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# MODEL A075/Ri

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## OPERATING INSTRUCTIONS

Serial Number \_\_\_\_\_



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## 1.0 GENERAL DESCRIPTION:

The Streckfuss model A075/Ri is designed to form the leads of dual in-line components utilizing a tube-to-tube feeding configuration. Fully adjustable, the A075/Ri requires no die changes which allows a wide range of component sizes to be processed quickly and easily. The lead span adjustment is displayed on a digital panel meter and the operating speed is infinitely variable. The component tubes are loaded onto an adjustable, input attachment and gravity fed to a foam padded belt that indexes them through the forming process. The belt holds the components securely against a set of infinitely variable guide rails. The forming action is performed by adjustable rollers located on either side of the guide rails. After forming the components are then deposited into a second tube for collection.

## 2.0 SETTING UP THE MACHINE:

1. Place the A075/Ri a suitable work surface.
2. Connect power cord coming from the back of the unit to an approved electrical service rated for the appropriate voltage as indicated on the specification label.

## 3.0 ADJUSTMENTS:

### 3.1 Body Thickness

1. Place a component upside-down on the gauge block as shown in figure 1.
2. Turn the adjustment screw in the direction as needed until the gauge pin contacts the component.

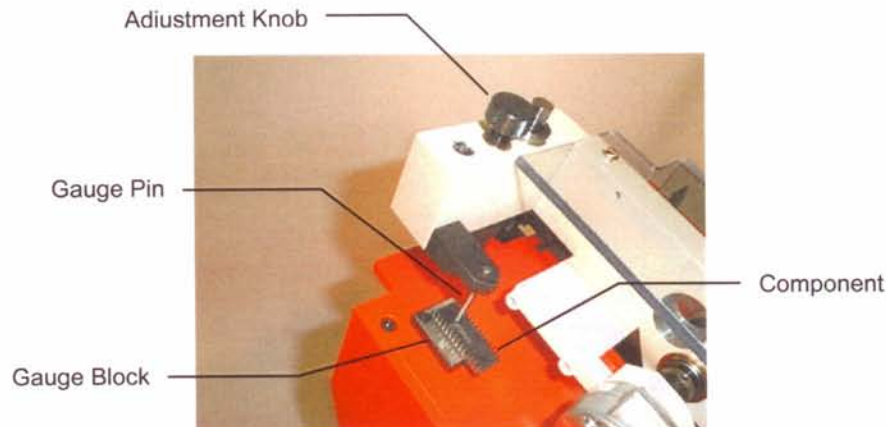


Figure 1

**3.0 ADJUSTMENTS:**

**3.1 Body Thickness**

3. Loosen the thumb screw securing the collar shown in figure 2.
4. Raise the collar until it contacts the linear bushing.
5. Re-tighten the thumb screw when finished.



Figure 2

**3.2 Lead Span or "Pitch"**

1. Set the panel meter selector switch to the # 2 position.



Figure 3

**3.0 ADJUSTMENTS:**

**3.2 Lead Span or "Pitch"**

2. Turn the pitch adjustment knob in the direction as needed until the required setting is displayed on the panel meter.

*Note: In some cases, components with the same part number from different vendors may require different settings on the panel meter. This is due to variations in the component from one vendor to the next.*

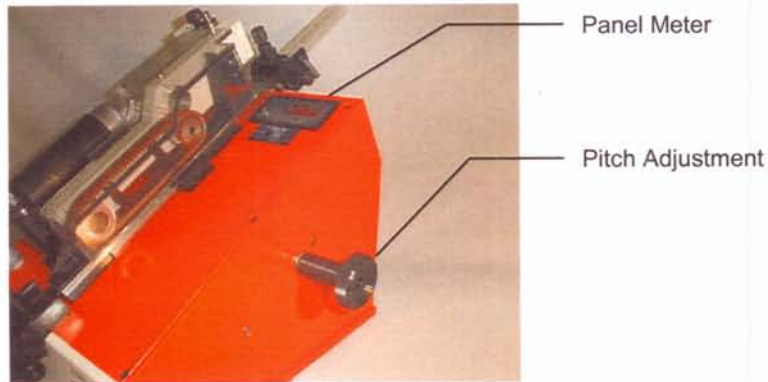


Figure 4

#### 4.0 OPERATION:

##### 4.1 Loading Input Tube

1. Lift upward on the tube retainer knob and turn the knob  $\frac{1}{4}$  turn to disengage the retaining plate.



Figure 5

2. Turn the lead in rail adjustment knob in the direction as needed until the bottom of the tube slides easily onto the lead in rails. The tube should fit onto the rails without any side to side play.

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#### 4.0 OPERATION:

##### 4.1 Loading Input Tube

3. Insert tube until it contacts the stop plate. The stop plate will keep the components in the tube until they are presented to the guide rails.

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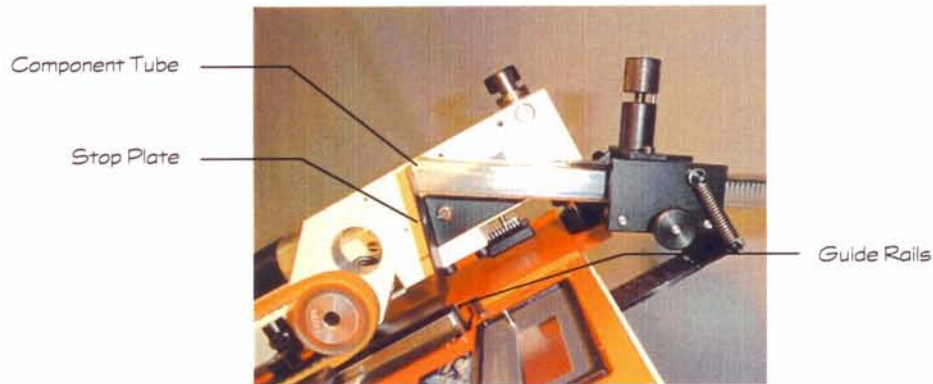


Figure 6

4. While holding the tube against the stop plate, swing the tube attachment upward until the components slide onto the guide rails.

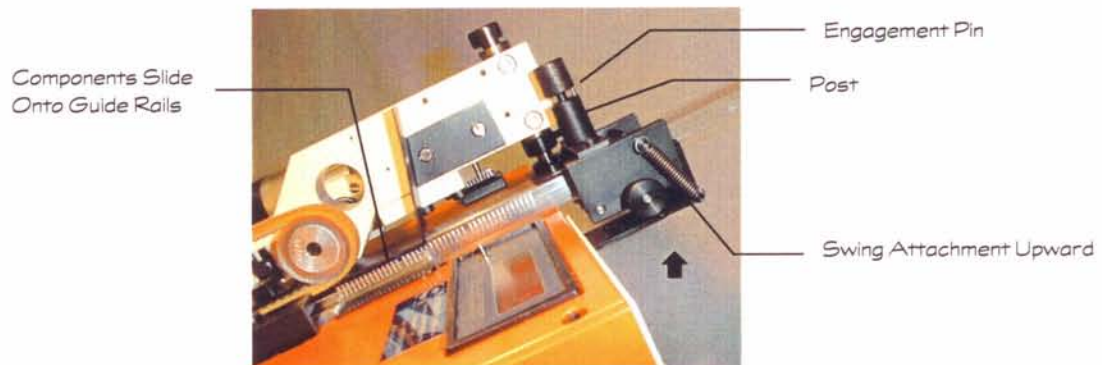


Figure 7

5. Lift upward on the tube retainer knob and turn the knob  $\frac{1}{4}$  turn to engage the retaining plate. The pin protruding from the bottom of the knob should fit into the hole in the post.

#### 4.0 OPERATION:

##### 4.2 Loading Output Tube

1. Lift upward on the tube retainer knob and turn the knob  $\frac{1}{4}$  turn to disengage the retaining plate.



Figure 8

2. Turn the lead in rail adjustment knob in the direction as needed until the bottom of the tube slides easily onto the lead in rails. The tube should fit onto the rails without any side to side play.
3. Insert the tube until it stops against the guide rails.
4. Lift upward on the tube retainer knob and turn the knob  $\frac{1}{4}$  turn to engage the retaining plate. The pin protruding from the bottom of the knob should fit into the hole in the post.

##### 4.3 Control Panel

1. Turn the speed control knob counter-clockwise to zero or the minimum setting.
2. Turn the power switch on to position "1".



Figure 9

#### 4.0 OPERATION:

##### 4.3 Control Panel

3. Turn the speed control knob clockwise until the desired operating speed is reached.
4. After all the components have been transferred from the input tube to the output tube turn the power switch off to "0".
5. Repeat the steps as described in sections 4.1 through 4.3 to process a new tube of components.

#### 5.0 PREVENTIVE MAINTENANCE:

##### 5.1 Daily

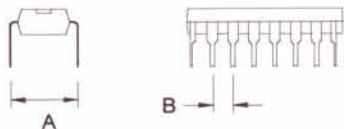
1. Clean any debris from the machine using a brush or vacuum.

##### Weekly

1. Remove the back panel from the machine and clean any debris from the interior of the machine.
2. Apply a light amount of a 10w Teflon® based oil to all guide shafts.
3. Check the transport belt for wear.

#### 6.0 TECHNICAL SPECIFICATIONS:

Production Rate:	5000 pcs/hr
Machine Dimensions:	18.0" L x 14.0" W x 15.0" H 458mm L x 356mm W x 381mm H
Electrical Requirements:	110v, 60hz, 0.8kw 220v, 50hz, 0.12kw



##### PARAMETERS

A: = .300" - .900" [7.62mm - 22.86mm]  
B: = .100" [2.54mm]

Custom Parameters And Forming  
Requirements Are Available Upon  
Request.





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## STRECKFUSS USA INC

### RECOMMENDED SPARE PARTS

Model A075/Ri

June 1991

QTY.	DESCRIPTION	PART NUMBER
1 ea.	Spare Parts Kit	P-A075-510
1 ea.	Transport Belt	P-A075-001
1 ea.	Linear Bearing (10mmx38mm)	P-A075-011
1 ea.	Lamp 110v/2w (1.90010.037)	P-Lamp-001
2 ea.	Fuse 1 amp (GDA 1A)	P-Fuse-018
1 ea.	Bearing (625 ZZ)	P-Bearing-012
1 ea.	Bearing (608 ZZ)	P-Bearing-022

WHEN ORDERING PARTS PLEASE SPECIFY MACHINE SERIAL NUMBER

NOTE - ALL Screws And Nuts Are Metric.