

Shenzhen Southern Machinery Sales and Service Co.,Ltd

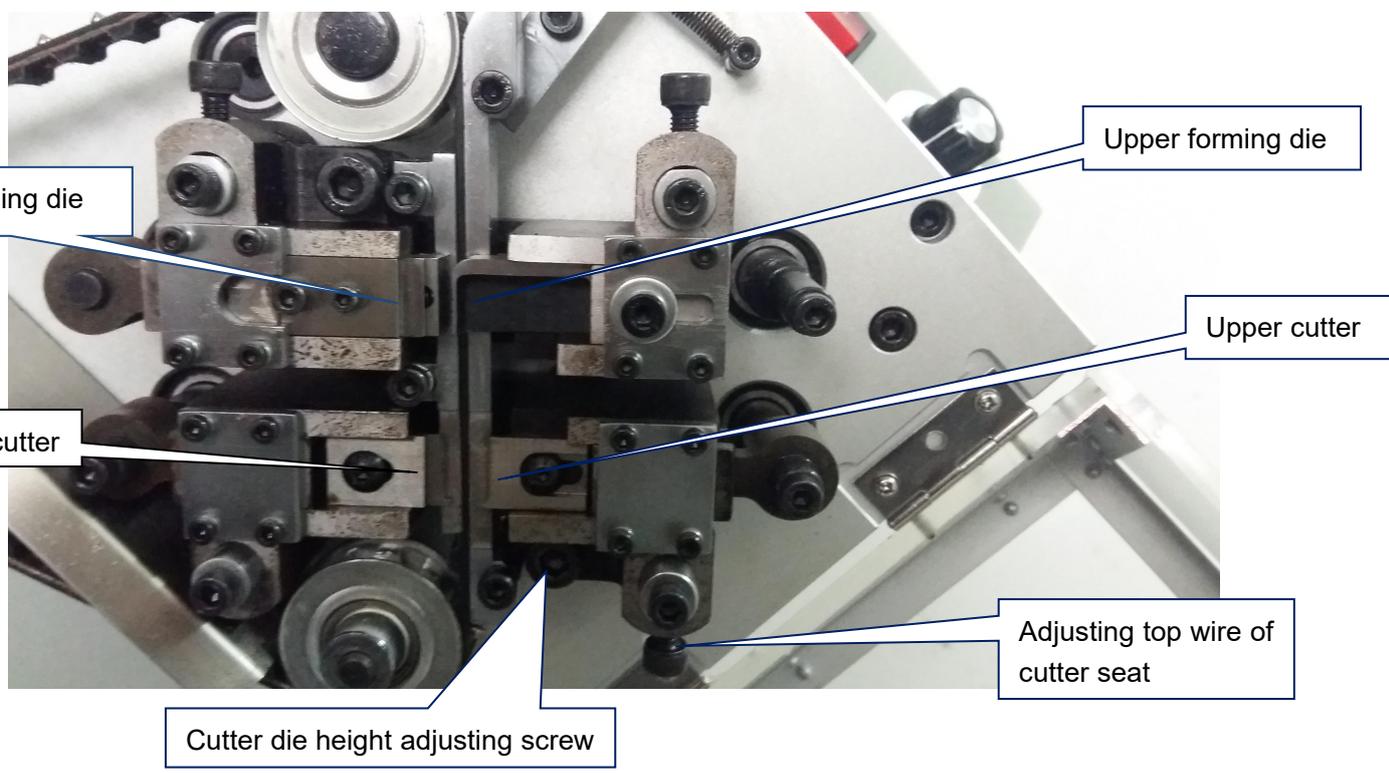
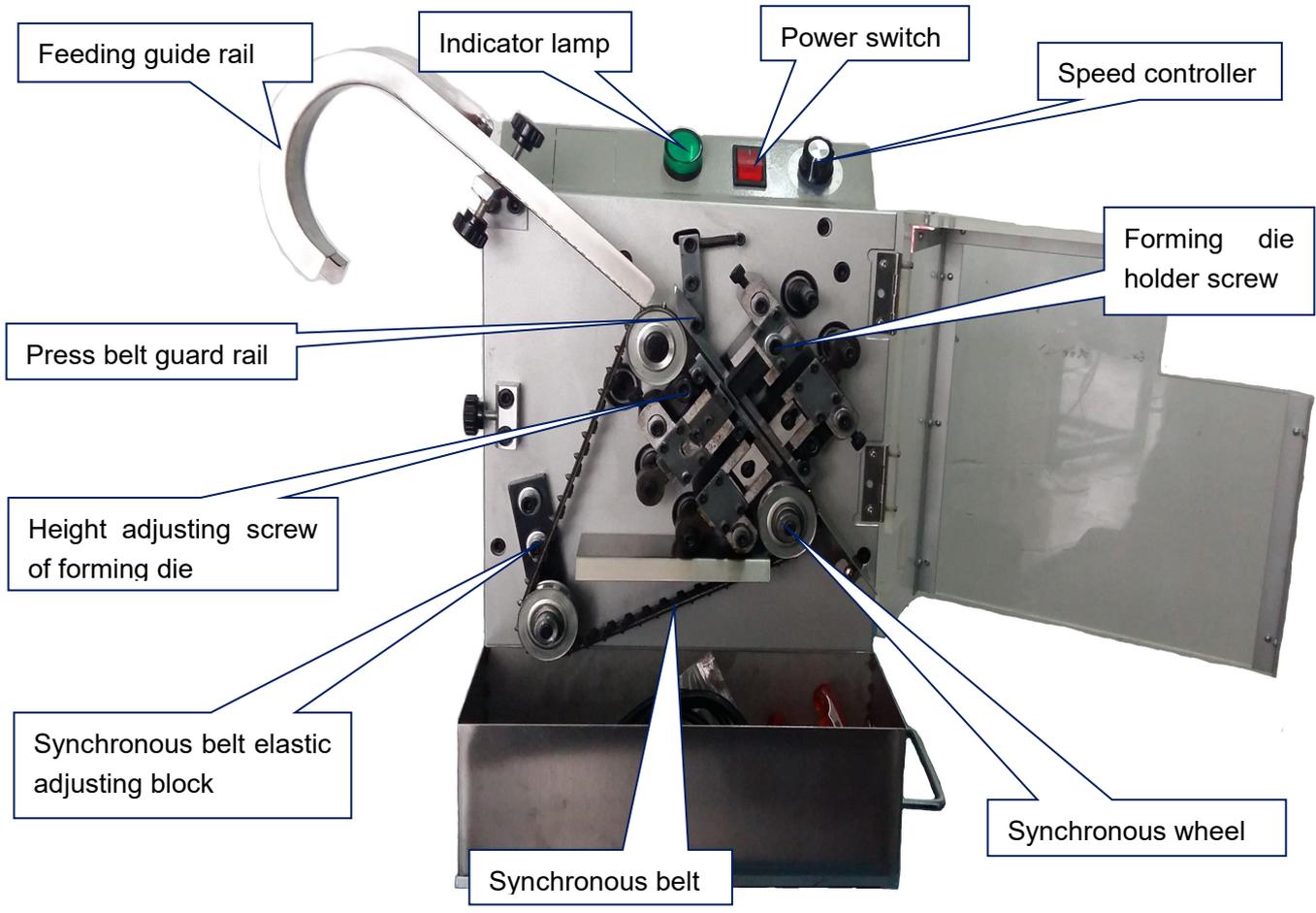
SM-320 Braiding radial element forming machine Operation and Maintenance Manual



Design, manufacture and sales

- Electronic components molding machine, electronic components casing machine, electronic components taping machine.
- PCB splitter, screw locking machine, dispensing machine, soldering machine.
- Assembly automation equipment.
- Non standard design and manufacturing automation equipment.
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1. Structure description



2.Operation method

2.1 Commissioning

Turn on the power switch and the indicator light will light up. Turn the governor to the appropriate position to start the operation. After the trial operation is normal, return the motor governor to zero and start the next action.

2.2 Feeding

Place the raw material rack between the two material wheels, place the paper belt inside, the material body is outward, and then enter the left track, so that the small circular hole of the paper belt can be aligned with the synchronous belt in a straight line. There is a conical small cylinder on the belt. Put the small circular hole of the paper belt into the conical small cylinder, press down the toothed belt guide rail by hand, slowly adjust and accelerate the speed of the governor, and the paper belt then enters the mold, and the feeding action is completed.

2.3 Attempt

When the material reaches the upper and lower forming molds, the thread foot will be formed and bent first (formed according to the style specified in the order), but the components are still attached to the paper tape. Check whether the forming angle is correct, and the depth and depth of the angle can be adjusted slightly by the fixing screw. After confirmation, the components can be cut off.

2.4 Height adjustment

The distance between the molding position of the molding foot and the body, and the molding position can be adjusted by rotating the height adjusting screw of the molding die base.

2.5 Foot length adjustment

For the length of the left thread foot, the height adjusting screw of the cutter base can be rotated to move the whole set of cutter base up and down, and the length of the foot also changes.

2.6 Tape out

When the component is cut off, the raw materials will jump out. It is necessary to close the protective cover, and the waste paper belt will be led out from the waste hole after being guided.

3.Points for attention

- 3.1 If the belt is loose, adjust the tension adjusting block of the synchronous belt.
- 3.2 The element has a synchronous relationship with the die and should be aligned with the center of the upper and lower forming die.
- 3.3 To adjust the position of the timing belt, loosen the screw on the pulley to adjust the forming position of the element.
- 3.4 The adjustment of forming die base and cutting die base is to rotate the adjusting screw to move the whole group.

4.Maintenance

- 4.1 There are four groups of eccentric shafts, which need to be rubbed and refueled regularly.
- 4.2 Round module, regular refueling is required.
- 4.3 The cutter fixing screw shall be locked without looseness.
- 4.4 The upper and lower forming dies need to be slightly adjusted with different wire diameters.