



Operating Manual

Please Read Before Operating Unit



D1 Twin Wheel Stripper



**DV1 Twin Wheel Stripper
with Integral Dust Collector**



D9 Twin Wheel Offset Stripper

Models D1, DV1, D9 Magnet Wire Strippers & Braid Combers

Please Call for Service or Spare Parts

The Eraser Company, Inc.
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Magnet Wire Wheel Strippers

ORDERING INFORMATION

Machines

AR0401 (D1).....Twin Wheel Stripper, 115V 60Hz
AR0501 (DV1) Twin Wheel Stripper
with dust collection, 115V 60Hz
AR0701 (D9)..... Twin wheel offset head stripper,
115V 60Hz

Replacement Parts

AR2701.....Wheel dresser handle and refill
AR2702.....Wheel dresser refills (packet of ten)
PR1070.....Replacement drive belt, 115V units
PR0511.....Replacement wire cutter
PR0629.....Replacement wire cutter blades
TG0238.....Replacement RH upper spindle nut
TG0248.....Replacement LH lower spindle nut
PR0074.....Replacement dust bag for
dust collection units

SAFETY INSTRUCTIONS

IMPORTANT! DO NOT OPERATE MACHINE UNTIL YOU HAVE READ THOROUGHLY, AND UNDERSTAND COMPLETELY, ALL PRECAUTIONS, INSTRUCTIONS AND INFORMATION ON THESE PAGES. THIS MANUAL CONTAINS IMPORTANT SAFETY AND OPERATING INSTRUCTIONS. IT SHOULD BE RETAINED WITH THE MACHINE FOR FUTURE REFERENCE.

SAFETY PRECAUTIONS - MECHANICAL

! DO NOT OPERATE UNIT WITHOUT GUARDS IN PLACE OR WITH DAMAGED GUARDS.

! DO NOT DEFEAT ANY OF THE SAFETY FEATURES.

! DO NOT PLACE FINGERS OR APPENDAGES NEAR MOVING PARTS OR IN OR NEAR OPENINGS IN GUARDS.

SAFETY PRECAUTIONS - ELECTRICAL

! ALWAYS UNPLUG UNIT FROM POWER SUPPLY

SPECIFICATIONS

D1Twin wheel stripper with length stop
DV1.....Twin wheel stripper with length stop
and integral dust collection
D9Twin wheel offset for unlimited strip length

Wire Sizes:

Maximum4 AWG (5.2mmø)
or square wire up to 1/4" x 1/4" (6.35mm x 6.35mm),
for rectangular wire, the maximum wheel opening
is 1/4" (6.35mm) and the maximum
material width is 1" (25.4mm).
Minimum35 AWG (0.14mmø)

Strip Length:

D1, DV1, with mini stop3/8" - 1-3/4"
(9.5-44.4mm)
D1, DV1, with regular stop.....5/8" - 2-1/2"
(15.9 - 63.5mm)
D9 Unlimited

Size:

D1 11" x 14" x 7"
(279mm x 355mm x 178mm)
DV1.....9-1/4" x 16-1/2" x 11"
(235mm x 419mm x 279mm)
D9 14-1/4" x 13-1/2" x 7-1/8"
(362mm x 342mm x 181mm)

Weight:

D126-1/2 lbs. (12 Kg)
DV1.....30 lbs. (13.6 Kg)
D923-1/4 lbs. (10.5 Kg)

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PRIOR TO ANY MAINTENANCE.

! DO NOT RUN UNIT WITH INCORRECT LINE VOLTAGE.

! NEVER RUN MACHINE WITH DAMAGED OR WORN POWER CORD.

! NEVER MODIFY THE PLUG PROVIDED. IF IT WILL NOT FIT INTO THE OUTLET, HAVE THE PROPER OUTLET INSTALLED BY A QUALIFIED ELECTRICIAN.

GROUNDING INSTRUCTIONS. Grounding provides a common return path for electric current to reduce the risk of electric shock. This machine is supplied with an electric cord with an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a licensed electrician if in doubt as to whether the machine is properly grounded.

SAFETY FIRST - USE BEST PRACTICES

ALWAYS USE SAFETY GLASSES. Everyday eyeglasses only have impact resistant lenses; they are NOT safety glasses. Also use face or dust mask if cutting operation is dusty.

REMOVE ADJUSTING KEYS AND WRENCHES. Form a habit of checking to see that keys and adjusting wrenches are removed from machine before turning it on.

KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents. Always leave at least 12" (305 mm) of space around all sides and top of unit.

DON'T USE IN DANGEROUS ENVIRONMENTS. Do not use or locate machine in high-humidity environments, or expose to rain. Keep work areas well lighted.

WEAR PROPER APPAREL. Do not wear

loose clothing, such as gloves, neckties, rings, bracelets, necklaces or any other clothing or jewelry that might get caught in moving parts. This is not an all-inclusive list. Wear protective hair covering to contain long hair. Non-slip footwear is recommended.

DON'T OVERREACH. Maintain proper footing and balance at all times.

MAINTAIN BLADES WITH CARE. Keep blades sharp and clean for optimal performance. Follow instructions for lubricating and changing blades and all accessories.

DISCONNECT MACHINE FROM POWER SUPPLY. Unplug the unit before servicing and when changing accessories.

DO NOT EXCEED THE UNIT'S MAXIMUM MATERIAL SPECIFICATIONS. Eraser's warranty will be null and void if machine has been used in any manner that is contrary to these instructions.

CHECK FOR DAMAGED PARTS. Before continued use of the machine, the guard and all moving parts should be carefully inspected to ensure that nothing is damaged.

Ensure proper alignment of moving parts. Check for any binding of moving parts, breakage of parts, and any other condition(s) that may affect operation. Any damaged part(s) should be properly repaired or replaced prior to any continued use of the machine.

ONLY ALLOW TRAINED AND QUALIFIED PERSONNEL TO OPERATE UNIT. Always keep these instructions within reach of the machine.

USE RECOMMENDED ACCESSORIES ONLY. Consult this operating manual for recommended accessories. Use only parts supplied by The Eraser Company, Inc. Use of improper accessories will void Eraser's warranty and may increase risk of injury.

ALL REPAIRS SHOULD BE PERFORMED BY AN ERASER COMPANY REPRESENTATIVE ONLY. Unauthorized disassembly of machines will void Eraser's warranty.

WHEN USING MACHINERY, ALL SAFETY

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PRECAUTIONS – INCLUDING, BUT NOT LIMITED TO, THOSE LISTED ABOVE - SHOULD BE FOLLOWED TO REDUCE THE RISKS OF FIRE, ELECTRIC SHOCK, AND PERSONAL INJURY, AND DEATH.

IMPORTANT: NO LIABILITY WILL BE INCURRED BY THE ERASER CO. FOR INJURY, DEATH, OR PROPERTY DAMAGE CAUSED BY A PRODUCT WHICH HAS BEEN SET UP, OPERATED, AND/OR INSTALLED CONTRARY TO ERASER'S WRITTEN OPERATING MANUAL, OR WHICH HAS BEEN SUBJECTED TO MISUSE, NEGLIGENCE, OR ACCIDENT, OR WHICH HAS BEEN REPAIRED OR ALTERED BY ANYONE OTHER THAN THE ERASER COMPANY, OR WHICH HAS BEEN USED IN A MANNER OR FOR A PURPOSE FOR WHICH THE PRODUCT WAS NOT DESIGNED.

OPERATING INSTRUCTIONS

SET-UP:

It is necessary to purchase and install wheels that match the application and wire size before operating. To comb coax braid, install two AC1223 wheels, one on each spindle. To strip larger wires, install two AC1230 wheels, one on each spindle (see "WHEEL SPECIFICATION" in this manual for proper wheel selection).

To install or change wheels, remove the side plate containing the strip length stop by loosening the 2 screws and sliding the plate away from the unit. Remove the nuts on the 2 spindles.

NOTE: The upper spindle nut is right hand thread and the lower spindle nut is left hand thread.

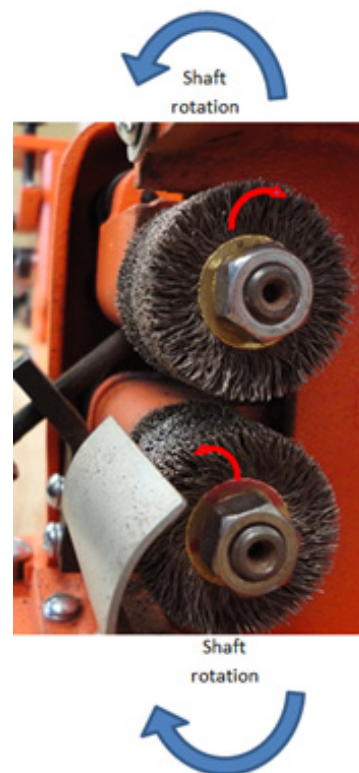
Install or change the wheels. Replace the nuts and tighten. Replace the side plate, taking care that the strip length stop plate is located properly behind the wheels.

NOTE: For best wire finish, install the wire wheels in the following manner.

The wire bristles on wire wheels lay in one direction. In the photo below, the wires lay in a slight clockwise orientation.



When looking at the machine shafts, the top shaft rotates counter clockwise and the bottom shaft rotates clockwise (see figure below). The wire lay should be in the **OPPOSITE** direction of the rotation of the shaft. The wire wheels will work in either direction, but installing the wire wheels in this manner will give the best results for stripping the wire.



All D1, DV1 and D9 units have 2 adjusting knobs.

The wheel spacing knob is located on the lower left front of the unit, and the pressure regulator knob is located on the left top of the unit. To properly adjust the unit for a particular wire or coax cable, first adjust the wheel spacing knob until the wire to be stripped or combed can be easily inserted between the wheels. Then release all tension by turning the pressure regulator knob counter-clockwise.

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All D1 and DV1 units are equipped with a regular strip length stop and a mini-stop. Both are installed in the machine upon receipt. For strip lengths from 3/8" (9.5mm) to 1-3/4" (44.4mm), use the mini-stop and the upper scale on the side plate. For strip lengths from 5/8" (15.9mm) to 2-1/2" (63.5mm), first remove the mini-stop. To do this, remove the depth stop side plate and use an allen wrench to remove the two socket head cap screws, removing the mini-stop. Replace the side plate onto the unit, and use the lower scale to measure strip length.

Plug the unit into a 115V, 60Hz power supply.

OPERATION:

Turn the unit on. While maintaining a firm grip on the wire to be stripped or coax braid to be combed, insert the wire between the wheels up to the length stop. While holding the wire between the wheels, adjust the wheel spacing knob until a slight tug is felt on the wire. Then adjust the pressure regulator knob to apply tension to the top wheel to help strip the wire. Withdraw the wire smoothly. If the wire is not completely stripped, readjust the knobs as necessary until the desired results are achieved.

NOTE: Excessive pressure is not desirable, and will lead to reduced wheel and bearing life. The wheels work best when only the tips of the bristles are being used.

! CAUTION: If there is too much tension on the wire, or the wheels are too close together, the machine may "grab" or pull the wire out of the operator's hand. When properly adjusted, the operator should feel only a slight tug on the wire when stripping.

! WARNING: NEVER RUN THE UNIT WITH THE WHEELS TOUCHING EACH OTHER. THIS WILL PUT STRAIN ON THE UNIT WHICH WILL RESULT IN DAMAGE TO THE SPINDLE BEARINGS AND MOTOR.

The operator will need to slightly twist or turn the wire during stripping in order to strip all the way around. This is especially true when stripping large wires or multiple wires. When stripping rectangular wires, the tension and space adjustments may be different for the 2 stripping stages (top and bottom of wire, and 2 sides of wire). When combing coax

braid with nylon wheels, start at the end of the coax and work inward towards the outer jacket. This will help prevent tangling of coaxial braid strands during combing.

MAINTENANCE:

On the D1, insulation dust will gather in the trash box and should be cleaned out periodically. On the DV1, with its integral dust removal base, the insulation dust will be collected in the dust bag at the back of the unit. This bag should be emptied regularly.

When using FybRglass® wheels, it is necessary to dress them periodically for maximum stripping efficiency and wheel life. Wheels should be dressed whenever they become grooved or laden with insulation.

To dress the wheels, use the special wheel dresser supplied with the unit. Open the wheels enough to allow the dresser to be inserted between them, and close the wheels onto the dresser with a light force. Move the dresser back and forth along the face of the wheels until they are smooth and clean. Whenever a pair of FybRglass® wheels is installed on the unit, they should be lightly dressed before using to ensure they are smooth and even. FybRglass® wheels can be continuously dressed and used to the point where the spindle housings touch. Additional wheel dresser refills may be purchased in a package of 10 (see "Replacement Parts").

It is not possible to dress nylon or wire wheels. If nylon wheels begin to wear unevenly, rearrange the sections on the spindles to achieve better results. Wire wheels, once grooved, must be replaced. **DO NOT try to force wheels to run while touching in order to close grooved areas. Doing so will lead to bearing and motor damage.**

Check all belts for wear regularly, and replace if necessary.

The spindle bearings are permanently lubricated and do not require oiling. No other regular maintenance is required.

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TROUBLESHOOTING:

PROBLEM:

Wheels stall when wire is inserted.

SOLUTIONS:

- 1) Check that wheels are not too close together.
- 2) Check that tension adjustment is not too tight.
- 3) Check that flat drive belt is not worn and slipping.

PROBLEM:

Wire will not strip.

SOLUTIONS:

- 1) Check for proper wheel type and grade and change if necessary.
- 2) Check that wheels are not grooved or worn. Dress if necessary (FybRglass® wheels only) or replace.
- 3) Increase tension slightly using the pressure regulator knob.
- 4) Bring wheels closer together using the wheel spacing knob.

PROBLEM:

Machine is very noisy or vibrates excessively.

SOLUTIONS:

- 1) Check that wheels are not touching each other while unit is running.
- 2) Check that dust take-off is not clogged (on DV1).
- 3) Be certain pulleys are tightened securely.

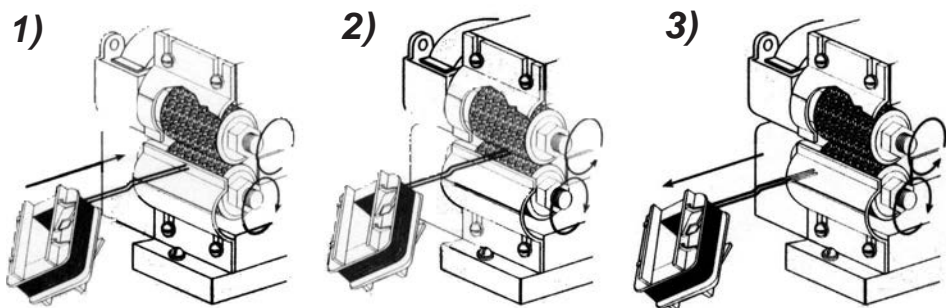
PROBLEM:

Wire breaks during stripping.

SOLUTIONS:

- 1) Check that grade and type of wheel being used is appropriate for wire size.
- 2) Decrease tension slightly with the pressure regulator knob.
- 3) Check that wheels are not grooved or worn. Dress if necessary (FybRglass® wheels only) or replace.

WIRE STRIPPING OPERATION

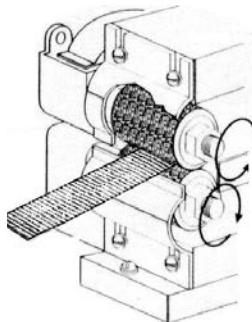


Insert wires to be stripped between wheels

Withdraw - wires are stripped

WHEEL DRESSING OPERATION

Dressing FybRglass®
Wheels Increases
Their Useful Life



Models D1, DV1 & D9 Wire Strippers & Coax Braid Combers

GENERAL WHEEL GUIDE



General guide for the selection of FybRglass® wheel grade to strip leads of sizes stated.

GRADE (FybRglass® Wheels)

201.....	Coarse, 24-30 AWG
553.....	General Purpose, 30-42 AWG
640.....	Fine, 35-45 AWG

WIRE BRUSH FILL SIZE

When selecting wire brush stripping wheels for wire stripping applications, grades of brush depends on wire size that is used for the material fill of the brush

0.005" (0.13mmø).....	Strips fine wires & braid combing
0.008" (0.2mmø).....	General Purpose

All of our FybRglass® and Wire Brush Stripping Wheels are manufactured to ensure the highest standards of quality and delivery. We make stripping wheels to fit competitive machines as well as for all Eraser models. There are many factors that determine the proper grade of FybRglass® wheel for a specific wire stripping application and these include: wire size, type of insulation, strip length, number of wires stripped at one time, etc. For this reason we suggest you send a sample of your wire so we may test it in our laboratory to provide you with the most efficient and economical grade of wheel. When sending it your wire, please include the strip length and number of wires to be stripped at one time.

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WHEEL SPECIFICATIONS

FybRglass® Stripping Wheels:

Part #	Material Grade	Size (Inches)			Size (mm)			Sold As
		OD	W	AH	OD	W	AH	
AE0254	201	1 1/4	1	.335	32	25	8.51	Pair
AE0255	553	1 1/4	1	.335	32	25	8.51	Pair
AE0256	640	1 1/4	1	.335	32	25	8.51	Pair
AE0274	553	Contact Eraser for wobble wheel dimensions		.335	Contact Eraser for wobble wheel dimensions		8.51	Pair

Wire Brush Stripping Wheels:

Part #	Size (Inches)				Size (mm)				Sold As
	OD	W	AH	WS	OD	W	AH	WS	
AC1223	1 1/4	1	.335	.005	32	25	8.51	.12	Each*
AC1230	1 1/4	1	.335	.008	32	25	8.51	.20	Each*

Fine Wire Brush/Combing Wheel:

Part #	Size (Inches)				Size (mm)				Sold As
	OD	W	AH	WS	OD	W	AH	WS	
AC1223	1 1/4	1	.335	.005	32	25	8.51	.12	Each*

* = Requires 2 Wheels

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