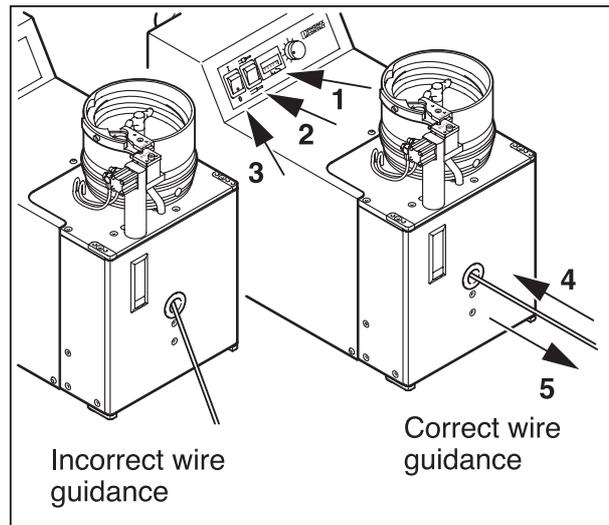


Figure 9 Strip the wires

! Refer to chapter **FAULTS** in the event of operation faults or incorrect stripping.

5. Put out of operation

- Read off the counter (1) as necessary and reset it to zero.
- Switch off the MC 40 with the mains switch (2) (press 0, the mains lamp goes out).

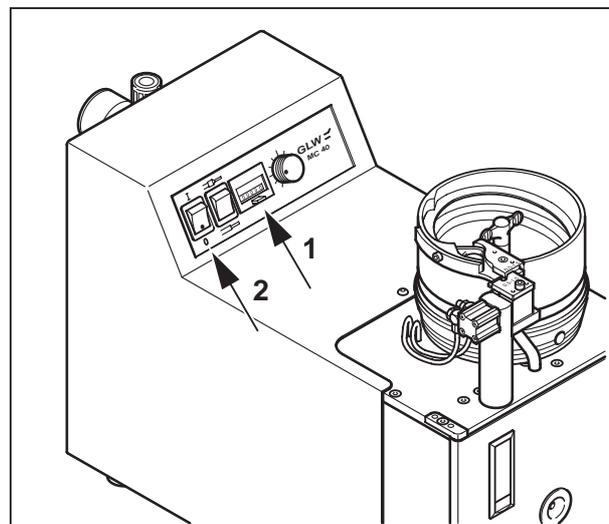


Figure 10 Put out of operation

6. Daily care

- ⚠ **The front door must be opened.
Pull out the mains plug.
Disconnect the compressed air.**

6.1 Switch off the MC 40

- Switch off the MC 40 with the mains switch (1) (press 0, the mains lamp is off).
- Pull out the mains plug (2).
- Disconnect the compressed air connection (3).

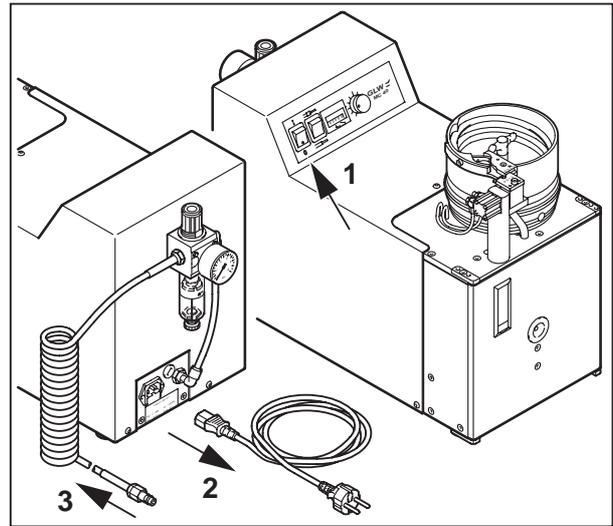


Figure 11 Switch off the MC 40

6.2 Clean the MC 40

- Open the front door (1).
- Empty the drawer (2).
- Clean the interior.
- Insert the drawer (3).
- Close the front door (4).

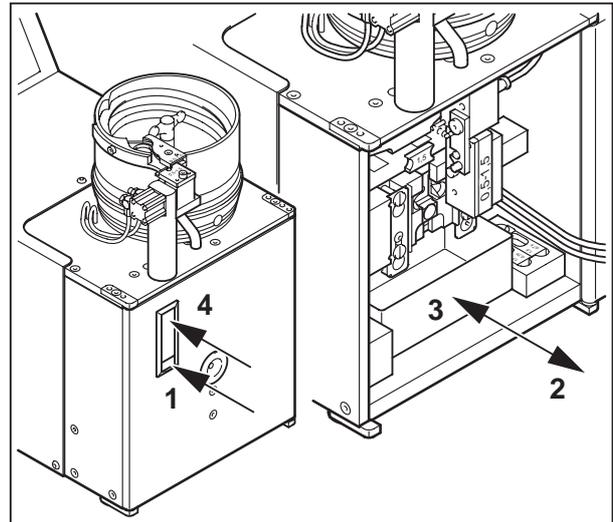


Figure 12 Clean the MC 40

6.3 Check the condensation level

- Check the water level in the water separator (1).
- If the water level has reached the mark Δ_{max} (2), put a container underneath, unscrew the drainage valve (3), drain off the water and screw on the drainage valve (4).

- ⚠ **The compressed air must be disconnected.**

- Connect the mains plug (5).
- Connect the compressed air connection (6).

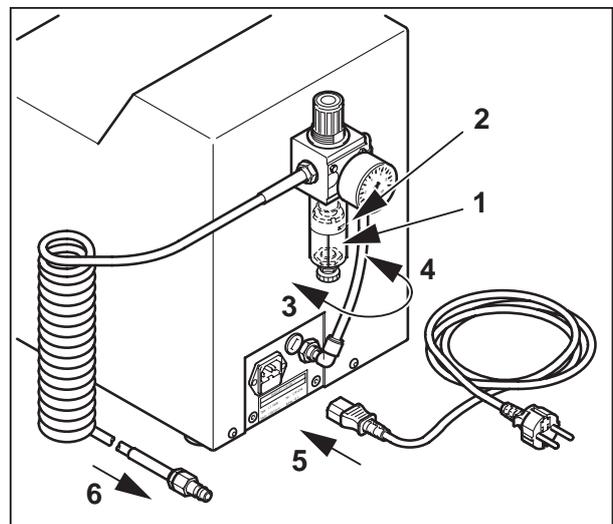


Figure 13 Check condensation

STRIPPING AND PRESSING

1. Check the cross section

- Open the front door (1).
- Check the correct cross section setting, see Figure 23; if necessary, tool in accordance with the chapter **RETOOLING**, steps 1 – 7.



Before working on the MC 40, pull out the mains plug and disconnect the compressed air.

- Close the front door (2).
- Fill the delivery drum (3) with wire end sleeves (max. 500).

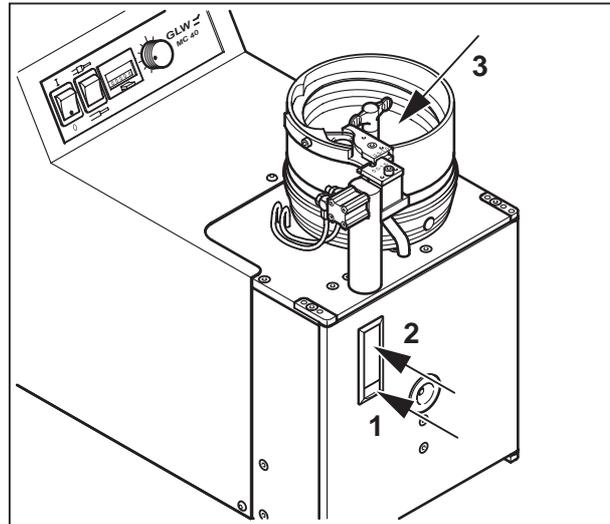


Figure 14 Check the cross section

2. Align the wire

- Before working, the wire must be aligned approximately straight.

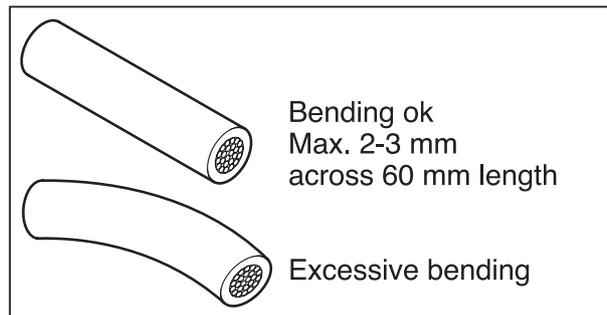


Figure 15 Align the wire

3. Cut the wire to size

- Cut off the wire cleanly and straight.



Incorrect cutting frequently results in incorrect crimping.

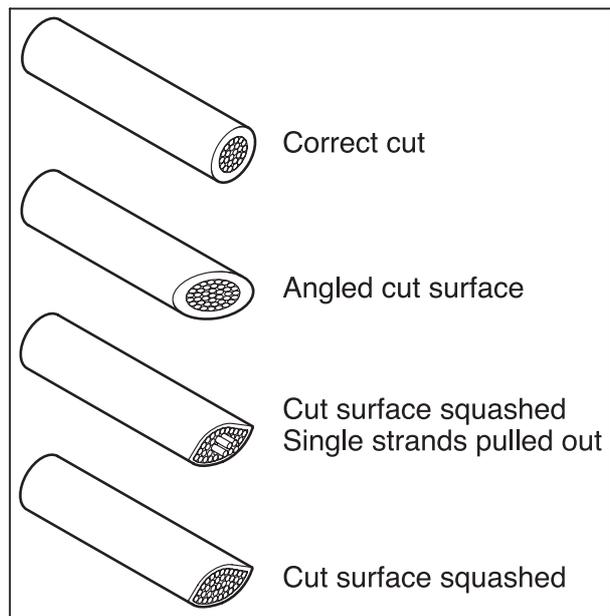


Figure 16 Cut the wire to size

4. Crimp the wire

- Read off the counter (1) as required and reset it to zero.
- Switch the preselector switch (2) to "strip and press" (press).
- Switch on the MC 40 with the mains switch (3) (Press I, the mains lamp lights up).
- Set the feed speed of the wire end sleeves with the delivery drum controller (4).
- Wait until the wire end sleeve is visible at the separator plate (5) and check if there is a pile-up.
- Push the wire (6) in a straight line as far as it will go into the insertion funnel and keep it under slight tension during crimping.
- The crimping procedure runs automatically.
- After the MC 40 comes to standstill, pull out the wire in a straight line.

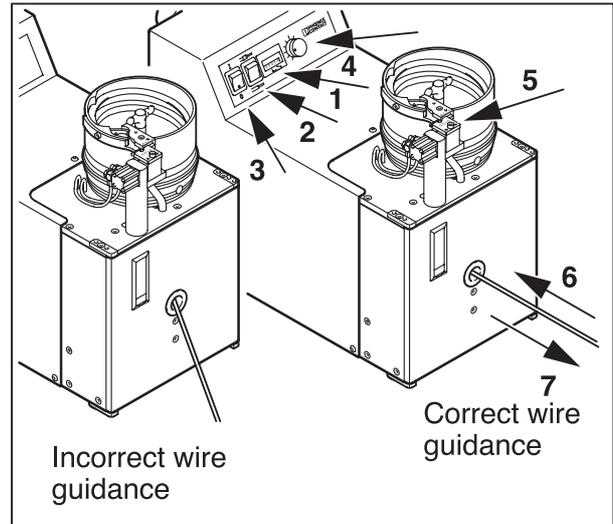


Figure 17 Crimp the wire

! Refer to the chapter **FAULTS** in the event of operational faults or incorrect crimping.

5. Putting out of operation

- Read off the counter (1) as necessary and reset it to 0.
- Switch off the MC 40 with the mains switch (2) (press 0, mains lamp if off).

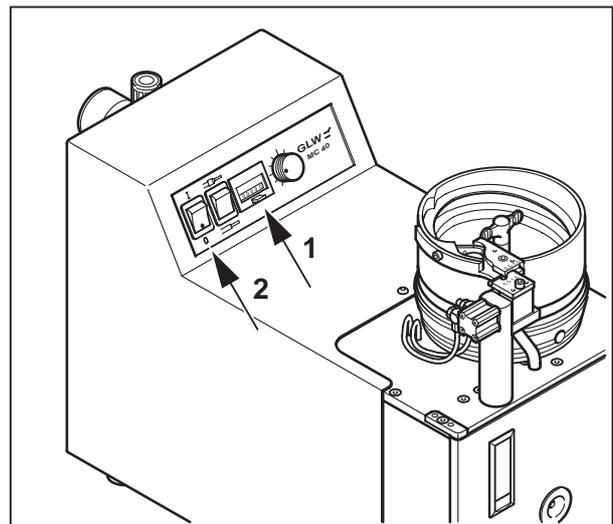


Figure 18 Put out of operation

6. Daily care

- ⚠ The front door must be opened.
Pull out the mains plug.
Disconnect the compressed air.**

6.1 Switch off the MC 40

- Switch off the MC 40 with the mains switch (1) and (press 0, mains lamp is off).
- Pull out the mains plug (2).
- Disconnect the compressed air connection (3).

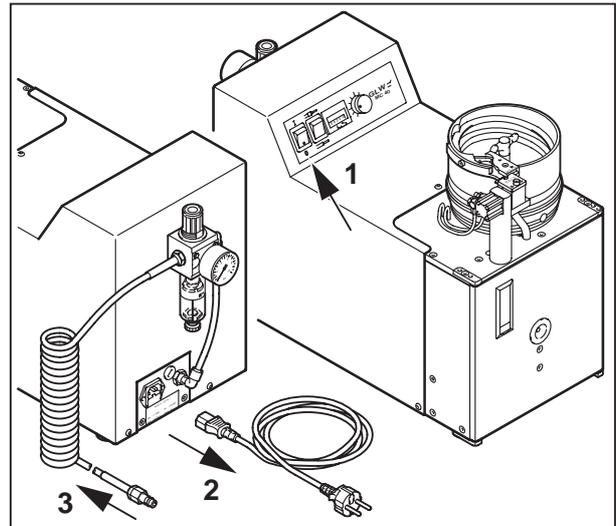


Figure 19 Switch off the MC 40

6.2 Clean the MC 40

- Open the front door (1).
- Empty the drawer.
- Clean the interior.
- Insert the drawer (3).
- Close the front door (4).

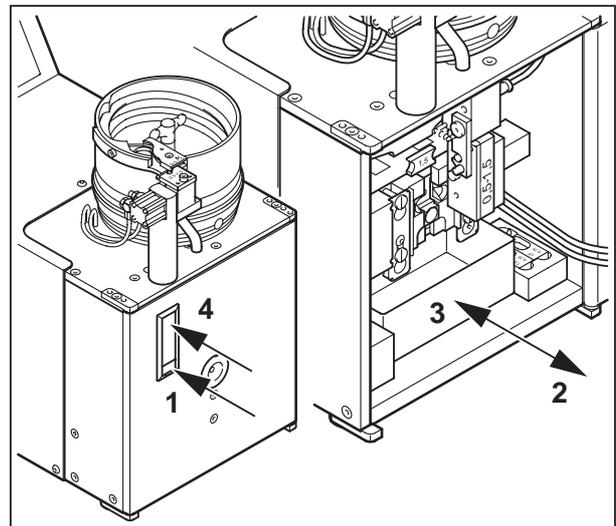


Figure 20 Clean the MC 40

6.3 Check the condensation level

- Check the water level in the water separator (1).
- If the water level has reached the mark Δ_{max} (2), put a container underneath, unscrew the drainage valve (3), drain off the water and screw on the drainage valve (4).

- ⚠ The compressed air must be disconnected.**

- Connect the mains plug (5).
- Connect the compressed air connection (6).

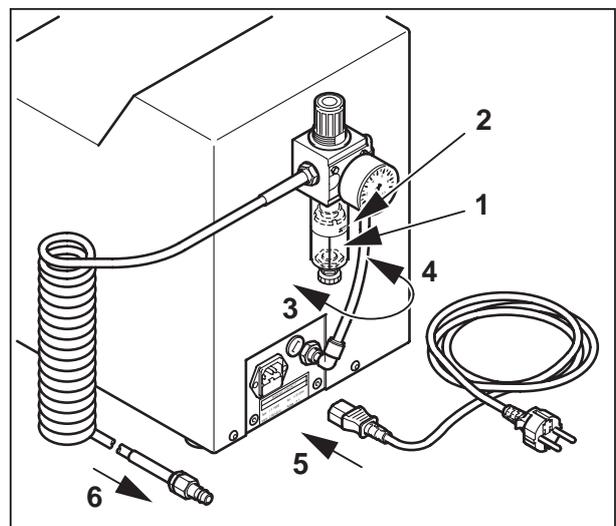


Figure 21 Check the condensation level

1. Preparing for retooling

**⚠ The front door must be opened.
Pull out the mains plug.
Disconnect the compressed air**

- Switch off the MC 40 with the mains switch (1) (press 0, the mains lamp is off).
- Pull out the mains plug (2).
- Disconnect the compressed air connector (3).
- Remove the delivery drum (4), empty it and change it if necessary, see Step 3.
- Open the front door (5).

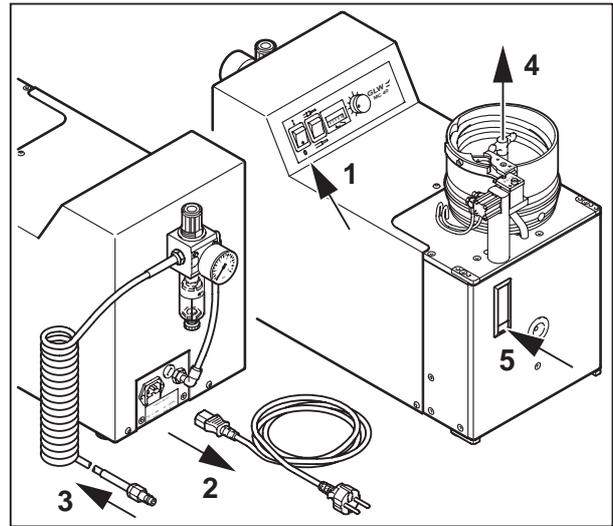


Figure 22 Preparing for retooling

2. Defining the cross section

- Figure 23 shows which retooling kit must be used for which cross section.
- Depending on the retooling parts required, install them in accordance with Steps 3 to 7.
- The start bolt must be changed for stripping sleeve lengths 6 mm or 10 mm (see the company leaflet for the retooling kit).

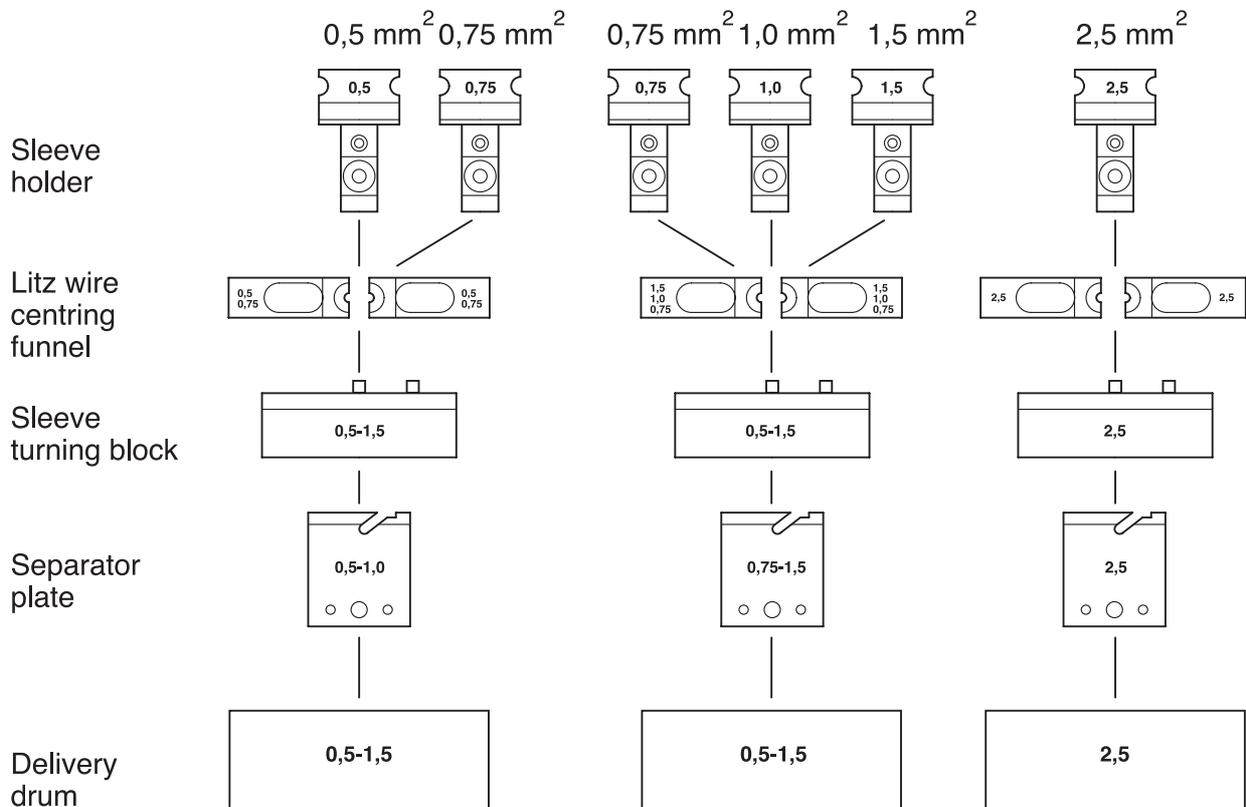


Figure 23 Retooling kits

3. Changing the delivery drum

! The delivery drum must be changed if the cross section is changed
0.5/0.75/1.0/1.5 ↔ 2.5.

- Unscrew the wing screw (1).
- Remove and empty the delivery drum (2).

! Ensure that all wire end sleeves, particularly in the slot below the chicane (3), are removed.

- Place on the delivery drum so that it slides into the centring pins (4).
- Screw on the wing screw (5).

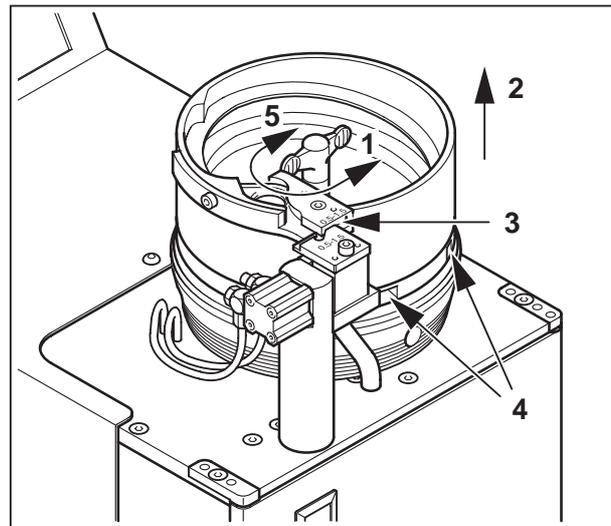


Figure 24 Changing the delivery drum

4. Changing the sleeve turning block

! The sleeve turning block must be changed if the cross section is changed
0.5/0.75/1.0/1.5 ↔ 2.5.

- Pull the unlocking lever (1) forwards.
- Pull off the sleeve turning block (2) downwards.
- Hold the unlocking lever securely in the front position and attach the sleeve turning block with the required cross section (3).
- Allow the unlocking lever (4) to engage.

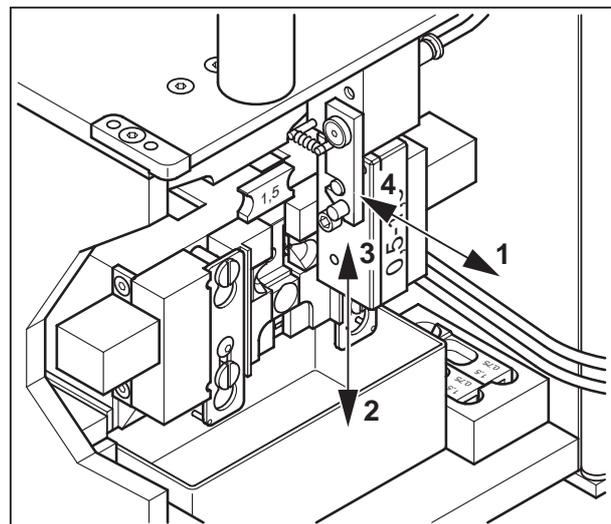


Figure 25 Changing the sleeve turning block

5. Changing the sleeve holder

! The sleeve holder must be changed whenever the cross section is changed.

- Remove the sleeve turning block as described in Step 4.
- Pull up the sleeve holder (1), remove it from the holding fixture and insert it into the transport holder (2).
- Remove the sleeve holder with the required cross section (3) from the transport holder or retrofitting kit, insert it into the holding fixture and press down (4).

! Check that it correctly engaged.

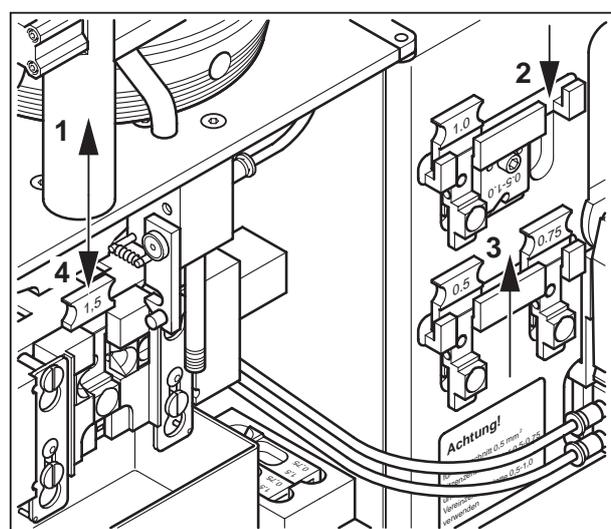


Figure 26 Changing the sleeve holder

- Install the sleeve turning block as described in Step 4.

6. Changing the litz wire centring funnels

! The litz wire centring funnels must be changed whenever the cross section is changed 0.5/0.75 ↔ 1.0/1.5 ↔ 2.5.

- Remove the sleeve holder as described in Step 5.
- Push up the slider (1) and pull off the holder (2) forwards.
- Remove the litz wire centring funnel (3).
- Remove litz wire centring funnel with the required cross section (4) from the transport holder or retrofitting kit and place it on the driver pins (5).
- Place on the holding fixture (6) and press down the slider (7).
- Change the second litz wire centring funnel in the same way.
- Store the old litz wire centring funnel in the transport holder (9) or in the retrofitting kit.
- Install the sleeve holder as described in Step 5.

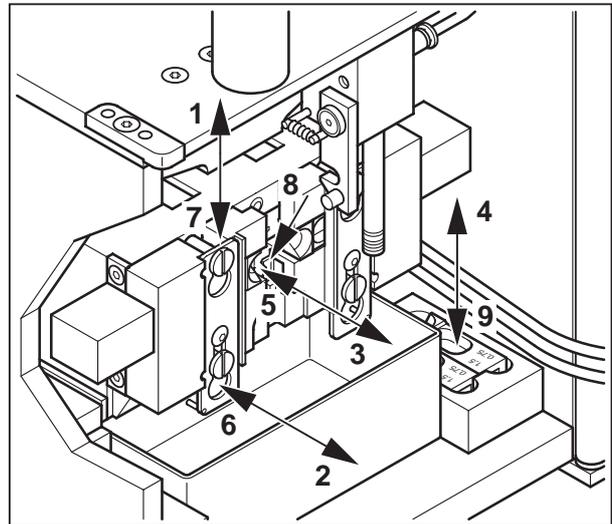


Figure 27 Changing the litz wire centring funnels

7. Changing the separator plate

! The separator plate must be changed when the cross section is changed 0.5 ↔ 0.75/1.0/1.5 ↔ 2.5.

- Unscrew the separator plate (1) with the hexagon socket spanner.
- Unscrew the separator plate with the required cross section from the transport holder (2) or take it from the retrofitting kit and screw it on in place of the original separator plate (3).
- Screw the old separator plate onto the transport holder (4) or store it in the retrofitting kit.

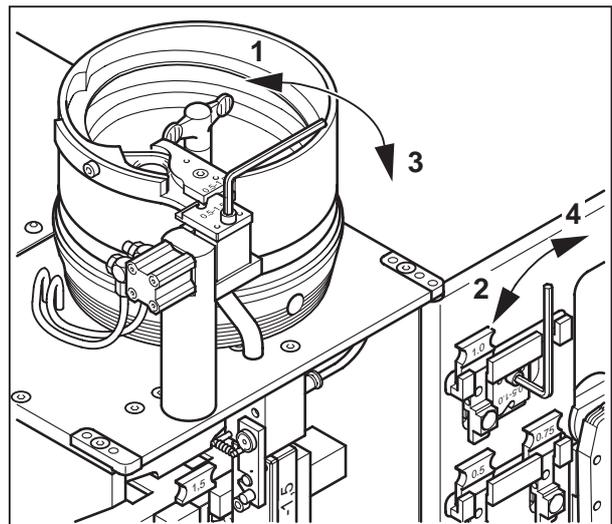


Figure 28 Changing the separator plate

In the event of a unit fault, the type of self-help depends on the fault scenario.

After the fault scenario is assessed, the self-help can be carried out in a targeted way under the defined fault scenario.

Fault scenario 1

The MC 40 does not work after it is switched on.

Fault scenario 2

The start procedure is not initiated when a wire is pressed in.

Fault scenario 3

The start procedure is initiated, but processing is not ended.

Fault scenario 4

The wire is not correctly held in place during stripping.

Fault scenario 5

The wire insulation is not completely removed.

Fault scenario 6

The wire end sleeve is not correctly pressed.

Fault scenario 7

Problem with delivery of the wire end sleeves.

Fault scenario 1

The MC 40 does not work after it is switched on.

1. Check the mains lamp

- Does the mains lamp light up (1)?

Yes: Check the air pressure, Step 3.

No: Check whether the mains plug is connected to the mains connector of the MC 40 and whether the earthing pin plug is connected to the mains socket. Ensure that the power supply at the mains socket is in order. If it is in order → Step 2.

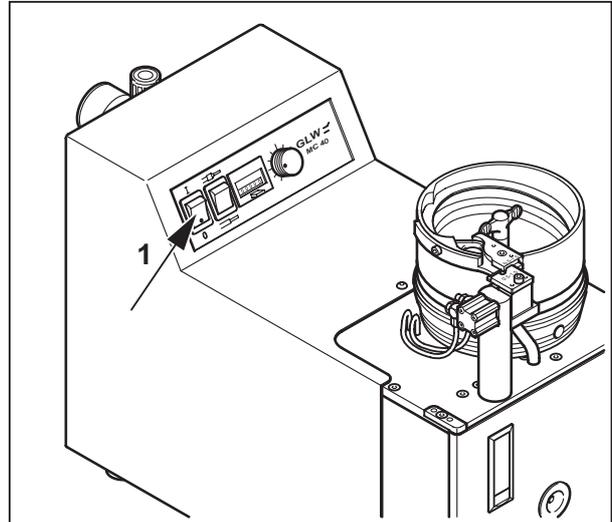


Figure 29 Check the mains lamp

2. Check the mains fuse

**⚠ The mains connection must be open.
Pull out the mains plug.**

- Switch off the MC 40 with the mains switch (press 0, the mains lamp is off).
- Pull out the mains plug (1).
- Pull out the fuse holder (2).
- Check the mains fuse (3).
- Replace the mains fuse with a reserve fuse (4). Reserve fuse retrofiting, Article No. see the Chapter **SPARE PARTS**.
- Push in the fuse holder.

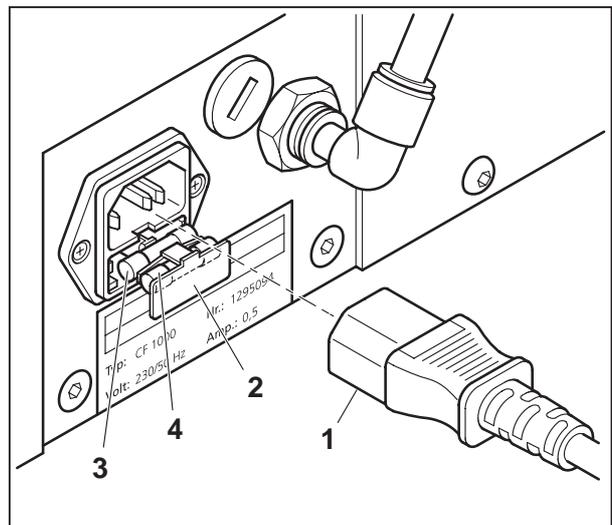


Figure 30 Check the mains fuse

! The fuse holder must engage.

3. Check the air pressure

- Check the air pressure at the pressure gauge (1): 5 bar.

No pressure

Check whether the compressed air port is connected to the compressed air supply. Ensure that the compressed air supply is in order.

Pressure not 5 bar

Pull up the air pressure regulator (2), set the air pressure to 5 bar (min. 4 bar) by turning (3) to the right (+) or to the left (-) and then press down the regulator (4).

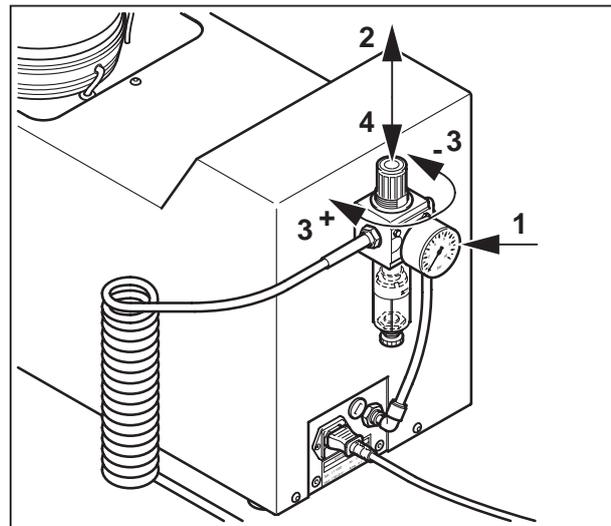


Figure 31 Check the air pressure

Fault scenario 2

The start procedure is not initiated when a wire is pressed in.

1. Check the front door

- Check whether the front door (1) is completely closed and locked.

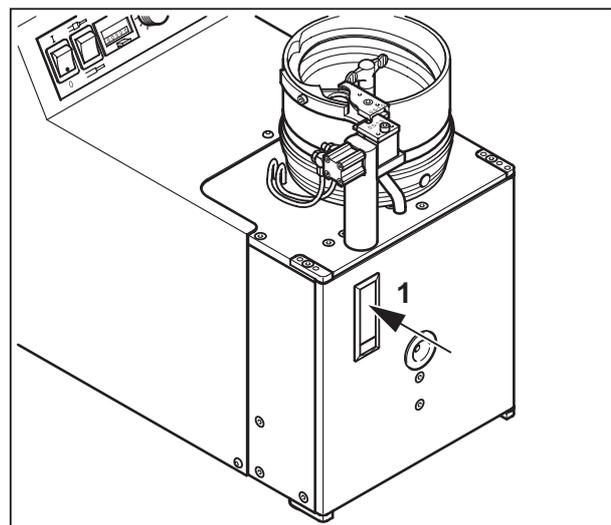


Figure 32 Check the front door

2. Check the air pressure

- Check the air pressure on the pressure gauge (1): 5 bar.
- Adjust the air pressure if necessary. To do this, pull up the air pressure regulator (2), set the air pressure to 5 bar (min. 4 bar) by turning (3) to the right (+) or to the left (-) and then press down the regulator (4).

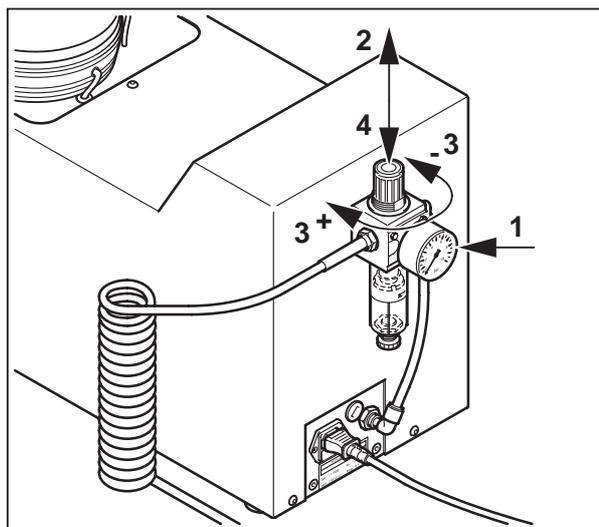


Figure 33 Check the air pressure

3. Check the sleeve holder

**⚠ The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air!**

- Switch off the MC 40 with the mains switch (press 0, the mains lamp is off).
- Disconnect the compressed air port.
- Open the front door.
- Pull the unlocking lever (1) forwards.
- Pull off the sleeve turning block (2) downwards.

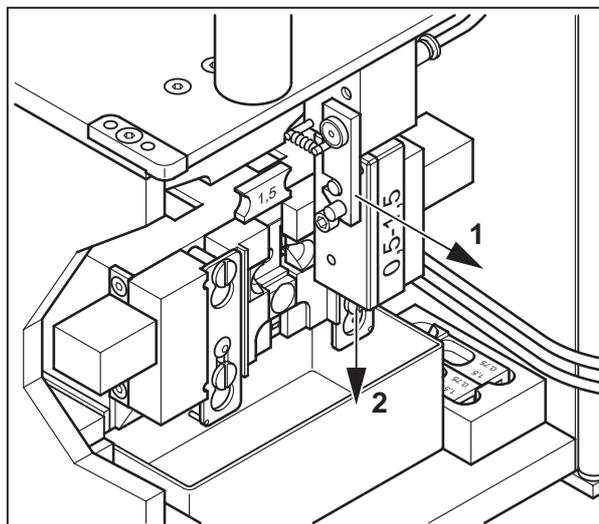


Figure 34 Remove the sleeve turning

- Check whether the sleeve holder (1) is sitting correctly and is engaged in the ball catch.
- Install the sleeve holder.
- Close the front door.

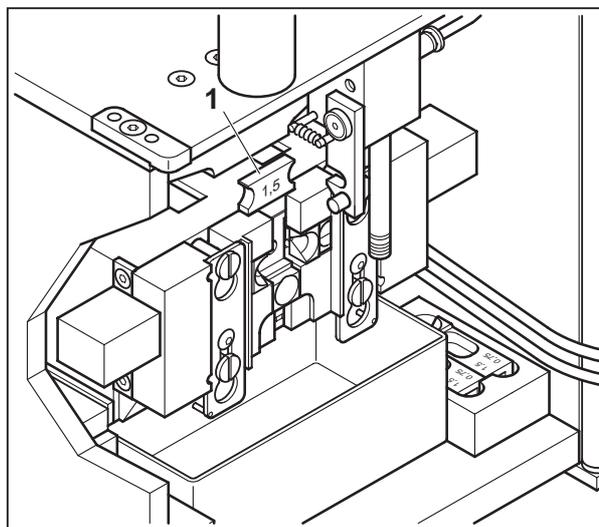


Figure 35 Check the sleeve holder

Fault scenario 3

The start procedure is initiated, but processing is not ended.

- Check the air pressure on the pressure gauge (1): 5 bar.
- Adjust the air pressure if necessary. To do this, pull up the air pressure regulator (2), set the air pressure to 5 bar (min. 4 bar) by turning (3) to the right (+) or to the left (-) and then press down the regulator (4).

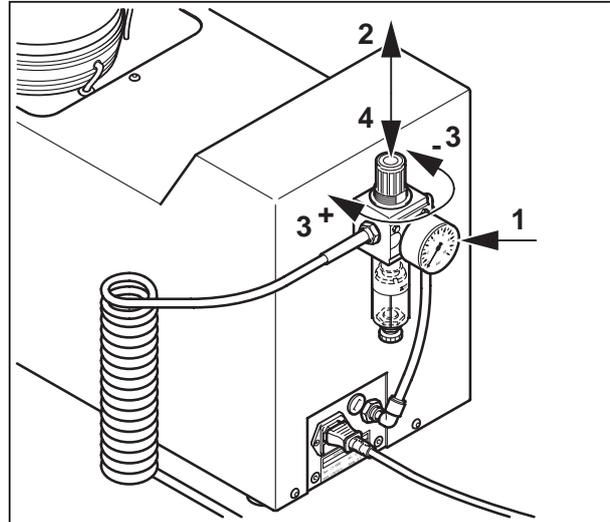


Figure 36 Check the air pressure

Fault scenario 4

The wire is not correctly held in place during stripping.

- ⚠ **The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air.**

- Insulation remnants or wire end sleeves have got stuck in the retaining tongs.
- Clean the holding jaws (1).

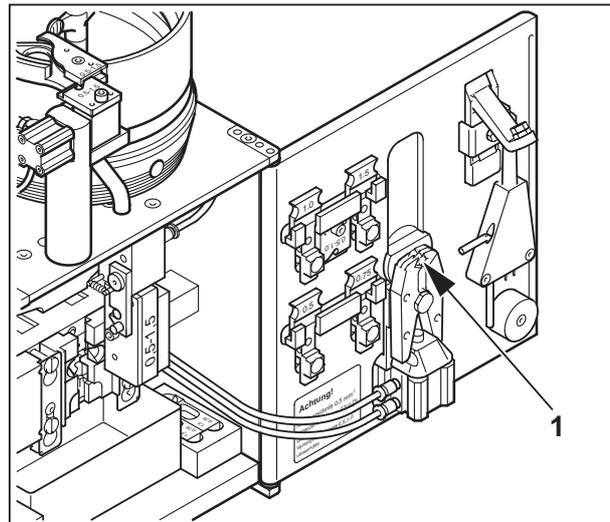


Figure 37 Clean the holding jaws

Fault scenario 5

The wire insulation is not completely removed.

- ⚠ **The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air.**

1. Check the cross section

If the wire is incorrectly stripped, first check whether the MC 40 is fitted with the correct retooling kit for the wire being used (see Figure 23).

In the event of incorrect assembly, adapt the retooling kit to the selected wire cross section (see the Chapter **RETOOLING**).

Also inspect the wire cross section.

If the fault occurs again with the correct retooling kit, the stripping blades must be checked (Step 2).

2. Check the stripping blades

**⚠ The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air.**

- Switch off the MC 40 with the mains switch (press 0, the mains lamp is off).
- Disconnect the compressed air port.
- Open the front door.
- Pull the unlocking lever (1) forward.
- Pull off the sleeve turning block (2) downwards.

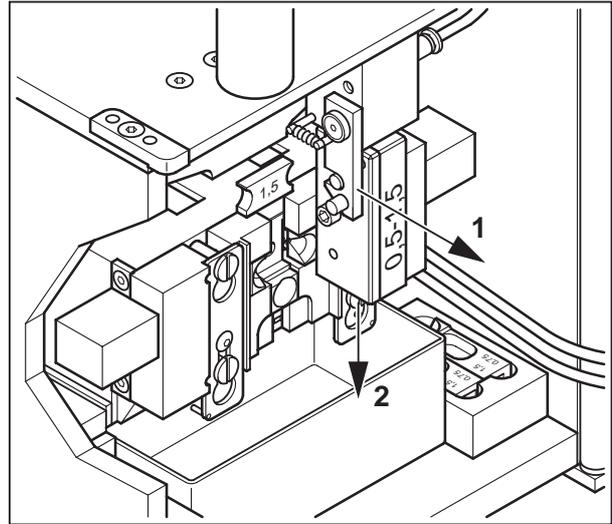


Figure 38 Remove the sleeve turning

- Pull off the sleeve holder (1) upwards and remove it from the holding fixture.

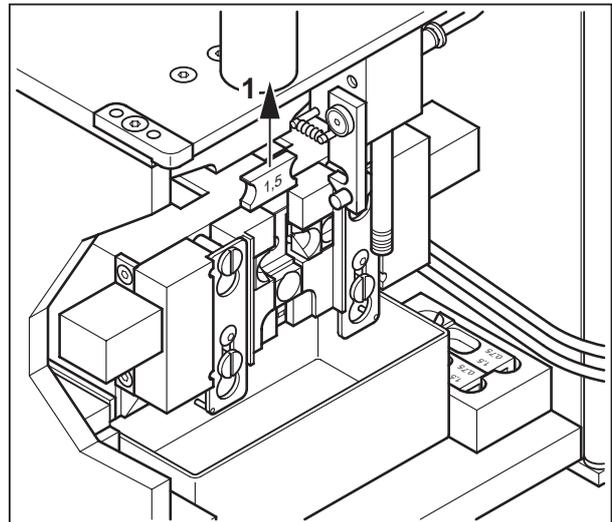


Figure 39 Remove the sleeve holder

- Push up the slider (1) and pull off the holding fixture (2) forwards.
- Remove the second holding fixture in the same way.

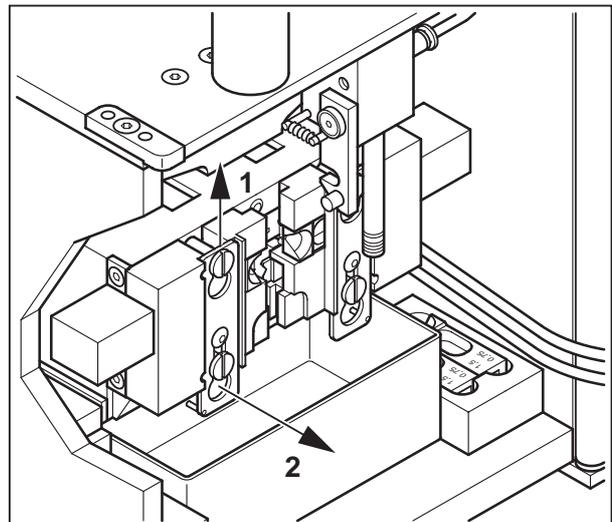


Figure 40 Remove the holding fixtures for the litz wire centring funnel

- Remove the left (1) and right (2) stripping blades.
- If the blades are worn or damaged, they must be replaced (Step 3).
The associated article number can be seen in the Chapter **SPARE PARTS**.
If the blades are in order, the fault can be remedied by correcting the cutting depth on the right blade (Step 3).

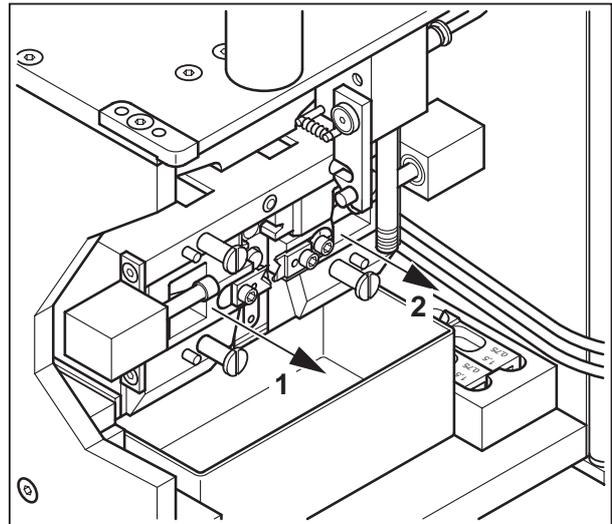


Figure 41 Remove the stripping blades

3. Change the stripping blades

! The left and right blades are identical.

Left blade

- Unscrew the hexagon socket screw (1) and remove the old blade (2).
- Place the new blade onto the journal (3) so that the inclined surfaces (4) face upwards.
- Tighten the hexagon socket screw (1).

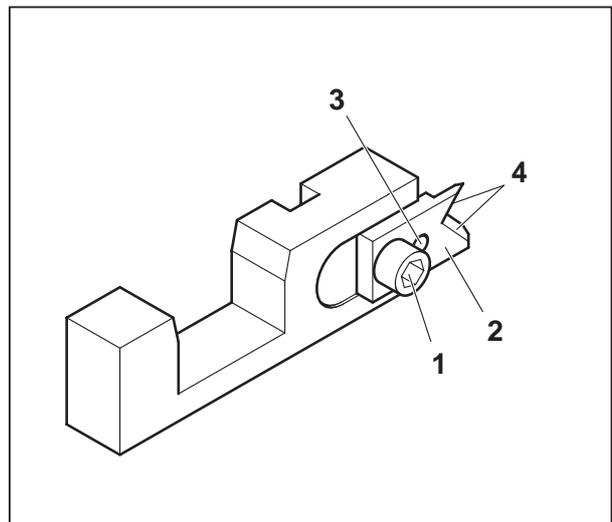


Figure 42 Change the left stripping blade

Right blade

- Unscrew the hexagon socket screw (1) and remove the old blade (2).
- Position the new blade so that the smooth surface (3) faces upwards.
- Slightly tighten the hexagon socket screw (1).
- Undo the hexagon socket screw (4).
- Adjust the eccentric via the slot (5) to the correct cutting depth (0 = basic setting).
- Press the blade against the eccentric and tighten both hexagon socket screws (1) and (4).

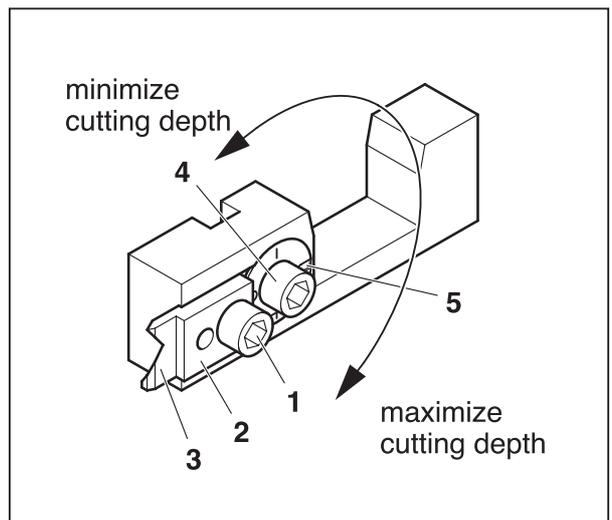


Figure 43 Change the right stripping blade

Fault scenario 6

The wire end sleeve is not correctly pressed.

1. Check the cross section

If the wire end sleeve is incorrectly pressed, first check whether the MC 40 is fitted with the correct retooling kit for the wire being used (see Figure 23).

In the event of incorrect assembly, adapt the retooling kit to the selected wire cross section (see the Chapter **RETOOLING**).

Also inspect the wire cross section.

If the fault occurs again with the correct retooling kit, the pressing jaws must be checked (Step 2).

2. Check the pressing jaws

 **The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air.**

- Switch off the MC 40 with the mains switch (press 0, the mains lamp is off).
- Disconnect the compressed air port.
- Open the front door.
- Pull the unlocking lever (1) forward.
- Pull off the sleeve turning block (2) downwards.

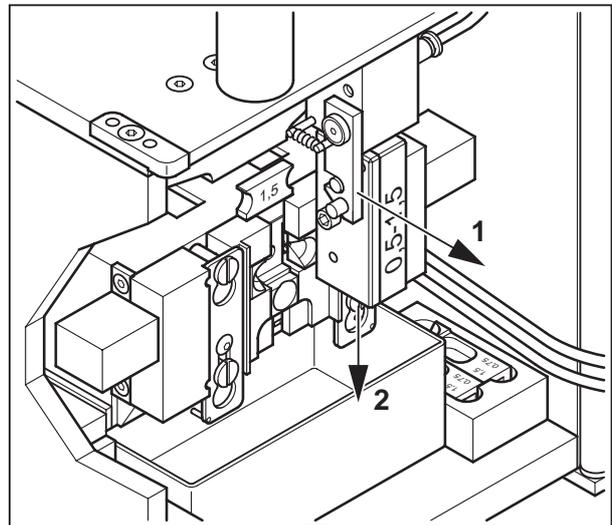


Figure 44 Remove the sleeve turning

- Pull off the sleeve holder (1) upwards and remove it from the holding fixture.

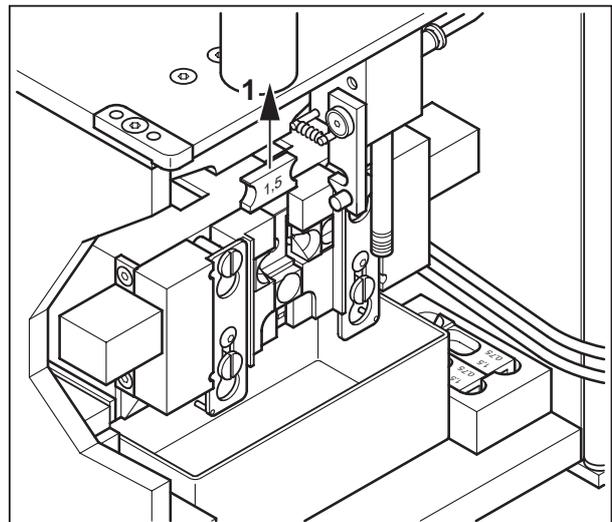


Figure 45 Remove the sleeve holder

- Push up the slider (1) and pull off the holding fixture (2) forwards.
- Remove the second holding fixture in the same way.

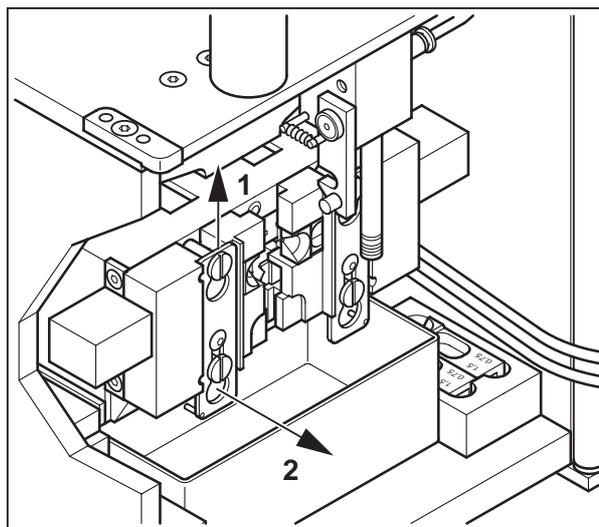


Figure 46 Remove the holders for the litz wire centring funnel

- Remove the left (1) and right (2) stripping blades.
- Push up the holding fixture (3).
- Remove the left (4) and right (5) pressing jaws.
- Check whether foreign bodies are stuck in the pressing jaws.
If the pressing jaws are worn, they must be replaced.
The associated article number can be seen in the Chapter **SPARE PARTS**.

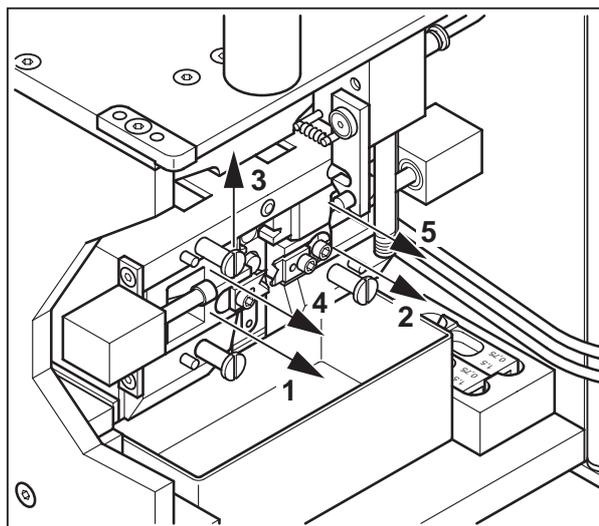


Figure 47 Remove the pressing jaws

Fault scenario 7

Problem with delivery of the wire end sleeves.

1. Check the delivery drum

- Check whether the wing screw (1) is loose and tighten it if necessary.
- Scrape back the wire end sleeves in the feed screw (2) and, if necessary, increase the feed speed with the delivery drum controller (3).

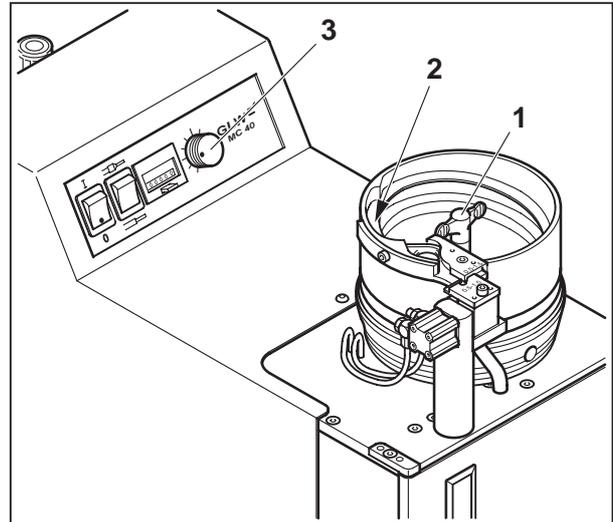


Figure 48 Check the delivery drum

2. Check the chicane

- Switch off the MC 40 with the mains switch (1) (0 pressed, mains lamp is off)
- Unscrew the chicane (2) with the hexagon socket spanner.
- Check the sleeve infeed and, if necessary, remove defective wire end sleeves.

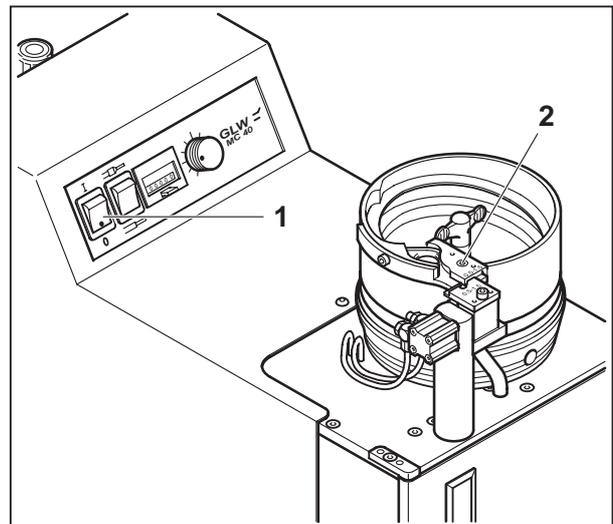


Figure 49 Check the chicane

3. Check the sleeve infeed

**⚠ The front door must be opened.
Pull out the mains plug!
Disconnect the compressed air.**

- Disconnect the compressed air port.
- Open the front door.
- Unscrew the separator plate (1) with the hexagon socket spanner.
- Remove the sleeve turning block (2).
- Push the wire through the infeed (3) and, if necessary, remove the stuck wire end sleeve.

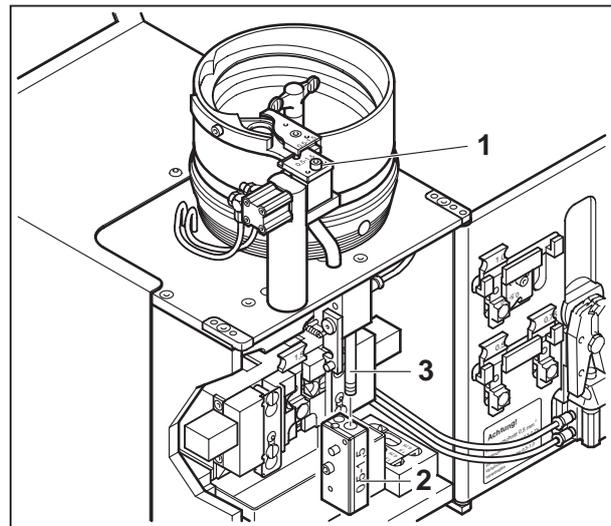


Figure 50 Check the sleeve infeed

4. Check the sleeve turning block

- Unscrew the hexagon socket screw (1) on the sleeve block with the hexagon socket spanner and open the sleeve block.
- If necessary, remove the stuck wire end sleeve.

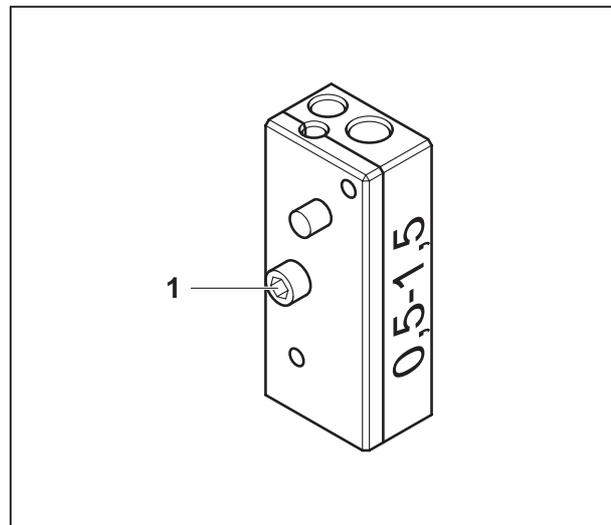


Figure 51 Open the sleeve turning block

- Clean the infeed channels (1) and the compressed air duct (2).

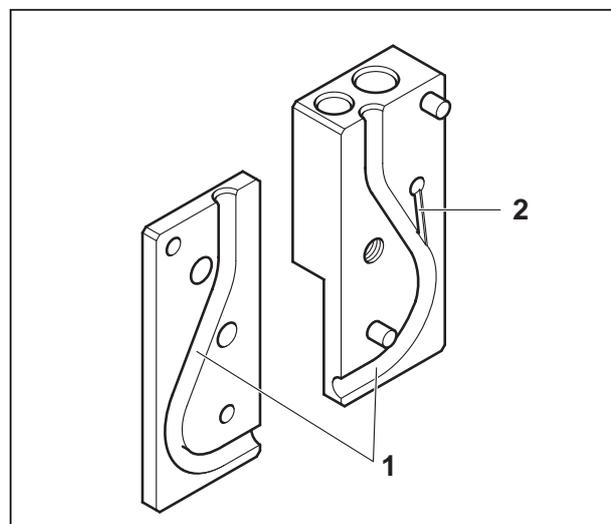
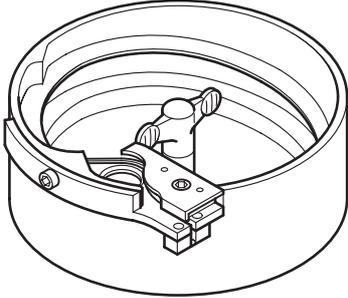
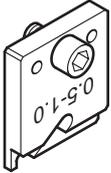
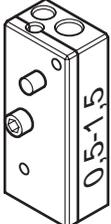
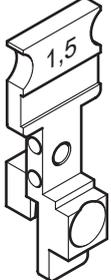
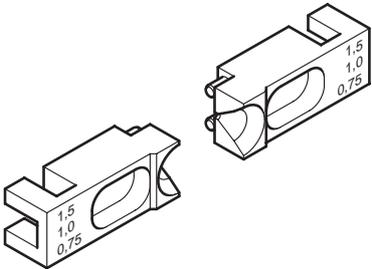
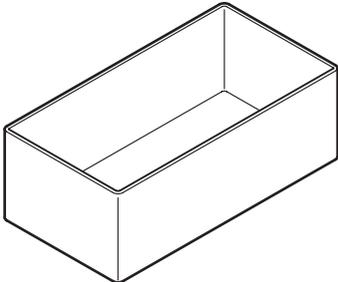
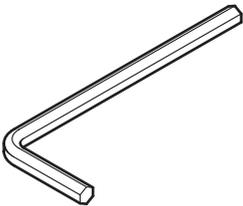
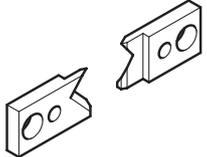
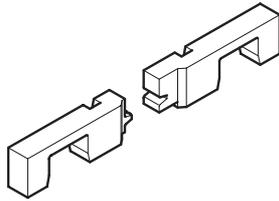
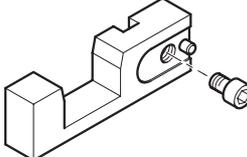
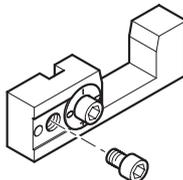
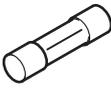
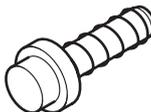


Figure 52 Check the sleeve turning block

The following spare parts can be reordered, quoting the relevant article number.

Part	Cross section	Article No.	Quantity supplied
Bowl-type vibratory feeder (Delivery drum) 	0,5 – 1,5 mm ²	MC4-SORT1.5	1 ea.
	2,5 mm ²	MC4-SORT2.5	1 ea.
	4,0 mm ²	MC4-SORT4.0	1 ea.
	0,25/0,34 mm ²	MC4-SORT0.34	1 ea.
Limiting plate (Separator plate) 	0,5 – 1,5 mm ²	MC4-VEP1.5	1 ea.
	0,5 – 1,0 mm ²	MC4-VEP1.0	1 ea.
	2,5 mm ²	MC4-VEP2.5	1 ea.
	0,25/0,34 mm ²	MC4-VEP0.34	1 ea.
	4,0 mm ²	MC4-VEP4.0	1 ea.
Vertical positional block (Sleeve turning block) 	0,5 – 1,5 mm ²	MC4-HWB1.5	1 ea.
	2,5/4,0 mm ²	MC4-HWB4.0	1 ea.
	0,25/0,34 mm ²	MC4-HWB0.34	1 ea.
Locator (Sleeve holder) 	0,5 mm ²	MC4-HA0.5	1 ea.
	0,75 mm ²	MC4-HA0.75	1 ea.
	1,0 mm ²	MC4-HA1.0	1 ea.
	1,5 mm ²	MC4-HA1.5	1 ea.
	2,5 mm ²	MC4-HA2.5	1 ea.
	0,25/0,34 mm ²	MC4-HA0.34	1 ea.
	4,0 mm ²	MC4-HA4.0	1 ea.

Part	Cross section	Article No.	Quantity supplied
Centring funnel 	0,75/1/1,5 mm ²	MC4-LZT1.5	1 pair
	0,5/0,75 mm ²	MC4-LZT0.75	1 pair
	2,5 mm ²	MC4-LZT2.5	1 pair
	0,25/0,34 mm ²	MC4-LZT0.34	1 pair
	4,0 mm ²	MC4-LZT4.0	1 pair
Waste box 	-	MC4-AF	1 ea.
Hexagon socket spanner 4 – 5/32" 	-	MC4-IS4	1 ea.

Part	Length	Article No.	Quantity supplied
Wire stripping blades 	-	MC4-AMV	1 pair
Die set (Pressing jaws) 	6 mm 8 mm 10 mm	MC4-P0625 MC4-P0825 (Standard) MC4-P1025	1 pair
Blade holder, left 	-	MC4-MH LI	1 ea.
Blade holder, right 	-	MC4-MH RE	1 ea.
Mains fuse M 400/250 C 	-	MC4-SICH	1 ea.
Insert stop (Start bolt) 	6 mm 8 mm 10 mm	MC4-SB06 MC4-SB08 MC4-SB10	1 ea. 1 ea. 1 ea.
Limit Stop 	6 mm 8 mm 10 mm 12 mm	MC4-HAN06 MC4-HAN08 MC4-HAN10 MC4-HAN12	1 ea. 1 ea. 1 ea. 1 ea.

Mains connection	230 V / 50 Hz
Power rating	0.5 A
Compressed air port	min 4 bar max 6 bar
Compressed air consumption	1.2 l / stroke
Cycle time	1.5 s
Operating range	0.5 – 2.5 mm
Wire end sleeves	loose in acc. with DIN 46228, Part 4
Pressing unit	trapezoidal
Conductors	Classes 2, 5 and 6 as per DIN VDE 0295
Controller	electrical / pneumatic with microprocessor
Counter	mech. display, 5-digit, resettable
Dimensions (W x H x D)	240 x 390 x 490 mm
Weight	approx. 29 kg

Rating plate

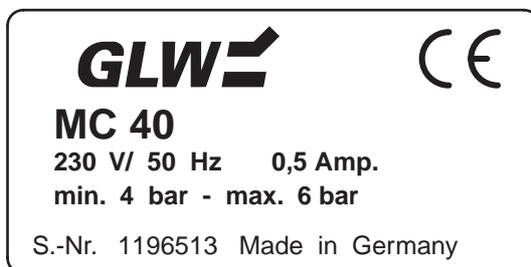
Manufacturer

Machine type

Mains connection

Compressed air port

Series number



EU symbol

Power rating

Country of production

Manufacturer: GLW GmbH
Address: Steinbeisstraße 2
D-88353 Kisslegg

We herewith declare that the machine named in the following complies in its design and type and in the equipment marketed by us with the relevant basic safety and health requirements of the EC machine directive. This declaration becomes void if changes are made to the machine without our permission.

Name of the machine: Wire stripping and crimping machine

Machine type: MC 40



Relevant EC directives: EC-Machine Directive (89/392/EEC) in the version 91/368/EEC
EC-Low Voltage Directive (73/23/EEC)
EC-Electromagnetic Compatibility Directive (89/336/EEC) in the version 93/31/EEC

Applied harmonized standards: DIN EN 292 Part 1
DIN EN 292 Part 2
DIN EN 294
DIN EN 349
DIN EN 60204 Part 1
DIN EN 50081 Part 2
DIN EN 50082 Part 2

Place, date Kisslegg, 30. Januar 2007

Legally binding signature:



Information about the signing person: Bruno Weiland

GLW GmbH
Steinbeisstraße 2
D-88353 Kisslegg
Tel. (07563) 9123-0
Fax (07563) 9123-99

Copyright on these operating instructions is held
by the company GLW.

Reprinting, copying or translation of this
document, either in whole or in part, are not
permissible without or express permission.

© 1997 GLW GmbH
