
C054



OPERATING INSTRUCTIONS

May 2000

Serial Number _____

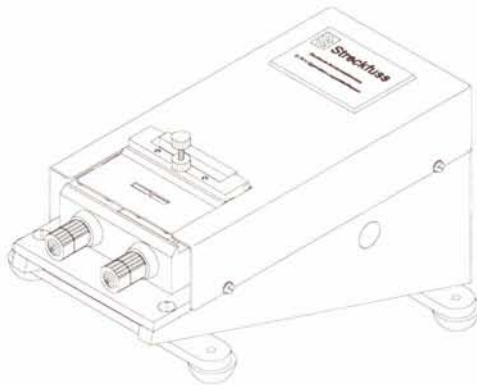


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Note: Some machines may vary from pictorials and illustrations as shown.

1.0 GENERAL DESCRIPTION:

The C054 is designed to cut and form radial components with single inline leads. A variety of form shapes can be achieved through the use of interchangeable die sets. Adjustments are provided for the form placement and exaggeration and allow set up changes to be made quickly and easily. Components are hand fed into the machine with their leads extending through the openings in the cover plate and positioned on either side of a center bar. Once the component is seated against the cover plate the foot pedal is depressed advancing the cutting and forming dies. Once the leads have been cut and formed the die set will retract allowing the component to be removed.

2.0 SETTING UP THE MACHINE:

1. Place the C054 on a suitable work surface with the foot pedal in a convenient location on the floor.
2. Connect one end of one of the PU-6 air hoses provided to the air fitting located underneath the machine at the back of the air cylinder and the other end to the top port located on the back of the foot pedal.
3. Connect one end of one of the PU-6 air hoses provided to the bottom port located on the back of the foot pedal and the other end to a clean, dry air supply rated at 60 to 90 psi.

Note: Refer to the pneumatic diagram as needed for further instructions.

3.0 ADJUSTMENTS:

3.1 Form Exaggeration

1. Loosen the two locking nuts securing the adjustment knobs shown in figure 1.
2. Turn the adjustment knobs in the direction as needed until the desired exaggeration is obtained.
3. Retighten the locking nuts when finished with adjustment.

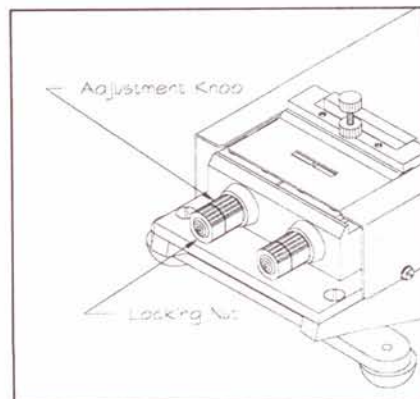


Figure 1

Note: Turning the adjustment knobs clockwise will increase the form exaggeration and turning the knobs counter-clockwise will decrease the form exaggeration.

3.0 ADJUSTMENTS:

3.2 Form Placement

1. Loosen the locking nut securing the thumb screw shown in figure 2.
2. Turn the thumb screw in the direction as needed until the cover plate is in a position above the tooling dies that will produce the desired form placement.
3. Retighten the locking hex nut when finished.

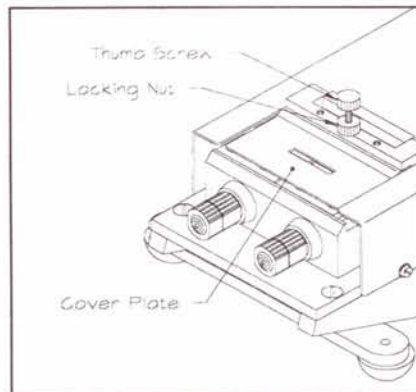


Figure 2

4.0 TOOLING EXCHANGE:

4.1 Cover Plate Exchange

1. Remove the two M3 screws securing the cover plate to its mount and remove the cover plate.
2. Install the new cover plate and secure with the two M3 screws.

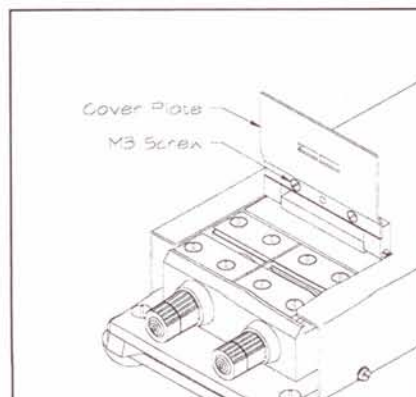


Figure 3

4.0 TOOLING EXCHANGE:

4.2 Die Exchange

1. Open the cover plate and remove the eight M4 screws securing the die set.

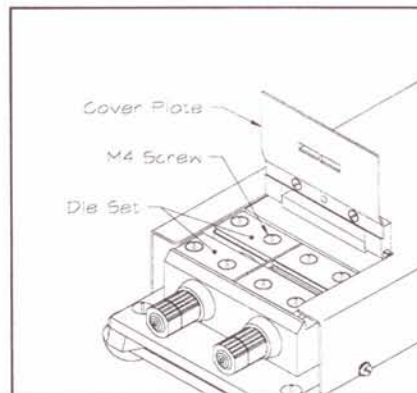


Figure 4

2. Remove the existing die set and install the new set as shown in figure 5.

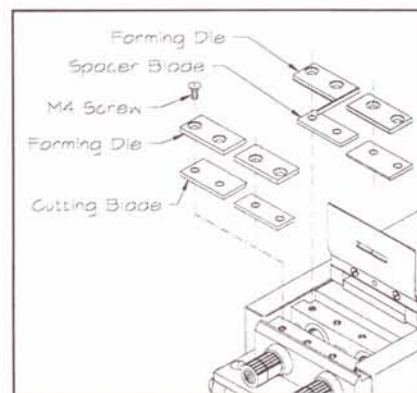


Figure 5

Note: The front and rear forming dies are mirror images of each other. The form orientation for the right lead will be opposite the orientation for the left lead. Location of the cutting and spacer blades may vary from machine to machine.

5.0 OPERATION:

1. Insert a component into the machine with one lead extending down the right side of the center bar and the other lead down the left side of the center bar as shown in figure 6. Seat the component body fully against the cover plate.

Note: For single in-line components with multiple leads insert the component with half the leads extending down the right side of the center bar and the other half down the left side of the center bar.

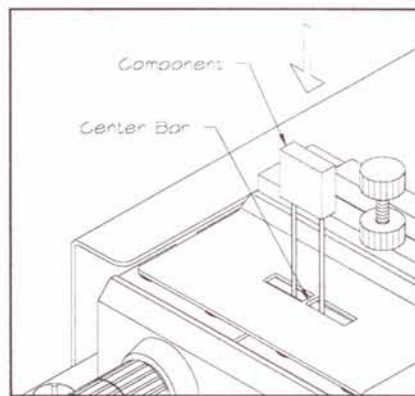


Figure 6

2. Depress the foot pedal and the front dies will close cutting and forming the leads in one motion. Release the foot pedal and the dies will open allowing the component to be removed.

Note: It is important to hold the component straight during the forming process.

6.0 PREVENTIVE MAINTENANCE:

6.1 Daily

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

6.2 Weekly

1. Remove the machine cover (Dwg 50.0, Item 26).
2. Clean any scrap leads or other debris from the machine using a brush or vacuum.
3. Remove the die set, clean thoroughly and apply a light coating of 10w oil to the top and bottom surfaces of the dies.
4. Apply a light amount 10w oil to the linear bearings (Dwg. 50.0, Item 8).
5. Apply a light amount 10w oil to the guide shafts (Dwg. 50.0, Item 7).
6. Apply a light amount 10w oil to the pivot pins (Dwg. 50.0, Item 24)
7. Apply a light amount 10w oil to the linkage assembly (Dwg 50.0, Items 18,23,24).
8. Inspect for wear.
9. Re-install the die set and machine cover.

7.0 TECHNICAL SPECIFICATIONS:

Production Rate:	500 - 1000 pcs/hr
Machine Dimensions:	8.0" W x 10.0" L x 8.0" H
Pneumatic Requirement:	60 - 80 psi



8.0 PARTS LIST:

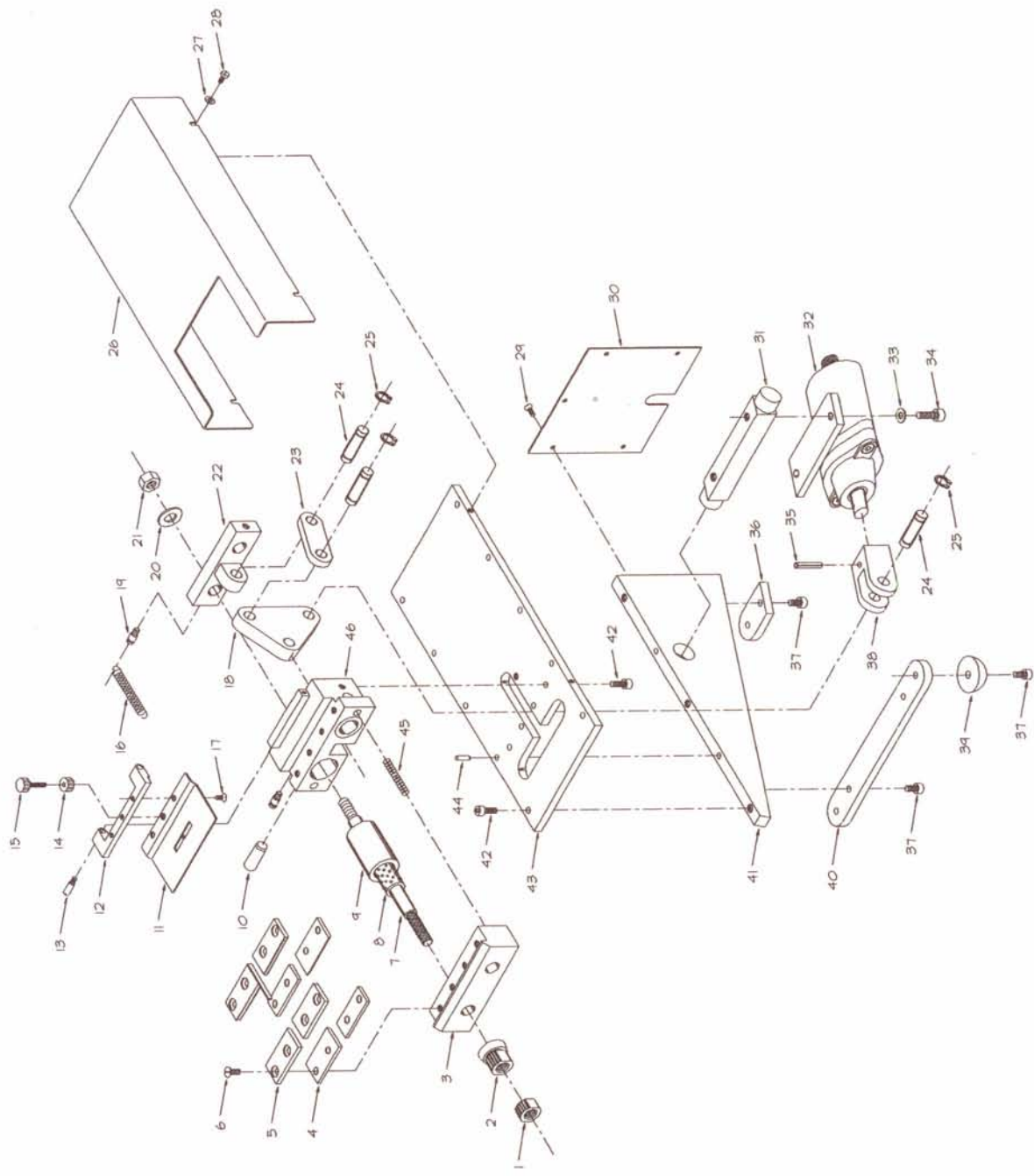
Dwg #	Item #	Part Number	Description	Qty	Notes
50.0	1	P-C054-036	Knurled Locking Nut	2	
50.0	2	P-C054-037	Knurled Adjustment Knob	2	
50.0	3	P-C054-009	Tooling Block (Front)	1	
50.0	4	T-C054-010	Cutting Blade Set	1	1
50.0	5	Upon Request	Forming Die Set	1	
50.0	6	P-C054-038	DIN 963 4x10 Flat Head Machine Screw	8	
50.0	7	P-C054-007	Guide Shaft	2	
50.0	8	P-C054-002	Linear Bearing (10x38)	2	1
50.0	9	P-C054-039	Bushing	2	
50.0	10	P-C054-040	DIN 6325H 8x18 Dowel Pin	1	
50.0	11	Upon Request	Tooling Cover Plate	1	
50.0	12	P-C054-041	Cover Plate Mount	1	
50.0	13	P-C054-042	Cover Plate Pivot Screw	2	
50.0	14	P-C054-024	DIN 467 M3 Knurled Nut	1	
50.0	15	P-C054-023	DIN 912 3x12 Plastic Cap Thumb Screw	1	
50.0	16	P-C054-004	Extension Spring (50.0.16)	2	1
50.0	17	P-C054-029	DIN 963 3x6 Flat Head Machine Screw	2	
50.0	18	P-C054-011	Linkage Plate (Front)	1	
50.0	19	P-C054-043	Spring Pin	4	
50.0	20	P-C054-019	DIN 125 M8 Flat Washer	2	
50.0	21	P-C054-018	DIN 934ZP M8 Hex Nut	2	
50.0	22	P-C054-013	Linkage Plate (Rear)	1	
50.0	23	P-C054-012	Linkage Plate (Center)	2	
50.0	24	P-C054-020	Pivot Pin	3	1
50.0	25	P-C054-021	DIN 471 8mm External Retaining Ring	6	1
50.0	26	P-C054-022	Machine Cover	1	
50.0	27	P-C054-044	DIN 125 M3 Flat Washer	4	
50.0	28	P-C054-028	DIN 85 3x6 Pan Head Machine Screw	4	
50.0	29	P-C054-026	DIN 963 3x8 Flat Head Machine Screw	5	
50.0	30	P-C054-016	Rear Cover	1	

50.0	31	P-C054-045	Cylinder Mount	1	
50.0	32	P-C054-005	Cylinder (AH-35-50)	1	
50.0	33	P-C054-046	DIN 125 M5 Flat Washer	2	
50.0	34	P-C054-030	DIN 912 5x14 Socket Head Cap Screw	2	
50.0	35	P-C054-047	DIN 1481 4x18 Spring Roll Pin	1	
50.0	36	P-C054-048	Foot Mount (Rear)	2	
50.0	37	P-C054-027	DIN 912 4x8 Socket Head Cap Screw	8	
50.0	38	P-C054-049	Clevis	1	
50.0	39	P-C054-006	Rubber Foot	4	
50.0	40	P-C054-050	Foot Mount (Front)	1	

8.0 PARTS LIST:

Dwg #	Item #	Part Number	Description	Qty	Notes
50.0	41	P-C054-014	Side Plate	2	
50.0	42	P-C054-031	DIN 912 4x10 Socket Head Cap Screw	10	
50.0	43	P-C054-015	Base Plate	1	
50.0	44	P-C054-017	DIN 6325H 4x12 Dowel Pin	4	
50.0	45	P-C054-003	Compression Spring (50.0.45)	2	¹
50.0	46	P-C054-010	Tooling Block (Rear)	1	
		P-C054-035	Foot Guard (4500 FH)		
		P-C054-035	Foot Pedal (F-3-1/4B)		

¹ Denotes Recommended Spare Part



NOTES:
 1. SOME ITEMS MAY BE REMOVED FOR CLARITY
 2. SOME MODELS MAY VARY FROM ILLUSTRATION AS SHOWN

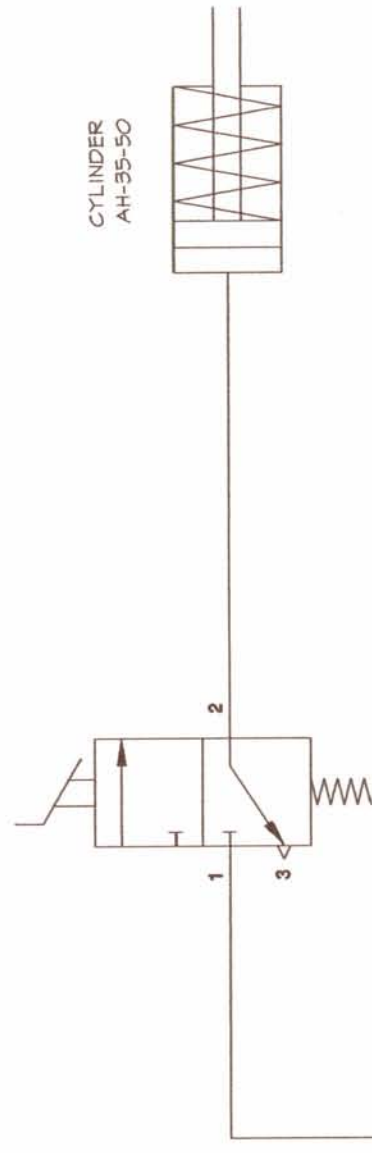
MODEL NO.	C054	DRAWING NO.	50.0	REV	B
DRAWN BY	A. SPRINGER	DATE	5/95	REV	B
SHEET			1/1		
540008					

TITLE PARTS IDENTIFICATION DRAWING

Streckfuss USA, Inc.

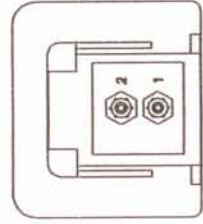


FOOT PEDAL
F-3-1/4-B



SUPPLY RATED @ 60-90 PSI

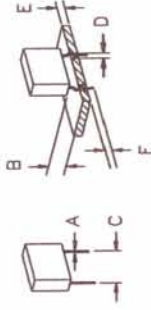
FOOT PEDAL

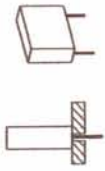
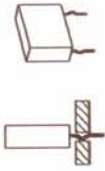


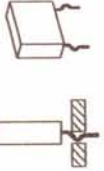




NOTES:
1. SOME MODELS MAY VARY FROM ILLUSTRATION AS SHOWN

 Streckfuss USA, Inc.	TITLE	PNEUMATIC DIAGRAM				MODEL NO.	C054	DRAWING NO.	51.0	SHEET	1/1
	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE	DATE
	BY	A. SPRINGER				BY		REV		REV	

Tel: 972-790-1614 – Fax: 972-881-9199



FORM SHAPE	DESCRIPTION	TOOL NUMBER	STANDARD DIMENSIONS (INCH)						
			A	B (min)	C	D	E	F	
	STRAIGHT CUT		.015-.030		.100-2.00			.062	.055-.065
	FLUSH MOUNT SNAP IN	1567	.015-.030		.100-2.00	.030-.040		.062	.055-.065
	STAND OFF	1553	.015-.023	.120	.100-2.00	.030-.040		.062	.055-.065
	STAND OFF SNAP IN	1554	.023-.030	.120	.100-2.00	.040-.050		.062	.055-.065
	STAND OFF SNAP IN	1614	.015-.023	.120	.100-2.00	.030-.040		.062	.055-.065
	STAND OFF SNAP IN	1664	.023-.030	.120	.100-2.00	.040-.050		.062	.055-.065
	STAND OFF SNAP IN	411	.015-.030	.075	.100-2.00	.030-.050		.062	.055-.065