

Shenzhen Southern Machinery Sales and Service Co.,Ltd

SM-101 resistance diode forming machine

Operation and Maintenance Manual



Design, manufacture and sales:

- Electronic components molding machine, electronic components casing machine, electronic components taping machine.
- PCB splitter, screw locking machine, dispensing machine, soldering machine.
- Assembly automation equipment.
- Non standard design and manufacturing automation equipment.
- Address: Rm 1806, Block 3, Jinyun COFCO, Qianjin 2 Road, Xixiang, Baoan District, Shenzhen City.
- Web: [Http://www.smthelp.com](http://www.smthelp.com) E-mail: [E-mai: info@smthelp.com](mailto:info@smthelp.com)

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1.Preface

SM is a powerful electronic equipment company in China, Professional design and manufacture of automation equipment,

The automation equipment developed and produced by our company integrates advanced technology at home and abroad and adopts high-quality imported spare parts, so that the products are at the leading level in the same industry.

2.Outline

Before using the equipment, please read this instruction manual first to avoid some improper operation and accidents, so as to shorten the service life of the equipment

2.1 Please read the manual carefully before using the equipment, and then operate and maintain it on duty;

2.2 Please place this manual at random for long-term use;

2.3 The warranty period of this machine is one year (except for wearing parts). If it can't work normally due to quality reasons within one year, please contact our sales department or after-sales department in time to avoid delaying the production of your company;

2.4 The following conditions are not covered by the warranty

- (1) Damage caused by improper use by users.
- (2) Damage of parts and components caused by self dismantling machine.
- (3) The voltage of the power supply does not meet the requirements.
- (4) Damage caused by force majeure.

3. Structure description

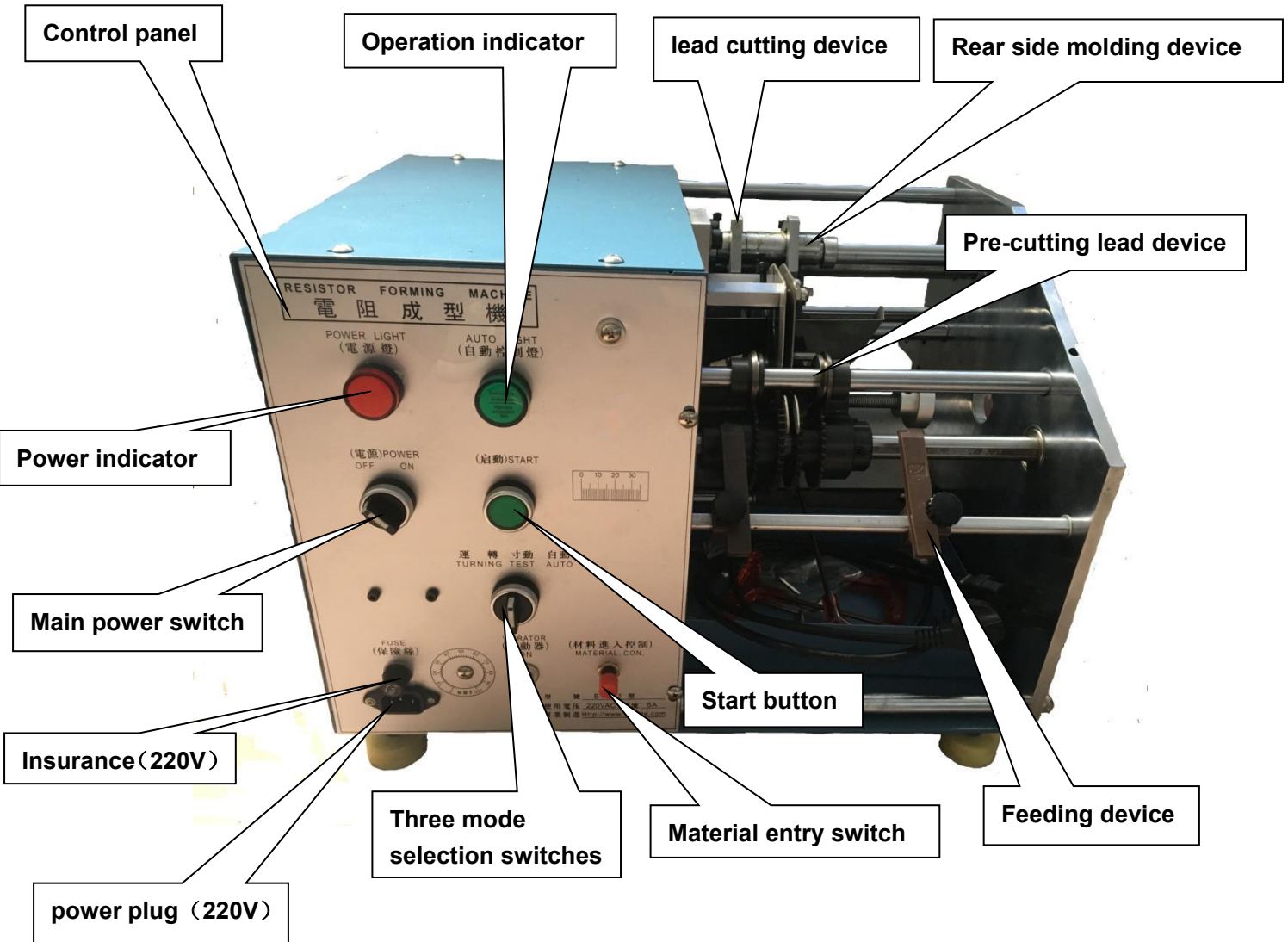


Figure 1

Operation process of the machine:

The braided material enters the equipment through the feeding device → cuts the belt by the pre-cutting foot device → moves from the feeding gear and feeding disk → cuts the material foot to the required size by the cutting foot device → the material is formed into the required shape by the forming device

4.Switch button description

There are three sections of machine working switch:

Automatic: when the switch is turned to the automatic mode, press the start button, the machine will run automatically, and press the stop button, it will stop automatically.

Jog: when the switch is turned to start button in inching mode, the machine will run for a while. It is usually used when adjusting the machine.

Running: when the switch is turned to the running mode, the machine will run immediately. This function is usually applied to the unfinished materials in the automatic mode.

Material entry control is used as an emergency stop in automatic mode.

5.Feeding device

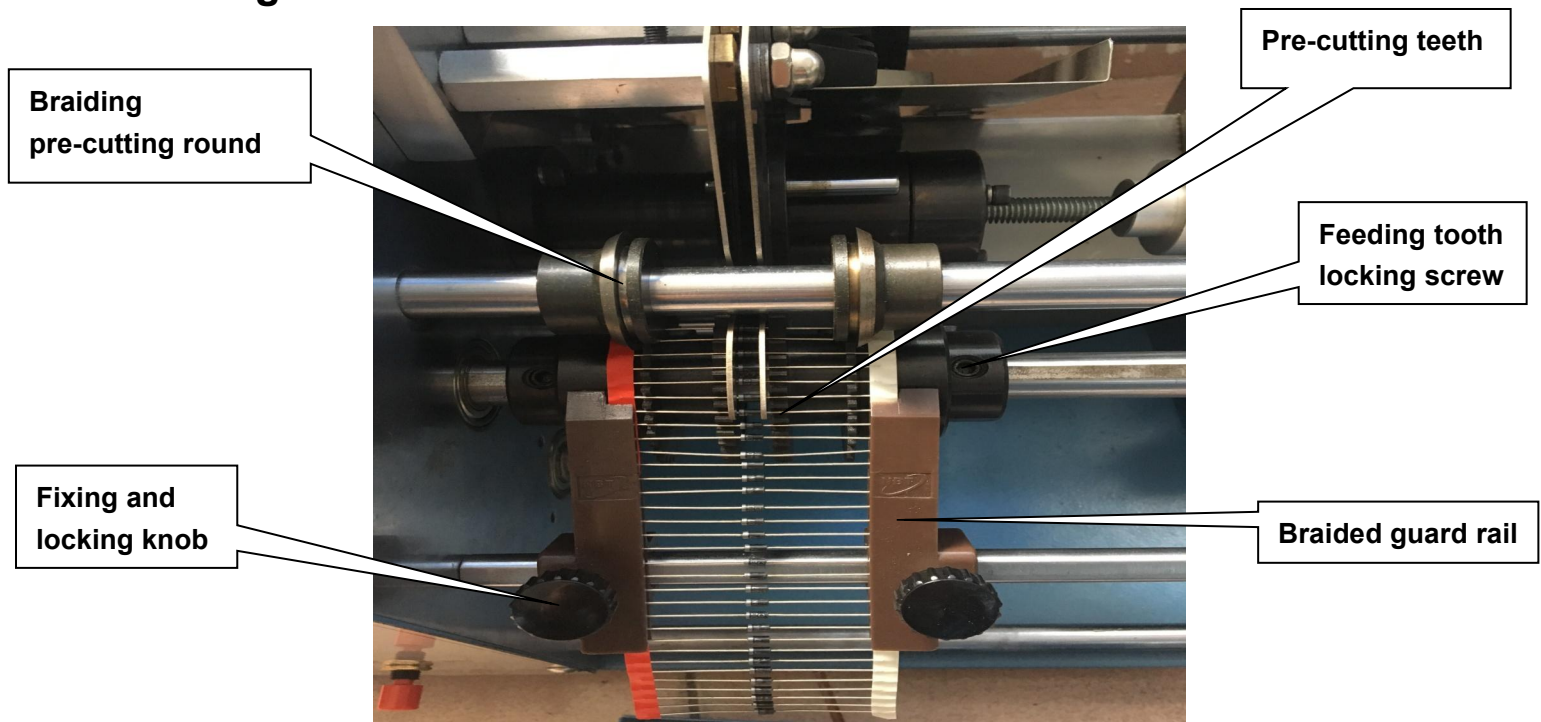


Figure 2

1. Firstly, adjust the width of feeding teeth according to the size of material body. The width adjustment requires that the width of feeding teeth is about 0.5mm larger than that of materials. (especially, the equipment is made up of the fixed surface on the left side of the disc as a reference, and only the right feeding teeth are required for width adjustment).

2. Adjust the position of the braiding guard rail according to the adjusted braiding position, and then lock it by the locking knob of the braiding guard rail.

3. The pre cutting teeth should be adjusted to cut about 5mm away from the braided tape, and the left and right lengths should be consistent as far as possible.

6. Disc adjustment mode

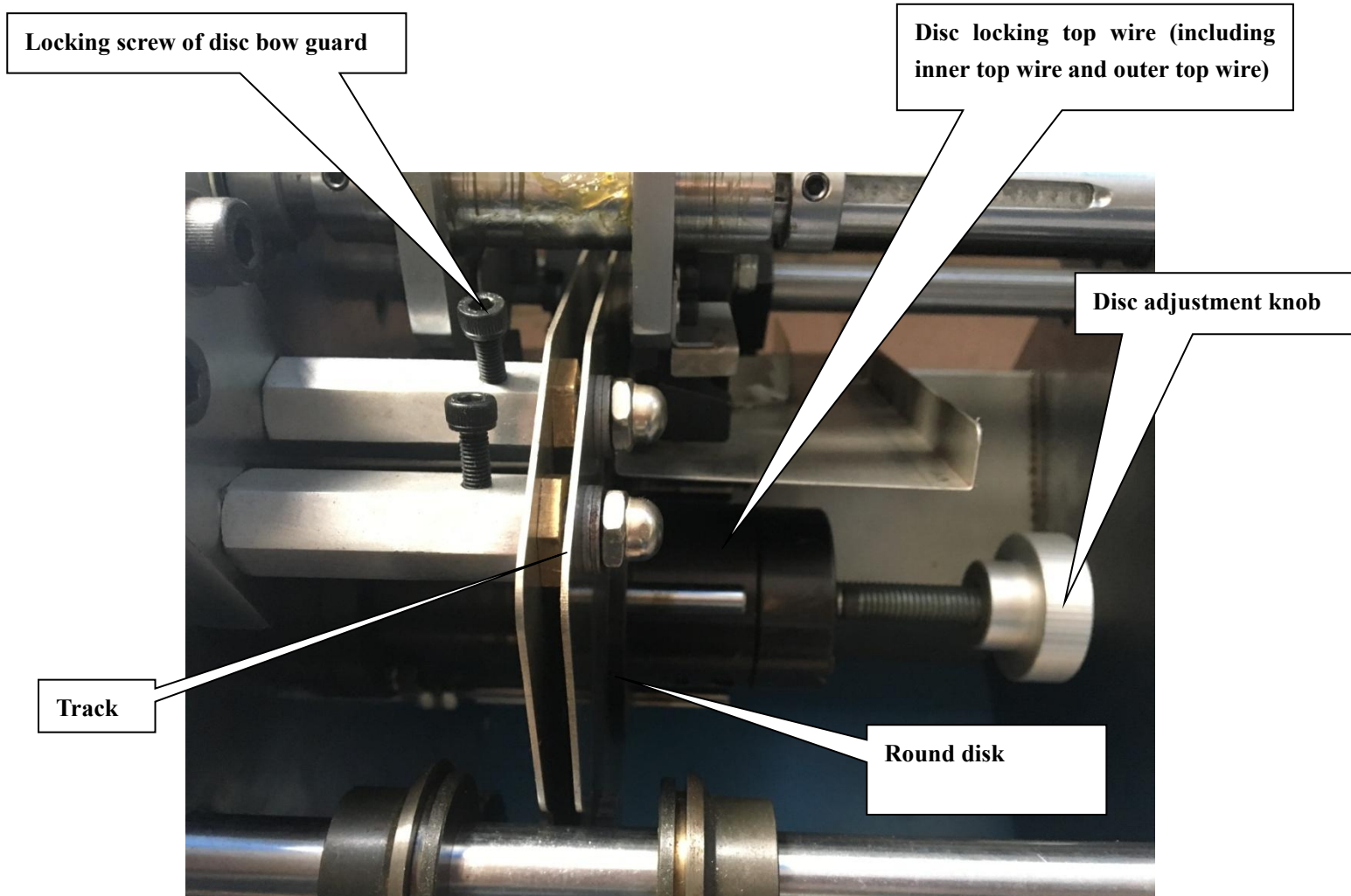


Figure 3

1. First loosen the locking screw of the disc bow, then loosen the locking screw of the disc, and then adjust the width of the inner and outer discs through the disc adjusting knob, so that the disc width is about 0.3mm larger than the material.
2. Then adjust the guard bow, so that the guard bow is directly above the disc, and then lock the lock screw of the guard bow.

7. Instructions for the feeding tray

1. The feeding tray is only responsible for feeding but the stay must be accurate. The feeding tray has synchronous relationship with each mechanism on the machine. If it is displaced due to the card, it is necessary to immediately adjust the original point, otherwise the machine cannot operate.
2. The inner top screw of the disc lock is responsible for fixing on the center of the drive spindle. If there is any displacement, it can be adjusted by this screw.
3. According to the length of the part body, loosen the outer top wire of the disc to adjust the distance of the feeding disc.
4. The forming groove on the feeding tray can be divided into different sizes. If the forming part body is needed, it is not suitable for the standard feeding tray. Please order separately and inform the size of the parts to facilitate production.
5. The feeding tray shall not be damaged. If there is any deformation of the missing angle, the feeding will be not smooth.

8. Special mold use and adjustment

- The forming die base is used to make customized products with special shape. Not every machine has this mechanism. The forming die base can be divided into single kink and double kink.
- The small cam pushes the rear frame rod to impact the axial thread foot in the forming die by the impact die, which completes the forming action of the first foot.
- When the forming lever pulls the other branch leg to a fixed point, the forming knife pushes forward from the large cam to form the second leg.
- For example, move the big cam and small cam to both sides and do not play kink.

9.Parameter of the machine

Project	Parameter
Power input	AC220V±10% 50Hz
Supply current	3A
The cycle time	0.8S~1.0S
Forming die	SKD11
The transmission gear	G45#
Working temperature	-5~+50°C
The altitude	≤1000 米
Relative humidity	≤95%(25°C)
Volume	550*480*400 mm
The weight of the	75kg

10.Maintenance

- Clean up the accumulated dust and sundries inside the equipment regularly, and check whether the connector wiring inside and outside the control box is loose or not in good contact, so as to ensure the normal use of section delivery and prolong its service life;
- Clean the dirt on the mould and worktable regularly;
- Regularly check all fixing screws for looseness;
- Add lubricating oil or butter to the rotating machinery parts regularly.

11. Matters needing attention

- When replacing the mold, the power supply and air source are turned off;
- Do not disassemble or disassemble the moving slider at will;
- Do not knock on motor and mould parts.

12. Troubleshooting

- The whole machine has no power supply after startup:
 - Check whether the external power supply is normal for section delivery;
 - Check whether the fuse is blown and determine whether it is replaced.
- Motor does not rotate:
 - Check whether the control switch button is in good condition, whether the corresponding wiring is loose, and whether the matching starting capacitor is damaged.
- Poor operation:
 - Check whether the fixing screws of each slide guide are loose, which causes the guide rails not parallel;
 - Loosen the fixing screw to detect the single slider, and observe whether there are impurities entering the slider and jamming the slider.