

CF-120 帶裝立式零件成型機 操作說明書

A. 操作方法:

1. 試運轉 – 開啓(D12)電源開關,電源指示燈(D14)隨之亮起,轉動 VR 調速器(D13)至適當位置,即可開始操作,試行操作一切正常後,把馬達調速器歸零,開始進行下一動作。
2. 入料 – 將原料架於兩架料輪(C23)之間,紙帶放於內方,材料本體向外,再進入(C17)左軌道,讓紙帶的小圓孔能直線對準(C7)時規皮帶,皮帶上有錐形小柱體,將紙帶小圓孔放入錐形小柱體,用手壓下(C10)齒型皮帶導軌,慢慢調整加快(D13)VR 控制器之速度,紙帶隨之進入模具中,入料動作即告完成。
3. 試做 – 當材料到達(B4)(B5)上下成型模時,會先將線腳成型折彎(依照訂購時所指樣式成型),但元件依然附於紙帶上,查看成型角度是否正確,角度之深與淺可調整(B41)固定螺絲做小幅度調整,等確認後再通過(B6)及(B7)將元件切斷。
4. 高低調整 – 線腳成型位置與本體間距,轉動(B10)調整螺絲,即可調整成型的位置。
5. 腳長短調整 – 所留的線腳長短,可轉動(B10)調整螺絲,即可整組切刀座上下移動,腳長短也隨之變化。
6. 出帶 – 當(B6)與(B7)將元件切斷時,原料會往外跳,必需將(D6)護蓋關上,廢紙帶導正後由廢料孔導出。

B. 注意事項:

1. 皮帶如有鬆弛 – 需調整(C1)橢輪。
2. 元件與模具有同步關係,並且要對準於(B4)與(B5)上下成型模中央。
3. (C7)時規皮帶位置調整需放鬆(C21)皮帶輪上的螺絲,即可調整元件成型的位置。
4. 成型模座與切斷模座之調整是轉動(B10)調整螺絲,即可整組移動。

C. 保養維護:

1. (A11)共四組偏心軸,需定期擦拭加油。
2. (B2)圓形模塊,需定期加油。
3. (B41)切刀固定螺絲,需確定鎖緊不可鬆弛。
4. (B4)及(B5)上下成型模,隨不同線徑,需作微幅調整。

※以上概略說明,如有疑問歡迎來電洽詢,本公司將以最大誠意為您服務,如需更換零件或購買備品,只要將圖上之代號,傳真回本公司,即可將您要的零件寄達貴司。

服務專線 TEL: +886-2-8201-1187 , 2202-1205
FAX: +886-2-2202-1204 , 2203-9391

CF-120 帶裝立式零件成型機 零件表

零件編號	零件名稱	零件編號	零件名稱	零件編號	零件名稱
A1	馬達	A13	橢輪軸	C6	皮帶鬆緊螺絲
A2	減速機	A131	直徑32培林	C61	螺姆
A21	平鍵	A132	直徑28培林	C7	時規皮帶
A22	馬達固定螺絲			C8	皮帶針
A23	螺姆	B1	成型座	C9	鉚合片
A3	間歇機構齒輪	B2	圓形模塊	C10	齒型皮帶導軌
A31	螺絲	B3	底模塊	C101	螺絲
A4	間歇機構轉輪	B4	上成型模	C102	螺絲
A5	分割齒輪軸	B41	螺絲	C103	螺姆
A51	平鍵	B5	下成型模	C11	皮帶入料軌
A52	直徑35培林	B6	上切刀	C111	螺絲
A53	直徑32培林	B7	下切刀	C12	連桿片(大)
A6	送料齒輪	B71	切刀墊片	C121	螺絲
A61	螺絲	B8	滑板蓋	C122	螺絲
A7	偏心軸齒輪	B81	螺絲	C123	螺姆
A71	螺絲	B9	滑軸	C124	螺姆
A8	橢齒輪	B91	螺絲	C13	連桿片(小)
A81	螺絲	B10	螺絲	C131	螺絲
A9	馬達齒輪	B11	螺姆	C14	銅襯套(短)
A91	螺絲			C15	銅襯套(長)
A10	送料皮帶軸	C1	橢輪	C16	軌道拉簧
A101	平鍵	C2	齒型皮帶輪	C161	螺絲
A102	直徑32培林	C21	螺絲	C162	螺姆
A11	偏心輸出軸	C3	橢軸調整軸	C17	左軌道
A111	平鍵	C4	皮帶橢輪軸	C171	軌道調整鈕
A112	直徑32培林	C5	送料皮帶調整桿	C18	L型導片
A12	偏心軸	C51	螺絲	C181	軌道調整鈕
A121	平鍵	C52	墊片	C19	軌道四方軸
A122	直徑32培林	C53	螺絲	C191	螺絲

零件編號	零件名稱	零件編號	零件名稱	零件編號	零件名稱
C20	導料支片	D6	護蓋		
C201	螺絲	D61	護蓋把手		
C22	架料軸	D62	螺絲		
C221	螺母	D63	后鈕		
C23	架料輪	D64	螺絲		
C231	螺絲	D65	螺絲		
C24	架料桿	D7	料盒		
C241	螺絲	D8	壓克力鎖		
C25	架料板	D81	調整螺絲		
C251	螺絲	D82	螺絲		
C26	護料蓋				
C261	螺絲				
C27	下帶片				
C271	螺絲				
D1	外殼				
D11	保險絲				
D12	電源開關				
D13	VR調速器				
D14	電源指示燈				
D2	前台身				
D21	螺絲				
D22	螺絲				
D3	後台身				
D4	連板軸				
D5	底板				
D51	腳墊				
D52	螺絲				
D53	螺絲				

User's manual – CF-120 Taped Radial Lead Former

A. Operation Instruction:

1. **Pilot Operating** - Turning on (D12) On/Off Switch, the power indicator (D14) Will be lighted. Turning the speed regulator (D13) up slowly, the operation will be started according to the speed controlled on the regulator. Turning the speed regulator to “0” position and go to next step when everything goes on smoothly.
2. **Feeding Components** - Put the taped components into the middle of two (C23) feeding wheels. Make sure the components are in outside position. Inserting it into the (C17) Left Track and aiming the hole of the tape at the center of conoid pin on the Synchronous Belt (C7). Push down the Guide Rail (C10). Turning up the speed regulator slowly, you will see the components that go into the forming mold step by step.
3. **Forming** - The components will be formed (according to the specification that required) by the forming mold when it reaches. Turn off the speed regulator and make sure the forming operation is correctly. The depth of forming can be adjusted by the adjusting screw (B41). Go ahead to cutting operation when the forming operations meet the requirements.
4. **Forming Height Adjustment** - The Height of the forming can be adjusted by the Height Adjusting screw (B10) to meet the requirements.
5. **Lead Length Adjustment** - The Lead Length can be controlled by the Lead Length adjusting screw (B10) That will move up or down the mold set to adjusting the length.
6. **Waste tape** - The components will jump up when it is cut by the cutter (B6)(B7). Close the cover Shielded (D6) to eliminate this condition and put the waste tape out through the guide hold in the cover.

B. Caution:

1. **Synchronous Belt** - Make sure the belt is tight enough. Adjusting the idler (C1) when necessary.
2. **Synchronism** - Make sure the component is aimed at the center of forming Mold (B4)(B5). The components must be synchronized with the mold.
3. **Forming Location** - The forming location can be adjusted by loosening the screw (C21) in Driving Wheel.
4. **The Location of Forming and Cutting Mold** - The location of the mold set can be adjusted by the adjusting screw (B10).

C. Maintenance:

1. **Keep clean and lubricated on the following position** - 4 sets of eccentric shaft (A11). Rotundity Module (B2).
2. **Fixed screw** – The screw (B41) is for fixed the forming and cutting mold. Please don't lose it unless necessary.
3. **Minor adjustment for Wire size** – For processing different wire diameter. Make sure to make a minor change on forming mold (B4)(B5).

※ Maintenance and technical support.

Please copy the sketch on the manual for further questions. For spare parts requirement, please ordering by fax in which specified part number or indicate by sketch. Welcome your inquiry for any question if unclear!

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CF-120 Taped Radial Lead Former-Spare Part List

Part No.	Part name	Part No.	Part name
A1	Motor	B1	Forming Pedestal
A2	Reducer	B2	Rotundity Module
A21	Flat Key	B3	Bottom Module
A22	Motor Fixed Screw	B4	Forming Mold , Top
A23	Screw Cap	B41	Screw
A3	Intermission Machine , Gear Wheel	B5	Forming Mold , Bottom
A31	Screw	B6	Cutting Blade , Top
A4	Intermission Machine , Rotation Annulus	B7	Cutting Blade , Bottom
A5	Shaft , Segmentation Gear	B71	Cutting Blade , Underlay
A51	Flat Key	B8	Cover , Forming Mold
A52	Diameter 35mm Bearing	B81	Screw
A53	Diameter 32mm Bearing	B9	Glide Shaft
A6	Feeding Gear Wheel	B91	Screw
A61	Screw	B10	Screw
A7	Eccentric Shaft , Gear Wheel	B11	Screw Cap
A71	Screw		
A8	Idler , Gear Wheel	C1	Idler
A81	Screw	C2	Dentition , Driving Wheel
A9	Motor Gear Wheel	C21	Screw
A91	Screw	C3	Idler , Adjusting Shaft
A10	Driving Wheel Shaft	C4	Belt , Idler Shaft
A101	Flat Key	C5	Feeding belt , Adjusting Bar
A102	Diameter 32mm Bearing	C51	Screw
A11	Eccentric Output Shaft	C52	Underlay
A111	Flat Key	C53	Screw
A112	Diameter 32mm Bearing	C6	Belt , Adjusting Screw
A12	Eccentric Shaft	C61	Screw Cap
A121	Flat Key	C7	Synchronous Belt
A122	Diameter 32mm Bearing	C8	Belt Pin
A13	Idler Shaft	C9	Riveting Plate
A131	Diameter 32mm Bearing	C10	Guide Rail
A132	Diameter 28mm Bearing	C101	Screw



Part No.	Part name	Part No.	Part name
C102	Screw	C261	Screw
C103	Screw Cap	C27	Outlet Plate , Waste
C11	Belt , Inputs Guide	C271	Screw
C111	Screw		
C12	Fastenings (Big)	D1	Outer Cover
C121	Screw	D11	Fuse
C122	Screw	D12	Power on/off Switch
C123	Screw Cap	D13	Speed Regulator
C124	Screw Cap	D14	Power Indicator
C13	Fastenings (Small)	D2	Front Frame
C131	Screw	D21	Screw
C14	Copper Lining (Smallish)	D22	Screw
C15	Copper Lining (Long)	D3	Rear Frame
C16	Track Pull Springs	D4	Joint Shaft
C161	Screw	D5	Bottom Frame
C162	Screw Cap	D51	Underlay
C17	Left Track	D52	Screw
C171	Track Adjusting Knob	D53	Screw
C18	L Type , Guide Parcel	D6	Cover Shielded
C181	Track Adjusting Knob	D61	Knob
C19	Shaft , Track Foursquare	D62	Screw
C191	Screw	D63	Hinge – Acrylic cover
C20	Guide Underlay	D64	Screw
C201	Screw	D65	Screw
C22	Roller Shaft , Tape Reel	D7	Finished Parts Bin
C221	Screw Cap	D8	Acrylic Lock
C23	Feeding Wheels	D81	Adjusting Screw
C231	Screw	D82	Screw
C24	Roller Bar , Tape Reel		
C241	Screw		
C25	Roller Plate , Tape Reel		
C251	Screw		
C26	Cover , Shielded Stuff		

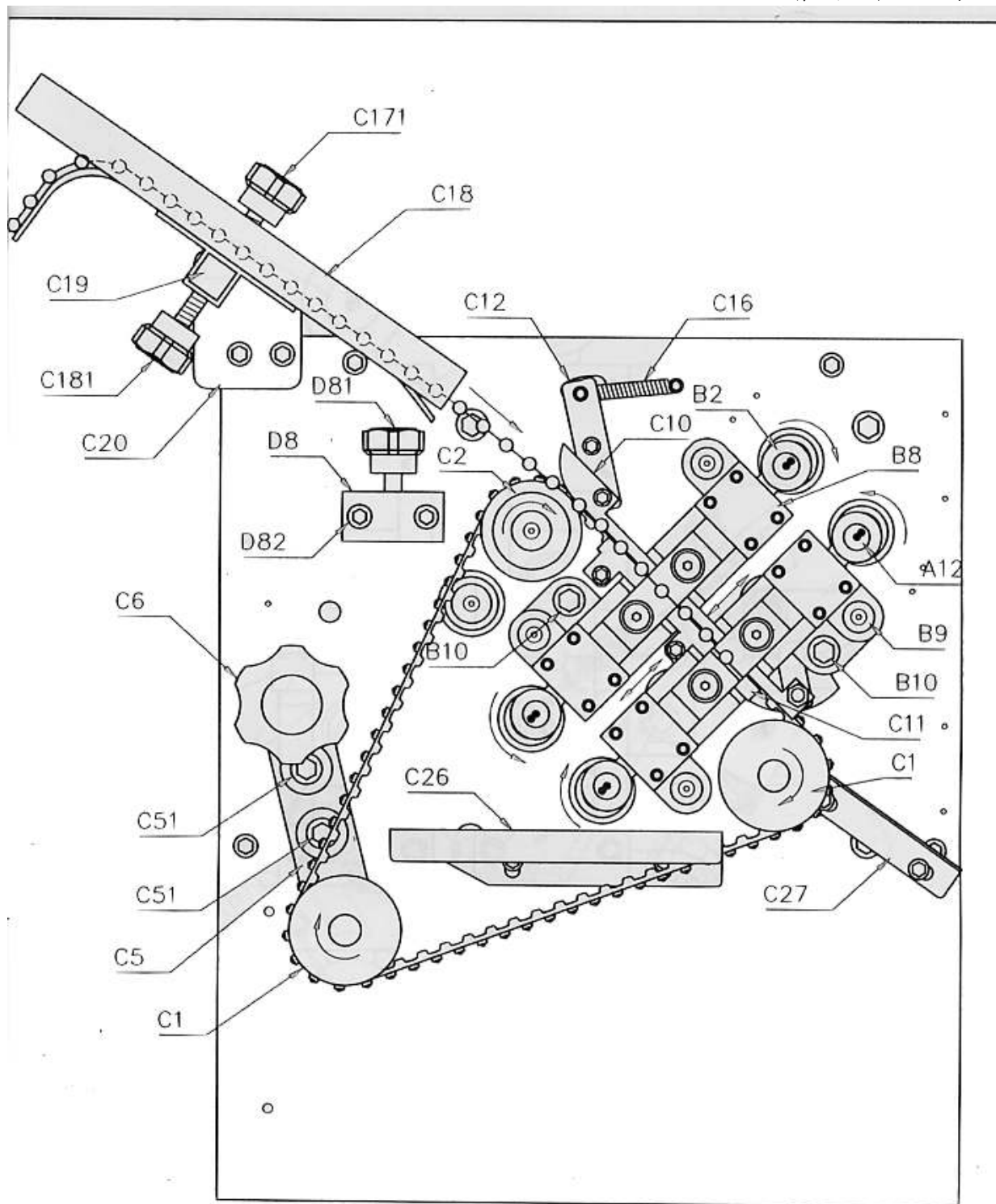


FIG-1

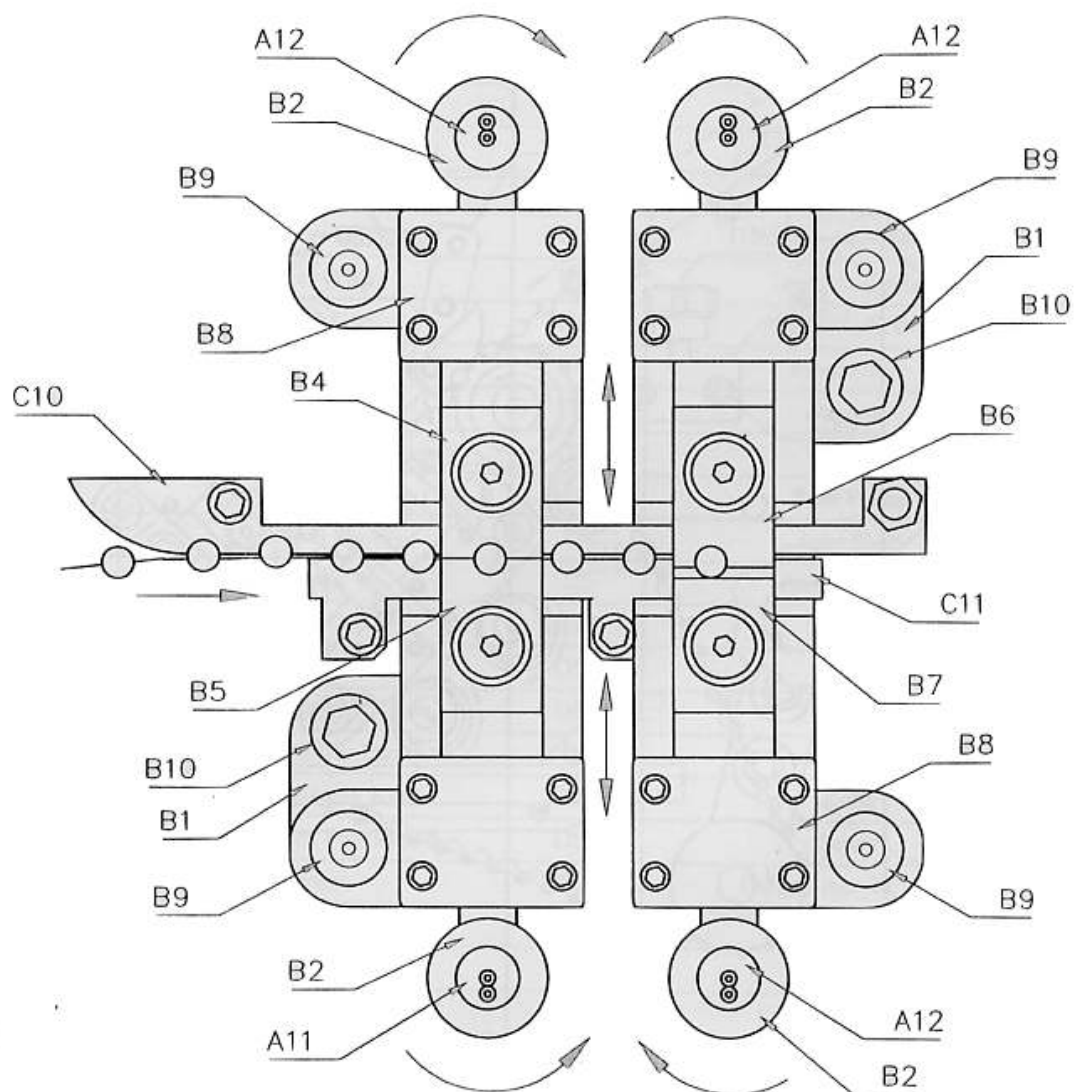
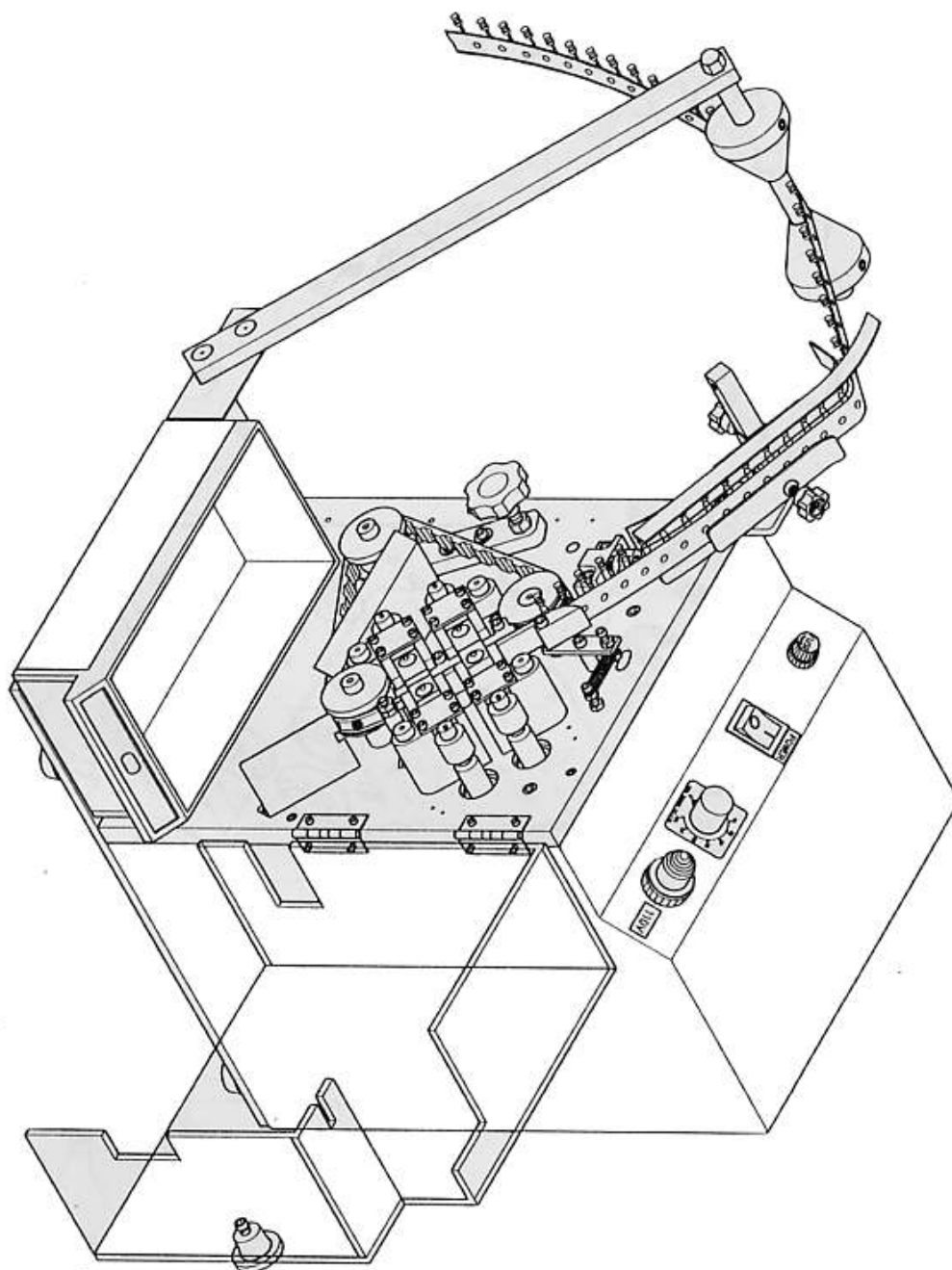


FIG-3



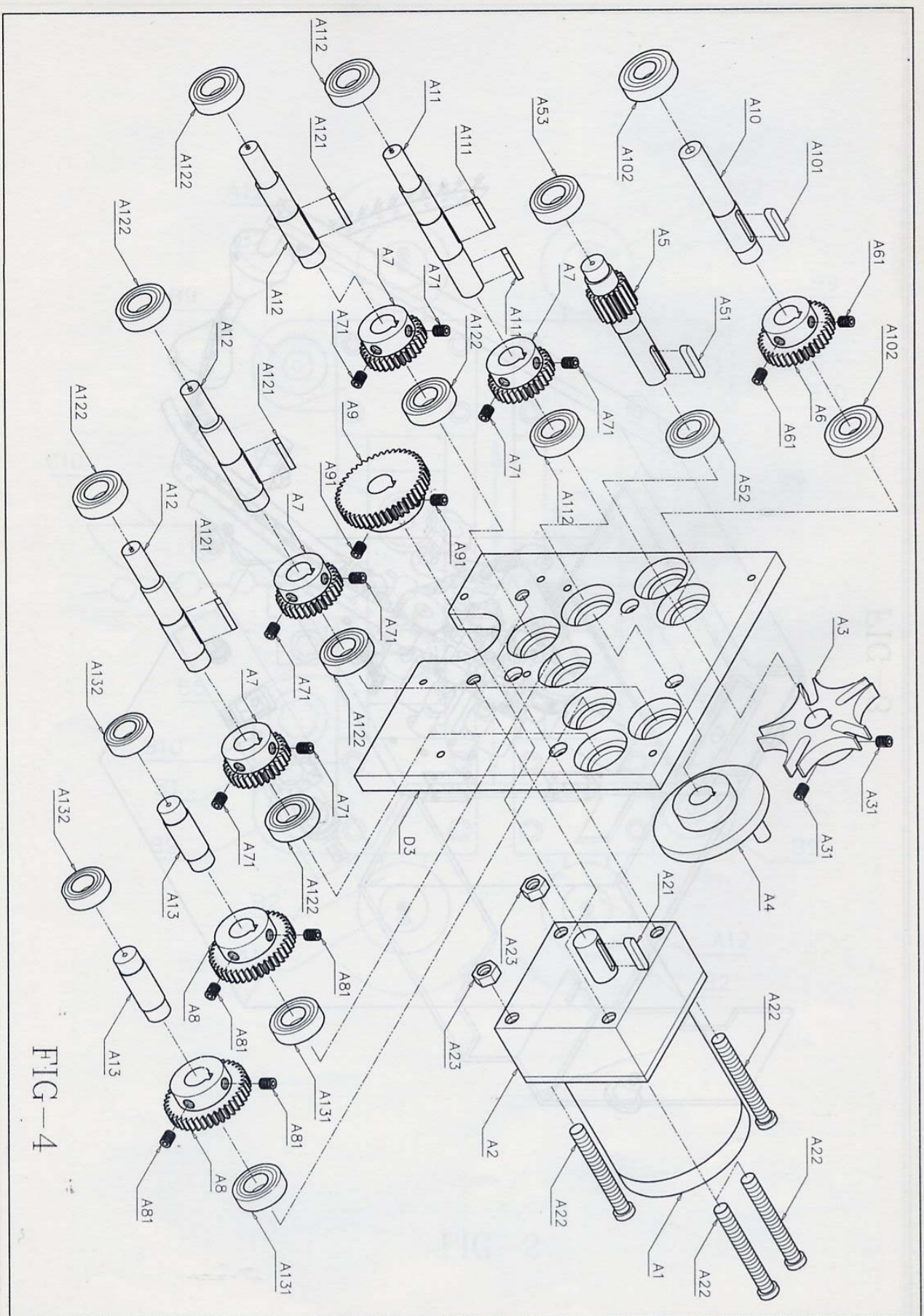


FIG-4

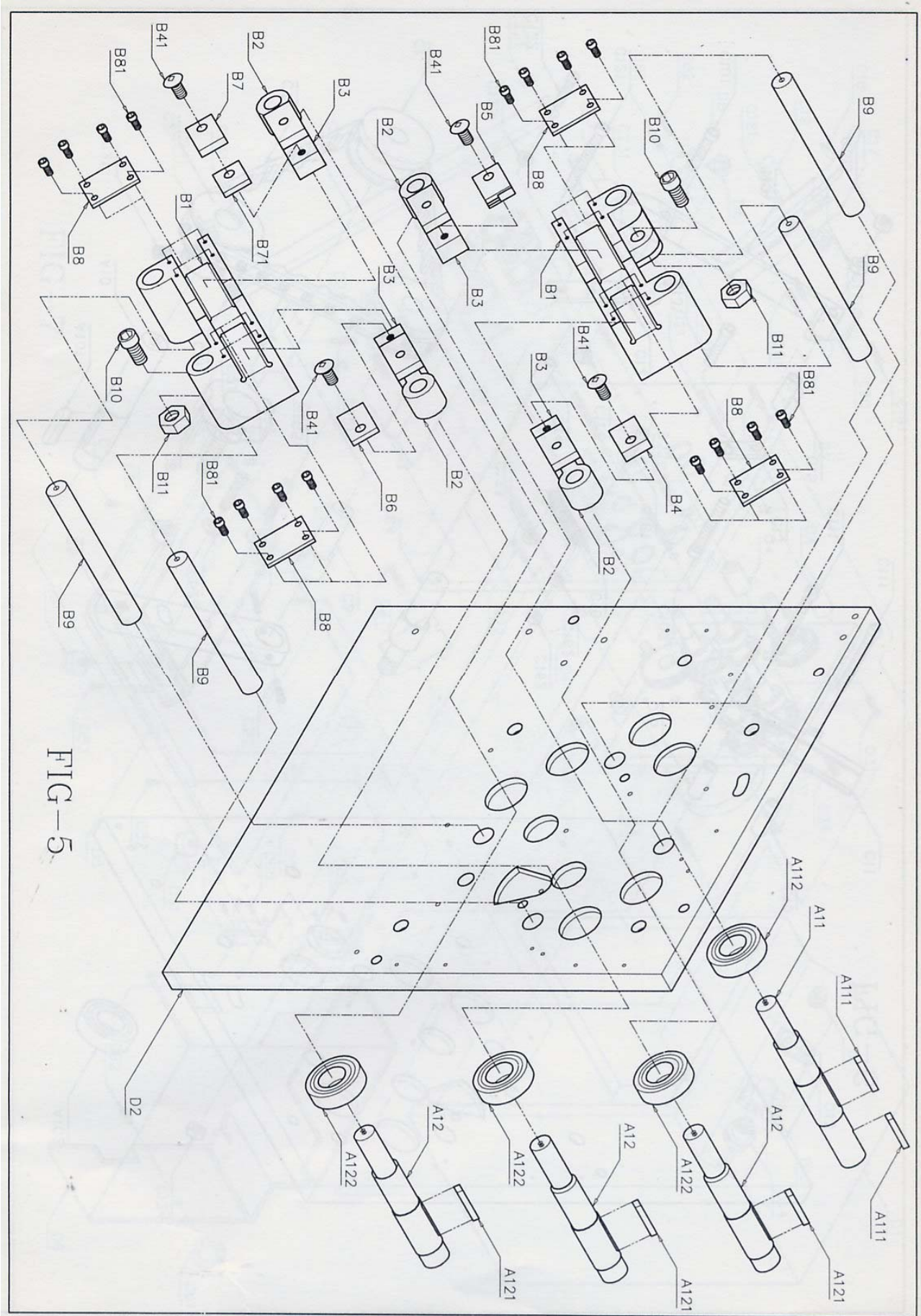
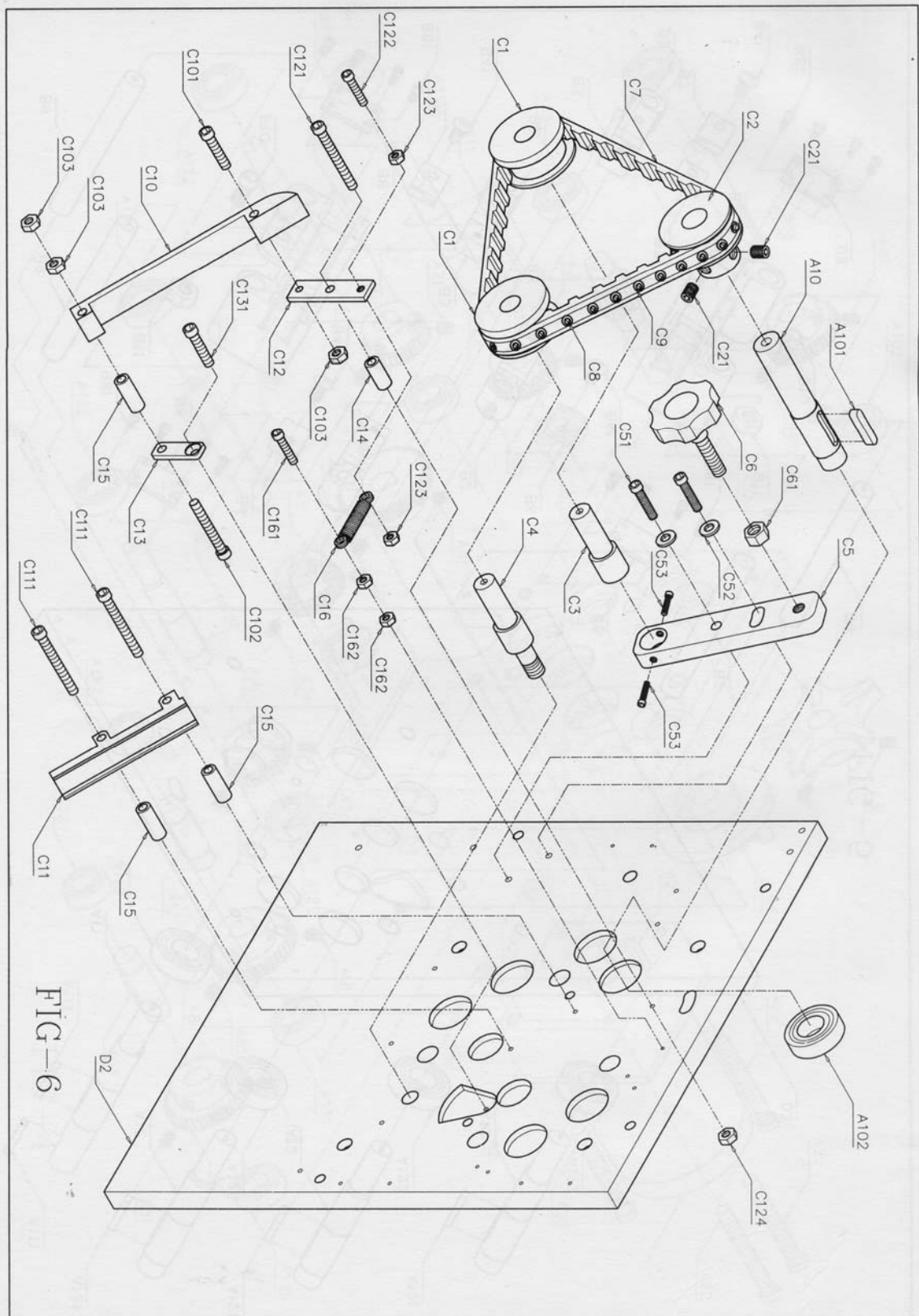


FIG-5



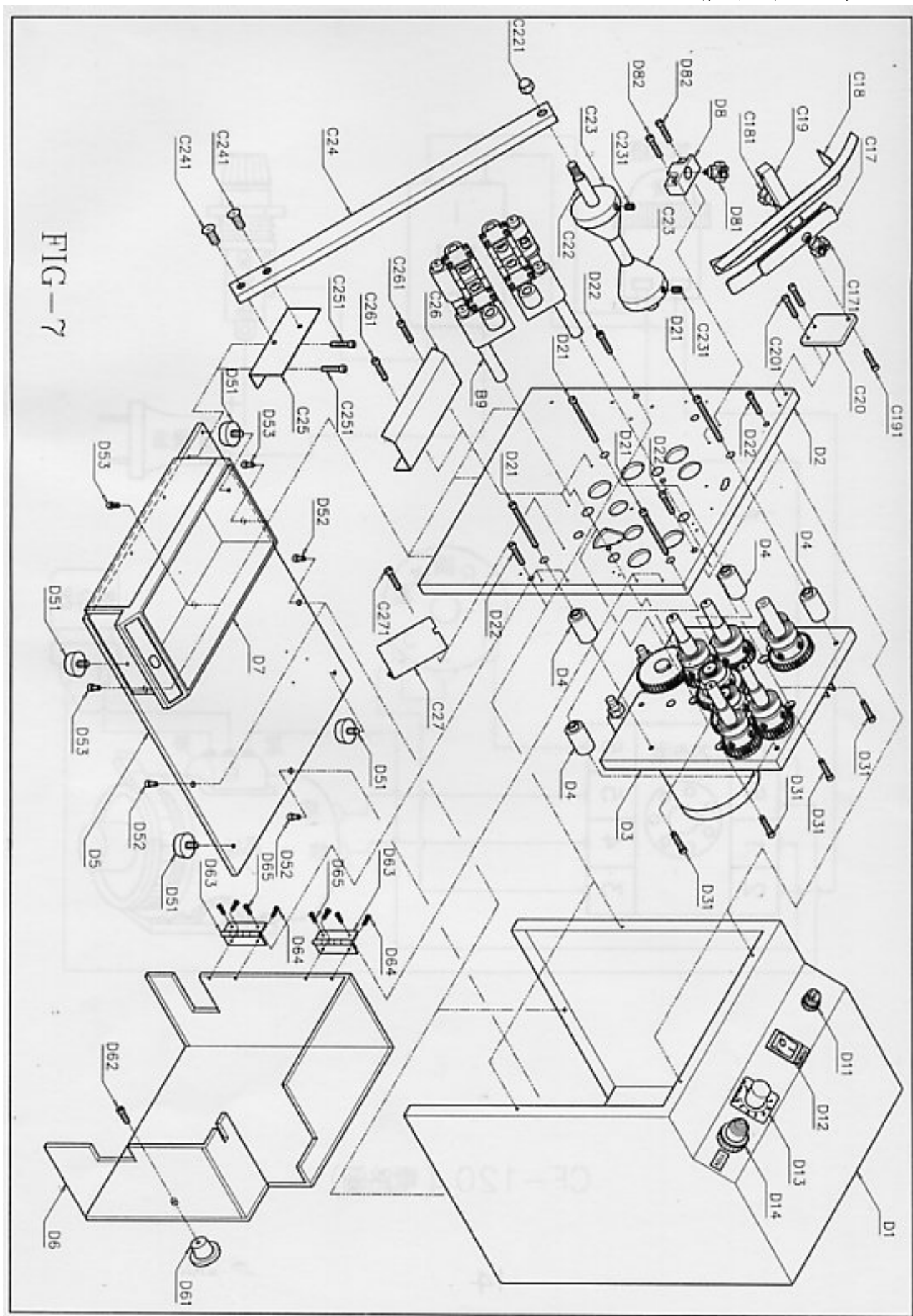
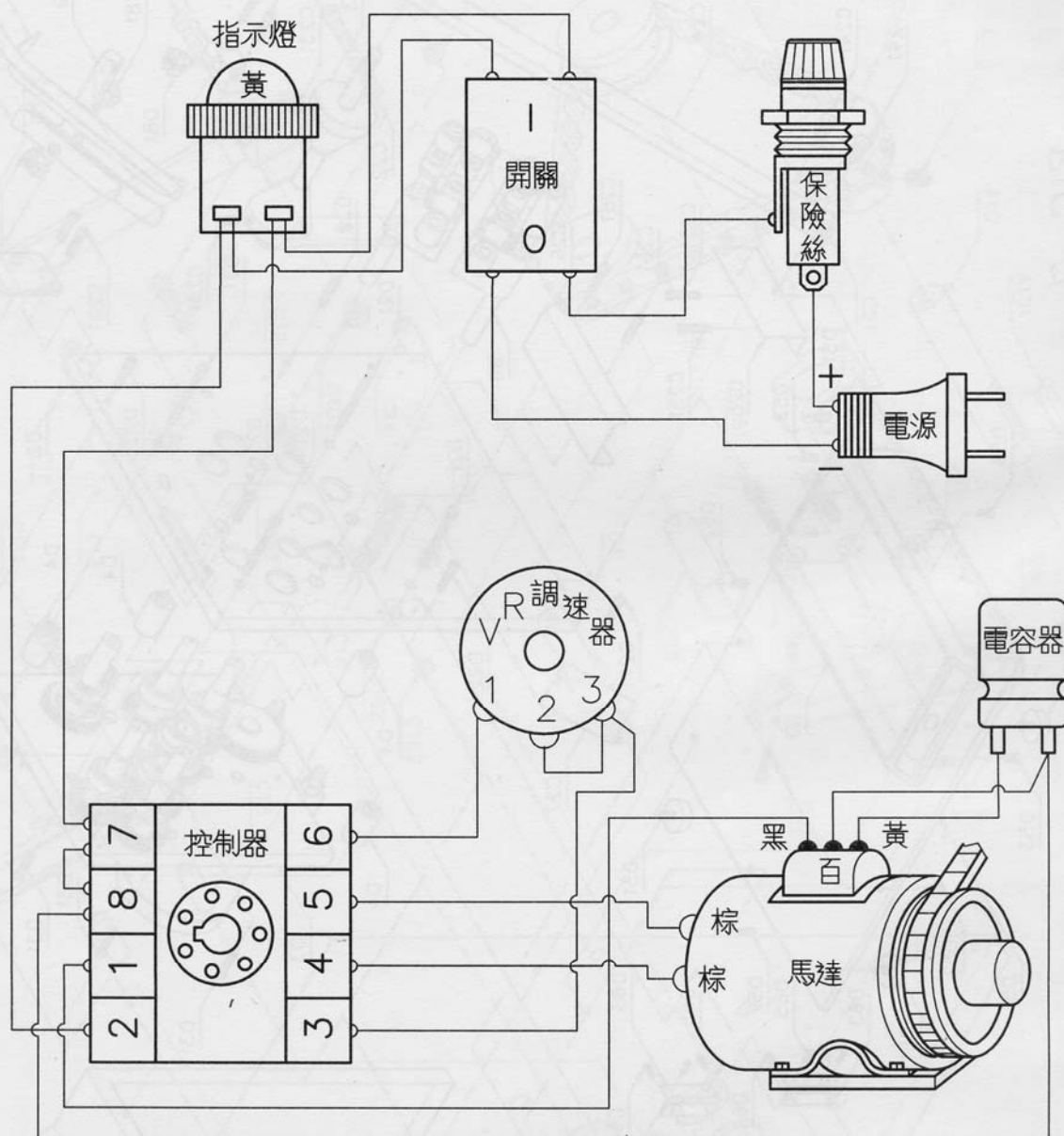


FIG-7



CF-120 (電路圖)