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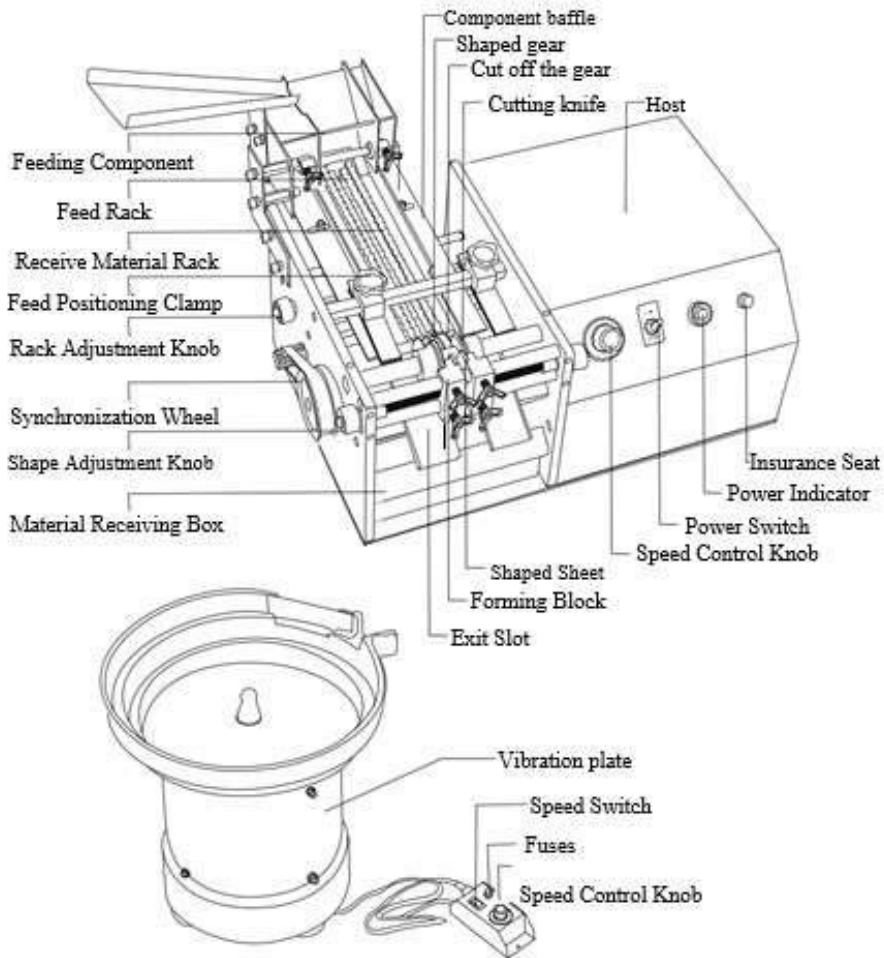
**AFM-E13U / AFM-E13F**

Elektrikli Axial Komponent Kesme Bükme Makinesi



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#### II. Product Introduction

AFM-E13U / AFM-E13F electric bulk tape resistance machine is mainly used for cutting and bending of axial tape or bulk electronic components such as resistors, capacitors, inductors, diodes, etc. into horizontal (u-type) / vertical (F-type) assembly Special equipment.

The machine is made of high-precision parts and high-quality materials. Its action principle is that the bulk components are poured into the vibrating plate. Automatically discharged from the vibrating plate to the hopper. Then arranged from the hopper die to the rear end of the receiving rack. By moving up and down in the oblique direction of the feeding rack. The components are automatically arranged orderly from the back to the front. And sent to the cutting gear and the forming gear to complete the cutting forming Processing. About the braiding element. A pair of feed positioning frames are sent to the cutting gear and cutter to complete the cutting of element pins. Then a pair of formed gears and sheets to complete the forming process. The machine features are as follows:

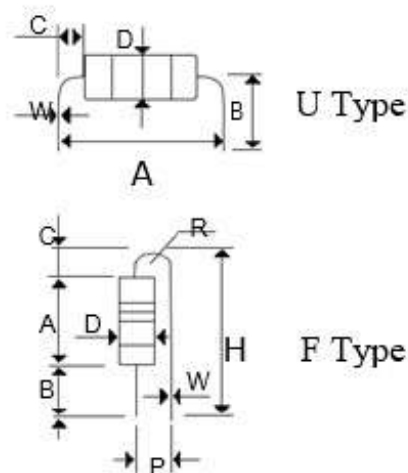
1. The machine structure is light and easy to operate.
2. It is High production efficiency that 36 components can be formed for each revolution of the gear.
3. Built-in power motor realizes automatic production.

Our quality policy is: "Continuous improvement, sustainable effectiveness, and users first".

#### III. Technical Reference

Model	AFM-E13U (mm)	AFM-E13F (mm)
A	6-40 (mm)	4-18 (mm)
B	3.6-15 (mm)	2.5-20 (mm)
C	1.2 (mm)	3.5 (mm)
D	1.5-8 (mm)	
W	Φ0.35-1 (mm)	
H	NO	25 (mm)
P	NO	2.5-13.5 (mm)
Voltage	AC220V 50Hz	

PS:U type and F type are different machine



## AFM-E13U / AFM-E13F

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#### IV. Installation and Commissioning

- 1.Unpacking the package and reading manual.
- 2.Remove and place the machine horizontally.
- 3.Take out the attachment well of the machine and install the hopper on the host machine then plug in the power and turn on the power switch and adjust the speed knob so that the rotating gears of the machine can operate normally.
- 4.Loosen the fixing screws on the feed positioning clamp and move to both sides of the machine.
- 5.Use 4# hexagonal wrench to loosen the cutting gear, forming gear and fixing screws on the forming base. According to the processing requirements of component, adjust the forming gear (the two gears in the middle) and the cutting read wheel (the two gears on both sides) to the required positions (note that the position of the ejection piece should be symmetrical to the left and right). Then turn the forming base. The seat adjustment knob moves the forming piece to the left and right. So that the distance between the forming piece and the forming wheel conforms to the diameter of the pin of the component and fix the screws on the above-mentioned parts.

The width of the inner diameter between the two forming elements is the distance between the outer diameters of the two forming gears. The length of the component cutting foot is the distance between the inner diameters of the two cutting gears.

#### V. Operation

##### 1.Taping components

- ① Place the taping element on the feed positioning clamp. Then adjust the feeding tracks on both sides so that the width is one to the width of the taping element and pass the taping element through the track slot. U type: the component is placed in the two forming gears (Fig. 1) F type: the component is placed between the side of the small-mouth forming gear and the cutting gear (Fig. 2). Finally, tighten the fixing screw on the feed positioning clip, and The element body lies flat on the forming gear and the cutting gear.



Fig.1 U Type



Fig.1 F Type

- ② Adjust the speed knob to make the components follow the forming gear into the cutting gear and the cutting knife one by one, and then the forming gear and the forming piece complete the forming process. The processed components fall into the component collection slot through the return piece until all the components are processed finish.

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# Elektrikli Axial Komponent Kesme Bükme Makinesi

### 2. Bulk Components

①. Move the feed positioning clamp to both sides first.

②. Adjust the rack adjustment knobs so that the positions of the two feed racks and the feed racks are on both sides of the two forming gears, and the distance between the two feed racks is greater than the length of the component. Take a straight component and place it on the rack, and then adjust the component baffle so that the component can move smoothly from back to front on the rack (Note: the width cannot be too wide) to fix the fixing screws on the baffle bar and move. The two waste outlet slots are placed on the outside of the cutting knife and are closely attached. Then the width of the hopper is adjusted so that the components can pass smoothly and fall into the rear end of the feeding rack.

U type: the element is placed in the two forming gears (Fig. 1), F type: the element is placed between the side of the small side forming gear and the cutting gear (Fig. 2).

③. Plug in the power of the host and the vibration disk, turn on the power from the host, and adjust the speed knob to make the machine run. Then turn on the power of the vibration plate to adjust the vibration speed. The components are sent to the hopper and turned to the rack through the vibration plate. By moving the rack in an oblique direction up and down, the components are automatically arranged and fed to the gear and cut off the gear. The processed components fall into the component collection slot through the return piece until all components are processed.

Tips: (1). The gap between the formed piece and the formed gear is the component lead wire diameter.

(2). The angle of the F component can be adjusted by the adjustable screw on the base of the forming piece.

(3). Do not rotate the motor too fast.

(4). Do not feed too much bulk components at one time.

(5). Dispose of waste in operation in a timely manner.

### VI. Attentions

1. Shaping axles and blade axles should always be kept lubricated.
2. Cutting gear, cutting knife, forming gear, forming pieces are processed, and should not be damaged by pushing against each other.
3. The bending gap should be adjusted according to the size of the component pin wire diameter. It is normal for the component pin to be slightly flat, and the copper leakage shall prevail.
4. Do not drop components into the gear to damage the gear
5. The components with uneven pins should be removed during operation to avoid damaging the gear.
6. When adjusting the tension of belt, the belt should be kept in a proper state and the timing belt cannot be oiled.
7. Before feeding bulk components, the surface of the feeding rack and the receiving rack must be clean before the test



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