

Foreword

This "Operation Manual" is attached at random. Please keep this manual for reference at any time. Please read this manual carefully before operating this equipment.

Due to technical updates and special requirements of the product, the actual product may be different from the manual, please refer to the actual product, and we will try to add additional instructions as much as possible.

When the equipment is in normal use, please reserve a certain space before and after the equipment as the space required for operation and maintenance. In addition, please do not set up the equipment to block the heat discharge space.

Equipment use environment: temperature: 5 ~ 25 °C, relative humidity: 20 ~ 95%, no direct sunlight, no dew condensation, no splash of water, oil, chemical liquid.

Technicians operating and servicing this machine must be able to use a computer.

The computer configured on this machine can only be used for this machine, it is strictly forbidden to use it for other purposes.

The randomly configured U disk must be strictly prevented from virus intrusion, and it is strictly forbidden to use it on other computers at will.

For personal safety, when the equipment is running or in standby, please do not open the front door, chain and stand guard without taking any safety measures. Clothes, limbs and other moving parts of the machine are strictly prohibited. accidental injury.

Repeated switching of the power supply will become one of the reasons for the failure of the equipment. After the power is turned off (cut off), turn the power on (on) again after 20 seconds or more.

Do not subject the device to shock or strong vibration, as this may cause malfunction.

When cutting off the power of the device, please perform the system exit/shutdown process in the following order. If you directly cut off or restart the power supply without performing this process, the data will not be kept intact, and the hard disk may be damaged at the same time.

Exit/shutdown process: Exit the application to exit Windows, power off the device. →

If you suspend the use of this equipment, please keep the equipment in the following places: the ambient temperature is (0-40) °C, the relative humidity is (20-95)%, and it will not be exposed to direct sunlight, dew condensation, splash water, Locations where oil and chemical liquids are used.

In order to prevent dust, consider taking cover measures (such as a hood), but to prevent moisture.

Please contact us if you do not understand, and do not operate blindly.

Note: Please pay attention to the above matters!

Machine overview:

S4000 series machines are high-speed, high-precision, high-performance equipment. It is a new generation of horizontal conjoined machines independently developed and produced by our company. It can arrange different types of tape components (carbon film resistors, diodes, cylindrical capacitors and other components) on the clip of the chain according to the set program sequence for the use of the plug-in head. This equipment fixes the plug-in head part horizontally, and realizes the precise plug-in in each area of the PCB board by the movement of the X and Y mechanisms. The angle of the plug-in is realized by the rotation of the turntable. This series of control software and operating software is also independently developed by our company, and all operations are controlled by a computer.

This series of vertical machines has the following advantages:

- △ Full computer control, full Chinese version of the operating system, based on Windows platform, easy to operate, fast, simple and easy to learn.
- △ Using machine vision technology, online automatic programming, automatic deviation correction, automatic identification of MARK points, and improved automation.
- △ Adopt AC servo system, optimize the line, eliminate the instability caused by line failure, and achieve the goal of stable high speed and energy saving.
- △ The worktable can be rotated clockwise and counterclockwise.

Software operation

1. Safety check before operation.

Please note: When the machine is newly installed or idle for a long time, the following safety checks must be done carefully before powering on, ventilating and operating the machine:

- 1) Check whether the power supply is at the specified rated voltage.
- 2) Check whether the main power supply is connected to the machine,

whether the insurance is in good condition, and whether the branch circuit breaker is closed.

- 3) Whether the equipment is properly grounded.
- 4) Make sure that no irrelevant objects are left in the electric control box and the movable parts of the machine.
- 5) Whether the conveyor belt and synchronous belt fall off during transportation.
- 6) Check whether the screw, slide rail, plug-in shaft and other heavy-duty, high-speed running mechanisms are well connected.
- 7) Push and pull the X, Y, H, W, L, and J mechanisms by hand to see if they move smoothly.
- 8) Check whether the limit detection and limit mechanism are dislocated.
- 9) Check whether the emergency switch is pressed, and check whether the main gas source and power switch are in the OFF state.
- 10) Check whether the connection plugs and air pipes of the computer, electric control box, main and auxiliary machines are well connected.

2. The operation interface description is divided into the following three areas.



Figure 1

1) Production operation area: This area controls the operation and production of the machine (as shown in the above picture):

Buttons and selection explanation:

Start: Start the plug-in program, and all parts of the machine cooperate to complete the plug-in task.

Stop: The machine stops working and enters the standby state.

Home: Return the table and turntable to the home zero position. It is a necessary move before the first shift and plug-in.

Alarm reset: When the machine encounters a plug-in error during the production process, it will stop working and display the error message in the shutdown information. When the information is repaired, you can click the **alarm reset** to continue production.

Production operation mode:

continuous: that is, the action is performed continuously until the production quantity is completed.

Single step: that is, to complete a complete plug-in cycle action.

Step-by-step: The plug-in action is broken down into several steps to

execute, and only one step is completed at each startup.

Dry run mode:

normal plug-in: complete the plug-in according to the normal plug-in action.

Sequential idling: move the worktable idling in the program sequence, and the chain does not move.

Reverse order idling: Move the worktable idling in reverse order according to the program, and the chain does not move.

Plug-in status detection:

Detection: During the plug-in process, the insertion of components is detected in real time. If it is found that the insertion is not good, the machine will stop and alarm.

No detection: During the plug-in process, the insertion of components is not detected.

Unloading state detection:

Detection: During the feeding process of the material station, it is detected whether there is material on the material station. If no material is detected for three consecutive times, the machine will stop and alarm.

No detection: During the feeding process of the material station, the situation on the material station is not detected.

MARK point

execution: When there is a MARK point correction command in the plug-in sequence command, perform MARK point correction.

Do not execute: Do not execute the MARK point correction command.

Chain running state

operation: The chain feeds the plug-in according to the program sequence.

Not running: The chain does not feed the inserts in the program sequence.

the cutting

is completed, the plug-in of the entire set of materials on the current chain is completed, and then it stops.

Table Movement Speed

The speed at which the table is manually moved.

running the speed

Adjust the speed of each axis in the process of



Figure 2

- 2) The plug-in sequence list shows the company Log when the plug-in data is not read, and the plug-in data when there is plug-in data; when the MARK point correction is encountered during production, the CCD image is displayed;
- 3) Operation information area
This area Displays current production information.



The screenshot shows a control interface for a machine. At the top, under '机器状态信息' (Machine Status Information), there is a green message: '没有找到合适的运动控制卡!' (No suitable motion control card found!). Below this is the '生产信息' (Production Information) section, which includes fields for '程序名称' (Program Name), '生产设定数量' (Production Set Quantity) with a value of 1000 and a '修改套数' (Modify Quantity) button, 'PPM统计' (PPM Statistics), '生产完成数量' (Production Completed Quantity), '实时速度' (Real-time Speed), and '平均速度' (Average Speed). At the bottom of this section, there are indicators for '剪脚头感应状态' (Scissor head induction status) with '左' (Left) and '右' (Right) buttons, each with a checkmark icon, and a '送跳线' (Send Jumper) button. The bottom of the interface displays the machine model: '卧式连体插件机IST-4000 ver2.20.2.4'.

Figure 3. The

shutdown information

shows the reason for the shutdown in the production process, which may be an alarm message or a scheduled production task that has been completed.

program name

shows the name of the program that is about to run or has already been run. Will vary with "open" different programs

production set quantity

is the quantity of PCB boards to be plugged in in production. It will automatically stop when the number value is reached.

PPM statistics

plug-in success rate calculation: (the number of components successfully inserted / the total number of plug-ins that have been inserted) * 100%.

production completed quantity

will automatically accumulate production records after inserting one component and one board.

real-time speed is

used to display the actual plug-in speed of the machine. Unit: pcs/hour.

Average Speed

The insertion speed of the machine over a period of time.

scissor head induction state

are red and flashing, indicating that the plug-in is inserted normally, and gray is indicating no insertion or insertion error.

The jumper

is used to drive the jumper axis to run the jumper when testing the jumper.

Modify the number of sets

Modify the preset number of plug-in sets. When the preset value is reached, the production will be stopped automatically.

Toolbar description



Figure 4

File program

import program

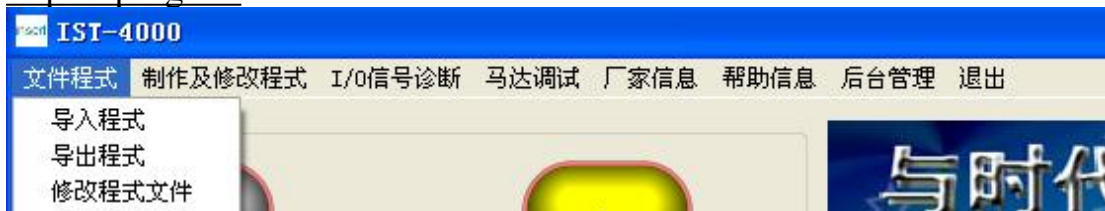


Figure 5

♀↓→'← ㄥ→↓∪ ∩∪∩∩∩∩∩ → Ψ∂'∧∩∩ ∩∩∩∩∩∩∩, →§
 ∩→↓∩ '∧' †

a dialog box that can display all file names (as shown below), and then click the program name you need to "open" in it, Click "Open" again, and the machine accepts the "task" that will execute the program, overwriting the previous program.



Figure 6

Export Program

♀↓→'← ㄥ→↓∪ ∩∩∩∩∩∩∩ → Ψ∂'∧∩∩ ∩∩∩∩∩∩∩, →§
 ∩→↓∩ '∧' † ∩ ∩→∩∩∩∩∩ '∧∩ ∩∩ ∩∩∩∩∩∩∩→∩∩ ∩

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 $\textcircled{R} \wedge \uparrow \times \nabla \times \downarrow \times \wedge \cup \nabla \xi \cup \xi \in \cup \rightarrow \downarrow \cup \nabla \times \partial \cup \textcircled{R} \wedge \uparrow$
 $\nabla \cup \cup \rightarrow \nabla \xi \in \cup \rightarrow \downarrow \cup \nabla \times \partial \cup \rightarrow \cup \downarrow \cup$, $\times \nabla \cup \downarrow \rightarrow \leftarrow$
 $\text{”} \times \uparrow \cup \text{”}$ $\Omega \in \times \xi \times \rightarrow \xi$.



Figure 7

Modify program file

$\rightarrow \downarrow \rightarrow \leftarrow \rightarrow \downarrow \cup \cup \sim \wedge \cup \sim \times \partial \rightarrow \times \wedge \rightarrow \rightarrow \rightarrow \textcircled{R} \cup \sim \wedge \cup \sim \times \partial$
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 $\times \cup \downarrow \cup \xi \rightarrow \nabla \cup \times \rightarrow \downarrow \cup \nabla \times \partial \cup$ ($\rightarrow \cup \uparrow \sim \cup \cup$ 6). $\Omega \in \cup \nabla$
 $\downarrow \rightarrow \leftarrow \xi \in \cup \nabla \times \partial \cup \wedge \rightarrow \xi \in \cup \sim \wedge \cup \sim \times \partial \textcircled{R} \wedge \uparrow \nabla \cup \cup \cup$
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Create and modify program



Figure 8

Create and modify program Generate or modify plug-in data with the help of the camera

$\rightarrow \downarrow \rightarrow \leftarrow \rightarrow \downarrow \cup \times \xi \cup \times \nabla \cup \times \wedge \rightarrow \rightarrow \rightarrow \textcircled{R} \cup \sim \wedge \cup \sim \times \partial \rightarrow$
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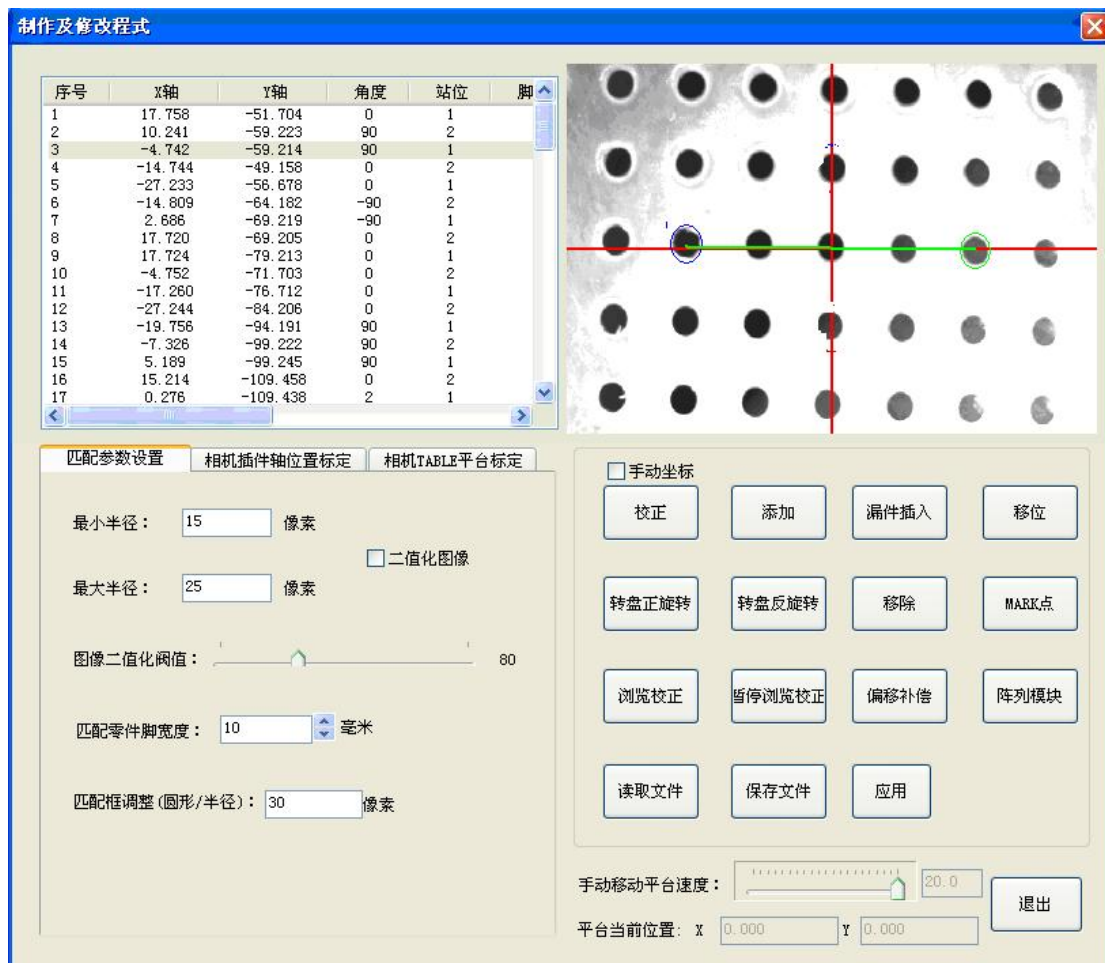


Figure 9

I Data display area: Display the generated plug-in Data

序号	X轴	Y轴	角度	站位	脚
1	-4.371	-107.994	0	1	
2	-19.37	-108.007	0	2	
3	-34.365	-107.986	0	3	
4	-49.364	-107.968	0	4	
5	-64.368	-107.96	0	5	
6	-84.374	-107.934	0	6	
7	-104.378	-107.823	0	7	
8	-95.715	-141.636	0	8	
9	-83.966	-145.872	-34	9	
10	-76.722	-156.86	-70	10	
11	-76.73	-170.454	72	11	
12	-84.011	-181.445	36	12	
13	-107.484	-145.83	36	13	
14	-114.748	-156.814	73	14	
15	-114.777	-170.405	-70	15	
16	-107.534	-181.412	-34	16	

Figure 10

II CCD image area: Displays the position where the image captured by the camera has been matched by the plug-in, helping to generate plug-in data. After modifying the matching difference, the image will respond in

real time.

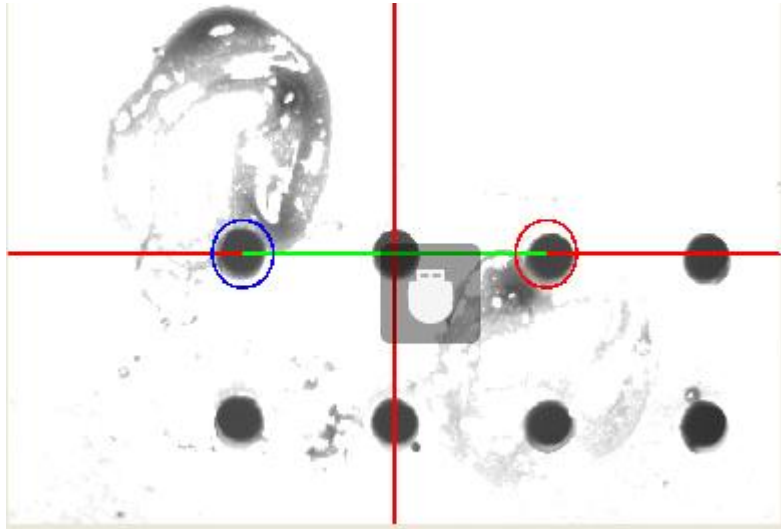


Figure 11

III Matching parameter setting area

This area has three pages: matching parameter setting, camera plug-in axis position calibration, camera TABLE platform calibration.

Matching parameter settings

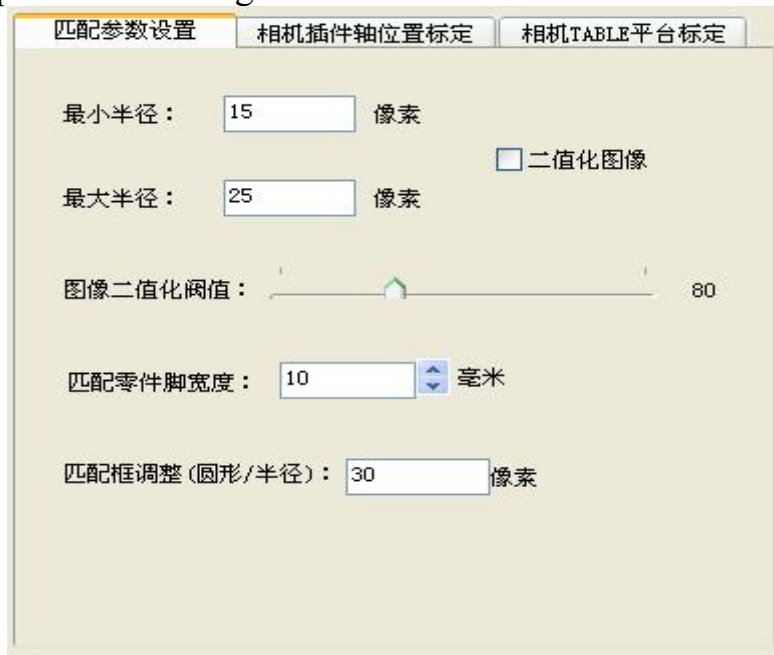


Figure 12

Minimum Radius

The minimum target size radius to find within the matching ROI area.

Max Radius

The maximum target size radius to look for within the matching ROI area.

The binarized image

divides the image according to the threshold into a black and white two-color grayscale image.

The image binarization threshold

adjusts the threshold value of the segmentation map.

width of the matching part feet is

based on the distance between the two pins of the component, and the distance range of this machine is 5mm-20mm.

Match Box Adjustment (Circle/Radius)

adjusts the range of the ROI area.

Camera plug-in axis position calibration



Figure 13

Calibration camera position

Move a plug-in position to the ROI area of the camera image, click to calibrate the camera position, the program matches and records the current platform position.

Calibrate plug-in axis position

Move the plug-in position used for calibrating the camera position to the plug-in axis, fine-tune the XY axis, and manually move H, so that H can be inserted at this position, click the calibration plug-in axis position program to record the current platform position.

mark is completed

, the camera position and plug-in axis position and sum are calibrated. Click Calibration Complete, and the program will calculate the relative position of the plug-in position under the camera image and the plug-in position

under the plug-in axis, and fill them in the two edit boxes on the right.

test

, move the plug-in position to the ROI area of the camera image first. Click the test program to correct the specific position in the ROI area first, and then automatically move it to the bottom of the plug-in axis. At this time, you can check whether the data is accurate.

The delivery

axis moves forward one grid.

Note: The keyboard direction keys can move the platform, the 'A', 'D' keys can adjust the width

Camera TABLE platform calibration



Figure 14

Calibrating the camera platform

Select the area with only one matching target on the matching board, as shown in the

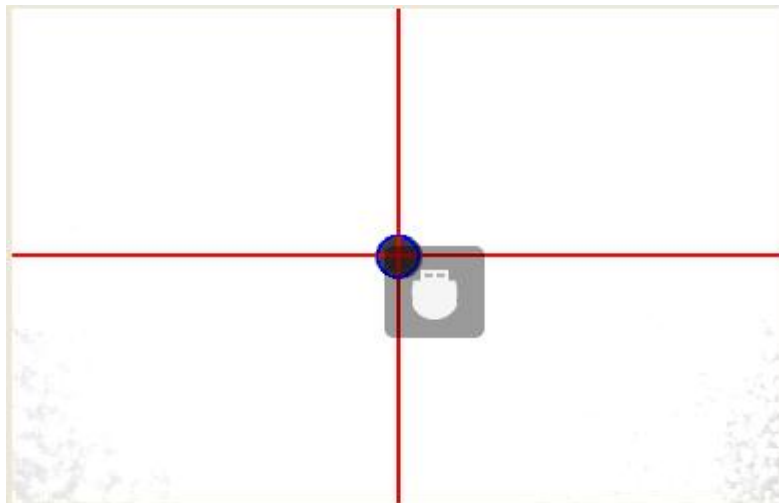


figure Figure 15 The

program will calculate The number of pulses moved by the XY axis The number of pixels moved by the XY axis on the image, which determines the ratio of the distance on the image to the actual distance.

test camera platform

moves the matching target to any position in the image, and if it can automatically return to the center of the camera, the calibration is successful.

IV matching operation area:



Manually

move the plug-in coordinates to the image ROI area, and directly record

the XY coordinates.the PCB board imaging is extremely irregular and cannot be matched, get the plug-in position

correction

Replace the plug-in data obtained in the ROI area of the current image with the data of the selected row

Add

the plug-in data obtained in the ROI area of the current image to the plug-in data listthe

Insert

plug-in data obtained in the ROI area of the current image into the position of the currently selected row.

position

does not reach the corresponding position of the focus row, move to the corresponding position;

if the current platform position is in the focus row , move to the corresponding position on the next line of the focus line.

The turntable is spinning The

turntable is rotated 90 degrees clockwise and recorded in the plugin data list.

Turntable Counter Rotation The

turntable rotates 90 degrees counterclockwise and is recorded in the plug-in data list.

Removed

delete row rotated in plugin data list (multiple rows possible).

MARK point

adds MARK point position correction to the program.

Browse correction

starts from the focus line to browse and correct the plug-in data of the plug-in data list.

Pause Browsing

Temporarily stops browsing corrections for plug-in data.

Offset compensation

selects a row, and then moves to the corresponding position of the focus row due to click shift, click offset compensation, you can fine-tune the multi-row data before knowing the turntable rotation command or stop command after this row.

array module

has edited an area, you can use this command to array several similar modules to



match a certain position in the first module and the same position in the last module, and then enter the number of modules in the X direction and the modules in the Y direction. number, you can generate plug-in data that combines several modules.

Read file

is the same as the import program in the menu bar, read the plug-in data from the file to the plug-in data list.

Save the file

is the same as the export program in the menu bar, save the plug-in data of the plug-in data list to the disk file, if there is no "stop" or "continue" command at the end of the list, the "stop" command will be added automatically.

application

saves the matching parameters to a disk file so that it will be automatically loaded on the next startup.

Plug-in information list

插件信息一览表											
序号	X轴	Y轴	宽度	站位	脚位	元件	类型	方向	高度	命令	引脚半径补偿
1	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
2	6.000	1.000	6.000	5			跳线	Z	0.100	插件检测	0.000
3	6.000	1.000	6.000	4		1/6w电阻	元件	Z	0.000	插件检测	0.000
4	6.000	1.000	6.010	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
5	6.000	1.000	0.000	0					0.000	转盘正旋转	0.000
6	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
7	6.000	1.000	6.000	5			跳线	Z	0.100	插件检测	0.000
8	6.000	1.000	6.000	4		1/6w电阻	元件	Z	0.000	插件检测	0.000
9	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
10	6.000	1.000	0.000	0					0.000	转盘正旋转	0.000
11	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
12	6.000	1.000	6.000	5			跳线	Z	0.100	插件检测	0.000
13	6.000	1.000	6.000	4		1/6w电阻	元件	Z	0.000	插件检测	0.000
14	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
15	6.000	1.000	0.000	0					0.000	转盘正旋转	0.000
16	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
17	6.000	1.000	6.000	5			跳线	Z	0.100	插件检测	0.000
18	6.000	1.000	6.000	4		1/6w电阻	元件	Z	0.000	插件检测	0.000
19	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
20	6.000	1.000	0.000	0					0.000	转盘正旋转	0.000
21	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300
22	6.000	1.000	6.000	5			跳线	Z	0.100	插件检测	0.000
23	6.000	1.000	6.000	4		1/6w电阻	元件	Z	0.000	插件检测	0.000
24	6.000	1.000	6.000	2		1/4w电阻	元件	Z	-0.010	插件检测	0.300

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退出

Station information list

窗口标题: 站位信息一览表

站位	元件名	类型	方向	数量	高度	元件引脚补偿
1						
2	1/4w电阻	元件	z	14	-0.010	0.300
3						
4	1/6w电阻	元件	z	7	0.000	0.000
5						
6						
7						
8						
9						
10						
11						
12						
13						
14						
15						
16						
17						
18						
19						
20						

下拉菜单选项: 1/6w电阻, 1/4w电阻, 1/8w电阻, 1/2w电阻, 玻璃二极管1N4148, 黑二极管14007

底部操作: 把 站供料更换为 站供料

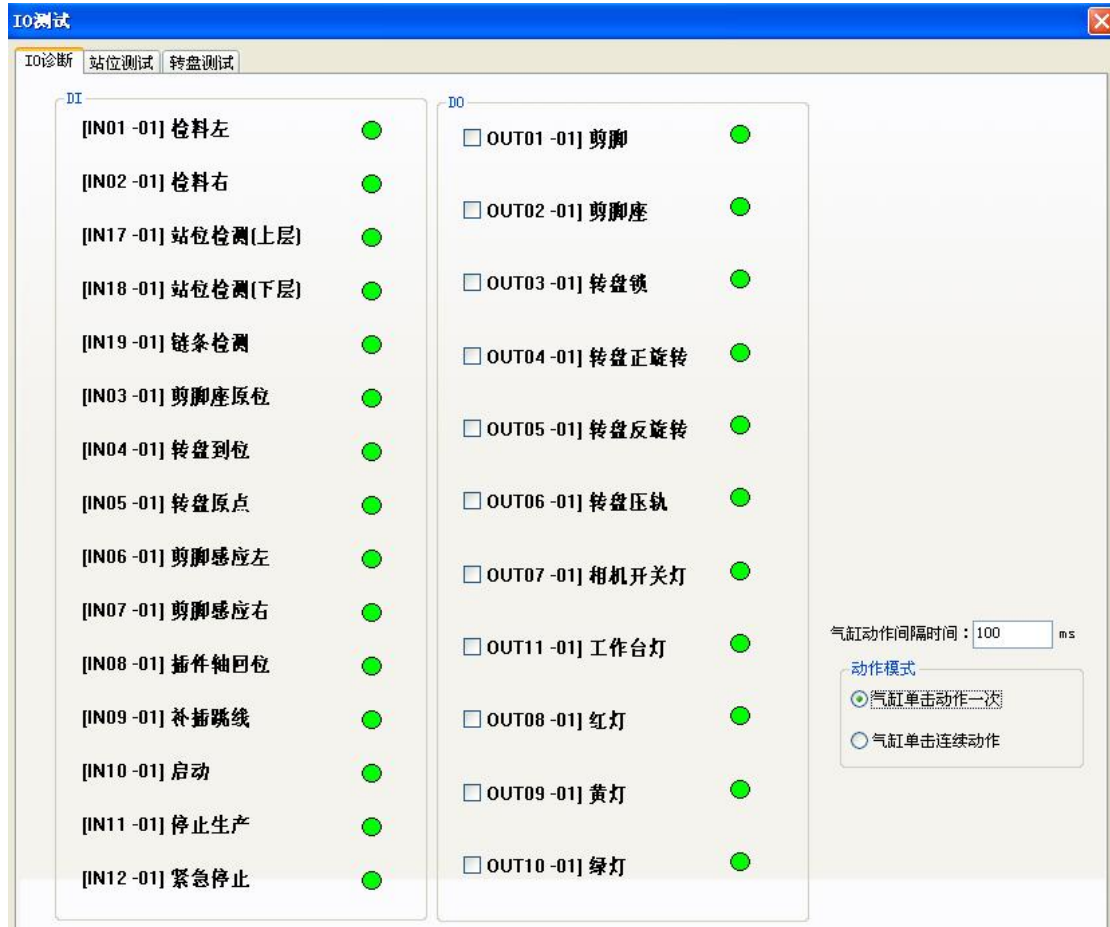
Here you can select the component name
Feeding station that can replace the component

Component information list

序号	元件名	类型	元件高度	元件引脚补偿
1	1/6w电阻	元件	0.000	0.000
2	1/4w电阻	元件	-0.010	0.300
3	1/8w电阻	元件	-0.020	-0.000
4	1/2w电阻	元件	-0.200	-0.000
5	玻璃二极管1N4148	元件	0.040	-0.000
6	黑二极管14007	元件	-0.080	0.000
7	0.6跳线	跳线	-0.050	0.000
8	跳线	跳线	0.000	0.000

添加 删除 保存 退出

I/O signal diagnosis



DI

Pick Left Pick Right Check the insertion status of components. When inserting, if the component is not accurately inserted into the hole or the foot clipper does not touch the pin of the component, the machine will stop or issue an alarm prompt. The normal state is red, otherwise it is green. The signal is taken from the foot clipper, and the principle is that a loop is formed between the foot clipper, the foot clipper and the ground under normal conditions.

Station detection (upper layer), station detection (lower layer):When the material on the material station is about to be used up, a signal is detected.

Chain detection detects the presence or absence of material on the chain.
Scissor foot seat low Detect whether the scissor foot seat is in the low position.

turntable is close to the "in-position" magnetic sensor of the turntable detection board, the signal output by the turntable detection board. Determines whether the turntable stops or continues to rotate.

turntable in-situ turntable is close to the "zero position" magnetic sensitive element of the turntable detection board, the signal output by the

turntable detection board.

Head home position signal: Click the "H-axis" switch on the panel, the H-axis is powered off, and after clicking again, the H-axis is powered on and returns to its original position.

patching jumper is currently patched and the patching patch is not inserted successfully, the patching patch will be inserted again.

Start When the start switch on the case is pressed, the state changes from high to low and vice versa.

Stop When the stop switch on the housing is pressed, the state changes from high to low and vice versa.

DO

camera light switch the camera's light source.

Green, yellow and red lights are warning lights on the housing.

clipper drives the action of the foot clipper cylinder.

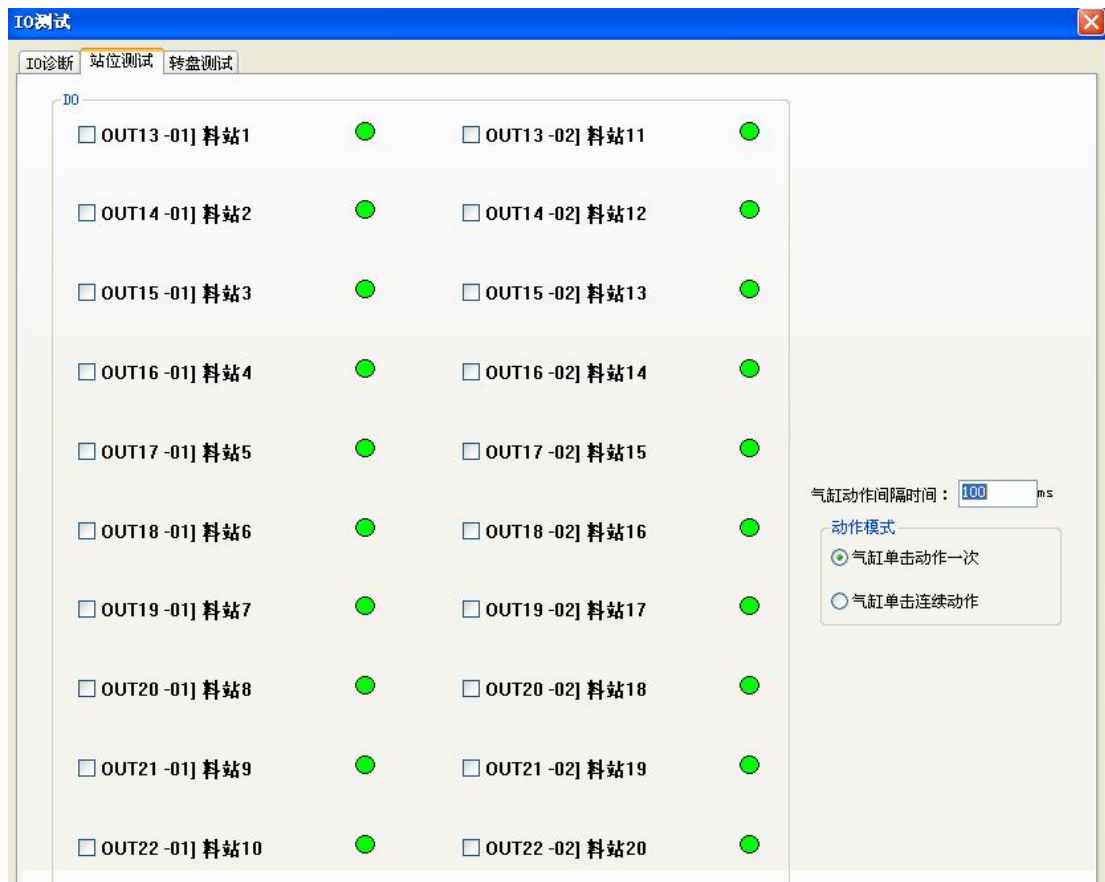
The turntable lock is the signal that drives the cylinder on the turntable locking mechanism to act.

turntable press wheel drives the cylinder on the turntable press wheel mechanism to act.

Clockwise control the clockwise relay signal of the turntable.

counterclockwise rotation of the turntable.

The base drives the signal for the base cylinder to rise and fall.



The DO signal on the distribution head can test the time delay setting of the turntable of the distribution head by single action and linkage



; turntable lock time; turntable forward rotation time and turntable reverse rotation time.

Press this button once when the turntable is rotating for a single rotation, and the turntable will rotate 90 degrees clockwise.

Press this button once during continuous rotation, and the turntable will rotate 90 degrees clockwise.

Then turn it 90 degrees clockwise to cycle the counter-rotation of the turntable. Press this key once during a single rotation, and the turntable will rotate 90 degrees counterclockwise.

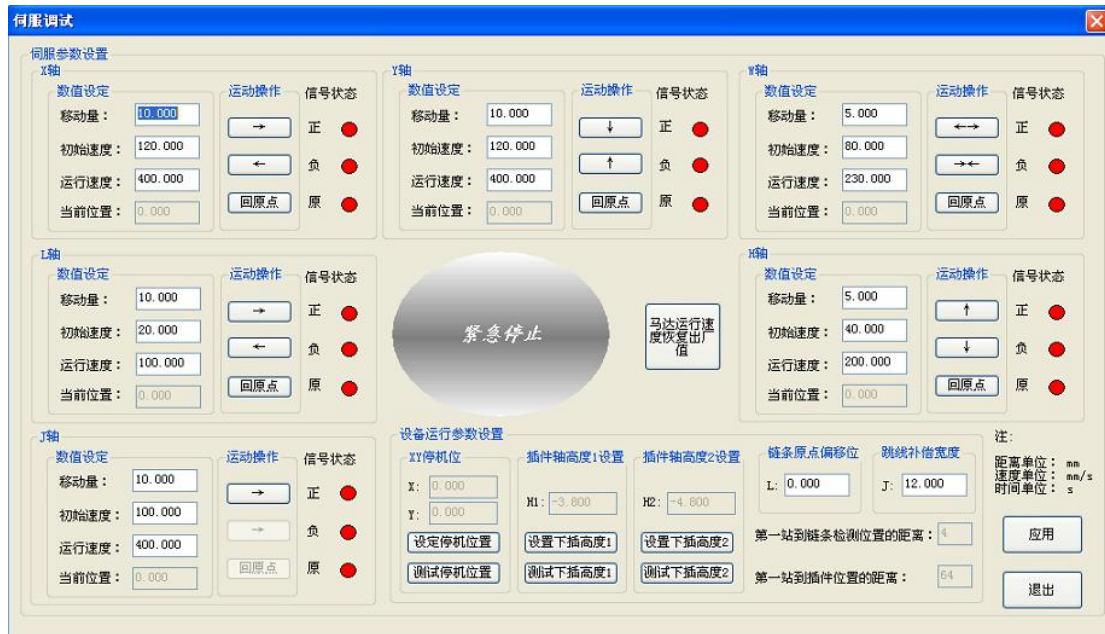
Press this button once during continuous rotation, and the turntable will rotate 90 degrees counterclockwise.

Then turn it 90 degrees counterclockwise to stop the rotation in this cycle

. After the turntable completes the current rotation action, it stops rotating, aiming at continuous rotation.

The turntable signal returns to monitor the DI DO signal related to the turntable in real time.

4.1) Motor debugging



Set the movement amount and movement speed of each axis, and then move each axis according to the direction of the arrow on the button to test whether the time movement direction of each axis is consistent with the direction indicated by the arrow; test whether the positive and negative limits are valid successively and reversed.

Test whether each axis can be returned to the origin and whether the position of the origin is correct.

The positive and negative limits are the abbreviations for the photoelectric switch signals of the maximum limit positions in the positive and negative directions of each axis, respectively.

origin The "zero point" detection signal of the

Stop position X: After the worktable is "zeroed", the actual position of the X axis should be ahead of the zero position.

Stop position Y: After the worktable is "zeroed", the actual position of the Y axis should be ahead of the zero position.

Turntable position X: The actual position of the X-axis before the turntable starts to rotate.

Turntable Position Y: The actual position of the Y-axis before the turntable starts to rotate.

Plug-in shaft height 1: The plug-in shaft is attached to the component down, and the position value of the component pins on the surface of the PCB board is a little higher than the position of the plug-in shaft height 2, which is convenient to check whether the plug-in holes and pins are aligned.

Plug-in shaft height 2: The position where the plug-in shaft is fully inserted into the surface of the PCB.

motor running speed is restored to the factory value: the speed of each axis is restored to the factory guide value when it leaves the factory.

Compensation value setting:

L-axis: the relative value of the L-axis origin when the plug-in axis is aligned with the L-axis material.

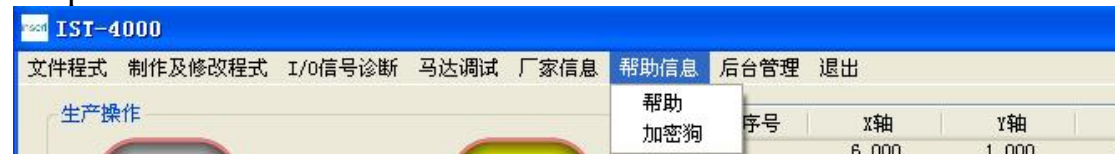
J axis: The compensation value sent to the jumper.

Manufacturer Information

After clicking the manufacturer information, the FactoryInfo.pdf file in the application directory will be opened.

If the file does not exist, a prompt message will pop up.

Help



Help

Click Help to open the S4000-HELP.pdf file in the application directory.

If the file does not exist, a prompt message will pop up.

dongle

clicks help, a dialog box will pop up,

加密狗
✕

若加密狗不正确，请将读取的机器码发送给
厂家，再向厂家索要新的加密狗

机器码：

分期本期累计使用时间： 小时

分期本期剩余使用时间： 小时

若本期加密狗已经过期，请支付下一期款项并向厂家
索要密码解锁

本机编号：

分期付款总期数：

已经支付的期数：

解锁密码：

if the current machine's dongle is incorrect, please read the machine code, and send the machine code to the manufacturer, and ask the manufacturer for a new dongle.

If the installment payment method is adopted, the valid use time of the installment has expired and the dongle is locked. Please send the machine number and the number of installments to be paid to the manufacturer, and ask for the unlock password to unlock.

Background management

About IST-4000
✕


卧式连体插件机IST-4000 ver2.20.2.4
英赛特机械科技有限公司

statistics



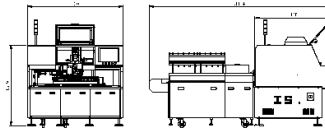
统计项	值
程序名	H:\VIST测试版.xls
开机时间统	0001时58分44秒
运行时间统	0000时00分00秒
待机时间统	0001时58分44秒
插件总数统	0
插件失败统	0
插件效率统	0
插件成功	100.00%
系统当前时	2014-05-08 13:42:48

show the statistics of production data and efficiency.

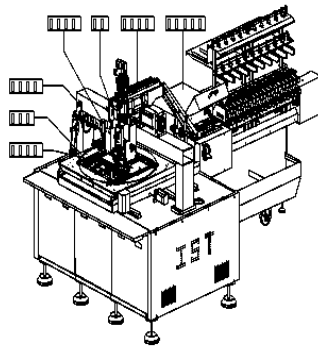
Exit

Click Exit to exit the program.

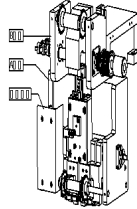
Conjoined plug-in machine floor plan



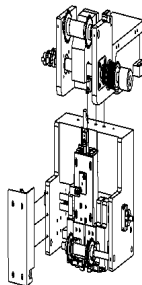
mechanical annotation drawing



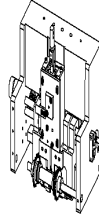
head assembly



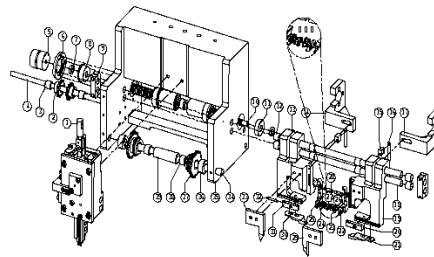
Assembly



Head



Exploded



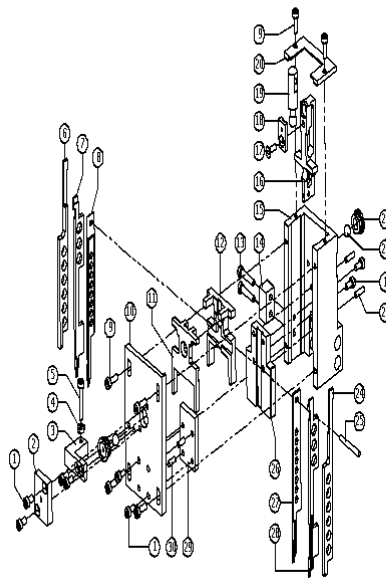
List

Serial	Name	Quantity	No.	Remarks
A	Part	A	Exploded	
Part	Drawing	Part	Drawing	
A	Head	No.	HeadTB-A003	
4	feed sprocket shaft (diameter	1	IST4000-TB-A004	

	9.5, length 282)			
5	double diaphragm coupling (10-8)	1	IST4000-TB-A005	
6	left and right screw bearing caps	1	IST4000-TB-A006	Shared with the base
7	M10X1 nuts	2	IST4000-TB-A007	
8	Bearings 5200Z (with circlip)	1	IST4000-TB-A008	Shared with the base
9	double-ended clamping blocks	2	IST4000-TB-A009	
10	left and right rotating rods	1	IST4000-TB-A010	and base share
11	bearings 6200Z	1	IST4000-TB-A011	and base share
12	copper sleeves (outer 14, inner 12, length 12)	8	IST4000-TB-A012	
13	Left tool holder	1	IST4000-TB-A013	
14	Screw Left Fitting	1	IST4000-TB-A014	
15	Spring Leaf Fixing Block	2	IST4000-TB-A015	
16	Spring	2	IST4000	
17	Screw Right Fitting	1	IST4000-TB-A017	
18	12 Optical Shaft (diameter 12, long 310)	2	IST4000-TB-A018	
19	Right tool holder	1	IST4000-TB-A019	
20	lower cutter	1	IST4000-TB-A020	
21	Right outer forming tool guide	1	IST4000-TB-A021	
22	Right forming tool holder	1	IST4000-TB-A022	
23	Right forming blade	1	IST4000-TB-A023	
24	Left forming blade	1	IST4000-TB-A024	
25	Left forming blade holder	1	IST4000-TB-A025	
26	M4 screw rubber ring	4	IST4000-TB-A026	
27	M4X5 slotted screw	4	IST4000-TB-	
28	blade holder mounting pin	2	IST4000-TB-A028	
29	Right blade cover	1	IST4000-TB-A029	
30	Left outer shaping blade guide	1	IST4000-TB-A030	
31	Left lower blade	1	IST4000-TB-A031	
32	Wire feed tube sleeve	1	IST4000-TB-A032	
33	Left knife cover	1	IST4000-TB-A033	
34	Feed sprocket shaft 1 (diameter 12, length 219)	1	IST4000-TB-A034	
35	Head mount	1	IST4000-TB-A035	
36	12 Tightening Ring	2	IST4000-TB-A036	
37	16 Tooth Sprocket	2	-TB-A037	
Bearin	TLA1212z	IST40	TB-A038	
g		00		
39	Race Steel Sleeve	1	IST4000-TB-A039	
2				



38

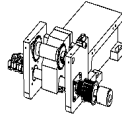


IST4000Box Part List

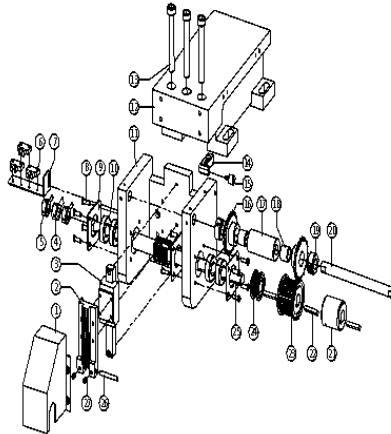
32

Serial Number	Name	Quantity	Number	Remarks
1	M5X10 Cup Head Screws	6	IST4000-TBDH001	
2	Blade Box Stopper Block	1	IST4000-TBDH002	
3	Blade Box Adjustment Block	1	IST4000-TBDH003	
4	M5 Nuts	1	IST4000-TBDH004	
5	M5X30 Cup Head Screws	1	IST4000-TBDH005	
6	left cutter	1	IST4000-TBDH006	
7	left outer forming cutter	1	IST4000-TBDH007	
8	left push cutter	1	IST4000-TBDH008	
9	M5X15 cup head screw	4	IST4000-TBDH009	
10	cutter box upper plate	1	IST4000-TBDH010	
11	cutter box outer blockshape	1	IST4000-TBDH011	
12	tool box inner block	1	-TBDH012	
13	M5X25 cup head screw	2	IST4000-TBDH013	
14	tool box adjustment block 1	1	IST4000-TBDH014	
15	tool box	1	IST4000-TBDH015	
16	cross knife holder	1	IST4000-TBDH016	
17	M5X12 Flat Head Screw	1	IST4000-TBDH017	
18	Connector Head	1	IST4000-TBDH018	
19	Connector Round	1	IST4000-TBDH019	
20	Knife Box Cover	1	IST4000-TBDH020	
21	Knife Box Upper Plate Plug	2	IST4000-TBDH021	
22	9.5	2	IST4000-TBDH022	
23	pins (diameter 4.75, length 16)	2	IST4000-TBDH023	
24	Right cutter	1	IST4000-TBDH024	
25	Knife edge connection pin	1	IST4000-TBDH025	
26	Knife box backing plate	1	IST4000-TBDH026	
27	Right push knife	1	IST4000-TBDH027	
28	Right outer Forming knife	1	IST4000-TBDH028	
29	knife box positioning block	1	IST4000-TBDH029	
30	pin (diameter 4.75, length 12)	2	IST4000-TBDH030	
31				

head part



B part B exploded view



head part B list

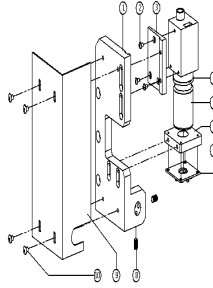
serial number	name	quantity	number	remarks
---------------	------	----------	--------	---------

1	gear protection Cover	1	IST4000-TB-B001
2	Head rack	1	IST4000-TB-B002
3	Linear guides (length 130)	1	IST4 000-TB-B003
4	H-axis detection piece	1	IST4000-TB-B004
5	H-axis zero position piece	2	IST4000-TB-B005
6	Photoelectric switch SX670	3	IST4000-TB-B006
7	Head photoelectric detection seat	1	IST4000-TB-B007
8	M5X8 round head screws	12	IST4000-TB-B008
9	H-axis bearing caps	3	IST4000-TB-
10	Bearings 6003Z	4	IST4000-TB-B010
11	Rail mounts	1	IST4000-TB-B011
12	Head castings	1	IST4000-TB- B012
13	M10X90 cup head screw	3	IST4000-TB-B013
14	belt pressure roller frame	1	IST4000-TB-B014
15	bearing CR10-I	1	IST4000-TB-B015
16	18 tooth sprocket	2	IST4000-TB-B016
17	Saigang Wheel	1	IST4000-TB-B017
18	Bearing TLA1416z	2	IST4000-TB-B018
19	14 Clamping ring	2	IST4000-TB-B019
20	clip top block shaft (diameter 14, length 170)	1	IST4000-TB-B020
21	H-axis adjustment Wheel	1	IST4000-TB-B021
22	Keys 5*5*30	3	IST4000-TB-B022
23	Synchronous Pulley 16L	1	IST4000-TB-B023
24	Clip Pulley	1	IST4000-TB-B024
25	H Turning Gear	1	IST4000-TB- B025
26	knife box connecting pin (diameter 4.75, length 40)	1	IST4000-TB-B026
27	M5X8 Kimi nut	2	IST4000-TB-B027

Camera part



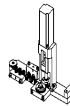
Camera exploded view



Camera part list

Serial No.	Name	Quantity	No.	Remarks
1	Camera Mounting Plate	1	IST4000- TB-XJ001	
2	M3X5 round head screws	3	IST4000-TB-XJ002	
3	camera fixing blocks	1	IST4000-TB-XJ003	
4	small cameras	1	IST4000-TB-XJ004	
5	camera heads	1	IST4000-TB-XJ005	
6	camera head mounting plates	1	IST4000- TB-XJ006	
7	Camera Light Board	1	IST4000-TB-XJ007	
8	M5X8 Kimi Screws	2	IST4000-TB-XJ008	
9	Camera Covers	1	IST4000-TB-XJ009	
10	M4X8 Round Head Screws	4	IST4000-TB-XJ010 Wire	

Feeding Part



Wire Explosion Figure

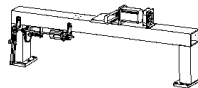


sending part list

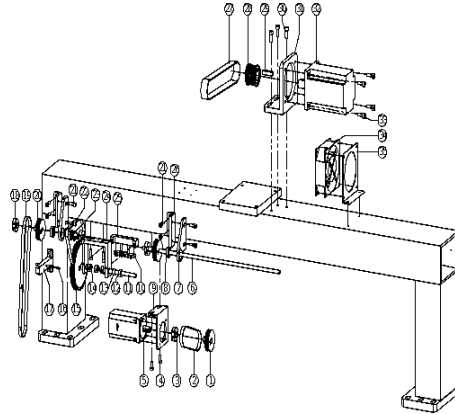
serial number	name	quantity	number	remarks
1	M5 custom screw	2	IST4000 -SX001	
2	Springs	6	IST4000-SX002	
3	Crimping Mounting Plate	Wheels 1	IST4000-SX003	
4	M5 Custom Screws 2	4	IST4000-SX004	
5	Crimping Plates 2	1	IST4000-SX005	
6	Crimping Wheels 3	10	IST4000-SX006	
7	Bearings 638/4	11	IST4000-SX007	
8	M4X12 round head screws	11	IST4000-SX008	
9	M4 spring washers	22	IST4000-SX009	
10	large pressure rollers	1	IST4000-SX010	
11	Wire pressure plates	1	IST4000-SX011	
12	M3X12 round head screws	2	IST4000-SX012	
13	100W motor	1	IST4000-SX013	
14	Couplings (8-8)	1	IST4000-SX014	
15	Jumper Motor Holder 1	1 1	IST4000-SX015	
16	Gear Shaft	1	IST4000-SX016	
17	Bearing 6000	2	IST4000-SX017	
18	0.4 Crimping Wheel	2	IST4000- SX018	
19	pin (diameter 3, length 9)	6	IST4000-SX019	
20	wire feed gear	1	IST4000-SX020	

21	jumper tube pressure block	1	IST4000-SX021
22	wire feed connection pad	1	IST4000-SX022
23	wire feed connection plate	1	IST4000- SX023
24	M5X25 cup head screws	2	IST4000-SX024
25	M5X15 cup head screws	4	IST4000-SX025
26	pins (diameter 3, length 18)	2	IST4000-SX026
27	wire feed gears 2	1	IST4000-SX027
28	bearings 605	2	IST4000-SX028
29	jumps Wire pulley screw	1	IST4000-SX029
30			
31			

Work frame part



Work frame exploded view

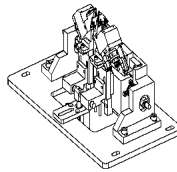


Work frame list

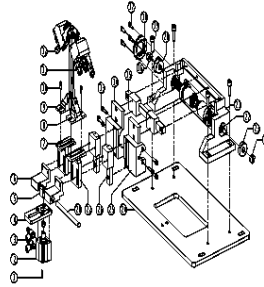
No.	Name	Quant	No.	Remarks
1	Jumper drive pulley (30XL)	1	IST4000-GZJJ001	
2	Belts 156XL-10	1	IST4000-GZJJ002	
3	18ring	1	IST4000-GZJJ003	
4	M6X15 cup head screw	2	IST4000-GZJJ004	
5	Fuji 400W motor	1	IST4000-GZJJ005	
6	10 optical axis (length 540)	1	IST4000-GZJJ006	
7	Z-axis transmission rod holder 2	2	IST4000-GZJJ007	
8	bearings 6000	2	IST4000-GZJJ008	
9	Z motor mounting bracket	1	IST4000-GZJJ009	
10	Photoelectric switch SX670	3	IST4000-GZJJ010	
11	width induction shaft (diameter 9.5, length 142)	1	IST4000-GZJJ011	
12	9.5 limit ring	2	IST4000-GZJJ012	
13	bearing BA66z	2	IST4000-GZJJ013	
14	width induction piece	3	IST4000-GZJJ014	
15	width induction pulley	1	IST4000-GZJJ015	
16	jumper tube	1	IST4000-GZJJ016	
17	jumper tube mounting block	1	IST4000-GZJJ017	
18	14 holding ring	3	IST4000-GZJJ018	
19	belt 250XL-10	1	IST4000-GZJJ019	
20	jumper drive pulley synchronous pulley (30XL)	2	IST4000-GZJJ020	
21	M6X20 cup head screw	4	IST4000-GZJJ021	
22	belt 182XL-10	1	IST4000-GZJJ022	
23	width sensor pulley (12XL)	1	IST4000-GZJJ023	
24	width sensor shelf	1	GZJJ024	
25	width sensor mounting	-	IST4000-GZJJ025	

	plate		
26	Z-axis drive rod holder 1	2	IST4000-GZJJ026
27	Belt 248L-28	1	IST4000-GZJJ027
28	Synchronous pulley A-16L	1	IST4000-GZJJ028
29	key 8*8*40	1	IST4000-GZJJ029
30	M8X20 cup head screw	3	IST4000-GZJJ030
31	Head motor seat	1	IST4000-GZJJ031
32	Fuji 1000W motor	1	IST4000-GZJJ032
33	M8X25 cup head screw	4	IST4000-GZJJ033
34	Cooling fan	1	-GZJJ034
35	Base fan mounting seat	1	-GZJJ0
37			
IST40			
00			

IST4000Base



scissor base Exploded diagram



Cut leg base list

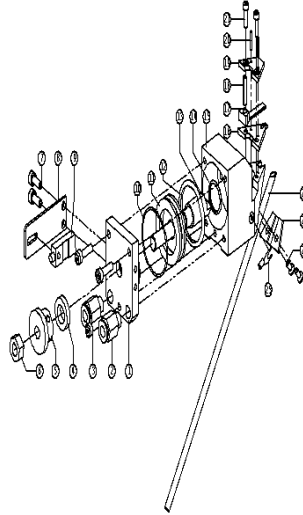
Serial number	Name	Quantity	No.	Remarks
1	Sensor	1	IST4000-BZ001	
2	Base Cylinder	1	IST4000-BZ002	
3	Control Valve PL6-01	2	IST4000-BZ003	
4	Cylinder Mounting Plate 1	1	IST4000-BZ004	
5	Cylinders Connection block	1	IST4000-BZ005	
6	Cylinder push block	2	IST4000-BZ006	
7	Left scissor foot up and down sliding fastener	1	IST4000-BZ007	
8	Right scissor foot cylinder mount	1	IST4000-BZ008	
9	Left scissor foot cylinder mount	1	IST4000-BZ009	
10	M4X10 Cup Head Screws	4	IST4000-BZ010	
11	Right Scissor Foot Cylinder	1	IST4000-BZ011	
12	Left Scissor Foot Cylinder	1	IST4000-BZ012	
13	M5X20 Cup Head Screws	6	IST4000-BZ013	
14	Left Scissor Foot Rail	1	IST4000-BZ014	
15	Scissor Foot Slide rail 200-15	1	IST4000-BZ015	
16	M10X1 nut	2	IST4000-BZ016	
17	M5X15 cup head screw	4	IST4000-BZ017	
18	left and right screw bearing cap	1	IST4000-BZ018	
19	M8X25 cup head screw	4	IST4000-BZ019	

20	bearing 5200z (with clip spring)	1	IST4000-BZ020
21	Base frame	1	IST4000-BZ021
22	Left and right rotating rods	1	IST4000-BZ022
23	Bearing 5200	1	IST4000-BZ023
24	Base mounting plate	1	IST4000-BZ024
25	Right scissor rail mount	1	IST4000-BZ025
26	Shear feet Slide rail 85-15	2	IST4000-BZ026
27	Right scissor foot up and down sliding fastener	1	IST4000-BZ027
28	10 optical axis (length 120)	1	IST4000-BZ028
29			

Left scissor foot



combination

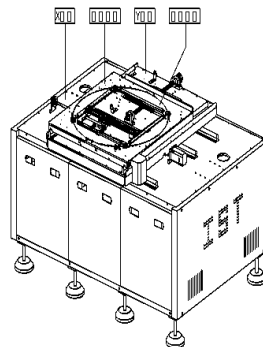


cylinderList

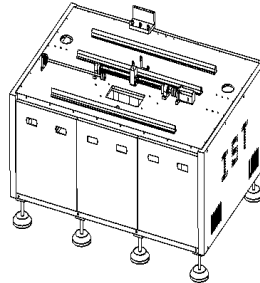
No.	Name	Quantity	No.	Remarks
1	Cylinder head with scissors	1	IST4000-ZJJQG001	
2	Steam connection PC06-01	2	IST4000-ZJJQG002	
3	M4X15 cup head screw	3	IST4000-ZJJQG003	
4	Cutting foot superior force rubber ring	1	IST4000-ZJJQG004	
5	Piston rod limit Nut	1	IST4000-ZJJQG005	
6	M8 Nut	1	IST4000-ZJJQG006	
7	M4X10 Cup Head Screw	2	IST4000-ZJJQG007	
8	Scissor Foot Sensor Mounting	1	IST4000-ZJJQG008	
9	Optical Fiber Sensor (TL-W3MC1)	1	IST4000-ZJJQG009	
10	Sealing	Ring.3 1.5-1	IST4000-ZJJQG010	
11	Pistons	1	IST4000-ZJJQG011	
12	Sealing Circle 28-3.5	IST4000	-ZJJQG012	
13	1	1	IST4000-ZJJQG013	
14	Seal 12.2-2.65	1	IST4000-ZJJQG014	
Cut	Cylome	1	ZJJQG015	
16	Triangle	-	Sword -ZJJQG016	
17	Right movable knife	1	IST4000- ZJJQG017	
18	hollow pin (diameter 3.2)	1	IST4000-ZJJQG018	
triangu	knife cover	1	ZJJQG019	

lar			
20	hollow pin (diameter 1.6)	1	IST4000-
M3X1	screw	2	21
0			
cup	ZJJQG020	-	IST4000
19	headTube pressing block	1	IST4000-ZJJQG023
24	M3X8 flat head screw	1	IST4000-ZJJQG024
25	wire plug	1	IST4000-ZJJQG025

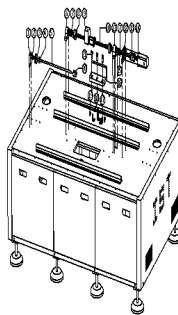
Workbench assembly



X platen



X platen explosion diagram

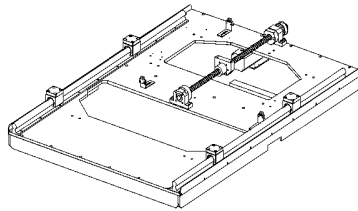


X platen list

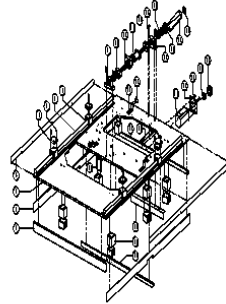
serial number	name	quantity	number	remarks
1	transmission rod fixing seat	1	IST4000 -GZT-XB001	
2	Bearings 6000	1	IST4000-GZT-XB002	
3	Jumper Drive Pulley Synchronization Pulley (30XL)	1	IST4000-GZT-XB003	
4	14 Tightening Rings	1	IST4000-GZT-XB004	
5	10 Optical Shafts (Length	1	IST4000 -GZT-XB005	

	540)		
6	X screw bearing housing 1	1	IST4000-GZT-XB006
7	bearing 6202	3	IST4000-GZT-XB007
8	X buffer glue	2	IST4000-GZT-XB008
9	X screw nut sleeve	1	IST4000-GZT-XB009
10	platform Screw 1	1	IST4000-GZT-XB010
11	X screw bearing seat 2	1	IST4000-GZT-XB011
12	X platform motor fixing seat	1	IST4000-GZT-XB012
13	Coupling (14-12)	1	IST4000-GZT-XB013
14	Fuji 400W motor	1	IST4000-GZT-XB014
15	M14X1.5 nut	1	IST4000-GZT-XB015
16	rack connector	1	IST4000-GZT-XB016
17	X limit sensor bracket	2	IST4000-GZT-XB017
18	X origin sensor bracket	1	IST4000-GZT-XB018
19	Photoelectric switch SX670	3	IST4000-GZT-XB019
20	Double diaphragm coupling (10-8)	1	IST4000-GZT-XB020
21	M12X30 cup head screw	3	IST4000-GZT-XB021

Y platen



Y platen exploded diagram

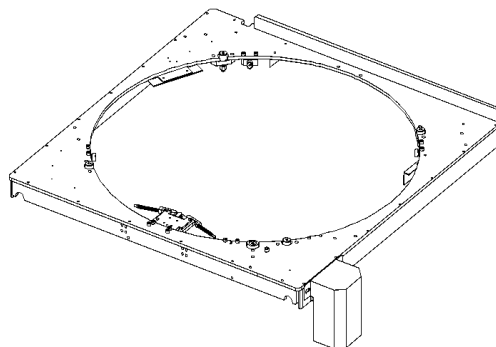


List of Y platen

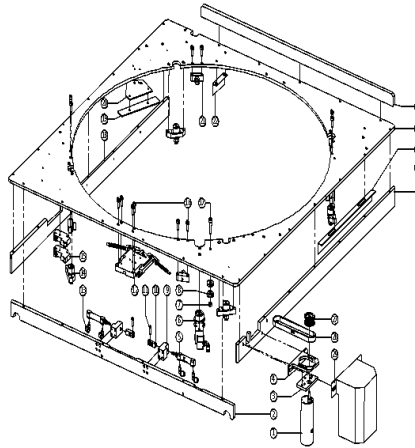
No.	Name	Quantity	No.	Remarks
1	Y platen reinforcement plate 3	1	IST4000-GZT-YB001	ks
2	Y platen left and right reinforcement plates	2	IST4000-GZT-YB002	
3	Y platen	1	IST4000-GZT-YB003	
4	5025 decorative plate	2	IST4000-GZT-YB004	
5	Slide block spacer	4	IST4000-GZT-YB005	
6	M6X15 cup head screw	8	IST4000-GZT-YB006	
7	Platform guide rail 2	2	IST4000-GZT-YB007	
8	Platform slide block	4	IST4000-GZT-YB008	
9	Y wire Rod bearing seat 1	1	IST4000-GZT-YB009	
10	Y buffer glue	2	IST4000-GZT-YB010	
11	Y screw nut sleeve	1	IST4000-GZT-YB011	
12	Screw nut	1	IST4000-GZT-YB012	
13	Platform screw 1	1	IST4000- GZT-YB013	
14	M6X25 cup head screw	6	IST4000-GZT-YB014	
15	Bearing 6202	3	IST4000-GZT-YB015	
16	16 Tightening ring	1	IST4000-GZT-YB016	
17	Belt 157L-15	1	IST4000-GZT-YB017	
18	XY drive pulley Wheel (14L)	1	IST4000-GZT-YB018	

19	Y screw bearing seat	1	IST4000-GZT-YB019
20	Photoelectric switch SX670	3	IST4000-GZT-YB020
21	Y limit sensor bracket	3	IST4000-GZT-YB021
22	Y platen reinforcement plate 2	2	IST4000-GZT-YB022
23	Tank chain fixing plate	1	IST4000-GZT-YB023
24	Fuji 400W motor	1	IST4000-GZT-YB024
25	Y motor mount	1	IST4000-GZT-YB025
26	M6X15 cup head screw	2	IST4000-GZT-YB026
27	18 Tightening ring	1	IST4000-GZT-YB027
28	XY screw drive pulley (14L)	1	IST4000-GZT-YB028
29	X limit sensing piece	1	IST4000-GZT-YB029
30	X origin sensing piece	1	IST4000-GZT-YB030
31	plus High spacer	6	IST4000-GZT-YB031

Disc platen



Disc platen exploded diagram

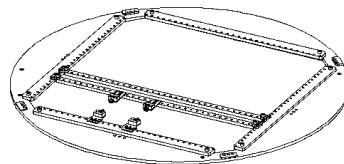


List of disc platen

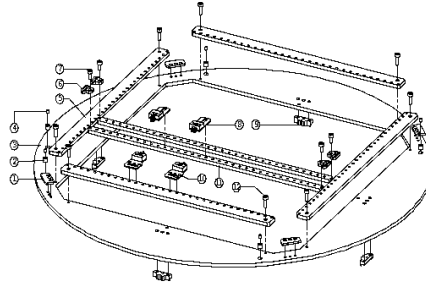
No.	Name	Quantity	No.	Remarks
1	100W small motor	1	IST4000-GZT-YPB001	
2	Turntable front shield	1	IST4000-GZT-YPB002	
3	Turntable motor mounting plate	1	IST4000-GZT-YPB003	
4	Turntable motor mounting bracket	1	IST4000- GZT-YPB004	
5	cylinder (CJ2B10-15)	2	IST4000-GZT-YPB005	
6	turntable pusher	1	IST4000-GZT-YPB006	
7	M6 nut	1	IST4000-GZT-YPB007	
8	bearing F606z	2	IST4000-GZT-YPB008	
9	cylinder mounting plate	2	IST4000 -GZT-YPB009	
10	cylinder connecting rod	2	IST4000-GZT-YPB010	
11	white race steel pin	2	IST4000-GZT-YPB011	
12	turntable lock	1	IST4000-GZT-YPB012	
13	elbow pipe (KJL-04-M3)	4	IST4000-GZT-YPB013	
14	Turntable Lateral Device X	4	IST4000-GZT-YPB014	
15	Solenoid Valve SMC (vqz115-5gb-m5-pr)	2	IST4000-GZT-YPB015	
16	M5X15 Cup Head Screw	12	IST4000-GZT-YPB016	
17	M6X25 Cup Head Screw	1	IST4000- GZT-YPB017	
18	turntable left guard plate	1	IST4000-GZT-YPB018	
19	turntable sensor	1	IST4000-GZT-YPB019	
20	turntable induction plate	1	IST4000-GZT-YPB020	
21	turntable lower rolling device	5	IST4000-GZT-YPB021	
22	Y limit sensor	1	IST4000-GZT-YPB022	
23	Turntable	Rear 1	IST4000-GZT-YPB023	

	Reinforcement Plate			
24	Mounting Plate 1	1		IST4000-GZT-YPB024
25	Y Origin Sensing Sheet	1		IST4000-GZT-YPB025
26	Turntable Right Guard Plate	1		IST4000-GZT- YPB026
27	Turning Motor Pulley (16XL)	1		IST4000-GZT-YPB027
28	Belt 222XL-10	1		IST4000-GZT-YPB028
29	Motor Cover	1		IST4000-GZT-YPB029

Turntable platen



Exploded view of turntable platen



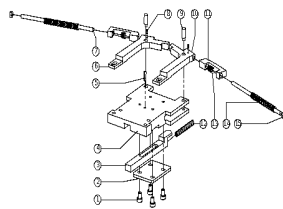
Turntable Table List

Serial Number	Name	Quantity	Number	Remarks
1	Turntable Card	4	IST4000-GZT-ZP001	
2	Magnet Mounting Ring	5	IST4000-GZT-ZP002	
3	Turntable	1	IST4000-GZT-ZP003	
4	Turntable Magnets (Diameter 4; Length 5)	5	IST4000-GZT -ZP004	
5	positioning beam	4	IST4000-GZT-ZP005	
6	beam connecting block	4	IST4000-GZT-ZP006	
7	M5X10 cup head screw	4	IST4000-GZT-ZP007	
8	PCD board holder	2	IST4000-GZT-ZP008	
9	turntable fixing block	4	IST4000- GZT-ZP009	
10	PCD board positioning seat	2	IST4000-GZT-ZP010	
11	Positioning beam 2	2	IST4000-GZT-ZP011	
12	M5X15 cup head screw	8	IST4000-GZT-ZP012	

Turntable Lock



Turntable Lock Exploded Diagram



Turntable Lock List

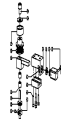
Serial Number	Name	Quantity	Number	Remarks
1	M4X6 Cup Head Screws	4	IST4000-GZT-ZPS001	
2	Turntable Lock Covers	1	IST4000-GZT-ZPS002	
3	Locking Pins	1	IST4000-GZT-ZPS003	
4	Turntable Locks	1	IST4000-GZT-ZPS004	

5	Hollow Pins (diameter 3)	1	IST4000-GZT-ZPS005
6	turntable lock accessories 3	1	IST4000-GZT-ZPS006
7	turntable lock accessories 4	2	IST4000-GZT-ZPS007
8	hollow pins (diameter 1.0)	2	IST4000-GZT-ZPS008
9	turntable lock pins	2	IST4000-GZT-ZPS009
10	Turntable lock accessories 1	1	IST4000-GZT-ZPS010
11	Turntable lock accessories 2	2	IST4000-GZT-ZPS011
12	springs (0.8*4.5*1.7*40)	1	IST4000-GZT-ZPS012
13	springs (0.8*4.5 *1.7*6)	1	IST4000-GZT-ZPS013
14	springs (1.2*7*2.5*65)	2	IST4000-GZT-ZPS014
15	M4 nuts	2	IST4000-GZT-ZPS015

turntable



pusher



List of Turntable Pushing Devices

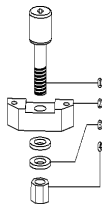
Serial Number	Name	Quantity	Number	Remarks
1	M3X6 Cup Head Screw	1	IST4000-GZT-ZPZZ001	
2	Sheet Bearings 6196	1	IST4000-GZT-ZPZZ002	
3	Turntable Axles	1	IST4000-GZT-ZPZZ003	
4	Needle Roller Bearings SCE45	2	IST4000-GZT-ZPZZ004	
5	push block	1	IST4000-GZT-ZPZZ005	
6	wheel (16XL)	1	IST4000-GZT-ZPZZ006	
7	turntable drive wheel	1	IST4000-GZT-ZPZZ007	
8	M8X10 cup head screw	1	IST4000-GZT-ZPZZ008	
9	M8 screw washer	1	IST4000-GZT-ZPZZ009	
10	Turntable pressure roller	1	IST4000-GZT-ZPZZ010	

	mounting block 1		
11	Gasket 1	1 1	IST4000-GZT-ZPZZ011
12	cylinder (CJP28B10-5D)	1	IST4000-GZT-ZPZZ012
13	elbow pipe (KJL-04-M3)	2	IST4000-GZT-ZPZZ013
14	cylinder nut	1	IST4000-GZT-ZPZZ014
15	turntable pressure roller mounting cover	1	IST4000-GZT-ZPZZ015
16	M4X15 cup head screw	4	IST4000-GZT-ZPZZ016
17	6.5 clamping ring	1	IST4000-ZPZZ17-GZT

Turntable side



device exploded view of turntable side



转盘侧向装置清单

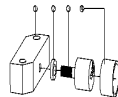
序号	名称	数量	编号	备注
1	♀M12♀ 螺丝	1	IST4000-GZT-ZPZX001	

2	♀ \varnothing 12 Ω 轴承安装座	1	IST4000-GZT-ZPZX002
3	赛钢垫片 2	2	IST4000-GZT-ZPZX003
4	♀ \varnothing 12 Ω 螺母	1	IST4000-GZT-ZPZX004

转盘下滚动装置



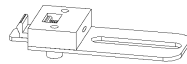
转盘下滚动装置爆炸图



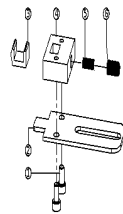
转盘下滚动装置清单

序号	名称	数量	编号	备注
1	♀ \varnothing 10- Ψ 安装座	1	IST4000-GZT-ZPXZZ001	
2	赛钢垫片 1	1	IST4000-GZT-ZPXZZ002	
3	CR10-I	1	IST4000-GZT-ZPXZZ003	
4	内 12 外 16 气管	1	IST4000-GZT-ZPXZZ004	

♀ \varnothing 板定位座



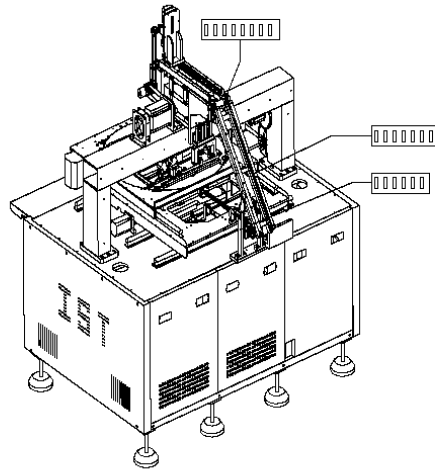
PCB 板卡座爆炸图



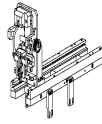
PCB 板卡座清单

序号	名称	数量	编号	备注
1	*3#5 杯头螺丝	2	IST4000-GZT-PCBBK001	
2	PCB 卡片	1	IST4000-GZT-PCBBK002	
3	顶片	1	IST4000-GZT-PCBBK003	
4	PCB 卡块	1	IST4000-GZT-PCBBK004	
5	弹 (0.4*4.3*1.9*10)	簧 1	IST4000-GZT-PCBBK005	
6	*5#6 基米螺丝	1	IST4000-GZT-PCBBK006	

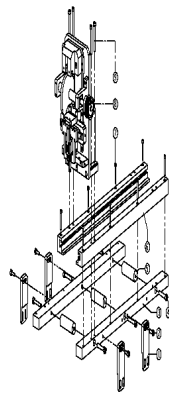
后面部分注解图



对中机构



对中机构爆炸图



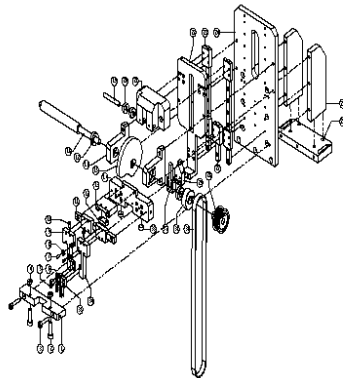
对中机构清单

序号	名称	数量	编号	备注
1	链槽支撑块	4	IST4000-DZJG0001	
2	*5 ∇ 15 杯头螺丝	4	IST4000-DZJG0002	
3	链条安装板	2	IST4000-DZJG0003	
4	*6 ∇ 35 杯头螺丝	6	IST4000-DZJG0004	
5	小赛钢轮	3	IST4000-DZJG0005	
6	链条滑动赛钢板	2	IST4000-DZJG0006	
7	*4 ∇ 30 杯头螺丝	8	IST4000-DZJG0007	
8	对中夹	1	IST4000-DZJG0008	
9	*5 ∇ 45 杯头螺丝	4	IST4000-DZJG0009	

对中夹



对中夹爆图

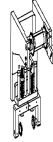


对中夹清单

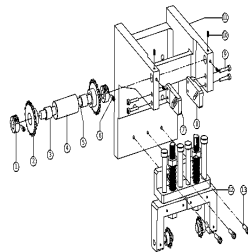
序号	名称	数量	编号	备注
1	对中限位块 2	1	IST4000-DZJ001	
2	*6 \times 30 杯头螺丝	2	IST4000-DZJ002	

3	*5 ∇ 25 杯头螺丝	2	IST4000-DZJ003
4	*6 螺母	2	IST4000-DZJ004
5	*3 ∇ 6 杯头螺丝	4	IST4000-DZJ005
6	左对中夹	1	IST4000-DZJ006
7	滚动轮安装销 (直径 3.长 8)	2	IST4000-DZJ007
8	滚动轮 2	2	IST4000-DZJ008
9	对中夹左安装块	1	IST4000-DZJ009
10	*3 ∇ 5 杯头螺丝	2	IST4000-DZJ010
11	短导轨	1	IST4000-DZJ011
12	对中夹优力胶垫	1	IST4000-DZJ012
13	对中限位块	1	IST4000-DZJ013
14	对中夹安装块 2	1	IST4000-DZJ014
15	对中凸轮	1	IST4000-DZJ015
16	传动轴固定架	2	IST4000-DZJ016
17	轴承 619/9	2	IST4000-DZJ017
18	对传动轴	1	IST4000-DZJ018
19	轴承销 (直径 6, 长 40)	1	IST4000-DZJ019
20	轴承 696	2	IST4000-DZJ020
21	滚动轮安装块	1	IST4000-DZJ021
22	对中夹连接块 1	1	IST4000-DZJ022
23	85 导轨 (长 170)	2	IST4000-DZJ023
24	对中夹安装块 1	1	IST4000-DZJ024
25	对中夹板中加强筋	2	IST4000-DZJ025
26	对中夹板加强筋	1	IST4000-DZJ026
27	中滑轨 (长 60)	1	IST4000-DZJ027
28	对中夹皮带轮 ⊙	1	IST4000-DZJ028
29	中间活动块	1	IST4000-DZJ029
30	皮带	1	IST4000-DZJ030
31	13 抱紧圈	1	IST4000-DZJ031
32	对中上下限位块	1	IST4000-DZJ032
33	优力胶垫圈	2	IST4000-DZJ033
34	对中夹右安装块	1	IST4000-DZJ034
35	右对中夹	1	IST4000-DZJ035
36			
37			
38			
39			

链轮上下调节组合



链轮上下调节组合爆炸图



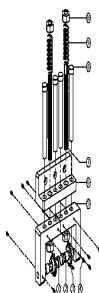
链轮上下调节组合清单

序号	名称	数量	编号	备注
1	14 抱紧圈	2	IST4000-LLSXTJ001	
2	18 齿链轮	2	IST4000-LLSXTJ002	
3	轴承 $\Omega \neq \odot 1416 \odot$	2	IST4000-LLSXTJ003	
4	赛钢轮	1	IST4000-LLSXTJ004	
5	对中链轮轴 (直径 14, 长 170)	1	IST4000-LLSXTJ005	
6	*4 ∇ 10 杯头螺丝	1	IST4000-LLSXTJ006	
7	右连接块	1	IST4000-LLSXTJ007	
8	左连接块	1	IST4000-LLSXTJ008	
9	*5 ∇ 25 杯头螺丝	4	IST4000-LLSXTJ009	
10	*4 ∇ 8 基米螺丝	4	IST4000-LLSXTJ010	
11	对中机构铸件	1	IST4000-LLSXTJ011	
12	链轮上下调节器	1	IST4000-LLSXTJ012	
13	*6 ∇ 20 杯头螺丝	3	IST4000-LLSXTJ013	

链轮上下调节器



链轮上下调节器爆炸图



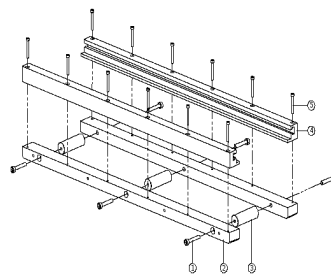
链轮上下调节器清单

序号	名称	数量	编号	备注
1	链轮销 (直径 9.5)	2	IST4000-LLSXTJQ001	
2	轴承 $\varnothing 68 \text{C}$	2	IST4000-LLSXTJQ002	
3	10 齿链轮	2	IST4000-LLSXTJQ003	
4	*4 \times 8 基米螺丝	10	IST4000-LLSXTJQ004	
5	*14 丝杆固定块	2	IST4000-LLSXTJQ005	
6	可调节板	1	IST4000-LLSXTJQ006	
7	*14 丝杆	2	IST4000-LLSXTJQ007	
8	12 销钉 (长 100)	4	IST4000-LLSXTJQ008	
9	弹簧	2	IST4000-LLSXTJQ009	
10	*14 螺母	4	IST4000-LLSXTJQ010	

后链条导轨部分



后链条导轨爆炸图



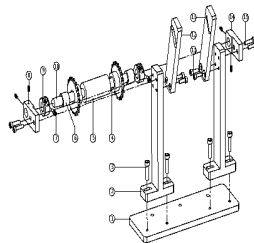
后链条导轨清单

序号	名称	数量	编号	备注
1	*6 ∇ 35 杯头螺丝	6	IST4000-HLTDG001	
2	后链条安装板	2	IST4000-HLTDG002	
3	小赛钢轮	3	IST4000-HLTDG003	
4	后链条滑动赛钢板	2	IST4000-HLTDG004	
5	*4 ∇ 30 杯头螺丝	10	IST4000-HLTDG005	
6				

尾部链轮部分



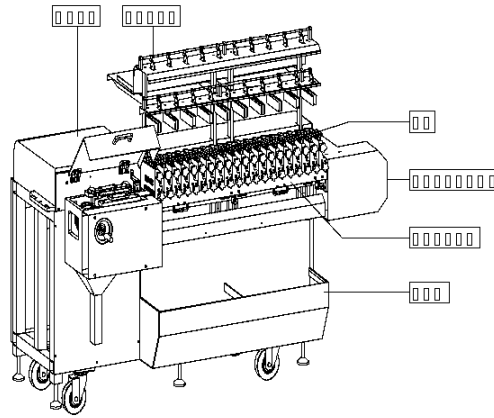
尾部链轮爆炸图



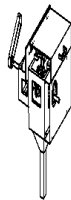
尾部链轮清单

序号	名称	数量	编号	备注
1	链轮架安装底板	1	IST4000-WDLL001	
2	Ω 型支撑架	2	IST4000-WDLL002	
3	*6 ∇ 25 杯头螺丝	4	IST4000-WDLL003	
4	18 齿链轮	2	IST4000-WDLL004	
5	赛钢轮	1	IST4000-WDLL005	
6	轴承 $\Omega \nabla \odot 1416 \odot$	2	IST4000-WDLL006	
7	*4 ∇ 10 杯头螺丝	2	IST4000-WDLL007	
8	*4 ∇ 8 基米螺丝	4	IST4000-WDLL008	
9	14 抱紧圈	2	IST4000-WDLL009	
10	14 光轴 (长 190)	1	IST4000-WDLL010	
11	*5 ∇ 15 杯头螺丝	4	IST4000-WDLL011	
12	链轮支撑左角度块	1	IST4000-WDLL012	
13	链轮支撑右角度块	1	IST4000-WDLL013	
14	尾部链轮轴安装块	2	IST4000-WDLL014	
15	*5 ∇ 20 杯头螺丝	4	IST4000-WDLL015	

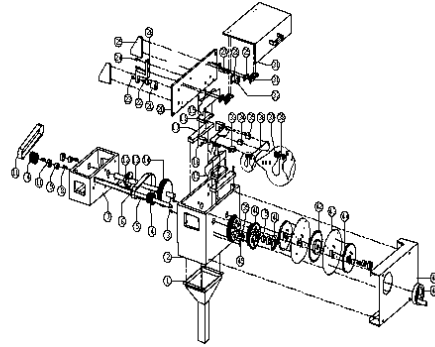
后支架总体



联体部分



联体部分爆炸图

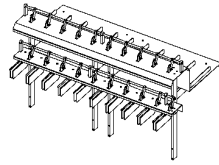


联体部分清单

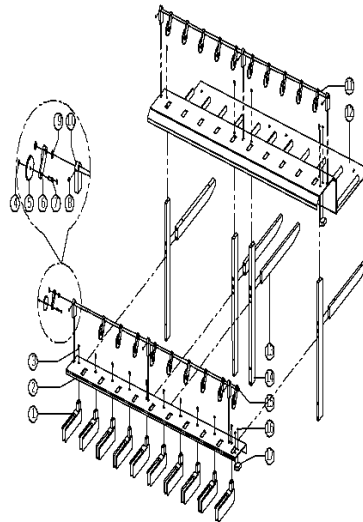
序号	名称	数量	编号	备注
1	废脚漏斗	1	IST4000-LT001	
2	铸件 2	1	IST4000-LT002	
3	销钉 (直径 6, 长 20)	2	IST4000-LT003	
4	主动同步轮 ($\delta\Omega\oplus-5-30$)	2	IST4000-LT004	
5	主动链轮轴	1	IST4000-LT005	
6	皮带 $\delta\Omega\oplus600-5*-25$	1	IST4000-LT006	
7	铸件 2	1	IST4000-LT007	
8	键 6*6*30	4	IST4000-LT008	
9	轴承 $\phi\odot1310\odot$	6	IST4000-LT009	
10	限位圈 (20.6)	4	IST4000-LT010	
11	皮带 $\delta\Omega\oplus580-5*-25$	1	IST4000-LT011	
12	同步轮固定座	1	IST4000-LT012	
13	从动链轮轴	1	IST4000-LT013	
14	从动同步轮 ($\delta\Omega\oplus-5-81$)	1	IST4000-LT014	
15	右挡片	1	IST4000-LT015	
16	垫块	2	IST4000-LT016	
17	压料片固定座	2	IST4000-LT017	
18	压料片安装块	2	IST4000-LT018	
19	左挡片	1	IST4000-LT019	

20	连接面板	1	IST4000-LT020
21	皮带压轮	1	IST4000-LT021
22	轴承 $\varnothing 12$	1	IST4000-LT022
23	轴承 $\varnothing 12$ 螺母	1	IST4000-LT023
24	*6 \times 25 杯头螺丝	2	IST4000-LT024
25	三角支撑块	2	IST4000-LT025
26	皮带压轮固定块	1	IST4000-LT026
27	感应器安装机构 1	1	IST4000-LT027
28	感应器安装机构 3	1	IST4000-LT028
29	合叶垫片	2	IST4000-LT029
30	亚克力盖板	1	IST4000-LT030
31	合叶 46 \times 60	2	IST4000-LT031
32	感应器 ($\varnothing 3 \approx - \Omega 61 -$ ♀)	1	IST4000-LT032
33	压料片左安装板	1	IST4000-LT033
34	间隔块	1	IST4000-LT034
35	压料片右安装板	1	IST4000-LT035
36	拱形压料片	2	IST4000-LT036
37	*5 螺丝垫片	4	IST4000-LT037
38	毛刷	2	IST4000-LT038
39	光电开关 $\varnothing 671$	1	IST4000-LT039
40	40 齿链轮	2	IST4000-LT040
41	10 齿检测盘	1	IST4000-LT041
42	36 齿链轮	1	IST4000-LT042
43	接料轮	2	IST4000-LT043
44	接料轮压板	2	IST4000-LT044
45	联体机构前盖板	1	IST4000-LT045
46	摇头	1	IST4000-LT046
47			

上护架部分



上护架爆炸图

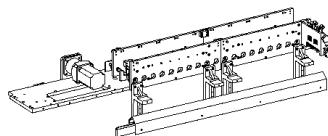


上护架清单

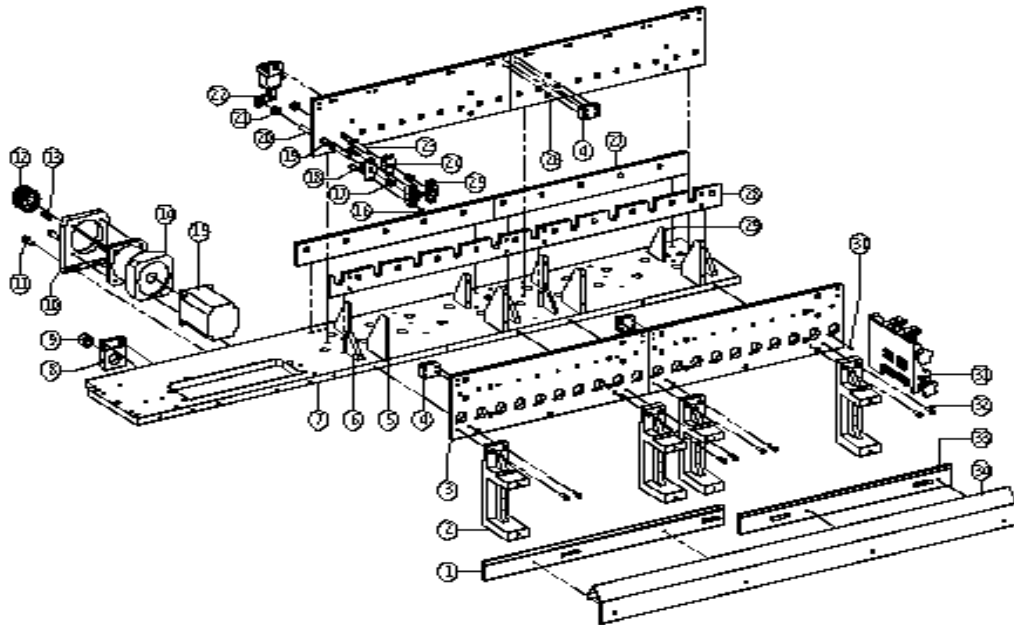
序号	名称	数量	编号	备注
1	∩♀⊕ 料	10	IST4000-SWJ001	
2	钣金 2	1	IST4000-SWJ002	
3	平头螺丝 *4#8	10	IST4000-SWJ003	

4	♂ 型外卡簧 (直径 40 3.5)	40	IST4000-SWJ004
5	感应器挡轮	20	IST4000-SWJ005
6	感应器挡轮座	20	IST4000-SWJ006
7	感应器挡轮销钉	20	IST4000-SWJ007
8	*4#8 基米螺丝	6	IST4000-SWJ008
9	♂ 型外卡簧 (直径 40 6.5)	40	IST4000-SWJ009
10	检测杆固定座	6	IST4000-SWJ010
11	上过料检测杆	1	IST4000-SWJ011
12	上护架组合	1	IST4000-SWJ012
13	天盖立板	4	IST4000-SWJ013
14	天盖立板 1	4	IST4000-SWJ014
15	下过料检测杆	1	IST4000-SWJ015
16	平头螺丝 *3.75	2	IST4000-SWJ016
17	感应器 (♂3#-Ω61-♀)	1	IST4000-SWJ017
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站位组合



站位组合爆炸图



站位组合清单

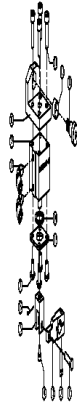
序号	名称	数量	编号	备注
1	头部下链引导板	1	IST4000-ZW001	
2	链条托架铸件	4	IST4000-ZW002	
3	下料头安装板	2	IST4000-ZW003	
4	连接块	3	IST4000-ZW004	
5	三角走支撑块	4	IST4000-ZW005	
6	站位铝板加强筋	4	IST4000-ZW006	
7	站位汽缸安装板 ⊙	1	IST4000-ZW007	
8	传动杆轴承安装套	1	IST4000-ZW008	
9	轴承 $\varnothing\odot 1310\odot$	1	IST4000-ZW009	
10	750m 马达座	1	IST4000-ZW010	
11	*8 ∇ 20 杯头螺丝	2	IST4000-ZW011	
12	同步轮 ($\delta\Omega\oplus-5-$ 30)	1	IST4000-ZW012	
13	键 6*60*30	1	IST4000-ZW013	
14	$\oplus\delta 090$ 减速机	1	IST4000-ZW014	
15	富士 750m 电机	1	IST4000-ZW015	
16	*5 防松螺母	40	IST4000-ZW016	
17	单向轴承 $\delta 7101612$	20	IST4000-ZW017	
18	连接螺丝	40	IST4000-ZW018	
19	铜套 (内 10, 外 12)	40	IST4000-ZW019	
20	汽缸推动轴 2 (长 204)	10	IST4000-ZW020	

21	限位圈	50	IST4000-ZW021
22	站位汽缸组合	20	IST4000-ZW022
23	汽缸推动轴 1 (长 130)	1	IST4000-ZW023
24	站位汽缸接头	20	IST4000-ZW024
25	站位汽缸接头 1	20	IST4000-ZW025
26	站位固定板 2	2	IST4000-ZW026
27	站位固定板 1	2	IST4000-ZW027
28	站位固定板 4	2	IST4000-ZW028
29	站位加强筋	3	IST4000-ZW029
30	下料头定位螺丝	20	IST4000-ZW030
31	下料头组合	20	IST4000-ZW031
32	*6 \times 20 杯头螺丝	8	IST4000-ZW032
33	下链引导板	1	IST4000-ZW033
34	下链条挡板	1	IST4000-ZW034

站位汽缸组合



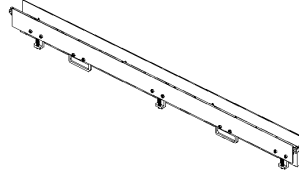
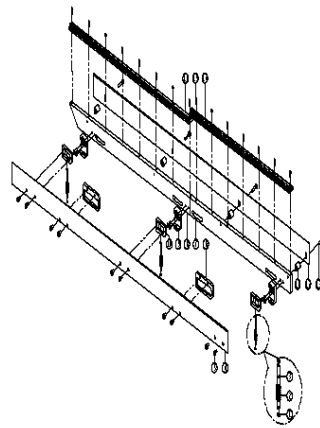
站位汽缸组合爆炸图



站位汽缸组合清单

序号	名称	数量	编号	备注
1	销钉 5 \times 25	1	IST4000-ZWQG001	
2	*5 \times 15 杯头螺丝	1	IST4000-ZWQG002	
3	汽缸推动块 3	1	IST4000-ZWQG003	
4	*4 \times 10 杯头螺丝	1	IST4000-ZWQG004	+ 螺丝胶
5	汽缸推动块 1	1	IST4000-ZWQG005	
6	销插	1	IST4000-ZWQG006	
7	*5 \times 10 圆头螺丝	4	IST4000-ZWQG007	
8	弯接管 ∇ 6-01	2	IST4000-ZWQG008	
9	E \odot ∇ 汽缸 20-15	1	IST4000-ZWQG009	
10	E \odot ∇ 汽缸固定座	1	IST4000-ZWQG010	
11	*5 \times 20 杯头螺丝	4	IST4000-ZWQG011	
12	铜套 (内 11, 外 13)	1	IST4000-ZWQG012	
13	* ∇ 10-10 螺栓	1	IST4000-ZWQG013	
14	汽缸卡簧固定圈	1	IST4000-ZWQG014	
15	汽缸卡簧固定块	1	IST4000-ZWQG015	
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链条导轨组合


链条导轨组合爆炸图

链条导轨组合清单

序号	名称	数量	编号	备注
1	♂ 型外卡簧	3	IST4000-LTDG001	
2	弹簧	3	IST4000-LTDG002	
3	弹簧销	3	IST4000-LTDG003	

4	上链条前挡板	1	IST4000-LTDG004
5	*5 ∇ 10 杯头螺丝	10	IST4000-LTDG005
6	拉手	2	IST4000-LTDG006
7	导轨辅助板 3	1	IST4000-LTDG007
8	机头导轨安装板	1	IST4000-LTDG008
9	导轨锁块	3	IST4000-LTDG009
10	前挡板固定板	3	IST4000-LTDG010
11	后挡板垫圈	4	IST4000-LTDG011
12	上链条后挡板	1	IST4000-LTDG012
13	*5 ∇ 30 杯头螺丝	4	IST4000-LTDG013
14	赛钢引导条	1	IST4000-LTDG014
15	*3 ∇ 12 杯头螺丝	15	IST4000-LTDG015
16	前赛钢引导条	1	IST4000-LTDG016

排料尾部链轮



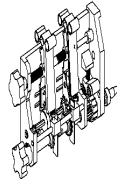
排料尾部链轮爆炸图



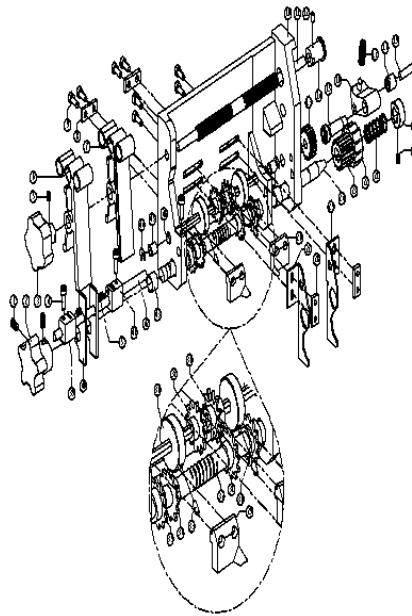
排料尾部链轮清单

序号	名称	数量	编号	备注
1	外卡簧 (直径 14)	2	IST4000-PLWD0001	
2	皮带轮连接轴	1	IST4000-PLWD0002	
3	键 5*5*30	1	IST4000-PLWD0003	
4	齿轮 36	1	IST4000-PLWD0004	
5	尾部链轮固定座	1	IST4000-PLWD0005	
6	调整块	1	IST4000-PLWD0006	
7	*10 螺母	1	IST4000-PLWD0007	
8	*10 ∇ 40 杯头螺丝	1	IST4000-PLWD0008	
9	尾部链条座定位块	1	IST4000-PLWD0009	
10	*4 ∇ 20 杯头螺丝	3	IST4000-PLWD0010	
11	*6 ∇ 25 杯头螺丝	4	IST4000-PLWD0011	
12	链条校正块	1	IST4000-PLWD0012	
13	*5 ∇ 35 杯头螺丝	2	IST4000-PLWD0013	
14	尾部链保护罩	1	IST4000-PLWD0014	
15	*8 ∇ 20 杯头螺丝	4	IST4000-PLWD0015	
16	尾部安装板 ⊙	1	IST4000-PLWD0016	
17	刹车连接板	1	IST4000-PLWD0017	
18	轴承 \varnothing C1616	2	IST4000-PLWD0018	

下料头组合



下料头组合爆炸图



下料头组合清单

序号	名称	数量	编号	备注
1	*5 \times 8 基米螺丝	2	IST4000-XLT001	

2	主驱动杆手柄	1	IST4000-XLT002
3	左右丝杆手柄	1	IST4000-XLT003
4	*4↗12 杯头螺丝	3	IST4000-XLT004
5	*4↗5 基米螺丝	1	IST4000-XLT005
6	左元件胶轨道	1	IST4000-XLT006
7	右元件胶轨道	1	IST4000-XLT007
8	左右切刀垫片	2	IST4000-XLT008
9	*4↗10 杯头螺丝	8	IST4000-XLT009
10	下料底板	1	IST4000-XLT010
11	左右丝杆	1	IST4000-XLT011
12	*3↗5 基米螺丝	1	IST4000-XLT012
13	被驱动齿轮	1	IST4000-XLT013
14	左右丝杆固定圈	1	IST4000-XLT014
15	*6 紧顶螺钉	1	IST4000-XLT015
16	弹簧跳座	1	IST4000-XLT016
17	弹簧	1	IST4000-XLT017
18	小赛钢轮	1	IST4000-XLT018
19	赛钢轮安装销	1	IST4000-XLT019
20	限位圈	1	IST4000-XLT020
21	弹簧	1	IST4000-XLT021
22	带动齿轮	1	IST4000-XLT022
23	主驱动齿轮	1	IST4000-XLT023
24	主驱动杆	1	IST4000-XLT024
25	右卡块	1	IST4000-XLT025
26	站头右侧切刀	1	IST4000-XLT026
27	左卡块	1	IST4000-XLT027
28	卡块垫块	1	IST4000-XLT028
29	站头左侧切刀	1	IST4000-XLT029
30	右侧齿轮切刀	1	IST4000-XLT030
31	右侧导向齿轮	1	IST4000-XLT031
32	弹簧	1	IST4000-XLT032
33	*3↗10 基米螺丝	2	IST4000-XLT033
34	左侧导向齿轮	1	IST4000-XLT034
35	左侧齿轮切刀	1	IST4000-XLT035
36	6 限位圈	1	IST4000-XLT036
37	左侧元件齿轮	1	IST4000-XLT037
38	右侧元件齿轮	1	IST4000-XLT038
39	左导向片固定块	1	IST4000-XLT039
40	导向片	2	IST4000-XLT040
41	右导向片固定块	1	IST4000-XLT041
42	导向片固定支杆	1	IST4000-XLT042
43	铜套（内 10，外 12）	2	IST4000-XLT043
44	♂ 型外卡簧（直径 5）	2	IST4000-XLT044
45	铜套（内 8，外 10）	2	IST4000-XLT045
46	驱动杆	1	IST4000-XLT046
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Southern Machinery Sales and Service Co., Ltd.