

Shenzhen Southern Machinery Sales and Service Co.,Ltd

SM-306 Automatic bulk components cutting 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.
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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.Features of the machine

3.1 This machine is suitable for mass production and is the best auxiliary equipment for short leg operation.

3.2 The equipment is composed of three parts: the lead shearing machine, the vibrating feeding plate and the supporting trolley; the shearing machine unit and the vibrating feeding plate can be used separately or in combination, so as to increase the use scope of the equipment.

3.3 The vibration feeding tray can realize automatic feeding operation for electrolytic capacitor (3-10 mm, height no more than 16 mm, flat bottom), LED (diameter 3-8 mm), triode, transistor and some safety regulations, ceramic capacitors and other parts; other special-shaped components can also be customized to achieve automatic lead cutting function.

3.4 With special cutting method, the cutter is made of Japanese imported material (SKD11 after special treatment), with long wear resistance and long service life.

3.5 The machine is fully automatic control; automatic state steps: feeding, cutting lead, blanking and feeding Step cycle.

4. Structure description



Figure 1

5.Vibrating Feeder

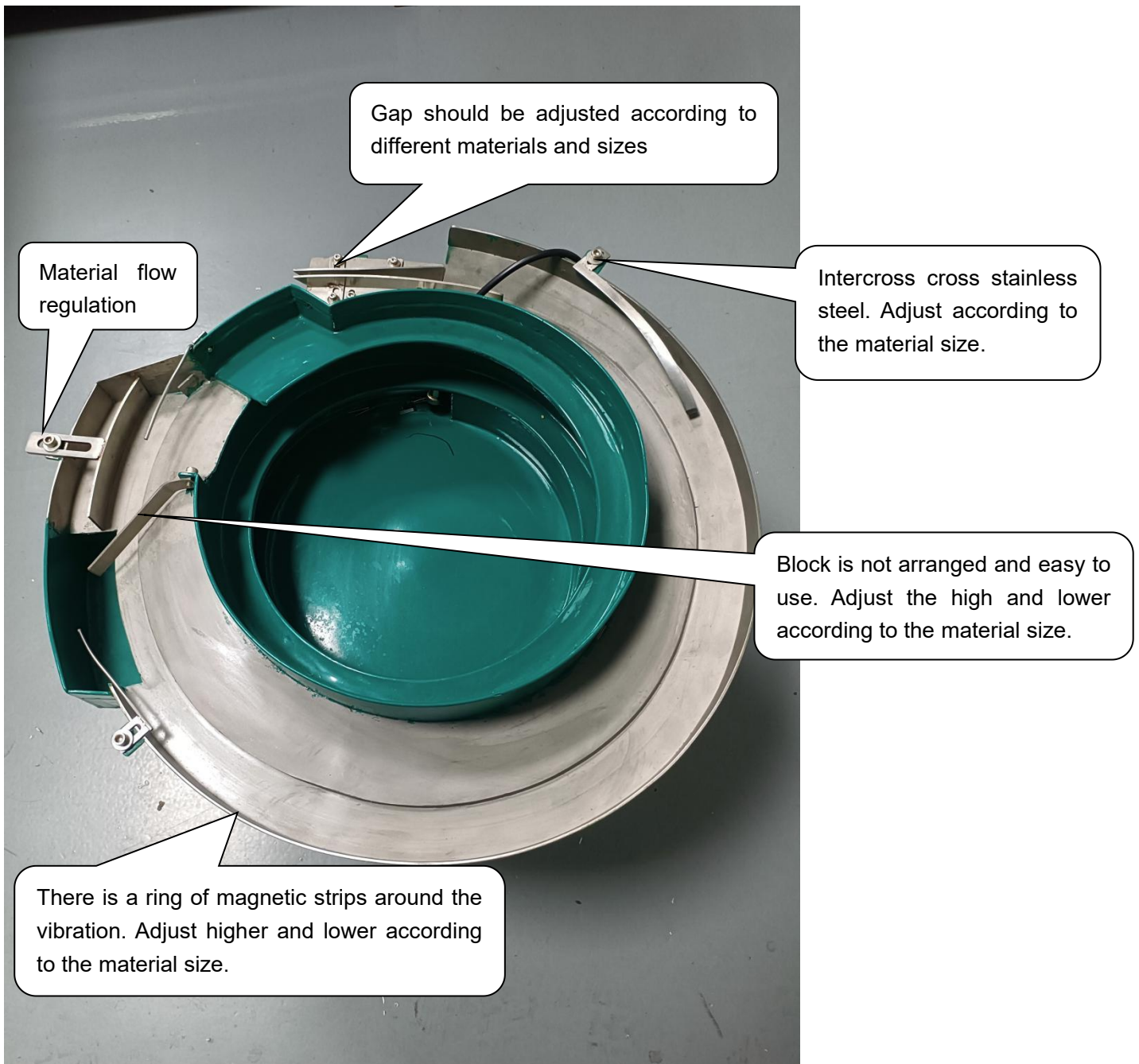


Figure 2

Note: there should be no lubricating oil or antirust agent on the surface of the vibrating plate, otherwise the material will slip.

6.Host

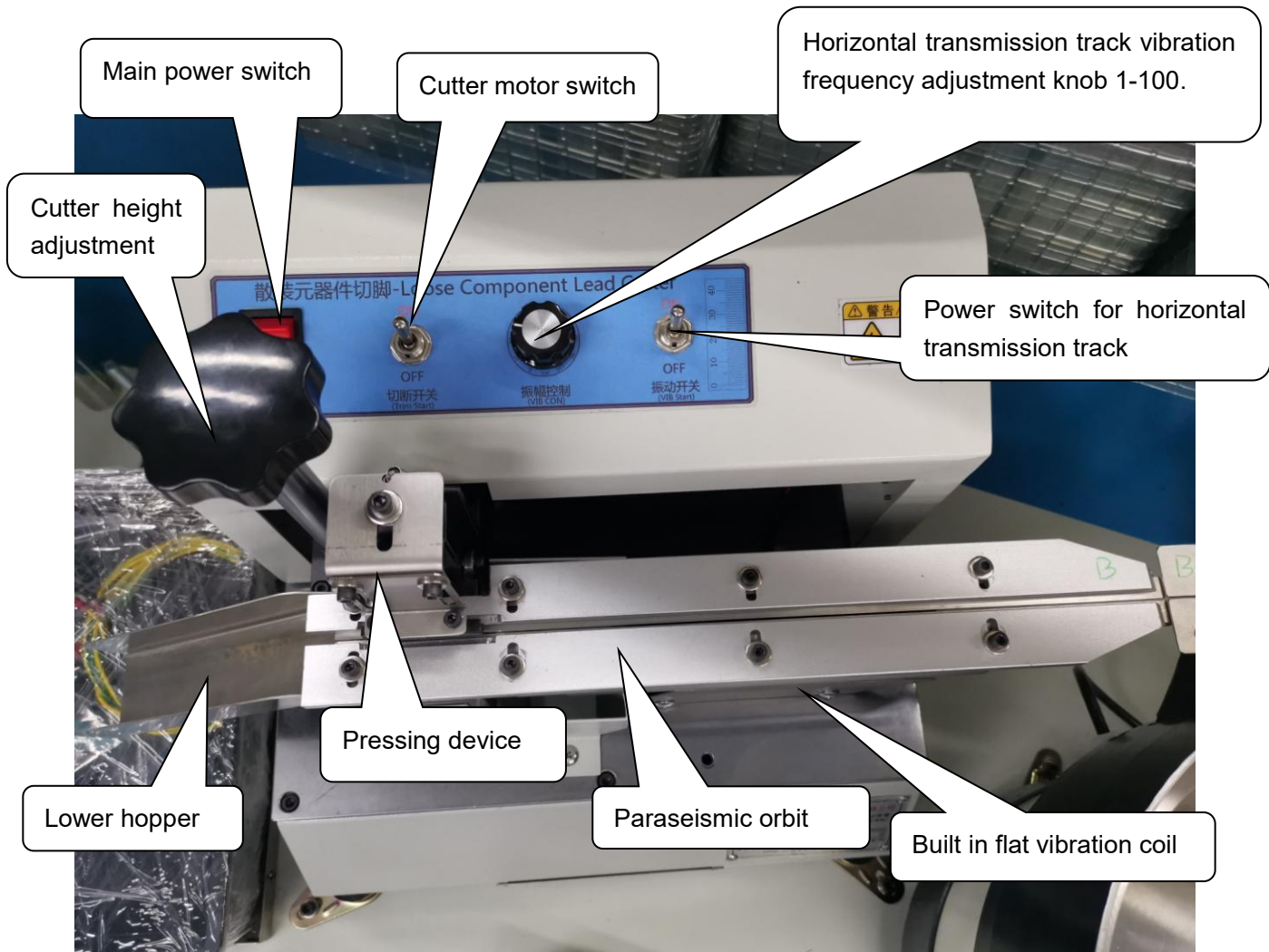


Figure 3

7.Cutter adjustment instructions

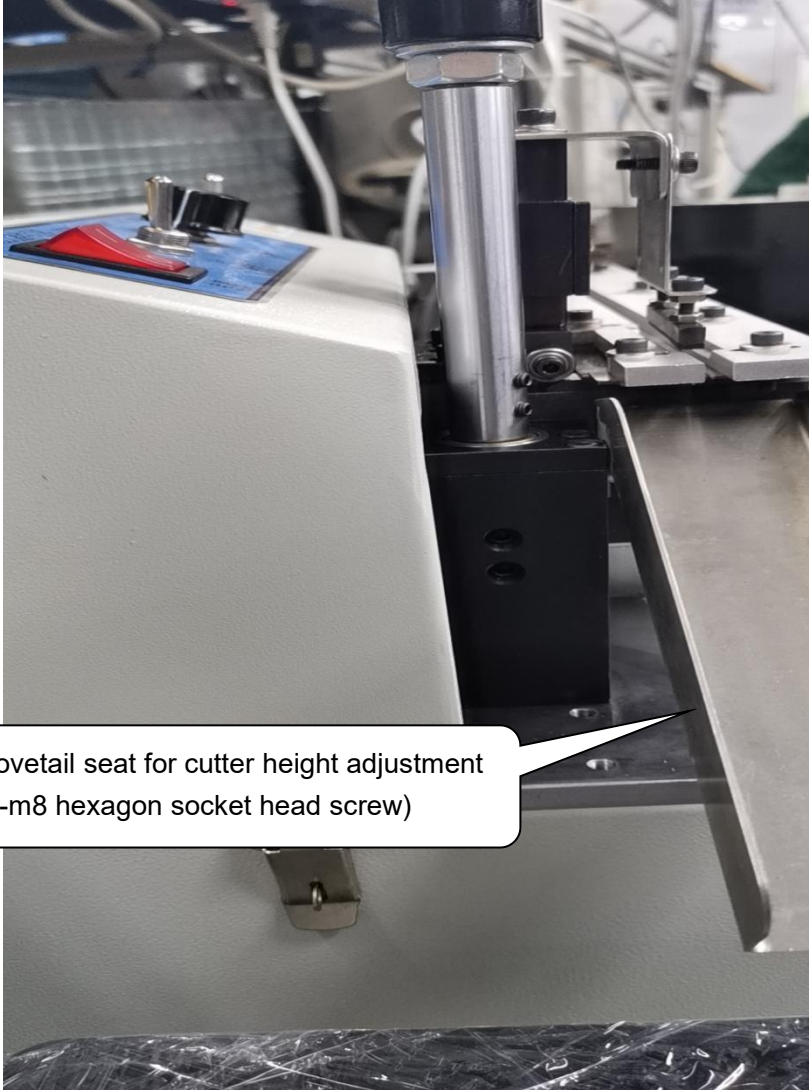


Figure 4

8. Operation process

Use and adjustment of main engine

1. Main power switch: when the power is on, when the switch is turned on, the red device is powered on, and when it is off, the device is powered off.
2. Cutter motor switch: when the switch is set to on, the motor will work, and when it is turned to off, the motor will stop working.
3. Leveling knob: (the premise is to turn on the power switch of the vibration coil of the horizontal motion track) the adjustment switch of the vibration frequency of the flat motion track is usually adjusted to 15 - 20.
4. Flat vibration and vibration panel power switch: when the switch is turned to on, the vibration panel will work, and when it is turned to off, the vibration panel will stop working.
5. Vibration knob: (the premise is to turn on the power switch of the vibration coil and vibration plate of the horizontal transmission track) the frequency adjustment switch of the vibration disk is usually adjusted to 15 - 20.
6. Flat track: according to different materials to adjust the width of the track, generally can pass through a material for the best state.
7. Material pressing device group: it is necessary to adjust the height of the pressure bar of the material pressing device according to the height of the material, so as to prevent the material from shaking, thus affecting the accuracy of the cutting lead

material.

8. Adjustment of cutting lead length: according to the length of the material to be processed, first loosen several jackscrews of 4-M8, then rotate the cutter height knob left and right, adjust to the required size, and then tighten several jackscrews of - M8 (to prevent running).

9.Parameter of the machine

Project	Parameter
Power Supply	AC220V±10% 50Hz
Power of Host and feeder	210W
Supply Current	0.95A
Work Cycle	0.5S~2S
Cutter Die	SKD11
Working Temperature	-5~+50°C
Altitude	≤1000 米
Relative Humidity	≤95%(25°C)
Volume	1100*650*1000 mm
Weight	150 kg

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 to the sliding strip of cutter 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 the flat vibration and mold parts.

Troubleshooting and 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.**
- 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.**