

# Streckfuss



Precision Equipment for the Electronic Industry

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## **C034 – C034/S**

### **Operating Manual**

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I. GENERAL DESCRIPTION:

The C034 was designed to cut and form 90° bends in the leads of loose and taped axial leaded components. The machine is hand fed and operated via a pneumatic foot pedal. Independent cut length and pitch adjustments make the C034 ideal for low volume applications where accuracy and reliability are a must.

II. SETTING UP THE MACHINE:

1. Place the C034 on a suitable work surface with the foot pedal in a convenient location on the floor.
2. Connect the three air hoses provided as shown in figure 1.
3. Air supply should be from a clean, dry source and regulated from 60 to 90 PSI.

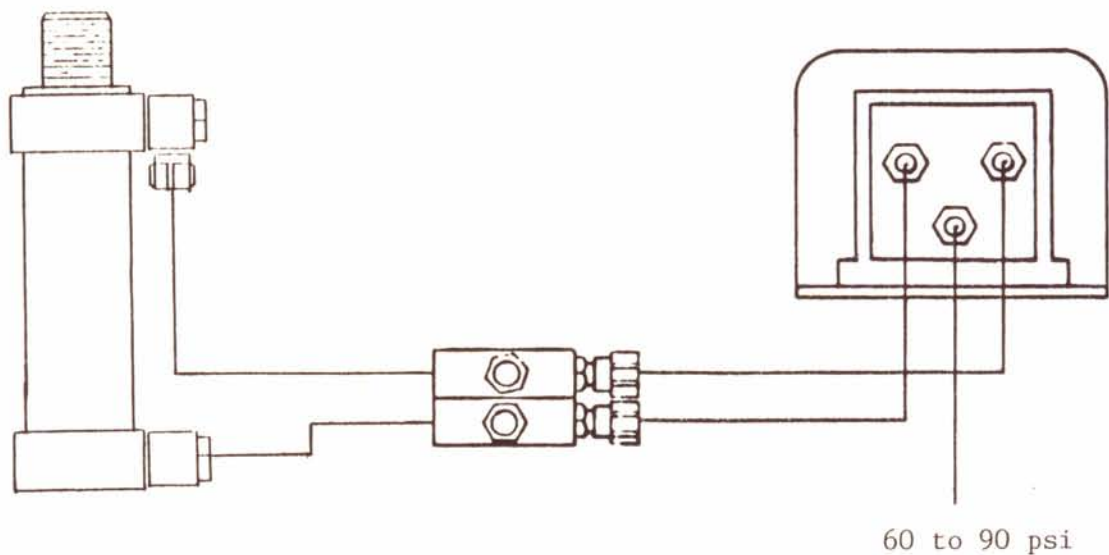


FIGURE 1

### III. ADJUSTMENTS:

#### 1. Pitch Adjustment

The pitch or lead center to center distance set by turning the pitch adjustment knob (item 19) located on the right side of the machine in the direction as needed until the desired setting is obtained. Turning the knob counter-clockwise will increase the pitch setting and turning the knob clockwise will decrease the pitch setting. Each revolution of the knob is equal to .100" of movement. A scale is provided on front of the machine for reference of this adjustment.

#### 2. Cut Length Adjustment

Independent cut length adjustments are provided for each lead. This determines the length of the lead measured from the bend point. To adjust the cut length loosen the locking screw (item 55) securing the cutting assembly and turn the cut length adjustment knob (item 15) in the direction as needed until the desired setting is obtained. A scale is provided for reference of each of these settings. Each side is adjusted in the same manner. Tighten the locking screw when finished with adjustments.

#### 3. Bending Anvil Adjustment

To allow for variations in lead diameters an adjustment is provided for the distance between the bending anvils and bending dies. This adjustment will also affect the angle at which the leads are bent. Underbends can be used to produce a slight spring action in the leads to help secure the component in the circuit board. To adjust the bending anvils turn the spanner adjustment screw (item 14) in the direction as needed until the desired lead diameter clearance and lead angle is obtained.

#### 4. Needle Valve Adjustment

Two needle valves are located on the back of the machine and are used to control the air pressure for the forward and return strokes of the air cylinder. These valves are factory set and should not require any further adjustment.

IV. OPERATION:

After making the adjustments as described in section III the C034 is ready to operate. Insert the component selected for forming into the tooling as shown in figure 2. The leads of the component should rest on the top of the bending anvils with the component body between the bending anvils. Depress the foot pedal and the tooling will close thus cutting and bending the leads in one motion. Release the foot pedal and the tooling will open and the ejector blades will drive forward ejecting the finished component.

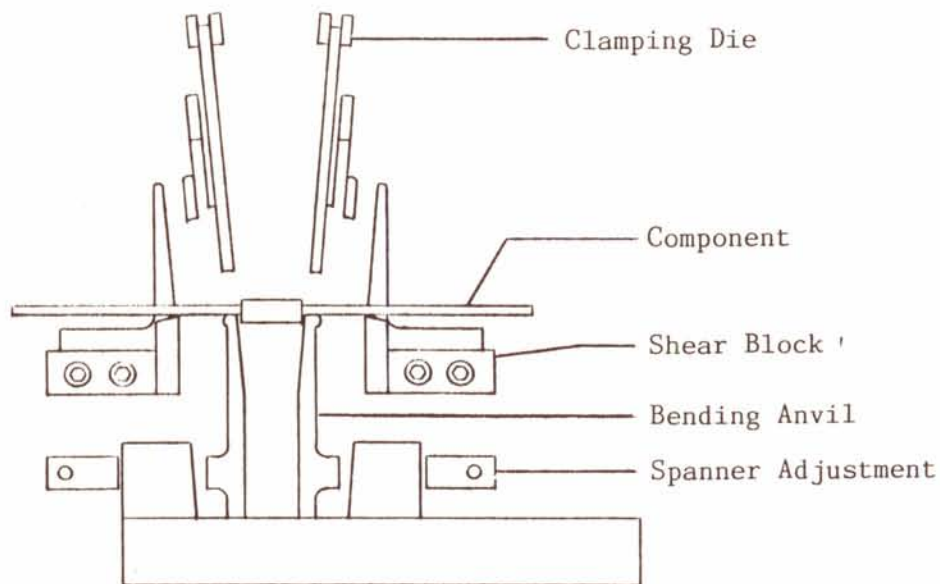


FIGURE 2

## V. PREVENTIVE MAINTENANCE:

- Daily - Remove all scrap leads from the machine with a brush or a light blast of air.
- Weekly - Apply a light amount of 10w oil to the pitch and cut length adjustment shafts and the linear bearings and guide shafts. Check for wear.
- Monthly - Disassemble the machine completely and clean all items thoroughly. Inspect for wear and relubricate.

## VI. PARTS LIST:

Item No.	Description	Part No.	Qty
1	Cutting Die Set (10mm)	T-C034-001	1
	Cutting Die Set (16mm)	T-C034-002	
2	Shear Block Set	T-C034-003	1
3	Bending Die Set (SL)	T-C034-004	1
	Bending Die Set (MTL)	T-C034-010	
	Bending Die Set (S)	T-C034-006	
4	Clamping Die Set (MTL)	T-C034-008	1
	Clamping Die Set (S)	T-C034-009	
5	Bending Anvil Set (MTL)	T-C034-005	1
	Bending Anvil Set (S)	T-C034-007	
6	Ejector Blade Set	P-C034-008	1
7	Linear Bearing (8mmx40mm)	P-C034-012	2
	Linear Bearing (8mmx80mm)	P-C034-058	
8	Linear Bearing (6mmx25mm)	P-C034-013	2
9	Cut Length Adjustment Screw	P-C034-014	2
10	Cutting Die Spring	P-C034-017	2
11	Cut Length Return Spring	P-C034-018	2
12	Bending Anvil Spring	P-C034-024	2
13	Pitch Adjustment Index Spring	P-C034-025	1
14	Spanner Adjustment Screw	P-C034-026	2
15	Cut Length Adjustment Knob	P-C034-037	2
16	Bushing	P-C034-028	2
17	Bushing	P-C034-029	2
18	Guide Shaft (8mmx150mm)	P-C034-030	2
	Guide Shaft (8mmx215mm)	P-C034-054	
19	Pitch Adjustment Knob	P-C034-031	1
20	Rubber Foot	P-C034-032	4

## VI. PARTS LIST: (con't)

Item No.	Description	Part No.	Qty
21	Tooling Base Plate (150mm)	P-C034-033	1
	Tooling Base Plate (215mm)	P-C034-056	
22	Machine Base	P-C034-034	1
23	Steel Ball (3.5mm)	P-C034-035	1
24	Hood Mounting Set (Short)	P-C034-036	1
	Hood Mounting Set (Long)	P-C034-069	
25	Pitch Adjustment Shaft (Short)	P-C034-027	1
	Pitch Adjustment Shaft (Long)	P-C034-070	
26	Ejector Pivot Screw (MTL)	P-C034-009	2
	Ejector Pivot Screw (S)	P-C034-023	
27	M3x20mm FHMS	P-C034-045	2
28	M4x12mm SHCS	P-C034-046	4
29	M4x5mm SHCS	P-C034-047	5
30	M5x10mm SHCS	P-C034-048	2
31	M4x10mm SHCS	P-C034-049	6
32	M3x5mm SFHMS	P-C034-050	4
33	Shoulder Disk (SL)	P-C034-038	2
	Shoulder Disk (S)	P-C034-066	
	Shoulder Disk (MTL)	P-C034-067	
34	Ejector Bow (Short)	P-C034-006	1
	Ejector Bow (Long)	P-C034-007	
35	Ejector Bow Spring	P-C034-020	1
36	Ejector Bow Sleeve	P-C034-039	1
37	Ejector Bow Pivot Shaft	P-C034-040	1
38	Ejector Bow Mount	P-C034-041	1
39	Ejector Bow Foot	P-C034-011	1
40	Ejector Return Stop Assembly	P-C034-042	1
41	Ejector Return Spring	P-C034-019	1
42	Ejector Kick-Out Pad	P-C034-010	1
43	Drive Shaft Mount (AV-35-50)	P-C034-043	1
	Drive Shaft Mount (DGS-25-50)	P-C034-068	
44	Drive Shaft (6mmx100mm)	P-C034-004	1
	Drive Shaft (6mmx165mm)	P-C034-005	
45	Air Cylinder (AV-35-50)	P-C034-001	1
	Air Cylinder (DGS-25-50)	P-C034-061	
46	Air Cylinder Nut (M24x1.5)	P-C034-071	1
47	Air Cylinder Washer (M24)	P-C034-059	1
48	M3x10mm SHCS	P-C034-051	2
49	M3x5mm SSS	P-C034-052	1
50	M4x20mm SHCS	P-C034-053	1

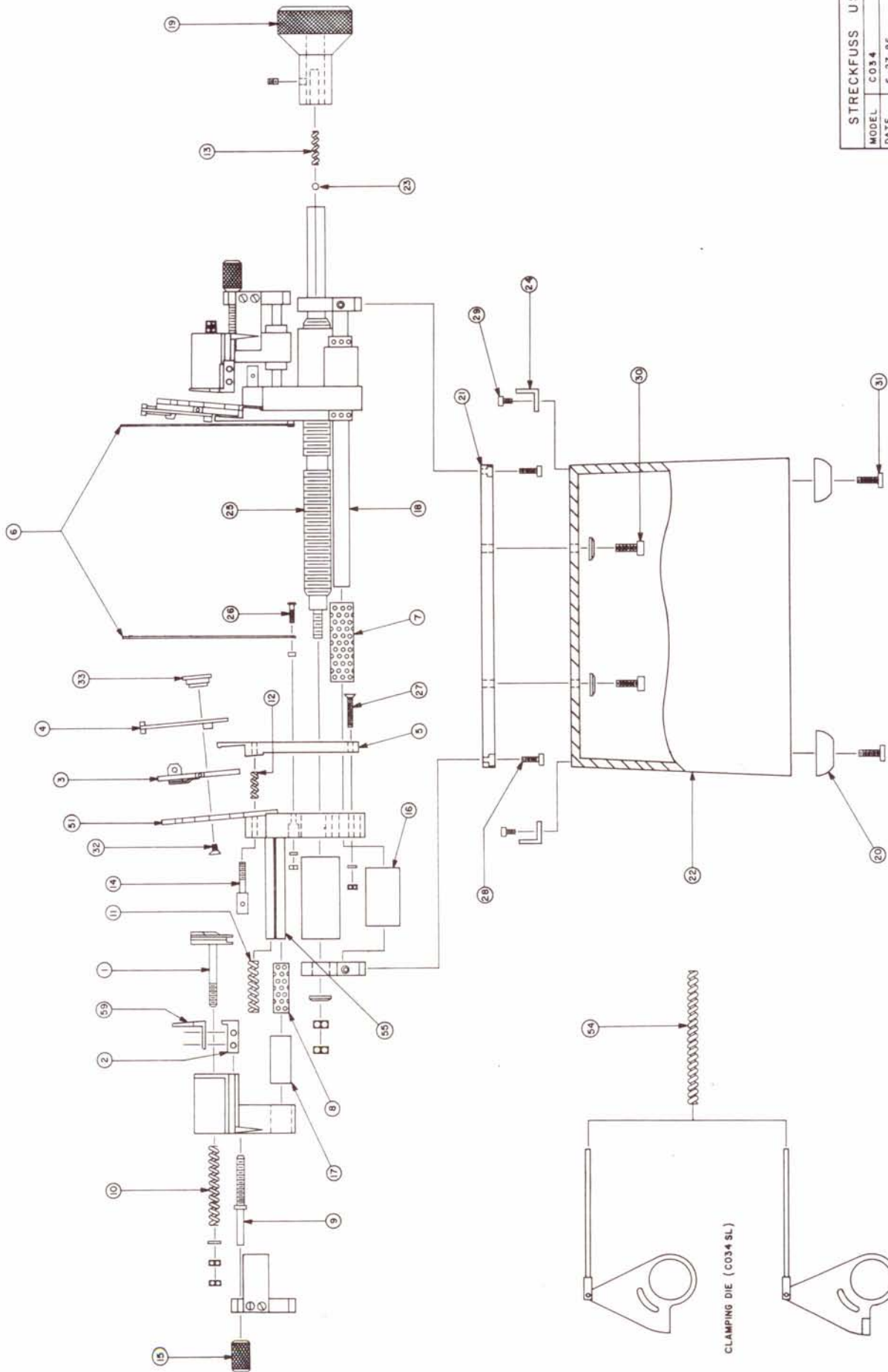
VI. PARTS LIST: (con't)

Item No.	Description	Part No.	Qty
51	Clamping / Bending Die Mounting Plate Set	P-C034-060	1
52	M4x35mm SHCS	P-C034-055	2
53	Needle Valve (GR-1/8)	P-C034-044	2
54	Clamping Die Spring	P-C034-016	2
55	Cut Length Guide Shaft	P-C034-065	4
56	M3x5mm SHCS	P-C034-057	4
57	Plexiglass Hood (Short)	P-C034-021	1
58	Plexiglass Hood (Long)	P-C034-022	1
59	Finger Guard Set	T-C034-011	1

Items Not Shown:

Description	Part No.	Qty
Air Cylinder Piston (AV-35-50)	P-C034-002	1
Air Cylinder Spring Set	P-C034-003	1
Complete Spring Set	P-C034-015	1
Pitch Adjustment Scale & Mount	P-C034-062	1
Cut Length Adjustment Scale & Mount Set	P-C034-063	1
Foot Pedal (F-5-1/4B)	P-C034-064	1

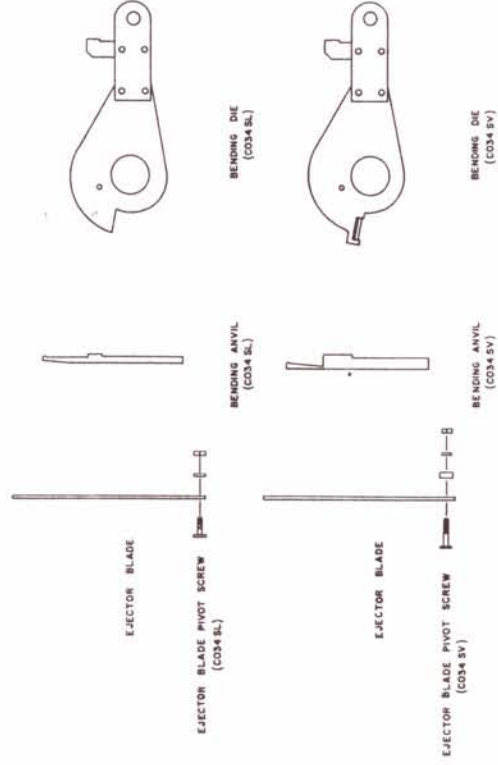
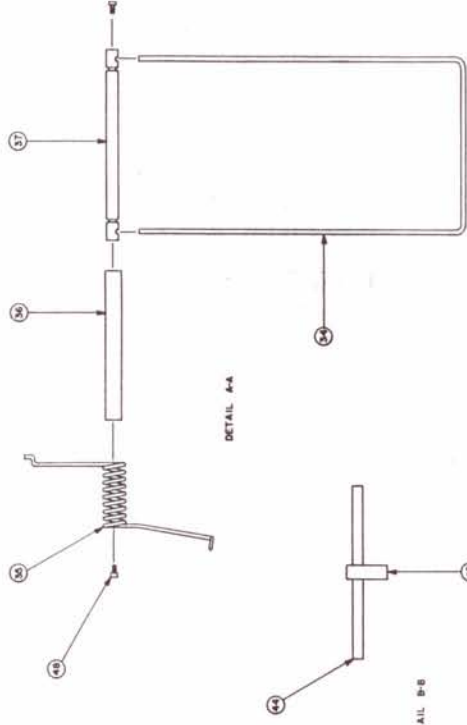
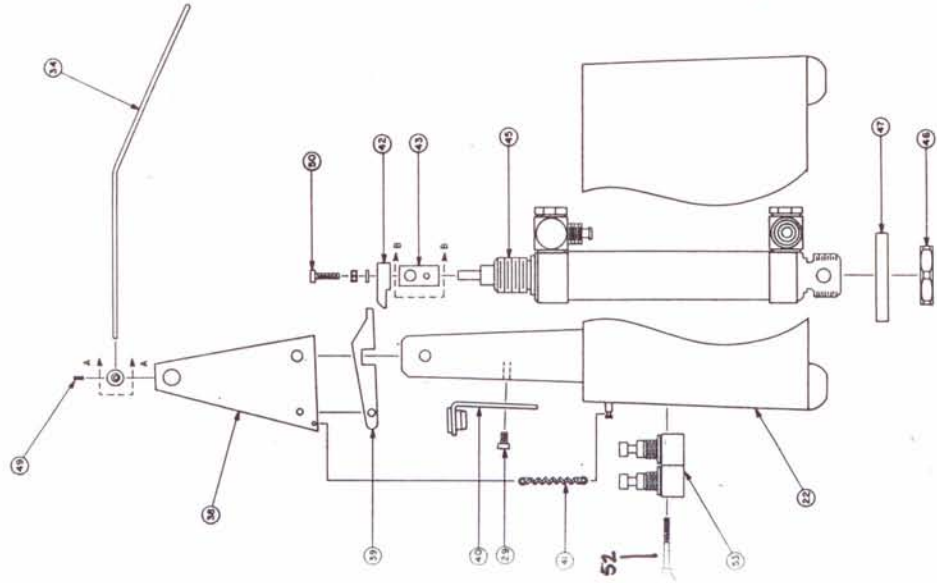




STRECKFUSS USA	
MODEL	C034
DATE	6-27-86
SCALE	NONE
DWR. NO.	51
DR BY	R. VITOVSKY
REVISED	4-2-90

CLAMPING DIE (C034 SL)

CLAMPING DIE (C034 SV)



STRECKFUSS USA	
MODEL	CO34
DATE	6-27-86
SCALE	NONE
DWR NO.	52
DR BY	RY
REVISED	4-2-90

Cylinder  
DGS-25-50

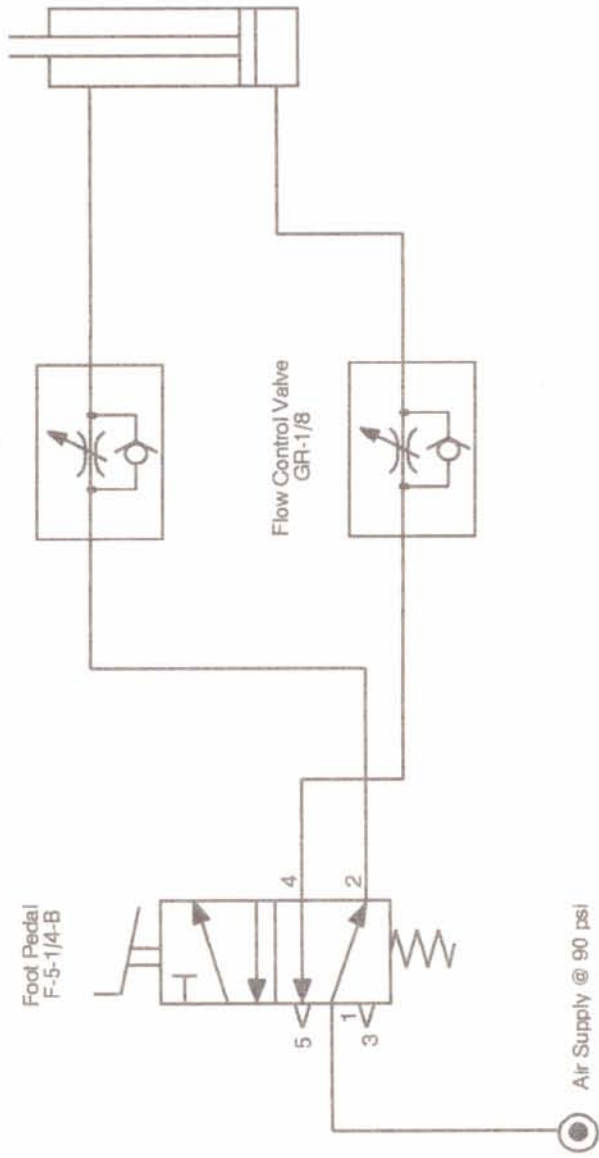
Flow Control Valve  
GR-1/8

Flow Control Valve  
GR-1/8

Foot Pedal  
F-5-1/4-B

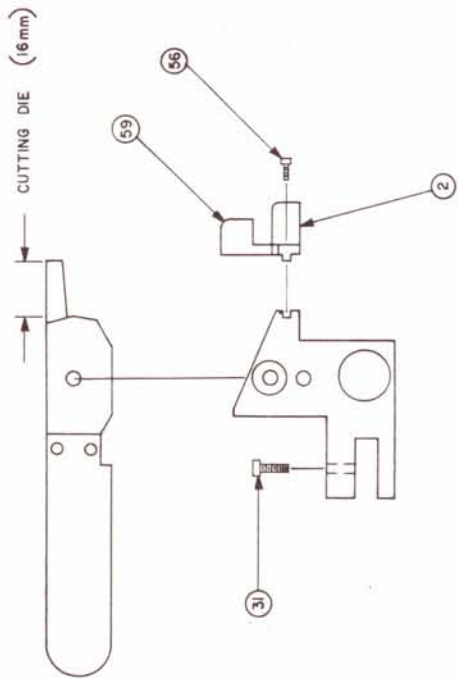
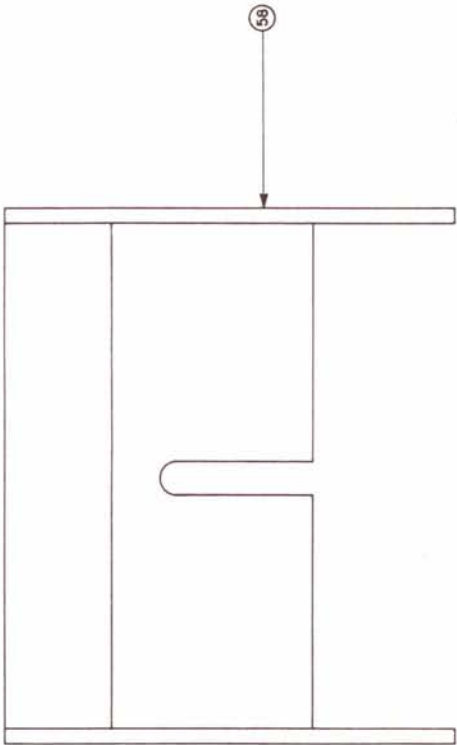
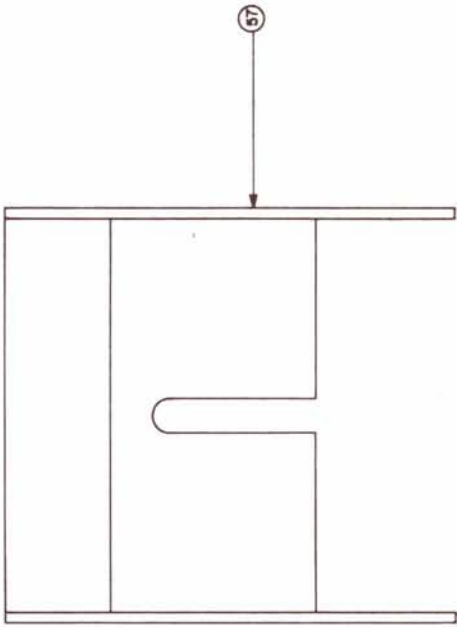
Air Supply @ 90 psi

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



# STRECKFUSS USA, INC.

PNEUMATIC DIAGRAM	
DESCRIPTION	
MODEL NO.	C034
DRAWN BY	A. J. ...
DRAWING NO.	PD92002
DATE	8/15/92



STRECKFUSS USA	
MODEL	C034
DATE	6-27-86
SCALE	NONE
DRW NO.	5.3
DR BY	RV
REVISED	4-2-90

**STRECKFUSS USA INC**

**RECOMMENDED SPARE PARTS**

**Model C034**

June 1991

QTY.	DESCRIPTION	PART NUMBER
1 ea.	Spare Parts Kit	P-C034-500
1 set	Ejector Blade	P-C034-008
2 ea.	Ejector Kick Out Pad	P-C034-010
1 ea.	Spring Set	P-C034-015
2 ea.	Steel Ball (3.5mm)	P-C034-035

WHEN ORDERING PARTS PLEASE SPECIFY MACHINE SERIAL NUMBER

NOTE - ALL Screws And Nuts Are Metric.