

S7000E Eyelet Insertion Machine Operation Manual



Southern Machinery Sales and Service Co., Limited

Eyelet Insertion Machine Operation Manual

Safety and Points for Attention

Before equipment transportation, installation, operation, warranty and testing, it is necessary to read this operation manual carefully and operate it correctly. After mastering the operating knowledge, safety information and precautions of the equipment, then begin to operate.

Danger: danger caused by improper operation, even accidents resulting in personal injury or death.



Note: due to improper operation resulting in danger, even moderate personal injury or property damage.



1. Operational precautions



HAZARD

As the machine may be in danger of electric shock or encounter, please pay attention to the following matters:

1. The ground wire of the machine must be grounded;
2. Cut off the power when moving the machine and wiring, repairing and testing, and do not operate until the indicator light on the operating panel is completely off, otherwise there will be electric shock risk;
3. In the case of cable skin falling off, excessive external force pulling, heavy weight squeezing,

etc., there will be the risk of electric shock;

4. During the operation of the machine, do not touch the operating table, otherwise there will be the risk of bruising.

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ATTENTION

1. When replacing parts, the parts specified and consistent with the machine must be used, otherwise the machine may fail;
2. It is forbidden to use in the vicinity of water, corrosive substances, flammable gases and inflammable substances;
3. Do not put all kinds of items on the machine, it will cause danger;
4. This machine has a laser sensor device, in the case of maintenance, do not look directly with the naked eye, otherwise there will be the risk of blindness;
5. When the machine is switched off and restarted, it must be kept for 5~10 seconds, otherwise the internal circuit of the machine cannot be fully initialized, which may lead to the failure of normal operation of the machine.

2. CARRY



ATTENTION

1. When handling, the working table must be fixed first;
2. When handling, be careful not to have violent impact action, otherwise the machine may be damaged;
3. Please use forklift when handling, do not move violently.

3. INSTALL



ATTENTION

1. Ensure that the machine is set in a horizontal state, or it will cause machine failure;
2. The machine cannot be strongly impacted, otherwise it will cause machine failure;
3. Ensure the power in a normal state, avoid electric shock, fire;
4. Ensure the pressure of the input air, otherwise it may cause instability of the insertion operation.

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4. OPERATE



ATTENTION

1. Please read this operation manual carefully before operating the machine, otherwise the machine will break down due to the error of operation;
2. When the machine has a fault, first clear the cause of the fault, to ensure safety before restarting;
3. Restart the machine immediately after the power is cut off, it is easy to cause serious machine failure, so be sure to wait for the machine to all the remaining power after the restart;
4. Even if the server is in a power off state, high voltage will be generated at the moment the current flows in or the power is cut off. Do not touch at this time;
5. Be sure to turn off the power when not in use for a long time.

5. MAINTENANCE AND TESTING



ATTENTION

1. Plugs and workstations are prone to damage due to faulty operation, so be careful when operating;
2. When testing the energized part, the power must be cut off first;
3. Pay attention to the connection of base, computer and other connection plug-ins;
4. When correcting the parameters of the servo driver, it is important to pay attention to what might happen

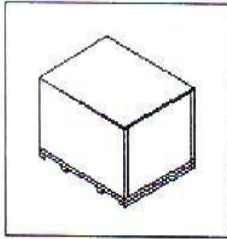


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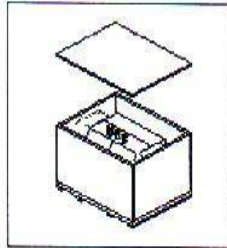
1. Do not disassemble or repair the servo drive and servo engine. In case of failure, repair by the manufacturer.

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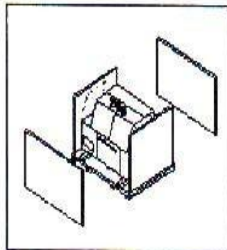
Packing disassembly sequence



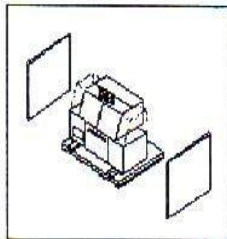
1. Place the machine in a flat, wide area



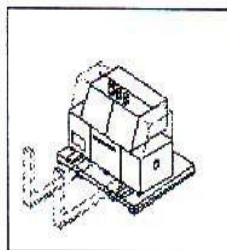
2. Open the packing cover on the upper end of the machine. Do not hit the tool hard and do not insert the tool too deeply. Be careful not to drop the upper packing board.



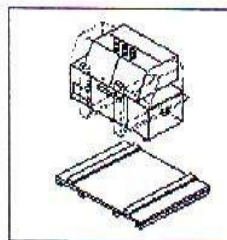
3. Remove front and back packaging panels



4. Remove the left and right side of the packaging sheet



5. Use a forklift to lift the machine from the middle of the front bottom of the machine. The weight of the machine is concentrated in the front, so be sure to lift the machine from the front.



6. Remove the packing sheet at the bottom while the machine is lifted, and remove the vacuum packing of the machine.

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Part 2 General introduction

1. SYNOPSIS

This device is used to automatically insert various special electronic components on the circuit board and It has the function of strengthening its adhesion strength.

It is forbidden to modify, disassemble or use the product for other purposes.

2. Introduction to Equipment data

- External dimension (MM):1400 width *1920 length *1580 height
- Weight:950KG
- Pressure:5.5±0.5Kg
- Voltage: 220V single 60HZ 1KW
- noise: 80 dB
- TABLE production range: 480MM*330MM
- Plug-in speed: 0.35Sec / EA
- PCB transfer speed: 4 /S
- control system: PLC control
- feeder system: vibration feed
- acquisition of coordinate data: E3Z-LT61 Laser automatic correction
- X Y motor : Mitsubishi MR-J4-40A servo system
- viewing screen: MT8121IE touch screen

3. Equipment startup process description

- 1» Turn on the air source and confirm the air pressure is $5.5\text{KG}\pm 0.5\text{KG}$;
- 2» Confirm that the main power supply is on at 220V, and turn the equipment main power switch 90 degrees counterclockwise;
- 3» Wait for the touch screen to start, and then return to the mechanical origin manually after the device self-test passes;
- 4» The origin is restored and the device is in standby state;

Introduction to the function of tri-color lamp

Green Equipment normal

Yellow ready mode

RED Bad insertion and equipment, please check the fault bar error message

Part2 Composition of the system

1. NC Program information

1》 NC X Y Coordinates and marked positions

2》 XY Specification work head selection

Program editing 01-

X: 0.00 Y: 0.00

OFFSET_X: 0.00 OFFSET_Y: 0.00

NO	position	X	Y	HEAD	Coding no
1		0.00	0.00	NOP	0
2		0.00	0.00	NOP	0
3		0.00	0.00	NOP	0
4		0.00	0.00	NOP	0
5		0.00	0.00	NOP	0
6		0.00	0.00	NOP	0
7		0.00	0.00	NOP	0
8		0.00	0.00	NOP	0
9		0.00	0.00	NOP	0
10		0.00	0.00	NOP	0

Teach

INS DEL




Insert position marking, manually enter the Numbers and letters on the touch keyboard, and press ENT to

Insert the X and Y coordinates. The data can be entered manually and visually. The data should not be larger than the workbench production

This item has INS 1-4 header selection, NOP means white space is meaningless, and END means the END of the program

3》 OFFSET

1. Enter standard compensation values as shown below.
2. If there is any deviation, input compensation value correction.

 EN
 **Note** Align parameters setting is wrong, it may damage the machine or print just after adjusting the sensor or replace the stencil you need to change
TABLE move


X: 0.00
Y: 0.00

HEAD compensation settir

	X compensation	Y compensation
HEAD1	105.00	0.00
HEAD2	35.00	0.00
HEAD3	-35.00	0.00
HEAD4	-105.00	0.00

Align parameters

Align Radius (MM)

Align speed (%)

Align move delay (S)

Code
test

ink
jet

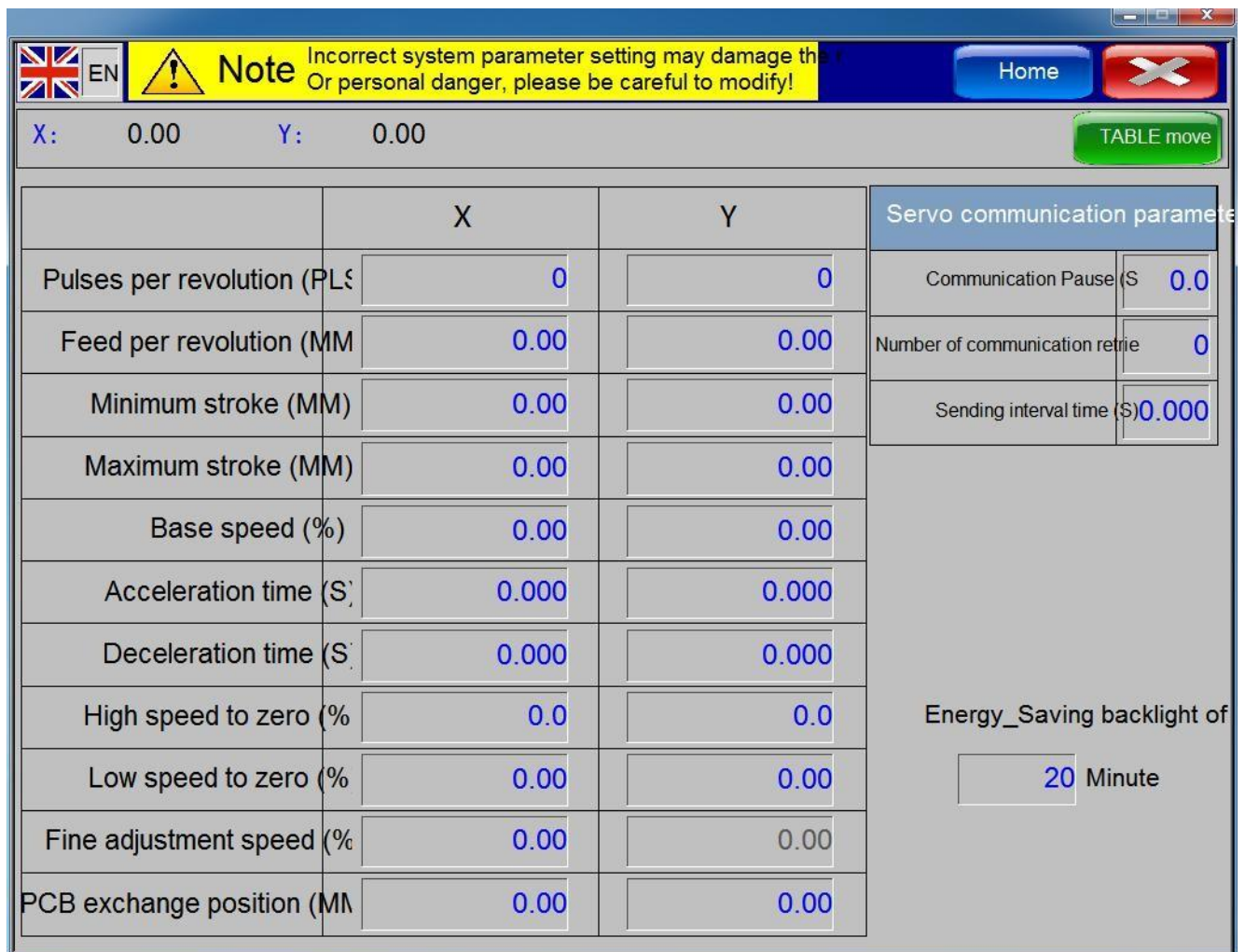
2. System procedures and system parameters

1. Equipment program is mainly written by Panasonic PLC man-machine dialogue, according to the maintenance and maintenance of the most brief method to develop the operation of the key surface, so as to improve production and maintenance to improve work efficiency.

2. basic parameter setting of system

Enter the system parameters from the main menu of the device, and the factory value password parameter is "2".

System parameter data setting mode: manually input, click to change the parameter input;



	X	Y	Servo communication parameters	
Pulses per revolution (PLS)	0	0	Communication Pause (S)	0.0
Feed per revolution (MM)	0.00	0.00	Number of communication retrie	0
Minimum stroke (MM)	0.00	0.00	Sending interval time (S)	0.000
Maximum stroke (MM)	0.00	0.00	Energy_Saving backlight of 20 Minute	
Base speed (%)	0.00	0.00		
Acceleration time (S)	0.000	0.000		
Deceleration time (S)	0.000	0.000		
High speed to zero (%)	0.0	0.0		
Low speed to zero (%)	0.00	0.00		
Fine adjustment speed (%)	0.00	0.00		
PCB exchange position (MM)	0.00	0.00		

Operating panel switch key

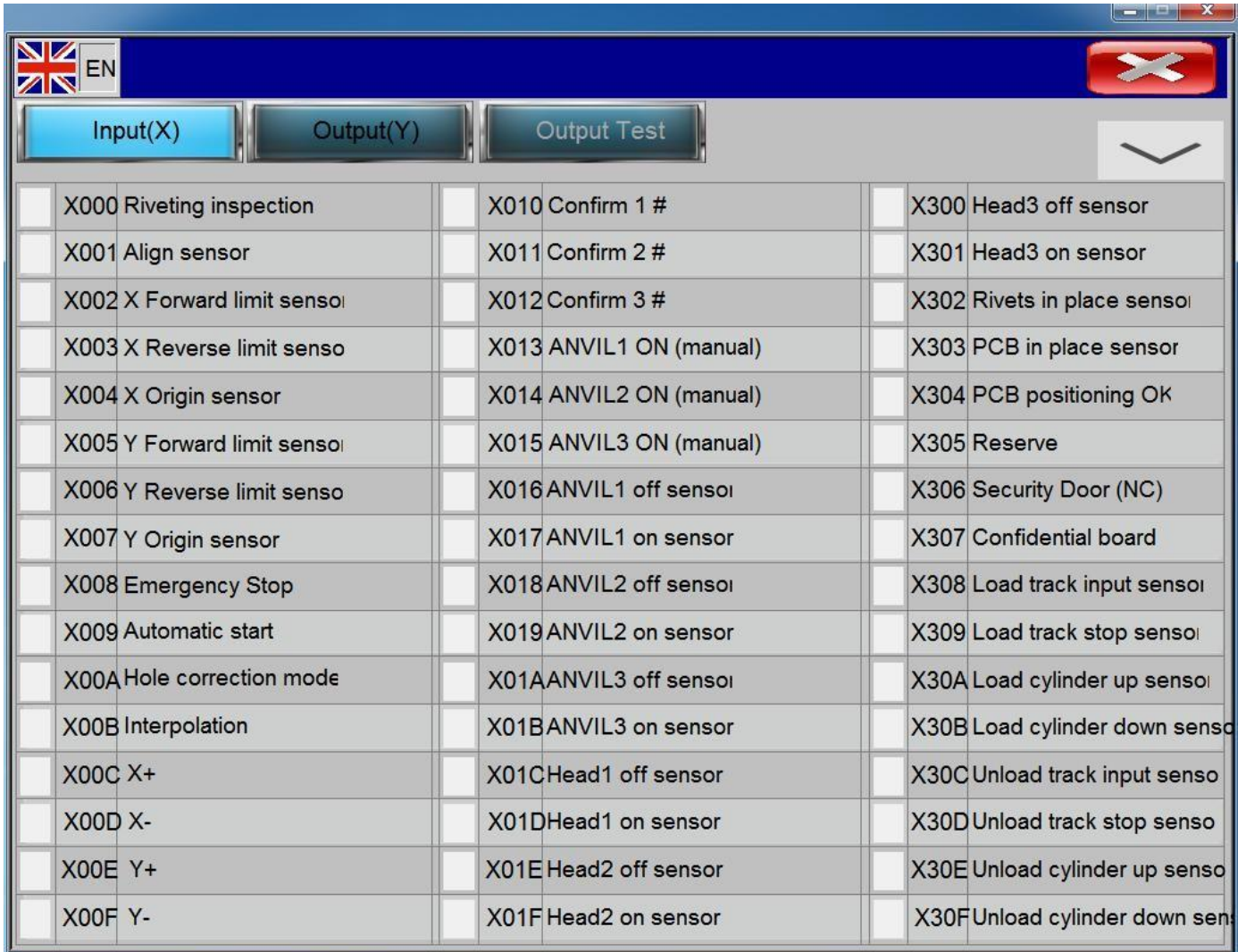
1. START The machine begins to execute the command
2. RECOVERY Completes the current location repair
3. CONTINUOUS Machine continuous production mode, to achieve continuous production
4. SINGLE STEP Complete a step action in NC program
5. EMERGENCY STOP In an emergency, pressing the button will stop the device
6. SERVO Servo motor lock and release mode switch
7. ANVIL1 1#Bottom nose up
8. ANVIL2 2#Bottom nose up
9. ANVIL3 3#Bottom nose up
10. ANVIL3 4#Bottom nose up
11. HEAD1 1# coordinate memory
12. HEAD2 2# coordinate memory
13. HEAD3 3# coordinate memory
14. HEAD4 4# coordinate memory
15. X+ X axis + directional move
16. X- X axis - directional move
17. Y+ Y axis + directional move
18. Y- Y axis - directional move

Part3 Program copy

Instructions for program saving and import

Enter the USB partition menu, insert the USB mobile disk, click the steps executed, wait for the host to show that the operation has been completed, execute the copy OK.

Part4 Reference table for signal code



Input(X)	Output(Y)	Output Test
X000 Riveting inspection	X010 Confirm 1 #	X300 Head3 off sensor
X001 Align sensor	X011 Confirm 2 #	X301 Head3 on sensor
X002 X Forward limit sensor	X012 Confirm 3 #	X302 Rivets in place sensor
X003 X Reverse limit sensor	X013 ANVIL1 ON (manual)	X303 PCB in place sensor
X004 X Origin sensor	X014 ANVIL2 ON (manual)	X304 PCB positioning OK
X005 Y Forward limit sensor	X015 ANVIL3 ON (manual)	X305 Reserve
X006 Y Reverse limit sensor	X016 ANVIL1 off sensor	X306 Security Door (NC)
X007 Y Origin sensor	X017 ANVIL1 on sensor	X307 Confidential board
X008 Emergency Stop	X018 ANVIL2 off sensor	X308 Load track input sensor
X009 Automatic start	X019 ANVIL2 on sensor	X309 Load track stop sensor
X00A Hole correction mode	X01A ANVIL3 off sensor	X30A Load cylinder up sensor
X00B Interpolation	X01B ANVIL3 on sensor	X30B Load cylinder down sensor
X00C X+	X01C Head1 off sensor	X30C Unload track input sensor
X00D X-	X01D Head1 on sensor	X30D Unload track stop sensor
X00E Y+	X01E Head2 off sensor	X30E Unload cylinder up sensor
X00F Y-	X01F Head2 on sensor	X30F Unload cylinder down sensor

Part4 program edit

1. NC program editing

1》 Press "Clear" on the main screen of production and the device will prompt "Whether to return to the intersecting board position". Click confirm and wait for X and Y to return to the intersecting board position

2》 After the origin is completed, press "Manual" to enter the manual mode

3》 Click "File" in the menu bar of production screen. After the file menu is opened, please select the object program to be edited by clicking up and down. When the cursor is moved to the selected file, you can directly click to change the name of the program, and press "ENT" to archive

4》 Click "Edit" on the menu bar at the bottom of the screen and wait for the program to open and complete

5》 The selected program is now set to an execution file

Note: When selecting a program as a new program, the program data must be "0". If it is a conversion program, follow the above steps.



6》 Enter the "edit" screen, select "Single cycle" and manually switch the "Check hole" key to light, and then press the "Start" key to light, and the "Normal operation" is displayed in the lower right corner of the screen.

7》 Get X Y information coordinates

1. Manually press the up, down, or left buttons to move the table, make the laser beam pass through the jack on the circuit board, and confirm the HEAD working HEAD

2. Automatically get X and Y coordinates and
automatically input

8» After confirming the memory coordinates, the display shows 'correct OK' before remembering the next coordinate

9» If the laser position finder beam does not pass through the jack screen on the circuit board, the "correction NG" will be displayed. The X and Y coordinates need to be obtained by manually pressing the up, down, or left or right buttons for confirmation

After the HEAD HEAD clicks 'retry' on the screen, the laser position finder will work normally. After normal work, the screen will display 'correct OK'.



X: 0.00 Y: 0.00
 OFFSET_X: 0.00 OFFSET_Y: 0.00

NO	position	X	Y	HEAD	Coding no
1		0.00	0.00	NOP	0
2		0.00	0.00	1#HEAD	0
3		0.00	0.00	2#HEAD	0
4		0.00	0.00	3#HEAD	0
5		0.00	0.00	4#HEAD	0
6		0.00	0.00	END	0
7		0.00	0.00	NOP	0
8		0.00	0.00	NOP	0
9		0.00	0.00	NOP	0
10		0.00	0.00	NOP	0

INS DEL

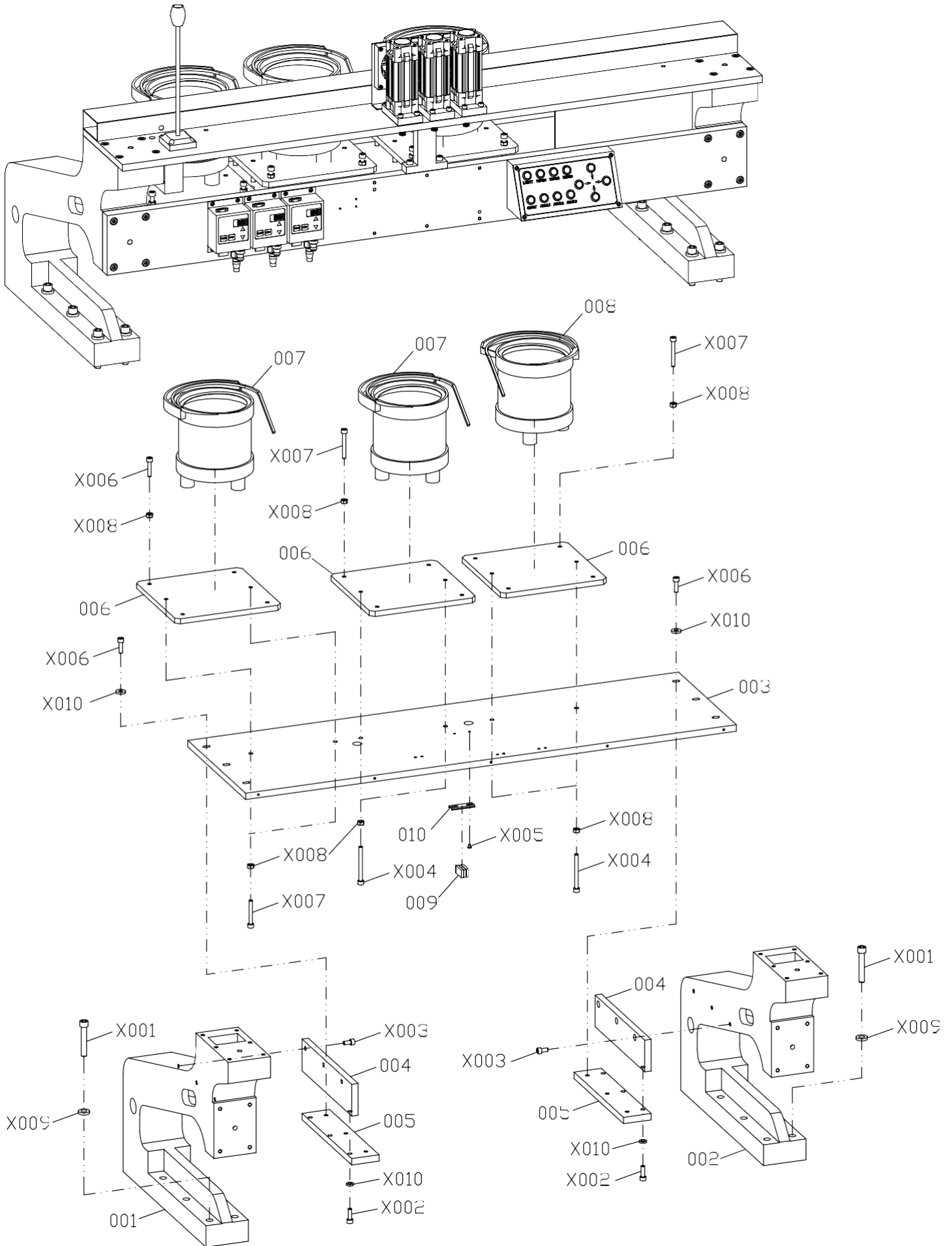
11» Click the triangle drop down menu in the "HEAD" bar of the worksheet, select "END", and press save

After saving, it will exit automatically. Press the "Clear" button to confirm returning to the intersection position.;

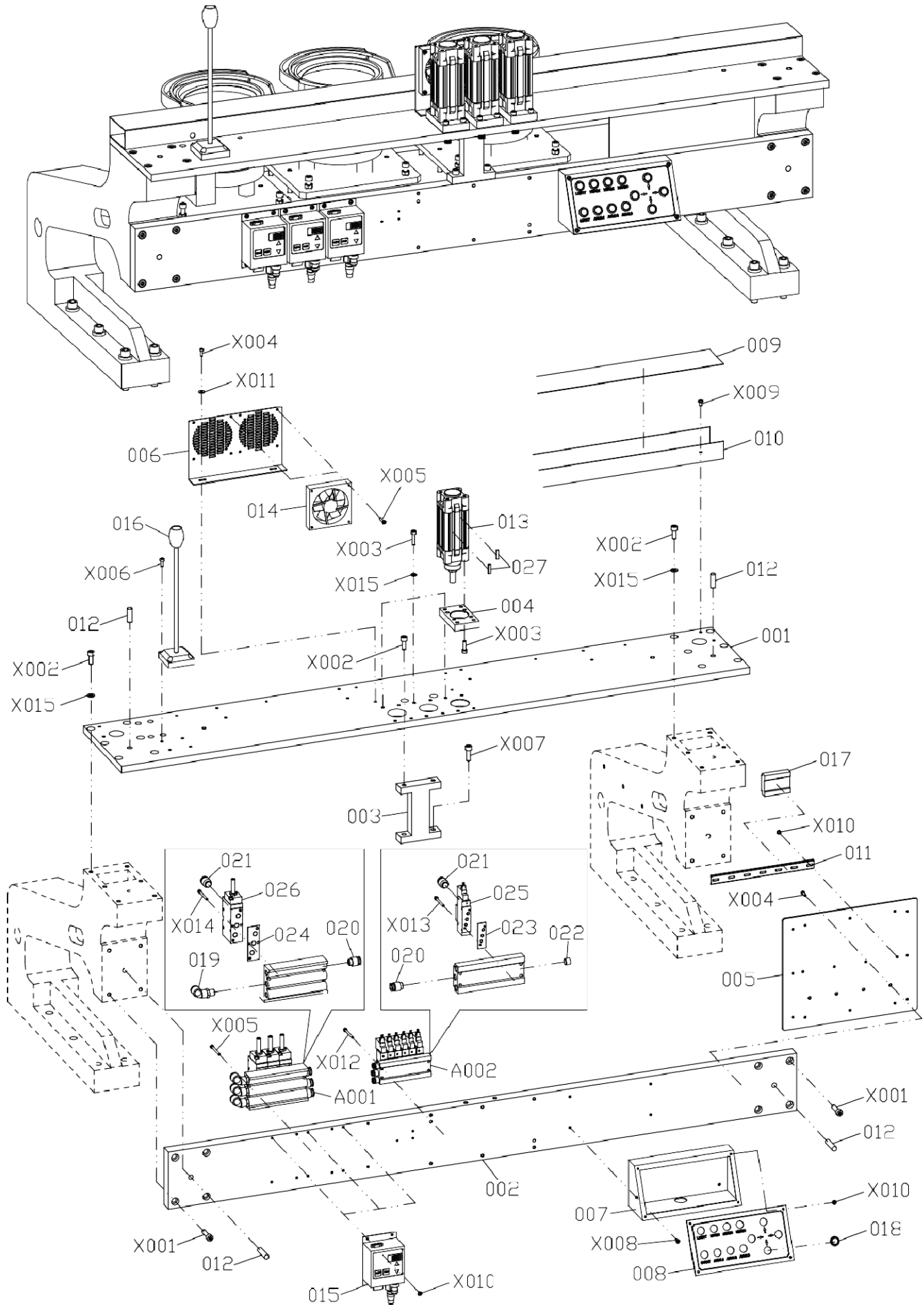
12 » Select the "single cycle" mode, press the "check hole" button and then press the "Start" button to automatically check the hole after completion of the new program, make OK.

13» According to the confirmation of X and Y coordinates, the first piece production is fully automatic.

1 MAIN BODY SECT.-1



1 MAIN BODY SECT. 2

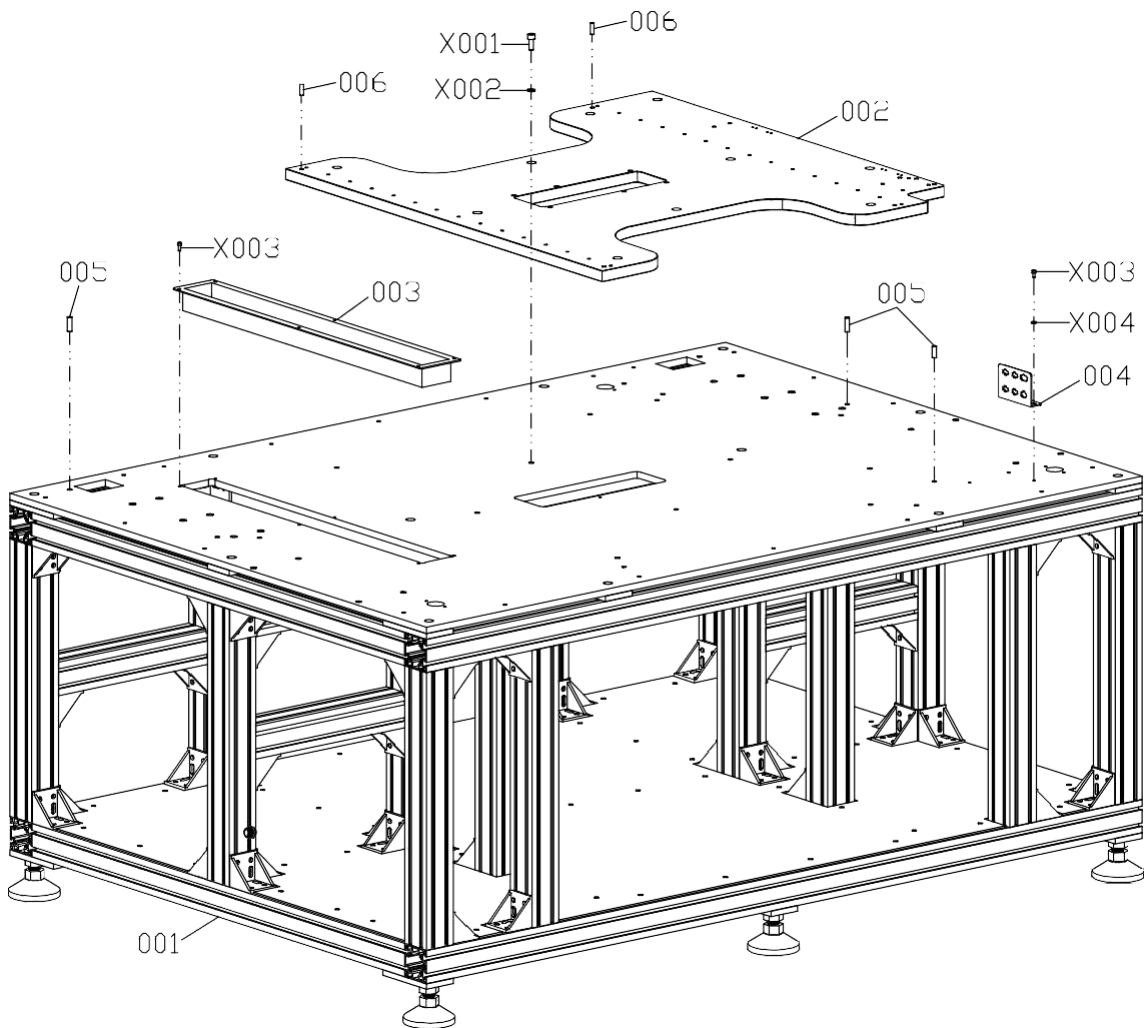
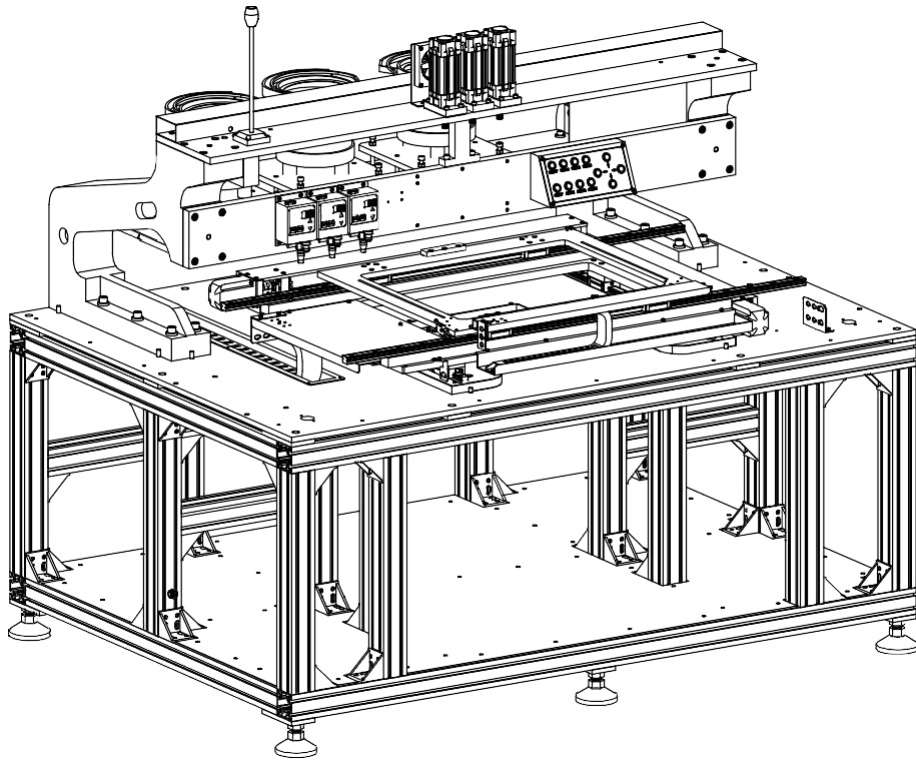


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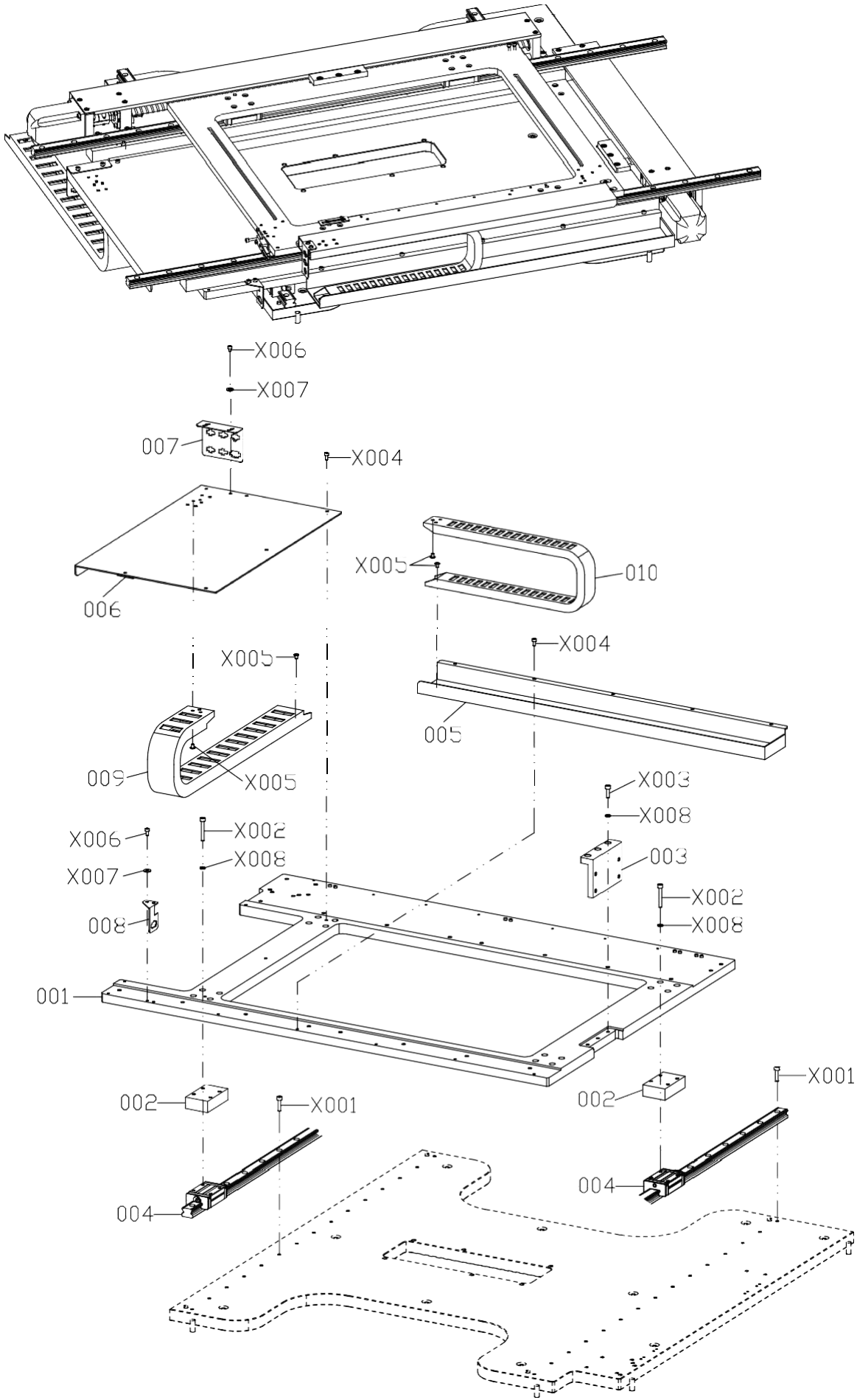
1 MAIN BODY SECT. -2

No	Material #	Material Name	Qty	Specification	Remark
001	FW01003AA	PLATE	1		
002	FW01004AA	PLATE	1		
003	FW01008AA	BLOCK	1		
004	FW01009AA	PLATE	3		
005	FW01010AA	PLATE	1		
006	FW01011AA	PLATE	1		
007	FW01012AA	PLATE	1		
008	FW01013AA	PLATE	1		
009	FW01014AA	TRNUKING	1		
010	FW01015AA	COVER	1		
011	FWKCE3XAA	BRACKET	1		
012	FWP1030AA	PIN	4		
013	FWDSBC4040	CYLINDER	3	DSBC40-40-PPVA-N3	
014	FW01016AA	FAN WITH MOTOR	2	JSD-12038A2HBT	
015	FWSDBC20	DIRECTOR	3	SDVC20-S	
016	FW01017AA	LAMP	1		
017	FWMIL850M	COMMUNICATION BOARD	1	MIL850M	
018	FW01018AA	START BUTTON	12		
A001	FW01019AA	PNEUMATIC COMPONENTS	1		
A002	FW01020AA	PNEUMATIC COMPONENTS	1		
019	FW01021AA	FITTING	3		
020	FW01022AA	FITTING	6		
021	FW01023AA	FITTING	21		
022	FW01024AA	PLUG	3		
023	FW01025AA	GASKET	6		
024	FW01026AA	GASKET	3		
025	FW01027AA	SOLENOID VALVE	6	SY5120-5GZD-01-F2	
026	FW01028AA	SOLENOID VALVE	3	MFH-5-1/8-B(19758)	
027	FW08014AA	SWITCH	6		
X001	FWSH0830	SOKET HEAD CAP SCREW	8	M8-L30	
X002	FWSH0820	SOKET HEAD CAP SCREW	14	M8-L20	
X003	FWSH0625	SOKET HEAD CAP SCREW	24	M6-L25	
X004	FWSH0412	SOKET HEAD CAP SCREW	6	M4-L12	
X005	FWSH0440	SOKET HEAD CAP SCREW	12	M4-L40	
X006	FWSH0516	SOKET HEAD CAP SCREW	4	M5-L16	
X007	FWSH0825	SOKET HEAD CAP SCREW	2	M8-L25	
X008	FWSH0410	SOKET HEAD CAP SCREW	4	M4-L10	
X009	FWPH0508	ROUND HEAD SCREW	12	M5-L8	
X010	FWPH0406	ROUND HEAD SCREW	20	M4-L6	
X011	FWFG0412	FLAT WASHER	2	4-12-H1.5	
X012	FWSH0435	SOKET HEAD CAP SCREW	4	M4-L35	
X013	FWSH0325	SOKET HEAD CAP SCREW	12	M3-L25	
X014	FWSH0450	SOKET HEAD CAP SCREW	6	M4-L50	
X015	FWSW08	SPRING WASHE	12	8-12.5-H2	
X016	FWSW06	SPRING WASHER	12	6-9.5-H1.6	

2 MAIN BODY SECT.



3 X-Y TABLE SECT. (Y-AXIS DRIVING SECT.-1)

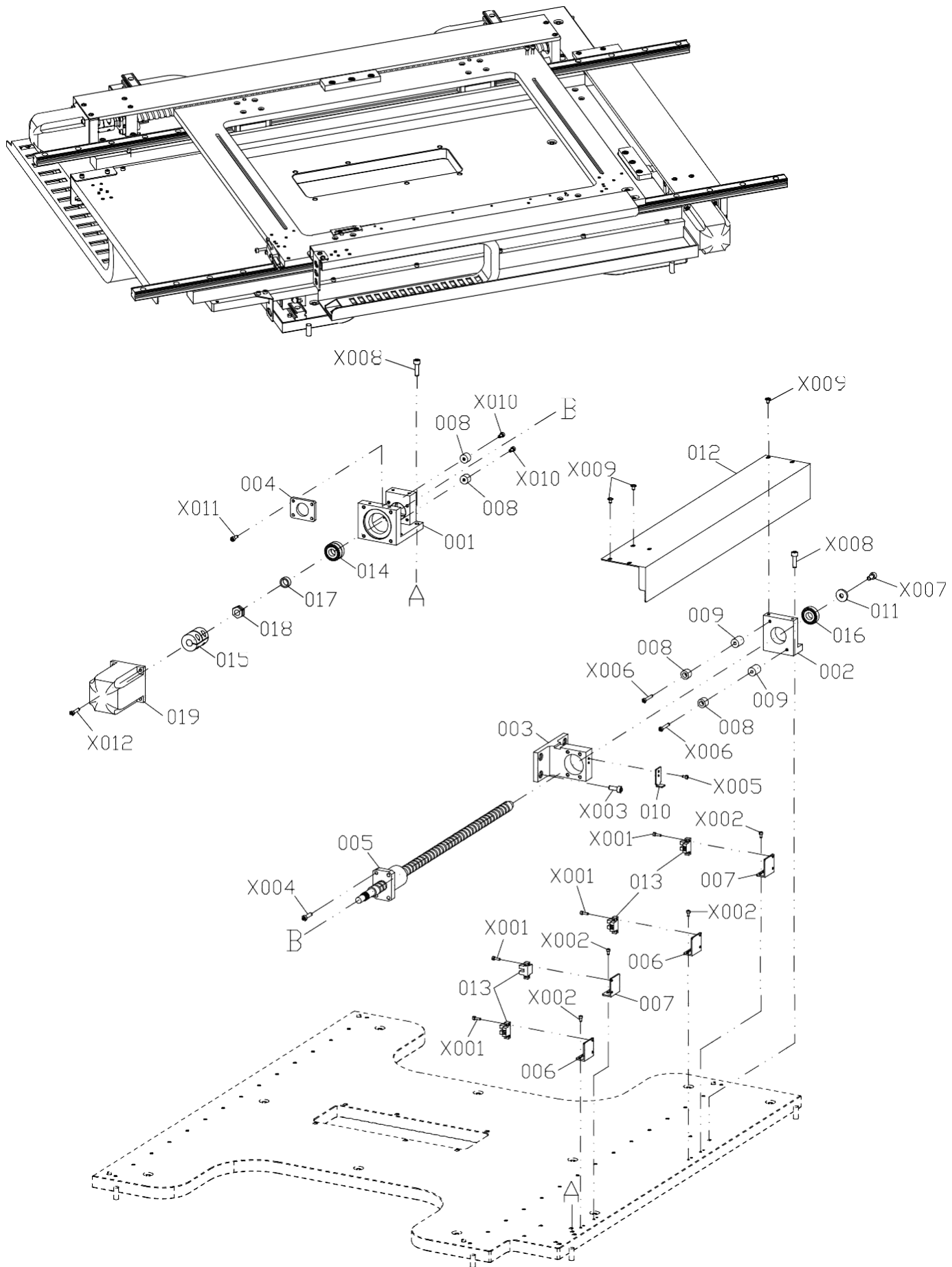


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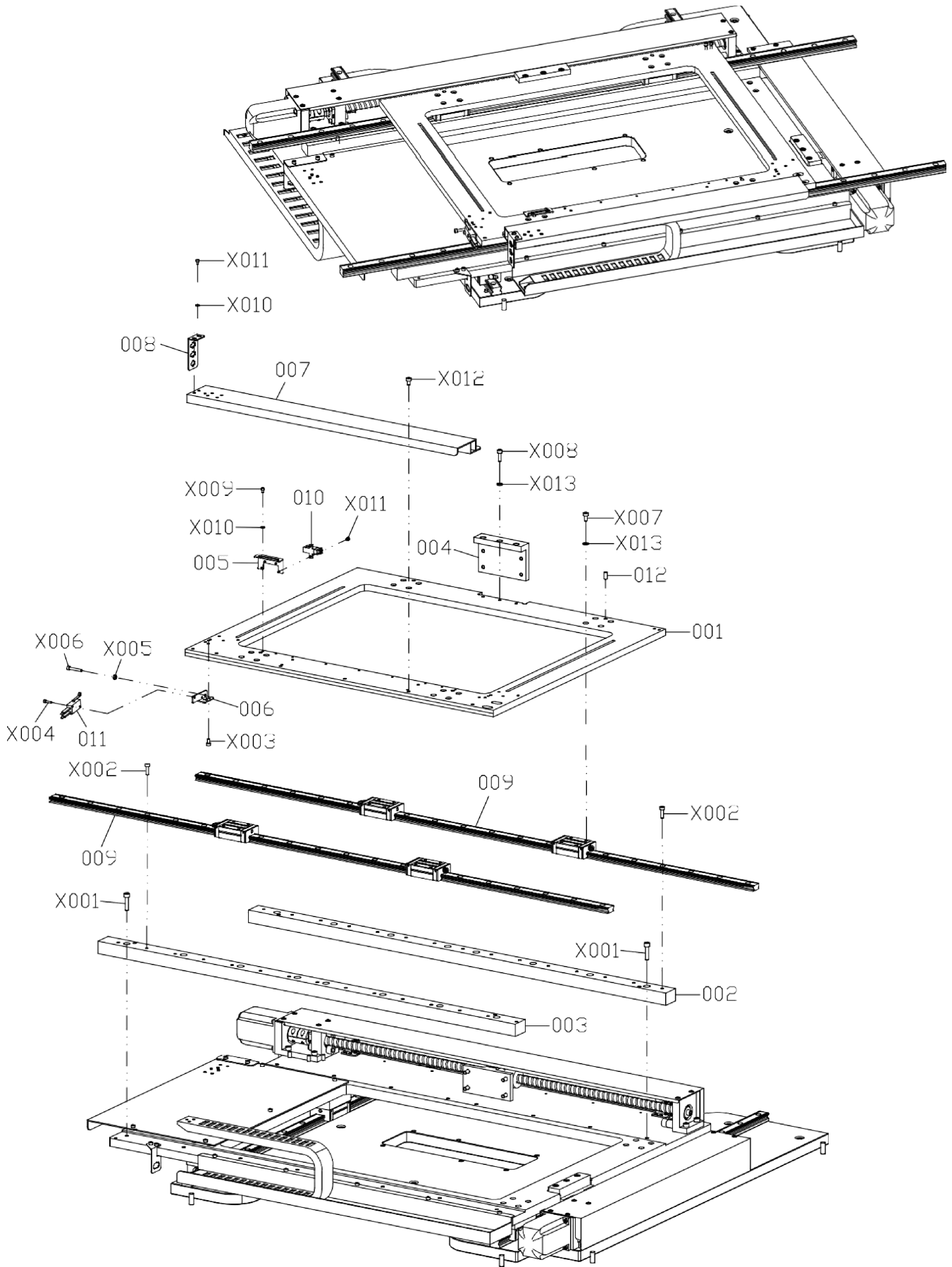
3 X-Y TABLE SECT. (Y-AXIS DRIVING SECT. -I)

No	Material #	Material Name	Qty	Specification	Remark
001	FW03002AA	Y-TABLE	1		
002	FW03009AA	SPACER	4		
003	FW03007AA	BRACKET	1		
004	FWSR20YAA	LINEAR MOTION UNIT (Y)	2	SR20W2SS-875	
005	FW03014AA	PLATE	1		
006	FW03012AA	PLATE	1		
007	FW03020AA	PLATE	1		
008	FW03022AA	PLATE	1		
009	FW03029AA	TANK CHAIN	1	18X37-23X50-L750	
010	FW03030AA	TANK CHAIN	1	18X25-23X37-L680	
X001	FWSH0520	SOKET HEAD CAP SCREW	30	M05-L20	
X002	FWSH0540	SOKET HEAD CAP SCREW	16	M5-L40	
X003	FWSH0520	SOKET HEAD CAP SCREW	3	M5-L20	
X004	FWSH0408	SOKET HEAD CAP SCREW	10	M4-L8	
X005	FWPH0406	ROUND HEAD SCREW	12	M4-L6	
X006	FWSH0406	SOKET HEAD CAP SCREW	4	M4-L5	
X007	FWFG0412	SOKET HEAD CAP SCREW	4	4-12-H1.5	
X008	FWSW05	SPRING WASHER	19	5-8-H1.3	

3 X-Y TABLE SECT. (Y-AXIS DRIVING SECT.-2)



3 X-Y TABLE SECT. (X-AXIS DRIVING SECT.-1)

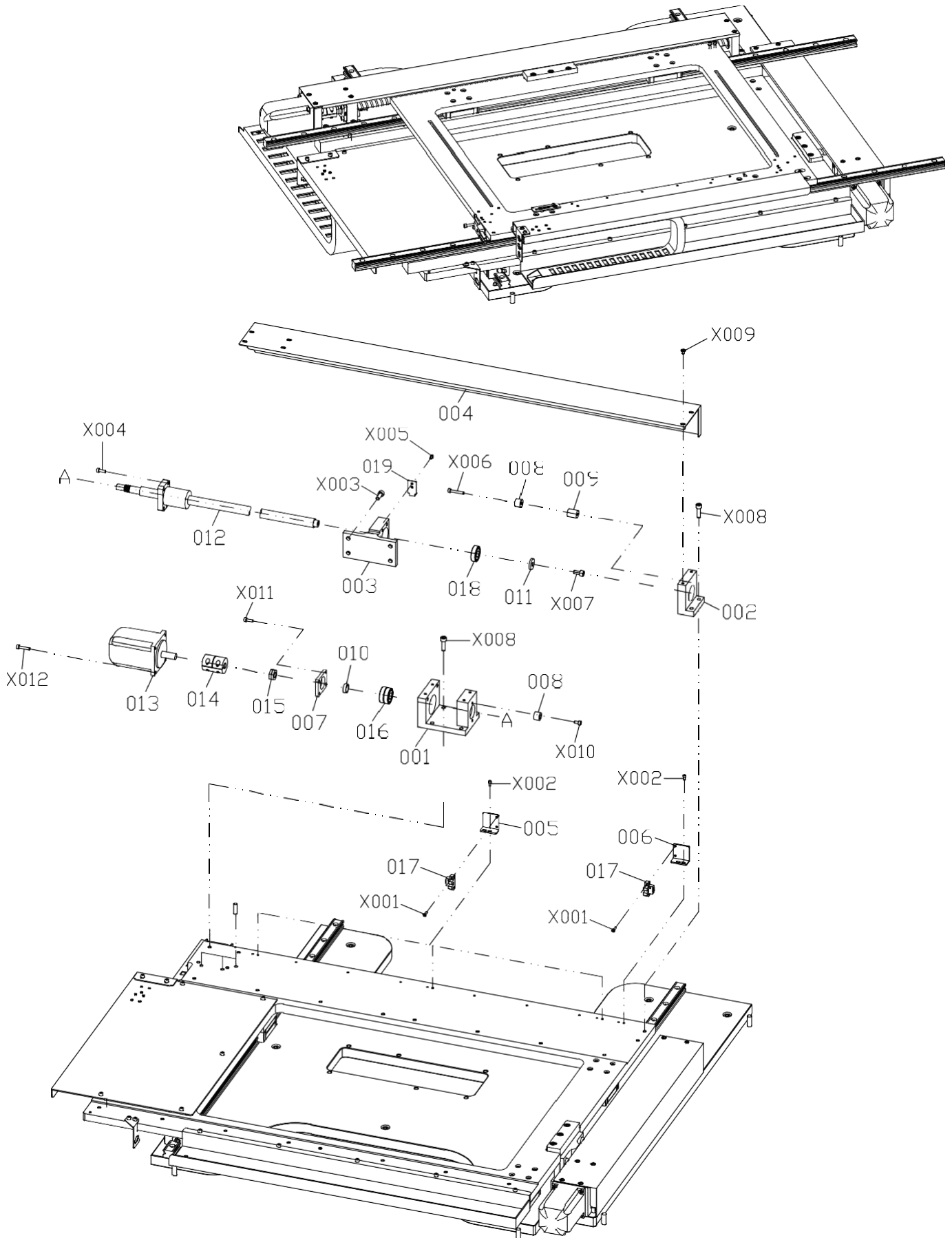


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3 X-Y TABLE SECT. (X-AXIS DRIVING SECT. -I)

No	Material #	Material Name	Qty	Specification	Remark
001	FW03003AA	Y-TABLE	1		
002	FW03008AA	PLATE	1		
003	FW03033AA	PLATE	1		
004	FW03007AA	BRACKET	1		
005	FW03024AA	BRACKET	1		
006	FW03023AA	BRACKET	1		
007	FW03013AA	PLATE	1		
008	FW03021AA	BRACKET	1		
009	FWSR20XAA	LINEAR MOTION UNIT (Y)	2	SR20W2SS-1175	
010	FWEESX672	SENSOR	1	EE-SX672K35M	
011	FWKW3AAA	MICRO SWITCH	1	KW3A	
012	FWP0612AA	PIN	4	ϕ6-L12	
X001	FWSH0630	ROUND HEAD SCREW	16	M6-L30	
X002	FWSH0516	ROUND HEAD SCREW	30	M5-L16	
X003	FWSH0410	ROUND HEAD SCREW	2	M4-L10	
X004	FWSH0312	ROUND HEAD SCREW	2	M3-L12	
X005	FWHEX04	HEXAGON NUT	1	M4	
X006	FWSH0425	ROUND HEAD SCREW	1	M4-L25	
X007	FWSH0512	ROUND HEAD SCREW	16	M5-L12	
X008	FWSH0516	ROUND HEAD SCREW	3	M5-L16	
X009	FWSH0308	ROUND HEAD SCREW	2	M3-L08	
X010	FWFG0307	FLAT WASHER	4	3-9-H1	
X011	FWSH0305	ROUND HEAD SCREW	4	M3-L05	
X012	FWSH0510	ROUND HEAD SCREW	5	M5-L10	
X013	FWSW05	SPRING WASHER	19	5-8-H1.3	

3 X-Y TABLE SECT. (X-AXIS DRIVING SECT.-2)

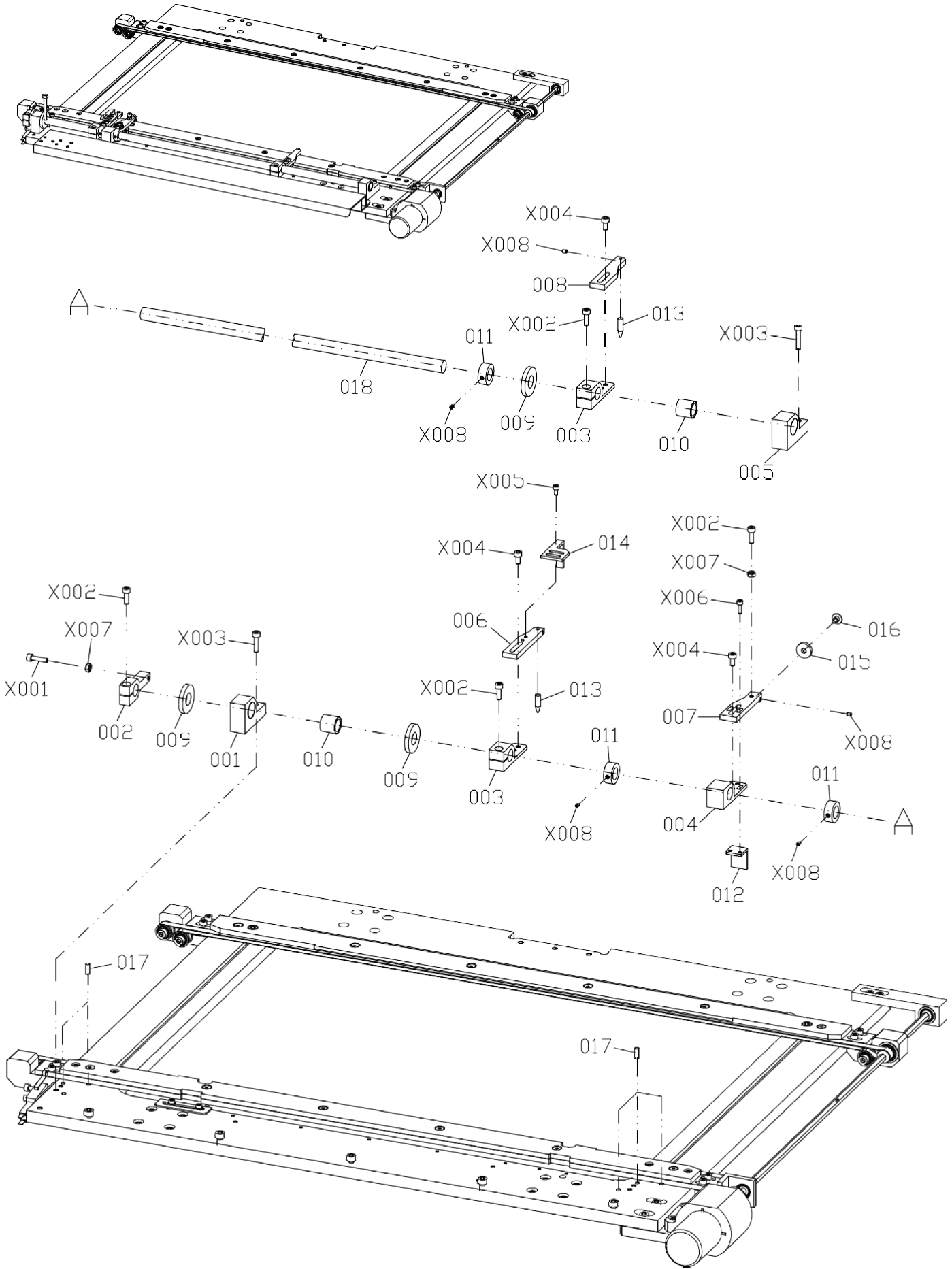


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3 X-Y TABLE SECT. (X-AXIS DRIVING SECT. -2)

No	Material #	Material Name	Qty	Specification	Remark
001	FW03004AA	BRACKET (MOTOR)	1		
002	FW03006AA	HOLDER (SHAFT)	1		
003	FW03005AA	HOUSING	1		
004	FW03010AA	COVER	1		
005	FW03017AA	BRACKET	3		
006	FW03016AA	BRACKET	1		
007	FW03019AA	BRACKET	3		
008	FW03027AA	STOPPER	4		
009	FW03026AA	WASHER	2		
010	FW03031AA	WASHER	1		
011	FW03028AA	WASHER	1		
012	FW1510YAA	BAL SOKET HEAD CAP SCREW	1		
013	FWKR43JAA	MOTOR	1	HG-KR43J/MR-J4-40A	
014	FW2810AA	COUPLING	1	GNC-28.5*38-10*14	
015	FW03032AA	NUT	1		
016	FW7001ZZ	BEARING	1	7001ZZ	
017	FWSX671A	SENSOR	4	EE-SX671A	
018	FW6000AA	BEARING	1	6000ZZ	
019	FW03018AA	DOG FOR SENSOR	1		
X001	FWSH0310	SOKET HEAD CAP SCREW	8	M3-L10	
X002	FWSH0308	SOKET HEAD CAP SCREW	8	M3-L08	
X003	FWSH0616	SOKET HEAD CAP SCREW	4	M6-L16	
X004	FWSH0520	SOKET HEAD CAP SCREW	4	M5-L20	
X005	FWSH0306	SOKET HEAD CAP SCREW	2	M3-L06	
X006	FWSH0430	SOKET HEAD CAP SCREW	2	M4-L30	
X007	FWSH0612	SOKET HEAD CAP SCREW	1	M6-L12	
X008	FWSH0620	SOKET HEAD CAP SCREW	6	M6-L20	
X009	FWPH0406	ROUND HEAD SCREW	6	M4-L6	
X010	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X011	FWSH0412	SOKET HEAD CAP SCREW	4	M4-L12	
X012	FWSH0420	SOKET HEAD CAP SCREW	4	M4-L20	

4 P.C.B POSITIONER SECT.(HOOK PLATE.-1)

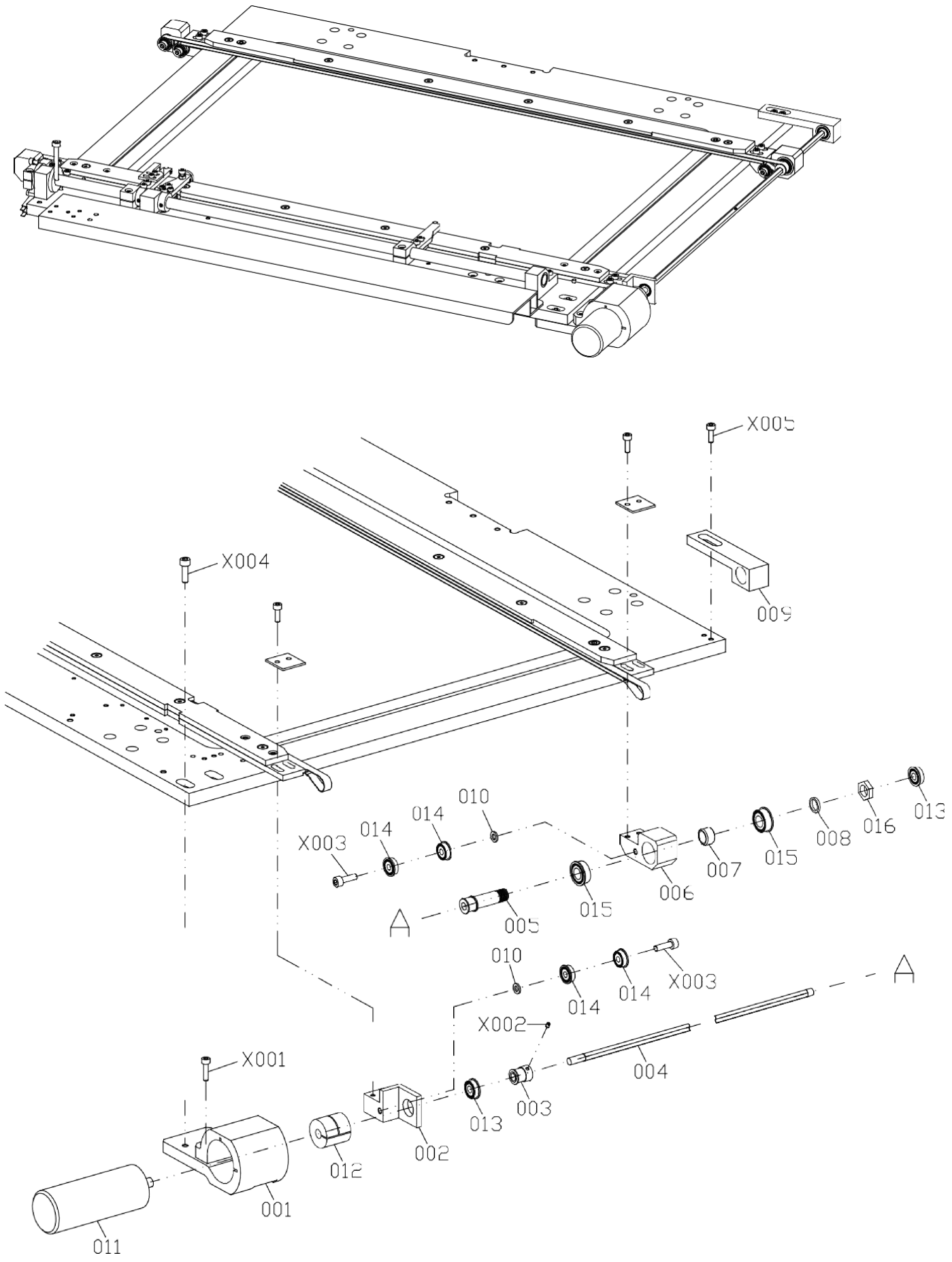


Southern Machinery Sales and Service Co., Limited

4 P. C. B POSITIONER SECT. (HOOK PLATE. -1)

No	Material #	Material Name	Qty	Specification	Remark
001	FW04006AA	BLOCK	1		
002	FW04010AA	LEVER	1		
003	FW04007AA	LEVER	2		
004	FW04008AA	LEVER	1		
005	FW04006AA	BLOCK	1		
006	FW04013AA	PLATE	1		
007	FW04014AA	PLATE	1		
008	FW04012AA	PLATE	1		
009	FW04018AA	BEARING	2	12-21-5	
010	FW04017AA	COPPER SHEATHING	2	12-16-15	
011	FW04015AA	COLLAR	3		
012	FW03025AA	DETECTION PLATE	1		
013	FW04030AA	PIN	2		
014	FW04016AA	BRACKET	1		
015	FW04019AA	COLLAR	1		
016	FW04031AA	PIN	1		
017	FWP0410AA	PIN	6	ϕ4-L10	
018	FW04005AA	SHAFT	1		
X001	FWSH0416	SOKET HEAD CAP SCREW	1	M4-L16	
X002	FWSH0412	SOKET HEAD CAP SCREW	4	M4-L12	
X003	FWSH0420	SOKET HEAD CAP SCREW	4	M4-L20	
X004	FWSH0408	SOKET HEAD CAP SCREW	4	M4-L08	
X005	FWSH0306	SOKET HEAD CAP SCREW	2	M3-L06	
X006	FWSH0310	SOKET HEAD CAP SCREW	2	M3-L10	
X007	FWHEX04	HEXAGON NUT	2	M4	
X008	FWSS0304	SUNK SCREW	5	M3-L4	

4 P.C.B POSITIONER SECT.(HOOK PLATE-2)

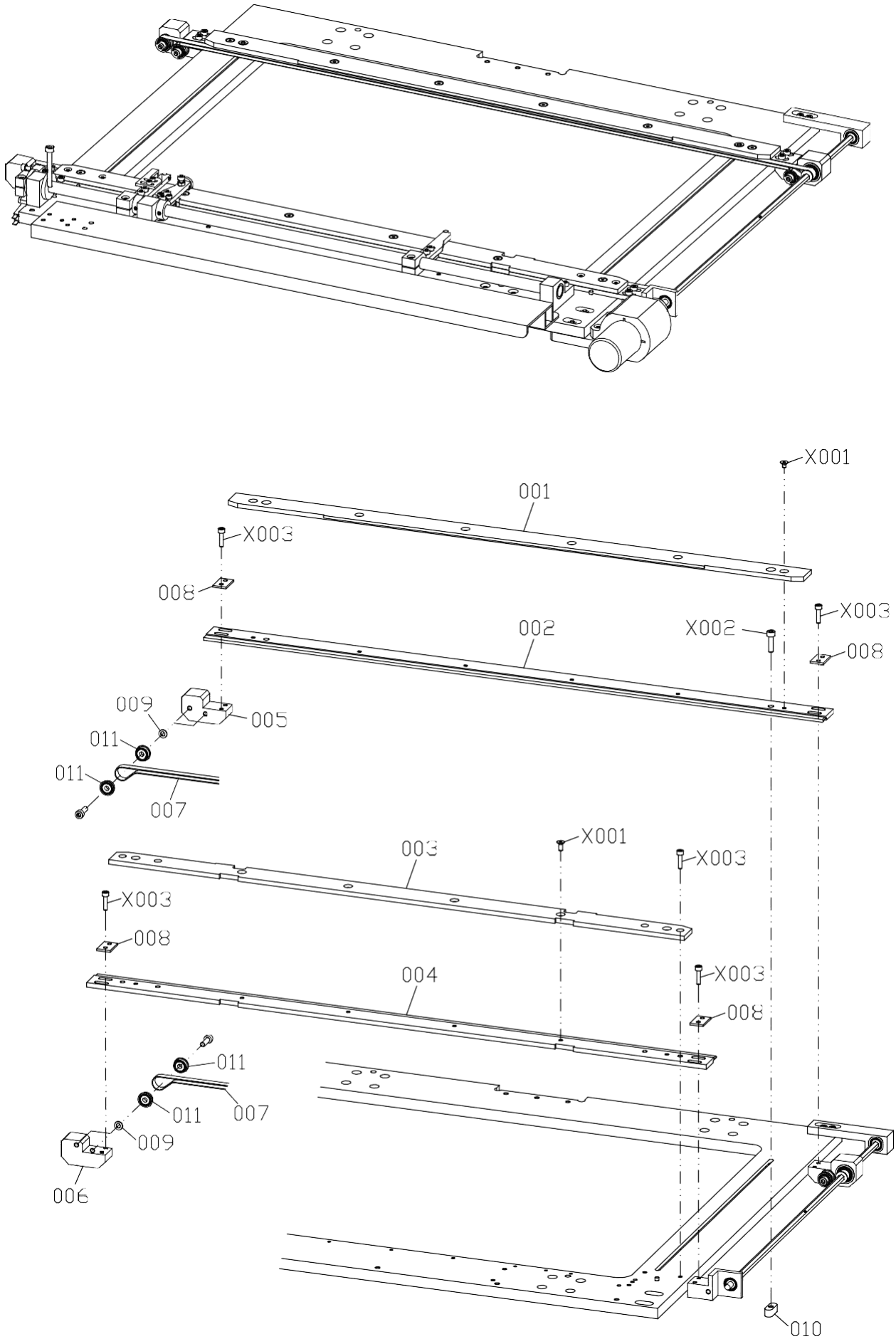


Southern Machinery Sales and Service Co., Limited

4 P. C. B POSITIONER SECT. (HOOK PLATE. -2)

No	Material #	Material Name	Qty	Specification	Remark
001	FW04011AA	BRACKET (MOTOR)	1		
002	FW04020AA	BLOCK	1		
003	FW04032AA	PULLEY	1		
004	FW04029AA	SHAFT	1		
005	FW04026AA	PULLEY	1		
006	FW04023AA	BLOCK	1		
007	FW04027AA	COLLAR	1		
008	FW04028AA	COLLAR	1		
009	FW04024AA	BLOCK	1		
010	FW05023AA	COLLAR	1		
011	FWX38REE	MOTOR	1	X38REE-5. 21X801	
012	FW20X25AA	COUPLING	1	GFC-20X25-6X8	
013	FWF696AA	BEARING	2	F696ZZ	
014	FWF605AA	BEARING	4	F605ZZ	
015	FWF6800AA	BEARING	2	F6800	
016	FW04033AA	HEXAGON NUT	1	M10X1.0	
X001	FWSH0416	SOKET HEAD CAP SCREW	2	M4-L16	
X002	FWSS0304	SUNK SCREW	1	M6-L04	
X003	FWSH0520	SOKET HEAD CAP SCREW	2	M5-L20	
X004	FWSH0516	SOKET HEAD CAP SCREW	2	M5-L16	
X005	FWSH0412	SOKET HEAD CAP SCREW	2	M4-L12	

4 P.C.B POSITIONER SECT.(HOOK PLATE-3)

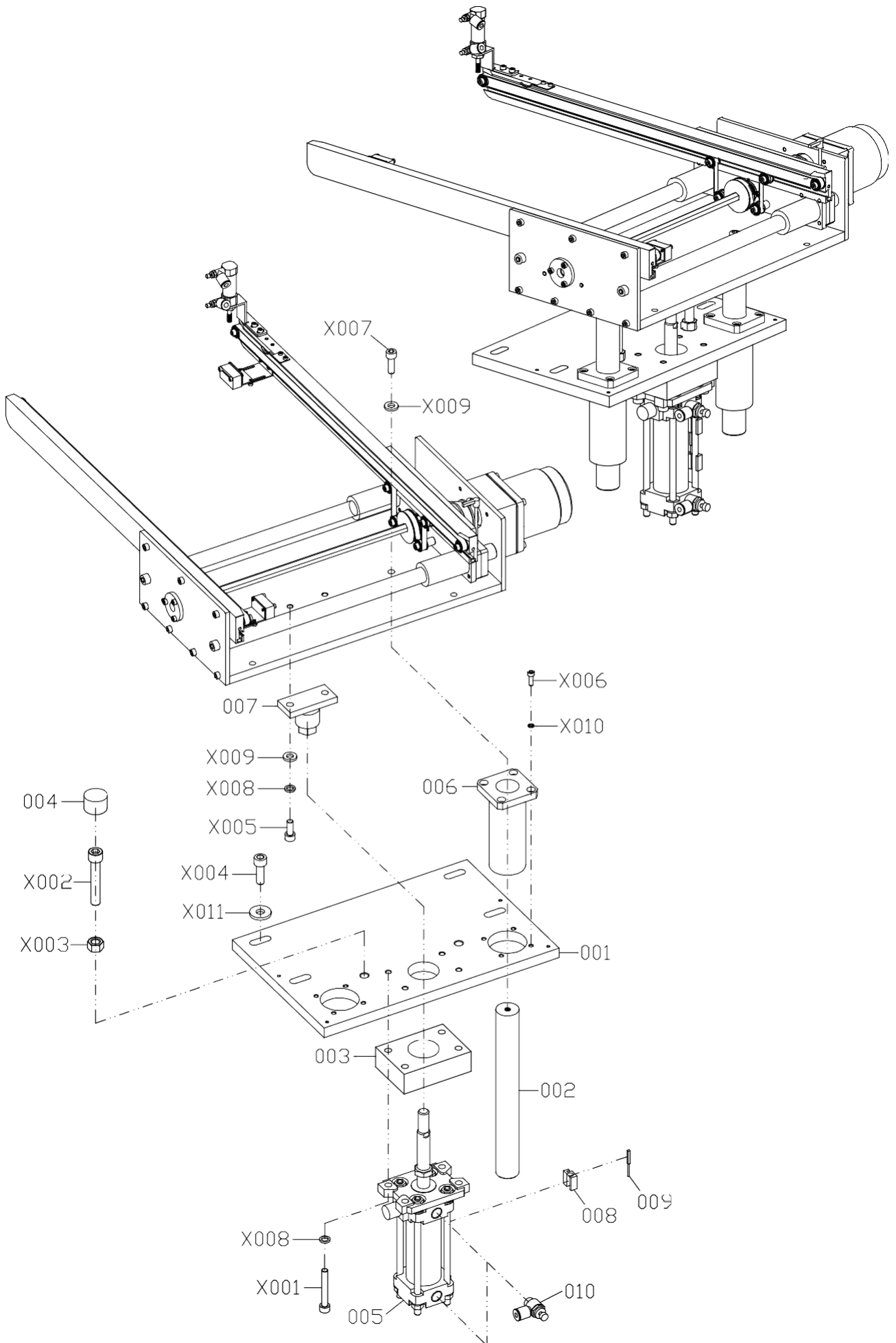


Southern Machinery Sales and Service Co., Limited

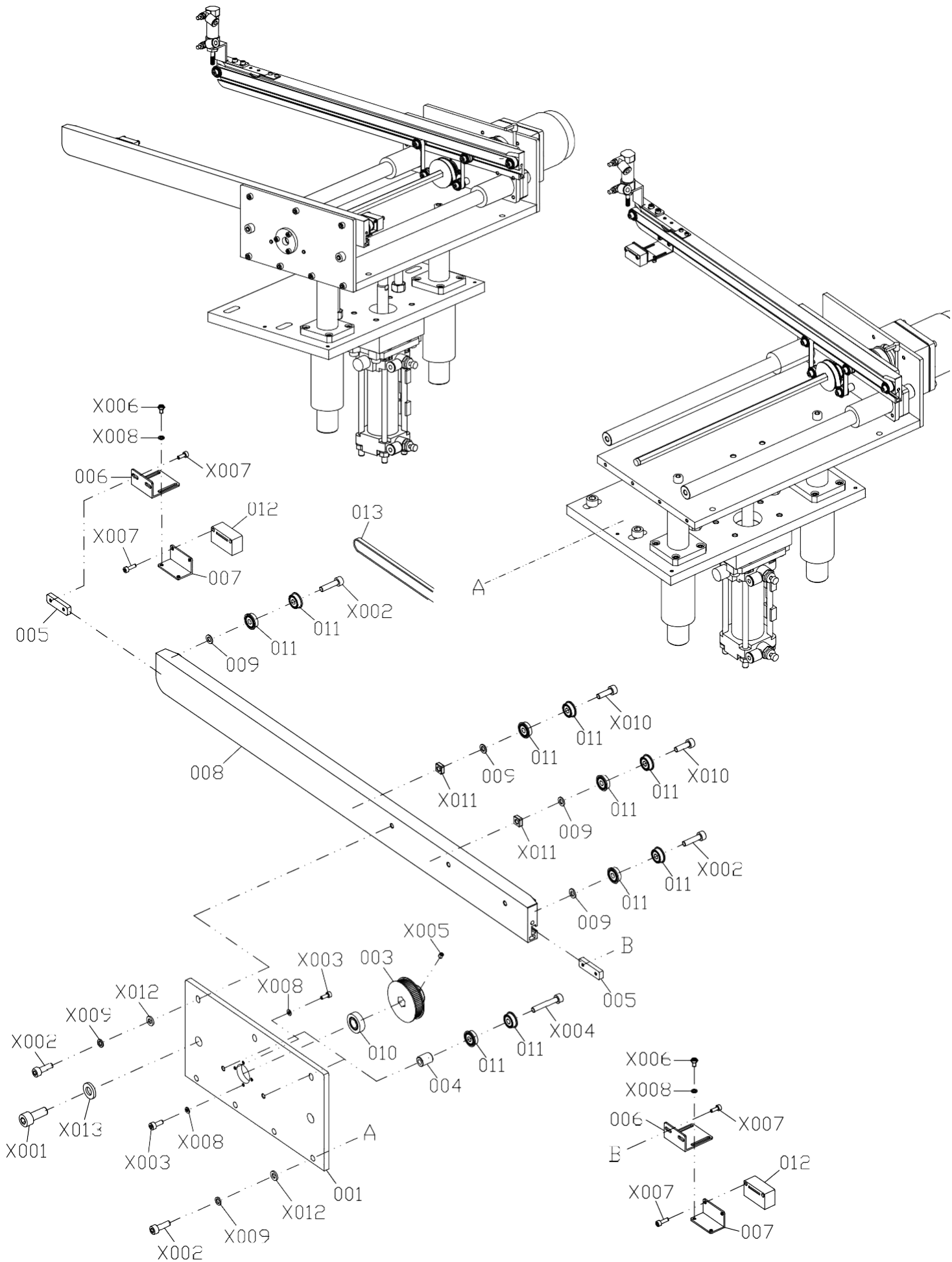
4 P. C. B POSITIONER SECT. (HOOK PLATE. -3)

No	Material #	Material Name	Qty	Specification	Remark
001	FW04001AA	GUIDE	1		
002	FW04003AA	GUIDE	1		
003	FW04002AA	GUIDE	1		
004	FW04004AA	GUIDE	1		
005	FW04022AA	BLOCK	1		
006	FW04021AA	BLOCK	1		
007	FW04034AA	BELT	2	1520*7.5*0.6	
008	FW04035AA	PLATE	4		
009	FW05023AA	COLLAR	4		
010	FW04025AA	PLATE	2		
011	FWF605AA	BEARING	8	F605ZZ	
X001	FWGS0410	FLAT SCREW	12	M4-L10	
X002	FWSH0520	SOKET HEAD CAP SCREW	2	M5-L20	
X003	FWSH0416	SOKET HEAD CAP SCREW	12	M5-L20	

5 - LOADER & UNLOADER SECT. (LOADER SECT.-1)



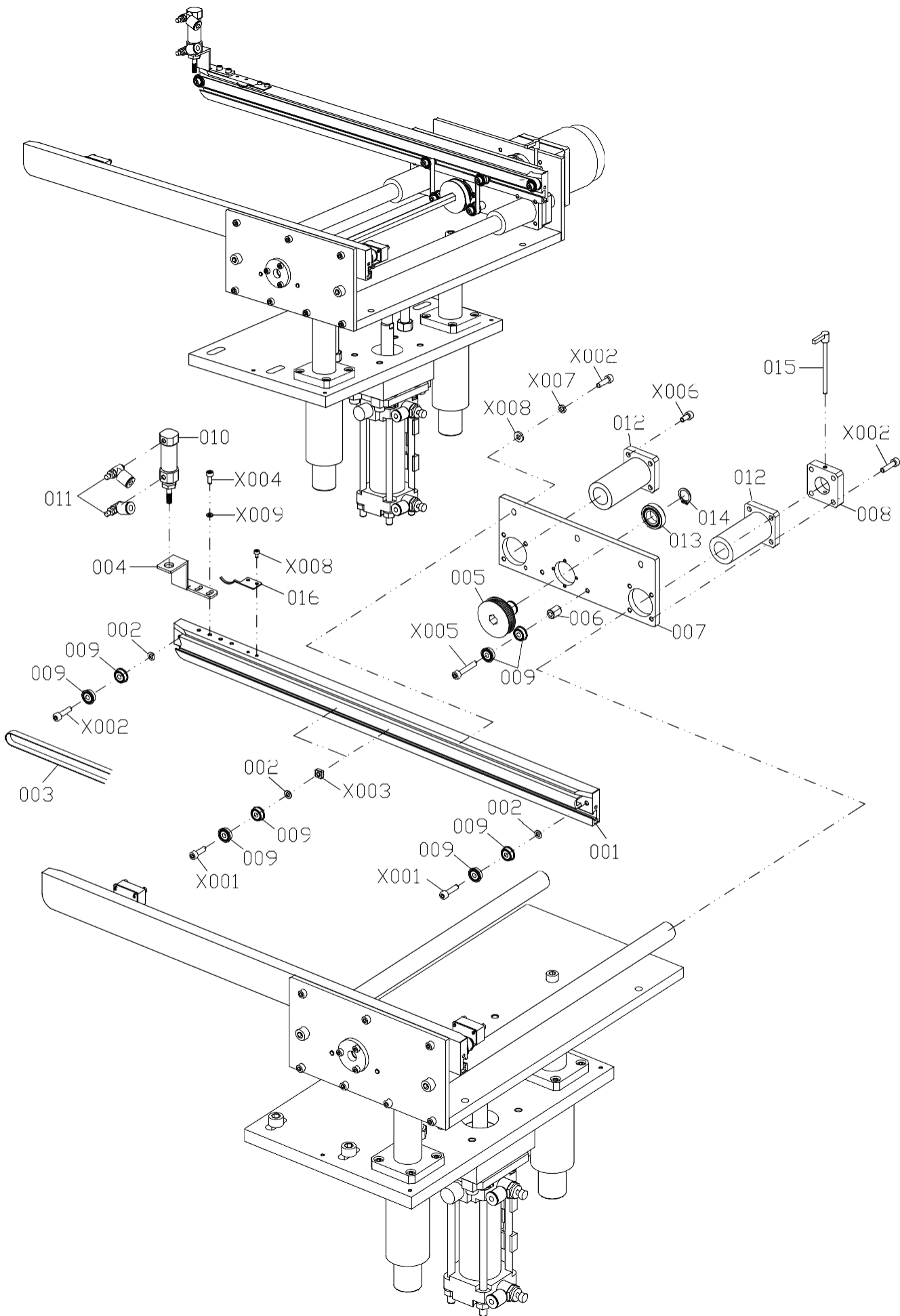
5 - LOADER & UNLOADER SECT. (LOADER SECT.-2)



5 LOADER Southern Machinery Sales and Service Co., Limited

No	Material #	Material Name	Qty	Specification	Remark
001	FW05004AA	PLATE	1		
003	FW05018AA	PULLEY	1		
004	FW05020AA	COLLAR	2		
005	FW05021AA	KEY	2		
006	FW05026AA	BRACKET	2		
007	FW05027AA	BRACKET	2		
008	FW05008AA	RAIL	1		
009	FW05023AA	COLLAR	4		
010	FW699ZZAA	BEARING	1	699ZZ	
011	FWF605ZZAA	BEARING	12	F605ZZ	
012	FWE3ZGD61	SENSOR	2	E3ZG-D61	
013	FW04035AA	BELT	1	1340*7.5*0.8	
X001	FWSH0820	SOKET HEAD CAP SCREW	2	M8-L20	
X002	FWSH0520	SOKET HEAD CAP SCREW	9	M5-L20	
X003	FWSH0306	SOKET HEAD CAP SCREW	4	M3-L06	
X004	FWSH0530	SOKET HEAD CAP SCREW	2	M5-L30	
X005	FWSS0405	SUNK SCREW	1	M4-L05	
X006	FWSH0305	SOKET HEAD CAP SCREW	4	M3-L05	
X007	FWSH0308	SOKET HEAD CAP SCREW	8	M3-L08	
X008	FWFG0307	FLAT WASHER	8	3-9-H1	
X009	FWSW05	SPRING WASHER	7	5-8-H1.3	
X010	FWSH0516	SOKET HEAD CAP SCREW	2	M5-L16	
X011	FWSN05	SQUARE NUT	2	M5	
X012	FWFG0512	FLAT WASHER	7	5-15-H2	
X013	FWFG0821	FLAT WASHER	2	8-21-H4	

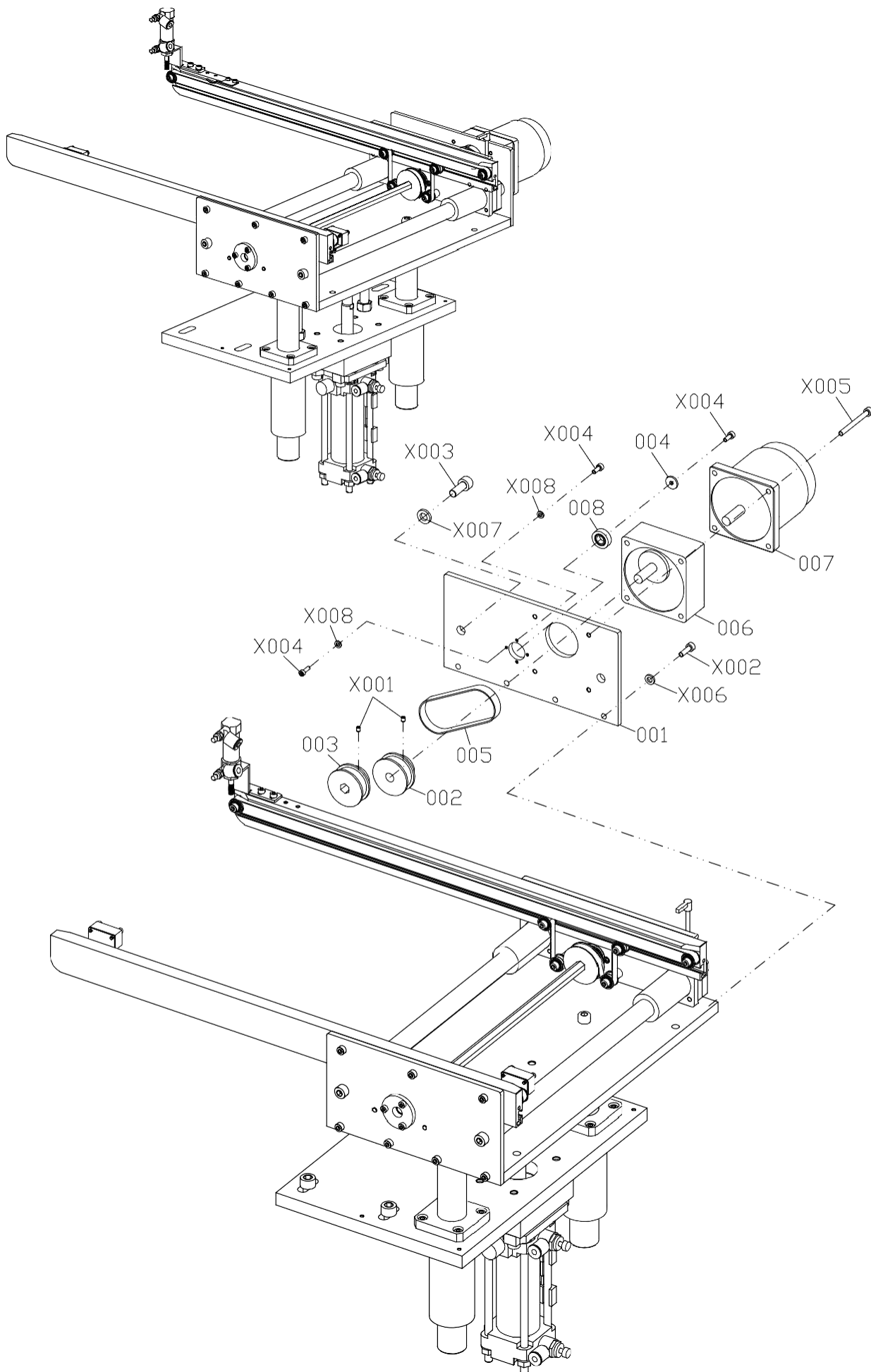
5 - LOADER & UNLOADER SECT. (LOADER SECT.-3)



5 LOADER & Southern Machinery Sales and Service Co., Limited

No	Material #	Material Name	Qty	Specification	Remark
001	FW05009AA	PLATE	1		
002	FW05023AA	COLLAR	4		
003	FW04035AA	BELT	1	1340*7.5*0.8	
004	FW05029AA	BRACKET	1		
005	FW05019AA	PULLEY	1		
006	FW05020AA	COLLAR	2		
007	FW05005AA	PLATE	1		
008	FW05022AA	PLATE	1		
009	FWF605ZZAA	BEARING	12	F605ZZ	
010	FW1610BAA	CYLINDER	1	SMC-CDJ2B16-10-B	
011	FWASM506AA	SPEED CONTROLLER	2	AS1201F M5-06	
012	FWLM20UUAA	BUSHING	2	LM20UU	
013	FW6902ZZAA	BEARING	1	6902ZZ	
014	FWJR14WAA	RETAINING RING C-TYPE	1	ϕ14	
015	FW05M4LAA	HEAD CAP BOLT	1		
016	FW05030AA	BRACKET	1		
X001	FWSH0516	SOKET HEAD CAP SCREW	2	M5-L16	
X002	FWSH0520	SOKET HEAD CAP SCREW	7	M5-L20	
X003	FWSN05	SQUARE NUT	2	M5	
X004	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X005	FWSH0530	SOKET HEAD CAP SCREW	2	M5-L30	
X006	FWSH0516	SOKET HEAD CAP SCREW	3	M5-L16	
X007	FWSW05	SPRING WASHER	3	5-8-H1.3	
X008	FWFG0512	FLAT WASHER	3	5-15-H2	
X009	FWFG0412	SOKET HEAD CAP SCREW	2	4-12-H1.5	

5 - LOADER & UNLOADER SECT. (LOADER SECT.-4)

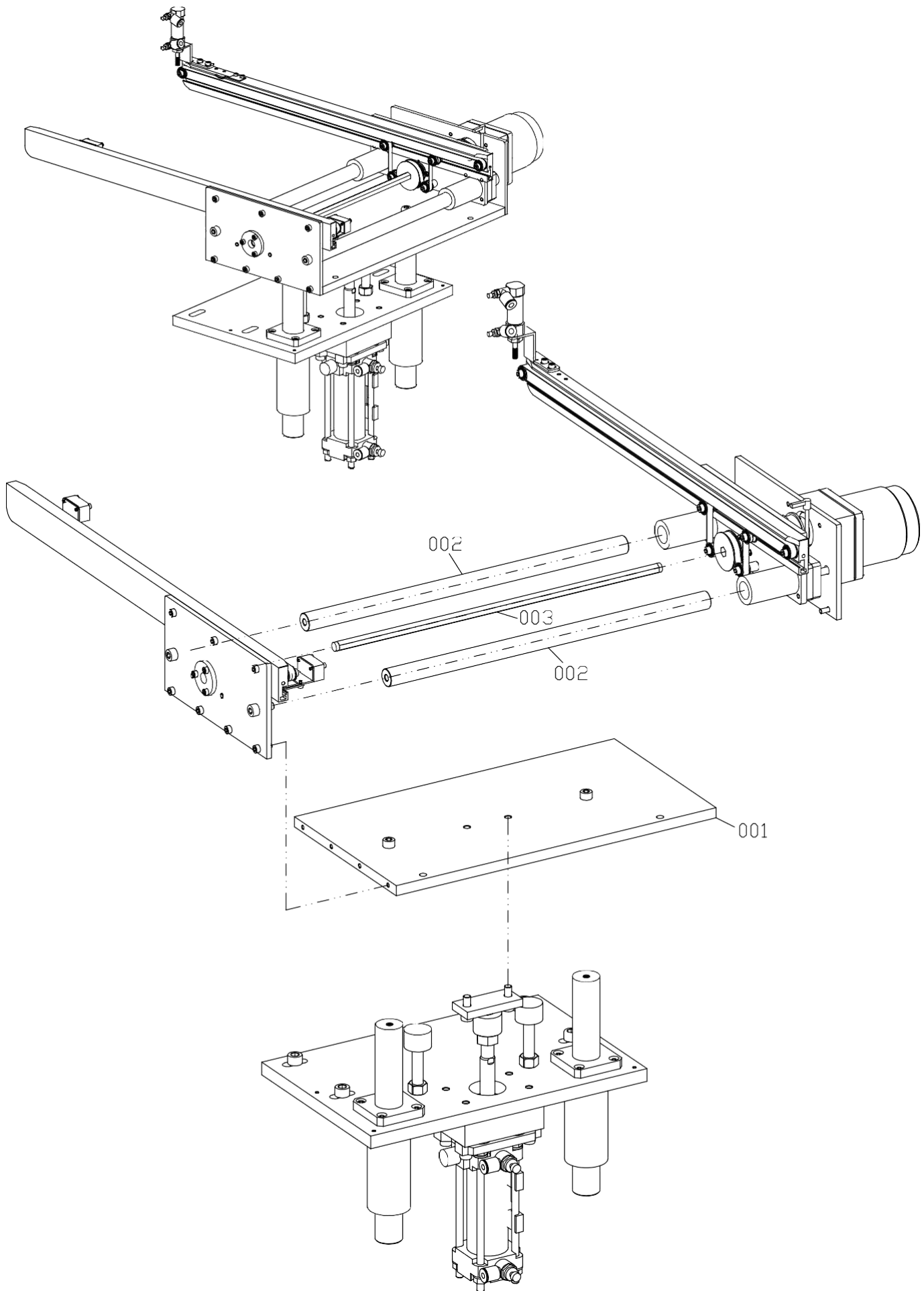


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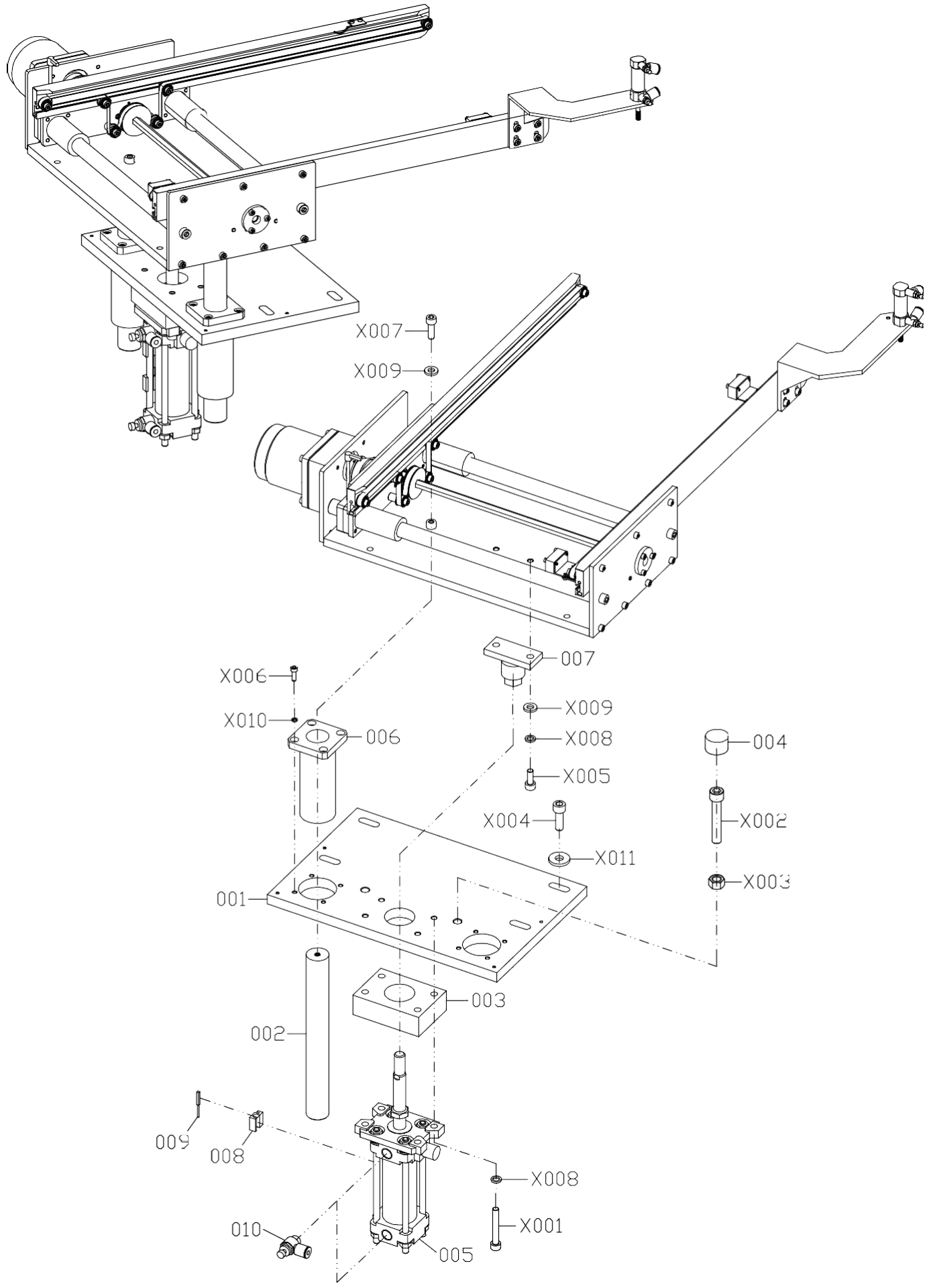
5 LOADER & UNLOADER SECT. (LOADER SECT.-4)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05006AA	PLATE	1		
002	FW05016AA	PULLEY	1		
003	FW05017AA	PULLEY	1		
004	FW05015AA	FLAT WASHER	1		
005	FW96XLAA	BELT	1	96XL-H10	
006	FWGH4GNAA	GEAR HEAD	1	4GN-7.5K	
007	FW4IK25AA	MOTOR	1	41K25GN-C	
008	FW699ZZAA	BEARING	1	699ZZ	
X001	FWSS0405	SUNK SCREW	1	M4-L05	
X002	FWSH0516	SOKET HEAD CAP SCREW	4	M5-L16	
X003	FWSH0820	SOKET HEAD CAP SCREW	2	M8-L20	
X004	FWSH0306	SOKET HEAD CAP SCREW	4	M6-L06	
X005	FWSH0550	SOKET HEAD CAP SCREW	4	M5-L55	
X006	FWFG0512	FLAT WASHER	4	5-15-H2	
X007	FWFG0821	FLAT WASHER	2	8-21-H4	
X008	FWFG0307	FLAT WASHER	4	3-9-H1	
X009	FWSS04010	SUNK SCREW	1	M4-L10	

5 - LOADER & UNLOADER SECT. (LOADER SECT.-5)



5 LOADER & UNLOADER SECT. (UNLOADER SECT.-1)

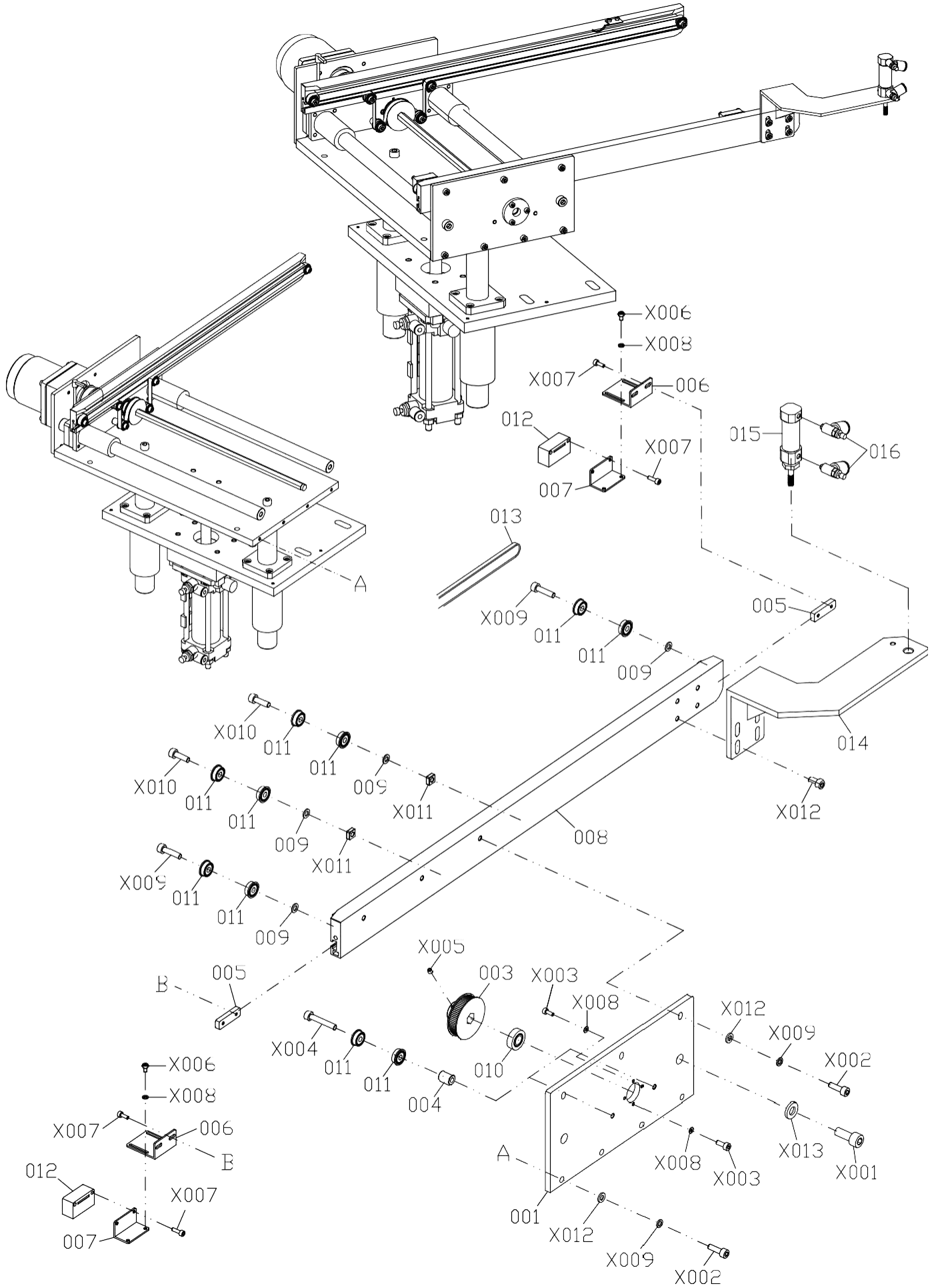


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5 LOADER & UNLOADER SECT. (UNLOADER SECT. -1)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05001AA	PLATE	1		
002	FW05002AA	SHAFT	2		
003	FW05012AA	SPACER	1		
004	FW05003AA	STOPPER	2		
005	FW4075RLAA	CYLINDER	1	CDBA2B40-75-RL	
006	FW30LUUAA	BUSHING	2	LMK30LUU	
007	FWJAF14AA	FLOATING JOINT	1	JAF-40-14-150	
008	FWDCSM07AA	BRACKET	2	DCSM-07	
009	FWDK21RAA	SWITCH	2	DK-21R	
010	FWAS0208SAA	SPEED CONTROLLER	2	AS2201F-02-08S	
X001	FWSH0860	SOKET HEAD CAP SCREW	4	M8-L60	
X002	FWSH1270	SOKET HEAD CAP SCREW	2	M12-L70	
X003	FWHEX12	HEXAGON NUT	2	M12	
X004	FWSH1030	SOKET HEAD CAP SCREW	4	M10-30	
X005	FWSH0820	SOKET HEAD CAP SCREW	2	M8-L20	
X006	FWSH0516	SOKET HEAD CAP SCREW	8	M8-L16	
X007	FWSH0825	SOKET HEAD CAP SCREW	2	M8-L25	
X008	FWSW08	SPRING WASHE	6	8-12.5-H2	
X009	FWFG0821	FLAT WASHER	4	8-21-H4	
X010	FWSW05	SPRING WASHER	8	5-8-H1.3	
X011	FWFG1025	FLAT WASHER	4	10-25-H4	

5 LOADER & UNLOADER SECT. (UNLOADER SECT.-2)

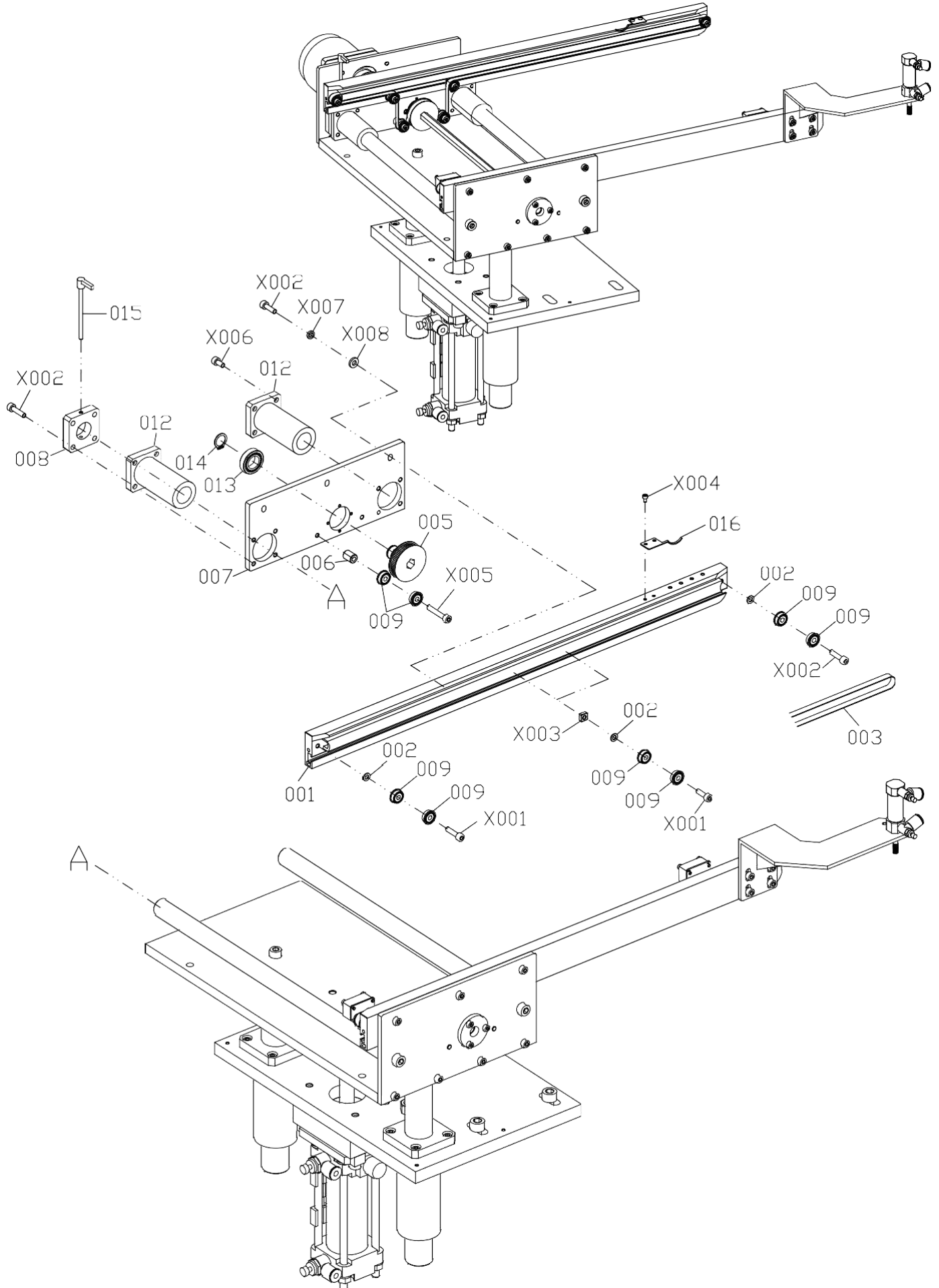


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5 LOADER & UNLOADER SECT. (UNLOADER SECT. -2)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05004AA	PLATE	1		
003	FW05018AA	PULLEY	1		
004	FW05020AA	COLLAR	2		
005	FW05021AA	KEY	2		
006	FW05026AA	BRACKET	2		
007	FW05027AA	BRACKET	2		
008	FW05010AA	RAIL	1		
009	FW05023AA	COLLAR	4		
010	FW699ZZAA	BEARING	1	699ZZ	
011	FWF605ZZAA	BEARING	12	F605ZZ	
012	FWE3ZGD61	SENSOR	2	E3ZG-D61	
013	FW04035AA	BELT	1	1340*7.5*0.8	
014	FW05028AA	SUPPORT	1		
015	FW1610BAA	CYLINDER	1	SMC-CDJ2B16-10-B	
016	FWASM506AA	SPEED CONTROLLER	2	AS1201F M5-06	
X001	FWSH0820	SOKET HEAD CAP SCREW	2	M8-L20	
X002	FWSH0520	SOKET HEAD CAP SCREW	9	M5-L20	
X003	FWSH0306	SOKET HEAD CAP SCREW	4	M3-L06	
X004	FWSH0530	SOKET HEAD CAP SCREW	2	M5-L30	
X005	FWSS0405	SUNK SCREW	1	M4-L05	
X006	FWSH0305	SOKET HEAD CAP SCREW	4	M3-L05	
X007	FWSH0308	SOKET HEAD CAP SCREW	8	M3-L08	
X008	FWFG0307	FLAT WASHER	8	3-9-H1	
X009	FWSW05	SPRING WASHER	7	5-8-H1.3	
X010	FWSH0516	SOKET HEAD CAP SCREW	2	M5-L16	
X011	FWSN05	SQUARE NUT	2	M5	
X012	FWFG0512	FLAT WASHER	7	5-15-H2	
X013	FWFG0821	FLAT WASHER	2	8-21-H4	

5 LOADER & UNLOADER SECT. (UNLOADER SECT.-3)

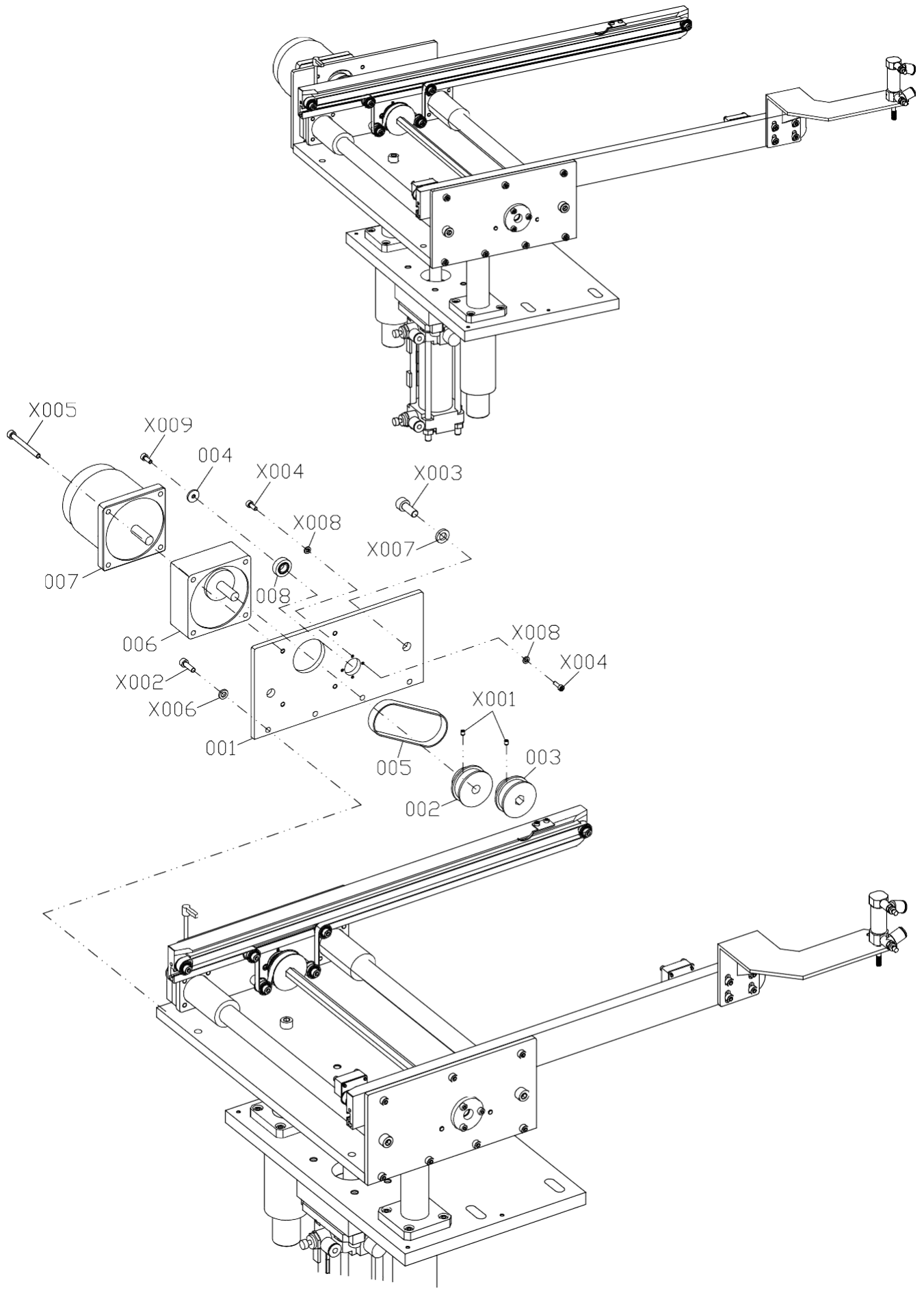


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5 LOADER & UNLOADER SECT. (UNLOADER SECT. -3)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05008AA	PLATE	1		
002	FW05023AA	COLLAR	4		
003	FW05035AA	BELT	1	0.8-8.0-1310	
005	FW05019AA	PULLEY	1		
006	FW05020AA	COLLAR	2		
007	FW05005AA	PLATE	1		
008	FW05022AA	PLATE	1		
009	FWF605ZZAA	BEARING	12	F605ZZ	
012	FWLM20UUAA	BUSHING	2	LM20UU	
013	FW6902ZZAA	BEARING	1	6902ZZ	
014	FWJR14WAA	RETAINING RING C-TYPE	1	ϕ14	
015	FW05M4LAA	HEAD CAP BOLT	1		
016	FW05030AA	BRACKET	1		
X001	FWSH0516	SOKET HEAD CAP SCREW	2	M5-L16	
X002	FWSH0520	SOKET HEAD CAP SCREW	7	M5-L20	
X003	FWSN05	SQUARE NUT	2	M5	
X004	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X005	FWSH0530	SOKET HEAD CAP SCREW	2	M5-L30	
X006	FWSH0516	SOKET HEAD CAP SCREW	3	M5-L16	
X007	FWSW05	SPRING WASHER	3	5-8-H1.3	
X008	FWFG0512	FLAT WASHER	3	5-15-H2	

5 LOADER & UNLOADER SECT. (UNLOADER SECT.-4)

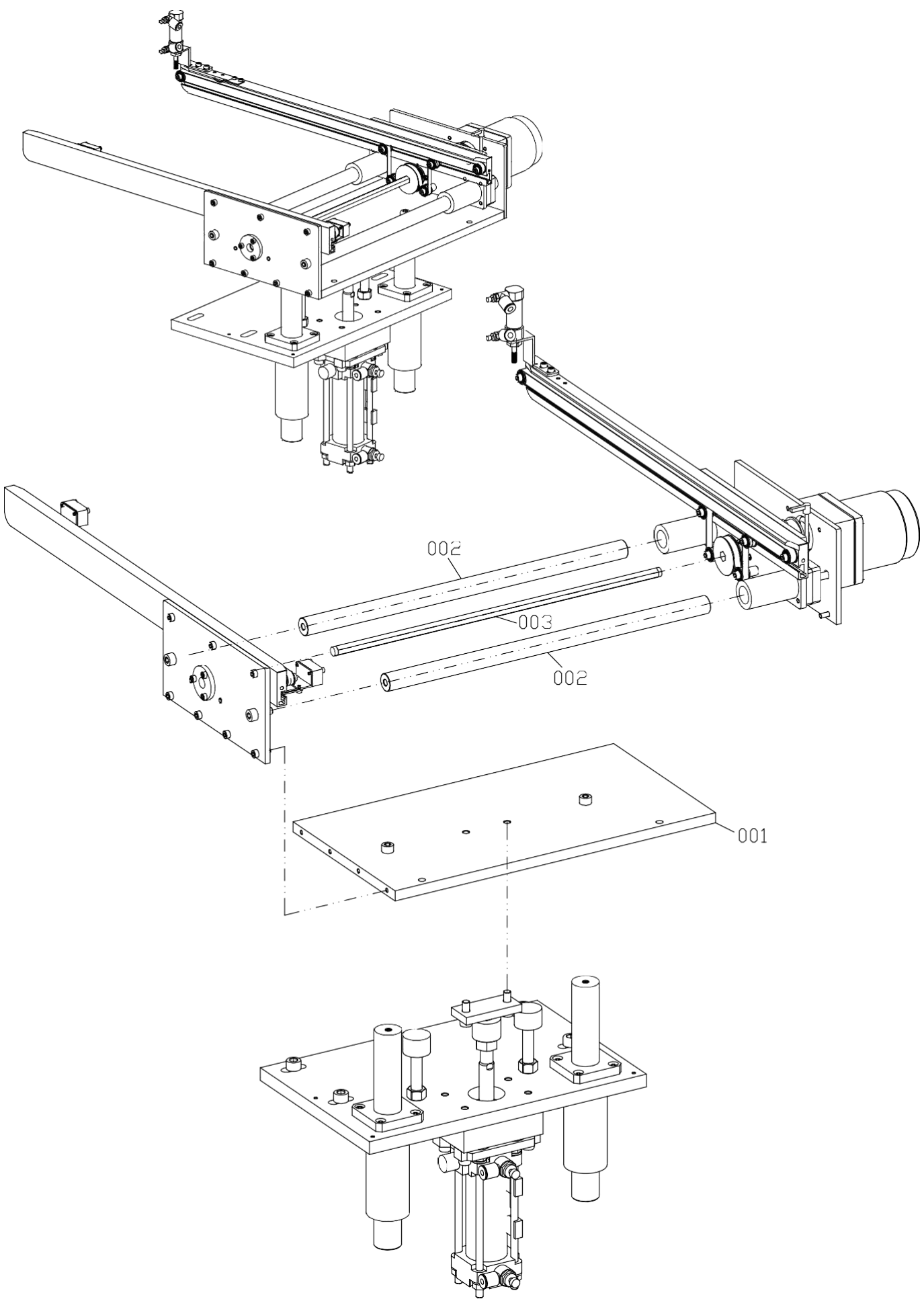


Southern Machinery Sales and Service Co., Limited

5 LOADER & UNLOADER SECT. (UNLOADER SECT. -4)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05006AA	PLATE	1		
002	FW05016AA	PULLEY	1		
003	FW05017AA	PULLEY	1		
004	FW05015AA	FLAT WASHER	1		
005	FW96XLAA	BELT	1	96XL-H10	
006	FWGH4GNAA	GEAR HEAD	1	4GN-7.5K	
007	FW4IK25AA	MOTOR	1	41K25GN-C	
008	FW699ZZAA	BEARING	1	699ZZ	
X001	FWSS0405	SUNK SCREW	1	M4-L05	
X002	FWSH0516	SOKET HEAD CAP SCREW	4	M5-L16	
X003	FWSH0820	SOKET HEAD CAP SCREW	2	M8-L20	
X004	FWSH0306	SOKET HEAD CAP SCREW	4	M6-L06	
X005	FWSH0550	SOKET HEAD CAP SCREW	4	M5-L55	
X006	FWFG0512	FLAT WASHER	4	5-15-H2	
X007	FWFG0821	FLAT WASHER	2	8-21-H4	
X008	FWFG0307	FLAT WASHER	4	3-9-H1	
X009	FWSS04010	SUNK SCREW	1	M4-L10	

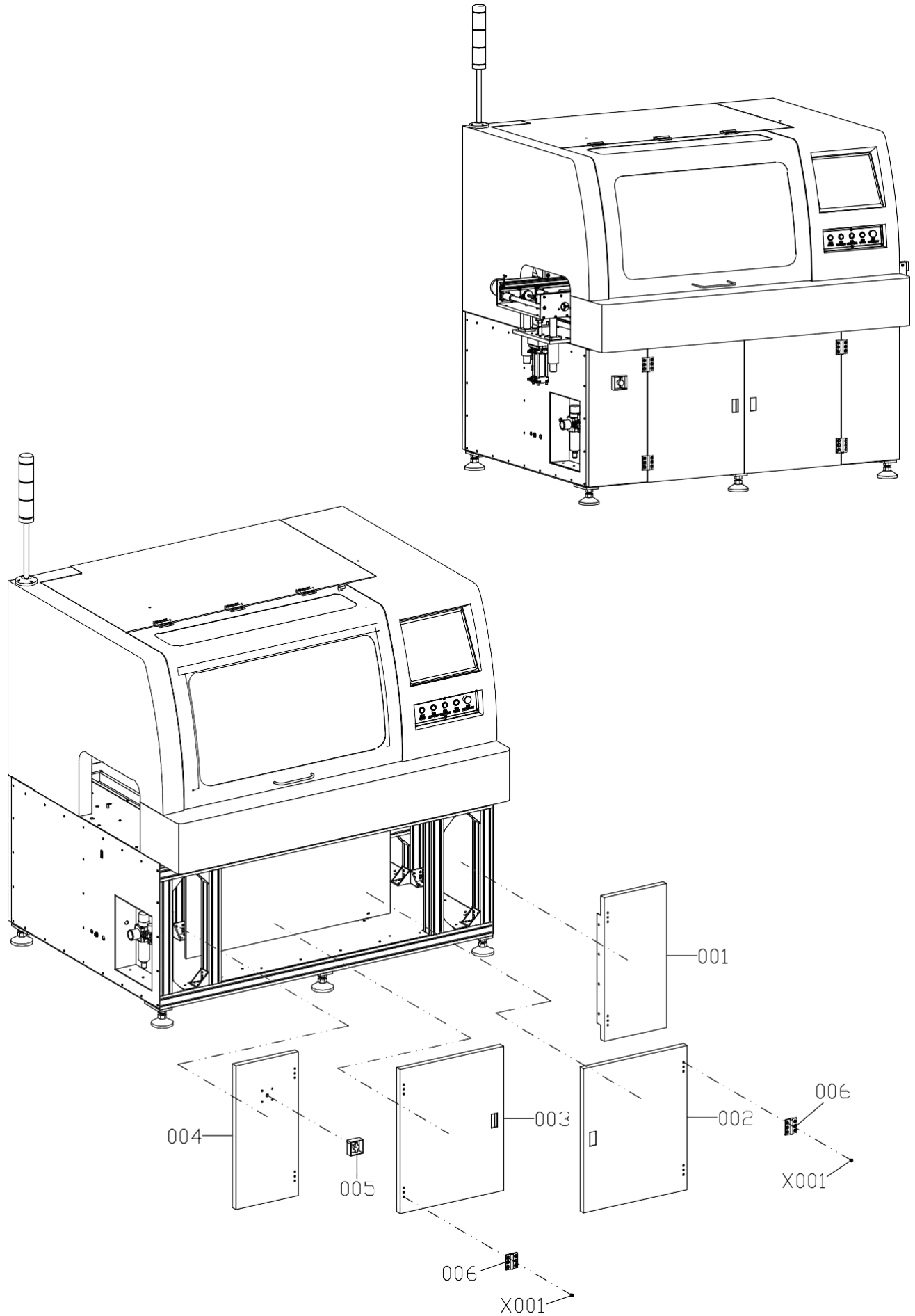
5 LOADER & UNLOADER SECT. (UNLOADER SECT.-5)

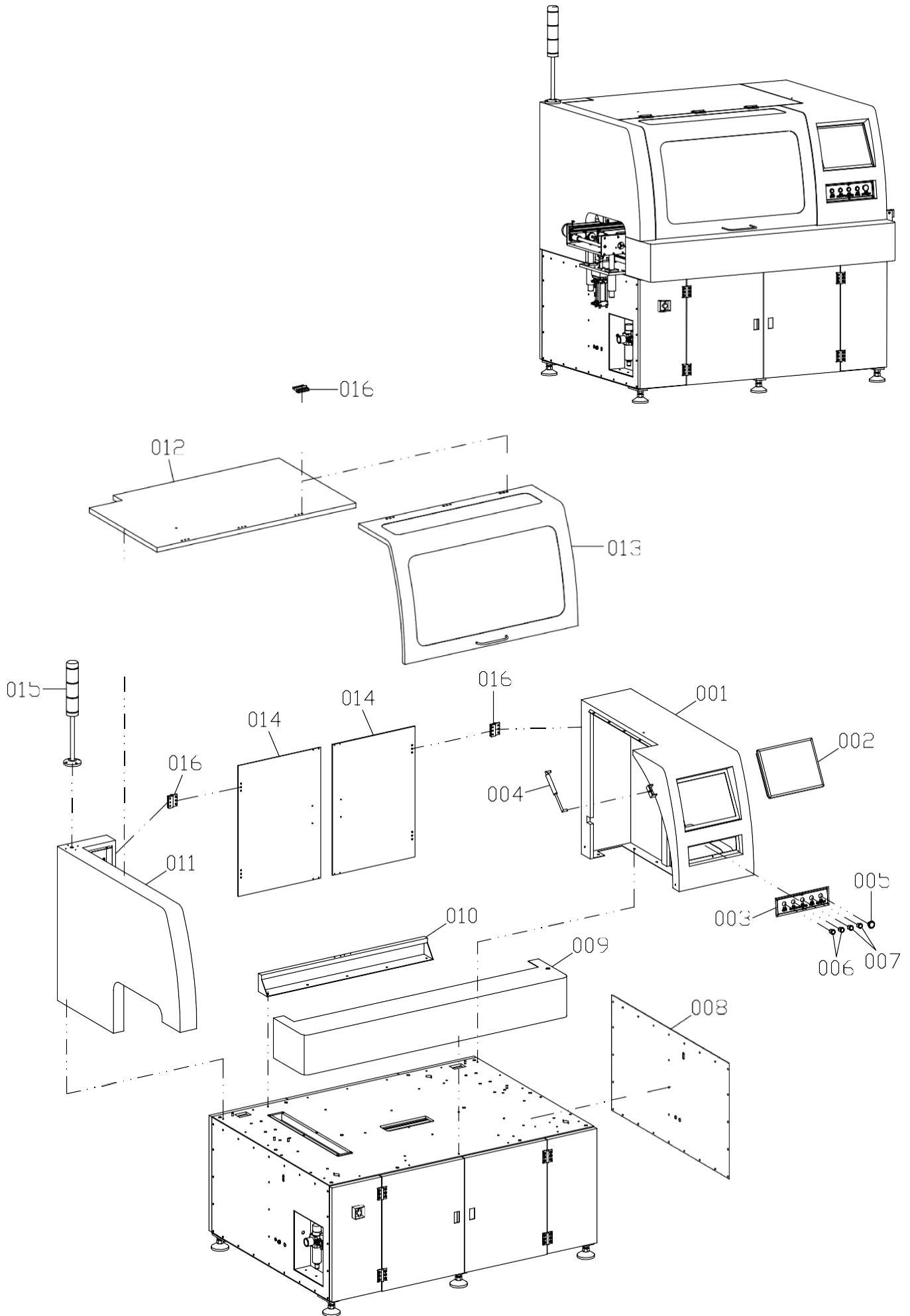


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5 LOADER & UNLOADER SECT. (UNLOADER SECT. -5)

No	Material #	Material Name	Qty	Specification	Remark
001	FW05007AA	PLATE	1		
002	FW05011AA	SHAFT	2		
003	FW05013AA	SHAFT	1		

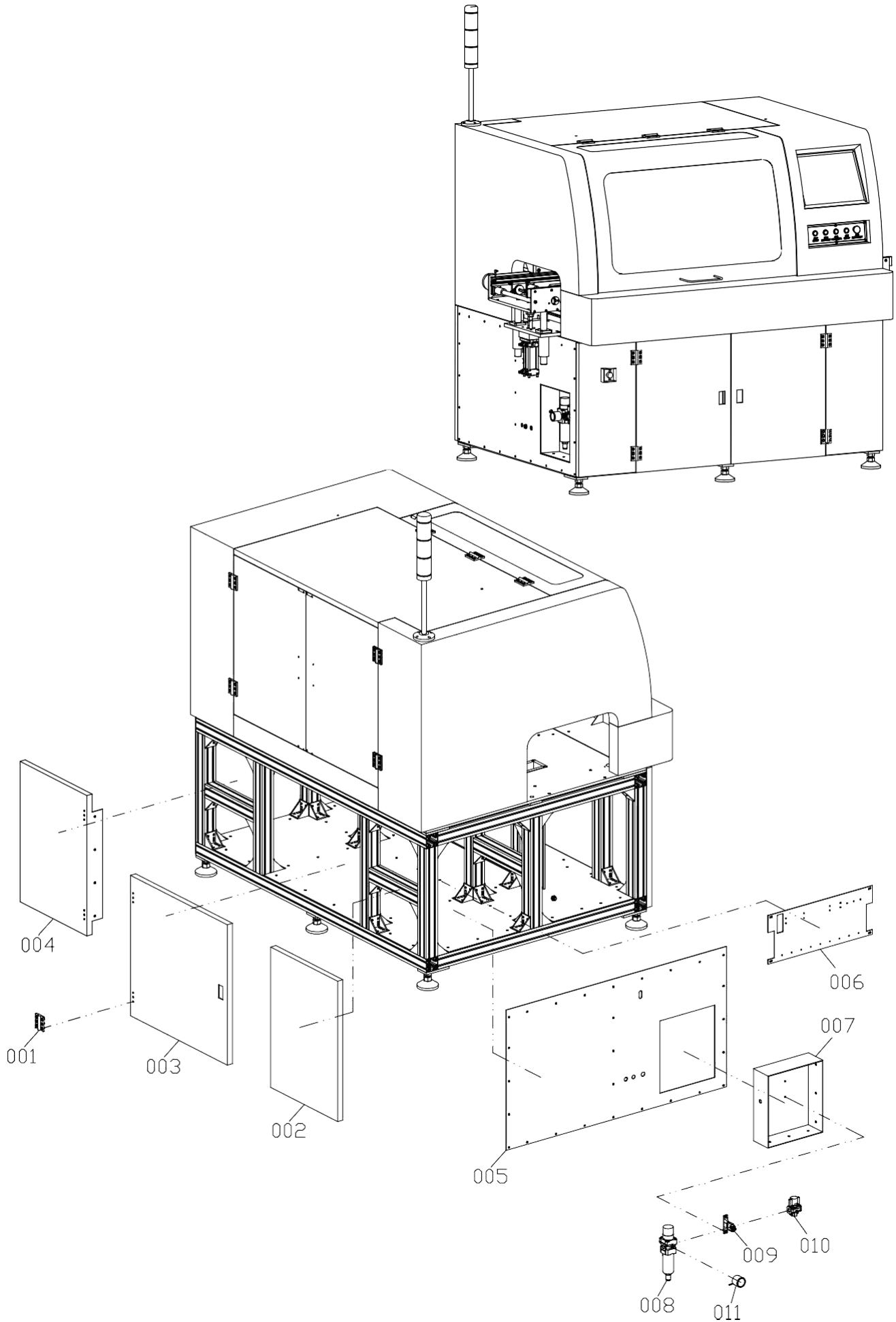




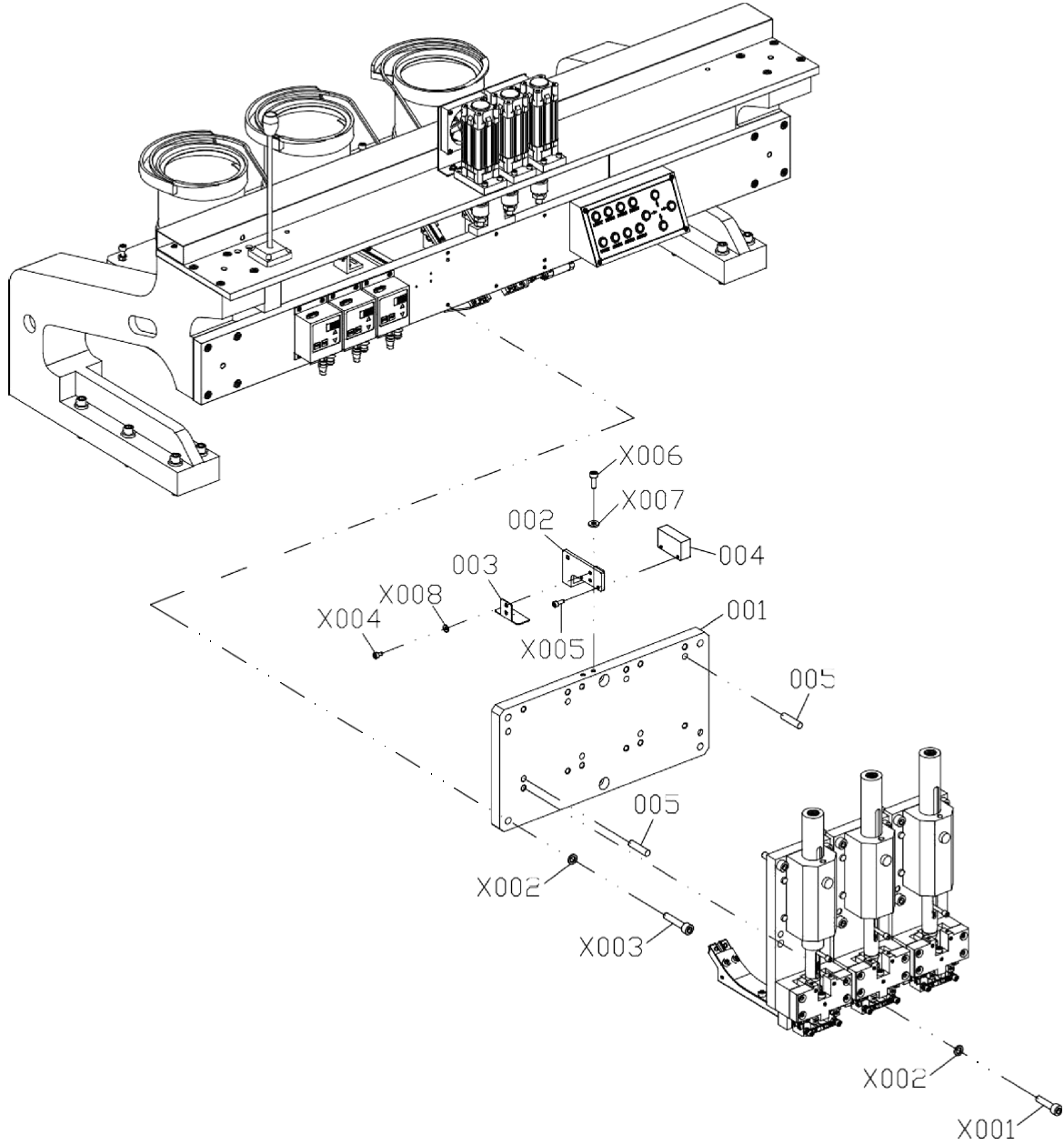
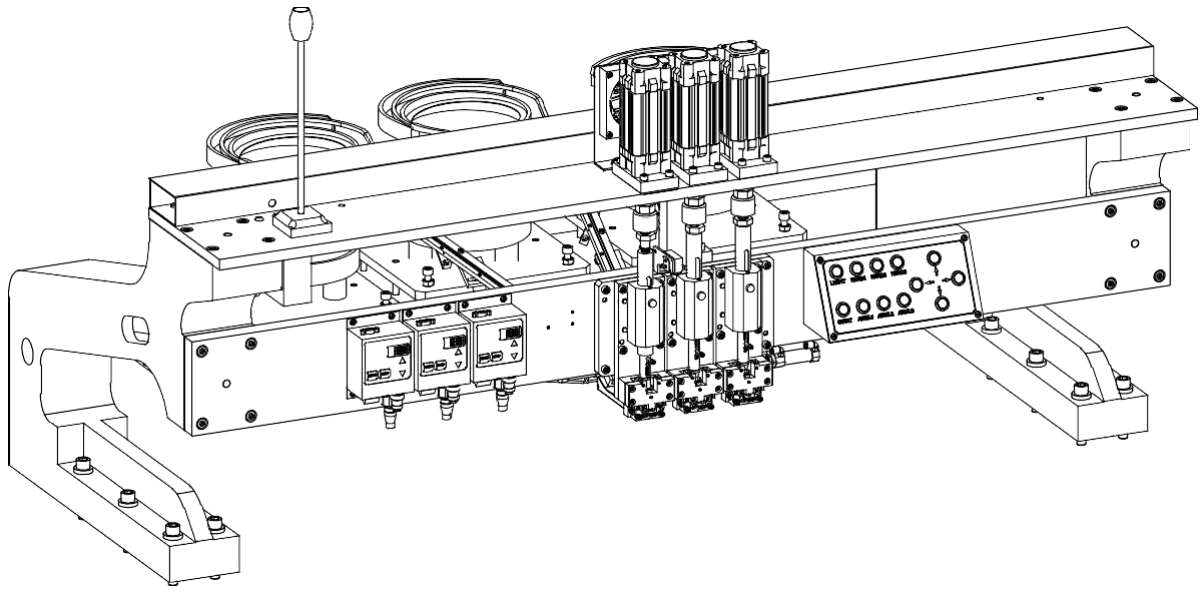
Southern Machinery Sales and Service Co., Limited

6 COVER SECT. -2

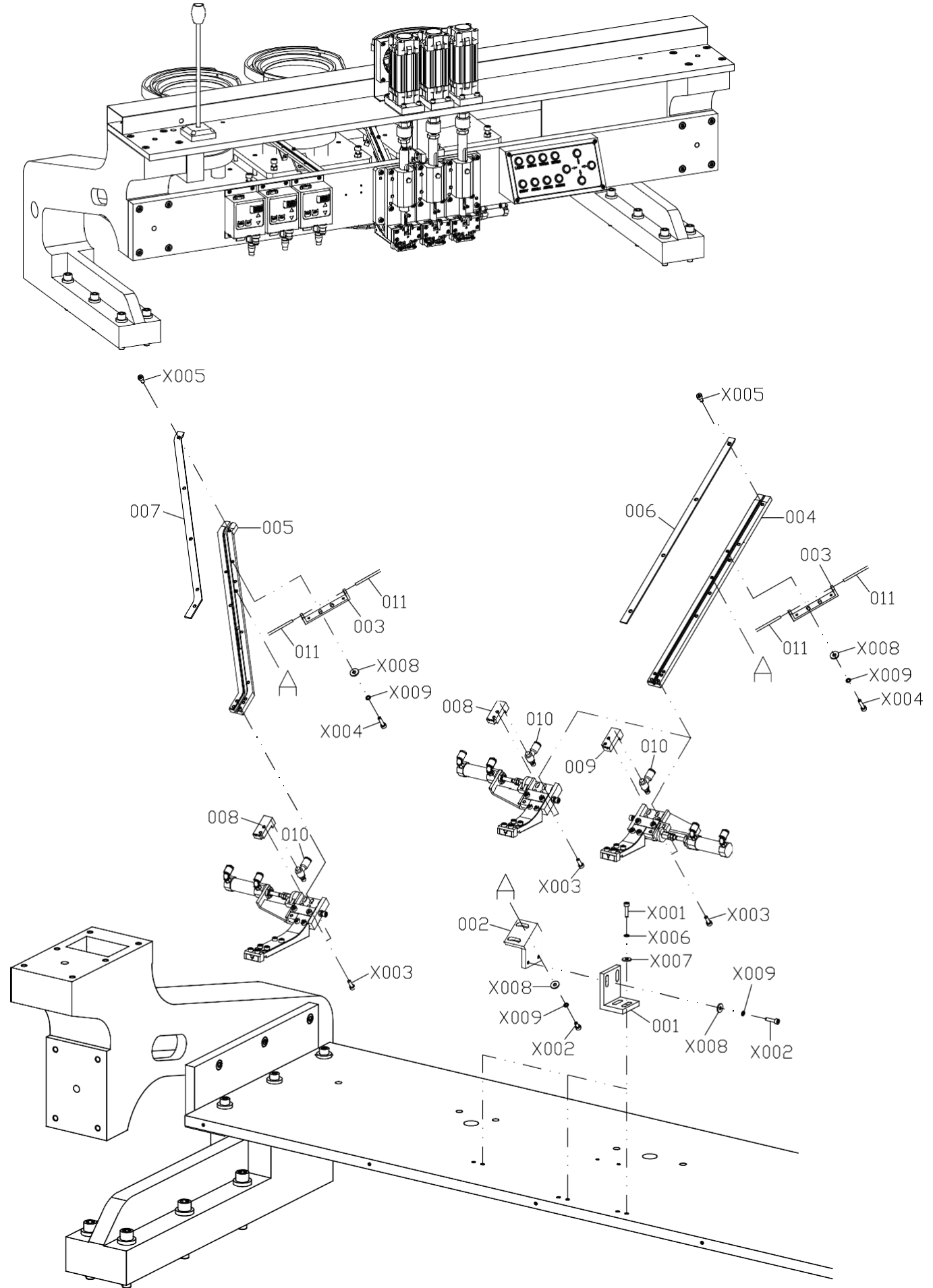
No	Material #	Material Name	Qty	Specification	Remark
001	FW06006AA	COVER	1		
002	FW06007AA	DISPLAYER	1	MT8121IE	
003	FW06008AA	NAMEPLATE	1		
004	FW06009AA	GAS SPRING	2		
005	FW06010AA	SWITCH	1	LAY7 (PBCY090)LAY37	
006	FW06011AA	BUTTON	2		
007	FW06012AA	BUTTON	2		
008	FW06013AA	COVER	1		
009	FW06014AA	COVER	1		
010	FW06015AA	COVER	1		
011	FW06016AA	COVER	1		
012	FW06017AA	COVER	1		
013	FW06018AA	COVER	1		
014	FW06019AA	COVER	2		
015	FW06020AA	SIGNAL LAMP	1		
016	FW06005AA	HINGE	7		



7 INSERTION HEAD SECT. (MAIN BODY SECT.-1)



7 INSERTION HEAD SECT. (MAIN BODY SECT.-2)

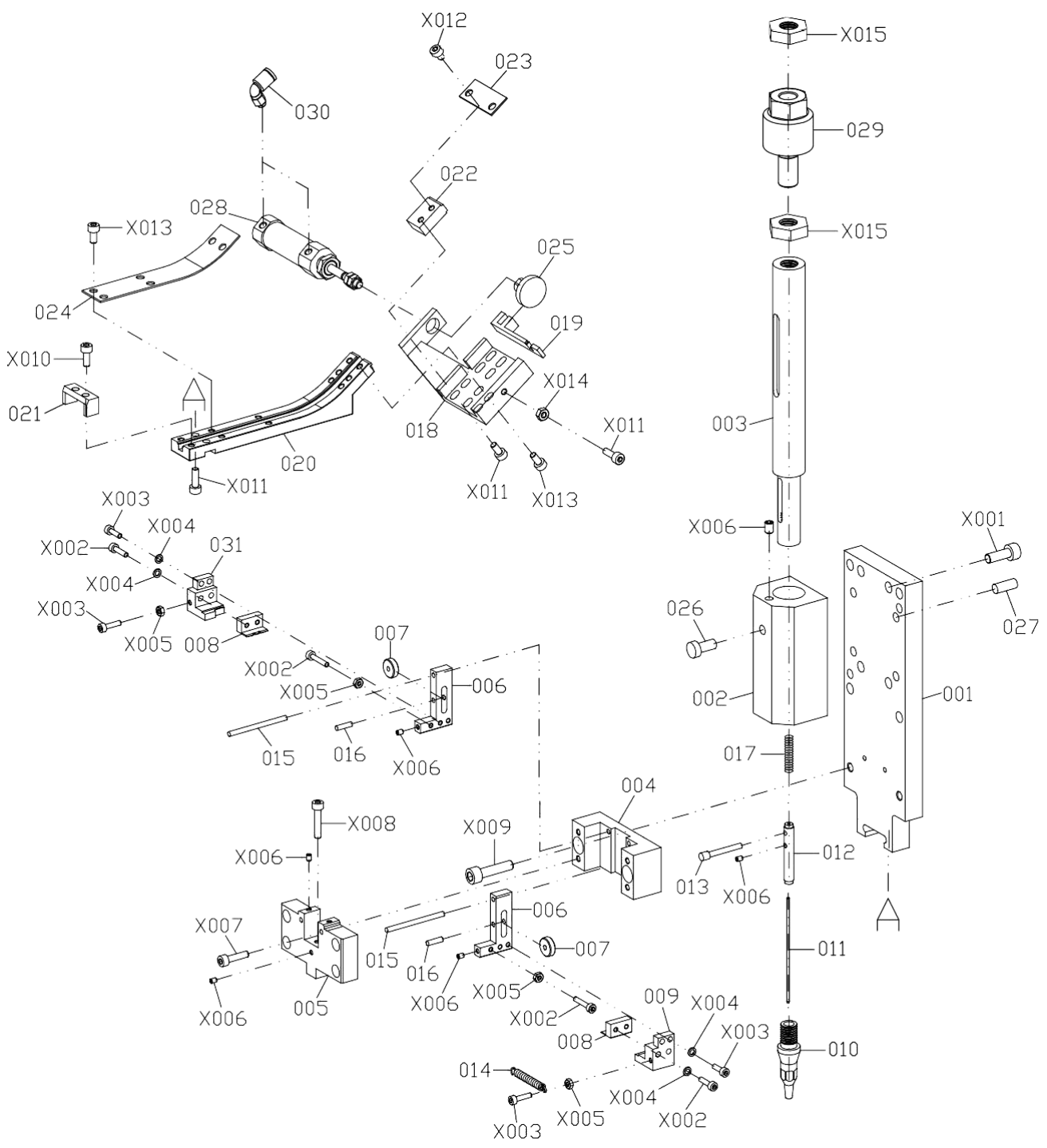
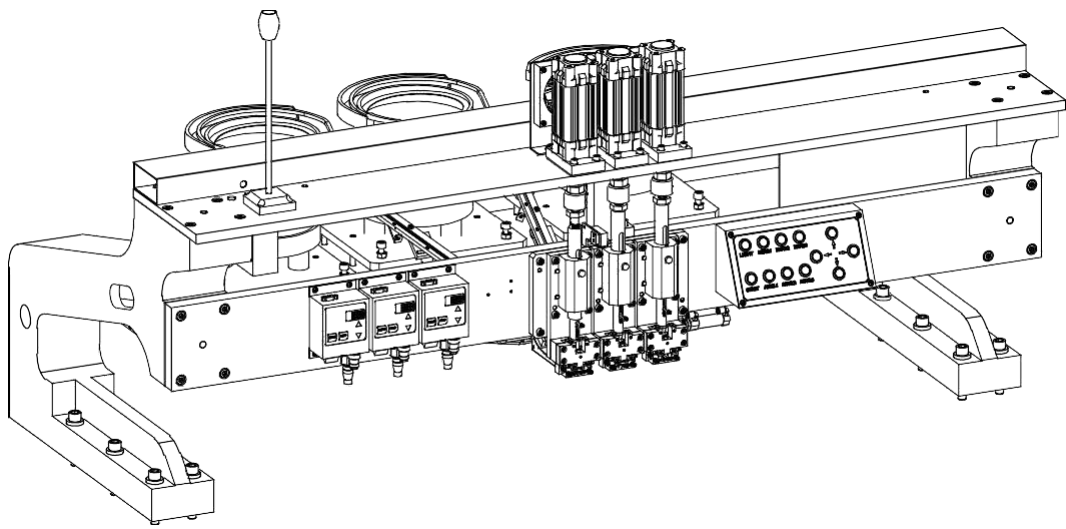


Southern Machinery Sales and Service Co., Limited

7 INSERTION HEAD SECT. (MAIN BODY SECT. -2)

No	Material #	Material Name	Qty	Specification	Remark
001	FW07030AA	BRACKET	3		
002	FW07031AA	BRACKET	3		
003	FW07025AA	BRACKET	3		
004	FW07042AA	GUIDE	2	1.2~4.0 OPTIONAL	
005	FW07043AA	GUIDE	1	1.2~4.0 OPTIONAL	
006	FW07028AA	COVER	2		
007	FW07029AA	COVER	1		
008	FW07018AA	BLOCK	2		
009	FW07017AA	BLOCK	1		
010	FW1211FAA	SPEED CONTROLLER	3	AS1211F-M5-04	
011	FWDCT410AA	OPTICAL FIBER CABLE UNIT	3	DCT-410	
X001	FWSH0520	SOKET HEAD CAP SCREW	6	M5-L20	
X002	FWSH0416	SOKET HEAD CAP SCREW	12	M4-L16	
X003	FWSH0414	SOKET HEAD CAP SCREW	18	M4-L14	
X004	FWSH0412	SOKET HEAD CAP SCREW	6	M4-L12	
X005	FWSH0410	SOKET HEAD CAP SCREW	13	M4-L10	
X006	FWFG0512	FLAT WASHER	6	5-15-H2	
X007	FWSW05	SPRING WASHER	6	5-8-H1.3	
X008	FWFG0412	SOKET HEAD CAP SCREW	18	4-12-H1.5	
X009	FWSW04	SPRING WASHER	18	4-7-H1.0	

7 INSERTION HEAD SECT. (MAIN BODY SECT.-1#)

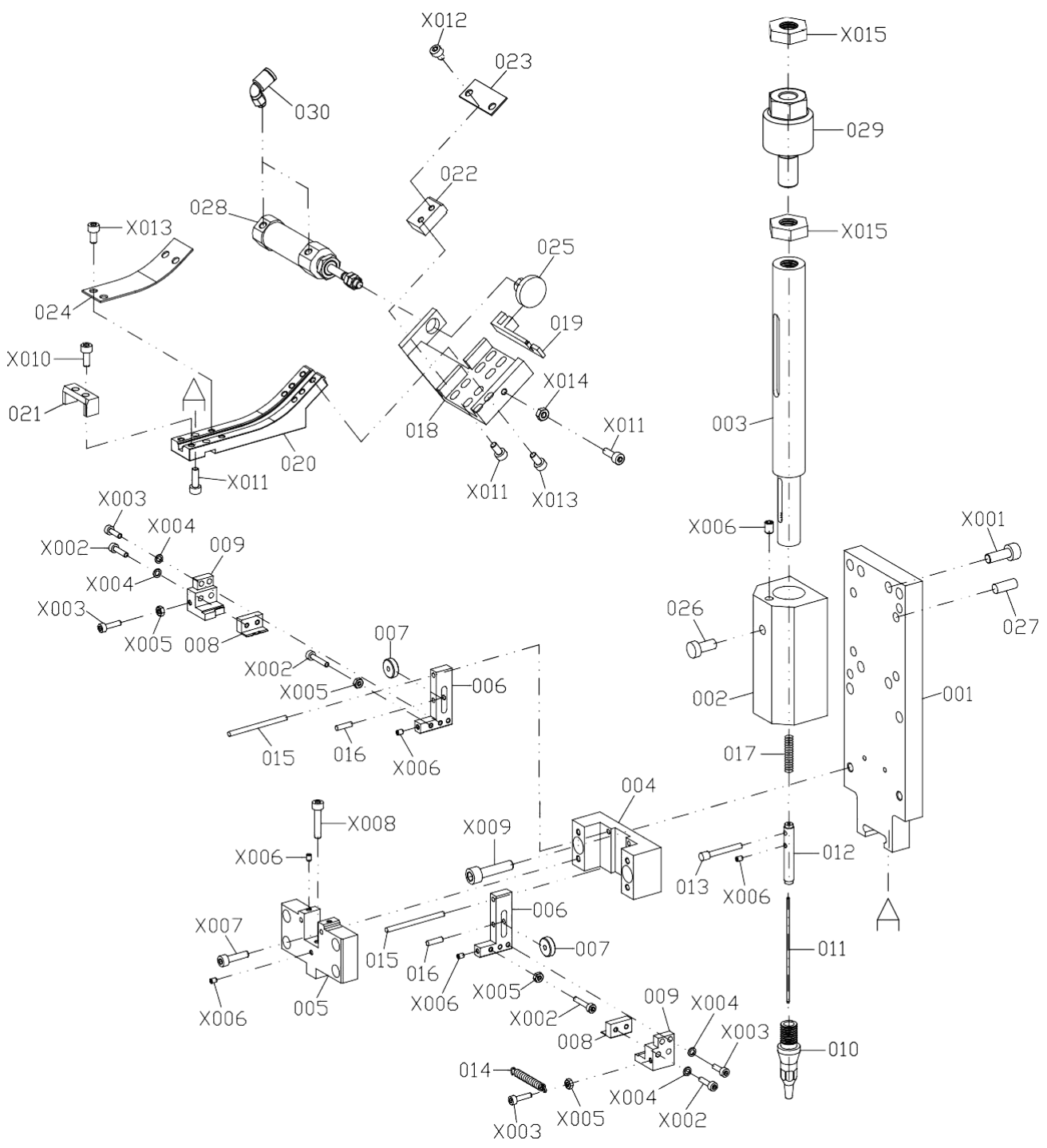
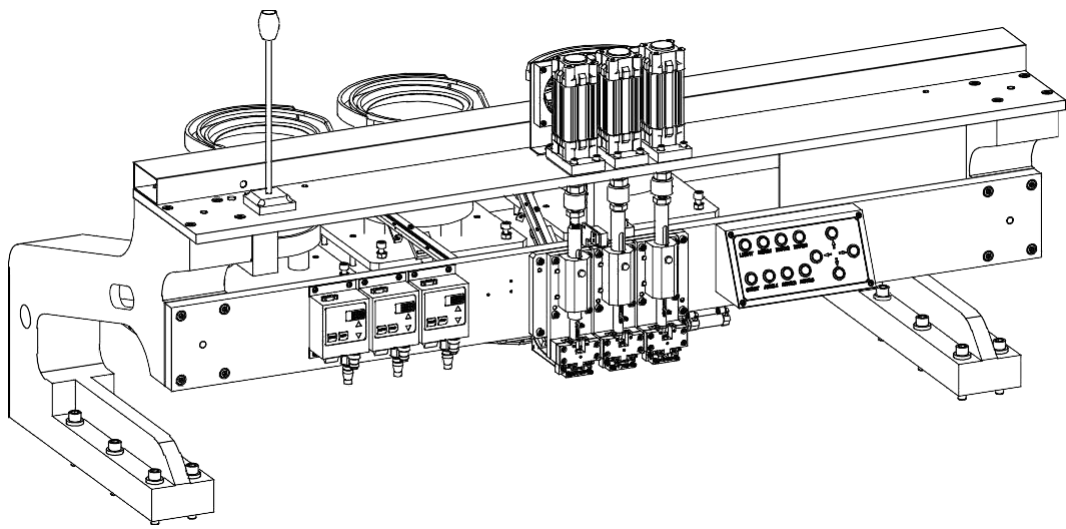


Southern Machinery Sales and Service Co., Limited

7 INSERTION HEAD SECT. (MAIN BODY SECT. -1#)

No	Material #	Material Name	Qty	Specification	Remark
001	FW07002AA	PLATE	1		
002	FW07003AA	FLANGE	1		
003	FW07006AA	SHAFT	1		
004	FW07004AA	BLOCK	1		
005	FW07005AA	PLATE	1		
006	FW07007AA	LEVER	2		
007	FW07011AA	ROLLER	2		
008	FW07038AA	BLOCK	2	1. 2 [~] 4. 0 OPTIONAL	
009	FW07036AA	BLOCK	1	1. 2 [~] 4. 0 OPTIONAL	
010	FW07040AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
011	FW07045AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
012	FW07044AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
013	FW07014AA	PIN	1		
014	FW07023AA	SPRING	1		
015	FW07012AA	PIN	2		
016	FW07013AA	PIN	2		
017	FW07024AA	SPRING	1		
018	FW07008AA	PLATE	1		
019	FW07041AA	LEVER	1	1. 2 [~] 4. 0 OPTIONAL	
020	FW07035AA	PLATE	1	1. 2 [~] 4. 0 OPTIONAL	
021	FW07020AA	PLATE	1		
022	FW07019AA	PLATE	1		
023	FW07009AA	COVER	1		
024	FW07027AA	COVER	1		
025	FW07022AA	ROD	1		
026	FW07021AA	PIN	1		
027	FWP0615AA	PIN	4	φ6-L15	
028	FW2B1615Z	CYLINDER	1	CDJ2B16-15Z-B	
029	FWJA40AA	FLOATING JOINT	1	JA40-12-125	
030	FWASM506AA	SPEED CONTROLLER	2	AS1201F M5-06	
031	FW07037AA	BLOCK	1	1. 2 [~] 4. 0 OPTIONAL	
X001	FWSH0616	SOKET HEAD CAP SCREW	4	M6-L16	
X002	FWSH0314	SOKET HEAD CAP SCREW	6	M3-L14	
X003	FWSH0312	SOKET HEAD CAP SCREW	6	M3-L12	
X004	FWSW03	SPRING WASHER	8	3-4-H1. 0	
X005	FWHEX03	HEXAGON NUT	4	M3	
X006	FWSS0304	SUNK SCREW	6	M3-L04	
X007	FWSH0416	SOKET HEAD CAP SCREW	4	M4-L16	
X008	FWSH0420	SOKET HEAD CAP SCREW	1	M4-L20	
X009	FWSH0625	SOKET HEAD CAP SCREW	2	M6-L25	
X010	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X011	FWSH0412	SOKET HEAD CAP SCREW	6	M4-L12	
X012	FWSH0405	SOKET HEAD CAP SCREW	2	M4-L05	
X013	FWSH0408	SOKET HEAD CAP SCREW	8	M4-L08	
X014	FWHEX04	HEXAGON NUT	1	M4	
X015	FWHEX12T	HEXAGON NUT	2	M12X1. 25	

7 INSERTION HEAD SECT. (MAIN BODY SECT.-2#)

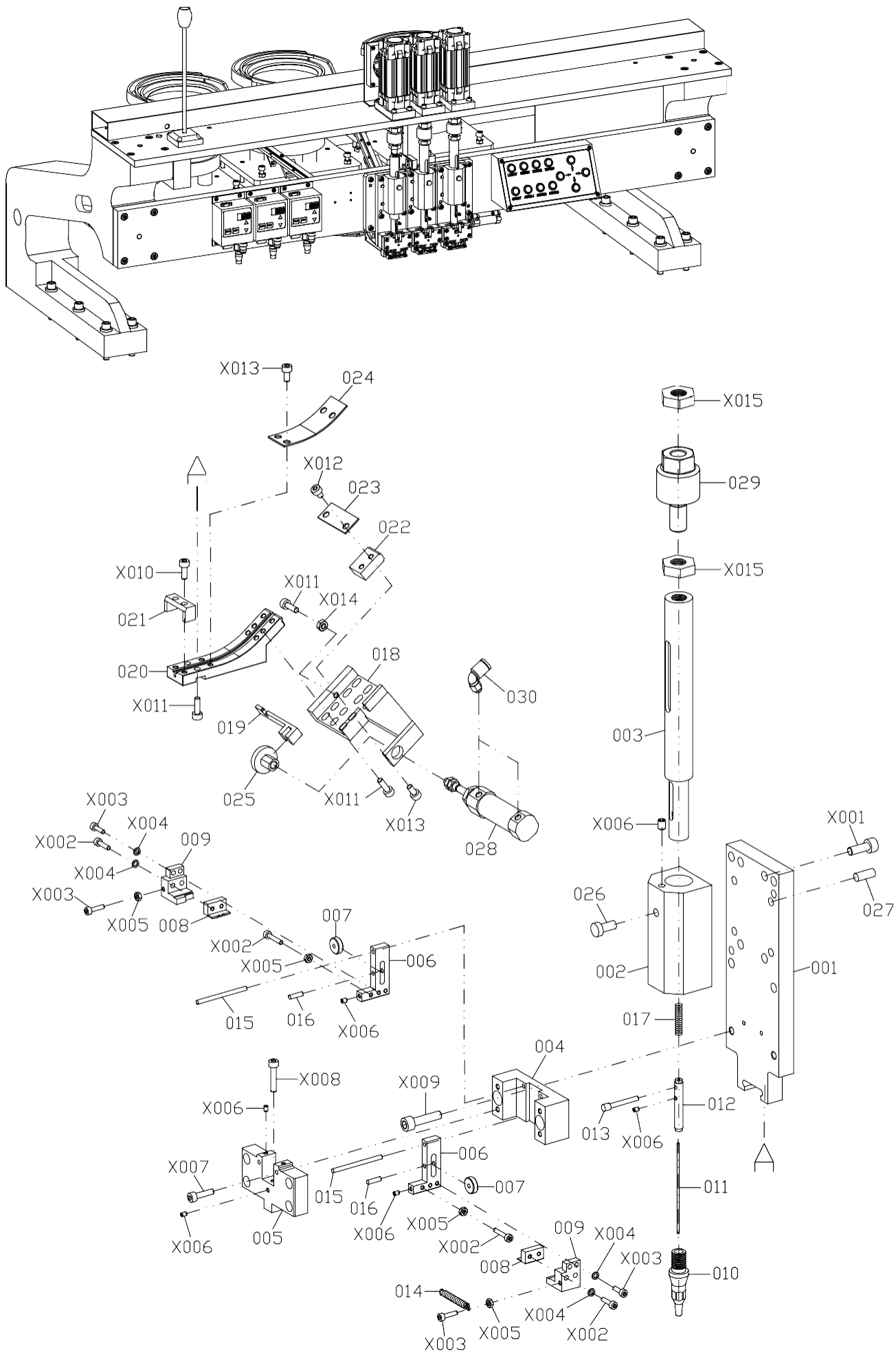


Southern Machinery Sales and Service Co., Limited

7 INSERTION HEAD SECT. (MAIN BODY SECT. -2#)

No	Material #	Material Name	Qty	Specification	Remark
001	FW07002AA	PLATE	1		
002	FW07003AA	FLANGE	1		
003	FW07006AA	SHAFT	1		
004	FW07004AA	BLOCK	1		
005	FW07005AA	PLATE	1		
006	FW07007AA	LEVER	2		
007	FW07011AA	ROLLER	2		
008	FW07038AA	BLOCK	2	1. 2 [~] 4. 0 OPTIONAL	
009	FW07036AA	BLOCK	2	1. 2 [~] 4. 0 OPTIONAL	
010	FW07040AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
011	FW07045AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
012	FW07044AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
013	FW07014AA	PIN	1		
014	FW07023AA	SPRING	1		
015	FW07012AA	PIN	2		
016	FW07013AA	PIN	2		
017	FW07024AA	SPRING	1		
018	FW07008AA	PLATE	1		
019	FW07041AA	LEVER	1	1. 2 [~] 4. 0 OPTIONAL	
020	FW07034AA	PLATE	1	1. 2 [~] 4. 0 OPTIONAL	
021	FW07020AA	PLATE	1		
022	FW07017AA	PLATE	1		
023	FW07009AA	COVER	1		
024	FW07026AA	COVER	1		
025	FW07022AA	ROD	1		
026	FW07021AA	PIN	1		
027	FWP0615AA	PIN	4	φ6-L15	
028	FW2B1615Z	CYLINDER	1	CDJ2B16-15Z-B	
029	FWJA40AA	FLOATING JOINT	1	JA40-12-125	
030	FWASM506AA	SPEED CONTROLLER	2	AS1201F M5-06	
031	FW07037AA	BLOCK	1	1. 2 [~] 4. 0 OPTIONAL	
X001	FWSH0616	SOKET HEAD CAP SCREW	4	M6-L16	
X002	FWSH0314	SOKET HEAD CAP SCREW	6	M3-L14	
X003	FWSH0312	SOKET HEAD CAP SCREW	6	M3-L12	
X004	FWSW03	SPRING WASHER	8	3-4-H1. 0	
X005	FWHEX03	HEXAGON NUT	4	M3	
X006	FWSS0304	SUNK SCREW	6	M3-L04	
X007	FWSH0416	SOKET HEAD CAP SCREW	4	M4-L16	
X008	FWSH0420	SOKET HEAD CAP SCREW	1	M4-L20	
X009	FWSH0625	SOKET HEAD CAP SCREW	2	M6-L25	
X010	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X011	FWSH0412	SOKET HEAD CAP SCREW	6	M4-L12	
X012	FWSH0405	SOKET HEAD CAP SCREW	2	M4-L05	
X013	FWSH0408	SOKET HEAD CAP SCREW	6	M4-L08	
X014	FWHEX04	HEXAGON NUT	1	M4	
X015	FWHEX12T	HEXAGON NUT	2	M12X1. 25	

7 INSERTION HEAD SECT. (MAIN BODY SECT.-3#)

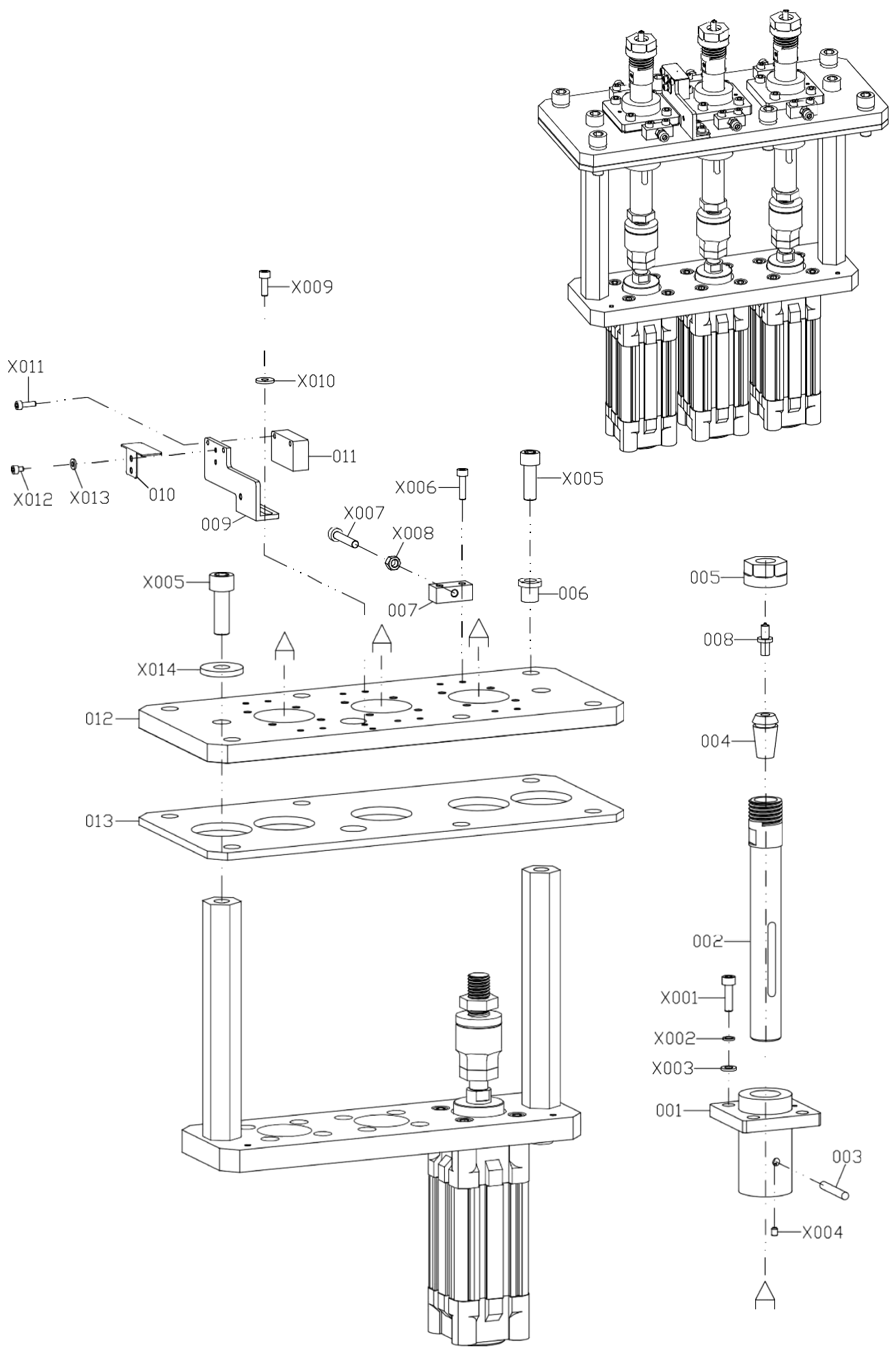


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7 INSERTION HEAD SECT. (MAIN BODY SECT. -3#)

No	Material #	Material Name	Qty	Specification	Remark
001	FW07002AA	PLATE	1		
002	FW07003AA	FLANGE	1		
003	FW07006AA	SHAFT	1		
004	FW07004AA	BLOCK	1		
005	FW07005AA	PLATE	1		
006	FW07007AA	LEVER	2		
007	FW07011AA	ROLLER	2		
008	FW07038AA	BLOCK	2	1. 2 [~] 4. 0 OPTIONAL	
009	FW07036AA	BLOCK	2	1. 2 [~] 4. 0 OPTIONAL	
010	FW07040AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
011	FW07045AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
012	FW07044AA	PIN	1	1. 2 [~] 4. 0 OPTIONAL	
013	FW07014AA	PIN	1		
014	FW07023AA	SPRING	1		
015	FW07012AA	PIN	2		
016	FW07013AA	PIN	2		
017	FW07024AA	SPRING	1		
018	FW07008AA	PLATE	1		
019	FW07041AA	LEVER	1	1. 2 [~] 4. 0 OPTIONAL	
020	FW07034AA	PLATE	1	1. 2 [~] 4. 0 OPTIONAL	
021	FW07020AA	PLATE	1		
022	FW07017AA	PLATE	1		
023	FW07009AA	COVER	1		
024	FW07026AA	COVER	1		
025	FW07022AA	ROD	1		
026	FW07021AA	PIN	1		
027	FWP0615AA	PIN	4	φ6-L15	
028	FW2B1615Z	CYLINDER	1	CDJ2B16-15Z-B	
029	FWJA40AA	FLOATING JOINT	1	JA40-12-125	
030	FWASM506AA	SPEED CONTROLLER	2	AS1201F M5-06	
031	FW07037AA	BLOCK	1	1. 2 [~] 4. 0 OPTIONAL	
X001	FWSH0616	SOKET HEAD CAP SCREW	4	M6-L16	
X002	FWSH0314	SOKET HEAD CAP SCREW	6	M3-L14	
X003	FWSH0312	SOKET HEAD CAP SCREW	6	M3-L12	
X004	FWSW03	SPRING WASHER	8	3-4-H1. 0	
X005	FWHEX03	HEXAGON NUT	4	M3	
X006	FWSS0304	SUNK SCREW	6	M3-L04	
X007	FWSH0416	SOKET HEAD CAP SCREW	4	M4-L16	
X008	FWSH0420	SOKET HEAD CAP SCREW	1	M4-L20	
X009	FWSH0625	SOKET HEAD CAP SCREW	2	M6-L25	
X010	FWSH0410	SOKET HEAD CAP SCREW	2	M4-L10	
X011	FWSH0412	SOKET HEAD CAP SCREW	6	M4-L12	
X012	FWSH0405	SOKET HEAD CAP SCREW	2	M4-L05	
X013	FWSH0408	SOKET HEAD CAP SCREW	6	M4-L08	
X014	FWHEX04	HEXAGON NUT	1	M4	
X015	FWHEX12T	HEXAGON NUT	2	M12X1. 25	

8 LOWER ANVIL SECT.

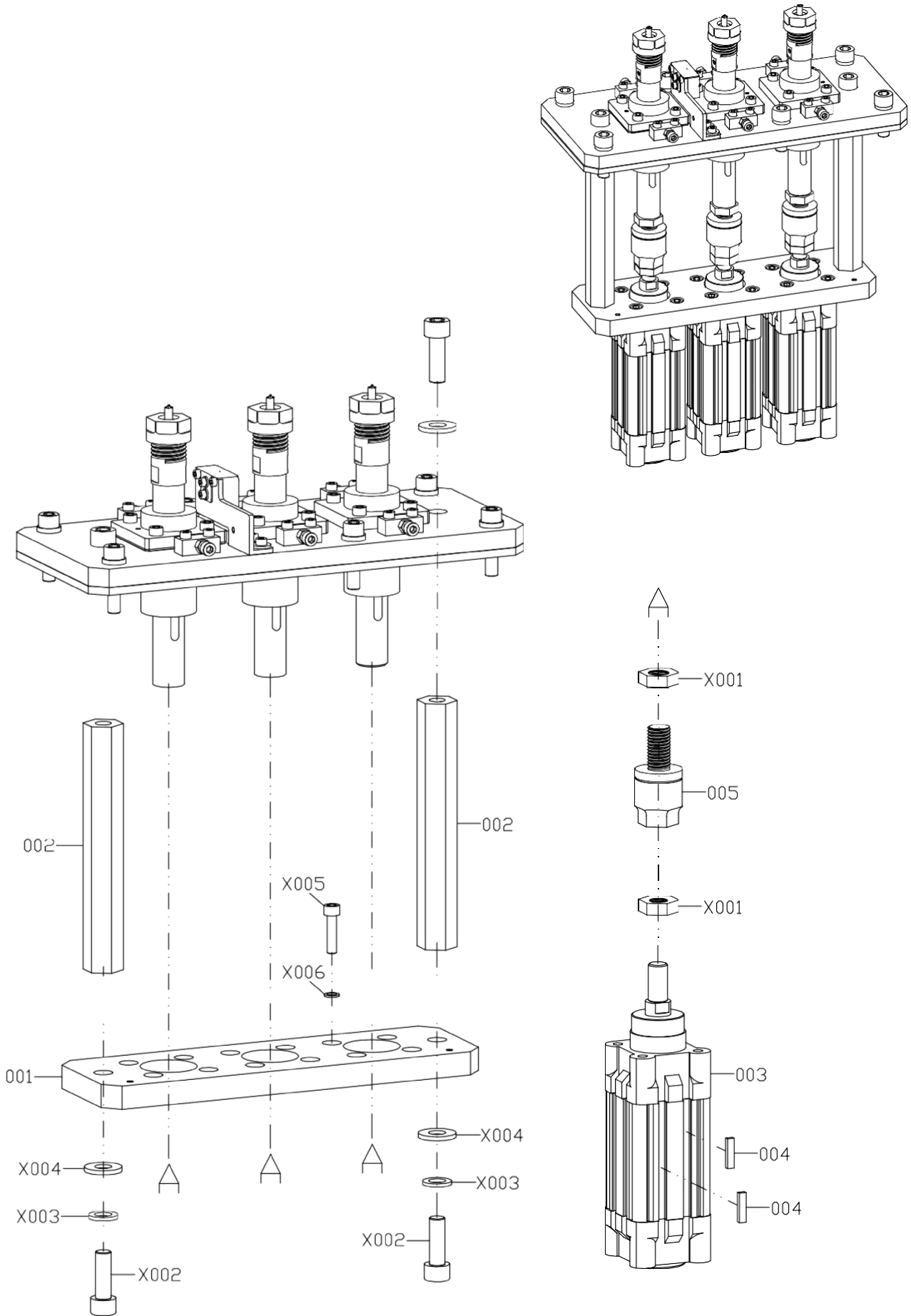


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8 LOWER ANVIL SECT. (MAIN BODY SECT. -1)

No	Material #	Material Name	Qty	Specification	Remark
001	FW08003AA	FLANGE	3		
002	FW08004AA	SHAFT	3		
003	FW08009AA	PIN	3		
004	FW08011AA	COLLET	3	ø6	
005	FW08012AA	ER-NUT	3	ER16-A	
006	FW08005AA	COLLAR	6		
007	FW08006AA	BLOCK	6		
008	FW08013AA	FORMING DIE	3	1.2~4.0 OPTIONAL	
009	FW08010AA	BRACKET	1		
010	FW07032AA	BRACKET	1		
011	FWE3ZLT61	SENSOR	1	E3Z-LT61-DLOT	
012	FW08001AA	PLATE	1		
013	FW08002AA	PLATE	1		
X001	FWSH0520	SOKET HEAD CAP SCREW	12	M5-L20	
X002	FWSW05	SPRING WASHER	12	5-8-H1.3	
X003	FWFG0512	FLAT WASHER	12	5-15-H2	
X004	FWSS0405	SUNK SCREW	6	M4-L05	
X005	FWSH0835	SOKET HEAD CAP SCREW	8	M8-L35	
X006	FWSH0416	SOKET HEAD CAP SCREW	12	M4-L16	
X007	FWSH0530	SOKET HEAD CAP SCREW	6	M5-L30	
X008	FWHEX05	HEXAGON NUT	6	M5	
X009	FWSH0412	SOKET HEAD CAP SCREW	2	M4-L12	
X010	FWFG0412	FLAT WASHER	2	4-12-H1.5	
X011	FWSH0310	SOKET HEAD CAP SCREW	2	M3-L10	
X012	FWSH0304	SOKET HEAD CAP SCREW	2	M3-L04	
X013	FWFG0307	FLAT WASHER	2	3-9-H1	
X014	FWFG0821	FLAT WASHER	2	8-21-H4	

8 LOWER ANVIL SECT.



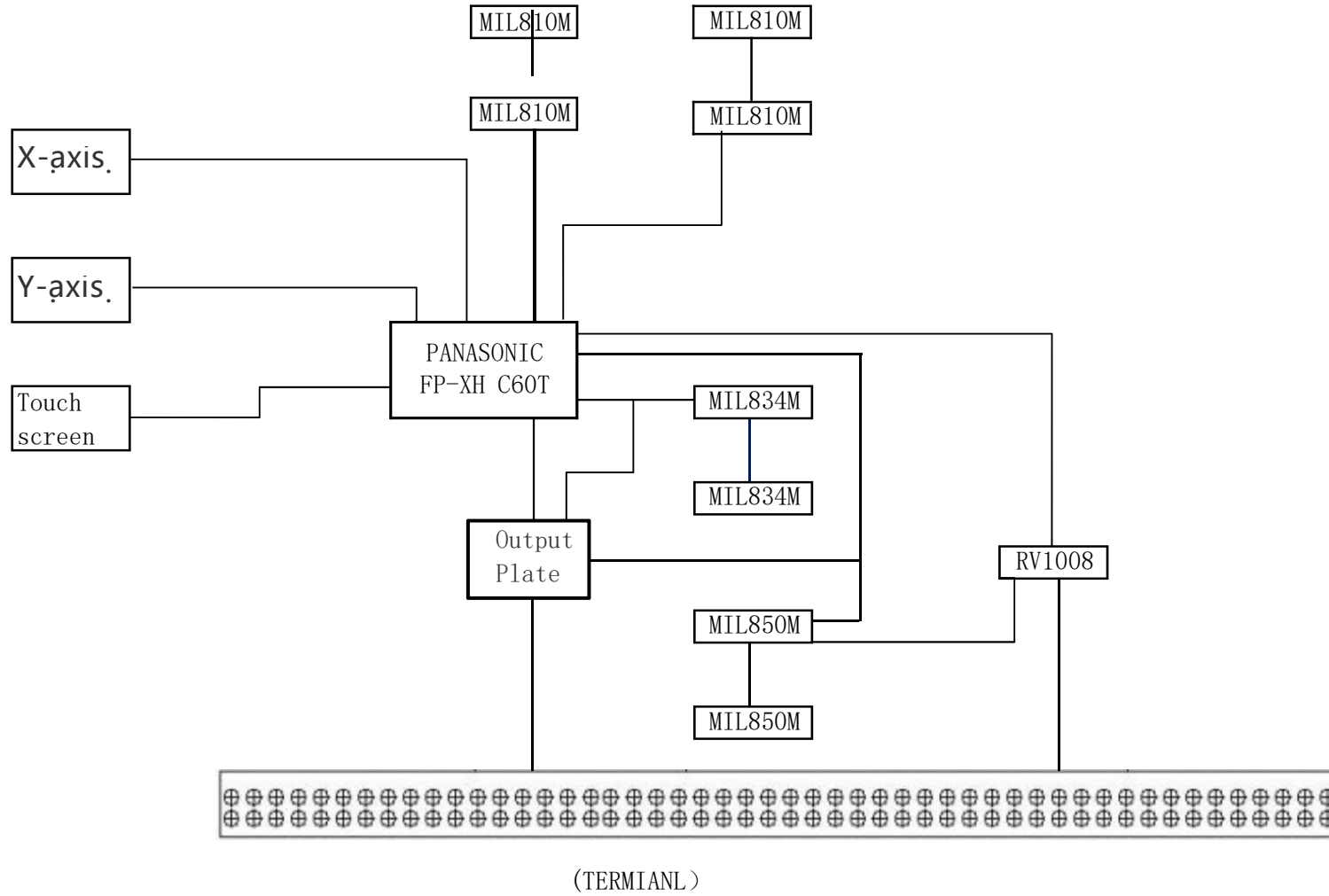
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8 LOWER ANVIL SECT. (MAIN BODY SECT. -2)

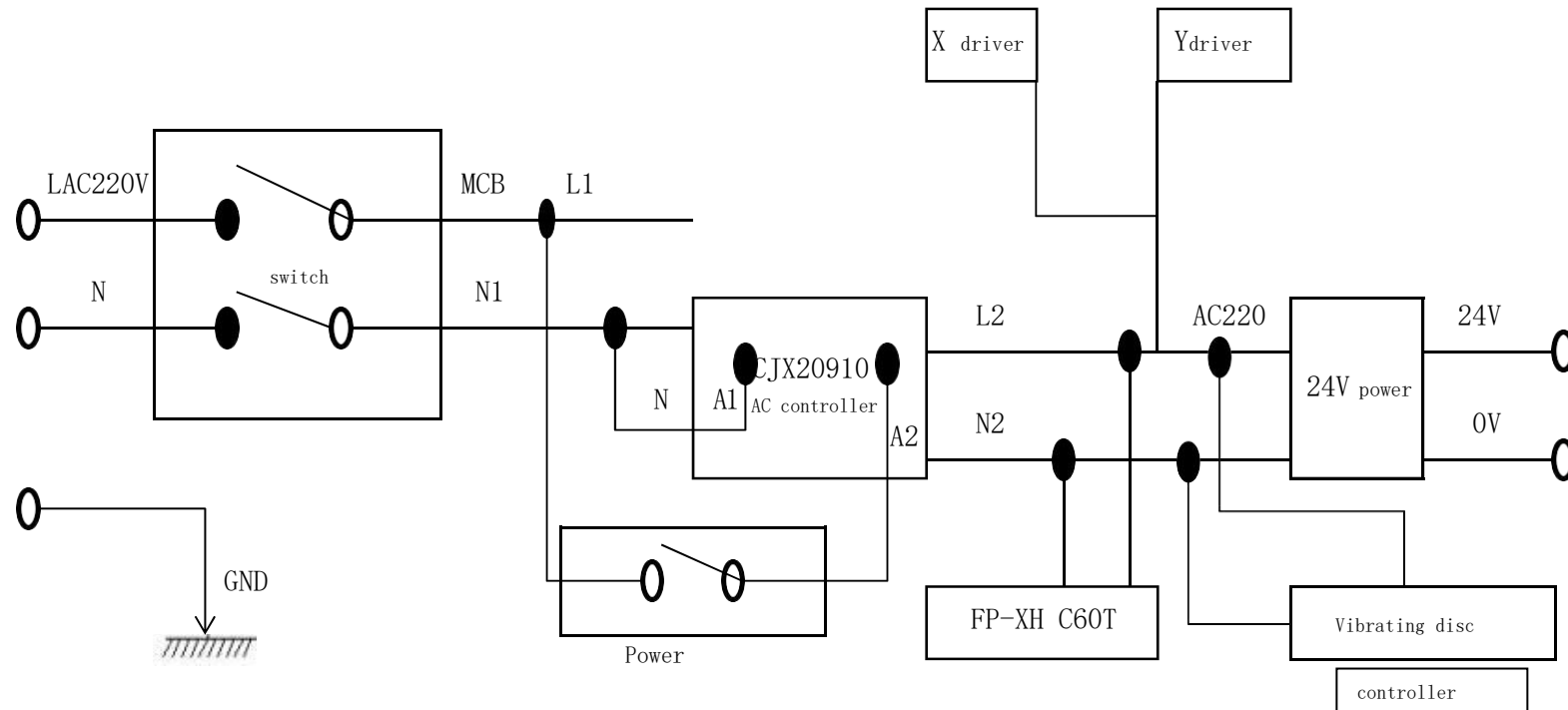
No	Material #	Material Name	Qty	Specification	Remark
001	FW08008AA	PLATE	1		
002	FW08007AA	ROD	2		
003	FWDSBC4025	CYLINDER	3	DSBC40-25-PPVA-N3	
004	FW08014AA	SWITCH	6		
005	FWJA40AA	FLOATING JOINT	3	JA40-12-125	
X001	FWHEX12T	HEXAGON NUT	6	M12X1.25	
X003	FWSW10	SPRING WASHER	4	10-15.5-H2.5	
X005	FWSH0625	SOKET HEAD CAP SCREW	12	M6-L25	
X006	FWSW06	SPRING WASHER	12	6-9.5-H1.6	

Southern Machinery Sales and Service Co., Limited

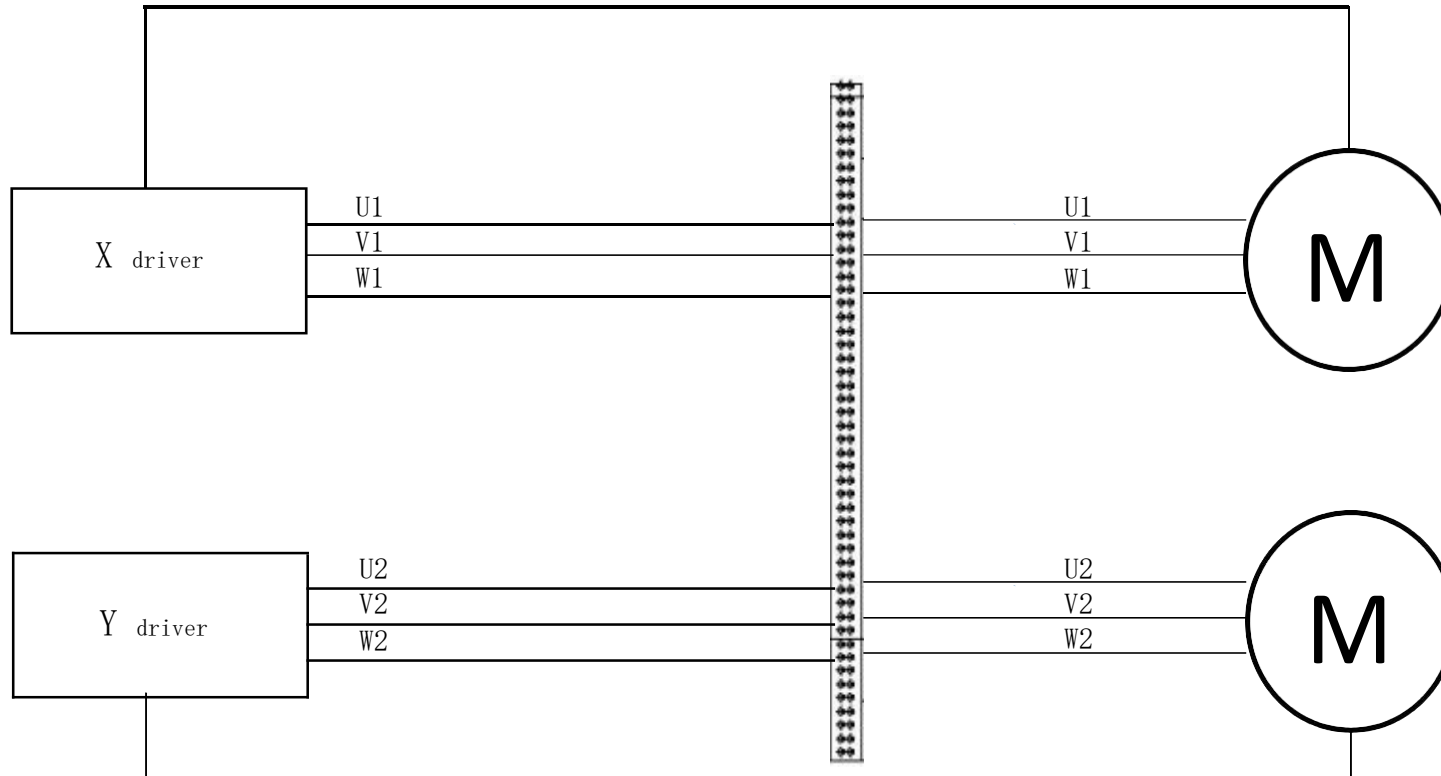
1、plot plan



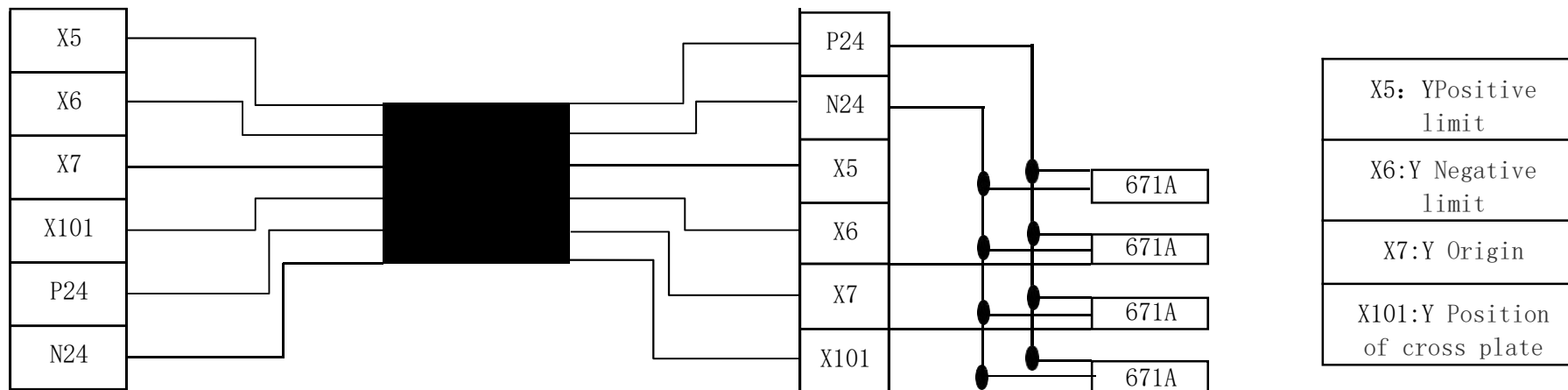
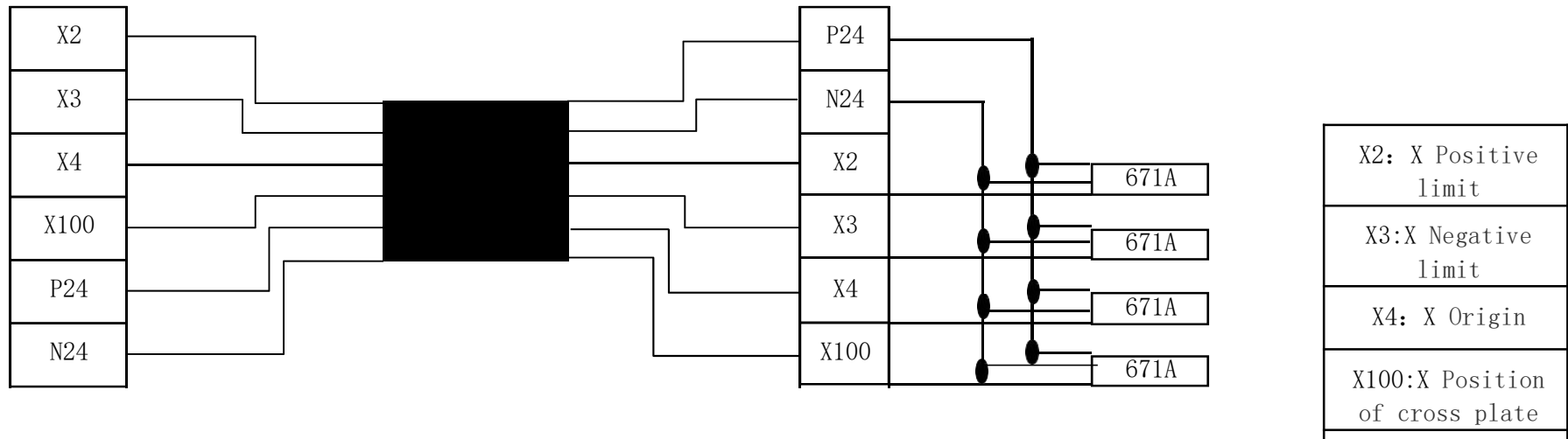
2. Main power line of the machine



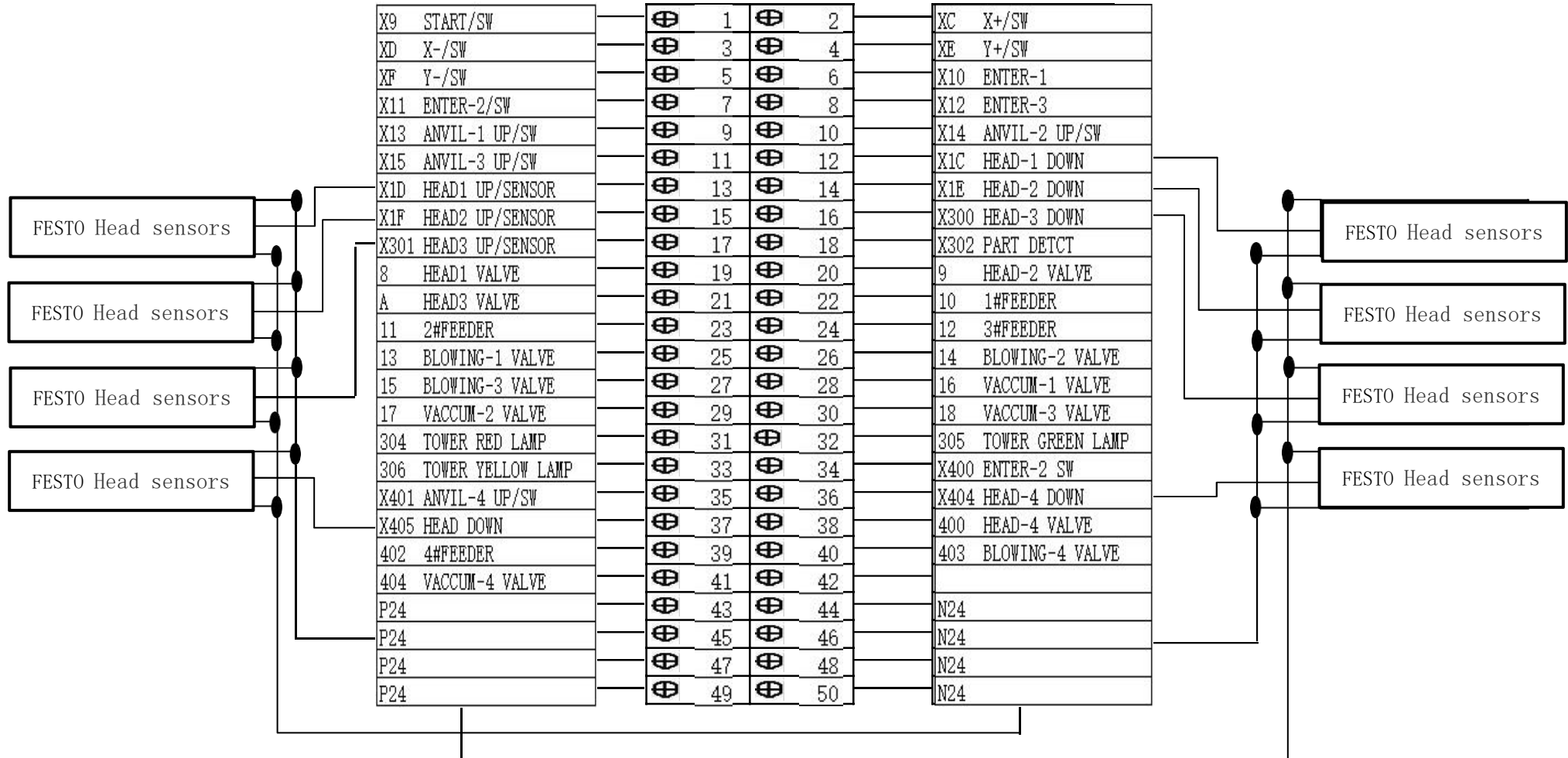
3、XY servo line



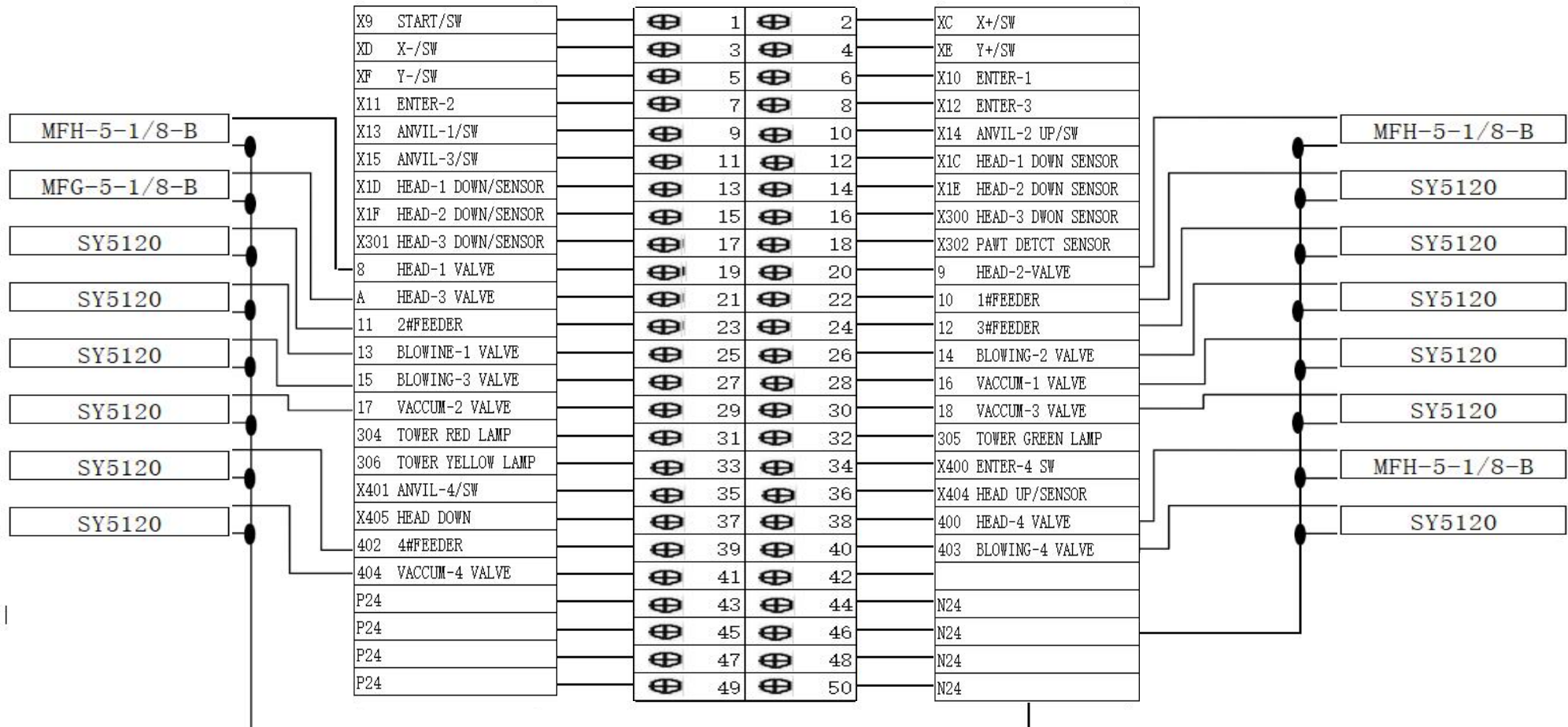
4、 Servo sensor circuit



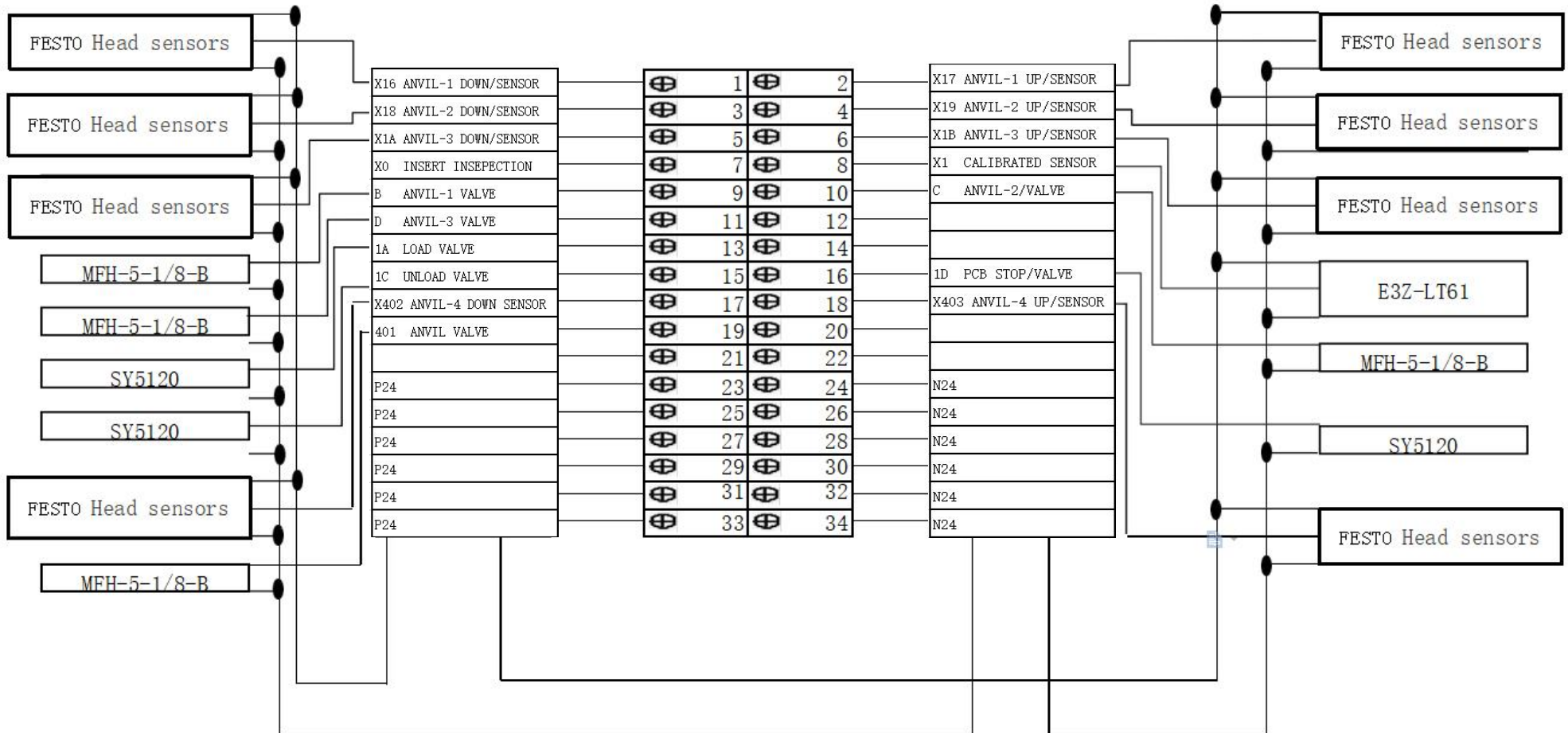
5、HEAD I/O Line (input)



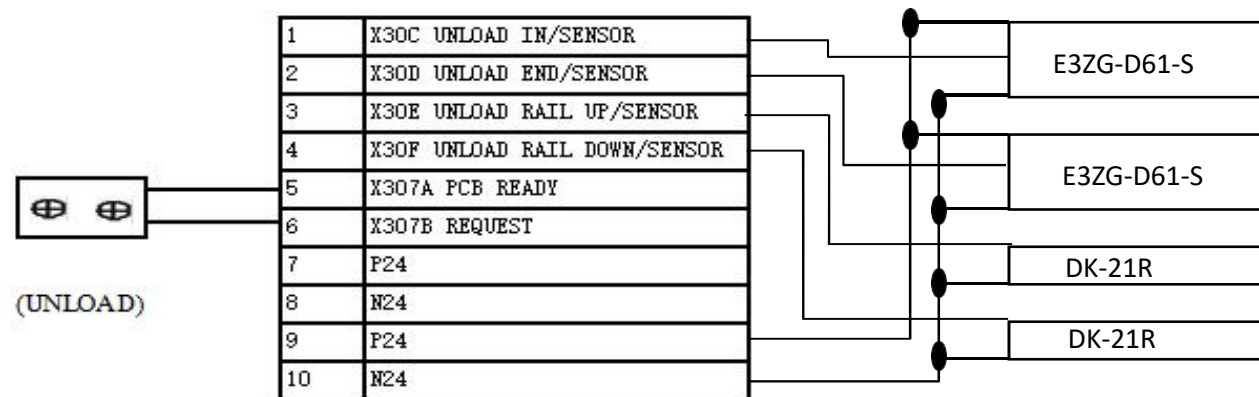
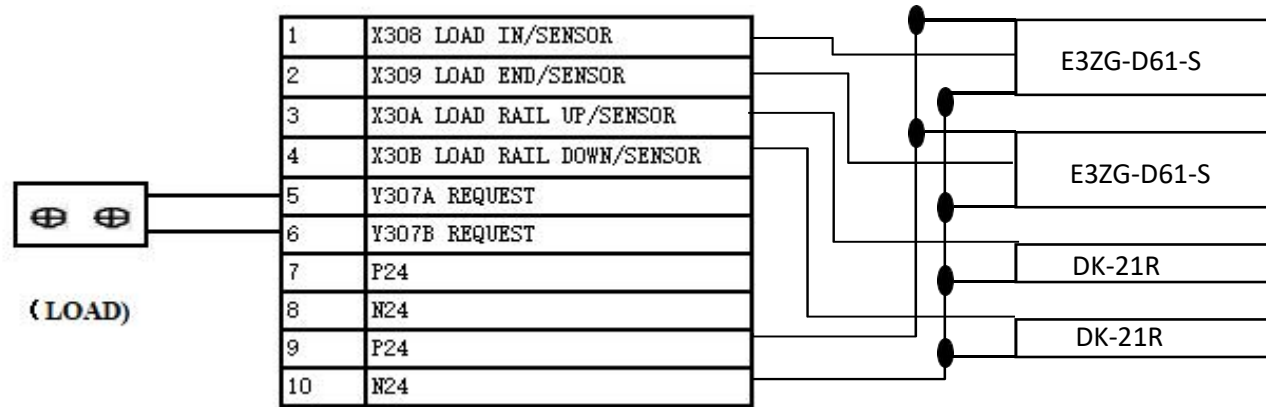
6、HEAD I/O Line (input)



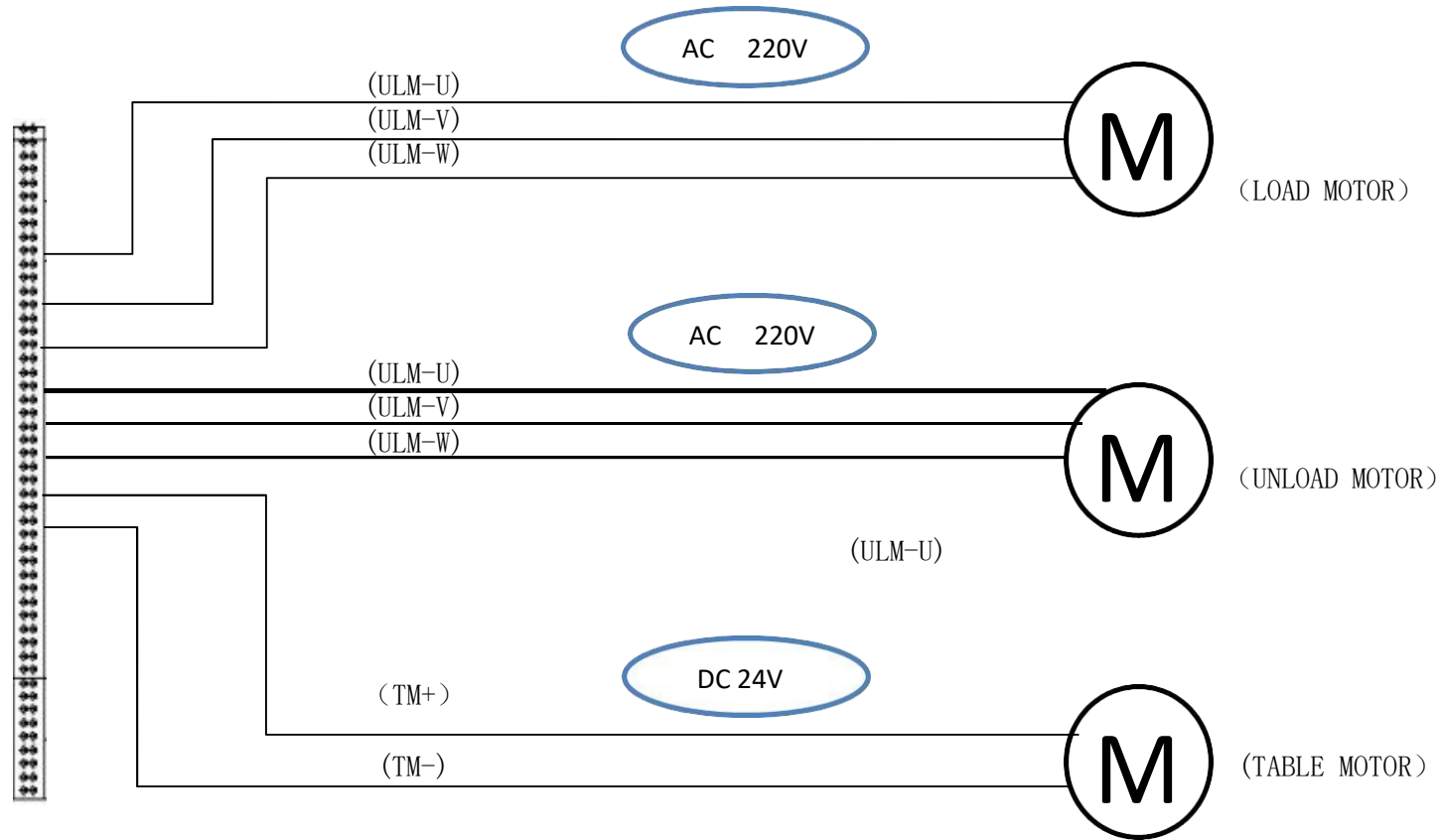
7、ANVIL I/O WIRING



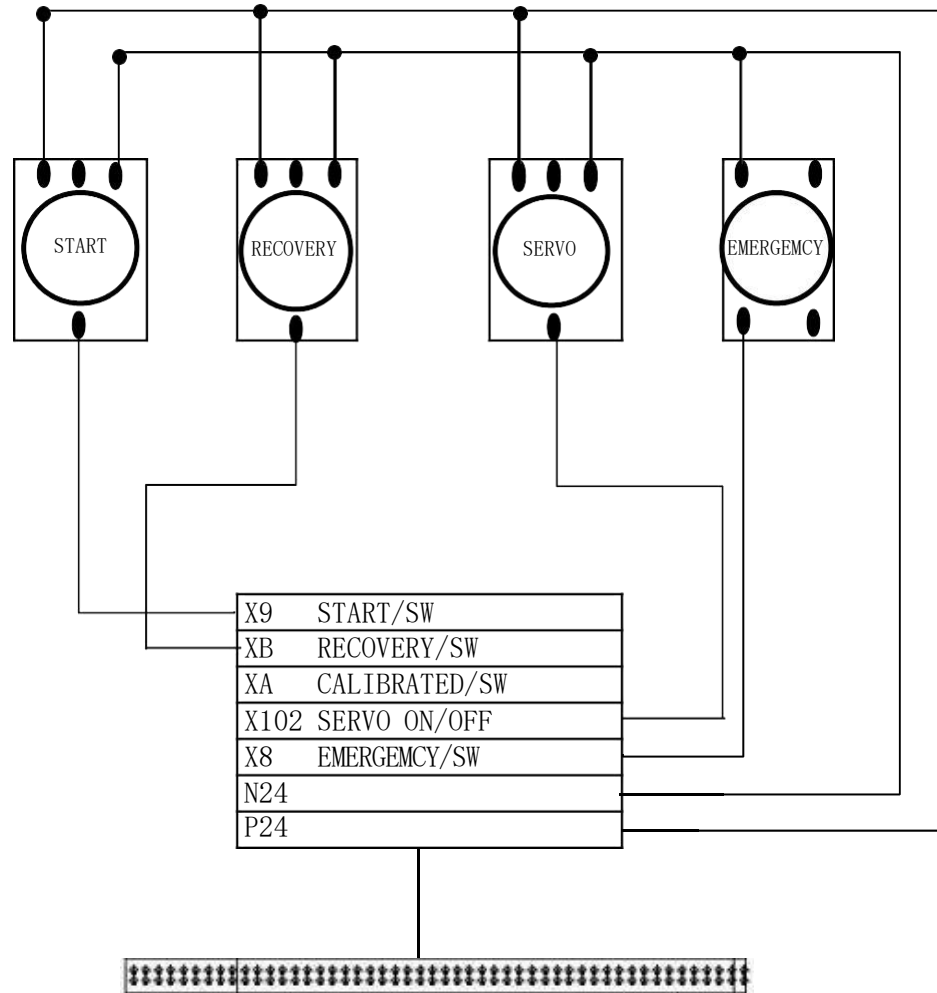
8、Upper and lower board track I/O line



9、Track /TABLE motor circuit



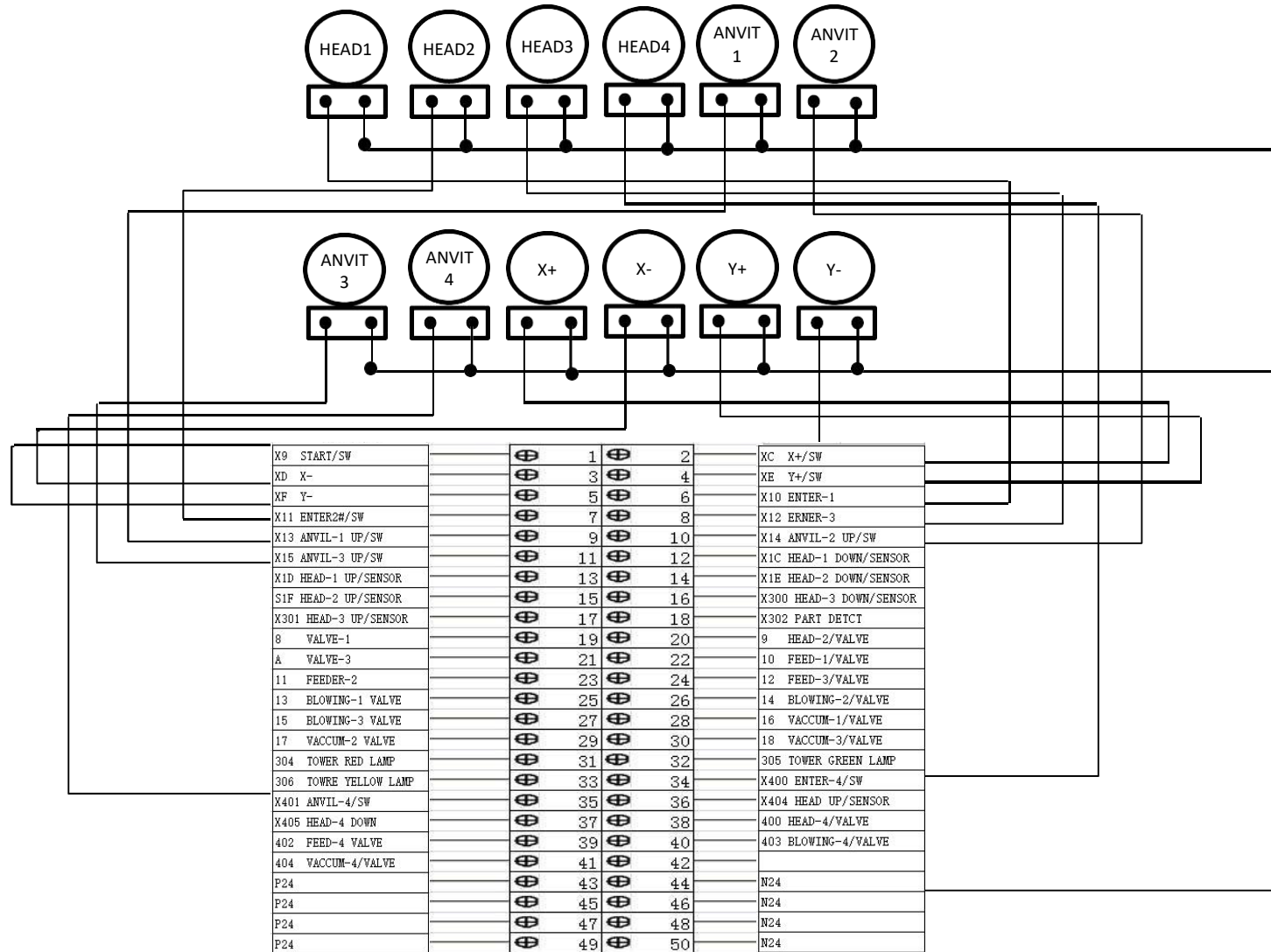
10、Wiring of main operation panel



(TERMIANL)

Southern Machinery Sales and Service Co., Limited

11、Wiring of auxiliary operation panel



MAINTENANCE MANUAL

Recommended lubricating oil

- machinery oils (For sliding parts)

Panasonic: N990PANA-028

Use ISOVG or equivalent grade oil

alban grease (Sliding section, ball screw, etc)

- Mobil: MOBILUX 2

Precautions for maintenance

Confirm whether the equipment is normally cut off and shut down.

Verify that the residual air pressure of the equipment cylinder is discharged.

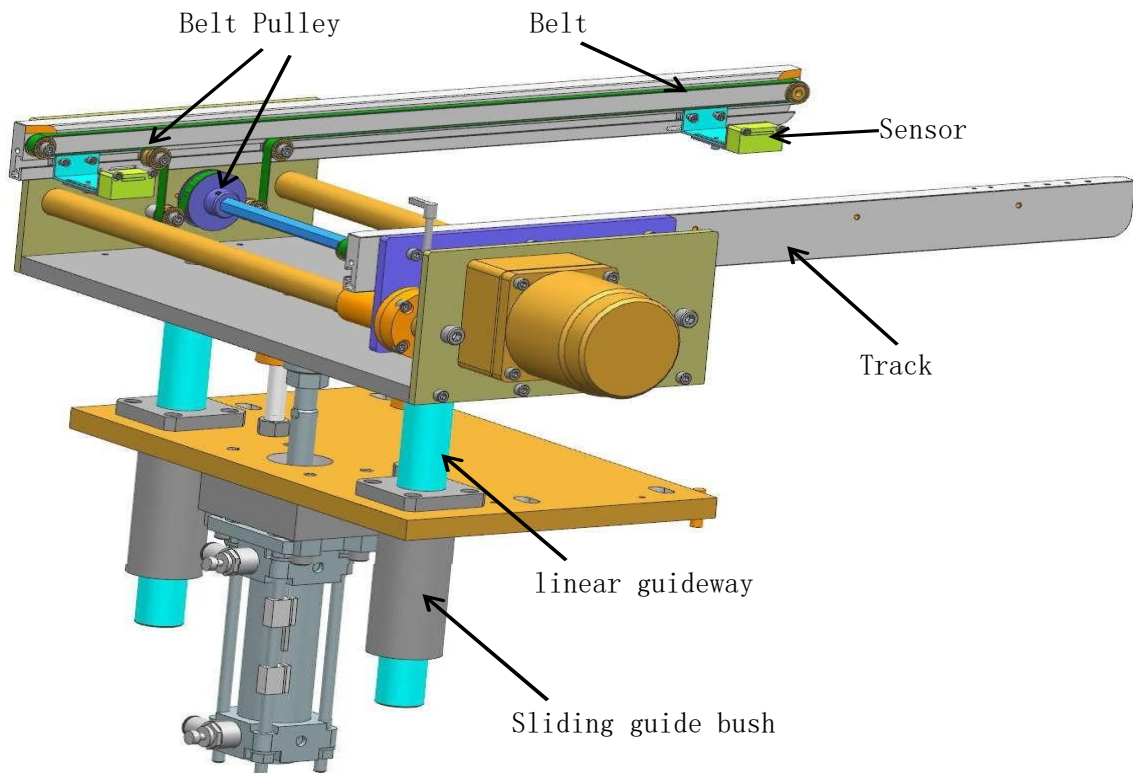
Make sure the maintenance parts are clean before filling lubricating oil and grease.

Confirm whether the mechanical parts of the equipment have safety hazards.

Southern Machinery Sales and Service Co., Limited

MAINTENANCE MANUAL

LOADER SECT



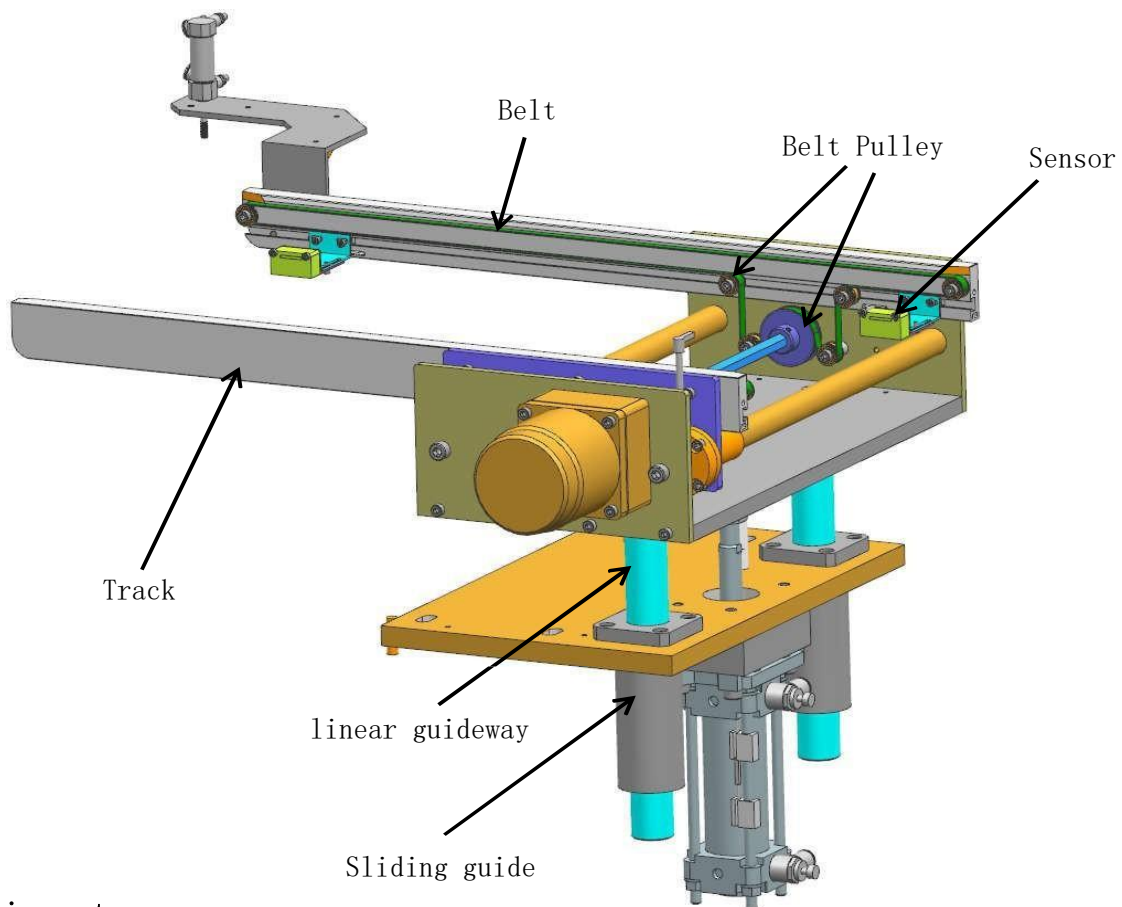
▲inspect

period	project	maintenance contents
everyday	Belt	Clean up grease, dust, board debris and other foreign bodies.
		Check the belt for wear and damage.
		Check the belt tension is correct.
	Track	Check that the track width meets the substrate (The width should be 0.3~1mm with the track)。
Check whether the movement of the lifting platform is smooth and normal.		
Check whether the substrate transfer process is smooth.		
weekly	Sensor	Ensure that there is no foreign body on the face of the sensor.
	Belt	Check whether the belt and pulley match properly (drive synchronization).
	Belt Pulley	Normal transmission, no blocking, stop.

▲apply oil

period	project	maintenance contents
monthly	linear guideway	Apply 0.3~0.5cm ³ calcium based grease evenly to the surface of the guide rail
	Sliding guide bush	
	Belt Pulley	Drop 0.25ml of mechanical oil (per pulley) into the pilot hole.

UNLOADER SECT



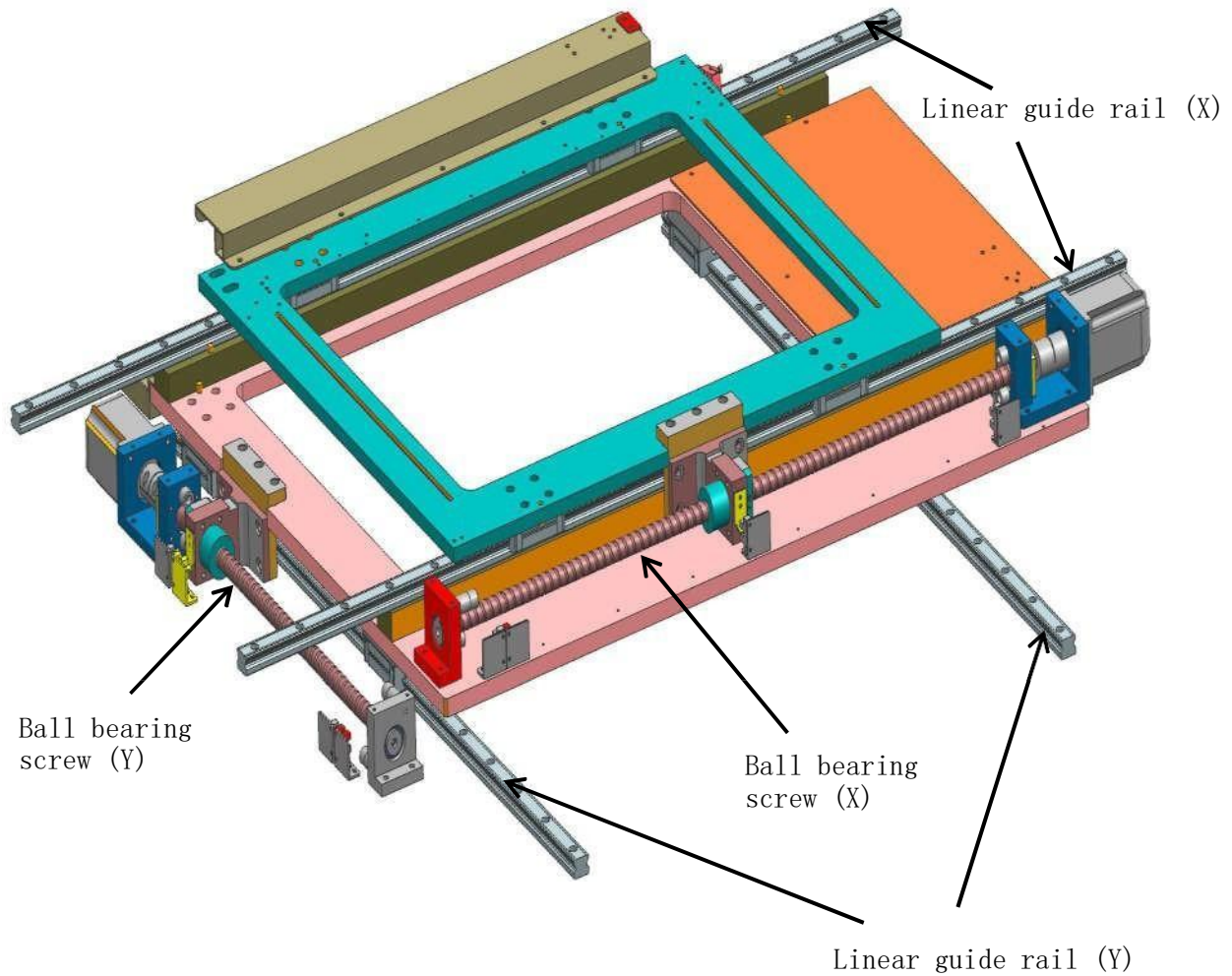
▲ inspect

period	project	maintenance contents
everyday	Belt	Clean up grease, dust, board debris and other foreign bodies.
		Check the belt for wear and damage.
		Check the belt tension is correct.
	Track	Check that the track width meets the substrate (The width should be 0.3~1mm with the track) .
Check whether the movement of the lifting platform is smooth and normal.		
Check whether the substrate transfer process is smooth.		
weekly	Sensor	Ensure that there is no foreign body on the face of the sensor.
	Belt	Check whether the belt and pulley match properly (drive synchronization).
	Belt Pulley	Normal transmission, no blocking, stop.

▲ apply oil

period	project	maintenance contents
monthly	linear guideway	Apply 0.3~0.5cm ³ calcium based grease evenly to the surface of the guide rail
	Sliding guide bush	
	Belt Pulley	Drop 0.25ml of mechanical oil (per pulley) into the pilot hole.

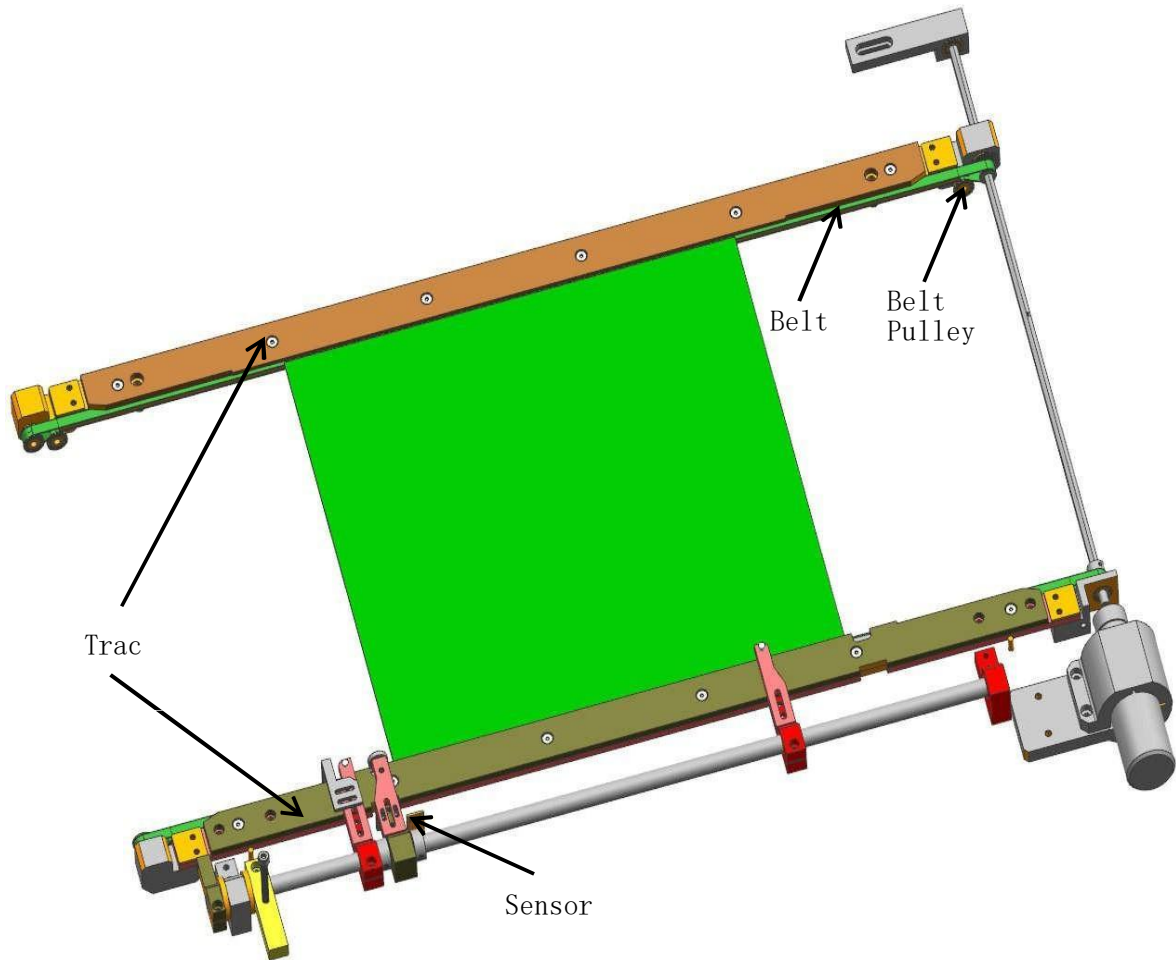
AXIS DRIVING SECT



▲apply oil

period	project	maintenance contents
fortnight	Ball bearing screw (X)	Apply 3~4cm ³ calcium grease evenly to the screw thread.
	Ball bearing screw (Y)	
monthly	Linear guide rail (X)	Apply 2~3cm ³ calcium based grease evenly to the surface of the guide rail
	Linear guide rail (Y)	

Substrate positioning unit



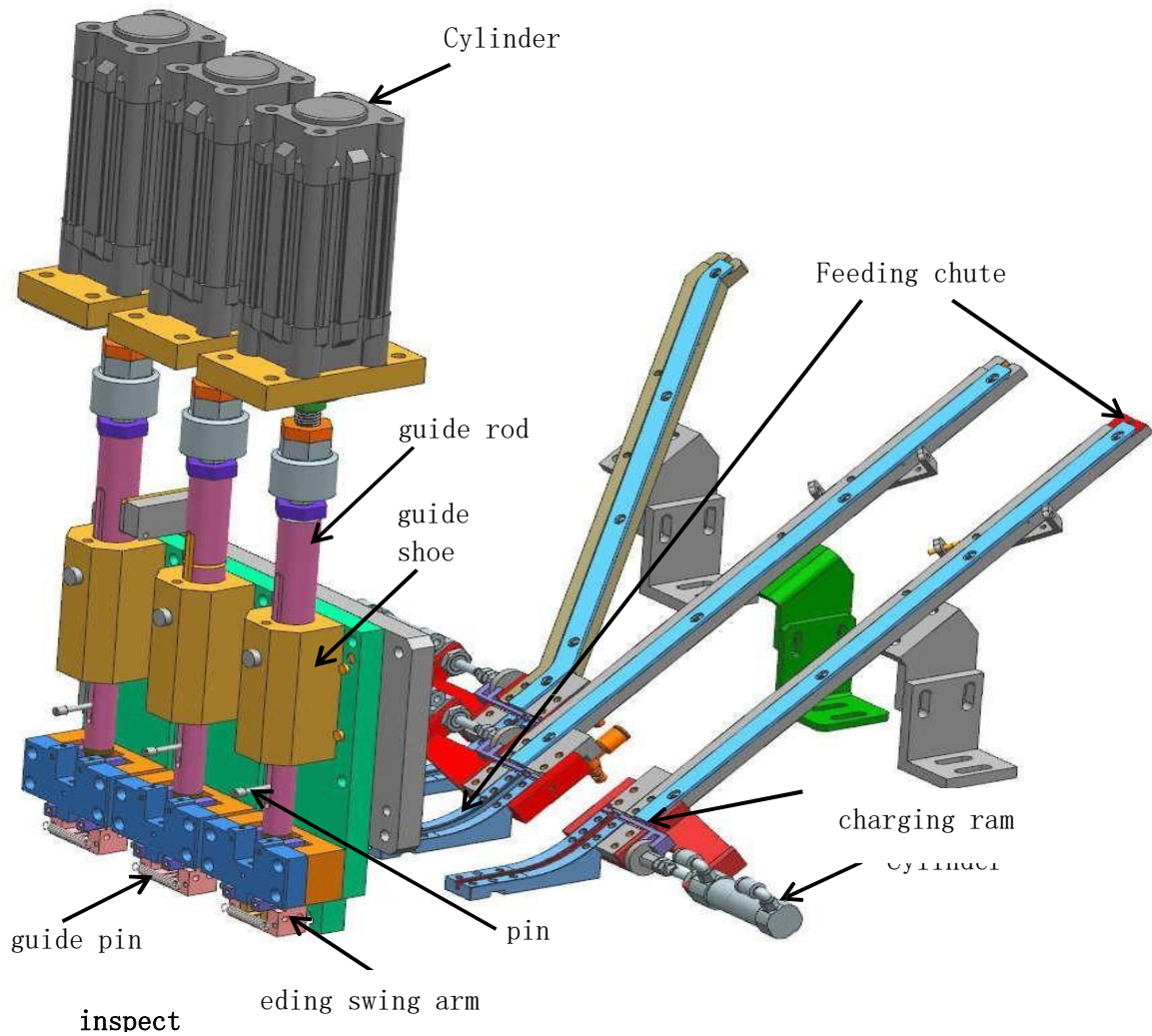
▲inspect

period	project	maintenance contents
everyday	Belt	Clean up grease, dust, board debris and other foreign bodies.
		Check the belt for wear and damage.
		Check the belt tension is correct.
	Track	Check that the track width meets the substrate (The width should be 0.2~0.5mm with the track) 。
Check whether the movement of the lifting platform is smooth and normal.		
Check whether the substrate transfer process is smooth.		
weekly	Sensor	Ensure that there is no foreign body on the face of the sensor.
	Belt	Check whether the belt and pulley match properly (drive synchronization).
	Belt Pulley	Normal transmission, no blocking, stop.

▲apply oil

period	period	maintenance contents
monthly	Belt Pulley	Drop 0.25ml of mechanical oil (per pulley) into the pilot hole.

INSERTION HEAD SECT.

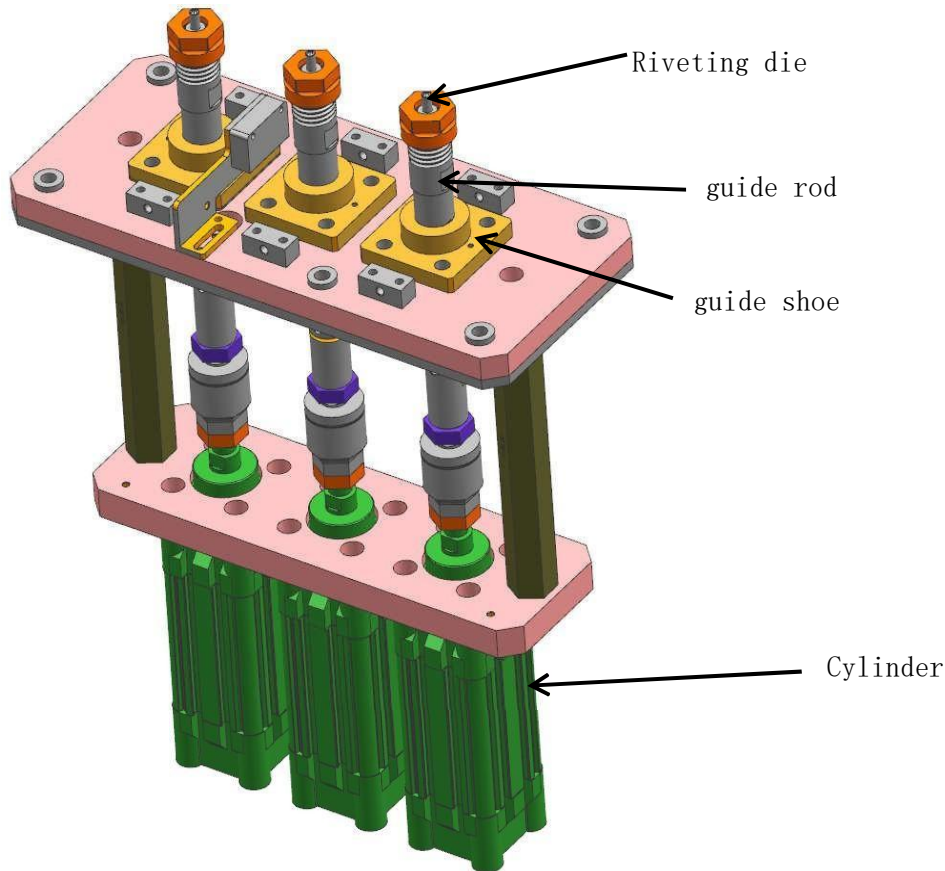


period	project	maintenance contents
everyday	guide pin	Check whether the guide needle is damaged or deformed by force.
	guide rod	Check whether the swing arm is smooth in the box.
	pin	Check the positioning pin for deformation and loosening.
weekly	Feeding chute	Check whether there are foreign bodies in the guide rails and whether the rivet slides smoothly.
	charging ram	Check whether the feed rod is smooth.
	Cylinder	Normal transmission, no blocking, stop, leakage phenomenon.

▲ apply oil

period	project	maintenance contents
monthly	guide rod	Take 0.1-0.2cm ³ calcium based grease and evenly apply it to the surface of the guide rod.
	guide shoe	
	feeding swing arm	Apply 0.05-0.1cm ³ calcium base grease to the place where the swing arm hits the wheel

LOWER ANVIL SECT



▲inspect

period	project	maintenance contents
everyday	Riveting die	Check whether the die is worn and riveted patterns meet the requirements.
weekly	guide rod	Check the guide rod and guide block is smooth, no gap swing.
	guide shoe	
	Cylinder	Normal transmission, no blocking, stop, leakage phenomenon.

▲apply oil

period	project	maintenance contents
monthly	guide rod	Take 0.1-0.2cm ³ calcium based grease and evenly apply it to the surface of the guide rod.
	guide shoe	

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