



Machine Model	CD-21 2M Linear Roll Up for CR-22C, D	Owners Manual
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SAFETY WARNING

Do not reach up underneath the guard while the belt is running.

GENERAL DESCRIPTION

The CD-21 Linear Roll Up Collector has been designed as an optional collection system to collect wires processed by the Artos **CR-22C and CR-22D**. This linear design system uses a conveyor belt to transfer the processed wire from the CR-22 into a collection tray allowing the operator to collect wires up to 2000mm (79inches) in length.

LIMITS OF USE

The CD-21 machine is intended for use in a dry indoor working environment. The machine cannot be exposed to liquid spray or mist, damages will result. Circuits should never be removed or tampered with or injuries may result. The electrical cabinets should only be opened by trained and authorized personnel. Use of the machine for purposes other than those stated in the general description may result in damage to the machine or personal injury.

SPECIFICATIONS

ELECTRICAL

Power Supply:

115±10% VAC 47-63 Hz. Single Phase 6 amps (Nominal)

Connection to Supply: Hooded connector into CR machine

Protection Against Electric Shock: Grounded metal enclosure

AIR SUPPLY

Average air requirement 2 cfm (56 L/m) 80 psi (5.5 bar)

DIMENSIONS

Tray Height from floor 37.3 inches (947mm)

Overall assembly

Height 44 inches (1118mm)

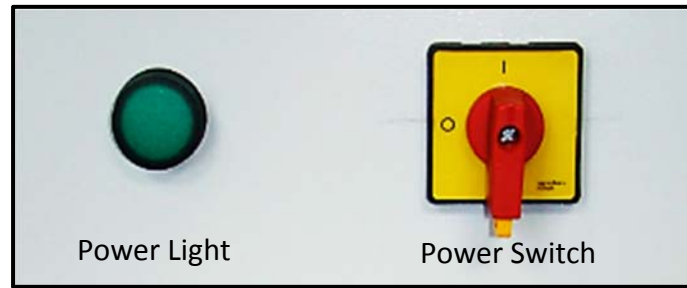
Length 93.3 inches (2370mm)

Depth 27.2 inches (691mm)

WEIGHT

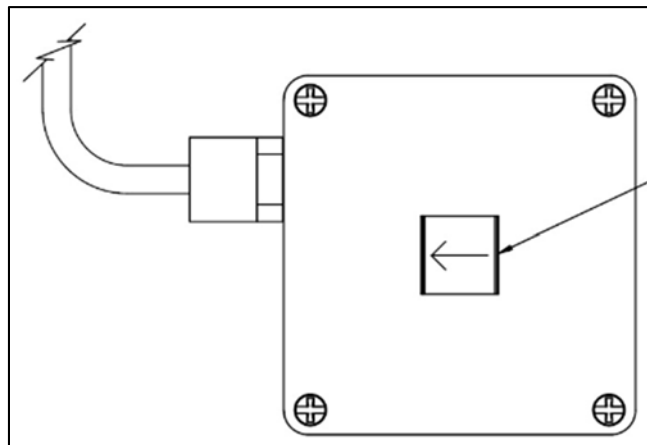
300lbs (136kg)

CD-21 CONTROLS



Power Light – Lights up when the CR-22C,D machine connected to the CD-21 is on. Also when the CD-20 is plugged in and the power is on.

Power Switch – ON/OFF switch. Turn CLOCKWISE to “I” symbol to turn ON and COUNTERCLOCKWISE to “O” symbol to turn off.



Batch Tray Button (Optional) – Automatically retracts batch tray.

CR-22C & CR-22D MACHINE CONFIGURATION

The CR-22C and CR-22D automatically assumes that a linear collector is plugged in.

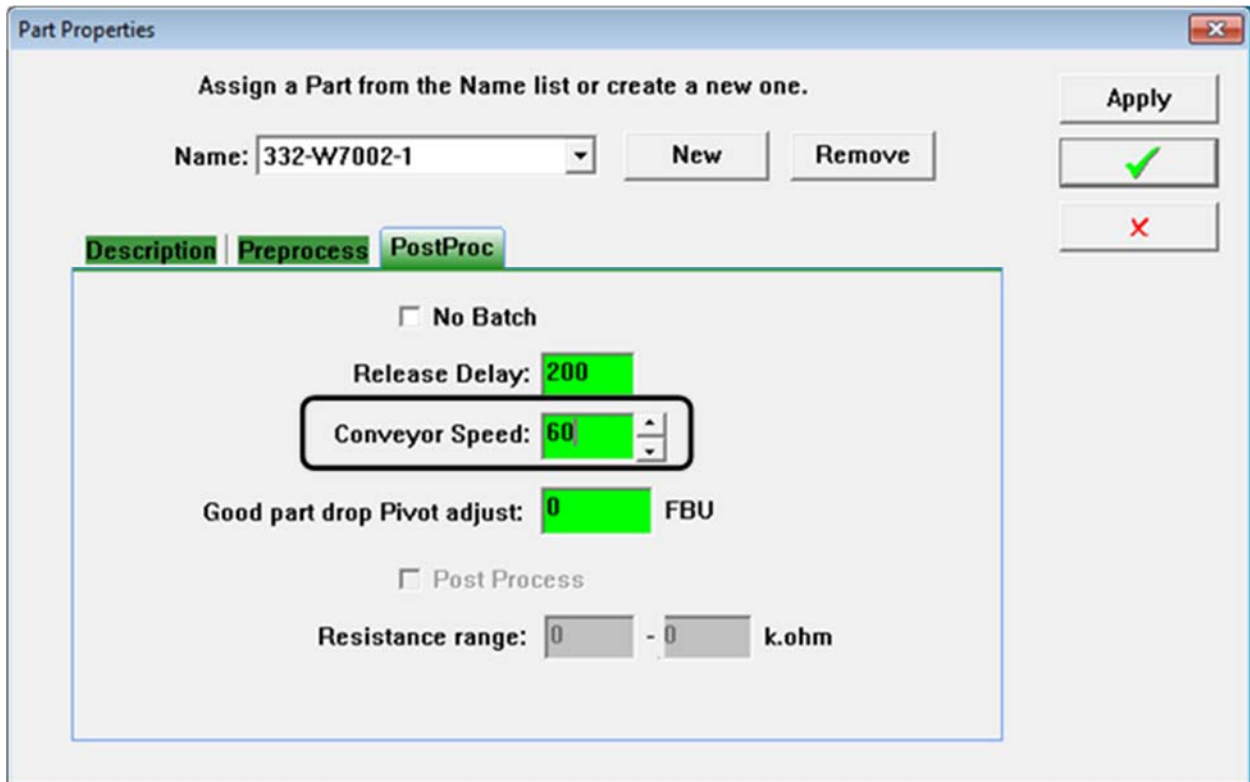
Displaying the Wire Feed Rate

This is shown in the wire properties screen.



Programing the Conveyor speed

The speed of the conveyor belt is determined by the Conveyor speed setting. When set for 100% the belt runs approximately 1.5m/S faster than the maximum feed rate of the wire feed drive. When processing long wires it is important to set the conveyor speed to be faster than the feed rate. Example, if you have a 10m/S feed drive and you have the feed rate programmed at 5m/S this 50% of maximum. In this case, set the Conveyor speed for 50%. When processing very short wires, having the belt running at a high speed does not provide any benefit. In this case you may only want the speed set for 10% so that the belt will carry away the scrap parts, but not use too much energy.



The screenshot shows a software window titled "Part Properties" with a close button (X) in the top right corner. Below the title bar, there is a text prompt: "Assign a Part from the Name list or create a new one." To the right of this prompt are three buttons: "Apply", a button with a green checkmark, and a button with a red X. Below the prompt is a "Name:" field containing "332-W7002-1" and a dropdown arrow. To the right of the name field are "New" and "Remove" buttons. Below the name field are three tabs: "Description", "Preprocess", and "PostProc", with "PostProc" being the active tab. The "PostProc" tab contains several settings: a checkbox for "No Batch" (unchecked), a "Release Delay:" field with a value of "200", a "Conveyor Speed:" field with a value of "60" and a spinner control, a "Good part drop Pivot adjust:" field with a value of "0" and the unit "FBU", a checkbox for "Post Process" (unchecked), and a "Resistance range:" field with values "0" and "0" and the unit "k.ohm".

MAINTENANCE

These items should be checked on a monthly basis.

- Check the control buttons and switches to ensure they are working properly.
- Belt Check (BELT # 147111):
 - Check the belt for any cracked ribs or tears on the surface of the belt.
- Checking Batch Tray function:
 - 1) Master start machine.
 - 2) Press Master Start Button to activate tray.
 - 3) Notice the tray speed: if tray speed is set too slow the wires won't drop off the tray, if too fast then the tray may be hitting other parts in the collector causing a loud banging noise.
 - 4) Adjust tray cylinder flow controls as needed.

