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ERASER

Always Moving Forward

Operating Manual

Please Read Before Operating Unit



D1 Twin WheelStripper



D9 Twin Wheel Offset Stripper

Models D1, DV1, D9 Wire Strippers & Braid Combers

Service and All Spare Parts Available

The Eraser Company, Inc.
PO Box 4961/ Oliva Drive
Syracuse, NY 13221, USA

Phone: (315) 454-3237
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E-mail: info@eraser.com

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Magnet Wire Wheel Strippers

Specifications

D1 .....Twin wheel stripper with length stop
DV1 .....Twin wheel stripper with length stop and integral dust collection
D9 .....Twin wheel offset for unlimited strip length

Wire sizes:

Maximum .....16 AWG (1.30mmø) 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)
Minimum.....35 AWG (0.14mmø)

Strip length:

D1, DV1, with mini stop.....3/8" - 1-3/4" (9.5-44mm)
D1, DV1, with regular stop.....5/8" - 2-1/2" (16 - 63mm)
D9.....Unlimited

Decibel rating.....72 dB(A) all units

Power.....1/4 HP, 115V, 60Hz or 220/240V, 50Hz

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 184mm)

Weight:

D1.....26-1/2 lbs. (12 Kg)
DV1.....30 lbs. (13.6 Kg)
D9.....23-1/4 lbs. (10.5 Kg)



DV1 Twin Wheel Stripper with Integral Dust Collector

Ordering Information

Machines

AR0401 (D1).....Twin wheel stripper, 115V 60Hz
AR0402 (D1).....Twin wheel stripper, 220/240V 50Hz
AR0501 (DV1).....Twin wheel stripper with dust collection, 115V 60Hz
AR0502 (DV1).....Twin wheel stripper with dust collection, 220/240V 50Hz
AR0701 (D9).....Twin wheel offset head stripper, 115V 60Hz
AR0702 (D9).....Twin wheel offset head stripper, 220/240V 50Hz

Replacement Parts

AR2701.....Wheel dresser handle and refill
AR2702.....Wheel dresser refills (packet of ten)
PR1070.....Replacement drive belt, 115V units
PR0067.....Replacement drive belt, 220/240V 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

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Models D1, DV1 & D9 Wire Strippers & Coax Braid Combers
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 10 sections of AC4003 nylon wheels, 5 on each spindle. To strip larger wires, install wire wheels, one on each spindle (see "Stripping Wheel Selection" 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 RH thread and the lower spindle nut is LH 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.

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.

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" (9mm) to 1-3/4" (44mm), use the mini-stop and the upper scale on the side plate. For strip lengths from 5/8"(15mm) to 2-1/2" (63mm), 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 the appropriate power supply, either 110V 60Hz or 220V 50Hz. NOTE: 220V 50Hz units are shipped without plugs. Wire on plug. Color Coding is: Brown = Live; Blue = Neutral; Green = Ground.

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.

***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 or motor.**

The operator may 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 new 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 or motor damage.**

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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.

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.

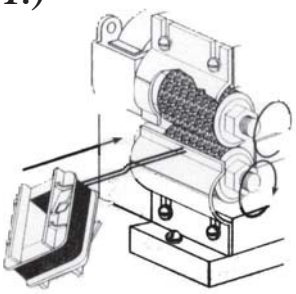
Solutions:
1. Check that grade and type of wheel being used is appropriate for wire size.
2. Decrease tension slightly with the pressure regulator knob.
3. Check that wheels are not grooved or worn. Dress if necessary (Fybrglass wheels only) or replace.

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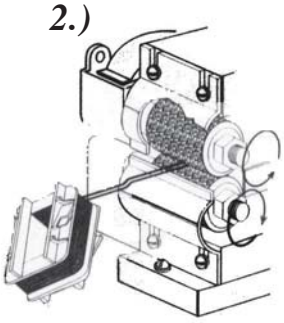
Wire Stripping Operation

1.)

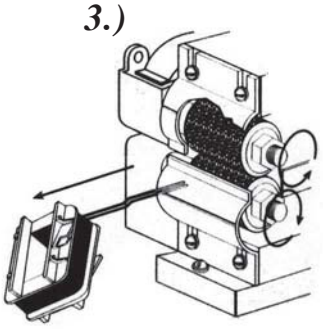


Insert wires to be stripped between wheels

2.)



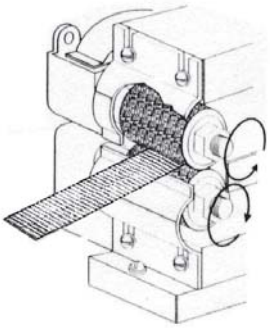
3.)



Withdraw - wires are stripped

Wheel Dressing Operation

Dressing Fybrglass Wheels
Increases Their Useful Life



Stripping Wheel Selection

Many factors affect wheel grade selection. The chart is for guidance only. The last digit of Grade Number before /5 indicates diameter (in thousands of an inch (0.025mm) of the steel wire from which the brush is made. For example, GR1003/5 is filled 0.003" (0.076mm) steel wire.

For firm recommendations on wheel selection, send us a sample of your coils or wires to be stripped.

All wheels 1-1/4" OD, 1" wide, 0.335" AH (32mmø x 25mm x 8.5mmø)

Fybrglass stripping wheels:

Order Number	Grade Number	Stripping Range
AE0353	(GR141C)	22 - 27 AWG (0.64 - 0.36mmø)
AE0254	(GR201C)	20 - 25 AWG (0.81 - 0.46mmø)
AE0255	(GR553C)	25 - 31 AWG (0.46 - 0.22mmø)
AE0256	(GR640C)	31 - 35 AWG (0.22 - 0.14mmø)

Wire brush stripping wheels:

Order Number	Grade Number	Stripping Range
AC1218	(GR1003/5)	Fine wires 18 - 24 AWG (1.02 - 0.51mmø)
AC1223	(GR1005/5)	Medium wires 16 - 22 AWG (1.30 - 0.64mmø)
AC1230	(GR1008/5)	For large wires, heavy insulations and rectangular section

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General Wheel Guide



All of our Fybrglass and Wire Brush Stripping Wheels are manufactured in house to ensure the highest standards of quality and delivery. We make stripping wheels to fit all competitive machines as well as for all Eraser Models. We can also manufacture custom sizes not shown on the charts of standard wheels on the opposite page. 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 [send us a 3 foot (1m) sample of wire with strip length and number of wires to be stripped at one time] .

General guide for the selection of fybrglass wheel grade to strip single leads of sizes stated.

Grade (fybrglass wheels)

141:.....Medium coarse, wire sizes 24 - 26 AWG (0.51 - 0.41mmø)
201:.....Coarse, wire sizes 26 - 30 AWG (0.41 - 0.25mmø)
553:.....General purpose, wire sizes 30 - 42 AWG (0.25 - .064mmø)
640:.....Fine, wire sizes 35 - 45 AWG (0.14 - .046mmø)
SPEC:.....Special application (e.g. multiple wires, etc.)

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.

.003" (.08mmø):.....For stripping fine wires
.004" (.10mmø):.....General purpose
.005" (.13mmø):.....General purpose
.006" (.15mmø):.....General purpose
.008" (.20mmø):.....For stripping large wires and rectangular sections
.0118" (.30mmø):.....For stripping heavy insulation on large wires and rectangular sections
.014" (.35mm):.....For stripping very heavy insulation on large wires and rectangular sections

Wheel Dimensions

Fybrglass

Figure 1 **Regular Wheels**

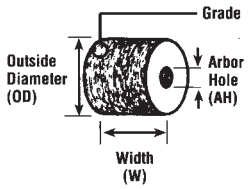


Figure 2 **AN Wheels With Allen nuts in Wheels**

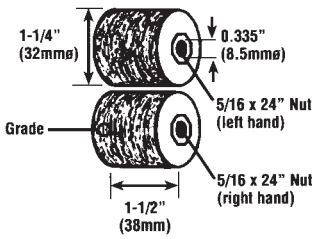


Figure 3 **Wobble Wheels (Long life-Surface of wheels oscillates)**

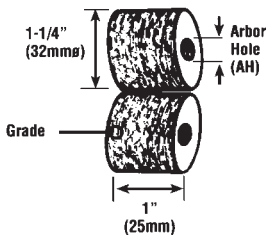


Figure 4 **RT2 Cone Wheels (for close up stripping)**

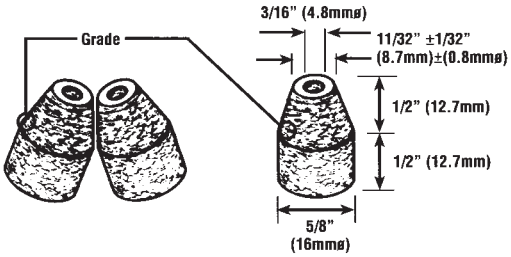
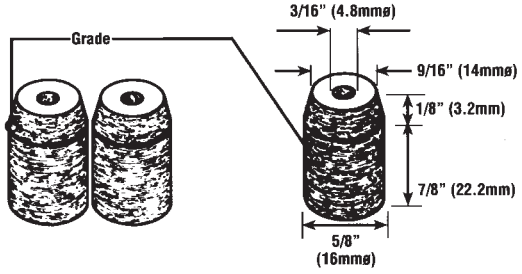
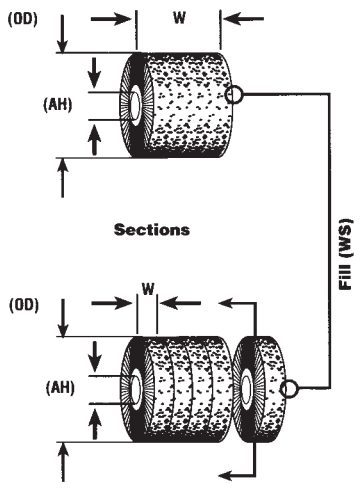


Figure 5 **Beveled Wheels (for easy entrance)**



Wire

Wide Face (Sections pre-assembled for easy quick changeover)



Four Sections of 1/4" wheels stacked = 1" wide face brush. Permits rearrangement of sections as portions of wheel wear.

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Wheel Selection Chart

Fybrglass Wheels

COMPUTER NUMBER	MATERIAL GRADE	SIZE (Inches) OD	W	AH	SIZE (mm) OD	W	AH	MODEL USED ON
AE0128	141	5/8	5/8	3/16	16	16	4.76	
AE0031	201	5/8	5/8	3/16	16	16	4.76	R1S
AE0032	553	5/8	5/8	3/16	16	16	4.76	ST-1
AE0033	640	5/8	5/8	3/16	16	16	4.76	
AE0144	640	5/8	1	3/16	16	25	4.76	
AE0131	141							
AE0076	201	BEV Dimensions						R1S
AE0077	553	See Figure 5						ST-1
AE0078	640							
AE0079	201							
AE0280	553	RT Dimensions						RT2
AE0081	640	See Figure 4						
AE0095	840							
AE0111	141	3/4	5/8	3/16	19	16	4.76	
AE0034	201	3/4	5/8	3/16	19	16	4.76	R1S
AE0035	553	3/4	5/8	3/16	19	16	4.76	
AE0036	640	3/4	5/8	3/16	19	16	4.76	
AE0112	201	1-1/4	1/8	.335	32	3.2	8.51	D109
AE0166	640	1-1/4	1/8	.335	32	3.2	8.51	
AE0044	553	1-1/4	1/4	.335	32	3.2	8.51	D109
AE0045	640	1-1/4	1/4	.335	32	3.2	8.51	
AE0004	201	1-1/4	3/4	25/64	32	19	9.90	PD9
AE0006	553	1-1/4	3/4	25/64	32	19	9.90	
AE0353	141	1-1/4	1	.335	32	25	8.51	
AE0093	SPEC	1-1/4	1	.335	32	25	8.51	
AE0254	201	1-1/4	1	.335	32	25	8.51	D Series
AE0255	553	1-1/4	1	.335	32	25	8.51	
AE0256	640	1-1/4	1	.335	32	25	8.51	
AE0072	141	Wobble Dimensions See Figure 3		.335	Wobble Dimensions See Figure 3		8.51	
AE0109	SPEC			.335			8.51	
AE0073	201			.335			8.51	D Series
AE0274	553			.335			8.51	
AE0075	640			.335			8.51	
AE0057	201	1-1/4	1	3/8	32	25	9.52	
AE0058	553	1-1/4	1	3/8	32	25	9.52	
AE0167	201	Wobble Dimensions See Figure 3		3/8	Wobble Dimensions See Figure 3		9.52	
AE0168	553			3/8			9.52	
AE0143	553	AN Dimensions See Figure 2						D Series
AE0151	640							
AE0087	553	1-3/8	3/4	6mm	35	20	6	PD2S
AE0088	640	1-3/8	3/4	6mm	35	20	6	
AE0066	201	3-1/2	5/8	1/2	89	16	12.7	
AE0067	553	3-1/2	5/8	1/2	89	16	12.7	

Wire Wheels

COMP. NO	BRUSH Dimensions (Inches) OD	W	AH	WS	BRUSH Dimensions (mm) OD	W	AH	WS	MODEL USED ON
AC0752	3/4	3/4	3/16	.004	19	19	4.76	.10	R1S
AC0754	-	-	-	.005	-	-	-	.12	R1S
AC0751	-	-	-	.008	-	-	-	.20	R1S
AC5005	1-1/4	3/16	.335	.005	32	5	8.51	.12	
AC5006	-	-	-	.006	-	-	-	.15	All
AC5008	-	-	-	.008	-	-	-	.20	D Series
AC5011	-	-	-	.0118	-	-	-	.30	D109
AC1217	1-1/4	3/16	3/8	.003	32	5	9.53	.08	
AC1220	-	-	-	.004	-	-	-	.10	
AC1228	1-1/4	3/16	3/8	.008	32	5	9.53	.20	
AC1257	-	-	-	.0118	-	-	-	.30	
AC1226	-	-	25/64	.006	-	-	9.92	.15	PD9
AC1229	-	-	-	.008	-	-	-	.20	PD9
AC1232	-	-	-	.0118	-	-	-	.30	PD9
AC1218	1-1/4	1	.335	.003	32	25	8.51	.08	
AC1221	-	-	-	.004	-	-	-	.10	
AC1223	-	-	-	.005	-	-	-	.12	All
AC1227	-	-	-	.006	-	-	-	.15	D Series
AC1230	-	-	-	.008	-	-	-	.20	Except
AC1252	-	-	-	.0118	-	-	-	.30	D109
AC1219	-	1-1/2	.335	.003	-	38	8.51	.08	
AC1224	-	-	-	.005	-	-	-	.12	
AC1231	-	-	-	.008	-	-	-	.20	
AC3503	1-3/8	3/4	.24	.004	35	20	6	.10	PD2S
AC1312	-	-	-	.005	-	-	-	.12	PD2S
AC3504	-	-	-	.006	-	-	-	.15	PD2S
AC1308	-	-	-	.008	-	-	-	.20	PD2S
AC1309	1-3/8	3/4	.24	.0104	35	20	6	.25	PD2S
AC1310	-	-	-	.0118	-	-	-	.30	PD2S
AC1501	1-1/2	3/16	3/8	.003	38	5	9.53	.08	
AC1505	1-1/2	3/16	3/8	.008	38	5	9.53	.20	
AC2006	2	1/4	1/2	.006	51	6	12.7	.15	
AC2007	-	-	-	.008	-	-	-	.20	E200
AC2010	-	-	-	.0118	-	-	-	.30	and
AC2011	-	-	-	.014	-	-	-	.36	E300
AC2068	2	2	1/2	.004	51	51	12.7	.10	
AC2069	-	-	-	.006	-	-	-	.15	E200
AC2042	-	-	-	.008	-	-	-	.20	and
AC2070	-	-	-	.0118	-	-	-	.30	E300
AC2071	-	-	-	.014	-	-	-	.36	

Wheel Dressers

AR2701.....Wheel dresser and handle-for twin wheel strippers with wheels over 1" (25mm) wide. for use with **(D1, DV1, D9, D109)**

AR2702.....Wheel dresser refills (package of 10) for use with **(D1, DV1, D9, D109)**

AR3020.....Wheel dresser refills for twin wheel strippers with wheels under 1" (25mm) wide (package of 10) for use with **(R1S, RT2, ST1)**

Eraser has the capability to design and make custom fybrglass and wire wheels of many types. If you have an application requiring a custom wheel not shown above, please contact our factory for details.

Nylon Wheels for Combing Coax

COMP. NO	SIZE (Inches) OD	W	AH	Nylon dia.	SIZE (mm) Ø mm	W	AH	Nylon Ø		Used on (Number to make one set)
AC4003	1-1/4	2	.335	0.016	32	5.0	8.51	0.41	Stack 5 together to make 1" (25mm) long brush	D Series (10)
AC2058	2	1/4	1/2	0.016	50	6.3	13	0.41	Stack 8 together to make 2" (50mm) long brush	E200 (16)

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