
MODEL C067

OPERATING INSTRUCTIONS

November 2001

Serial Number _____



Streckfuss USA



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1.0 GENERAL DESCRIPTION:

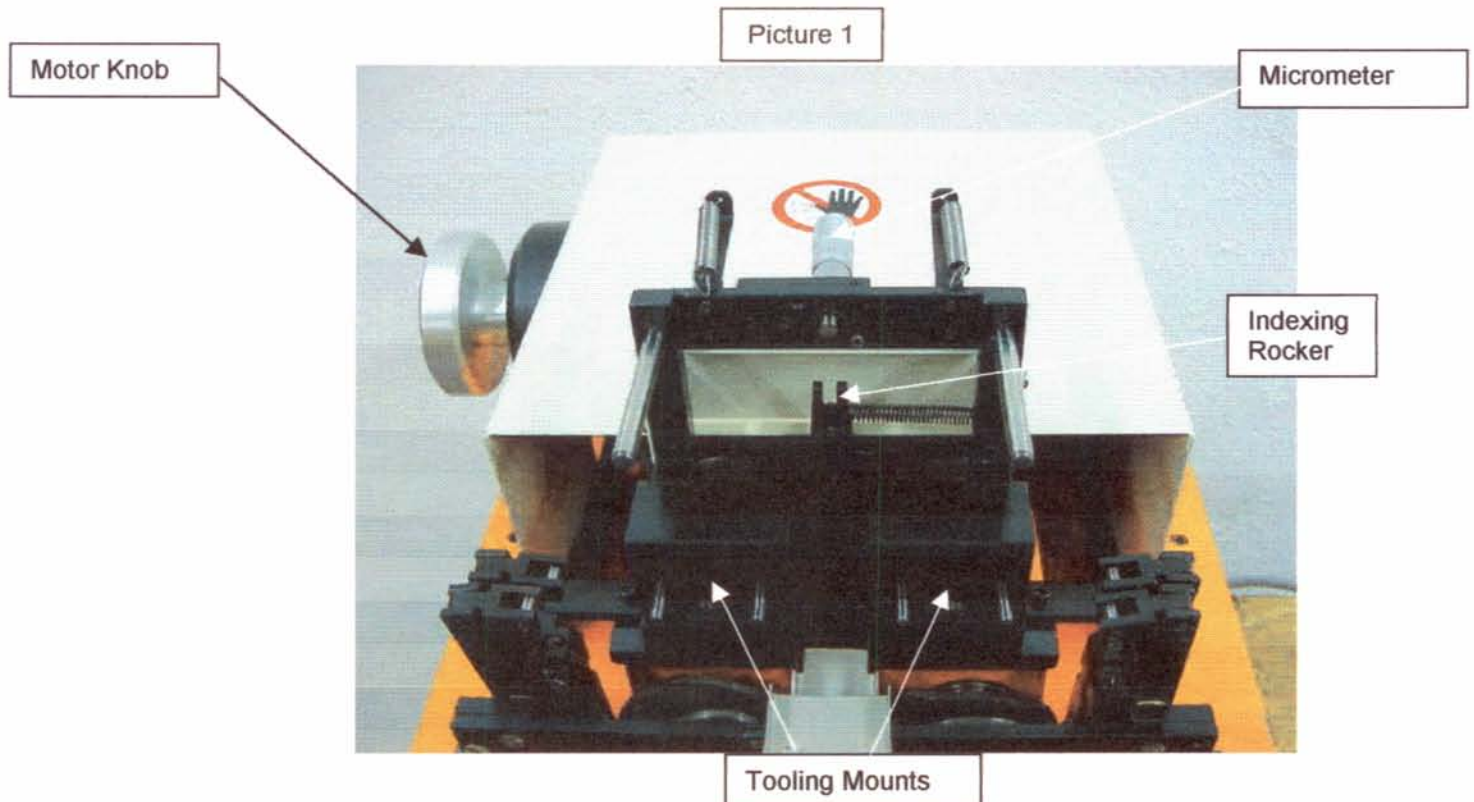
The C067 was designed to cut and form the leads of TO-126, TO-220 power transistors and other radial leaded components with similar body shapes. The machine can be set up for hand or tube feed and will process components with 2 to 5 leads inline. Die sets are available for horizontal or vertical mounting of the components as well as a wide variety of hole pattern and form configurations.

2.0 SETTING UP THE MACHINE:

Place the C067 on a suitable work surface and connect the power cord to an approved electrical service rated at 110v, 15a, 60hz.

2.1 Installing The Feed Magazine

1. Turn the micrometer knob clockwise (direction from the front of the machine) to retract the pin which sets the cut length/form placement.
2. Set the indexing rocker directly under the micrometer pin by turning the motor knob toward the front of the machine.
3. Push the feed magazine onto the guide shafts and align the engagement pin with the slot at the top of the indexing rocker.
4. Secure the feed magazine in place by connecting the two magazine retaining springs with the two spring pins on the feed magazine

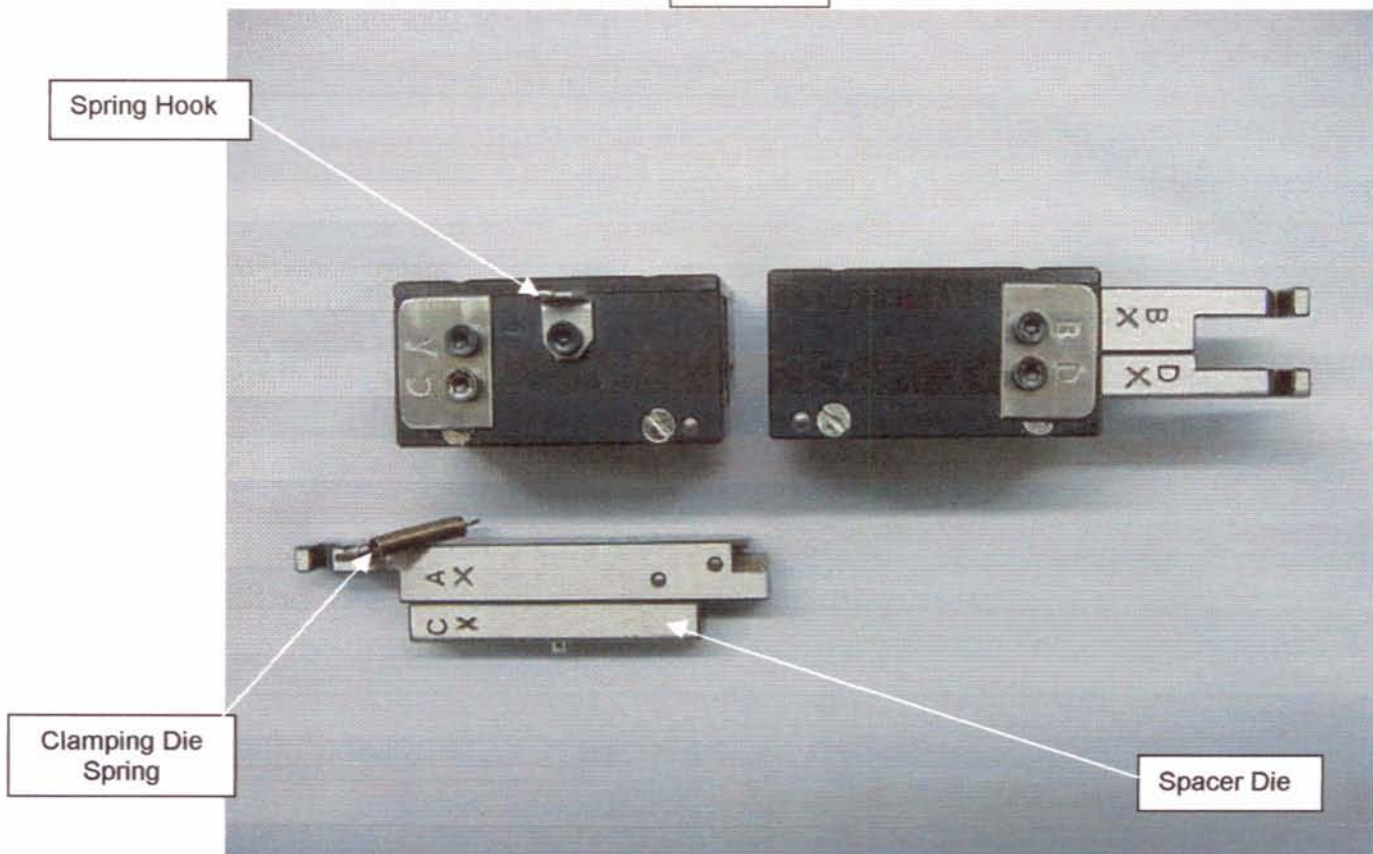


2.2 Installing The Forming dies/Tool Blocks

1. When installing the forming die inserts, verify that the letters on the inserts match the letters on the tool block.
2. On the tool block which has a spacer and a forming die, slide the spacer into the block first followed by the forming die. On the opposite tool block with two dies, slide the back or "B" die (picture 2) into the tool block first followed by the front die. Connect the clamping die spring to the hook on the block.
3. Align the two holes located on the back of each tool block with the dowel pins protruding from the tooling mount. Push the tooling block into position until it is fully seated against the mount. Secure the blocks in position using the two M5 x 20mm screws provided.
4. Attach the rocker arms to the forming die inserts using the latches (picture 3). If the latch does not reach the die, cycle the machine manually with the motor knob until the rocker arm advances toward the die.

NOTE- cycle the machine by hand to verify all items have been assembled correctly.

Picture 2



4.0 OPERATION:

After making the adjustments as described above the C067 is ready to operate.

1. Verify the orientation of the component is correct for insertion into the PCB. Feed the components into the top of the feed magazine. When hand feeding, the components are fed into the feed magazine one at a time. When tube feeding, an entire tube is positioned over the top of the feed magazine and held in place by a special attachment designed for the type of tube being used.
2. Turn the speed control knob counter-clockwise to the minimum position or "0".
3. Turn the power switch to the on or "EIN" position.
4. Adjust the speed control knob clockwise until the optimum operating speed is achieved for the form configuration installed.

5.0 PREVENTIVE MAINTENANCE:

5.1 Daily

1. Remove all scrap leads from the machine with a brush or controlled, light blast of air.

5.2 Monthly

1. Remove and disassemble the forming dies. Clean thoroughly and relubricate using a light amount of 10w oil.
2. Apply a light amount of 10w oil to the linear bearings, guide shafts and cams.
3. Check for wear.

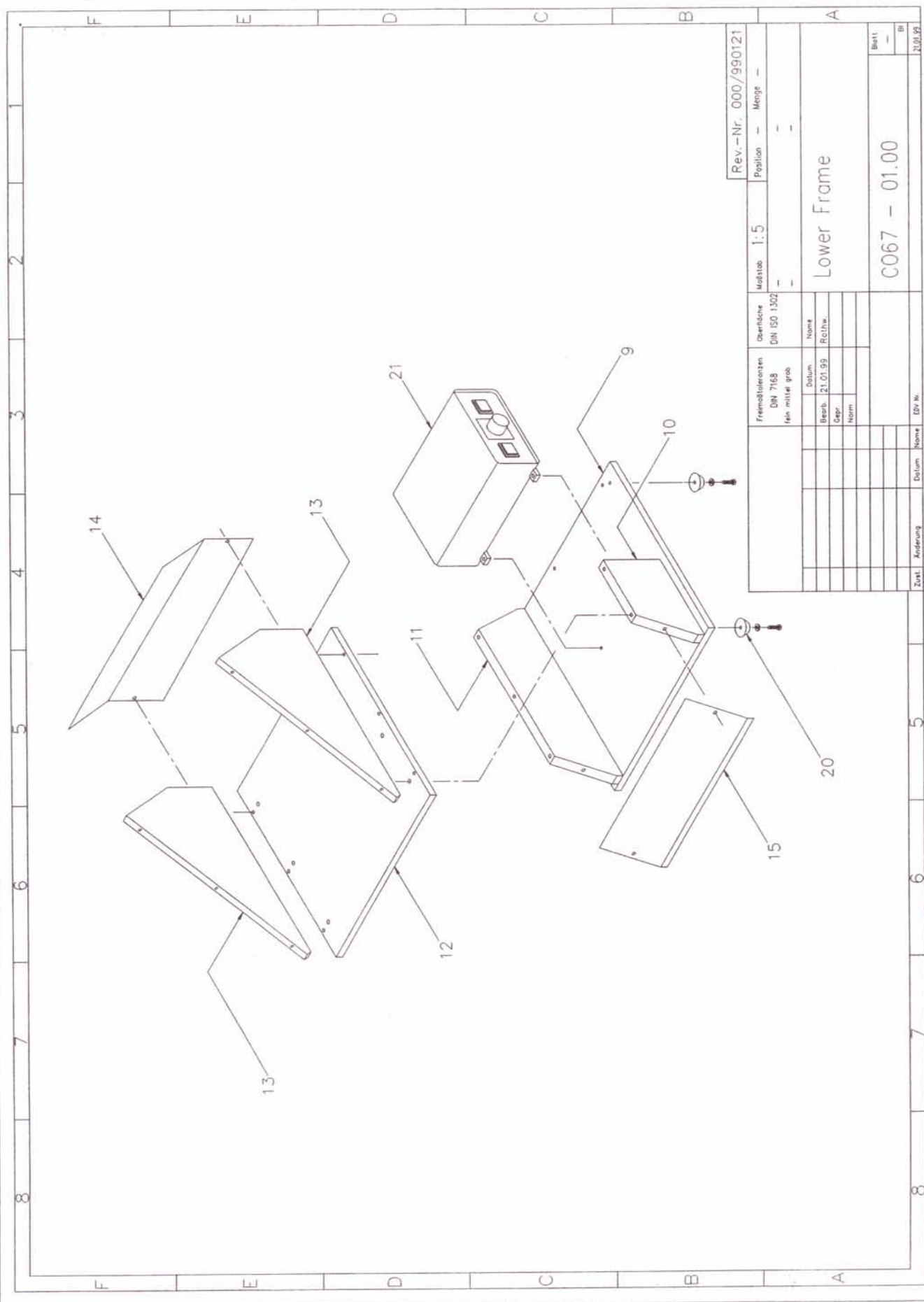
Dwg #	Item #	Part Number	Description	Qty	Notes
01.00	9	P-C067N-001	Lower Base Plate	1	
01.00	10	P-C067N-002	Lower Side Plate - Right	1	
01.00	11	P-C067N-003	Lower Side Plate - Left	1	
01.00	12	P-C067N-004	Sub Plate	1	
01.00	13	P-C067N-005	Upper Side Plate	2	
01.00	14	P-C067N-006	Rear Cover	1	
01.00	15	P-C067N-007	Front Cover	1	
01.00	20	P-C067N-008	Rubber Foot	4	
01.00	21	P-C067N-009	Speed Control Unit	1	
02.00	2	P-C067N-010	Bearing Block	1	
02.00	11	P-C067N-011	Bearing Bolt	1	
02.00	12	P-C067N-012	Acrylic Safety Hood	1	
02.00	14	P-C067N-013	Angle Bracket	1	
02.00	15	P-C067N-014	Bearing Mount	1	
02.00	17	P-C067N-015	Tooling Base Plate	1	
02.00	18	P-C067N-016	Motor Cover	1	
02.00	19	P-C067N-017	Mounting Bracket - Right	1	
02.00	20	P-C067N-018	Mounting Bracket - Left	1	
02.00	21	P-C067N-019	Motor Mount	1	
02.00	22	P-C067N-020	Screw	2	
02.00	30	P-Brng-007	Needle Bearing (NK 8/16 TN)	1	1
03.00	6	P-C067N-021	Mounting Bracket	1	
03.00	7	P-C067N-022	Scrap Lead Chute	1	
03.00	8	P-C067N-023	Angle Bracket	1	
03.00	9	P-C067N-024	Spacer	6	1
03.00	11	P-C067N-025	Angle Bracket	1	
03.00	12	P-C067N-026	Component Exit Chute	1	
03.00	13	P-C067N-027	Mounting Bracket	2	
03.00	16	P-C067N-028	Rocker Arm Mounting Block	2	
03.00	17	P-C067N-029	Rocker Arm Mounting Block	4	
03.00	18	P-C067N-030	Cam Follower	4	
03.00	19	P-C067N-031	Die Engagement	4	
03.00	20	P-C067N-032	Spring Cap	1	
03.00	30	P-Brng-011	Radial Ball Bearing (624-ZZ)	4	1
03.00	31	P-C067N-033	DIN 6325H Dowel Pin (8x45)	2	1
03.00	32	P-C067N-034	Spring (D-180 D)	4	1
04.00	1	P-C067N-035	Tooling Mount	1	
04.00	2	P-C067N-036	Magazine Mount	2	
04.00	4	P-C067N-037	Spring Bracket	2	
04.00	10	P-C067N-038	Mounting Bracket	1	
04.00	11	P-C067N-039	Spring Pin	1	
04.00	12	P-C067N-040	Clamp	2	
04.00	13	P-C067N-041	Micrometer Mount	1	
04.00	14	P-C067N-042	Safety Cover	1	
04.00	20	P-C067N-043	Spring (16529)	2	1

Dwg #	Item #	Part Number	Description	Qty	Notes
04.00	21	P-C067N-044	Micrometer	1	
04.00	22	P-C067N-045	DIN 6325H Dowel Pin (6x60)	2	
05.00	2	P-C067N-046	Shaft	1	
05.00	3.1	P-C067N-047	Cam (3.1)	1	
05.00	3.2	P-C067N-048	Cam (3.2)	1	
05.00	3.3	P-C067N-049	Cam (3.3)	1	
05.00	3.4	P-C067N-050	Cam (3.4)	1	
05.00	3.5	P-C067N-051	Cam (3.5)	1	
05.00	4.1	P-C067N-052	Spacer (2.7mm)	2	
05.00	4.2	P-C067N-053	Spacer (3.5mm)	1	
05.00	4.3	P-C067N-054	Spacer (13.5mm)	1	
05.00	5	P-C067N-055	Belt Pulley	2	
05.00	6	P-C067N-056	Shaft	1	
05.00	7	P-C067N-057	Hand Knob	1	
05.00	20	P-Brng-019	Radial Ball Bearing (6003-ZZ)	4	1
05.00	21	P-C067N-058	Belt (10-T5/330)	1	1
05.00	22	P-C067N-059	Motor Coupling (OX33G-D33)	1	
06.00	1	P-C067N-060	Pivot Block	1	
06.00	2	P-C067N-061	Cam Follower	1	
06.00	6	P-C067N-062	Spring Pin	1	
06.00	7	P-C067N-063	Indexing Rocker	1	
06.00	10	P-C067N-064	Spring (16528)	1	1
06.00	11	P-C067N-065	DIN 6325H Dowel Pin (10x52)	1	
06.00	12	P-Brng-011	Radial Ball Bearing (624-ZZ)	1	1
08.00	9	P-C067N-066	Magazine Cover Plate Set	1	1
08.00	12	P-C067N-067	Clamping Pin	1	
08.00	15	P-C067N-068	Indexing Plate	2	1
08.00	19	P-C067N-069	Mount	1	
08.00	21	P-C067N-070	Tube Attachment	1	
08.00	22	P-C067N-071	Cover Plate	1	
08.00	23	P-C067N-072	Tube Holder	1	
08.00	24	P-C067N-073	Tube Lock	1	
08.00	25	P-C067N-074	Shoulder Bolt	1	
08.00	27	P-C067N-075	Feed Chute with Orientation Plate - H/S Right	1	
08.00	27a	P-C067N-076	Feed Chute with Orientation Plate - H/S Left	1	
08.00	28	P-C067N-077	Magazine Base Plate	1	
08.00	29	P-C067N-078	Indexing Sub Plate	1	
08.00	30	P-C067N-079	Mounting Block	1	
08.00	31	P-C067N-080	Mounting Block	1	
08.00	32	P-C067N-081	Exit Finger	1	
08.00	33	P-C067N-082	Clamping Pin Mount	1	
08.00	34	P-C067N-083	Safety Cover	1	
08.00	35	P-C067N-084	Gauge Pin	1	
08.00	36	P-C067N-085	Sleeve Bushing	1	
08.00	37	P-C067N-086	Engagement Pin	1	

Dwg #	Item #	Part Number	Description	Qty	Notes
08.00	38	P-C067N-087	Spring Pin	1	
08.00	50	P-C067N-088	Spring (D-095 C)	1	1
08.00	51	P-C067N-089	Spring (D-029)	1	1
08.00	52	P-C067N-090	Spring (D-079)	1	1
08.00	53	P-C067N-091	Bearing Bushing (N-6v)	2	
08.00	54	P-C067N-092	DIN 6325H Dowel Pin (4x110)	2	
09.00	1	P-C067N-093	Tool Block	2	2
09.00	1a	P-C067N-093	Cap Plate	2	2
09.00	2	P-C067N-093	Rear Plate	2	2
09.00	5	P-C067N-093	Spring Hook	1	2
09.00	7	P-C067N-093	Ref Designator Plate	2	2
09.00	10	P-C067N-094	Spring (14776)	1	1,2
10.00	1	P-C067N-093	Tool Block	2	2
10.00	1a	P-C067N-093	Cap Plate	2	2
10.00	2	P-C067N-093	Rear Plate	2	2
10.00	5	P-C067N-093	Spring Hook	1	2
10.00	7	P-C067N-093	Ref Designator Plate	2	2
10.00	10	P-C067N-094	Spring (14776)	1	1,2

¹ Recommended Spare Part

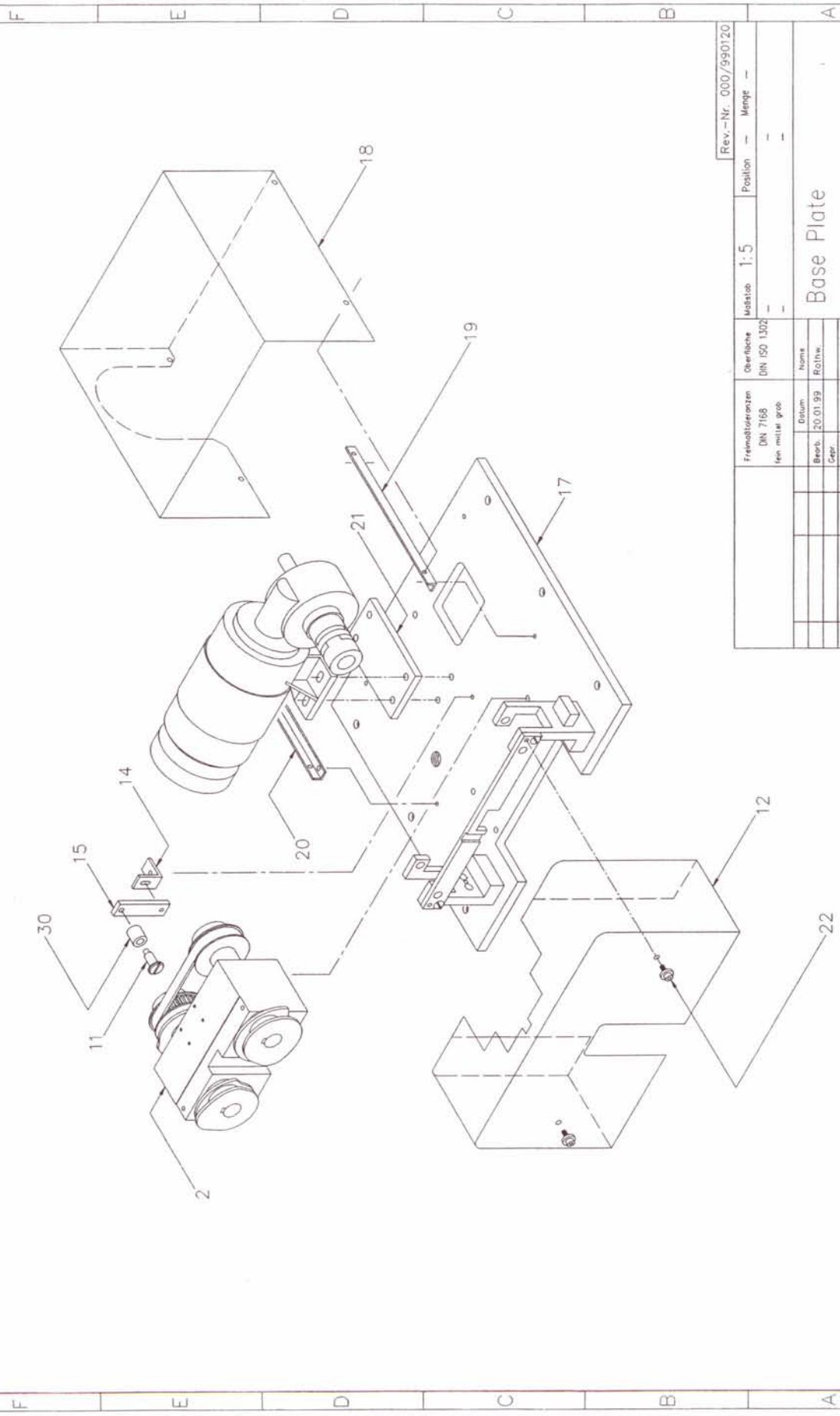
² Only as Complete Assembly



Rev.-Nr. 000/990121		Position	Menge
Maßstab 1:5			
Toleranzen DIN 7168 fein mittel grob		Oberfläche DIN ISO 1302	
Datum		Name	
Bezb. 21.01.99		Reithw.	
Gepr.		Norm	
Änderung		Datum	
Zust.		Name	
EDr.Nr.		Best.	
		C067 - 01.00	
		Bl.	
		21.01.99	

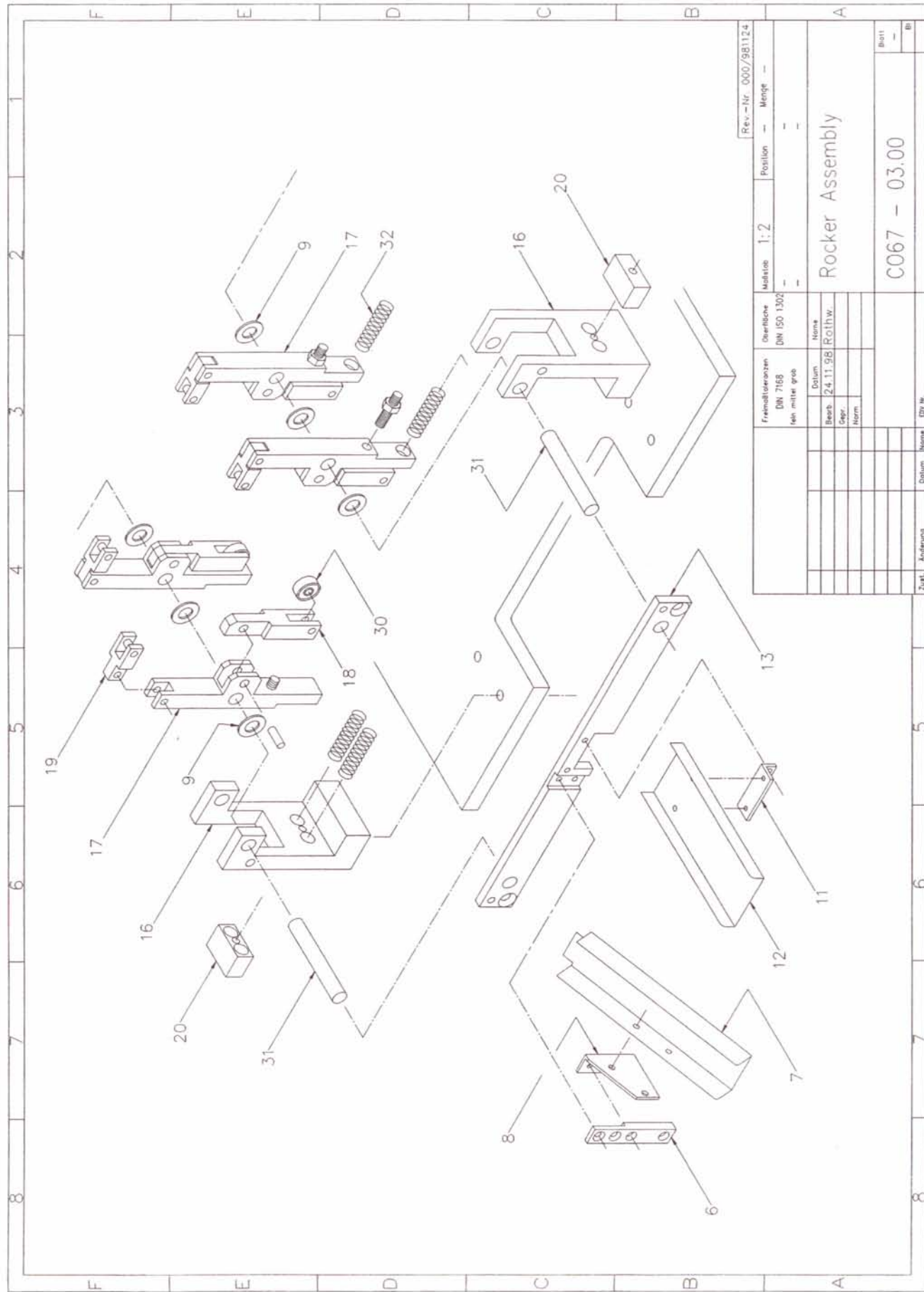
Lower Frame

C067 - 01.00

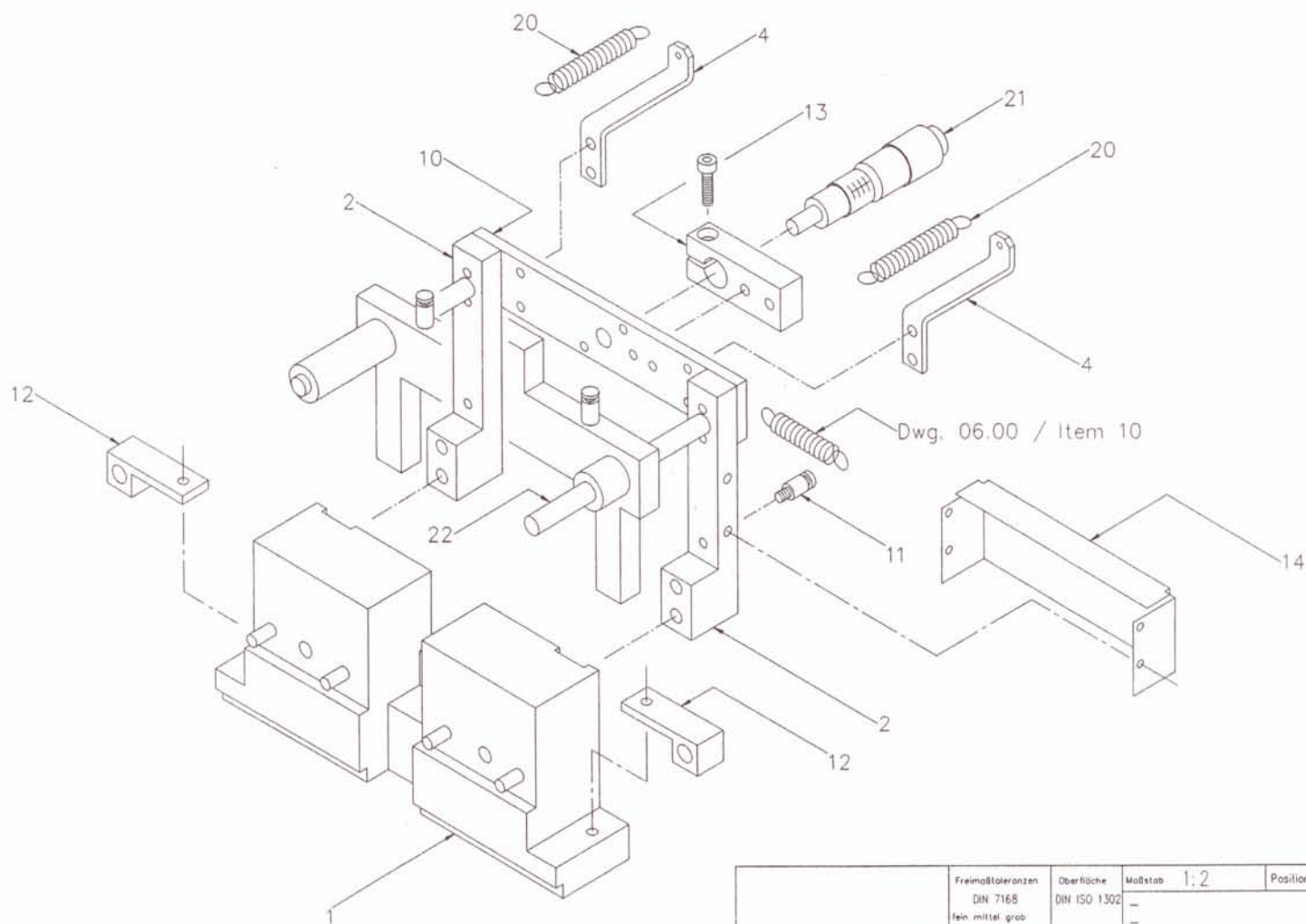


Rev.-Nr. 000/990120		Position	Menge
Maßstab 1:5			
Oberfläche DIN ISO 1302		Base Plate	
Freibleistungen DIN 7168 fein mittel grob		C067 - 02.00	
Name		Beitl.	
Datum		Bl.	
Bearb. 20.01.99		21.03.99	
Gepr.			
Norm.			
Datum			
Name			
EDZ Nr.			

Skalierfaktor 1,3

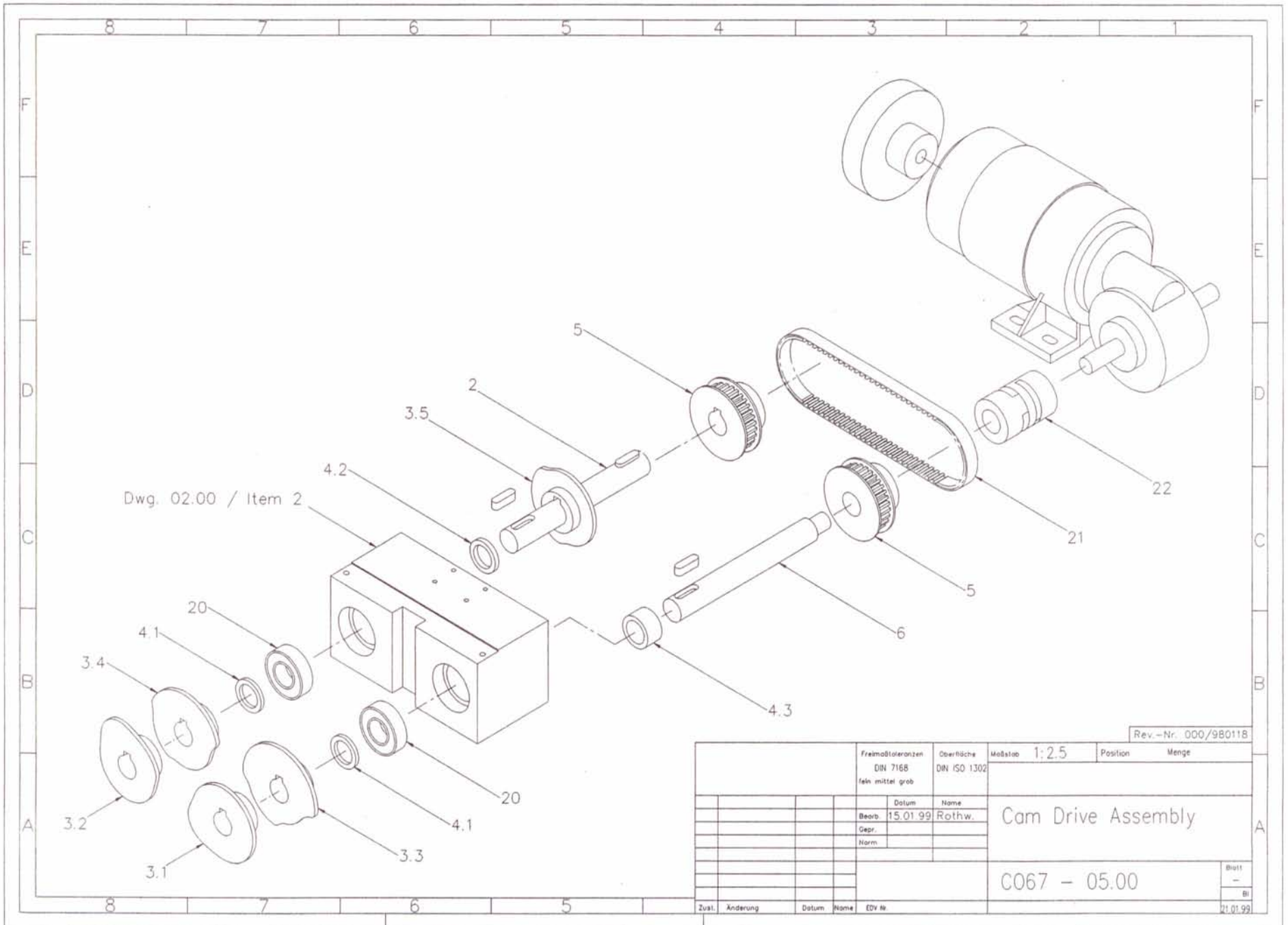


Rev.-Nr. 000/981124		Position		Menge	
Maßstab 1:2		-		-	
Oberfläche DN ISO 1302		Name		Rocker Assembly	
Fräskriterien DN 7168 Neh mitte grob		Datum		24.11.98	
Beerb		Gepr.		Norm	
Zust.		Änderung		Datum	
Name		Name		Dr. Nr.	
C067 - 03.00		Blatt		-	
		-		-	



Rev.-Nr. 000/981126

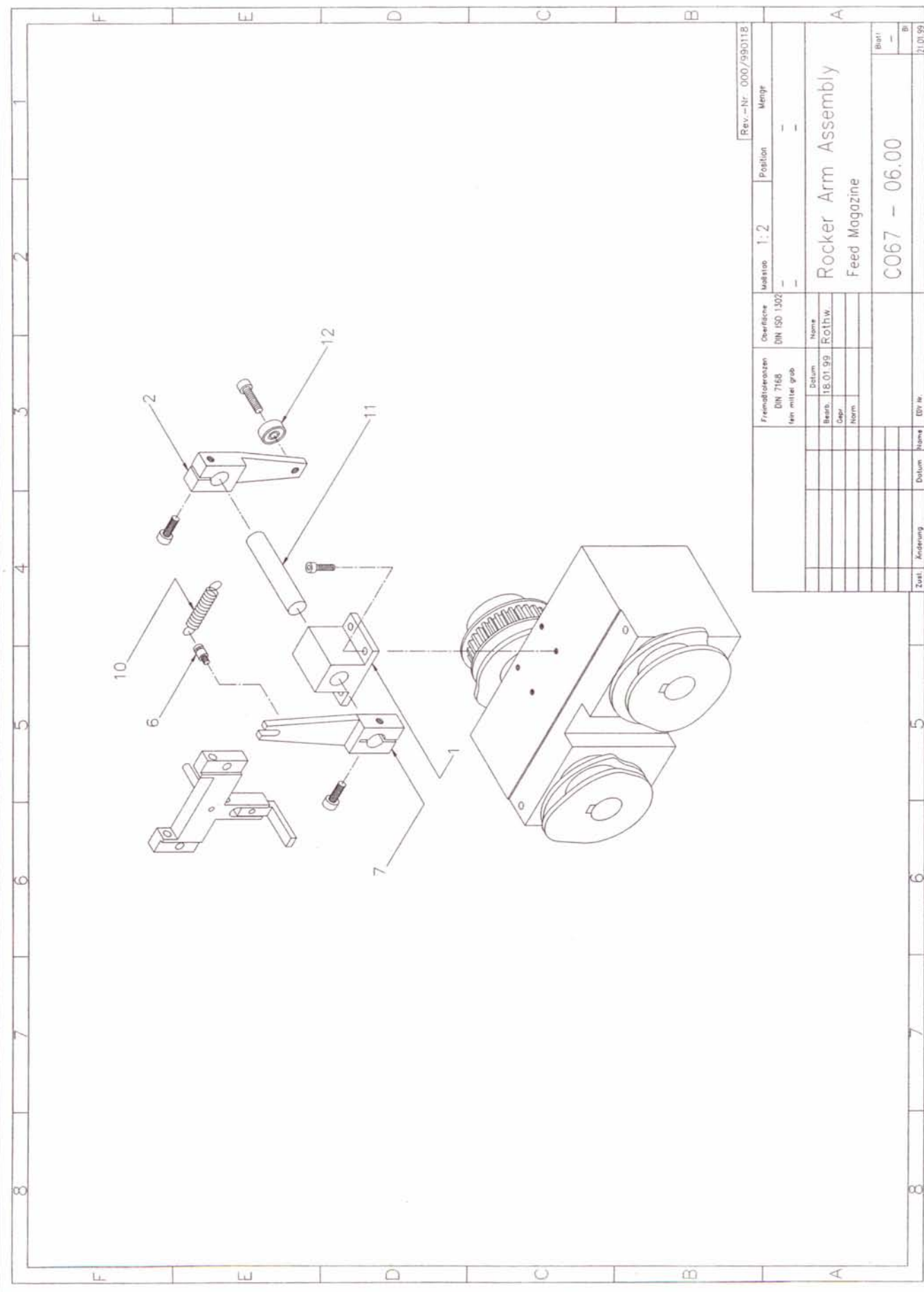
	Freiabl. toleranzen DIN 7168 fein mittel grob	Oberfläche DIN ISO 1302	Maßstab 1:2	Position -	Menge -
	Datum	Name	Feed Magazine Adjustment		
	Bearb. 26.11.98	Rothw.			
	Gepr.				
	Norm				
			C067 - 04.00		
Zusl.	Änderung	Datum	Name	EDV Nr.	Blatt -- Bl 25.01.99



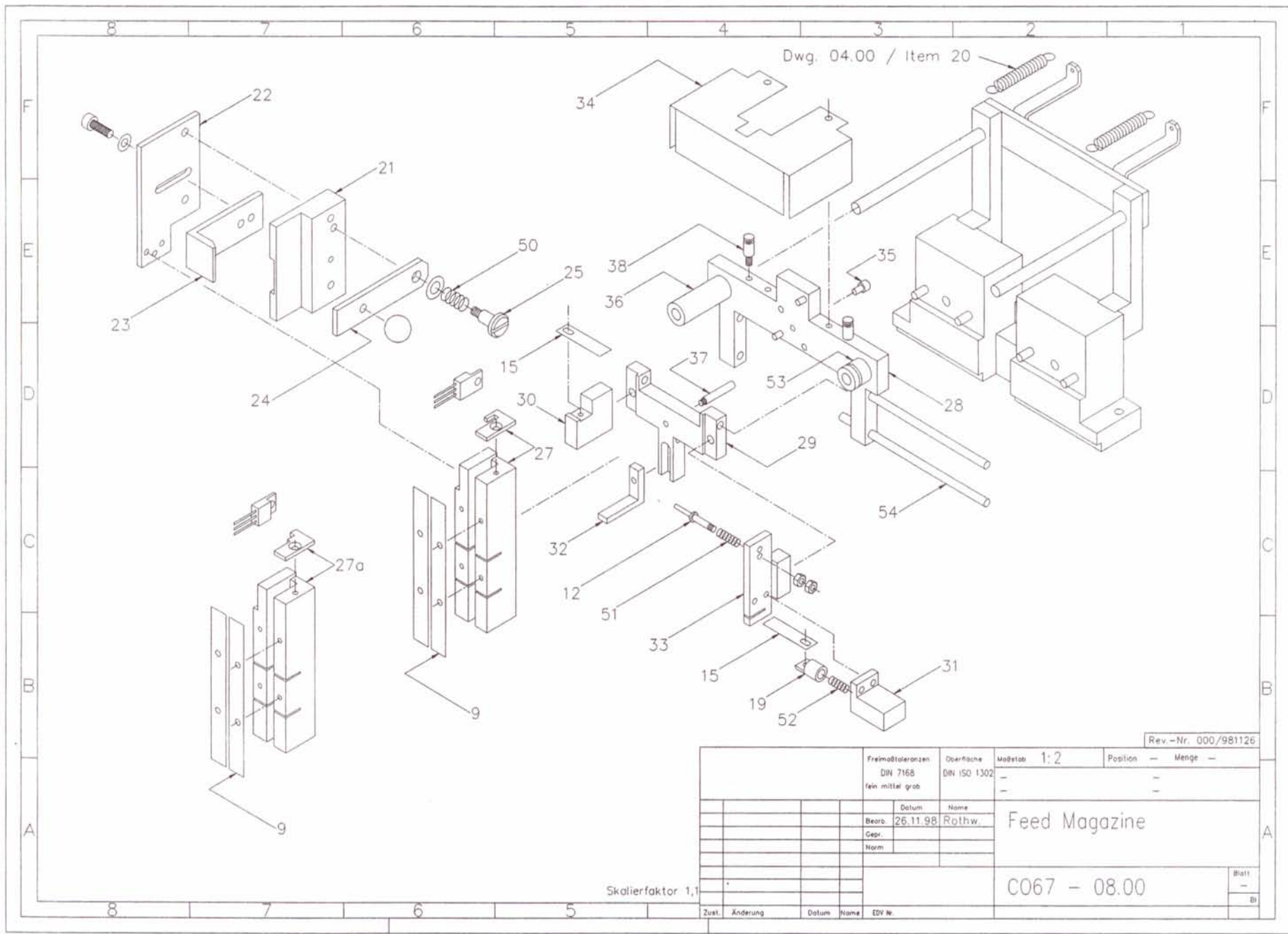
Dwg. 02.00 / Item 2

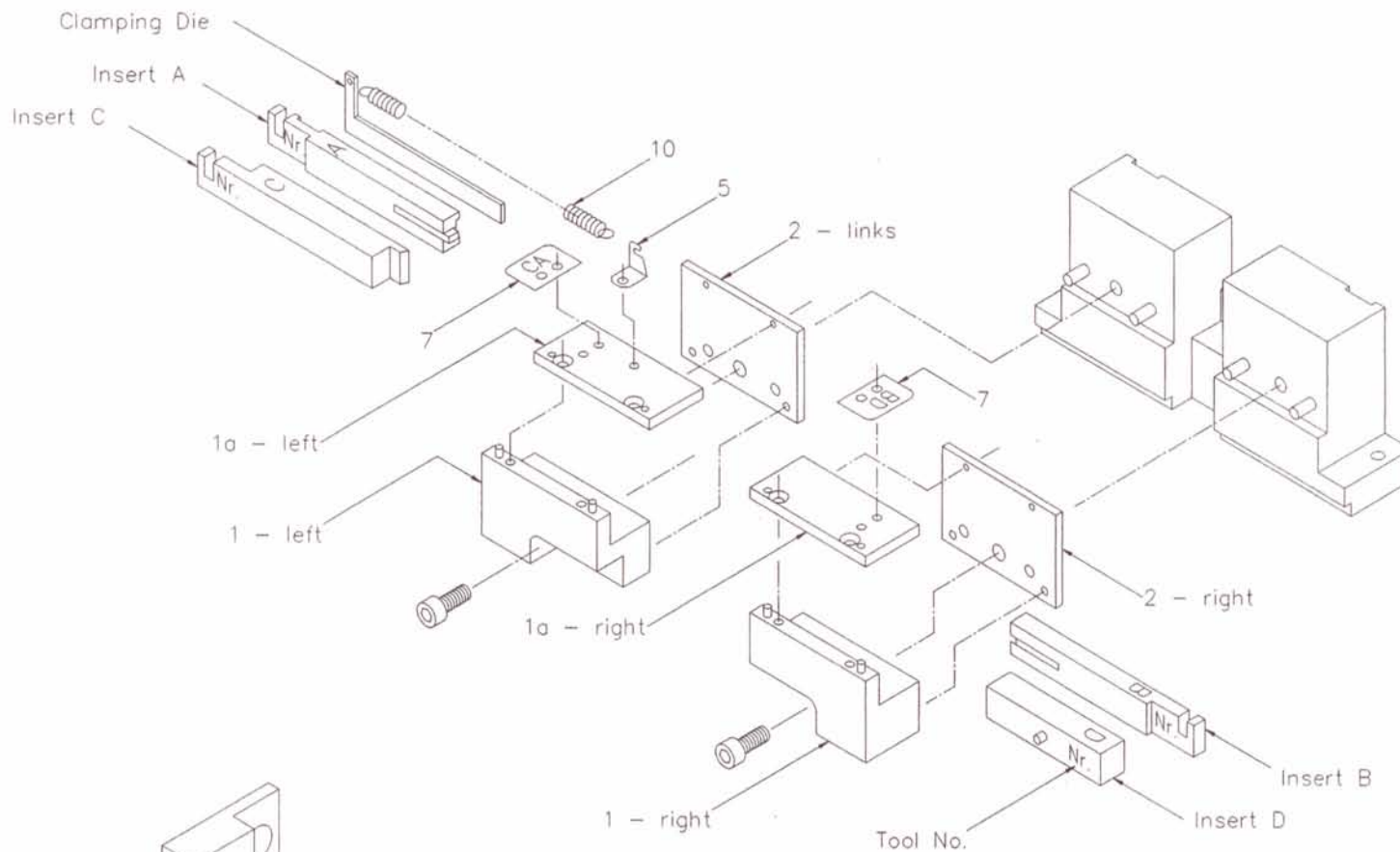
Rev.-Nr. 000/980118

Freimaßtoleranzen DIN 7168 fein mittel grob		Oberfläche DIN ISO 1302	Maßstab 1:2.5	Position	Menge
Datum	Name		Cam Drive Assembly		
Bearb.	15.01.99 Rothw.				
Gepr.					
Norm					
C067 - 05.00			Blatt		
			-		
			Bl		
Zust.	Anderung	Datum	Name	EDV Nr	21.01.99



Rev.-Nr. 000/990118		Menge	
Verhältnis	1:2	Position	--
Oberfläche	DIN ISO 1302		
Fremdtoleranzen	DIN 7168		
fein mittel grob			
Name		Rothw.	
Datum	18.01.99		
Bezeichnung			
Gepr.			
Norm			
Zust.		Änderung	
Datum	Name	Datum	EDr-Nr.
Rocker Arm Assembly		Feed Magazine	
C067 -- 06.00		Blatt	
		Bl	
		21.01.99	





Rev.-Nr 000/990111

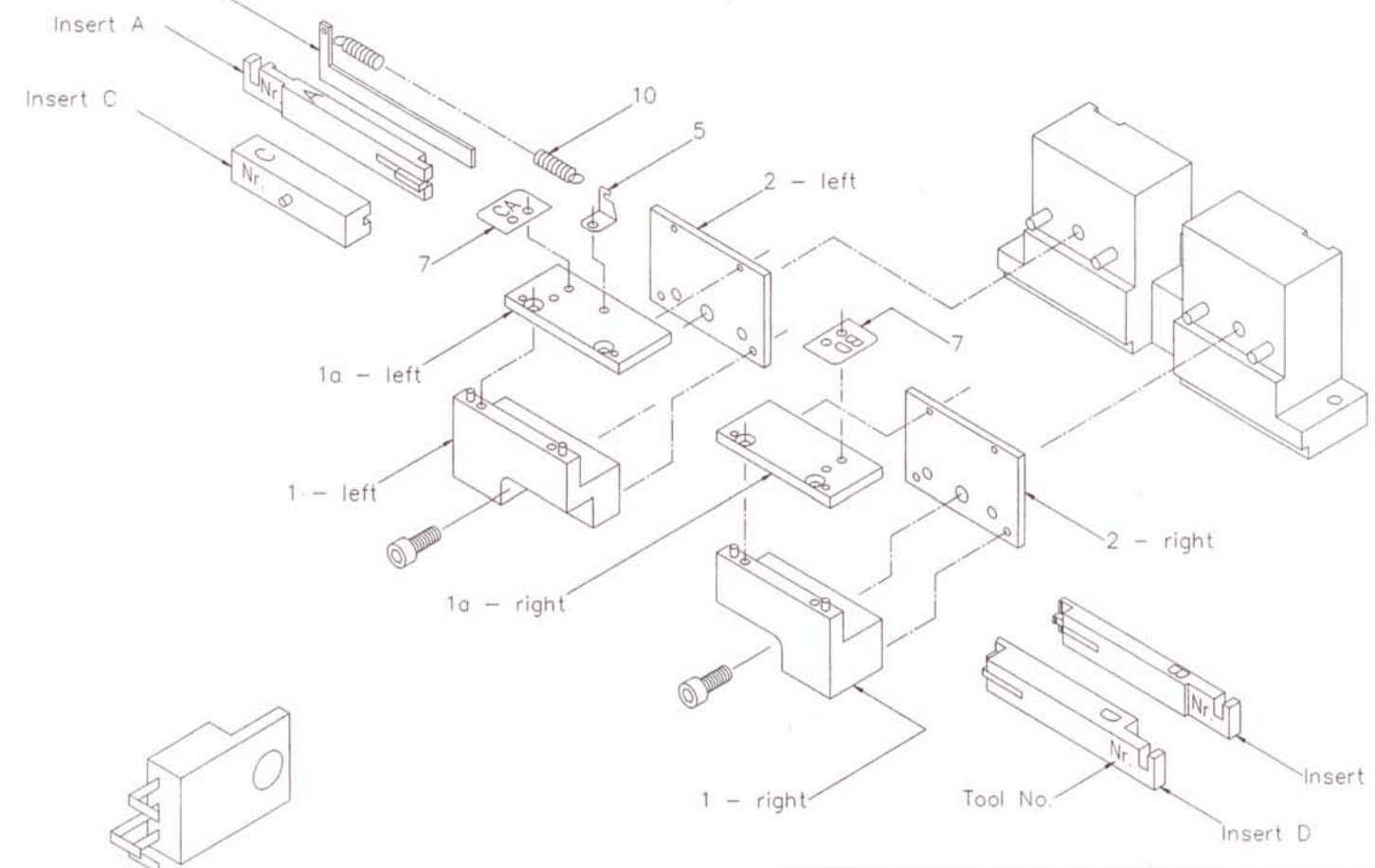
	Freiüberranzen DIN 7168 fein mittel grob	Oberfläche DIN ISO 1302	Maßstab: 1:2	Position	Menge
	Datum	Name	Tooling Block Heat Sink Left		
	Bearb. 23.12.98	Rothw.			
	Gepr.				
	Norm				
			C067 - 09.00		
Zust.	Änderung	Datum	Name	EDV Nr.	Blatt - Bl
					25.01.99

Skalierfaktor 1,2

Clamping Die

Insert A

Insert C



Heat Sink Orientation

Skalierfaktor 1,2

Rev.-Nr. 000/990112

	Freiablöteranzen DIN 7168 fein mittel grob	Oberfläche DIN ISO 1302	Maßstab 1:2	Position - Menge -
	Datum	Name	Tooling Block Heat Sink Right	
	Bearb. 23.12.98	Rothw		
	Gepr.			
	Norm			
			C067 - 10.00	Blatt -
				11
Zust.	Änderung	Datum	Name	EDV Nr.
				15.01.99