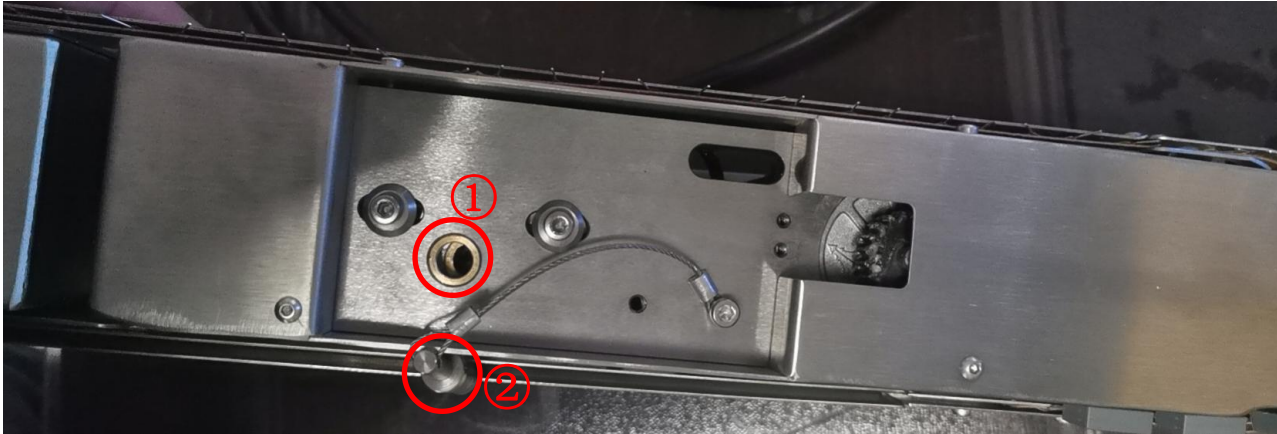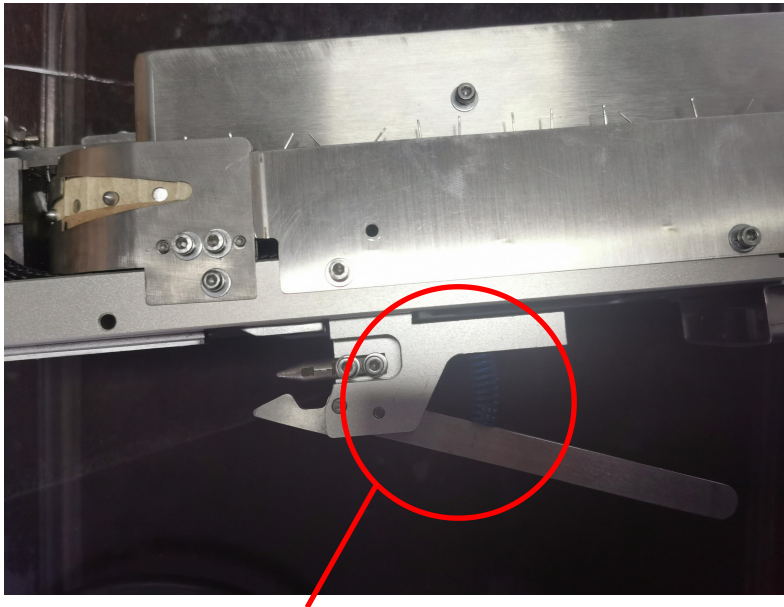# 1. Open/close safety plug
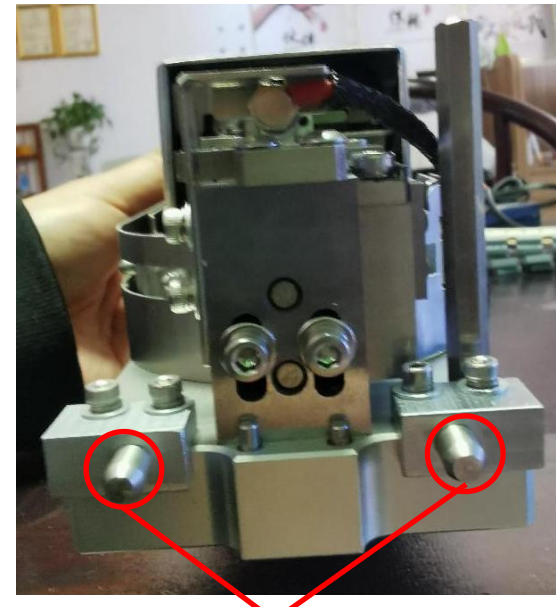

① Safety hole   ② Safety plug

1. Before using the feeder, the first step is to open the safety plug ② from ① to out.

2. When the feeder is not used for a long time, the safety plug ② should be inserted into the safety hole ① to ensure that the mechanical position of the feeder is fixed.
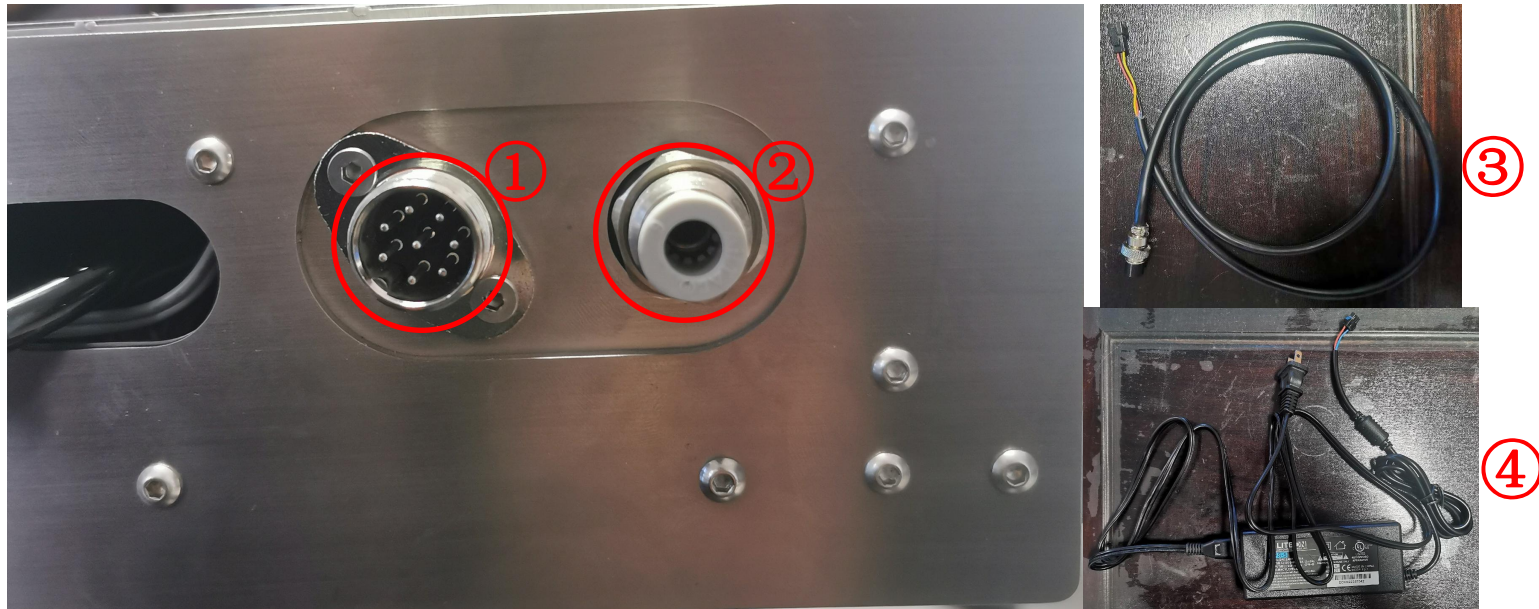
2. Fix the feeder

① **Fixed handle**

② **Positioning pin**

1. Hold the fixed handle ① firmly all the time and insert the positioning pin ② into the positioning hole.

2. Loosen the fixed handle ① to complete the fixing of the feeder.

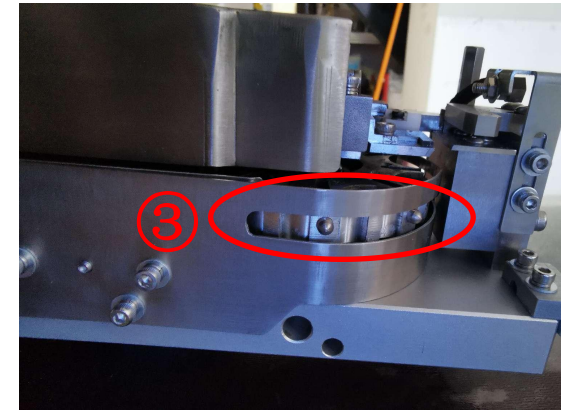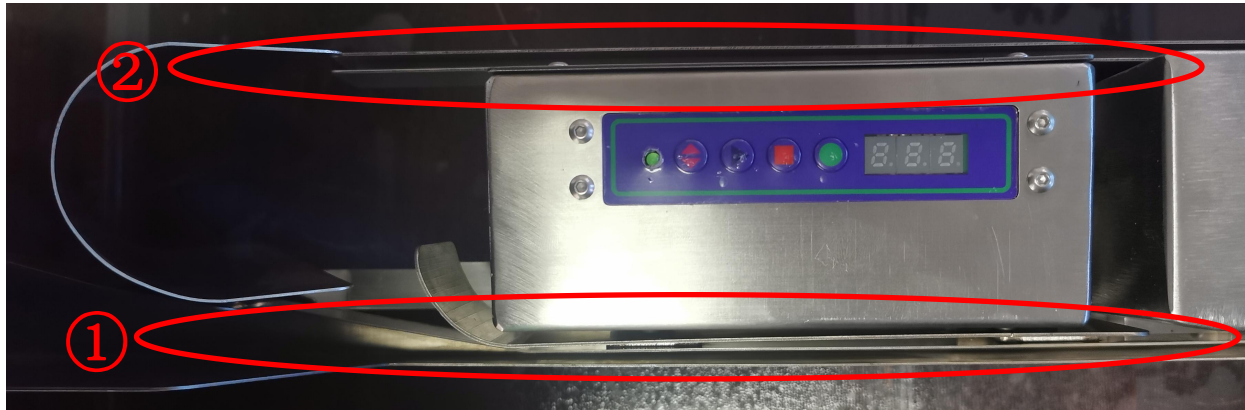# 3. Connect power and air

③

④

① Power interface **② Air interface** **③ Power Wire Part 1** **④ Power Wire Part 2**

1.First connect the first part of the power wire ③ to power interface ①, there is an interface on the machine, so there is no need to connect the second part of the power wire ④.

2. Connect the air interface ②.

4. Load components

① **Components input channel**   ② **Components output channel**   ③ **Feed gear**

1. Guide the part to enter from the components input channel ①.

2. The holes on the tape should be aligned with the bumps on the feed gear ③.

3. Click the green run button, the feeder will run automatically, and the rest of the leads will come out of the components output channel ②.

5. Key Description
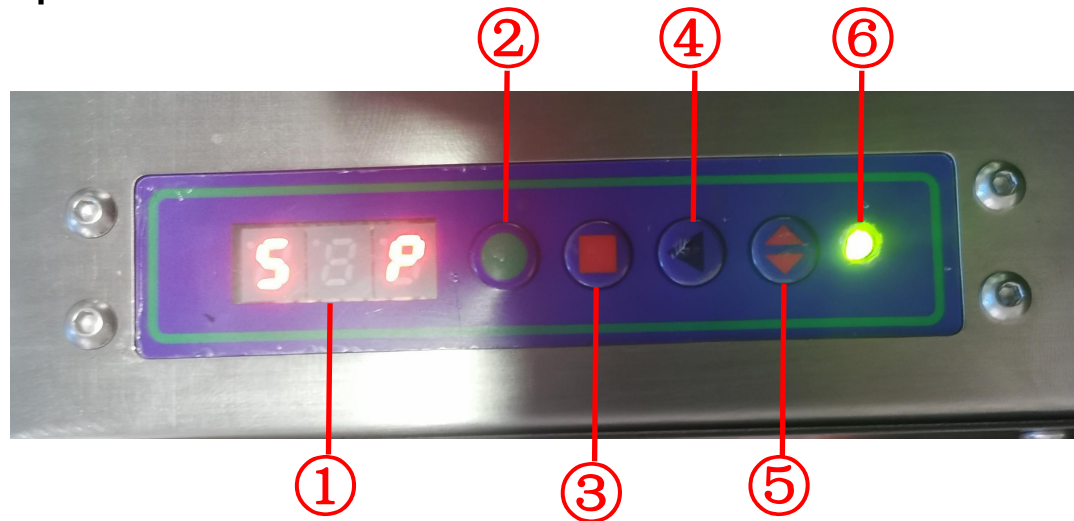
① **Display area:** For displaying values.

② **Start up button:** 1. Start the Feeder; 2. Return to modify parameter interface.

③ **Stop button:** 1. Stop the feeder; 2. release the alarm; 3. Enter the parameter setting interface(3s).

④ **Forward button:** 1. Feed forward; 2. Turn up the parameter.

⑤ **Back button:** 1. Feed backward; 2. Turn down the parameter.

⑥ **Indicator light:** Green light for normal operation, red light for failure yellow light for waiting.

6. Feeder debugging steps

3. Put the paper tape on this wheel, push the whole mechanism that pulls back forward, and insert the pin.

1. Pull the whole pin out.
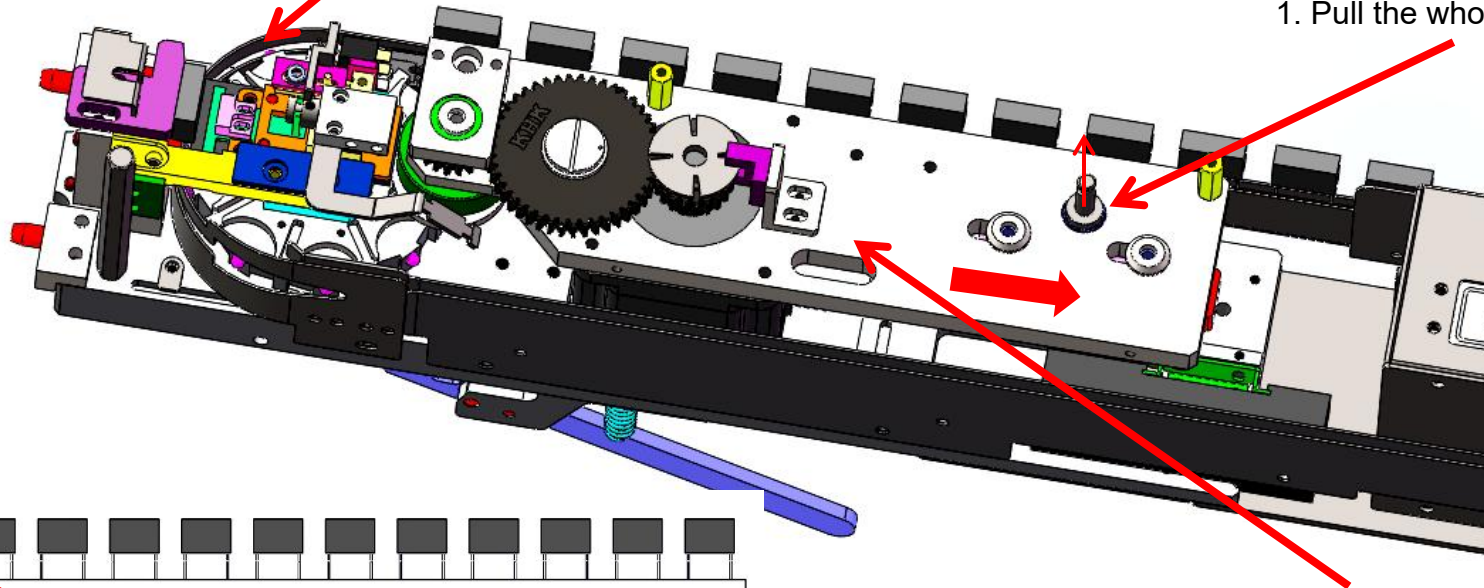
2. Pull the whole mechanism backwards, let the mechanism disengage from the feeding wheel at the front, so that the feeding wheel can be easily rotated at will.

4· When loading the paper tape, be sure to use the hole in the middle of the component to cover the nail of the feeding wheel. If it is not the hole, the feeding position is incorrect.

· The smooth side of the paper tape is attached to the surface of the wheel to feed the component.
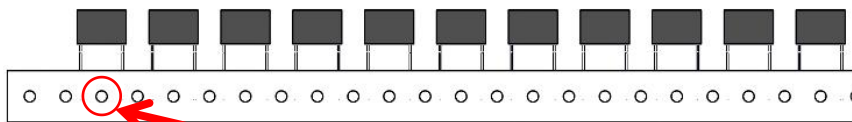
7. Parameter

YAMAHA RADIAL FEEDER PARAMETER					
Num	Para.Code	Para.Meaning	Value	Unit	Remark
1	A	Feeding automatic speed	30	pulse	The smaller the value, the faster the speed
2	B	Feeding motor manual speed	40	pulse	The smaller the value, the faster the speed
3	C	Feed alarm delay	99	pulse	There is this alarm when X0 is enabled
4	D	Nozzle Sensing Delay	5	ms	X12 senses how long it takes to loose Y0
5	E	refeed time interval	80	ms	How long does it take for the motor to turn after loosening Y0
6	F	Stroke of push cutter	16	pulse	Cutter opening distance after nozzle sensing

8. Instructions

1. Press start to execute AUTO automatic operation.

2. When changing parameters, press and hold MANU for more than 3 seconds to change various codes of A, B, and C. At this time, press the up and down keys to change the parameters. After the modification, continue to modify the next parameter. Wait for more than 6 seconds to automatically exit the parameter interface. If you want to quickly To exit the parameter change interface, press the start directly, or the cutter button to quickly exit the parameter change interface.

3. When the feeder sends out an alarm, ERR appears on the screen.
Err01: The components feeding exceeds the set C length, and the material alarm has not been sensed yet. Click to reset to dismiss the alarm.

4. The driver current of P006 is adjusted to 2.2A, and the percentage is adjusted to 50%.

5. Subdivision dialed to 0 subdivision, 10FF, 20FF.

9. Feeder Code

X0: Components sensor.
X1:
X2: Feeding photoelectric switch.
X3:
X4:
X5:
X6: Motor forward.
X7: Motor back.
X10: Start up button.
X11: Components sensor.
X12: Nozzle sensing fiber optic.
X13: Reset button.

P2.0: Motor pulse

P2.1: Motor direction

P2.2: Motor pulse

P2.3:

P2.4: CLK

P2.5: DIO

P2.6:

P2.7: LED

Y0: Presser foot cylinder

Y1:

Y2:

Y3: Components signal

Y4:

Y5:

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