

C044

OPERATING MANUAL

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I. GENERAL DESCRIPTION:

The Streckfuss model C044 is designed to cut and form the leads of loose axial components for vertical mounting. A variety of form shapes are available through the use of interchangeable die sets. Set up adjustments are simple to make and secured to provide accurate forming on every component. Components are hand fed into the tooling with the body positioned between the left die and the bending mandrel. Once in position the foot pedal is depressed and the right lead is clamped securely against the bending mandrel to reduce stress. The die sets are then advanced cutting and forming the leads in one motion. Depending on the form shape any "dimples" required such as "stand offs" are put in the leads at this point. After the leads have been cut and formed the die sets retract and the bending jaws advance to bend the leads to the 180° configuration. The bending jaws and clamping die then retract and the finished component is ejected.

II. SETTING UP THE MACHINE:

1. Place the C044 on a suitable work surface. The surface selected should be sturdy enough to support the weight of the machine.
2. Connect the three air hoses provided from the foot pedal to the machine as shown in figure 1.

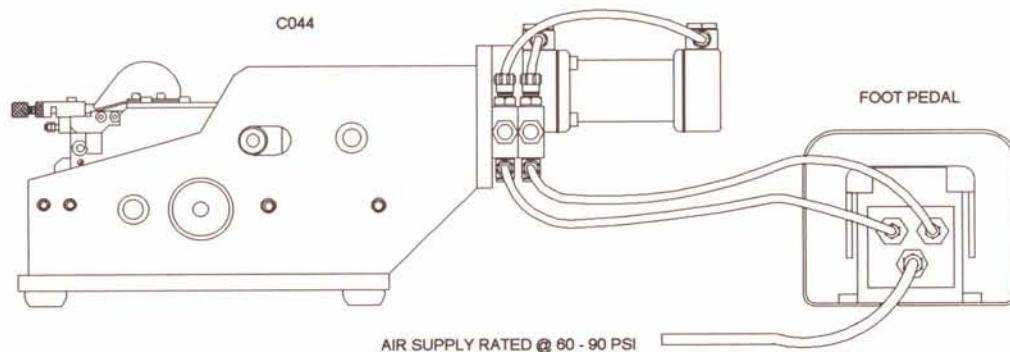


Figure 1

III. ADJUSTMENTS:

A. Form Placement or Cut Length

When straight cut dies are installed in the machine this adjustment determines the distance from the end of the component body to the cut point on the lead. When forming dies are installed in the machine this adjustment will determine where on the lead the form is placed. To adjust for the cut length or form placement turn the adjustment knob shown in figure 2 in the direction as needed until the desired cut length or form placement is obtained.

Due to variances in component bodies or application it may be necessary to adjust the position of left side tooling dies independently of the right side. Using a 2.5mm hex key loosen and remove the screw securing the offset adjustment bushing shown in figure 2 and turn the bushing in the direction as needed. Turning the bushing clockwise will increase the offset and turning the bushing counter-clockwise will decrease the offset. Replace the screw when finished with this adjustment.

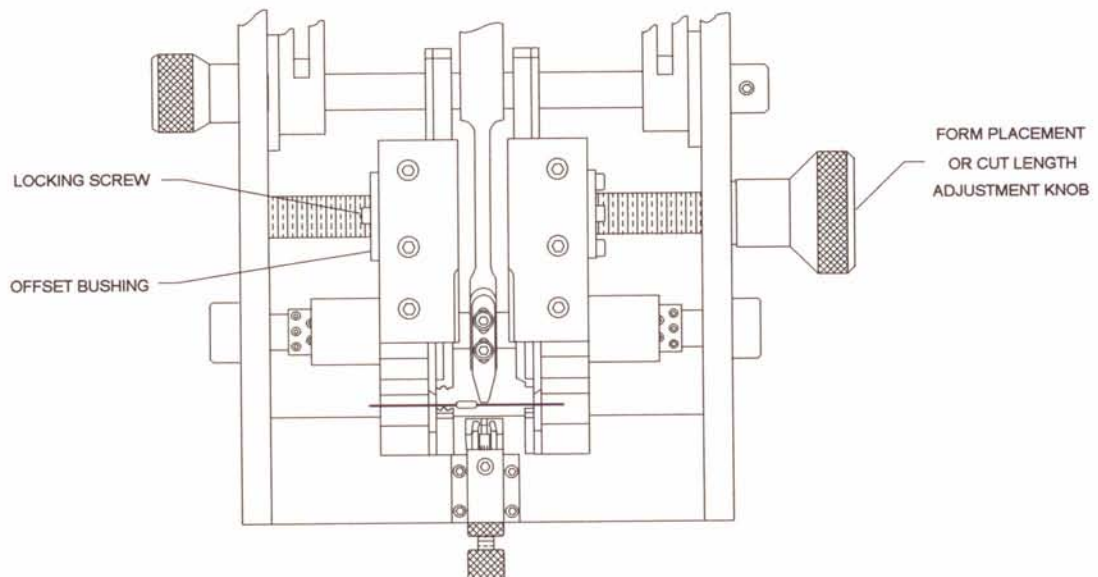


Figure 2

III. ADJUSTMENTS: (con't)

B. Component Positioning

When making the form placement or cut length adjustment the dies must be positioned to allow a minimum clearance of .075" between the bending mandrel and the component body as shown in figure 3.

Align the component leads with the bending mandrel and front forming dies as shown in figure 3 by loosening the two screws and moving the bending mandrel in the direction as needed. Retighten the two screws when finished.

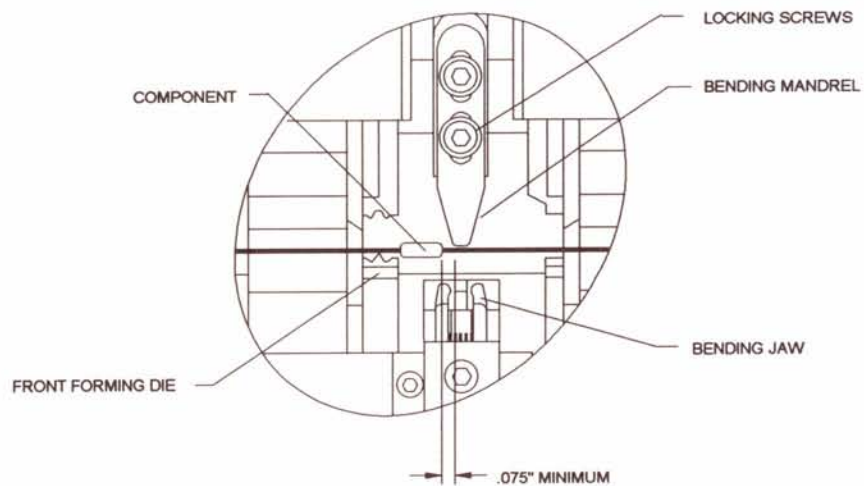


Figure 3

III. ADJUSTMENTS: (con't)

C. Form Exaggeration And Lead Span

The exaggeration of the form can be adjusted by loosening the screw and turning the eccentric shown in figure 4 in the direction as needed. Increasing or decreasing the form exaggeration allows the lead to be "custom fit" to the hole.

The lead span or center to center distance can be varied from .100" to .200" by adjusting bending jaws. Loosen the locking nut and turn the adjustment knob shown in figure 4 in the direction as needed. Retighten the locking nut when finished.

Note: The minimum lead span adjustment is dependent on the width of the bending mandrel. Changing this adjustment may also require readjusting the offset bushing adjustment.

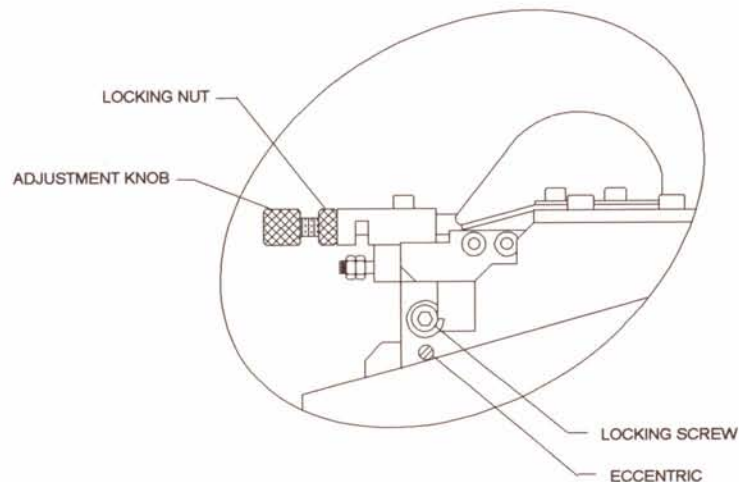


Figure 4

IV. OPERATION:

After making the adjustments the C044 is ready to operate. Position a component in the tooling as described in section III-B. Depress and hold the foot pedal until the component leads have been cut, formed and bent into the 180° configuration. Release the foot pedal and the component will drop into the tray below the tooling.

V. PREVENTIVE MAINTENANCE:

- Daily - Remove all scrap leads and dust particles from the machine with a brush.
- Weekly - Remove the tooling dies, clean thoroughly and relubricate using a light amount of 10w oil. Check for wear.
- Monthly - Lubricate the shafts, linear bearings and slides with a light amount of 10w oil. Check for wear.

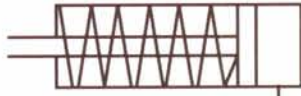
VI. RECOMMENDED SPARE PARTS:

<u>Qty</u>	<u>Description</u>	<u>Part Number</u>
1 ea.	Spare Parts Kit	P-C044-500
<u>Spare Parts Kit Consists Of:</u>		
1 ea	Spring Set	P-C044-001
2 ea	Eccentric	P-C044-004
1 ea	Bending Mandrel (2.5mm)	T-C044-013
1 ea	Bending Jaw	T-C044-016

When Ordering Parts Please Specify Machine Serial Number

Note: ALL screws and nuts are metric.

Cylinder
ESN-8-25-P



Cylinder
DC-35-50



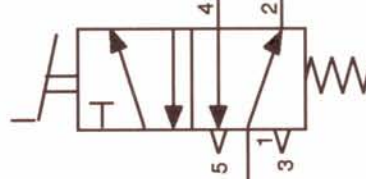
Flow Control Valve
GR-1/8



Flow Control Valve
GR-1/8



Foot Pedal
F-5-1/4-B



Air Supply @ 90 psi

- 1 = Supply
- 2 = Working Outlet
- 3 = Exhaust
- 4 = Working Outlet
- 5 = Exhaust

STRECKFUSS USA, INC.

PNEUMATIC DIAGRAM	
DESCRIPTION	
MODEL NO.	C044
DRAWN BY	A. Saranen
DRAWING NO.	PD92017
DATE	7/23/93