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|---------------|----------------|---------------|-----|------|-------------|
| Machine Model | PF-6 PREFEEDER | Owners Manual |     |      |             |
| PN            | 6-119863       | Rev.          | 1.3 | Date | 03 OCT 2014 |



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## SAFETY WARNINGS!!



- **Do not operate the PF-6 without electrical safety devices in place and functioning properly.**
- **Do not attempt to lift heavy reels of material on to the PF-6 to avoid personal injury.**
- **Avoid contact with material as it transfers to the cutting machine.**
- **The electrical enclosures must be kept closed and secured. Only authorized persons with appropriate training should access these enclosures. In the event that it is required to access electrical enclosures with main power on, only persons properly trained and familiar with acceptable Safety regulations may do so.**

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# PF-6 SPECIFICATIONS

## Spool Specifications for PF-6

### Standard PF-6

Maximum spool weight 150lbs (68kg)

Maximum spool diameter 24 in (609mm)

For a spool center I.D. of 0.89 (22mm) The maximum reel width is 12.25 (311mm)

For a spool center I.D. of 2.00 (51mm) The maximum reel width is 14.25 (362mm)

### PF-6 with large spool adaption kit.



### 24 inch (610mm) diameter large spool adaption kit.

#### Small cone

For a reel center I.D. of 0.89 (22mm) The maximum reel width is 14.7 (373mm)

For a reel center I.D. of 1.75 (45mm) The maximum reel width is 16.8 (427mm)

#### Large cone

For a reel center I.D. of 1.25 (32mm) The maximum reel width is 13.2 (335mm)

For a reel center I.D. of 3.19 (81mm) The maximum reel width is 16.8 (427mm)

### 32 inch (813mm) diameter large spool adaption kit.

#### Small cone

For a reel center I.D. of 0.89 (22mm) The maximum reel width is 14.7 (373mm)

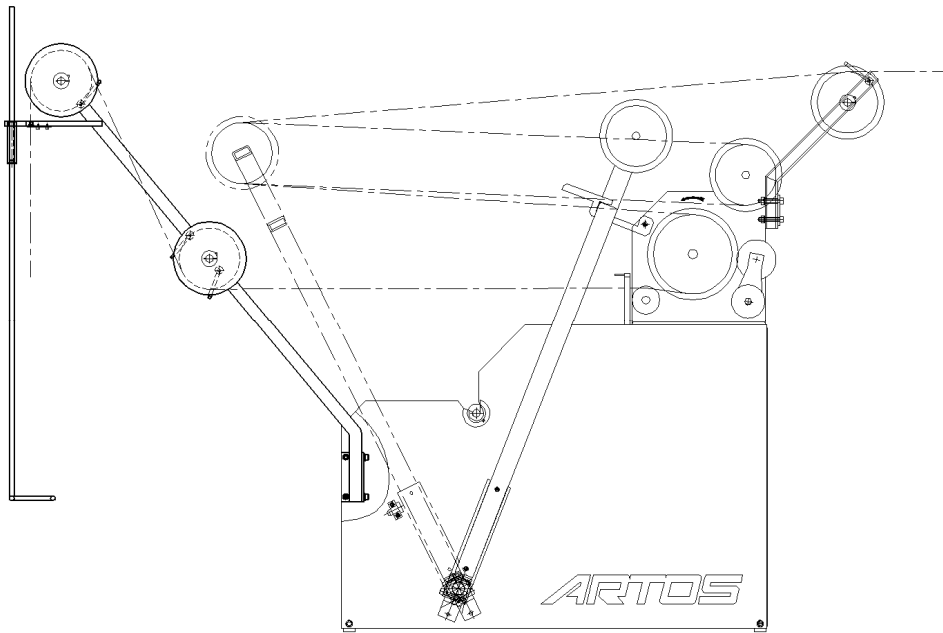
For a reel center I.D. of 1.75 (45mm) The maximum reel width is 16.8 (427mm)

#### Large cone

For a reel center I.D. of 1.25 (32mm) The maximum reel width is 13.2 (335mm)

For a reel center I.D. of 3.19 (81mm) The maximum reel width is 16.8 (427mm)

## PF-6 with wire coil / loose bundle kit.



Barrel stand or wire coil / loose bundle kit.

## Electrical Specifications

110±10% VAC 60 hz 6 Amps

220±10% VAC 50/60hz 3 Amps

## Wire Diameter

Standard plastic pulley option.

Wire diameter up to approximately 0.38 inches (9.6mm)

Large aluminum pulley option

Wire diameter up to approximately 0.50 inches (12.7mm)

## Payout Rate

Adjustable up to 4M/Sec (820Ft./Min)

## Mechanical

### Standard PF-6

Height 53" (1340mm)

Length 46" (1170mm)

Depth 21" (533mm)

**PF-6 with large spool adaption kit.**

Height 53" (1340mm)

Length 66" (1677mm)

Depth 21" (533mm)

**PF-6 with wire coil / loose bundle kit**

Height 53" (1340mm)

Length 72" (1829mm)

Depth 21" (533mm)

# STANDARD ASSEMBLY NUMBERS / OPTIONS

## MAIN ASSEMBLY

**2-134900-500** Main Base Assembly (**Standard**)– on the drawing it lists voltage options, e-stop option, and barrel adaptor kit. For the sizing below if you do not use a cone to center spool on the shaft, the maximum reel width is 15.5 (394mm). The size of the shaft is 0.625 (16mm) diameter.

## PULLEYS

**2-134900-510** Aluminum large wire 3 pulley option. Maximum wire diameter is 0.50 inches (12.7mm).

**2-134900-520** Plastic 3 pulley option (**Standard**). Maximum wire diameter is 0.38 inches (9.6mm).

**2-134900-530** Aluminum large wire 7 pulley option, for long wires. Maximum wire diameter is 0.50 inches (12.7mm). 7 pulleys gives you added wire accumulation. This is useful when you are processing wires greater than 10 feed (3meters) in length.

**2-134900-540** Plastic 9 pulley option, for long wires. Maximum wire diameter is 0.38 inches (9.6mm). 9 pulleys gives you added wire accumulation. This is useful when you are processing wires greater than 10 feed (3meters) in length.

## ROLLERS

**2-134900-550** Reel support rollers. This options will allow you set the spool into the pre-feeder, rather than putting a shaft through the core of the spool and hanging the spool in the pre-feeder. This option requires the spool flanges to be round and undamaged.

## POWER / CONTROL OPTIONS

**2-134900-560** 110 VAC power

**2-134900-570** 220 VAC power

**2-134900-610** 110 VAC power with over travel shut down and machine feedback. This option will automatically shut down the pre-feeder when the arm is pulled all the way forward. This can happen when the wire is tangled and cannot be pulled off the spool. A connector is provided that will provide a dry contact that opens when the pre-feeder is shut down. This connector can be wired to e-stop the wire cutting machine.

**2-134900-600** 220 VAC power with over travel shut down and machine feedback. This option will automatically shut down the pre-feeder when the arm is pulled all the way forward. This can happen when the wire is tangled and cannot be pulled off the spool. A connector is provided that will provide a dry contact that opens when the pre-feeder is shut down. This connector can be wired to e-stop the wire cutting machine.

## WIDE REEL ADAPTION KITS

**5-144396-x** Wide reel adaption kit. This option adds extension arms to the back of the pre-feeder so that it can accept wider reels.

5-144396-1 Base parts. Order one of these and select one of the items from the list below

For the sizing below if you do not use a cone to center spool on the shaft, the maximum reel width is 19.5 (495mm), The size of the shaft is 0.625 (16mm) diameter.

- 5-144396-2 Accepts 24 inch diameter reel. Small cone
- 5-144396-3 Accepts 24 inch diameter reel. Large cone
- 5-144396-4 Accepts 32 inch diameter reel. Small cone
- 5-144396-5 Accepts 32 inch diameter reel. Large cone

### **LOOSE WIRE COIL / BUNDLE KIT**

**5-143910** Barrel stand or loose bundle / wire coil kit.

### **SPARE PARTS KIT**

**2-136429-500** Spare parts kit, contains the following

- AH-2610-500 Pressure roller, this holds the wire against the drive wheel rubber ring.
- H-14097-3 Rubber ring for main wire drive wheel, this is what gives the drive wheel traction on the wire. 2pc
- 903-003 Switch that turns off the drive wheel when the accumulator is full
- 902-359 Center drive belt.
- 902-769 Upper drive belt.
- 905-285 Lower drive belt.

### **TENSION SPRINGS**

- H-15500 Spring 2.96 Lbs per inch, 0.518 N per mm
- 144592 Spring 4.44 Lbs per inch, 0.778 N per mm, Hook end is painted yellow. Comes standard when ordering pre-feeder with 3 pulley system
- 135012 Spring 8.90 Lbs per inch, 1.55 N per mm Comes standard when ordering pre-feeder with 7 pulley system
- 5-141881 3 spring conversion kit. Does not include springs



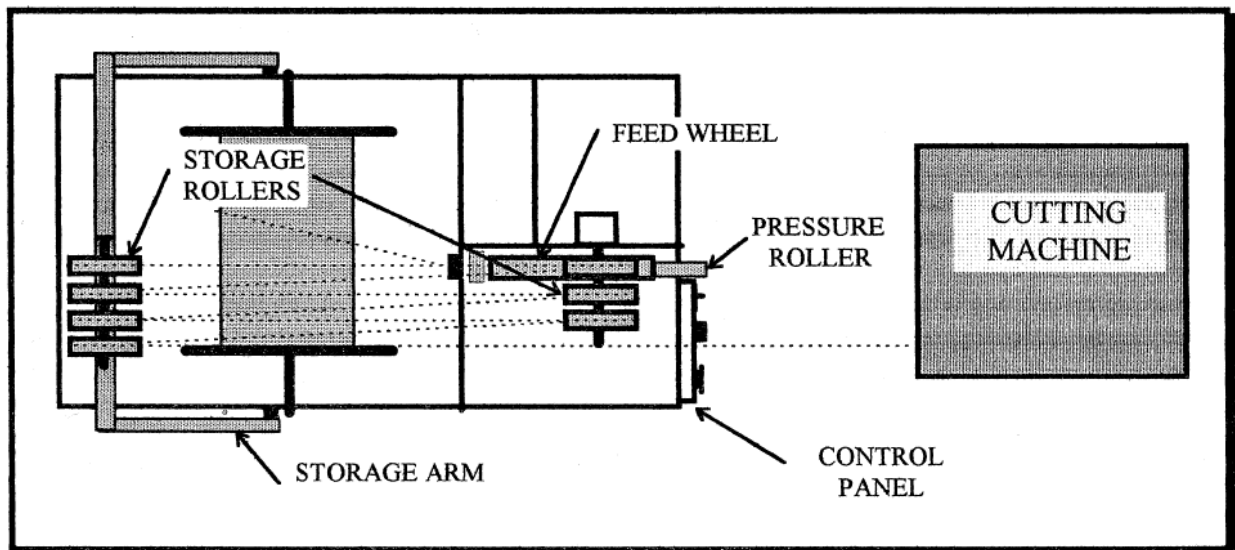
## INSTALLATION

Place the Artos PF-6 on a flat level surface adjacent to the infeed side of the cutting machine. It should sit so the top of the storage pulleys are the same height as the infeed point of the cutting machine. The nearest storage arm pulley should line up with the infeed point in front to back plane

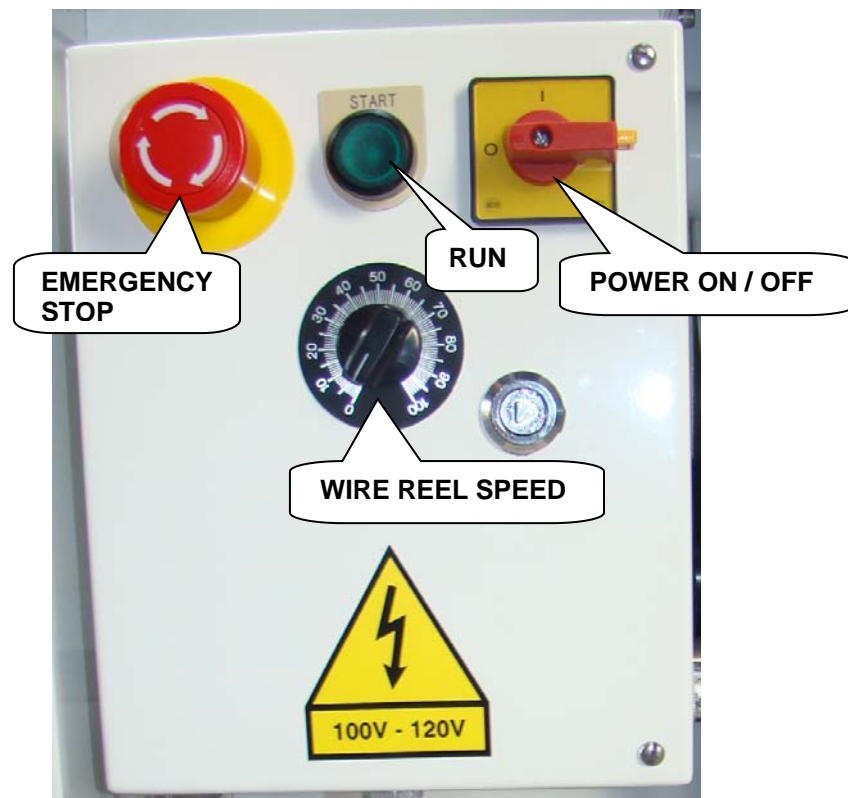
**WARNING:** Do not lift the pre-feeder storage arm unless motor power is on. Damage to the variable speed pulley can result if it is not energized while moving.

**WARNING:** Do not operate this machine on a wet floor or potentially wet area!

Attached the power cord to an appropriate size power source.



## OPERATIONAL PUSH BUTTON CONTROLS



**POWER ON/OFF:** Applies or disconnects power to the machine

**START:** Applies power to the motor speed control. (Button lights when “on”)

**EMERGENCY STOP:** Stops all power to the motor when depressed.

**SPEED:** Sets the base (maximum) speed the PF-6 can achieve at full arm travel.

## LOADING

To load the Artos PF-6 you should first move the storage arm to the full travel position and move the latch to the locked position. **This must be done with the motor on.** Once latched, stop the motor.



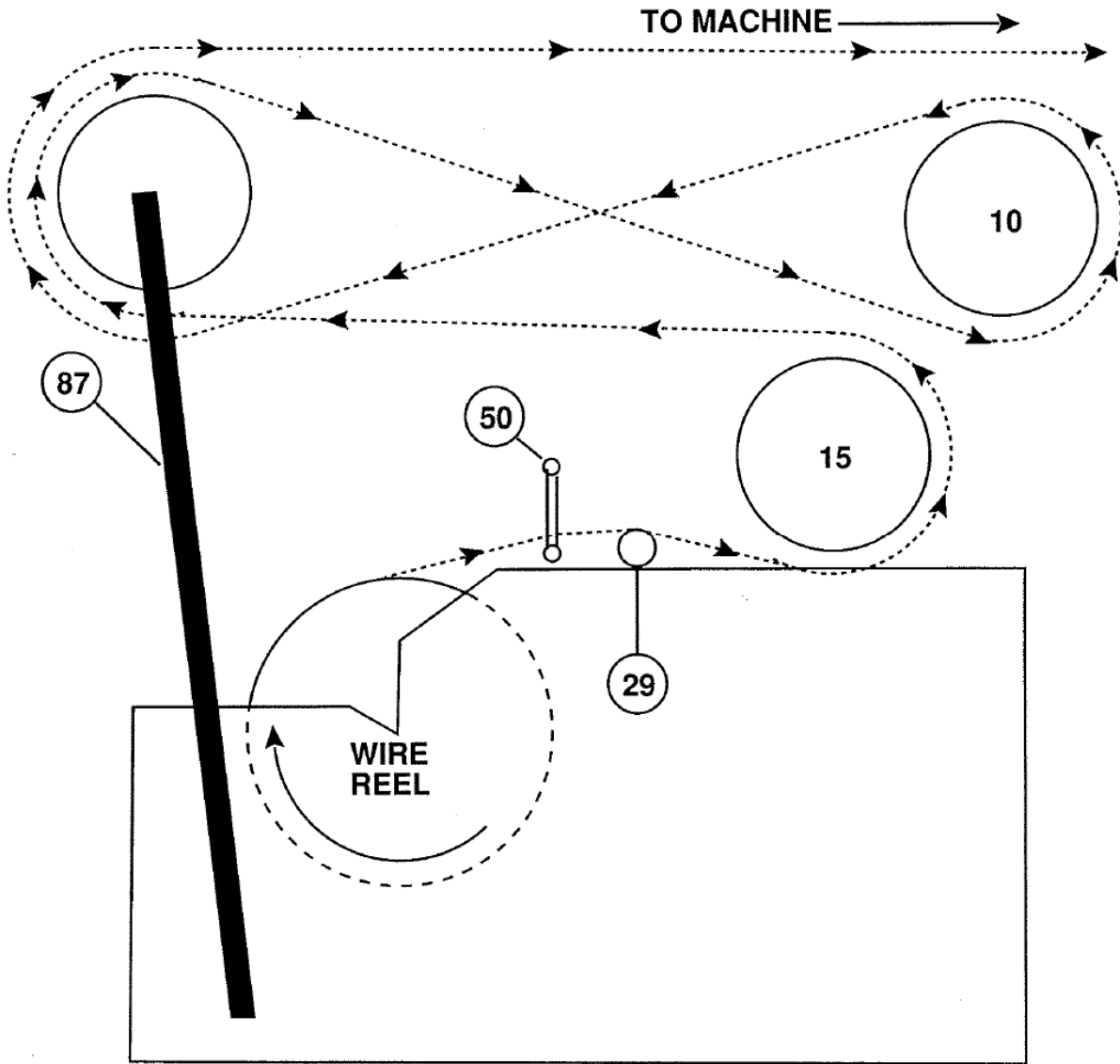
**CAUTION:** Never attempt to move the storage arm with the motor on. Damage to the variable speed pulley will occur. If the arm becomes jammed at the maximum travel and will not come back under power it will be necessary to disconnect the machine from power, remove the front guard and turn it over by hand until the mechanism is free.

Place the reel on the shaft provided and rest the shaft in the frame. Make certain the double rings on the shaft straddle one of the side plates. Restart the motor and while holding the arm release the latch to allow the arm to retract slowly.



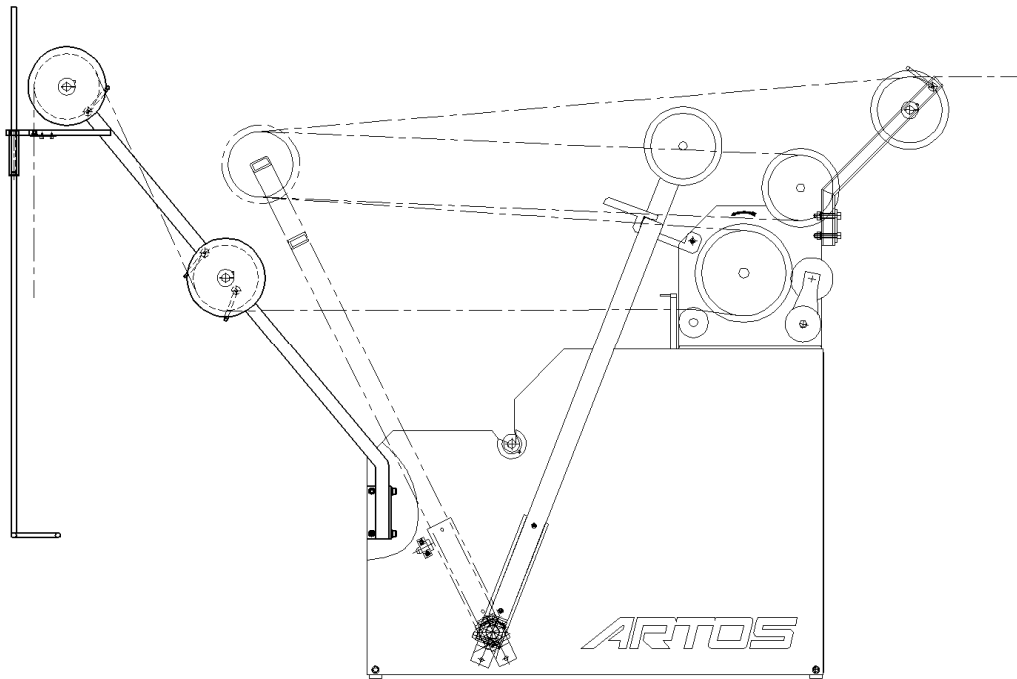
**CAUTION:** Do not substitute the supplied shaft with a longer shaft. Damage to the arm will occur.

A reel with a good circumference edge can be placed on the rollers if so equipped. The wire should come off the top of the reel and into the feed wheel.



Wire direction diagram for standard or wire reel PF-6

1. Feed the wire through (50) wire guide.
2. Thread wire over (29) idler pulley.
3. Thread wire under and over (15) feed pulley.
4. Thread wire under and over 1<sup>st</sup> pulley on (87) load arm control.
5. Thread wire under and over (10) stationary pulley
6. Return wire and thread under and over 2<sup>nd</sup> pulley on (87) load control arm.
7. Feed wire into machine.



Wire direction diagram for PF-6 with loose bundle kit

## ADJUSTMENT

The only adjustment for the operation of the Artos PF-6 is the speed setting. The speed should be set at a rate that allows the storage arm to oscillate about half way up in its travel range. For the best results the motor should not stop during normal cycling and the storage arm should not use its maximum travel.

## MAINTENANCE

**Daily:** Clean machine and check condition of the feed wheel band for wear.  
Check all control functions.

**Monthly:** Remove the front cover and check belts and lubricate variable speed pulley with multi-purpose grease.

**Annually:** Check motor brushes and replace as needed.