
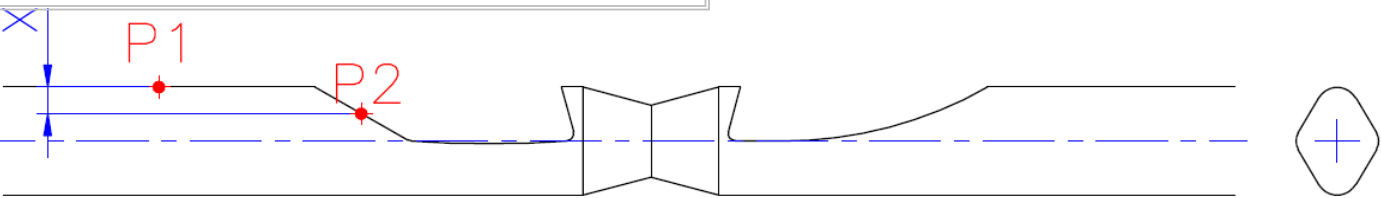


WORK INSTRUCTION			
ISSUE LEVEL	ISSUE DATE	SUPERSEDES	AUTH
1	14-Aug-09	NONE	
DOC REF.	TITLE		
AEU00171	MEASUREMENT OF PUNCHED WIRE FEED LENGTH		

Wire Presentation & Orientation.



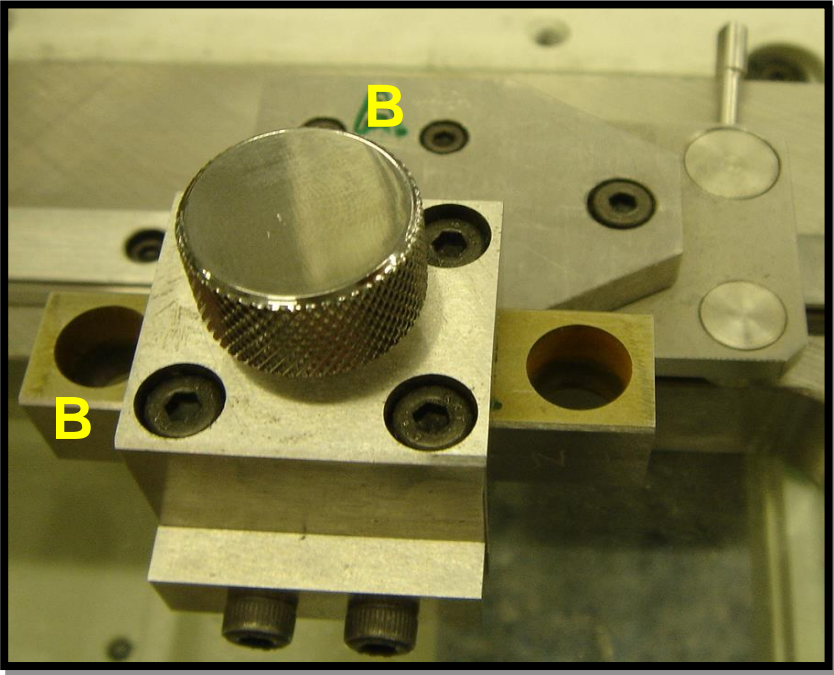
The sample feed length should be presented in the same orientation as it would come off the press. The sample must be viewed through the wire's punch side face. This is achieved by having the punch and crush feature facing away from you and the first notch 1 to your left as

Wire Guide & Wire Assembly.

1 Choose correct wire guides depending upon the size of the wire being punched and crushed.



2 Place wire guides "A" into support "A" and wire guides "B" into support "B".

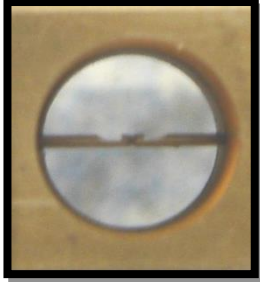


Ensure the wire guides are correctly orientated to suit the wire sample's angles and so that the sample can be presented correctly in the main fixture.



**3** Feed the wire sample into the first wire guide, ensuring the wire is in the correct orientation.

**4** Before locking off the wire guide support, align punched notch features within wire guide view hole as shown below.



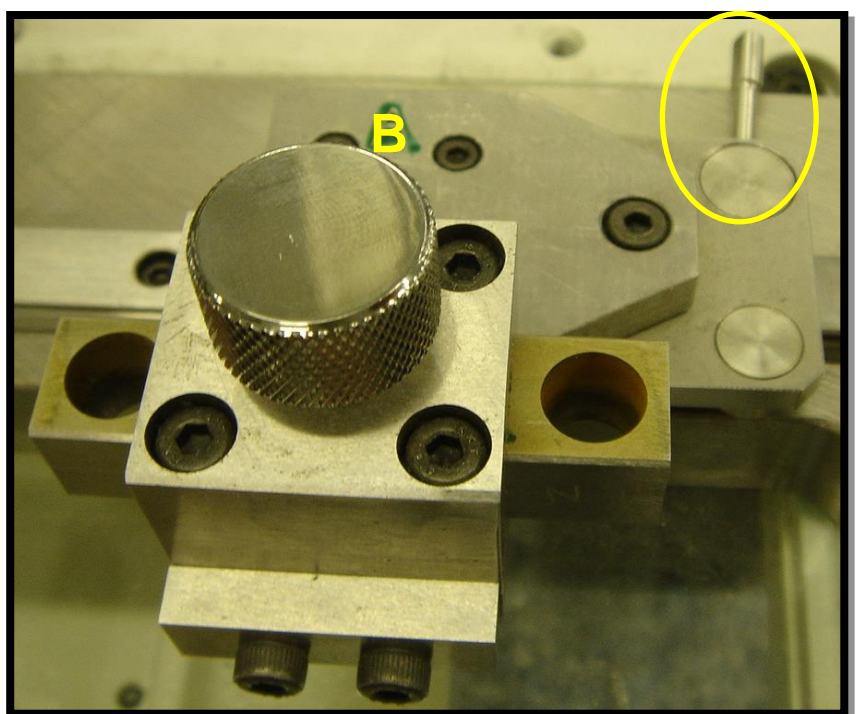
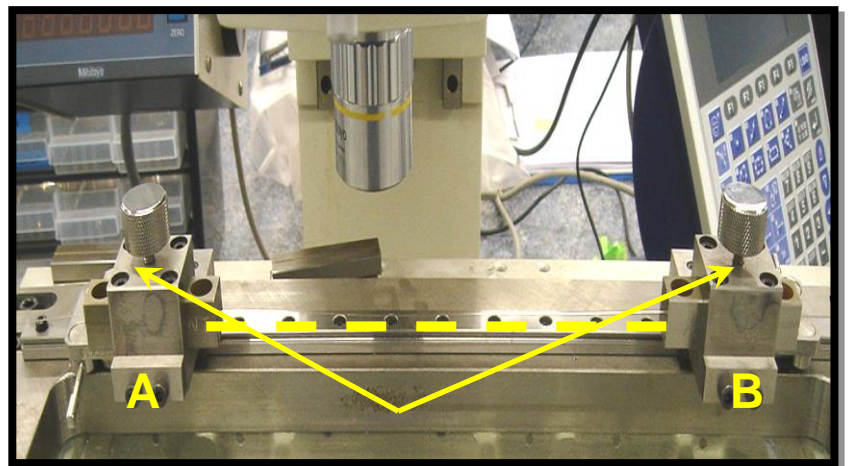
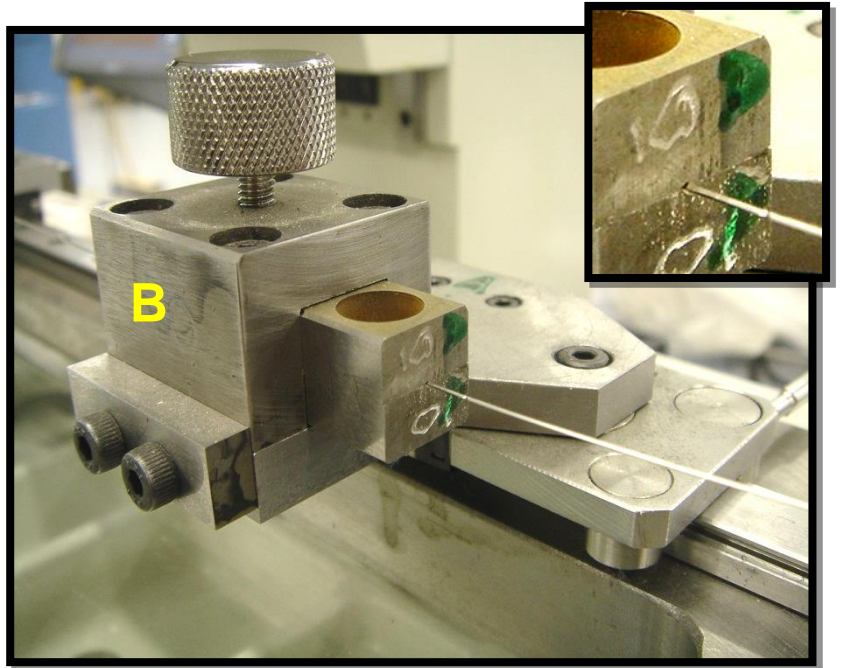
**5** Continue to feed sample wire through the first wire guide to the second wire guide.

Again, before locking off the second wire guide support, align punched notch feature within wire guide view hole.

**6** Tighten both A & B sets of guides into wire guide supports.

**7** Before locking off the wire guide support, align punched notch feature within wire guide view hole.

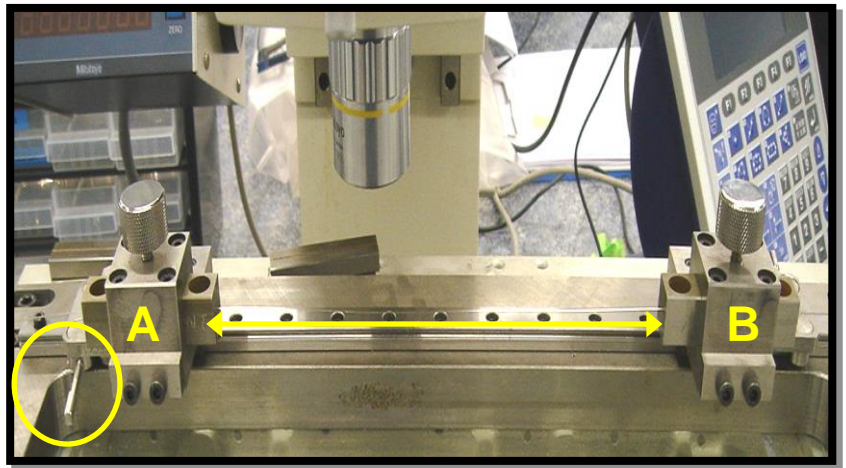
Lock off one wire guide support.





**8** Space the two wire guides as wide apart as possible, as to achieve the maximum number of feed lengths that can be measured in one set-up.

Tension wire sample with the other side and then lock off..

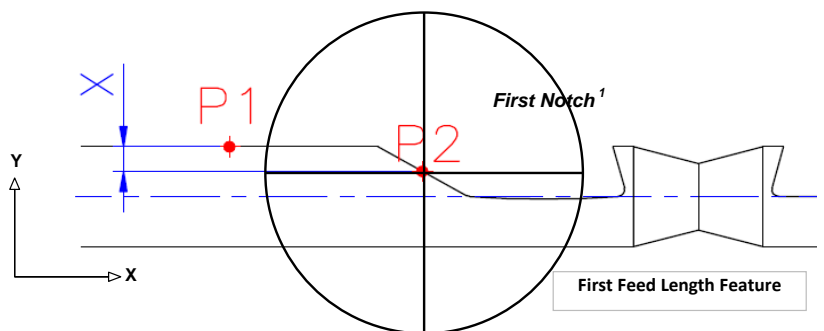


### Measurement Sequence.

**9** Clean first punched sample feature in view.

**10** Focus then align horizontal cross hairs along the sample wire edge P1.

**11** Zero the Y axis

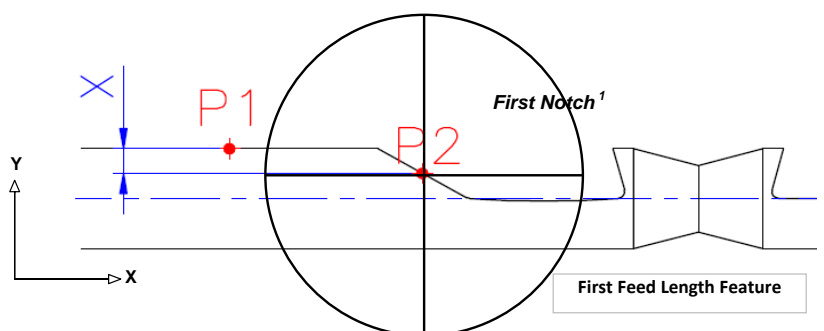


**12** Move cross hairs down in the Y axis to given depth for wire size.



This Y depth will be used as a datum depth for all readings.

The correct depth for wire size must be used to generate datum point P2 so as all data recorded can be used as a comparison



**13** Traverse at this depth in the X axis and align cross hairs on the leading edge feature of the first notch P2.

**14** Zero the X axis counter.

This will be datum point P2 for the first sample feed length.



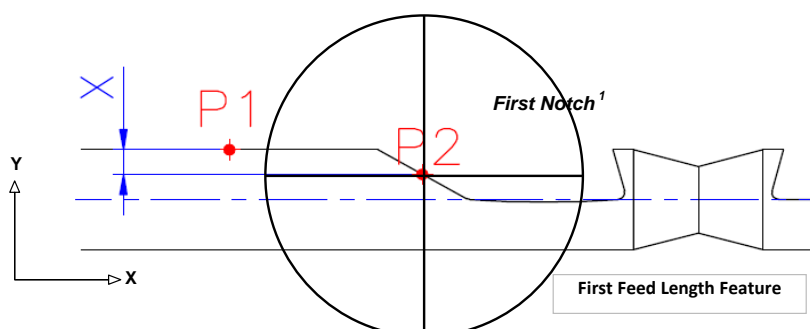
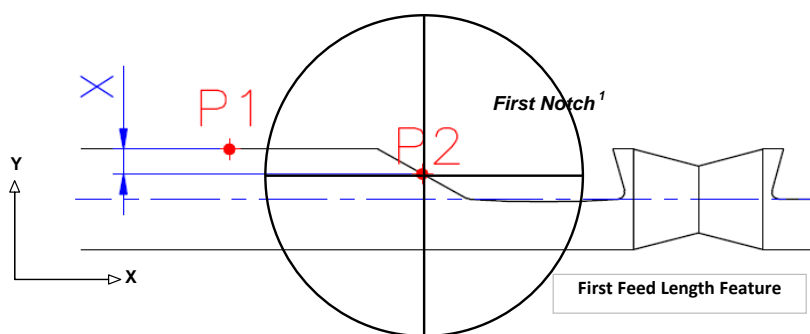
**15** Traverse along the sample feed length to the second punched feature.

**16** Repeat instruction (8) for the second punched feature, focusing and aligning cross hairs on the sample wire edge P1.

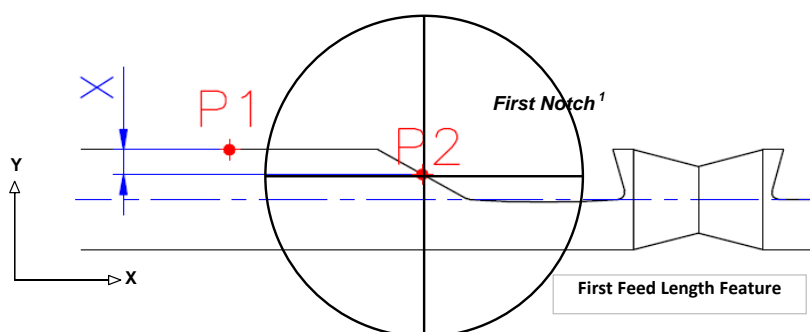
**17** Zero the Y axis counter. on the sample wire edge P1.



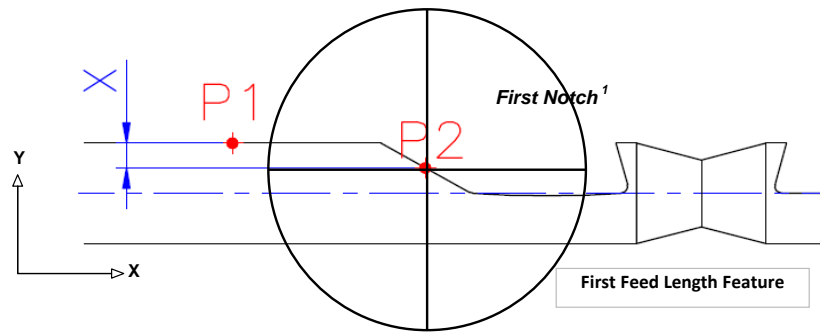
**18** Repeat instruction (11) for the second punched feature, moving the cross hairs down in the Y axis to the noted datum depth.



Position second pressed feature under cross hairs



**19** Repeat instruction (12) for the second punched feature traversing in the X axis and aligning cross hairs on the leading edge of the first notch P2.



**20** Note the figure in the X axis counter, this is your feed length result.



**21** Using this second position as a datum point for the next feed length, repeat the measuring procedure moving along the full length of sample wire, recording the results for all the subsequence feed lengths into MeasurLink.