

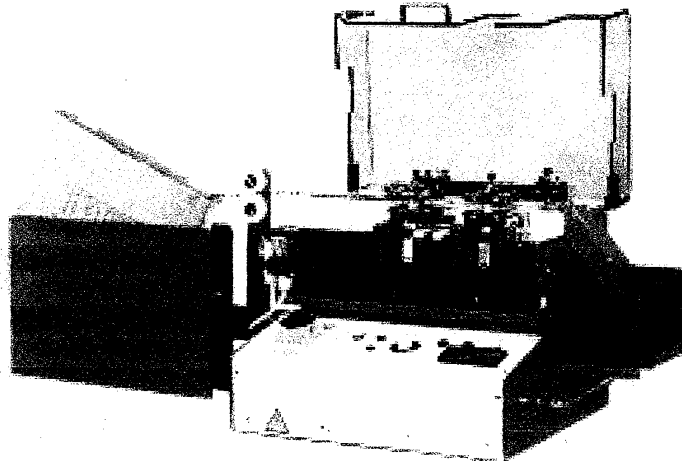
MODEL C069/G



OPERATING INSTRUCTIONS

May 2001

Serial Number _____



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* Recommended spare parts are indicated on the parts list with a (1) under the "notes" column

1.0 GENERAL DESCRIPTION:

The Streckfuss Model C069/G was designed to cut and form the leads of radial components. Simplicity in design and operation make this machine ideal for fast, accurate preforming of components. A full range of adjustment are provided for versatility in set up and operation, with the exception of periodic cleaning and light lubrication, the C069/G is virtually maintenance free.

2.0 SETTING UP THE MACHINE:

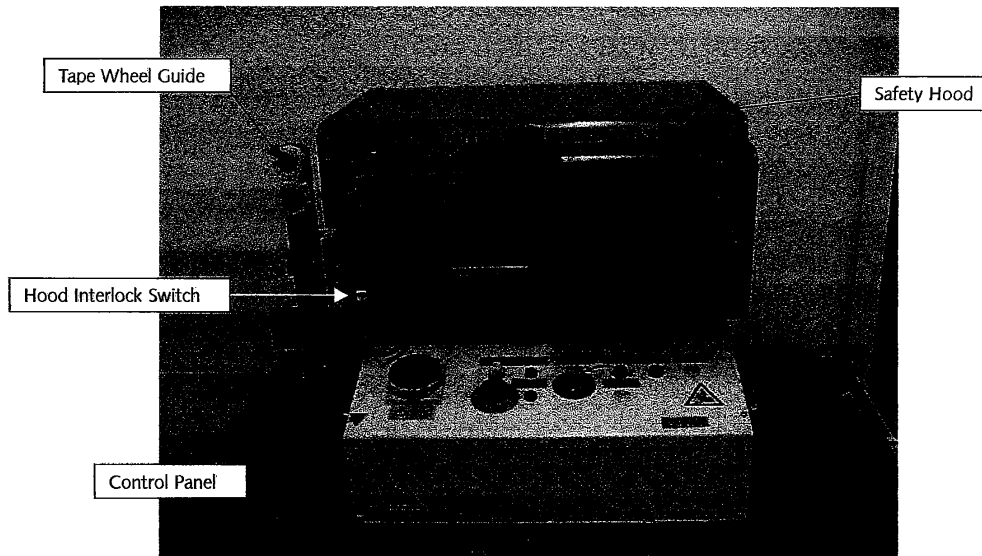
Place the C069/G on a suitable work surface. The surface selected should be sturdy enough to support the weight of the machine.

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.

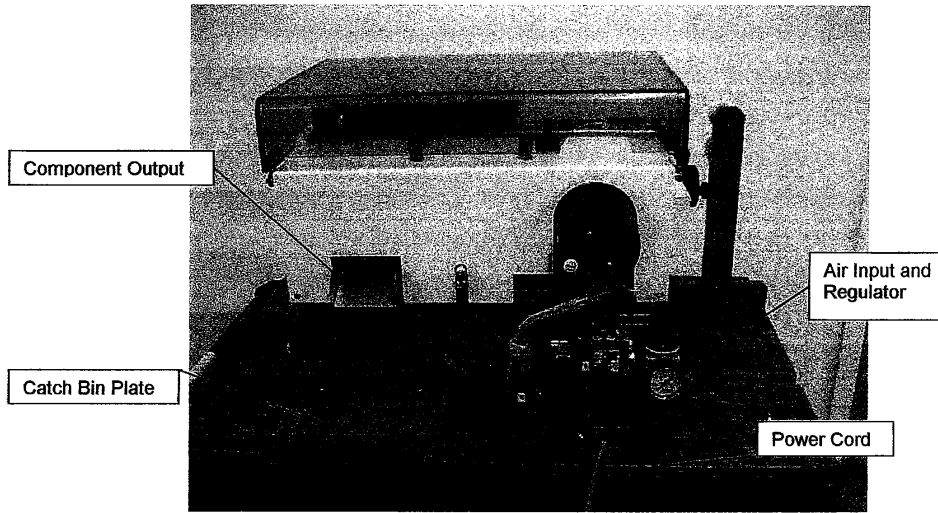
Connect one end of the air hose provided to the air regulator mounted on the back of the machine. Connect the other end to a clean, dry air supply regulated from 60 to 90 PSI.

3.0 MACHINE OVERVIEW:

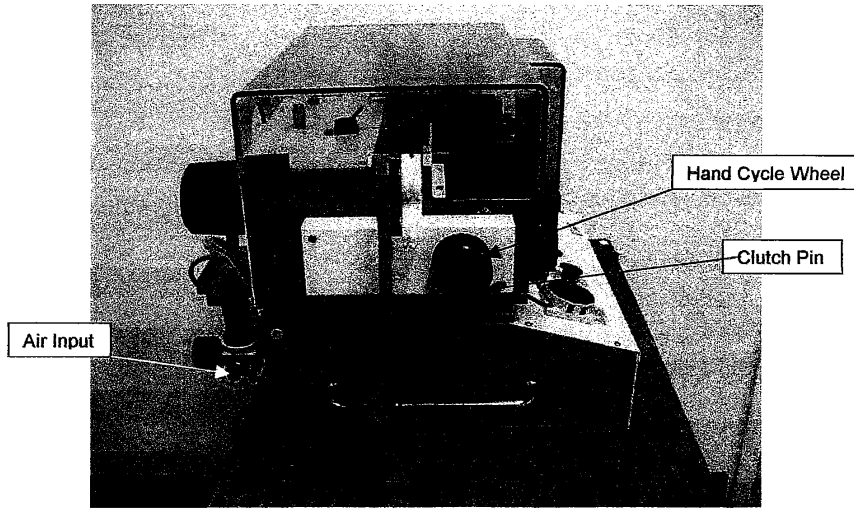
3.1 Front view



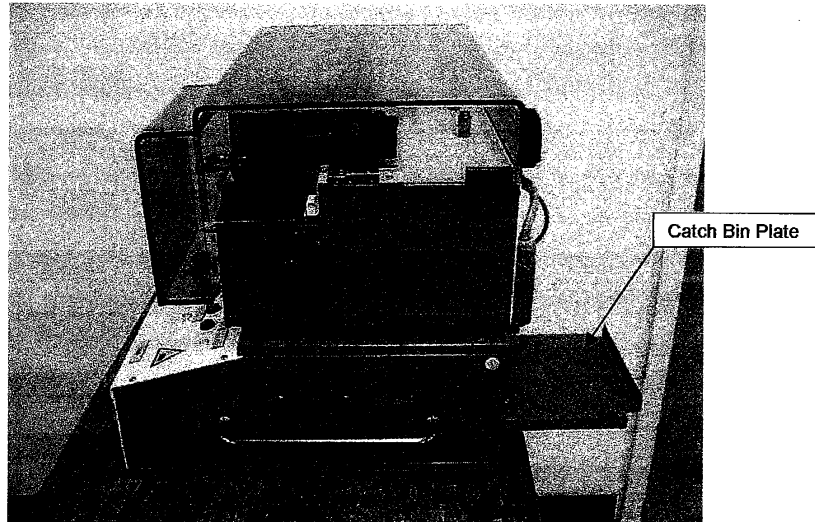
3.2 Rear view



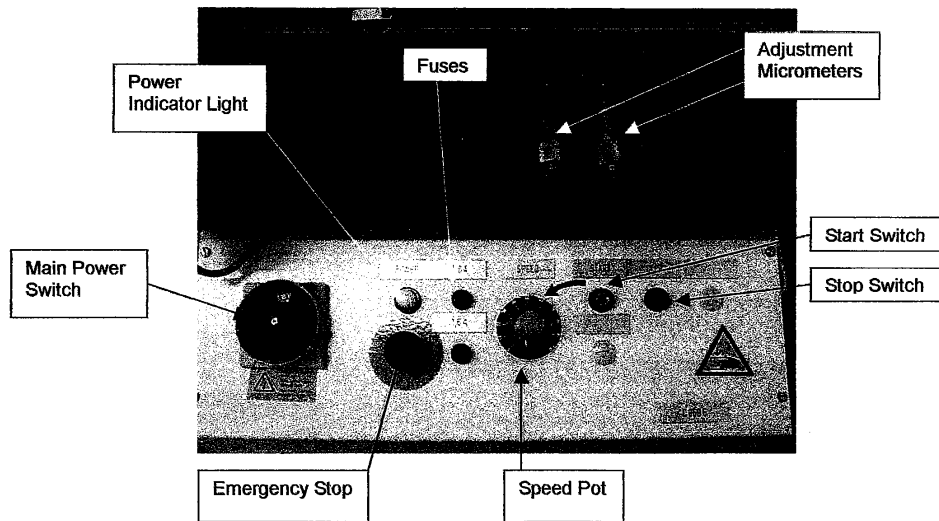
3.3 Left view



3.4 Right view

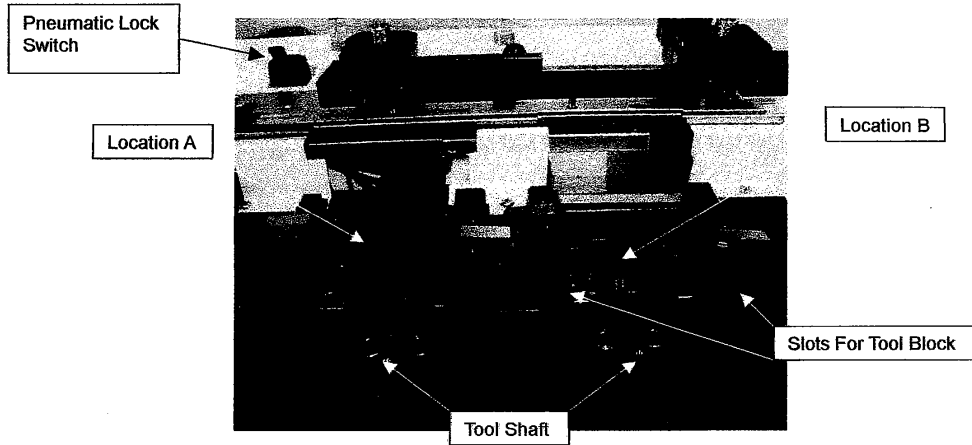


3.5 Control Panel Overview



4.0 ADJUSTMENTS

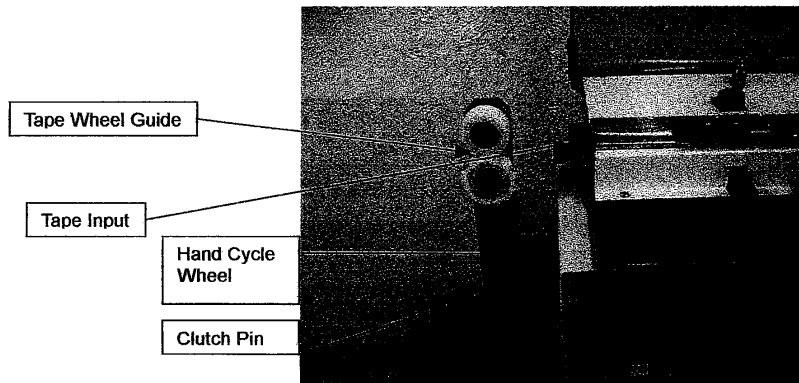
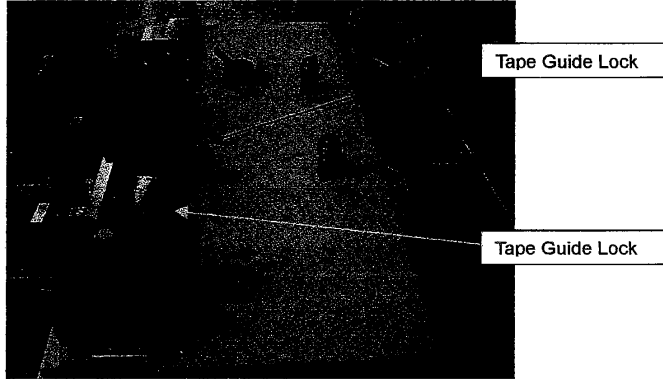
4.1 Installation of cutting and forming tool blocks



1. Turn off the pneumatic tool lock switch
2. Location "A" (the left most tooling area) is for forming tool blocks only. Location "B" (the right most tooling area) is for the cut and spread/cut tool blocks only.
3. Loosen the retaining screw in the shaft guide and remove the shaft guide from the tool shaft.
4. Install the tool block into the slots on the left and right sides of the tooling location (A/B). Slide the tool block all the way back into the tooling location until it stops.
5. Slide the shaft guide back on to the shaft. Tighten retaining screw.

Note: When installing the spread/cut tool make sure to connect the air line to the air fitting on the right side.

4.2 Installation of the tape into the C069/G

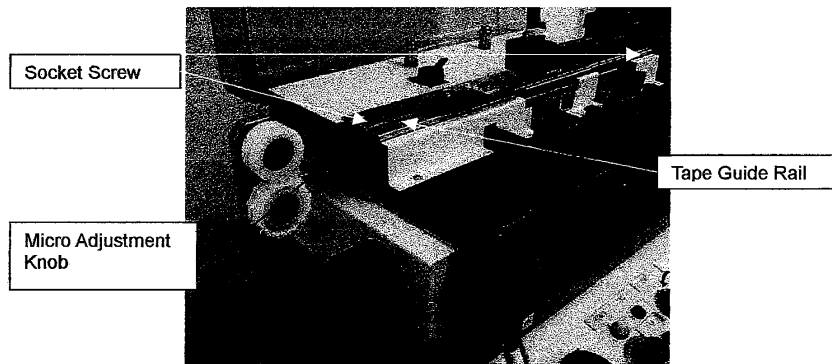


4.2 Installation of the tape into the C069/G -Continued-

1. Pull and turn the clutch pin so the C069/G can be hand cycled.
2. Turn the tape guide lock assembly.
3. Pull down the tape retainer.
4. Feed the tape (leads up) in to the guide wheels that are located to the left of the machine.
5. Hand cycle the machine so the centering pins slightly protrude.
6. From the guide wheels slide the tape into the tape track until the tape touches the 1st centering pin.
7. Insert the 1st centering pin into the hole in the tape. It may be necessary to hand cycle the machine to lower the centering pin to do this.
8. Raise the tape retainer back in to position. It may be necessary to hand cycle the machine to do this.
9. Turn the tape guide lock back into position.
10. Re-engage the clutch pin.

4.3 Micro adjustment of tape location

Misalignment of components and form/spread/cut tools and be adjusted via the component adjustment knob located on the left side of the C069/G at the tape input.



1. Advance the tape in to the C069/G by the use of the hand wheel until the component is directly under the tool and the rail for the tape moves downward and holds the tape in position.
2. Now verify the component is centered in the tool.
3. If the component is not in the center of the tool, follow steps 4,5 and 6.
4. Loosen the two socket head cap screws on each end of the tape guide rail.
5. Now turn the component adjustment knob to move the component into the center of the tool.
6. Re-tighten the two socket head cap screws in the tape guide rail.

4.4 Adjust the form/spread/cut position on the component

1. Turn off the pneumatic tool lock switch.
2. Loosen the retaining screw in the shaft guide so the shaft guide will slide freely on the tool shaft.
3. While applying pressure to the tool block turn the micrometer the desired setting.
4. Tighten the retaining screw.

Note: DO NOT change any of the settings on these tool blocks. They are factory set to your requirements.

5.0 OPERATION

After making all the adjustments described in section 4.0, the machine is ready to form components. Close the hood assembly, the machine has a lock out switch and will not operate with the hood in the open position. Before starting the C069/G turn the speed dial down to zero until you hear it click. Depress the start button, the machine will begin to cycle. To increase the speed, slowly turn the speed pot clockwise. To stop the C069/G depress the stop button. In case of emergency depress the red "E" stop button.

NOTE: DO NOT EXCEED 60 ON THE SPEED DIAL. DUE TO THE COMPLEXITY OF THE SPECIAL TOOLS PROVIDED FOR THIS C069/G OPERATING THIS MACHINE FASTER THAN THE MAXIMUM RECOMMENDED SPEED CAN DAMAGE THESE TOOLS.

6.0 PREVENTIVE MAINTENANCE

- | | |
|----------|--|
| Daily - | Clean all scrap leads from the machine with a brush. An acid or flux brush will do the task. Check belt for wear or debris. |
| Weekly - | Remove the back panel from the machine and clean all scrap leads from the inside. Apply a light amount of 10w oil to all bearings, shafts and the cutting die tracks. Check the cutting dies for wear. |

Dwg #	Item #	Part Number	Description	Qty	Notes
01.00	1	P-C069G-001	Base Plate	1	
01.00	2	P-C069G-002	Side Plate (Right)	1	
01.00	3	P-C069G-003	Side Plate (Left)	1	
01.00	5	P-C069G-004	Back Panel	1	
01.00	6	P-C069G-005	Bushing	2	
01.00	7	P-C069G-006	Stand Off	2	
01.00	8	P-C069G-007	Belt Tension Bracket	1	
01.00	9	P-C069G-008	Bearing Bolt	1	
01.00	10	P-C069G-009	Hinge Pin	2	
01.00	11	P-C069G-010	Spacer	2	
01.00	12	P-C069G-011	Hinge Plate	2	
01.00	13	P-C069G-012	Hinge Plate	2	
01.00	14	P-C069G-013	Angle Bracket	2	
01.00	15	P-C069G-014	Scrap Chute	1	
01.00	16	P-C069G-015	Cover Panel	1	
01.00	17	P-C069G-016	Support Block	1	
01.00	18	P-C069G-017	Adaptor Plate	1	
01.00	19	P-C069G-018	Threaded Bushing	1	
01.00	20	P-C069G-019	Spring Pin	1	
01.00	21	P-C069G-020	Angle Bracket	1	
01.00	22	P-C069G-021	Acrylic Safety Hood	1	
01.00	23	P-C069G-022	Block	1	
01.00	24	P-C069G-023	Front Plate	1	
01.00	25	P-C069G-024	Component Chute	1	
01.00	30	P-Brng-007	Needle Bearing (NK8/16TN)	1	1
01.00	31	P-C069G-025	Handle	1	
01.00	32	P-C069G-026	Safety Switch (AZ15zvr)	1	
01.00	33	P-C069G-027	Safety Switch Key	1	
01.00	34	P-C069G-028	Microswitch	1	1
02.00	1	P-C069G-029	Electrical Cabinet	1	
02.00	2	P-C069G-030	Chassis	1	
02.00	3	P-C069G-031	Control Panel	1	
02.00	4	P-C069G-032	Front Panel	1	
02.00	5	P-C069G-033	Tray	2	
02.00	6	P-C069G-034	Ledge Block	2	
02.00	10	P-C069G-035	Handle	2	
03.00	1	P-C069G-036	Tooling Plate	1	
03.00	2	P-C069G-037	Tool Guide	1	
03.00	3	P-C069G-038	Tool Guide	1	
03.00	4	P-C069G-039	Tool Guide	1	
03.00	5	P-C069G-040	Tool Guide	1	
03.00	6	P-C069G-041	Retainer Screw	7	
03.00	7	P-C069G-042	Clamp	4	

Dwg #	Item #	Part Number	Description	Qty	Notes
03.00	8	P-C069G-043	Retainer Plate	1	
03.00	9	P-C069G-044	Angle Plate	1	
03.00	10	P-C069G-045	Angle Plate	1	
03.00	11	P-C069G-046	Angle Plate	1	
03.00	20	P-C069G-047	Short Stroke Cylinder (AV-12-4)	4	1
03.00	21	P-C069G-048	Air Fitting (LCK-M5-PK4)	4	
03.00	22	P-C069G-049	Dowel Pin (DIN6324H Ø6x?)	4	
04.00	1	P-C069G-050	Transfer Block (Specify Left/Right)	2	
04.00	2	P-C069G-051	Transport Rail	1	
04.00	5	P-C069G-052	Spring Pin	1	
04.00	7	P-C069G-053	Bearing Mount	1	
04.00	8	P-C069G-054	Transport Pins	3	
04.00	9	P-C069G-055	Eccentric Bolt	4	1
04.00	10	P-C069G-056	Spring Pin	2	
04.00	11	P-C069G-057	Spring Pin	2	
04.00	12	P-C069G-058	Bearing Pin	2	1
04.00	14	P-C069G-059	Bearing Pin	1	1
04.00	15	P-C069G-060	Retaining Washer	1	
04.00	16	P-C069G-061	Transport Block (Specify Left/Right)	2	
04.00	20	P-C069G-062	Shaft (Ø10h6 x 450)	2	
04.00	21	P-C069G-063	Linear Bushing (N-10v)	3	
04.00	22	P-C069G-064	Needle Bearing (NK5/10)	7	1
04.00	23	P-C069G-065	Ball Cage (Ø6 x Ø10 x 25)	2	
04.00	24	P-C069G-066	Outer Race (Ø10 x Ø14 x 25)	2	
04.00	25	P-C069G-067	Dowel Pin (DIN6324H Ø6 x 60)	2	
04.00	26	P-C069G-068	Spring	2	1
04.00	27	P-C069G-069	Spring	1	1
05.00	1	P-C069G-070	Guide Rail	1	
05.00	2	P-C069G-071	Centering Guide	1	
05.00	3	P-C069G-072	Block (Specify Right/Left)	2	
05.00	4	P-C069G-073	Tape Retaining Plate	1	
05.00	5	P-C069G-074	Lever	1	
05.00	6	P-C069G-075	Hinge Block	1	
05.00	7	P-C069G-076	Linkage Shaft	1	
05.00	8	P-C069G-077	Shear Block	1	1
05.00	9	P-C069G-078	Cutting Blade	1	1
05.00	10	P-C069G-079	Holder	2	
05.00	11	P-C069G-080	Angle Block	1	
05.00	12	P-C069G-081	Tape Guide	1	
05.00	13	P-C069G-082	Tape Centering Pin	3	
05.00	14	P-C069G-083	Collar	2	
05.00	15	P-C069G-084	Bushing	2	
05.00	16	P-C069G-085	Tape Guide	1	

Dwg #	Item #	Part Number	Description	Qty	Notes
05.00	17	P-C069G-086	Adjustment Block	1	
05.00	18	P-C069G-087	Adjustment Screw	1	
05.00	19	P-C069G-088	Adjustment Arm	1	
05.00	20	P-C069G-089	Roller Mount	1	
05.00	21	P-C069G-090	Latch	1	
05.00	22	P-C069G-091	Retaining Screw	1	
05.00	30	P-C069G-092	Shaft (Ø8 x 60)	2	
05.00	31	P-C069G-093	Ball Cage (Ø8 x Ø13 x 40)	2	
05.00	32	P-C069G-094	Outer Race (Ø13 x Ø18 x 30)	2	
05.00	33	P-C069G-095	Needle Bearing (NK7/10TN)	1	1
05.00	34	P-C069G-096	Spring	2	
05.00	35	P-C069G-097	Spring	2	
05.00	36	P-C069G-098	Spring	2	
05.00	37	P-C069G-099	Spring Washer	1	
05.00	38	P-C069G-100	Shaft	2	
05.00	39	P-C069G-101	Clevis Eye (SGS-M4)	1	
07.00	1	P-C069G-102	Cam Shaft	1	
07.00	2	P-C069G-103	Drift Key	1	
07.00	3	P-C069G-104	Cam 3	1	1
07.00	4	P-C069G-105	Bearing Nest (Left)	1	
07.00	5	P-C069G-106	Cam 5 (Support Cam)	1	1
07.00	6	P-C069G-107	Cam 6 (Drive Cam)	1	1
07.00	8.2	P-C069G-108	Cam 8.2	1	1
07.00	8.4	P-C069G-109	Cam 8.4	1	1
07.00	8.6	P-C069G-110	Cam 8.6	1	1
07.00	9.1	P-C069G-111	Cam 9.1	1	1
07.00	9.3	P-C069G-112	Cam 9.3	1	1
07.00	9.5	P-C069G-113	Cam 9.5	1	1
07.00	12	P-C069G-114	Spring Stop	1	
07.00	14	P-C069G-115	Cam 14 (Support Cam)	1	1
07.00	15	P-C069G-116	Bearing Nest (Right)	1	
07.00	18	P-C069G-117	Cam 18	1	
07.00	20		Radial Ball Bearing (6004-ZZ)	2	1
07.00	21	P-C069G-118	Spring	1	1
08.00	2	P-C069G-119	Lifter Arm	4	
08.00	3	P-C069G-120	Strut	2	
08.00	4	P-C069G-121	Bushing	8	
08.00	6	P-C069G-122	Guide	1	
08.00	7	P-C069G-123	Pivot Pin	2	
08.00	8	P-C069G-124	Pivot Arm (Specify Left/Right)	2	
08.00	10	P-C069G-125	Spring Pin	2	
08.00	11	P-C069G-126	Spring Pin	2	
08.00	12	P-C069G-127	Drive Block	2	

Dwg #	Item #	Part Number	Description	Qty	Notes
08.00	13	P-C069G-128	Drive Block	2	
08.00	15	P-C069G-129	Base Plate	1	
08.00	17	P-C069G-130	Rocker Arm	1	
08.00	18	P-C069G-131	Bushing	1	
08.00	19	P-C069G-132	Cam Follower	2	1
08.00	20	P-C069G-133	Bushing	4	
08.00	21	P-C069G-134	Kurled Knob	2	
08.00	30	P-C069G-135	Shaft (Ø10h6 x 60)	4	
08.00	31	P-C069G-136	Shaft (Ø8h6 x 88)	4	
08.00	32	P-Brng-012	Radial Ball Bearing (625-ZZ)	6	1
08.00	33		Radial Ball Bearing (626-ZZ)	1	1
08.00	34	P-C069G-137	Spring	4	1
08.00	35	P-C069G-138	Spring	2	1
08.00	36	P-C069G-139	Drive Pin	2	
09.00	1	P-C069G-140	Motor Knob	1	
09.00	2	P-C069G-141	Belt Pulley	1	
09.00	3	P-C069G-142	Motor Coupling	1	
09.00	4	P-C069G-143	Belt Pulley	1	
09.00	5	P-C069G-144	Drive Sleeve	1	
09.00	6	P-C069G-145	Sleeve	1	
09.00	10	P-C069G-146	Clutch Pin (GN 617.1-6-A)	1	1
09.00	11	P-C069G-147	Belt (T5/420-10)	1	1
10.00	1	P-C069G-148	Yoke Attachment	1	
10.00	2	P-C069G-149	Base Plate	1	
10.00	3	P-C069G-150	Lower Tool Block	1	
10.00	4	P-C069G-151	Cover Plate (Specify Left/Right)	2	
10.00	5	P-C069G-152	Lifter Plate (Specify Left/Right)	2	
10.00	6	P-C069G-153	Upper Tool Plate	1	
10.00	7	P-C069G-154	Cover Plate (Specify Left/Right)	2	
10.00	8	P-C069G-155	Spacer	2	
10.00	9	P-C069G-156	Locking Nut	1	
10.00	10	P-C069G-157	Adjustment Screw	1	
10.00	11	P-C069G-158	Micrometer Clamp (Specify Left/Right)	1	
10.00	22	P-C069G-159	Lower Tool Stop (Specify Left/Right)	2	
10.00	23	P-C069G-160	Cover Plate - Lower (Specify Left/Right)	2	
10.00	24	P-C069G-161	Upper Tool Stop (Specify Left/Right)	2	
10.00	25	P-C069G-162	Cover Plate - Upper (Specify Left/Right)	2	
10.00	26	P-C069G-163	Limit Plate	1	
10.00	27	P-C069G-164	Limit Plate	1	
10.00	34	P-C069G-165	Shaft	2	
10.00	50	P-C069G-166	Outer Race (Ø14 x Ø20 x 23.5)	2	
10.00	51	P-C069G-167	Outer Race (Ø14 x Ø20 x 22)	2	
10.00	52	P-C069G-168	Ball Cage (Ø10 x Ø14 x 20)	4	1

Dwg #	Item #	Part Number	Description	Qty	Notes
12.00	53	P-C069G-212	Ball Cage (Ø6 x Ø10 x 25)	2	
12.00	54	P-C069G-213	Short Stroke Cylinder (AV-12-4)	1	
12.00	55	P-C069G-214	Flow Valve (GRLZ-M5-PK3)	1	
12.00	56	P-C069G-215	Spring	1	¹
12.00	57	P-C069G-216	Spring	1	¹
12.00	58	P-C069G-217	Spring	1	¹
12.00	A	P-C069G-218	Upper Die Insert	1	
12.00	B	P-C069G-219	Lower Die Insert	1	
12.00	C	P-C069G-220	Lower Die Insert Mount	1	

¹ Recommended Spare Part

