

Rittal – The System.

Faster – better – everywhere.

Length-cutting machine C8+



AS 4050.455

Operating instructions

ENCLOSURES

POWER DISTRIBUTION

CLIMATE CONTROL

IT INFRASTRUCTURE

SOFTWARE & SERVICES

FRIEDHELM LOH GROUP



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1 About this documentation

The warnings in this documentation are structured differently depending on the severity of danger.



Warning!

Possible risk of fatality!

Notices with the signal word "warning" warn you about situations which could lead to fatal or serious injuries if you do not pay attention to the notices specified.



Caution!

Risk of injury!

Notices with the signal word "caution" warn you about situations which could lead to injury if you do not pay attention to the notices specified.

Attention!

Property damage!

Notices with the signal word "attention" warn you about dangers which could result in damage to property.

Situation-related warnings may contain the following warning symbols:

Symbol	Meaning
	Warning: dangerous electrical voltage
	Warning: injury to hands due to sharp blades
	Warning: hand injuries (crushing)
	Work may only be performed by an electrical specialist
	Only perform work with personal protective equipment
	Notes on the documentation

Additional formatting is used in the rest of the text which has the following meaning:



Note:

This constitutes information which is not related to safety, but which provides important information regarding correct and effective work.

- This symbol indicates an "action point" and shows that you should perform an operation or procedure.
- Bullet points are indicated with dashes.

2 General safety notes

2.1 Intended use

The machine is intended for the cutting to length of round cables.

Only the material described in section 2.2 may be processed using the machine.

The machine must only be used within the technical limits described (see section 3.1 "Technical data" and 3.2 "Type plate"). Modifications to and reconstructions of the machine must not be performed. Notices may not be removed.

Intended use also includes paying attention to the complete documentation. All other uses are considered improper. An improper use is not known to the manufacturer.

Failure to comply with these instructions will not guarantee safe operation and will exclude liability of the manufacturer.

2.2 Processable material

Flexible wires with a cross-section of:

- Flexible wire: 0.08–10.0 mm² (AWG 28–8)
- Solid wire: 0.08–2.50 mm² (AWG 28–14)

2.3 Safety equipment

The machine is equipped with the following safety devices:

- Protective cover
- Emergency power off
- Mains adaptor

These items of safety equipment must not be rendered ineffective. They must be checked once per year by a service technician.

In case of malfunction, the machine must not be operated.

2.4 Personnel

Only trained personnel may operate the machine and perform maintenance activities. Training also includes having fully read the operating instructions.



Repairs may only be performed following consultation with Rittal Service and only by an electrical specialist.



Keep the operating instructions stored so that they can be inspected by operating personnel at any time.

3 Device description



Fig. 1: Front view

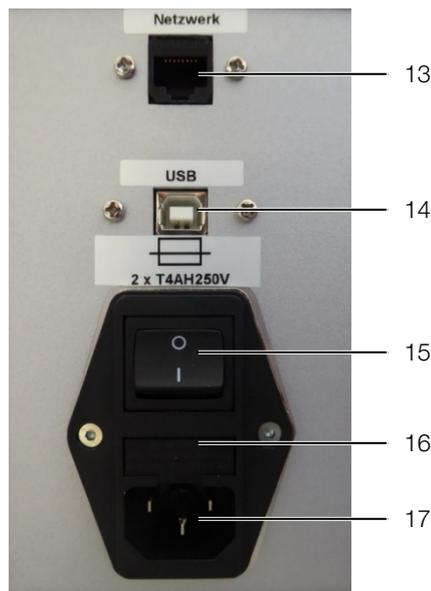


Fig. 2: Rear view

Key

- 1 Adjustment wheel for contact pressure of the feed rollers
- 2 Start button
- 3 Feed rollers
- 4 Protective cover
- 5 Wire entrance
- 6 Chute
- 7 Cutting blade
- 8 Carrying handle, both sides
- 9 Emergency stop
- 10 Rotary switch for feed roller position
- 11 Control unit with keyboard and display
- 12 USB connection type A (USB memory stick)
- 13 Screen connection (optional)
- 14 USB connection type B (PC)
- 15 On/Off switch
- 16 Fuse compartment
- 17 Mains connection socket

3.1 Technical data

	Length-cutting machine C8+
Drive	Electric
Supply voltage	1~, 100–240 V AC; 50/60 Hz
Power consumption	240 VA
Fuse (mains filter module)	2 x T2AH250V
Maximum short-circuit current (SCCR)	1.5 kA
Protection type	IP20
Protection class	I / protective earth conductor
Wire insertion length	200 mm
Cross section	Fine wire 0.08–10.0 mm ² (AWG 28–8), single wire 0.08–2.50 mm ² (AWG 28–14)
Max. external diameter	8 mm (7.87")
Length pre-selection	1–99,999 mm (0.04–3,937")
Programming memory	Max. 200 cutting jobs
Slip correction	Article specifically programmable
Feed speed	max. 1.5 m/s
Ambient temperature	
Operation	+5 °C to 40 °C (41 °F to 104 °F)
Storage/transport	-25 °C to +55 °C (brief +70 °C) -13 °F to +131 °F (brief +158 °F)
Environmental conditions	
Operating environment	Operation in closed and dry rooms/workshops

4 Transporting and setting up the machine

EN

	Length-cutting machine C8+
Internal temperature in operation	max. 45 °C (max. 113 °F)
Max. operating altitude	2,000 m above sea level
Humidity	50% at +40 °C (104 °F) (without condensation), 90% at +20 °C (68 °F) (without condensation)
Contamination level	2
Continuous sound pressure level	< 70 dB(A)
Dimensions (W x D x H)	385 x 360 x 470 mm (15.16" x 14.17" x 18.50")
Colour	RAL 9003/RAL 7016
Weight	20 kg (44.09 lbs)

3.2 Type plate

Symbol	Meaning	
	Operate machine only in dry and closed rooms / workshops.	IEC 60417
	Reference to the information enclosed or attached to the product. Directive 2003/15/EU	European Union
	CE identification	European Economic Area (EEA)
	Number of years that the product can be used as intended. SJ/T 11363-2006 (China RoHS)	China
	Labeled product must not be disposed of with household waste. WEEE directive	Europe

4 Transporting and setting up the machine

4.1 Installation location

The installation location must meet the following requirements:

- Stable foundation with level, even surface (for machine weight, see section 3.1 "Technical data").
- Keep 30 cm work area free on both sides and in front of the machine.
- Electrical connection easily accessible close by.
- Following the ergonomic principles as a standing or sitting workplace.
- The workplace lighting should be 500-1000 lux.

4.2 Transporting the machine



Caution!

- Always wear work shoes with foot protection when transporting the machine.

- Note the weight of the machine (see section 3.1 "Technical data"). Use a transport aid if necessary.
- To move the machine, always use the side carrying handles.
- To prepare the machine for shipping (e.g. in the event of servicing), use the transport packaging.

4.3 Unpacking the delivery

- Check the delivery for completeness (for scope of delivery, see section 4.4 "Scope of delivery").
- Store away the transport packaging.
- Ensure that the operating instructions are accessible to the user at all times.

4.4 Scope of delivery

- Trimming machine
- Mains connection cable (10 A, 250 V)
- PC connection cable
- AS Manager CD software
- Plastic stylus for touch display
- Operating instructions

4.5 Establishing connections

- Set up the machine in the intended location.
- Insert the power cable into the mains connection socket (fig. 1, item 13) of the machine and connect it to the power supply.

5 Setting up the machine



Note:

This chapter addresses machine setters and technicians. For the work described here, you must be logged in as machine setter or technician.

The menu prompting and the operation of the automatic machine in normal operation are described in section 6 "Operating the machine".

The automatic machine is supplied with the following settings:

- German operating language
- Operator authorisation
- Normal operation
- Short program active

The program structure and the required authorisations are described in section 5.14 "Program structure".



Note:

- Before each switch-on, ensure that the mains connection cable is in perfect condition.

- Switch on the machine.

5 Setting up the machine

EN

The following display appears on the display.



Fig. 3: Display after switching on the machine

Attention!

The display can be damaged!

Unsuitable tools can cause scratching of the display.

- Operate the touch display with your finger or use an input stylus with silicon tip.

5.1 Login as machine setter or technician

- Open menu **3**.
- Enter the password.
 - Machine setter: 1212
 - Technician: Password of the AS country representative.
- Press **E** to save the setting.

You are now logged in as machine setter or technician. This mode remains active until the automatic machine is switched off. For the next switch-on, normal operation with authorisation "Operator" is active again.

5.2 Changing the language

The automatic machine is supplied with the following operating languages:

- German
- English
- French
- Open the "Language" menu item in menu **6**.
- Select the desired language with the **arrow keys**.
- Press **E** to save the setting.

5.3 Available program locations

2000 program locations can be assigned in the automatic machine. As supplied, these locations are organised as follows:

- 000: reserved for the Quick start program
- 001–500: editable programs
- 501–2000: reserved for wiring data

When you use interface software, you should assign only the first 500 program locations with production programs, because program locations starting at 501 are overwritten with the wiring data.

If required, you can change the organisation of the program locations.

- Open the "Progr. memory location" menu item in menu **6**.
- Change the organisation.
- Press **E** to save the setting.

5.4 Loading production data into the automatic machine

Requirement: The production data prepared in the AS Manager is copied to a USB stick.



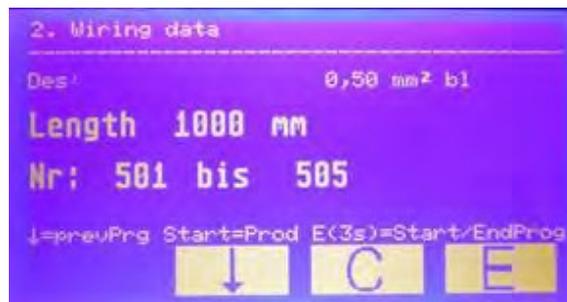
Note:

The AS Manager handling is described in section 10 "AS Manager".

- Insert the USB stick in the USB socket at the rear of the operating unit (fig. 1, item 12).
- Open menu 4.
The USB interface is displayed.
- Press **E**.
The production data is transferred to the automatic machine.
- Remove the USB stick from the USB socket.

5.5 Using wiring data

- Open menu 2.
The following display appears on the screen.



- Press the Start button to begin the processing.
After completion of the processing, the display changes:



- Press the arrow key to repeat the program that has just completed.
- Press the Start button to begin the processing of the next program.

5.6 Changing the production program

You can change the standard parameters in any production program:

- Program number
- Designation
- Quantity
- Length (in mm)

If you want to change the following parameters, you must deactivate the short program beforehand (see section 5.7 "Setting the short program"):

- Subquantity
- Correction
- Subquantity wait time

- Motor wait time
- Cable type
- Open menu **5**.
- Enter the number of the program that you want to change.
- Press **E** to open the program.
- Select with the **arrow keys** the program parameter that you want to change.
- Press **E**.
- The cursor flashes.
- Perform the change.
- To save the setting, press **E** for at least 3 seconds.
- If required, change further parameters similarly.
- Once all changes have been performed, exit the menu by pressing **C**.

5.7 Setting the short program

Only the standard parameters can be changed in the short program. In order to be able to change further parameters, you must deactivate the short program.

- Open the "Short program" menu item in menu **6**.
- Select the desired setting (1 = active, 0 = not active) with the **arrow keys**.
- Press **E** to save the setting.

5.8 Resetting the day quantity counter

- Open menu **7**.
- Keep **C** pressed (for at least 5 seconds).
- The day quantity counter is set to zero.

5.9 Setting cable monitoring

When this function is active, the automatic machine detects whether a conductor is present between the feed rollers.

- Open the "Cable monitoring" menu item in menu **6**.
- Select the desired setting (1 = active, 0 = not active) with the **arrow keys**.
- Press **E** to save the setting.

5.10 Setting zero overlap

When this function is active, a zero overlap is performed at each program start.

- Open the "0 overlap" menu item in menu **6**.
- Select the desired setting (1 = active, 0 = not active) with the **arrow keys**.
- Press **E** to save the setting.

5.11 Setting program start

When this function is active, the automatic machine can be started from a connected PC or the Start key.

- Open the "PC start" menu item in menu **6**.
- Select the desired setting (1 = active, 0 = not active) with the **arrow keys**.
- Press **E** to save the setting.

5.12 Setting ramp-up speed

You can change the speed with which the automatic machine is ramped up after being switched on.

- Open the "Motor ramp" menu item in menu **6**.
- Select the desired setting (1 = fast, 10 = slow) with the **arrow keys**.
- Press **E** to save the setting.

5.13 Setting length correction

You can correct the cable feed with the length correction.

- Open the "Correction" menu item in menu **6**.
- Select the desired value (-99 mm ... +99 mm) with the **arrow keys**.
- Press **E** to save the setting.

5.14 Program structure

Name	Authorisation ¹⁾			Options	Default	Description
1. Production menu	I					
2. Wiring data	I					
3. User menu	I					
4. USB data		II				
5. Programs		II				
6. Settings						
Language		II		German/English/ French	German	
Short program		II		1 / 0	1	1: Standard parameters that can be changed 0: Further parameters that can be changed
Program memory locations		II		1 ... 2000		Organisation of program locations
Cable monitoring		II		1 / 0	1	Cable between the feed rollers
0 overlay		II		1 / 0	1	Zero overlap at program start
PC start		II		1 / 0	0	Start command by the AS Manager
Motor ramp		II		1 ... 10	5	Ramp up after switch-on 1 = fast, 10 = slow
Speed		II		0.1 ... 1.5 m/s	1.5	Feed speed of the cable feed
Correction		II		-99 ...+99 mm		Length correction of the cable feed
Timeout position			III	0 ... 99 s	50	
Program wait time			III	0 ... 100 s		
Motor increments			III	1 ... 9999 inc/rev	2000	
Path/motor revolution			III	1 ... 99.9999 mm/rev	36.4425	
Max. feed current			III	0 ... 255	95	
Max. cutting current			III	0 ... 255	50	
Machine type						
Machine number						
7. Operating data		II		Delete day counter		
			III	Delete all programs		
			III	Factory settings		
8. Manual operation			III			
9. Test inputs			III			
10. Test outputs			III			

¹⁾ Authorisation: I = operator, II = machine setter, III = technician

6 Operating the machine



Note:

- Things to check prior to each activation:
 - Is the machine without without recognisable defects and damages?
 - Is the power cable in fault-free condition?

If one of these defects is present, the machine must not be operated.

- Check whether the defect can be remedied by maintenance. Otherwise, contact your Rittal service.

- Switch on the machine (fig. 1, item 15). The production menu is shown in the display.



Fig. 4: Display with production menu

Key

- 1 Active menu
- 2 Program number
- 3 Designation
- 4 Length
- 5 Piece quantity
- 6 Cable feed speed

6.1 Operating the touch display

Attention!

The display can be damaged!

Unsuitable tools can cause scratching of the display.

- Operate the touch display with your finger or use an input stylus with silicon tip.

When operating menus are shown on the display, only the lower four fields are touch-sensitive. These fields allow navigation through the program.



Fig. 5: Tap fields in the operating menus

Button	Functions
↑	Select menu (move forwards) or increase value
↓	Select menu (move backwards) or reduce value
C	Exit menu

Button	Functions
E	Activate selected menu or set value

- To select an operating menu, press the **arrow keys**.
- To switch to the selected menu, press **E**.
- Move to the desired point inside a menu using the **arrow keys**.
- To activate a selected point, press **E**.
- To exit the menu, press **C**.

Only menus 1 to 3 are relevant for operation.

Here you can:

- Menu 1: Change speed
- Menu 2: View wiring data
- Menu 3: Login as machine setter or technician

Only menus 4-7 are relevant for the machine setter.

Here you can:

- Menu 4: Load USB data
- Menu 5: Change program parameters
- Menu 6: Change the organisation of the memory location assignment
- Menu 7: Reset the day quantity counter

The other menus are provided only for the Service.

6.2 Selecting a program

Each program in normal operation includes the following settings:

- Program number
- Designation
- Length
- Quantity
- Switch to the production menu if it is not already displayed.
- Press **E**.
- Press the **arrow keys** to set the number of the program that you want to use.
- Press **E** to activate the program.
- Continue as described in section 6.4 "Machining the conductor".

6.3 Quick start program

Program location 000 is reserved for the "Quick start program". This allows you to work even without a predefined program. You can enter the required length and quantity for the "Quick start program".

- Switch to the production menu if it is not already displayed.
- Press **E**.
- Set number "0" with the **arrow keys**.
- Press **E**.
- Enter the length (in mm).
- Press **E** to save the setting.
- Enter the quantity.
- Press **E** to save the setting.
- Continue as described in section 6.4 "Machining the conductor".

The settings for the "Quick start program" at program location 000 remain until they are changed.

6.4 Machining the conductor

- Check that the feed rollers are open.

6 Operating the machine

EN



Fig. 6: Open roller position

- Insert a conductor into the conductor feed until the end appears at the right next to the cutters.
- Close the feed rollers.



Fig. 7: Closed roller position

The conductor is drawn in automatically. The automatic machine performs a zero overlap. The selected program then starts.

An acoustic signal sounds when the set quantity has been machined.

- Open the feed rollers.
- Remove the conductor.

6.5 Changing the feed speed

You can set the feed speed of the cable feed.



Note:

If you set a cut length >1 m, you should always reduce the speed.

- Press **C** briefly in the production menu.
The cursor for the speed display flashes.
- Set the desired value (0.1 m/s ... 1.5 m/s) with the **arrow keys**.
- Press **E** to save the setting.

Alternatively, you can change the speed in the "Speed" menu item in menu **6**.

6.6 Service display

The service display appears for each switch-on of the automatic machine when 250,000 cutting cycles have been performed.

- Press **C** to acknowledge the display.

The automatic machine is then operational.



Note:

To retain the operational capability of the automatic machine as long as possible, the prescribed service intervals should be observed:

- Service after 250,000 cutting cycles
 - Contact your responsible Rittal country representative.

6.7 Emergency off

After activating the Emergency off, the automatic machine is de-energised.

- To switch the automatic machine on again, turn the Emergency-off switch.

6.8 Switching off the automatic machine

- Switch off the automatic machine.

The display screen is extinguished.

7 Cleaning and maintaining the machine

7.1 Cleaning the machine externally

The machine should be freed of dust on a regular basis. It must be cleaned externally as and when required.



Note:

Cleaning the inside is part of maintenance which must only be carried out by trained personnel.

- Make sure that the machine is switched off.

Attention!

The display may become damaged!

Using unsuitable cleaning agents may scratch or damage the display.

- Clean the display carefully, either using a special cleaning cloth for display surfaces or with a soft cloth and some display cleaner.

- Clean the surface of the machine with a damp cloth. If necessary, use soap-based cleaning agents. Do not use any abrasive cleaners or solvents.

7.2 Machine maintenance

In order to ensure fault-free operation, the described maintenance tasks (see section 7.3 "Maintenance schedule") must be performed at the specified intervals.



Warning!

Potential risk of fatality due to electric shock!

When working on the inside of the machine, non-insulated parts may be touched.

- Switch the machine off.
- Pull the power plug.
- Detach the cover and place it down carefully.



Note:

Keep the following ready for maintenance work:

- Brush and cleaning cloth
- Spirit
- Phillips screwdriver for M4 screws

7.3 Maintenance schedule



Fig. 8: Maintenance item overview

Maintenance item	Interval / maintenance activity	See section
Weekly		
1	Clean feed rollers	7.4
2	Clean cutting area	7.5
Half-yearly		
3	Cleaning the interior	7.6
4	Check both toothed belts	7.7
As required		
4	Replace toothed belt	7.8
5	Replace stripping blade	8.3

7.4 Cleaning rollers

- Remove the protective cover.
- Rub the feed rollers with a soft cloth and some spirit.

7.5 Clean cutting area

- Remove the protective cover.
- Blow out the cutting area with compressed air.

7.6 Cleaning the interior

- Clean the inside of the machine with a brush and, if necessary, with a vacuum cleaner.

7 Cleaning and maintaining the machine



Note:

- Never use compressed air for cleaning the inside because otherwise small particles (e.g. cutting residues) become inaccessible on the inside of the machine. This may result in malfunctions and operational stoppages.

7.7 Check toothed belts

- Visually check if the toothed belts are damaged or porous.

7.8 Replace toothed belt

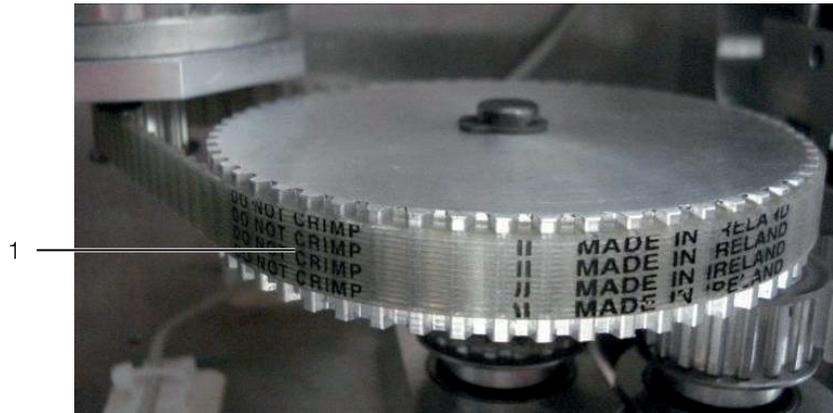


Fig. 9: Replace toothed belt

- Remove the toothed belt (1) from the drive motor.

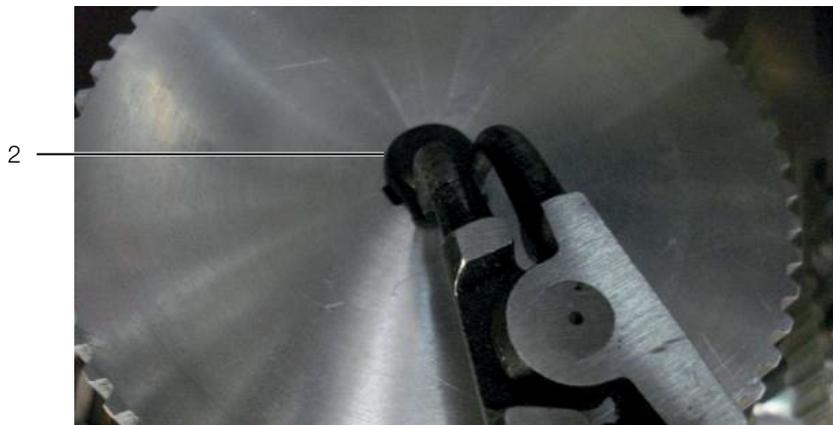


Fig. 10: Remove the circlip

- Remove the circlip (2).



Note:

- Note the feather key (3) below the gear wheel.
- Lift the gear wheel off carefully.
- Make sure that the feather key stays in its position in the process.

7 Cleaning and maintaining the machine

EN

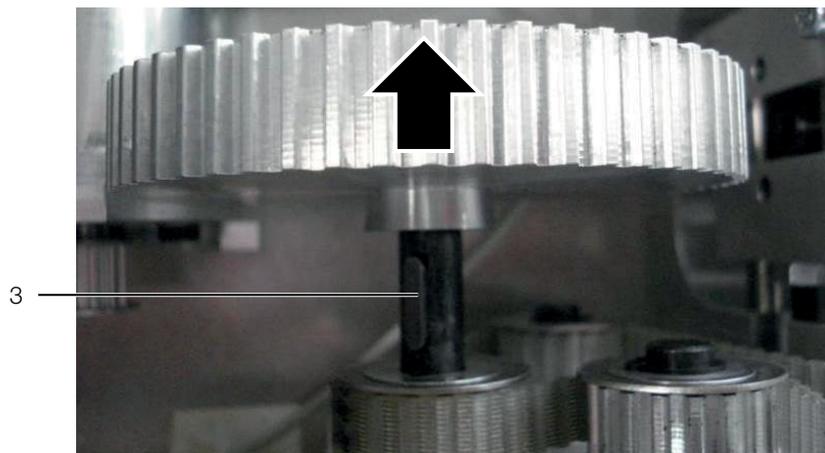


Fig. 11: Lift the gear wheel

- Close the feed rollers with the rotary switch (fig. 1, item 1).

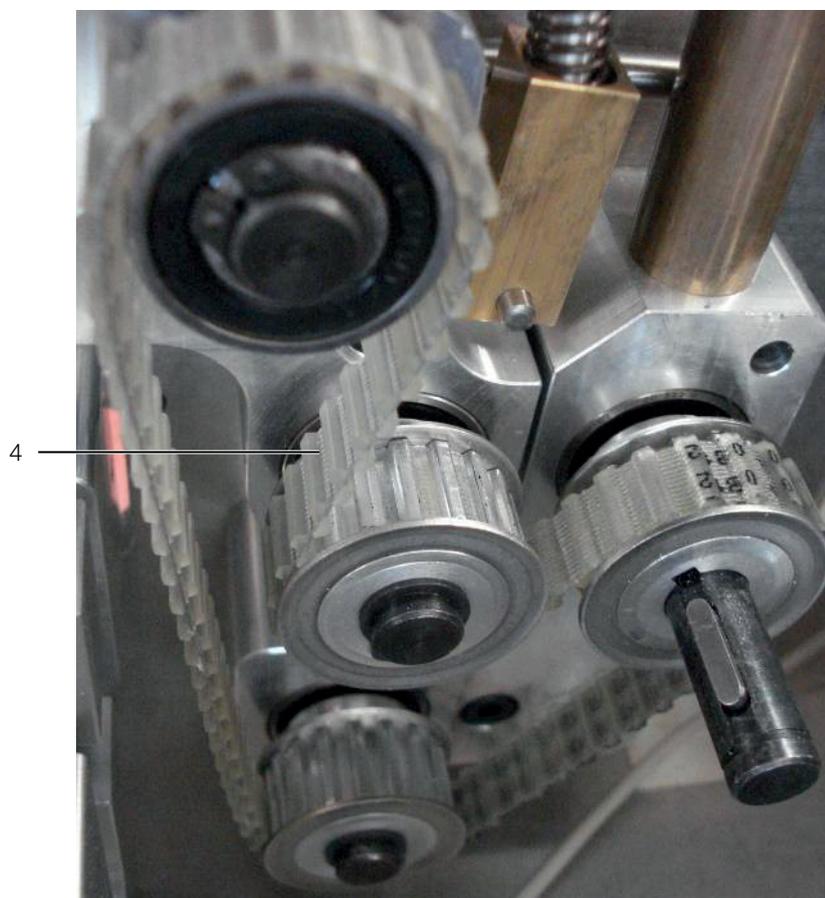


Fig. 12: Remove the double-sided toothed belt

- Remove the double-sided toothed belt (4).

Installation:

- Attach the new double-sided toothed belt.
- Open the feed rollers to tension the toothed belt.
- Attach the gear wheel and fix it with the circlip.
- Attach the toothed belt to the drive motor.

8 Troubleshooting



Note:
If a fault cannot be resolved by means of the actions described here, please refer to Rittal Service.

8.1 Fault table

Fault	Possible cause	Recommended action
Machine cannot be switched on.	No power supply	<ul style="list-style-type: none"> ■ Check the power cable and the mains connections. ■ Check fuses.
Increased scrap	Cutting blade damaged or blunt	■ Replace the blade (see section 8.3 "Replacing a cutting blade").
	Setting shifted	■ Check the setting.
Length deviation	Worn toothed belt	■ Replace the toothed belt.
	Slip	■ Perform a slip correction (see section 5.13 "Setting length correction").
Motor blocked	Cable feed sluggish	■ Check the cable feed.

8.2 Wearing parts

Product	Order no.
Cutting blade (set)	4050.465

8.3 Replacing a cutting blade



Attention!
Risk of injury posed by sharp blades!

- Use forceps to change the blades.
- Dispose of the removed blades in a separate container.



Note:
All present blades must be replaced each time the knife is changed.

- Remove the protective cover and the chute.



Fig. 13: Cutting blade

- Loosen the fixing screws (1) (Allen key 2.0 mm).

9 Taking the machine out of operation and disposing of it

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- Remove the blades (2).
- Align the new blades so that the bevelled edges are turned away from one another.



Fig. 14: Aligning the blades

- Insert the new blades.
- Screw both fixing screws back on tightly.
- Reattach the chute and the protective cover.

8.4 Replacing the fuses

- Make sure that the machine is switched off.
- Remove the power plug.

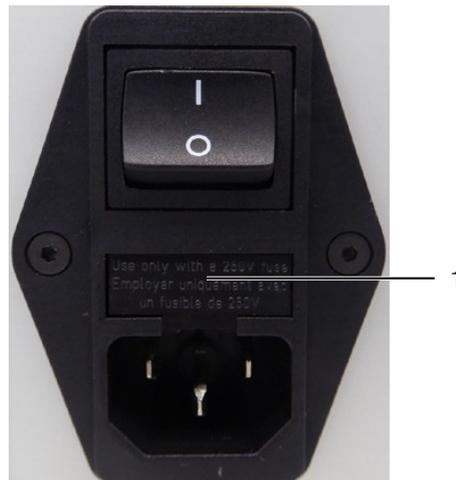


Fig. 15: Opening the fuse compartment

- Lever the fuse compartment (fig. 15, item 1) out of the mains filter unit using a slotted screwdriver.
- Replace both fuses with new ones (2 x T2AH250V).
- Put the fuse compartment back into the mains filter unit.

9 Taking the machine out of operation and disposing of it

9.1 Taking the machine out of operation

- Switch the machine off.
- Pull the power plug.
- Pack the machine in its original packaging.

The machine is now ready for transport and, if necessary, disposal.

9.2 Disposing of the machine

- Take the machine out of operation as described in section 9.1 "Taking the machine out of operation".
- Make sure that the machine is disposed of in accordance with national and local regulations.



The machine must not be disposed of as domestic waste. The machine must be disposed of in an environmentally-friendly and professional manner.



Note:
You can send the machine to Rittal for disposal. Refer to the representative responsible for your country.

10 AS Manager

The AS Manager for the machine "Length-cutting machine C8+" serves to optimise production processes.

Preparation:

- Connect the PC to the machine
- Open the AS Manager.

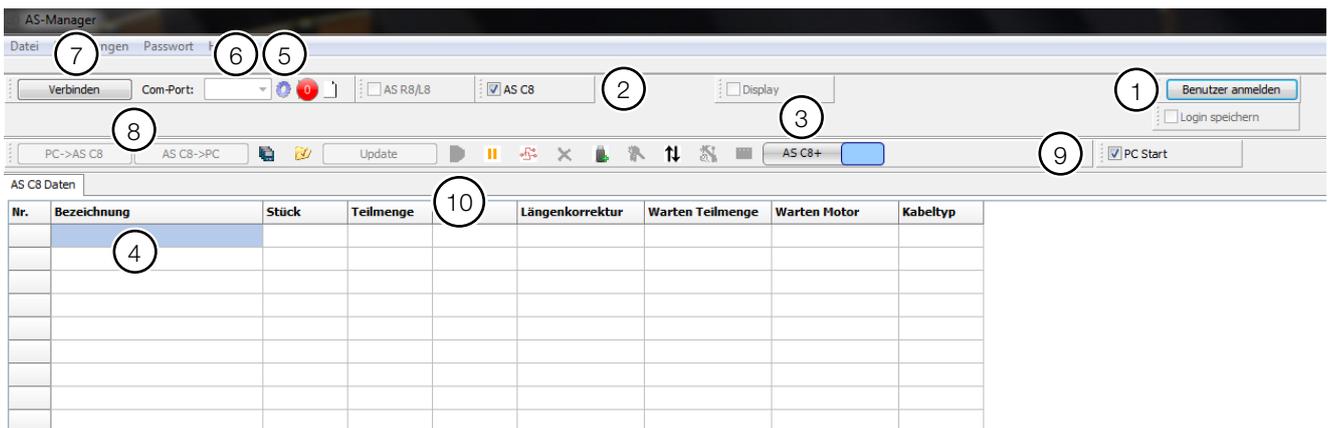
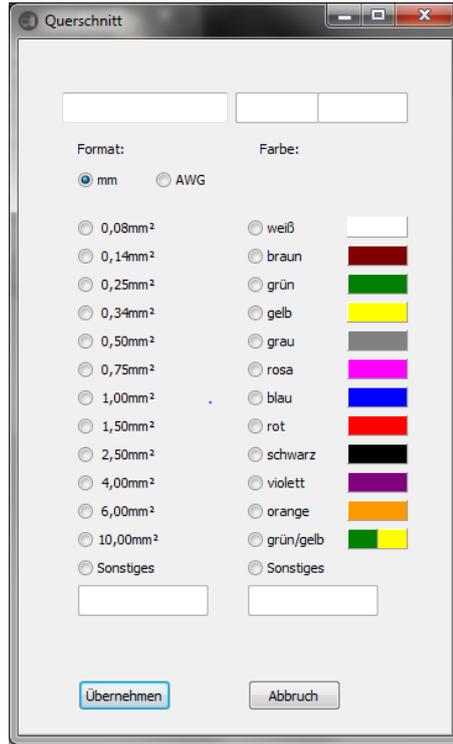


Fig. 16: AS Manager

- Log in as setter (password: 1212) (fig. 16, item 1).
 - Activate "AS C8" (fig. 16, item 2).
 - Select "C8+" or "C8" (change by clicking on the grey area, fig. 16, item 3).
 - Enter "name", "piece", "length" and further information as required (fig. 16, item 4).
 - Click on the gear wheel (fig. 16, item 5).
 - The corresponding COM-port can be selected (fig. 16, item 6).
 - Click on "connect" (fig. 16, item 7).
 - Transfer the data from the PC to the machine or the other way around (fig. 16, item 8).
 - By activating "PC start" (fig. 16, item 9), you can start the automatic machine from the PC, you must also set the "PC start" menu to "1" in the menu.
- By pressing the "Update" button (fig. 16, item 10), the data is transferred to a temporary memory of the automatic machine and processed.

Input options in the "Designation" field

Free text can be entered in the white fields.



Buttons

Button	Description
	Change COM interface
	Status of the COM connection
	Clear displays
	Save the program data
	Open the program data
	Start cable list processing
	Pause cable list processing
	Display/hide wiring data
	Generate USB data
	Sort cable list (according to the designation)

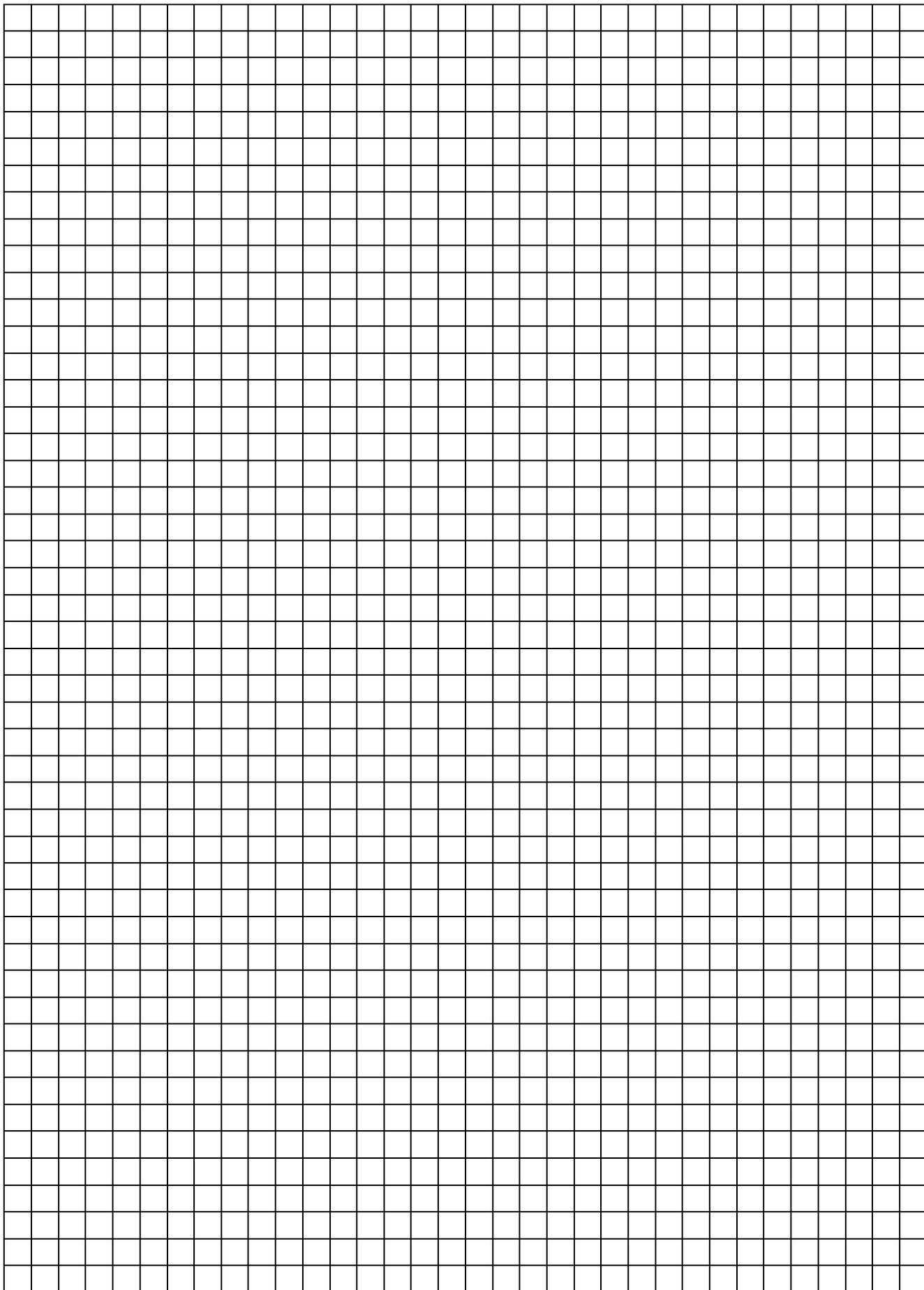
Create production program in Excel

When data is created externally in an Excel table, ensure the correct order of the columns so that the data can be transferred.

Datei											
Start		Einfügen		Seitenlayout		Formeln		Daten		Überprüfen	
Ansicht		Acrobat									
B1		Querschnitt									
	A	B	C	D	E	F	G	H	I		
1	Lfd. Nummer	Querschnitt	Farbe	Bündel Nr.	Quelle	Ziel	Länge [mm]	Aderendbehandlung	Quelle	Aderendbehandlung Ziel	

Generate USB data

- Select the "📁" button.
This allows data to be transferred to a USB stick.
- Create a description for the exact definition of the data (production data).
This description is queried by the software.
The storage location for the created file "UCUSBxxx.txt" is then queried.
- Select the USB stick.
 - The USB data must be stored in the folder with the designation "UCUSBDIR".
 - If no such folder exists, it will be created by the program.
- Remove the USB stick and insert it in the length-cutting machine C8+.
- Go to menu **4**, "USB data".
- Press **E**.
- Select the appropriate file with the **arrow keys**.
The description (production data) is also displayed.
- Press **E**.
The data is loaded starting at program 501. Any existing data is overwritten.
- Go to menu **2**, "Wiring data".
The data appears on the display.
- Press the Start button to begin the processing.



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